

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).

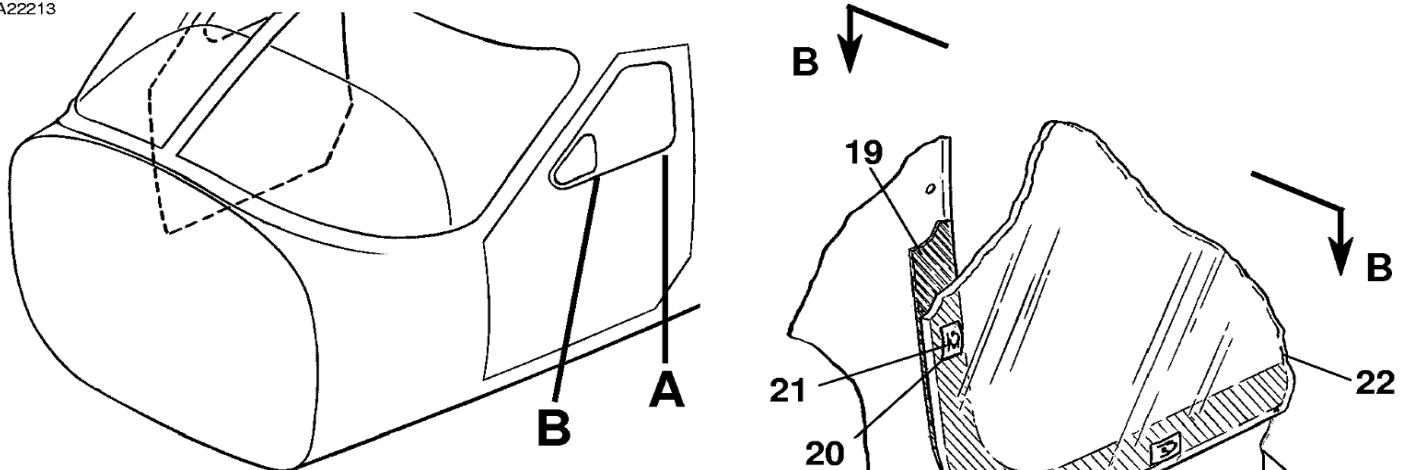
- (1) Cover window (5) to protect from scratches.
- (2) Remove upholstery around window by removing the upholstery attaching screws.
- (3) Drill out attaching rivets (3) around periphery of window (1) or (2) securing retainer rings (4).
- (4) Remove window from cabin opening and remove sealant (6).

