

56

WINDOWS

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56-TC (BA)

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WINDOWS

DESCRIPTION AND OPERATION

1. GENERAL

The windows are used for pilot and passengers visibility.

Visibility is ensured by an assembly of elements in plexiglas formed to the profile of the fuselage.

The main elements are :

- the windshield,
- the rear transparent panels,
- the door transparent panels.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Windshield	1	210	/	56-10-00
Rear transparent panel	2	210	/	56-20-00
Door transparent panel	2	210	/	56-30-00

3. DESCRIPTION

A. Windshield

The windshield is secured to the front section of the upper fuselage panel structure.

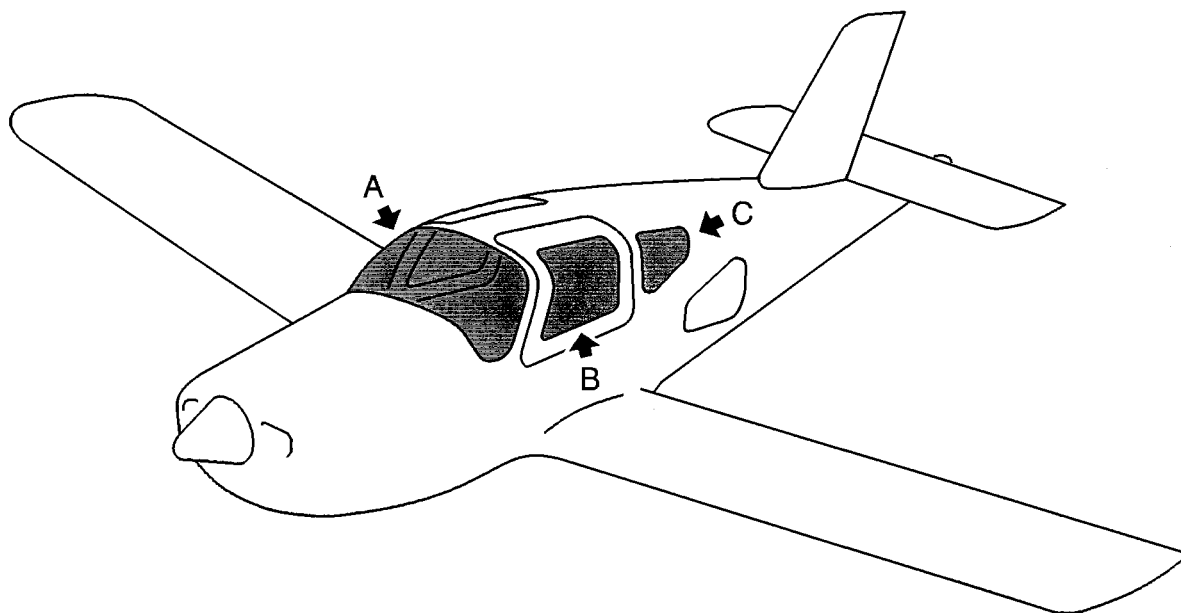
B. Rear transparent panel

The rear transparent panels are secured to the fuselage sidewalls.

C. Door transparent panel

The door transparent panels are secured to the access doors.

- A - Windshield
- B - Door transparent panel
- C - Rear transparent panel



1456000AAA BYZ4100

Windows - Identification and location of components
Figure 1

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JUN 01

WINDOWS

REPAIR

1. AUTHORIZED REPAIR OF SCRATCHES

NOTE : Repairable defects are defects such as scratches, grooves, dents, etc...

A. Tools and consumable materials

- Abrasive cloth (TB 05-916A), (TB 05-916B), (TB 05-916F) and (TB 05-916G)
- Unwoven cloth or cheese cloth (TB 11-911)
- Polishing product (TB 05-902)

B. Removal of scratches at low depth

- 1) Clean the area to be polished - refer to 12-22-04.
- 2) Using an unwoven cloth or cheese cloth (TB 11-911), apply a polishing product (TB 05-902) with circular movements over an area at least two or three times in diameter the length of the scratch to be repaired.
- 3) Wipe off and repeat the operation until the scratch disappears.
- 4) Clean the transparent panel - refer to 12-22-04.

