

915 Kearsley Park Blvd.
Flint, MI 48503



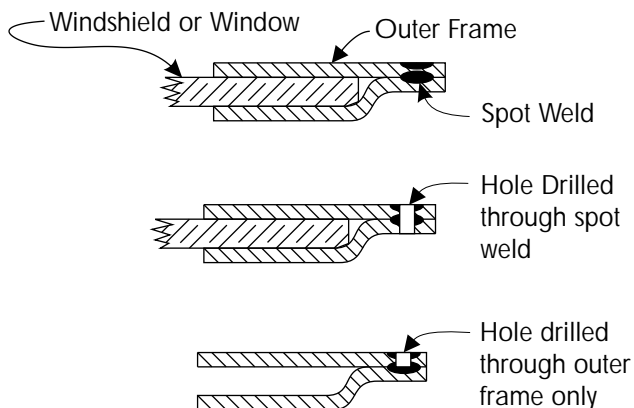
Instructions B-1

(810) 235-1402
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For Beechcraft Windshields and Windows with metal frames

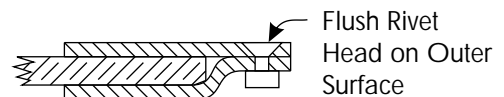
1. Remove the windshield (or window) assembly from the airplane.
2. Clean the edges of the metal frame - if rivets were used to fasten the inner & outer frames, remove the rivets.
3. If the assembly is spot welded - find the spot welds and drill through the center of the weld with a #30 drill. On some windshields it is only necessary to disassemble the lower half of the windshield assembly. On windows with hinges it may be easier if the hinge area is not disassembled.
4. Using a putty knife carefully separate the inner and outer frames by breaking the spot welds with the putty knife. If the welds are difficult to break a larger drill may have to be used (I.E. #21).
5. Remove the windshield (or window) from the frame. Clean and straighten the frame pieces so that it will reassemble properly and fit the new windshield (or window) into the frame (trim as necessary - see trimming instructions).
6. When a good fit is obtained, apply silicone sealant (or other approved sealant) to the mating surfaces and reassemble the frame and windshield (or window) assembly. **NOTE: IF THE WINDSHIELD IS CAREFULLY MASKED WITH MASKING TAPE IT WILL HELP TO MINIMIZE THE MESS OF THE SEALANT.** Flush rivets may be used in the holes drilled through the spot welds to hold the assembly together until it is replaced in the airframe - use rivets as required. On the openable hinged windows all the holes drilled in disassembly should be riveted.
7. Hinged windows may then be replaced in the airplane in the normal manner.
8. Replace the windshield (or window) assembly in the airplane using rivets or screws and locking nuts (I.E. AN 364) as required, and silicone sealant or other approved sealant. Use lighter fluid or VM&P naphtha to clean the sealant (careful masking will help minimize the mess from the sealant).

Disassembly - Typical Sections



Optional drilling of welds

Assembly - Typical Sections



Hinged Windows (Center)

