

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.

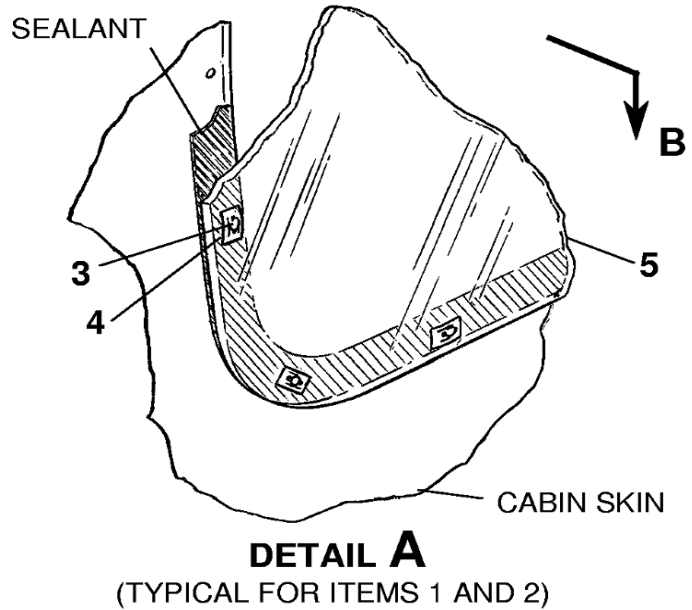
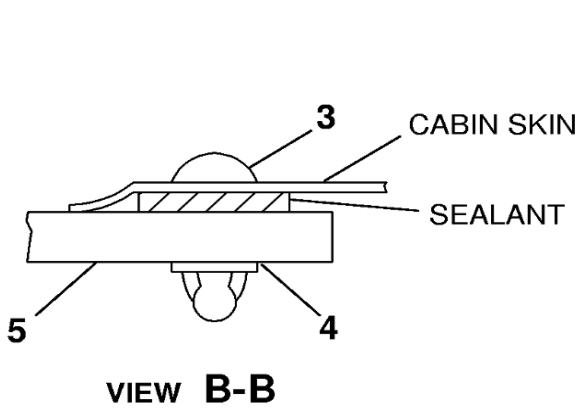
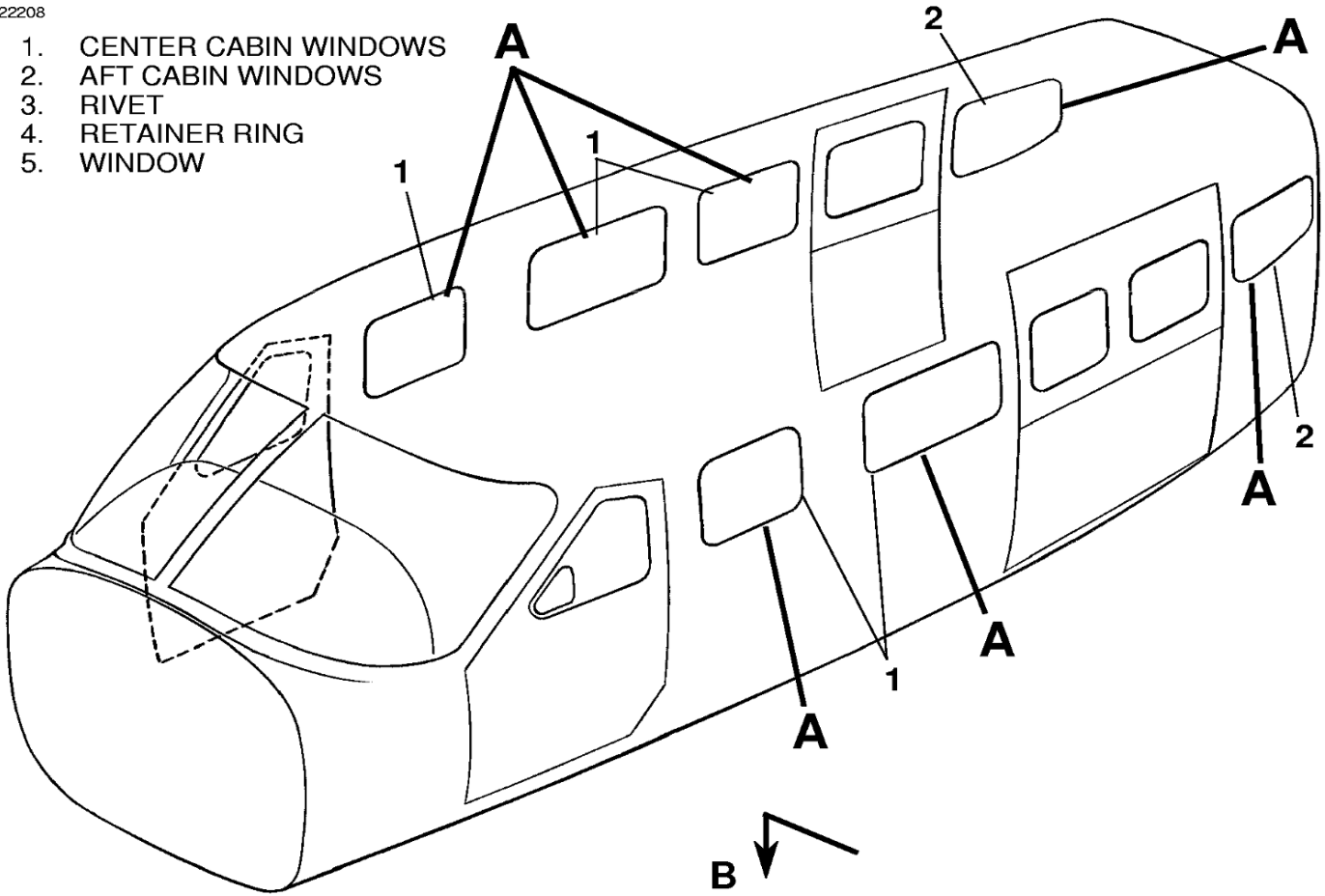
B. Install Cabin Windows (Refer to Figure 401).

