

**INSTRUCTIONS A-9A**

**INSTRUCTIONS FOR INSTALLING DOMED OR BUBBLE RH DOOR  
WINDOWS IN CESSNA AIRPLANES (NON-OPENABLE STYLE WINDOW)  
CESSNA MODELS 170B ( SN 26996 & ON ), 172, 172A, 172B ( THRU SN 17248181 ),  
175, 175A, 175B ( THRU SN 17556927 )**

**MATERIALS REQUIRED**

1. Domed or bubble windows Great Lakes Aero Products part number(s) W-, W/T-, W/G-2902-2, -4, or -6 ( RH ).
2. Rivets as required.
3. Sealant - Presstite # 579.6 or silicone sealant - I.E. GE or Dow Corning

**TOOLS REQUIRED**

1. Drill ( I.E. Air or Electric )
2. Drills or Drill set - proper sizes for rivets.
3. Rivet gun for rivets - or tool for cherry rivets - as required.

**REMOVAL AND INSTALLATION PROCEDURE**

1. Remove the upholstery as required.
2. Drill out the rivets that hold the retaining strip around the window. Only drill out enough rivets to allow the removal of the old window, and installation of the new bubble window.
3. Remove the window being carefull to not damage the structure of the door.
4. Carefully clean and inspect the door and retainer for any conditions that would create problems in installing the new window.
5. Compare the trimmed size of the bubbled window to the one you removed from the frame. Trim if necessary- see attached trimming instructions. NOTE: the skin on the door may be trimmed a slight amount if it interferes with the bubble portion of the new window.
6. Install the new window, again being careful to not damage the frame or the skin of the door. Sealant is used as necessary to prevent excessive leakage. When the new window is in the proper position the rivets can be reinstalled.
7. Fill out the necessary paperwork - I.E. 337 form.

## GREAT LAKES AERO PRODUCTS

### NOTES

- a. There is no change in weight and balance when standard windows are replaced.
- b. Mask the new window to protect it from getting scratched and to prevent making a mess on the window or the door with the sealant - as required.
- c. 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.
- d. There may be a negligible change to the airplane performance when domed windows are installed.