B. Install Cargo and Passenger Door Windows (Refer to Figure 402).

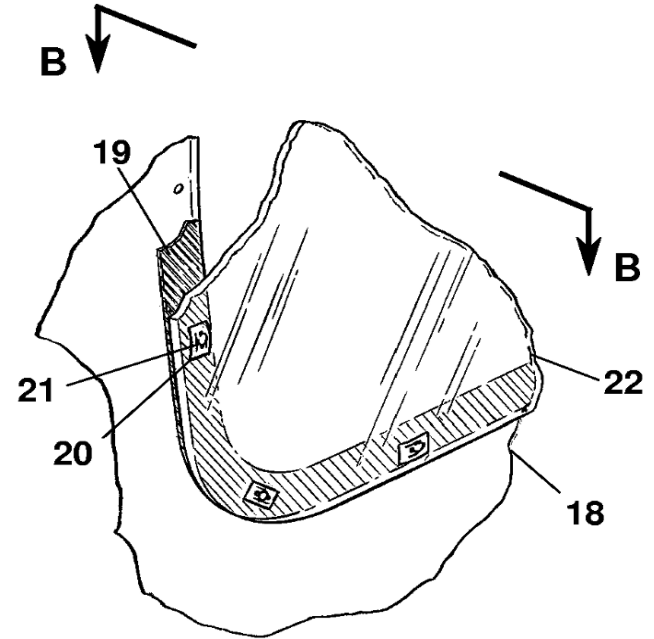
- (1) Cover window (5) to protect from scratches.
- (2) Ensure opening around window is free from foreign material, old sealant and solutions.
- (3) Apply FS-4291 sealant (6) around outer periphery of window (5).
- (4) Position window in door opening and install rivets (3) through door frame and window (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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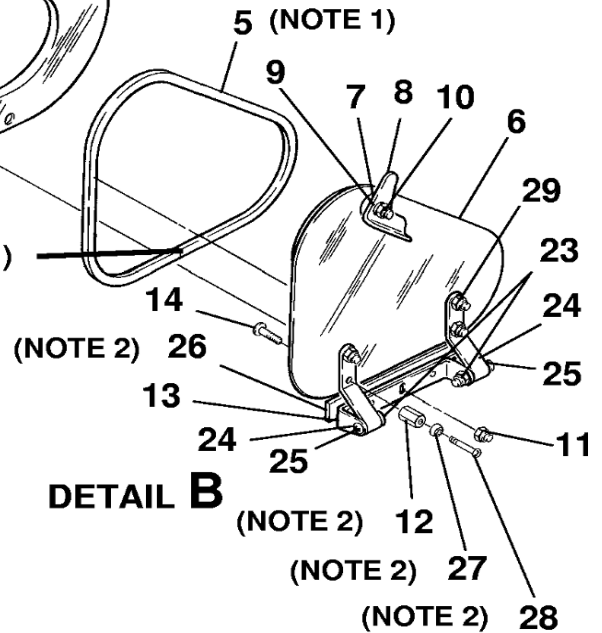
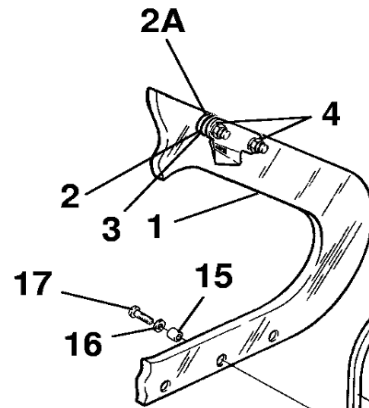


1. PILOT'S WINDOW
2. STOP BRACKET
- 2A. SHIMS
3. WASHER
4. NUT
5. SEAL
6. VENT WINDOW
7. SPACER
8. VENT WINDOW HANDLE
9. WASHER
10. CAP NUT
11. CAP NUT
12. SPACER (NOTE 2)
13. HINGE STRAP
14. SCREW
15. TUBE
16. WASHER
17. SCREW
18. DOOR SKIN
19. SEALANT
20. RETAINER RING
21. RIVET
22. CREW WINDOW
23. NUTS
24. SPACERS
25. SCREWS
26. SHIM (NOTE 2)
27. BUMPER (NOTE 2)
28. SCREW (NOTE 2)
29. CAP NUT



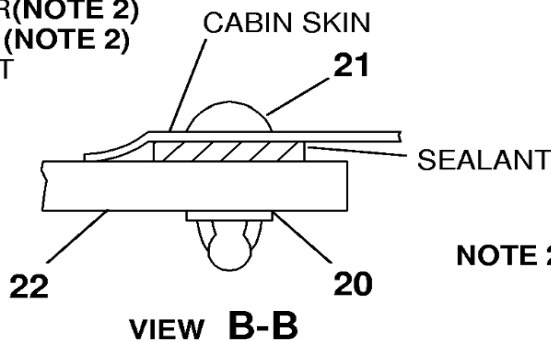
DETAIL A

NOTE 1: SPLICE JOINT OF SEAL MUST BE IN THIS AREA WITH 0.04 INCH MAXIMUM GAP.



