

DOOR WINDOWS - REMOVAL/INSTALLATION

1. General

- A. The left and right crew doors incorporate windows made of 0.250 inch thick, green-tinted acrylic. The left crew door incorporates a vent window hinged at the bottom which opens inward. The vent window is made of 0.375 inch thick, green-tinted acrylic.
- B. Two cargo door windows are mounted in the top half of the cargo door. The cargo door windows are made of 0.187 inch thick, green-tinted acrylic.
- C. One window is mounted in the top half of the right side passenger door. The passenger door window is made of 0.187 inch thick, green-tinted acrylic.
- D. This section provides instructions for removal and installation of the windows located within both passenger and crew doors.

2. Tools, Equipment and Materials

- A. For a list of required tools, equipment and materials, refer to Windows - General.

3. Crew Door Window Removal/Installation

- A. Remove Crew Door Window (Refer to Figure 401).
 - (1) Cover crew door window to protect from scratches.
 - (2) Remove upholstery trim around window and door assist strap by removing the upholstery and door assist strap attaching screws.
 - (3) Drill out attaching rivets (21) around the periphery of the window (22) securing retainer rings (20).
 - (4) Remove crew window (22) and sealant (19).
- B. Install Crew Door Window (Refer to Figure 401).
 - (1) Cover window to protect from scratches.
 - (2) Ensure opening around window is free from foreign material, old sealant and solutions.
 - (3) Apply FS-4291 sealant around outer periphery crew door window (22).
 - (4) Position crew door window (22) in cabin door skin (18) opening.
 - (5) Install rivets (21) through cabin door skin (18) and crew window (22).
 - (6) Install retainer ring (20) on rivet shanks (21).
 - (7) Buck rivet shanks just enough to swell the rivet slightly.
 - (8) Install upholstery trim around cabin window (22) with attaching screws and remove protective cover from window.

4. Pilot's Vent Window Removal/Installation

- A. Remove Pilot's Vent Window (Refer to Figure 401).
 - (1) Cover window to protect from scratches.
 - (2) Move handle (8) to disengage vent window (6) from window stop.
 - (3) Remove nuts (23), screws (25) and spacers (24), and remove vent window.
 - (4) Retain seal (4) for reinstallation.
 - (5) If hinge straps (13) are to be removed, remove attaching hardware.
 - (6) If required, remove handle (8) by removing nut (10), handle (8), spacer (7) and screw.
- B. Install Pilot's Vent Window (Refer to Figure 401).
 - (1) Cover window to protect from scratches.
 - (2) Install seal (5) on vent window (6).
 - (3) Align holes in vent window (6) with holes in hinge strap assembly (13).
 - (4) Install hardware securing hinge strap assembly to vent window (6).
 - (5) If handle (8) was removed, install screw, spacer (7), handle (8), washer (9) and nut (10) on vent window (6).
 - (6) Remove protective cover from vent window.
 - (7) Install spacers (24), screws (25) and nuts (23).

