

## INST. A2A

Great Lakes Aero Products, Inc.

915 Kearsley Park Blvd.  
Flint, MI. 48503 (810) 235-1402

### INSTRUCTIONS FOR INSTALLING BEECH DOOR WINDOW WITH VENT

#### Materials required:

1. Window, *W or W/T-, or W/G-2221 STC # SA00690CH*
2. 56 pieces AN 507 or 526-632 R9 or 10 ( See note below )  
56 pieces AN 364-632 (nuts)  
56 pieces AN 960-6L (washers)
3. Masking Tape
4. Can of spray Enamel
5. RTV Silicone Rubber Sealant GE, Dow or equal
6. Optional - VM&P Naphtha or Lighter Fluid

#### Tools Required:

1. Phillips screw drivers
2. Electric drill
3. Drill set
4. Counter sink tool
5. 5/16 inch box end wrench
6. Sander -Disk or Belt ( may be done by hand if necessary )

#### Installation procedure:

1. Remove old Window and clean opening of old sealant. Inspect opening for distorted metal or damaged surface where new window will contact.
2. Peel the protective paper back on the new window not more than 1 to 2 inches from the edge and use masking tape to hold it.
3. Place new Window in opening and mark any spots that have to be sanded for a better fit. ***DO NOT REMOVE EXCESSIVE AMOUNTS OF MATERIAL AT ONE TIME - you can always take more off - you cannot put any back on! Do not use tools such as screwdrivers to pry the window out - use your fingers and hands.***
4. Make sure the edges of the window are smooth and then replace the window in the opening. If any interference still exists repeat step #3
5. When a good fit is obtained, have someone inside the aircraft hold the window in position and drill the top center hole (from the outside) with a drill (see sharpening instructions) that will just clear the airframe. Place a screw through the hole and a nut inside and tighten ***very*** gently. Now drill the bottom center hole and place a screw through and a nut and tighten gently. **DO NOT OVER TIGHTEN**

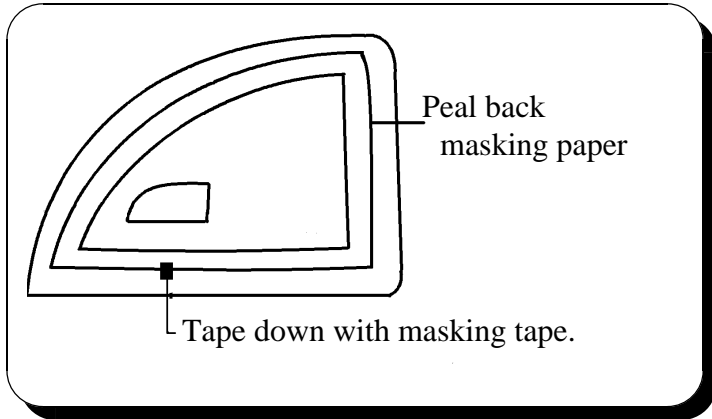
NOTE: The AN 526 screws may be used in holes that are not dimpled ( countersunk ) use as required.

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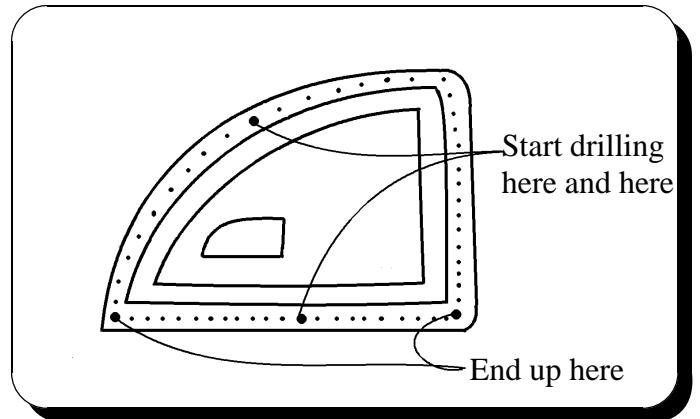
### ***Instructions For Installing Beech Door Window Cont.,***

6. Drill four or five more holes on both sides of the center, top and bottom, working from the center out. Place the screws in the outer most holes that you have just drilled and tighten gently. **DO NOT OVER TIGHTEN!**
7. Repeat the process (step 6) until **all** holes are drilled and there is one screw and nut in every fourth or fifth hole.
8. Mark the window with a grease pencil ( china marker ) to show where the edge of the airframe meets the window.
9. Remove the screws in the reverse order ( outside in ) and remove the window from the opening.
10. Mask the Window 1/8 inch past the mark from step 8 leaving the outer edge of the opening exposed ( approximately 1/2 inch ).
11. Redrill all the holes with a 3/16 to 7/32 drill ( see sharpening instruction ) and countersink slightly to clear the dimpled countersunk holes in the airframe (countersink window only on the side that contacts the airframe).
12. Clean the edge of chips of dirt, spray a **very** light coat of enamel on the exposed (1/2 inch or so as in step 10) on the side that contacts the airframe. (NOTE: inspect masking **first** to be sure no paint will get on the plastic except for the edge). This coating is necessary as RTV Silicone Rubber will not adhere well to Acrylic.
13. When the paint on the edge is dry remove the extra masking tape (The window may at this time be remasked to the line drawn in step 8 to protect the window from getting silicone on the exposed surface - clean the grease pencil line off of the surface before applying the silicone so that it does not show under the silicone when it hardens ) and replace window in airframe. (no screws yet)
14. Squeeze a bead of RTV Silicone Rubber between the window and the airframe.
15. Put the screws and nuts in by starting in the center and working out. **DO NOT OVER TIGHTEN** work Quickly - as the silicone rubber starts to "skin" over in 10 to 20 minutes
16. When all the screws and nuts are in place go over all of them - **tighten gently** and back off 1/4 to 1/2 turn on each of them.
17. The window is now permanently installed - excess RTV Silicone Rubber ( the excess that should squeeze out ) may be wiped off and then cleaned with a rag dampened with VM&P Naphtha or lighter fluid ( don't use too much ).
- 17a. Or optionally the excess may be allowed to harden for a day or two and then peeled off as it will not adhere well to the acrylic. Don't use a knife as you may cut into the window causing a stress concentration.