DETAIL B

NOTE 2: AIRPLANES 20800140 AND ON AND 208B0055 AND ON AND ALL SPARES



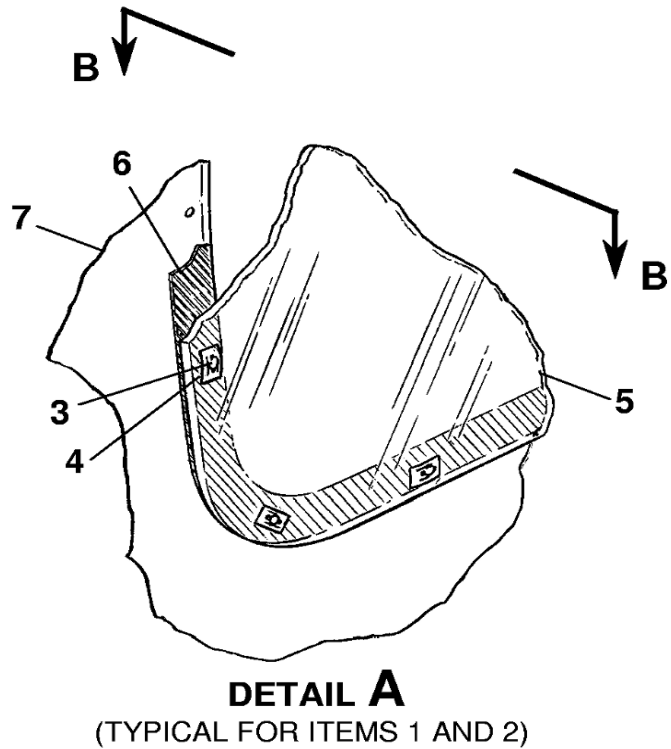
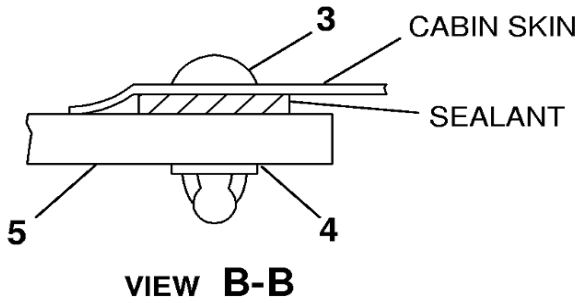
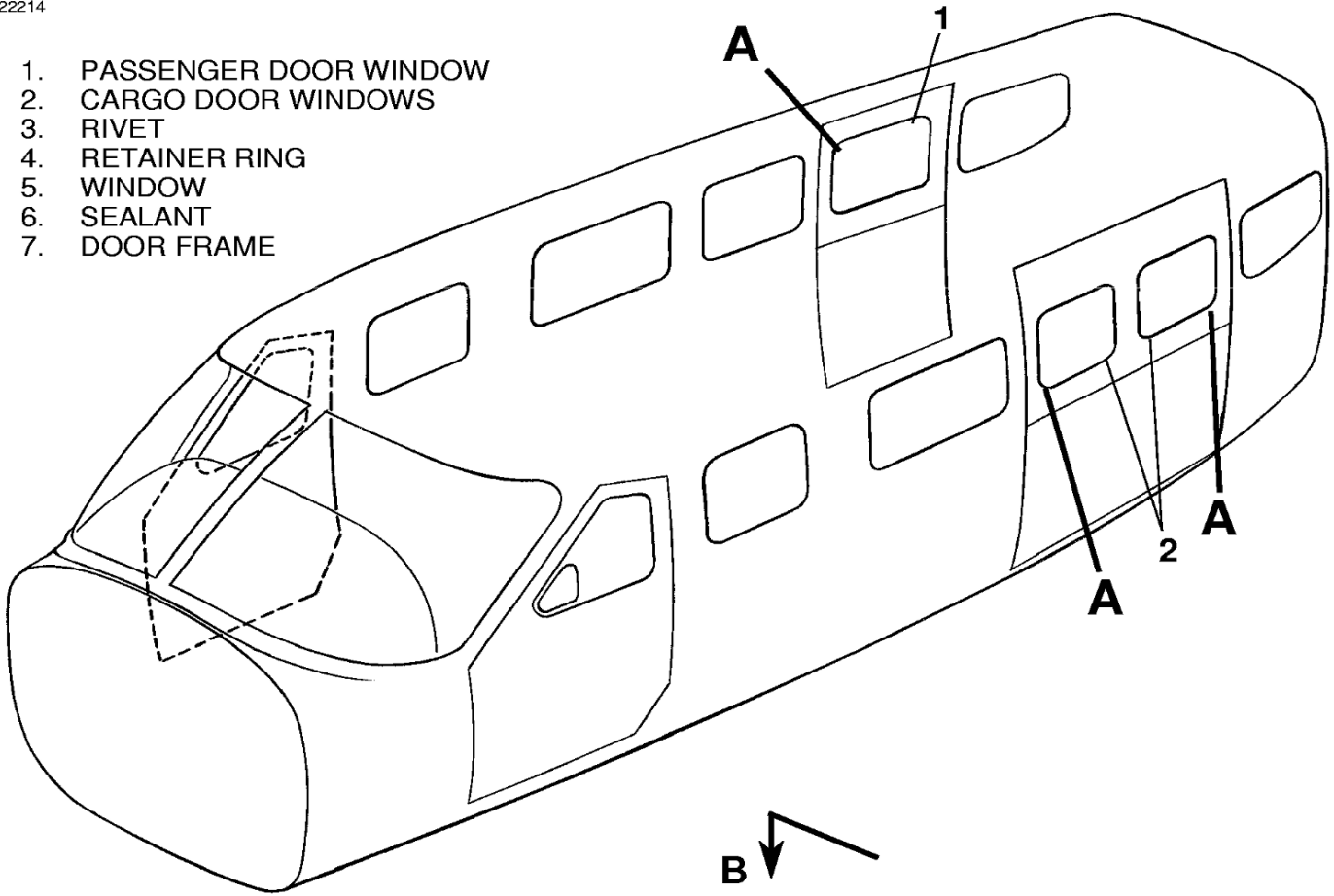
VIEW B-B