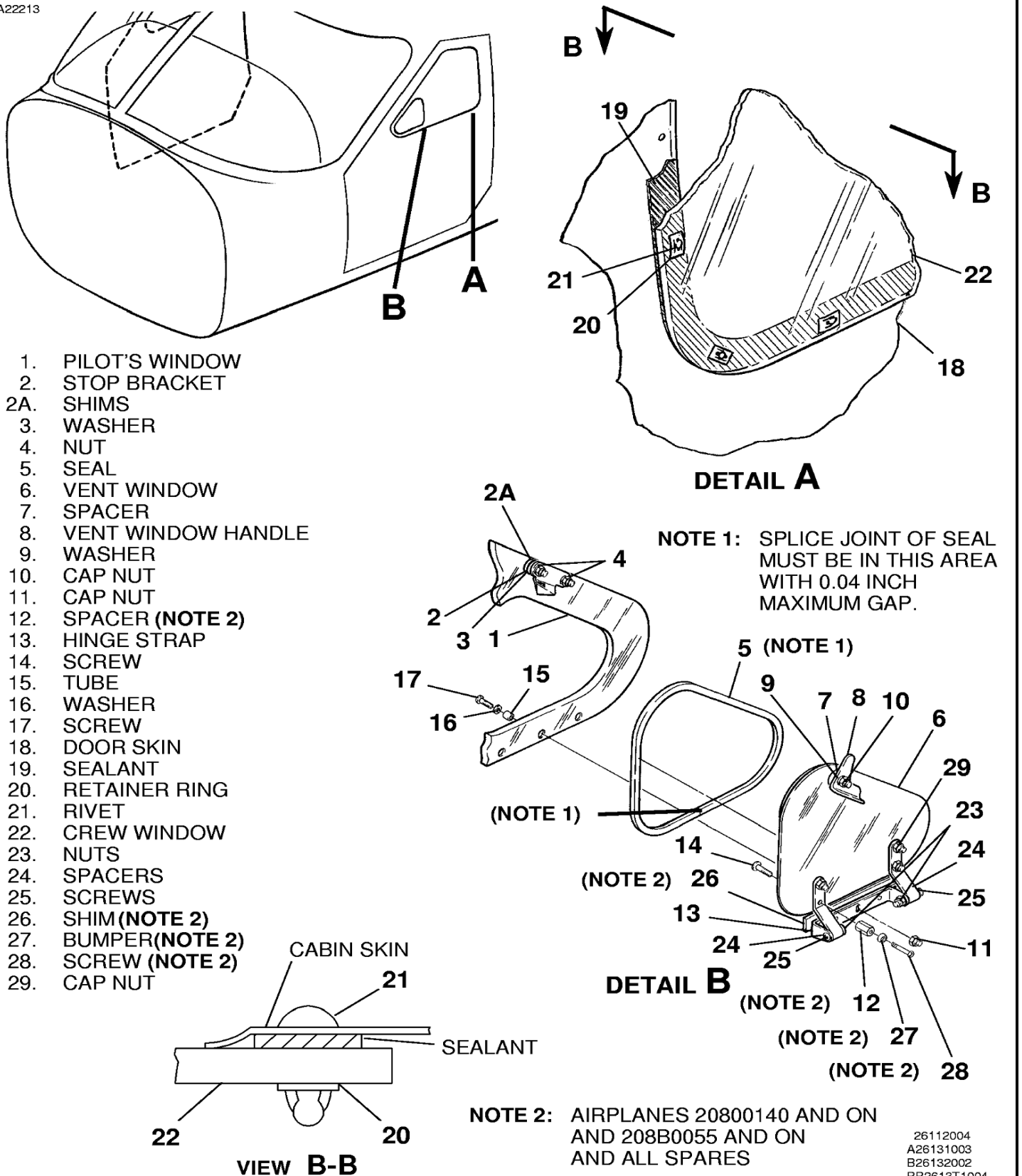
- (8) Engage handle (8) to secure vent window.

5. Cargo and Passenger Door Window Removal/Installation

- A. Remove Cargo and Passenger Door Windows (Refer to Figure 402).
 - (1) Cover window (5) to protect from scratches.
 - (2) Remove upholstery around window by removing the upholstery attaching screws.
 - (3) Drill out attaching rivets (3) around periphery of window (1) or (2) securing retainer rings (4).
 - (4) Remove window from cabin opening and remove sealant (6).
- B. Install Cargo and Passenger Door Windows (Refer to Figure 402).
 - (1) Cover window (5) to protect from scratches.
 - (2) Ensure opening around window is free from foreign material, old sealant and solutions.
 - (3) Apply FS-4291 sealant (6) around outer periphery of window (5).
 - (4) Position window in door opening and install rivets (3) through door frame and window (5).
 - (5) Install retainer ring (4) on rivet shafts (3).
 - (6) Buck rivet shanks (3) just enough to swell the rivet slightly.
 - (7) Install upholstery trim around window (5) with attaching screws and remove protective cover from window.