- (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.

Figure 401 : Sheet 1 : Cabin Window Installations

A22208

- 1. CENTER CABIN WINDOWS
- 2. AFT CABIN WINDOWS
- 3. RIVET
- 4. RETAINER RING
- 5. WINDOW



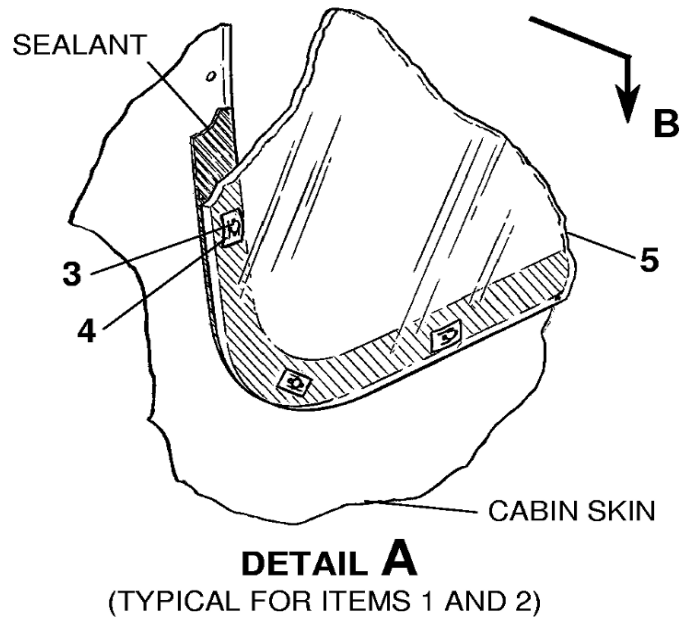
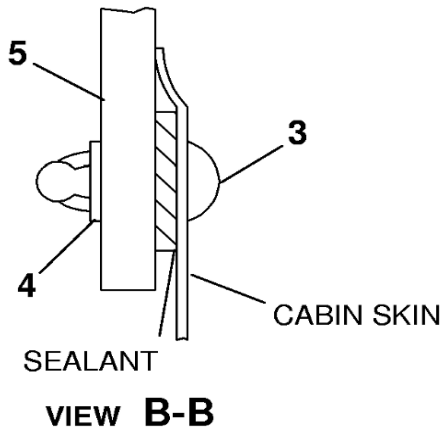