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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



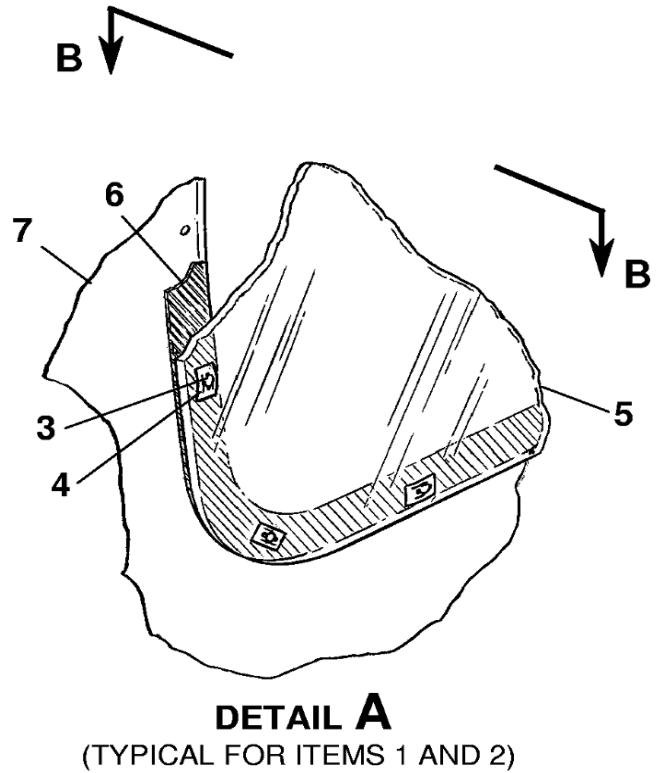
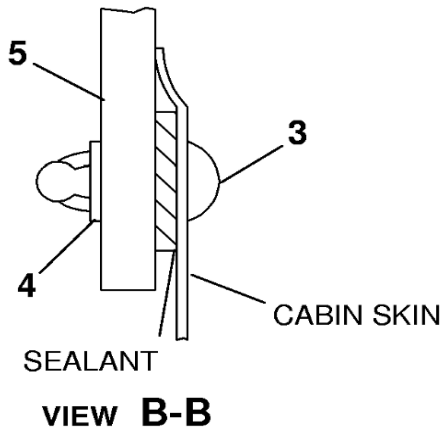