Figure 401 : Sheet 1 : Crew Door Windows and Pilot's Vent Window Installation

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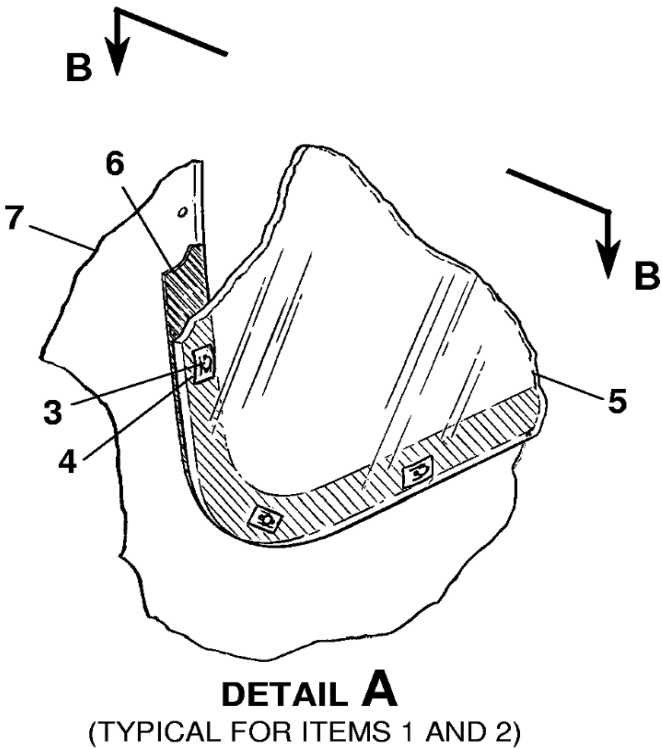
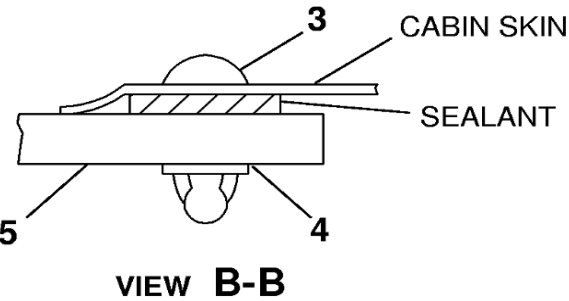
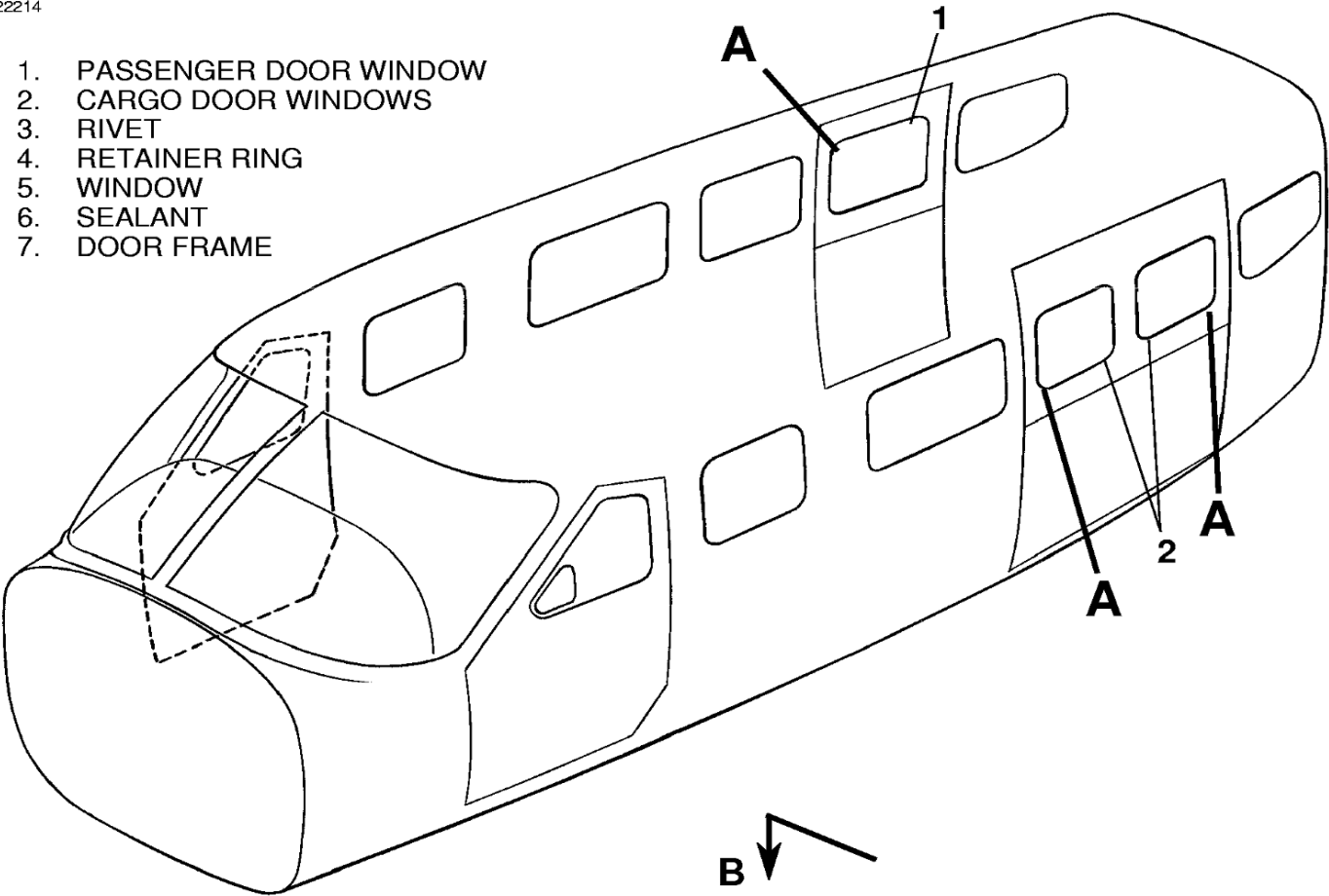