C. Removal of defects not deeper than 0.004 in. (0.1 mm)

- 1) Clean the area to be repaired - refer to 12-22-04.
- 2) Polish the area to be repaired with abrasive cloth (TB 05-916) with decreasing sizes of abrasive and water.
- 3) Rinse with clear water and check the repair progress. Continue the polishing operation until the initial defect disappears.
- 4) Using unwoven cloth or cheese cloth (TB 11-911), apply a polishing product (TB 05-902) with circular movements over an area at least two or three times in diameter the length of the defect to be repaired.
- 5) Wipe off and repeat the operation until the defect disappears.
- 6) Clean the transparent panel - refer to 12-22-04.

2. REPAIR OF CRACKS (Figure 801)

A. Tools and consumable materials

- Abrasive cloth (TB 05-916A), (TB 05-916B), (TB 05-916F) and (TB 05-916G)
- Air gun
- Unwoven cloth or cheese cloth (TB 11-911)
- Adhesive tape (TB 08-919)
- Resin (TB 08-933)
- Syringe with a big needle
- Piece of wood
- Polishing product (TB 05-902)

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- Drill No. 47 (dia. 2 mm) sharpened to 150°
- Cylindrical milling cutter with very fine teeth

B. Procedure

- 1) Clean the transparent panel - refer to 12-22-04.

WARNING : ONLY REPAIR THOSE TRANSPARENT PANELS THE REPAIR OF WHICH DOES NOT ALTER THE PILOT VISIBILITY THROUGH THE WINDSHIELD (DEFORMATIONS) AND THOSE ON WHICH THE CRACK LENGTH DOES NOT EXCEED 0.787 in. (20 mm).

- 2) Check the location and the length of the crack. The crack must not exceed 0.787 in. (20 mm) and must not alter the pilot visibility through the windshield (deformations).
- 3) If the crack is longer than 0.787 in. (20 mm), replace the windshield - refer to 56-10-00.

CAUTION : MAKE SURE THE SURFACE IS FREE FROM SCRATCHES BEFORE PERFORMING CRACK STOPPAGE AND CHAMFERS.

- 4) If the crack is lower than or equal to 0.787 in. (20 mm), perform a crack stoppage. Drill a hole using a drill No. 47 (dia. 2 mm) sharpened to 150° at 0.20 in (5 mm) from the end of the crack (at both ends if necessary). Moderately press the drill point to avoid material overheating.

NOTE : If the crack starts at an attachment, remove the latter and enlarge the rivet or bolt hole by 0.039 in. (1 mm) max. using a cylindrical milling cutter with very fine teeth to remove other possible crack starts.

- 5) Put adhesive tape (TB 08-919) on both sides of the transparent panel around the crack to protect them against unforeseen scratches.
- 6) Chamfer both sides of the transparent panel using a tool for chamfering or a sharp knife blade.

NOTE : To make the tool for chamfering or sharpen the knife blade - refer to Figure 801.

- 7) Clean the transparent panel with an air gun.

CAUTION : READ THE TECHNICAL HANDBOOK ON RESIN (TB 08-933) CAREFULLY.

- 8) Prepare resin (TB 08-933), allow the solution to degas several minutes before emptying it into a syringe with a big needle.
- 9) Remove the air from the syringe, letting it eventually degas, then lay a fine thread of resin in each chamfer.
- 10) Plug the hole(s) drilled for crack stoppage and the chamfer with resin (TB 08-933). Wait for several minutes and do it again until attaining a light overthickness.
- 11) Carefully clean excess resin (TB 08-933).
- 12) Remove adhesive tape from the transparent panel when the resin is partially dry.
- 13) Wait for complete curing of resin (TB 08-933).
- 14) Carefully remove the resin overthickness using the tool for chamfering.

NOTE : This process is relatively long, but the final result depends on it. Scrape the bead flush as accurately as possible on both faces.

- 15) Sand using abrasive cloth (TB 05-916) with increasing sizes of abrasive and water.

