

INSTRUCTIONS A-9

**INSTRUCTIONS FOR INSTALLING DOMED OR BUBBLE DOOR
WINDOWS (OPENABLE STYLE) IN CESSNA AIRPLANES**

CESSNA MODELS 172, 172A THRU P, 175A THRU C, 180A THRU J,

P172D, 182A THRU D, 185 THRU A185F

REIMS AVIATION MODELS F172F THRU F172N

MATERIALS REQUIRED

1. Domed or bubble windows Great Lakes Aero Products part number(s) W-, W/T-, W/G-2901-2, -4, or -6 (LH) or W-, W/T-, W/G-2902-2, -4, or -6 (RH).
2. Blind rivets (I.E. Cherry rivets) - not supplied.
3. Sealant - Presstite # 579.6 or silicone sealant - I.E. GE or Dow Corning - not supplied.
4. Placard - PN W-2910

TOOLS REQUIRED

1. Drill (I.E. Air or Electric)
2. Drills or Drill set - proper sizes for blind rivets.
- 3 Blind rivet puller for rivets.

REMOVAL AND INSTALLATION PROCEDURE

1. The window assembly may be removed from the door by pulling the hinge pins or drilling the rivets out of the hinges and disconnecting the window stop. (Or installation may be done with the frame still attached to the door).
2. Drill out the blind rivets on the splice - **note** - you only have to drill out half the rivets , it is not necessary to remove the splice from both sides.
3. Spread the frame carefully so the old window can be removed with the least amount of bending or damage to the frame. Carefully clean and inspect the frame for any conditions that would create problems in installing the new window.
4. Compare the trimmed size of the bubbled window to the one you removed from the frame. Trim if necessary- see attached trimming instructions.

GREAT LAKES AERO PRODUCTS

5. Reinstall the new window, again being careful to not damage the frame. Sealant may be used as necessary to prevent excessive leakage. When the new window is in the proper position and the splice is slid together, the blind rivets can be installed.
6. The window assembly may be reinstalled in the door, if it was removed in step 1.
7. Fill out the necessary paperwork - I.E. 337 form.

NOTES

There is no change in weight and balance when standard windows are replaced.

Install placard (Caution: do not open above 105 knots (120 mph)) either on the window in a spot near the latch or on a appropriate surface near the latch.

The window can be resealed with silicone sealant from the outside if required - mask the window and the frame to minimize the mess created by the sealant.

There may be a negligible change in airplane performance when domed windows are installed.

The change in airflow over the window *may* cause the frame to leak air and hiss or make other noises at the front of the frame. The following Cessna parts may be used to install the latch on the front of the frame if the leakage is objectionable. The new latch should be installed as far forward on the frame as possible but staying in the straight portion of the frame. Use the existing latch as a pattern to install the second latch.

<u>part #</u>	<u>description</u>
1411202-201***	Bracket assy. (use with S-1483-1 or -2)
S1483-1 ***	R.H. Handle
S1483-2 ***	L.H. Handle
NAS561P3-8***	Roll pin (use with S-1483-1 or -2)
NAS514P1032-14	Screw (2)
NAS43PT3-24	Spacer (2)
0711021-7*	Plate *
0711093-1**	Plate **
0517002-1#	Plate #
0511241-1##	Plate ##
1217065-3 (LH) , -4 (RH) Striker plate ****	
1217066-1 (LH), - 2 (RH) Latch Assy. ****	
S1021Z8-8	Screw

* sn 18051465 thru 18052905, 185-0001 thru 185-0516, 185-0787 thru 185-03458
17249545 thru 17257161

** sn 18051184 thru 18051464, 185-0517 thru 185-0786

*** 180 sn 32662 thru 18052905, 182 33843 thru 18253598, 185-0001 thru 185-03458

sn 17257162 thru 17269309

Use for 180 sn 32662 thru 18051183 - this part is listed as not available (from Cessna) so a used one may have to be found or one may have to be fabricated.

sn 17246755 thru 17249544

**** 172 sns 17269310 & up, 18052906 & up, 18503459 & up