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Figure 402 : Sheet 1 : Cargo and Passenger Door Window Installation

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- 1. PASSENGER DOOR WINDOW
- 2. CARGO DOOR WINDOWS
- 3. RIVET
- 4. RETAINER RING
- 5. WINDOW
- 6. SEALANT
- 7. DOOR FRAME



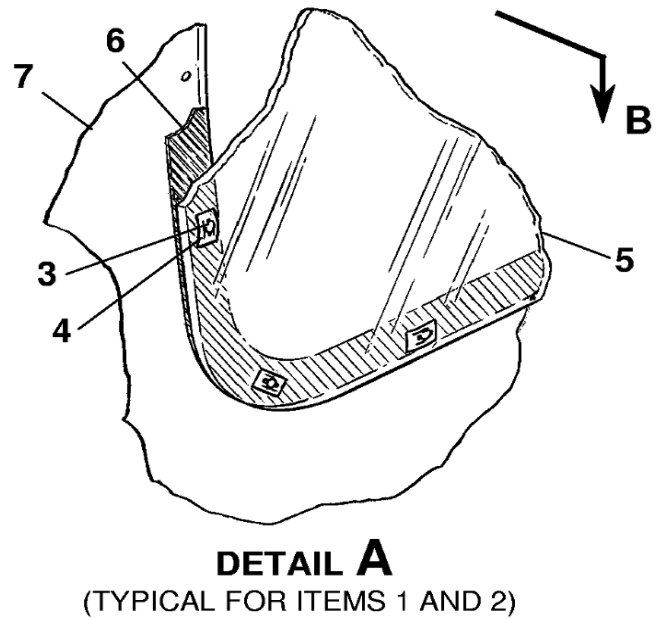
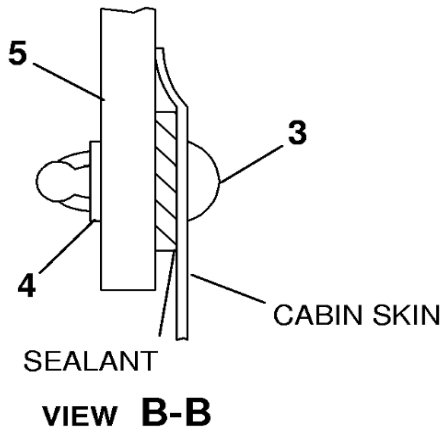