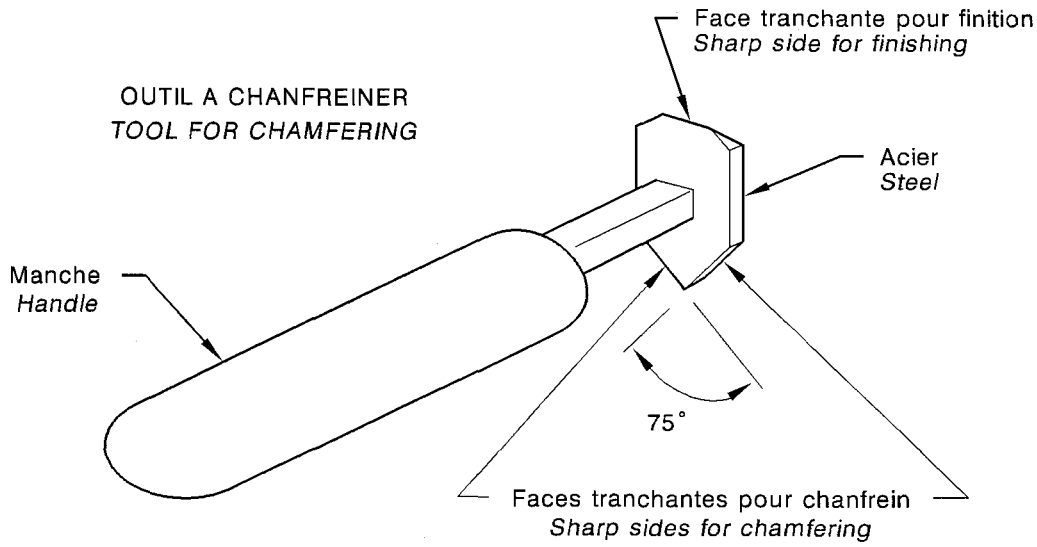
NOTE : Use a small piece of wood to direct the action of the abrasive cloth.

- 16) Using an unwoven cloth or cheese cloth (TB 11-911), apply a polishing product (TB 05-902) with circular movements.
- 17) Wipe off and repeat the polishing operation if necessary.
- 18) Clean the transparent panel - refer to 12-22-04.

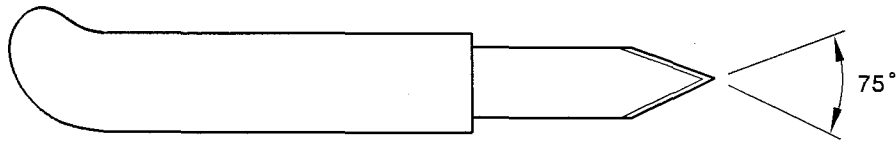
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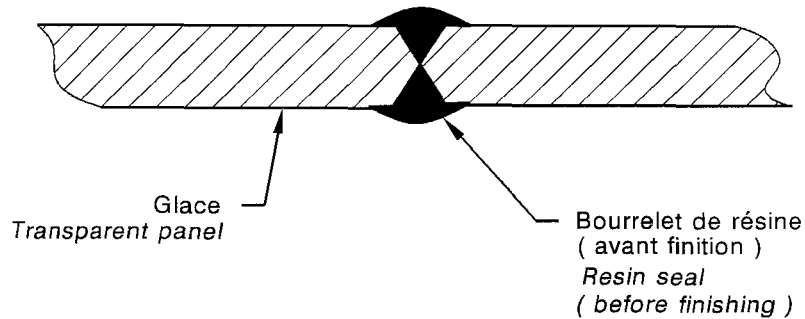
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LAME DE COUTEAU (meulée)
KNIFE BLADE (sharp)



SECTION DE LA ZONE CRIQUEE
CROSS SECTION OF THE CRACKED AREA



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Windows - Repair of cracks
Figure 801

