

Installation Instructions A-8

GREAT LAKES AERO PRODUCTS, INC.

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**One Piece Windshield Installation
For Piper PA-23-250 and PA-E23-250**

- Windshield part # W-, W/T-, or W/G- 2080
- For installation on piper aircraft models PA-23-250 (6 place) and PA-E23-250 (6 place)

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STC # SA585GL

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Materials List:

1. Windshield - part # as shown above
2. 4 pcs. #4-¼ PTA sheet metal screws
3. 8 pcs. AN-526-632-R 10 screws
4. 8 pcs. AN-364 or 365 632 nuts
5. 8 pcs. M-1000-1 elastomer bushings
6. 1 pc .060" X 1" X 12" Aluminum strip
7. Bracket part # M-1003 or cover part # M-1002. as required
8. Sealant - dichromate putty or silicone rubber (RTV) or other approved sealant Ⓢ not supplied Ⓢ

Installation Procedure:
PA-23-250, and PA-E23-250 Windshield

1. Remove compass (if mounted on center post) and OAT. Remove necessary upholstery and trim.
2. Remove old windshield by removing center outer strip and lower fairing. Remove the screws on the top and sides and remove the old windshields.
3. Cover the top of the instrument panel to prevent foreign material from entering radios and instruments.
4. Remove center post by drilling out the necessary rivets and removing the bolt at the bottom, if the compass is to be located other than shown on Page 3 of these instructions. If the compass is to be located at the top of the windshield, cut the post as shown on Page 3 and remove the bolt at the bottom.
5. Clean the old sealant from the windshield mounting area and carefully inspect and repair the mounting area to remove nicks, burrs and distorted metal as required.
6. Remove the edge of the protective paper as shown on page 3.
7. Fit the new windshield to the opening by trimming - use a disk sander or a belt sander - be careful not to remove too much material (you can not put any back on, but you can always remove a little more). When the windshield fits properly, mark and drill or notch the holes at the top and sides for the screws. →
NOTE: The bottom of the windshield should fit tightly against the skin as it helps to hold the windshield in position.
8. With the windshield and lower fairing in place, locate and drill the 4 holes in the lower fairing an thru the windshield and aluminum strip. **BE SURE TO FOLLOW THE DRILL SHARPENING INSTRUCTION INCLUDED IN THESE INSTRUCTIONS** a #27 drill is used through the fairing and the aluminum strip. A 5/16" drill is used to drill the windshield using the smaller hole as a pilot hole. 6 or 8 holes may be used along the lower fairing (rather than 4), if it seems necessary to keep the windshield from leaking in this area. The 2" screw spacing is typical and AN 960 washers should be used on the outer holes - beyond the 12" strip.
9. Remove the windshield and smooth all edges with fine sandpaper. Install the elastomer bushings in the holes at the bottom.
10. Apply sealant to all mounting surfaces and reinstall the windshield in the opening. Re install the lower fairing and the other related fasteners.
11. Clean the excess sealant and windshield (VM&P Naphtha or lighter fluid will not harm the Plexiglas **but most other solvents will**). Use a good grade of aircraft windshield cleaner to remove the thin film that will remain after cleaning the sealant with the VM&P Naphtha.
12. Re install the O.A.T. - it may be installed through the windshield, but it is desirable to relocate it elsewhere. Reinstall the compass as shown on page 3 or relocate as desired. A C2400L4P may be mounted on top of the instrument panel.
13. Repair painted areas and replace upholstery (as required)
14. Fill out 337 form.