## CABIN WINDOWS - REMOVAL/INSTALLATION

## 1. General

A. This section provides removal and installation procedures for the cabin windows.

## 2. Cabin Window Removal/installation

- A. Remove Cabin Windows (Refer to Figure 401).
  - (1) Cover window to protect from scratches.
  - (2) Remove upholstery trim around window by removing the upholstery attaching screws.
  - (3) Drill out attaching rivets (3) and remove retainer rings (4) to remove window. Retain retainer rings (4).
  - (4) Remove window from inside cabin opening.
- B. Install Cabin Windows (Refer to Figure 401).
  - (1) Cover window to protect from scratches.
  - (2) Ensure window and cabin skin are free from foreign material, old sealant and solutions.
  - (3) Apply Pro-Seal 890 with 890A Accelerator around outer periphery of window in a bead 0.85 inches wide.
  - (4) Position window in cabin opening.
  - (5) Install rivets through cabin skin and window.
  - (6) Install retainer rings (4) on rivet shanks.
  - (7) Buck rivet shanks just enough to swell the rivet slightly.
  - (8) Install upholstery trim around cabin window with attaching screws, and remove protective cover from window.

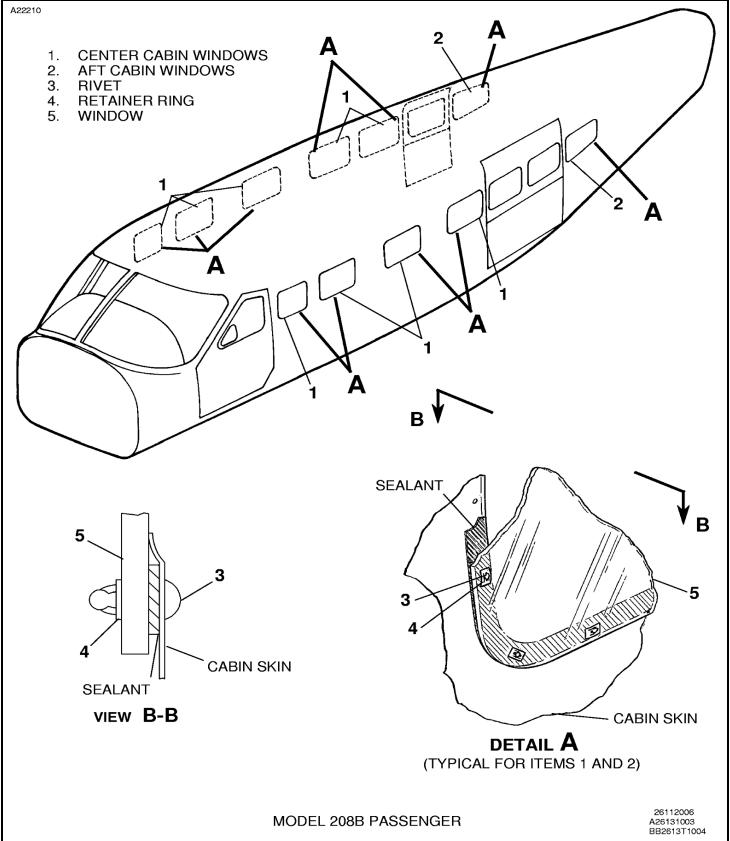
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A22208 **CENTER CABIN WINDOWS** 1. **AFT CABIN WINDOWS** 2. 3. **RIVET RETAINER RING** 4. **WINDOW SEALANT CABIN SKIN SEALANT** VIEW B-B **CABIN SKIN** DETAIL A (TYPICAL FOR ITEMS 1 AND 2) 26112004 A26131003 BB2613T1004 MODEL 208 ONLY

Figure 401: Sheet 1: Cabin Window Installations

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Figure 401: Sheet 2: Cabin Window Installations



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