WINDSHIELD

DESCRIPTION AND OPERATION

1. GENERAL

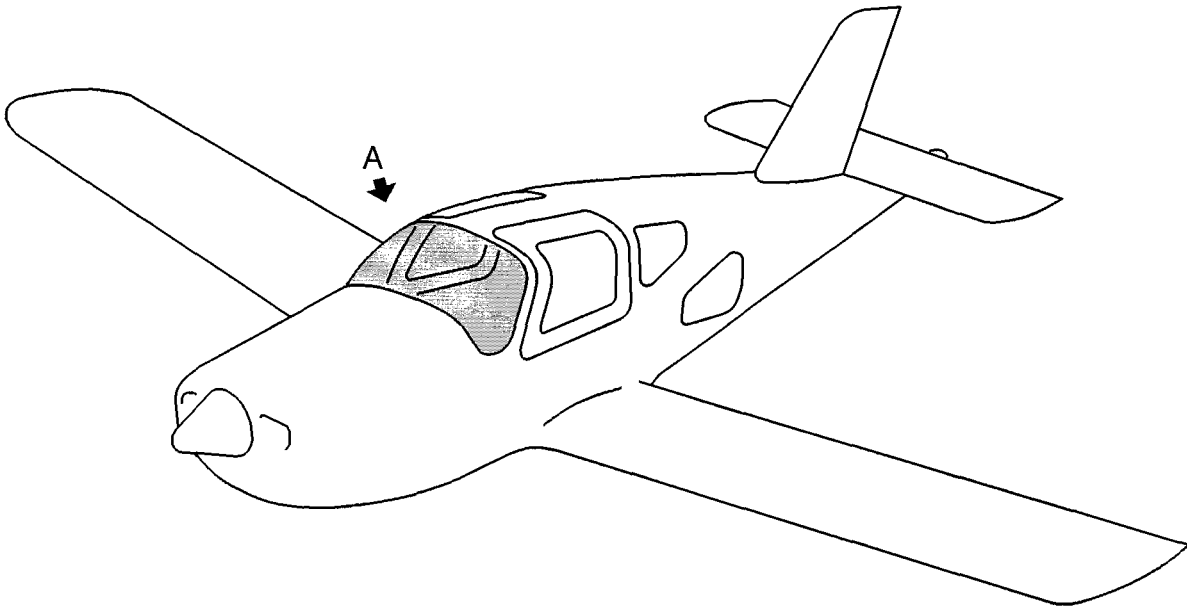
The windshield is secured to the front section of the upper fuselage panel structure.

The windshield is made of acrylic plastic (polycast).

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Windshield	1	210	/	56-10-00

A - Windshield



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Windshield - Identification and location of components
Figure 1

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56-10-00 (BA) Page 2
JUN 01

WINDSHIELD REMOVAL / INSTALLATION

1. REMOVAL OF THE WINDSHIELD (Figure 401)

A. Tools and consumable materials

- Drill No. 20 (dia. 4.1 mm) sharpened at 150°
- Spatula
- Warm air generator
- Adhesive tape (TB 08-919A)
- Cleaning agent (TB 11-003)
- Pneumatic vacuum-cleaner

B. Procedure

- 1) Remove the side upholstery panels of windshield front former.
- 2) Mask with adhesive tape the windshield edge and protect the fuselage, instrument panels and cabin inside with paper.

CAUTION : BEFORE DRILLING A BLIND RIVET, PUNCH OUT THE INNER SHANK OF THE RIVET BY MEANS OF A PIN DRIFT.

- 3) Punch out the inner shank of rivets.
- 4) Unrivet the windshield with a drill No. 20 (dia. 4.1 mm), equalize the remaining part of the rivet pin without damaging the former protection.

NOTE : During removal of rivets, mark the position of attachment bridges of front former upholstery panels.

- 5) Punch out the rivets with a pin drift.

CAUTION : UNBOND THE WINDSHIELD LENGTHWISE IN ORDER NOT TO DAMAGE ITS BEARING SURFACE.

- 6) Moderately heat the sealant bead with a warm air generator to soften sealant. Remove sealant bead using a spatula.
- 7) Unbond windshield, begin with L.H. and R.H. sides using spatulas, then unbond lengthwise.
- 8) Remove and discard windshield.
- 9) Unbond and discard the windshield seal and PR.

CAUTION : TAKE CARE NOT TO PROJECT CLEANING AGENT (TB 11-003) ON CABIN PADDING AND FRONT SEATS.

- 10) Remove the remaining PR from windshield posts with cleaning agent (TB 11-003).
- 11) Using a pneumatic vacuum cleaner, remove PR and rivet shank ends from the working area.

NOTE : In the front section, the rivet shank ends are not recoverable.