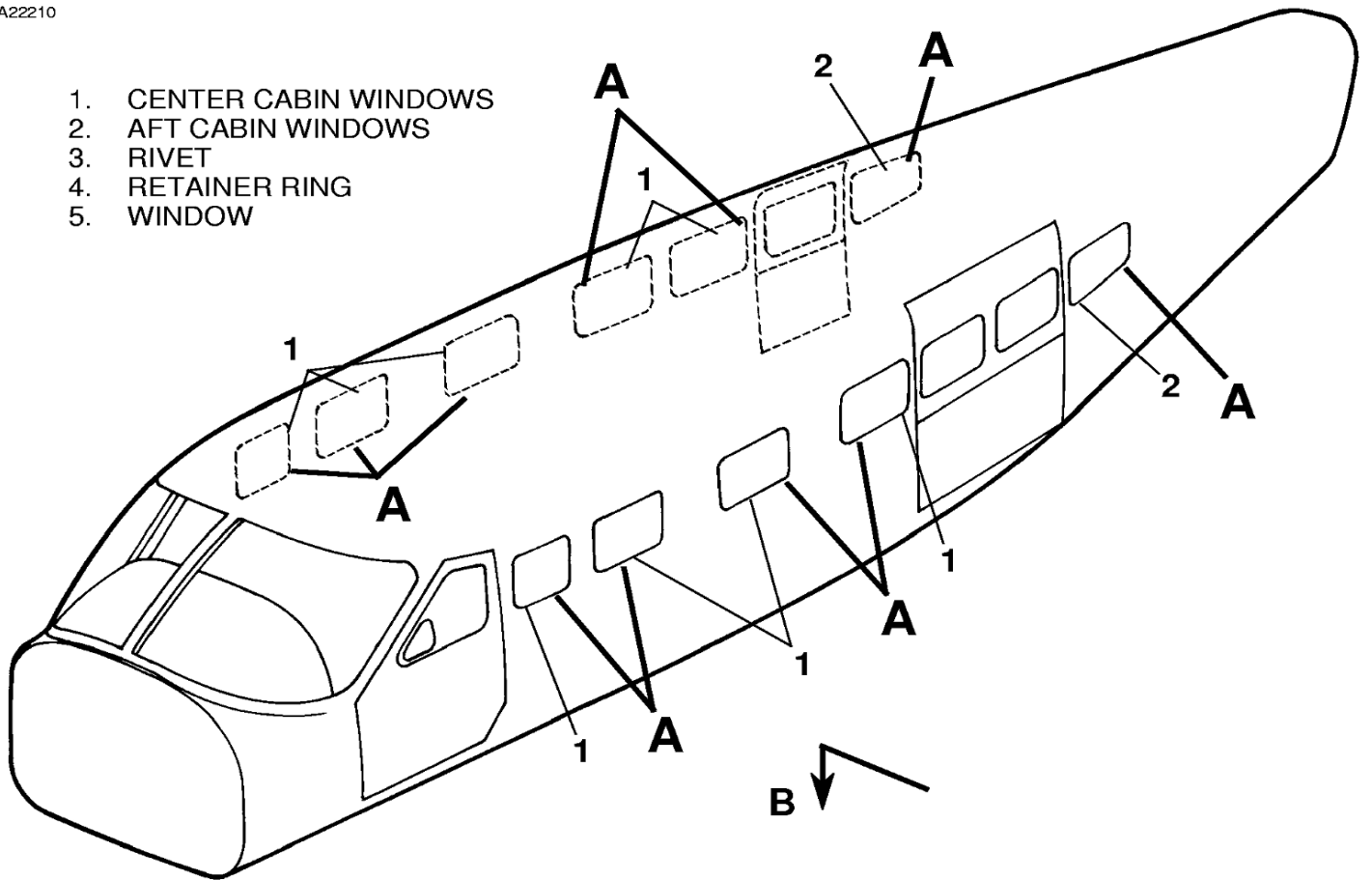
MODEL 208 ONLY

26112004
 A26131003
 BB2613T1004

Figure 401 : Sheet 2 : Cabin Window Installations

A22210

1. CENTER CABIN WINDOWS
2. AFT CABIN WINDOWS
3. RIVET
4. RETAINER RING
5. WINDOW



MODEL 208B PASSENGER

26112006
 A26131003
 BB2613T1004