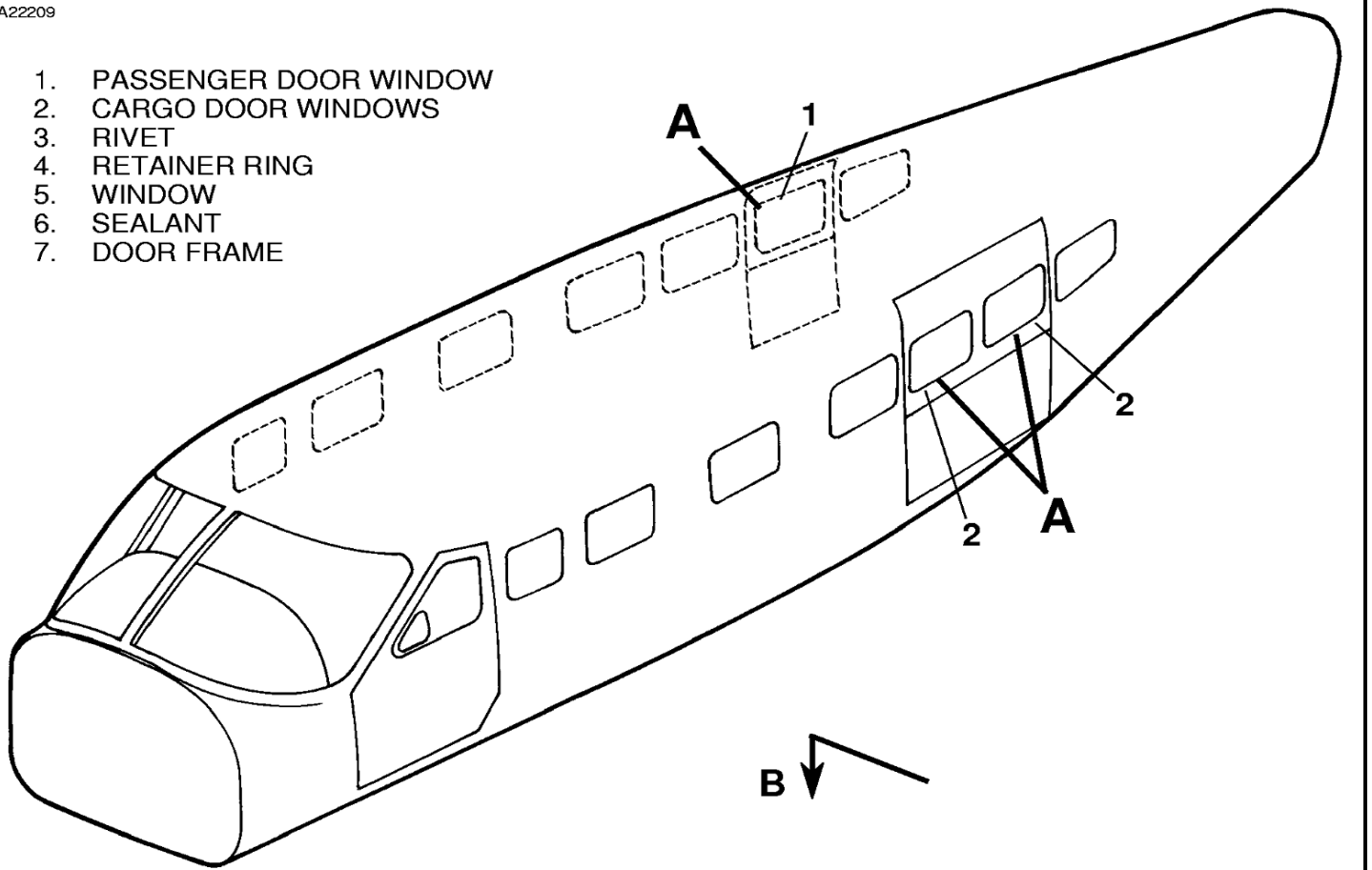
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Figure 402 : Sheet 2 : Cargo and Passenger Door Window Installation

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1. PASSENGER DOOR WINDOW
2. CARGO DOOR WINDOWS
3. RIVET
4. RETAINER RING
5. WINDOW
6. SEALANT
7. DOOR FRAME



MODEL 208B PASSENGER

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