2. INSTALLATION OF THE WINDSHIELD (Figure 401)

NOTE : If the windshield is fastened with bolts, refer to SL 10-045-56 and apply Technical Instruction OPT10 9215-56.

A. Tools and consumable materials

- Drill No. 19 (dia. 4.2 mm) sharpened at 150°
- Drill No. 20 (dia. 4.1 mm) sharpened at 150°
- Sealant (TB 09-917)
- Drill No. 6 (dia. 5.2 mm) sharpened at 150°
- Sealant (TB 09-908)
- Rivets
- Abrasive cloth (TB 05-916A)
- Pins dia. 0.157 in. (4 mm)
- Strap
- Spatula
- Adhesive tape (TB 08-919A)
- Lintfree clean cloths
- Isopropyl alcohol (TB 10-002)
- Scriber

B. Procedure

CAUTION : TAKE ALL NECESSARY PRECAUTIONS TO AVOID SCRATCHING THE WINDSHIELD.

- 1) Check the seating surface for correct condition.
- 2) If the windshield has to be replaced, perform as follows :
 - a) Position the new windshield on the upper fuselage panel and release its protection from the attachment hole area.
 - b) With a strap, hold the windshield on the upper fuselage panel.
 - c) Drill the windshield to match existing holes in the upper fuselage panel. Use a drill 1/8" (dia. 3.2 mm) sharpened at 150° - refer to Figure 401. Moderately press the drill point to avoid material overheating.
 - d) Counterdrill the windshield with a drill No. 6 (dia. 5.2 mm) sharpened at 150° - refer to Figure 401. Moderately press the drill point to avoid material overheating and temporarily secure with pins dia. 0.157 in (4 mm) as you progress.
 - e) Remove the strap, the pins and the windshield.
 - f) Vacuum-clean drilling chips from the working area with a pneumatic vacuum-cleaner.
- 3) Clean the windshield periphery with isopropyl alcohol (TB 10-002).
- 4) Clean the windshield seating surface on the upper fuselage panel with isopropyl alcohol (TB 10-002).
- 5) Put sealant (TB 09-908) on the windshield seating surface on the upper fuselage panel.

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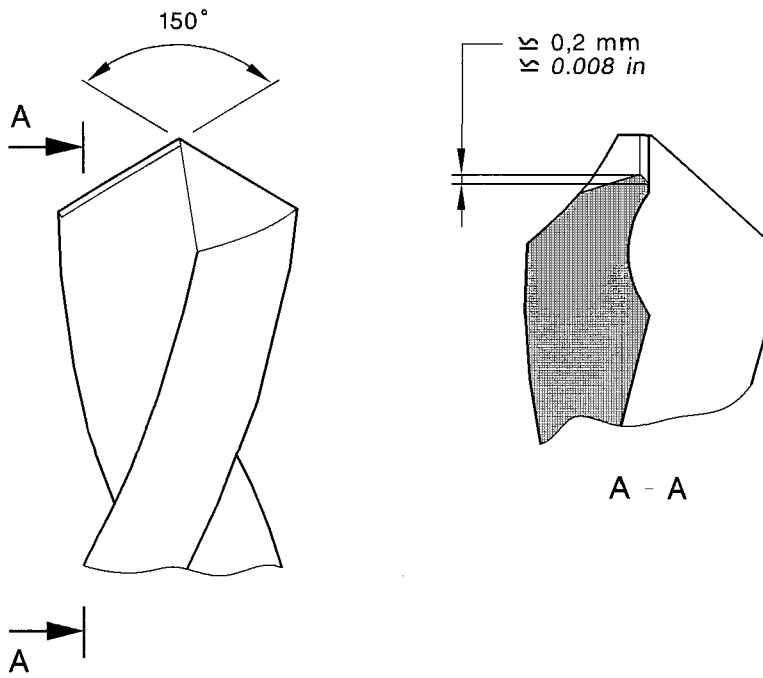
- 6) Perforate attachment holes into sealant (TB 09-908) using a scribe.
- 7) Remove protective paper from sealant (TB 09-908).
- 8) Position the windshield, dry and clean, on the upper fuselage panel.
- 9) Strap and temporarily secure the windshield with pins.
- 10) Secure the windshield with the rivets - refer to 51-40-02.