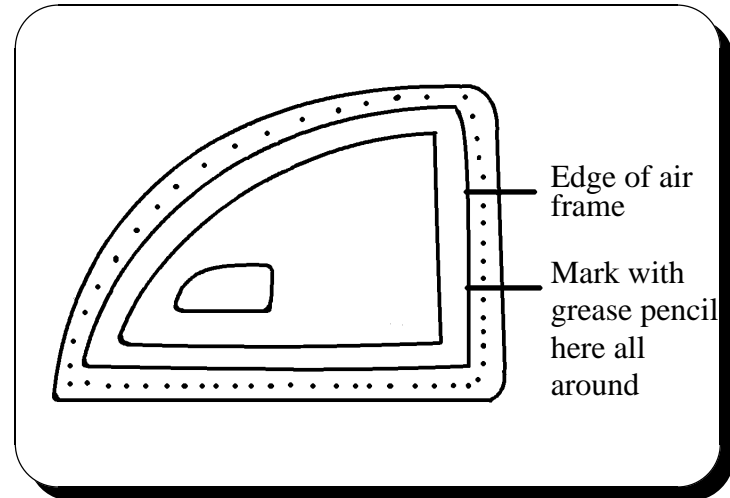
Step # 2



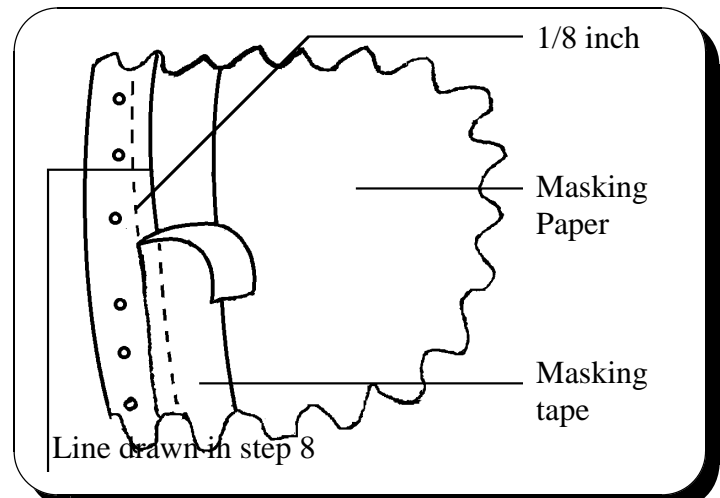
Step # 5, 6, & 7



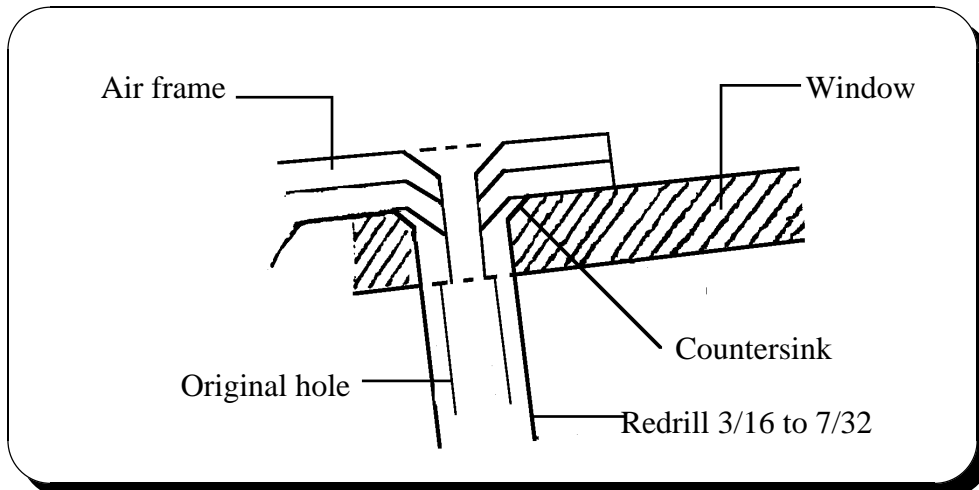
Step # 8



Step # 10



Step # 11



Weight and Balance information

➤ Right hand ( door ) window replace 35-400320-4, -10, -32 or -34

with W-, W/T-, W/G-2221

New weight change..... + 1.93# ( exchange )

Arm..... + 88½"

Moment..... + 170 in #

**Usability of Right Hand ( door ) window  
W- or W/T-, W/G-2221**

Model	Serial Number
35-33 thru G33	CD-1 & on / CE-1 thru -632/ CJ-1 & on
35 thru V35B	DI thru D-9855 except D-9819
36 & A36	E-1 thru E-830 except E-754
95-55 thru E55A	TC-1 thru TC-1935 / TE-1 thru TE-1069
56TC & A56 TC	TG-1 & on
58 & 58A	TH-1 thru TH-732
95 thru E95	TD-2 thru TD-721