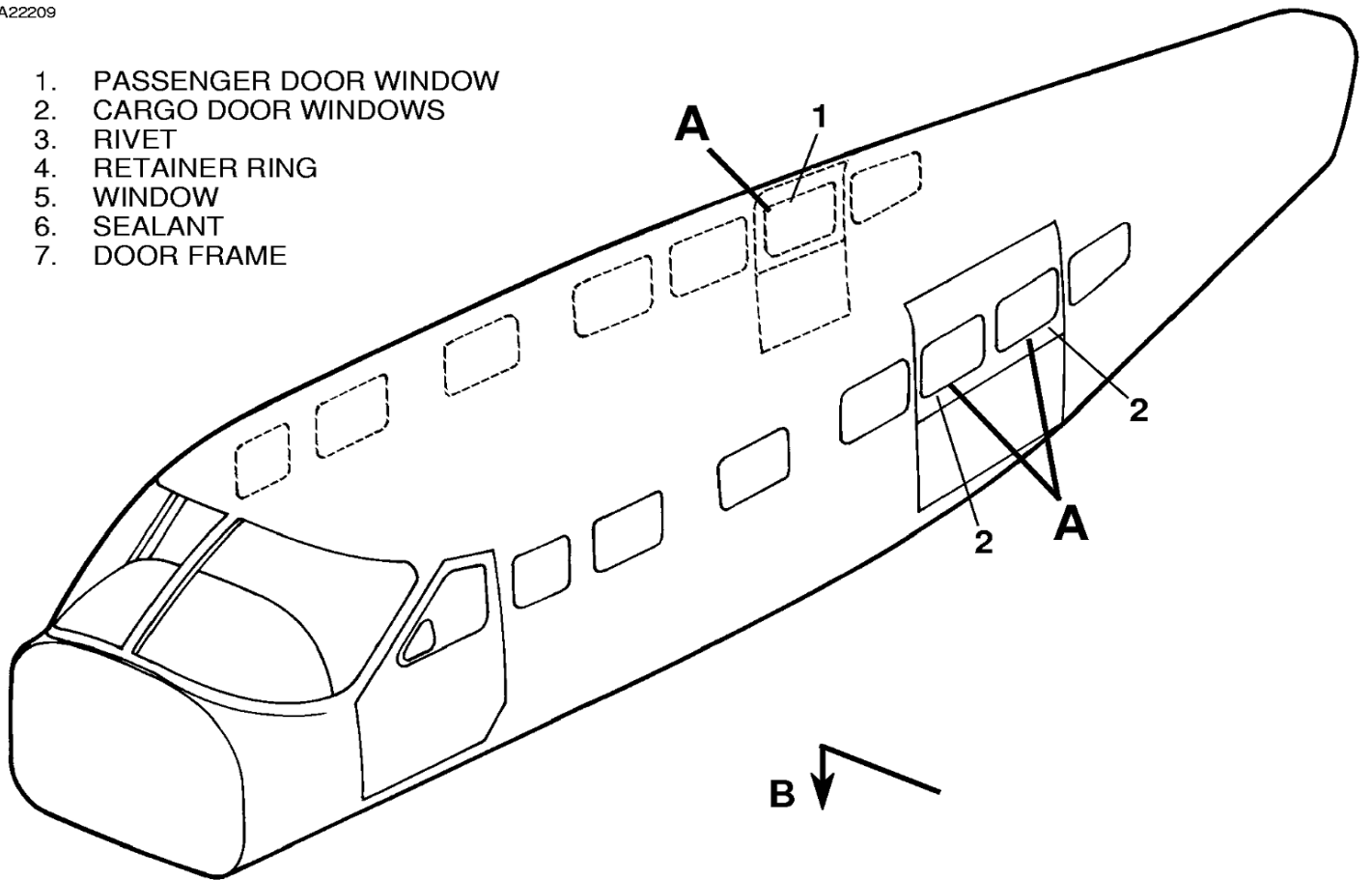
MODEL 208 ONLY

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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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