NOTE : During rivet installation, put attachment bridges of front former upholstering panels as indicated during removal.

- 11) Remove the strap.
- 12) Plug the holes of rivet inner shanks with sealant (TB 09-917) - refer to 20-00-09.
- 13) Clean windshield periphery with a lintfree clean cloth moistened with isopropyl alcohol (TB 10-002).
- 14) Protect the windshield panel with adhesive tape (TB 08-919A) so that only the location of the sealant bead appears.
- 15) Make sealant bead with sealant (TB 09-917) - refer to 20-00-09.

NOTE : Apply 2 coats at the lower part of the windshield.

- 16) Remove adhesive tape from the windshield and from the upper fuselage panel after sealant partial drying (12 to 24 hours).
- 17) Wait for complete curing of sealant (TB 09-917).
- 18) If necessary, remove the windshield protection.
- 19) Sprinkle the windshield to check its tightness.
- 20) Make sure all the tools and materials are removed and the work area is clean and free from debris.
- 21) If necessary, perform paint touch-ups - refer to 20-00-03.
- 22) Install the side upholstery panels of the windshield front former.
- 23) Clean the windshield - refer to 12-22-04.



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Windshield - Removal / Installation
Figure 401

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WINDSHIELD

REMOVAL / INSTALLATION

1. REMOVAL OF THE WINDSHIELD (Figure 401)

A. Tools and consumable materials

- Spatulas
- Warm air generator
- Adhesive tape (TB 08-919A)

B. Procedure

- 1) Remove the side upholstery panels of windshield front former.
- 2) Protect the paint of upper fuselage panel around windshield (1) with adhesive tape (TB 08-919A).
- 3) Remove screws (3) and washers (2).
- 4) Moderately heat sealant bead (4) with a warm air generator to soften sealant. Remove sealant bead (4) using a spatula.
- 5) De-bond windshield (1) with spatulas. Begin with L.H. and R.H. sides.
- 6) Remove and discard windshield (1).

2. INSTALLATION OF THE WINDSHIELD (Figure 401)

A. Tools and consumable materials

- Adhesive tape (TB 08-919A)
- Cleaning agent (TB 11-922)
- Primer (TB 16-911)
- Cleaning agent (TB 11-921)
- Adhesive (TB 08-934)
- Sealant (TB 09-917)
- Lintfree clean cloths
- Isopropyl alcohol (TB 10-002)
- Sealant (TB 09-919)
- Loctite (TB 08-908)

B. Procedure

CAUTION : TAKE ALL NECESSARY PRECAUTIONS TO AVOID SCRATCHING THE WINDSHIELD.

- 1) Remove any adhesive and sealant residues from the upper fuselage panel and rubber stops (5). Inspect the bonding surface for condition.
- 2) Bond new rubber stops (5) on upper fuselage panel with loctite (TB 08-908) - refer to 20-00-08.

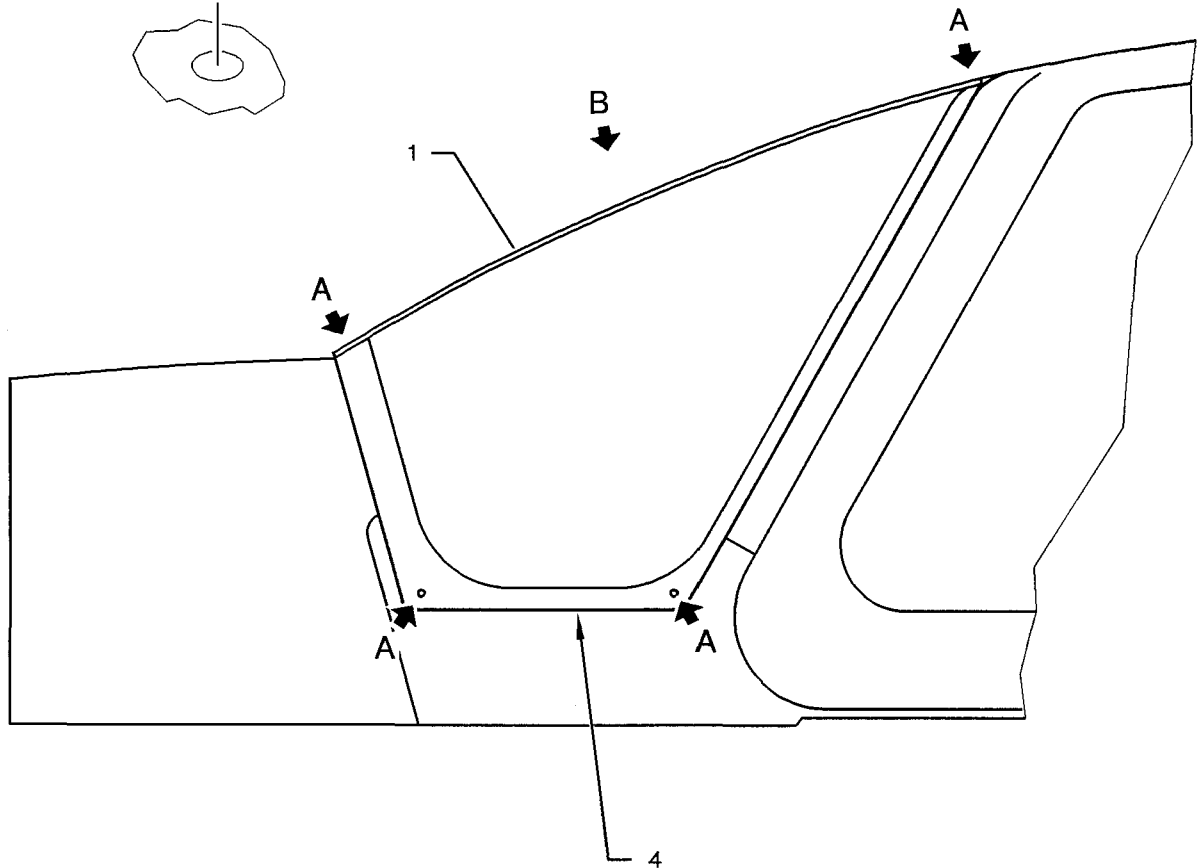
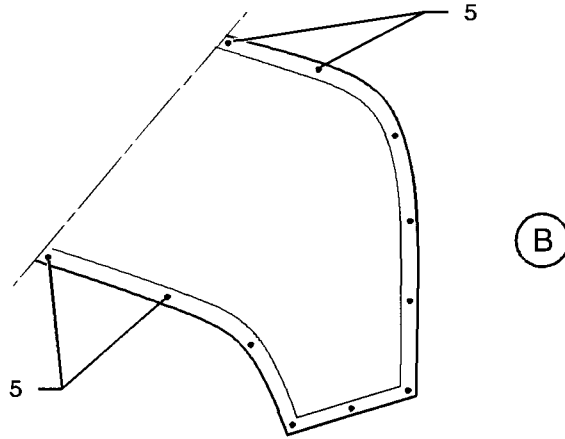
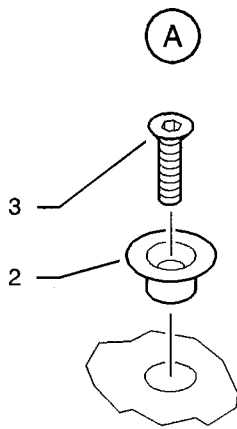
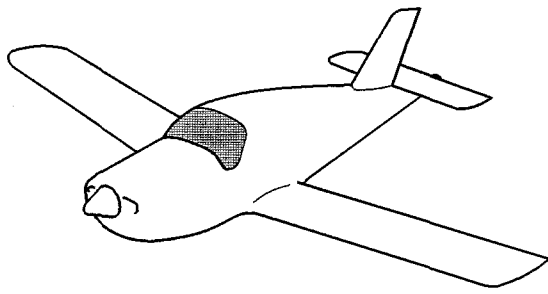
NOTE : To determine the position of rubber stops (5) - refer to Detail B.

- 3) Perform paint touch-ups as required - refer to 20-00-03.
- 4) Install windshield (1) with screws (3) and washers (2). Do not tighten screws (3).
NOTE : Clear the protection of windshield (1) over a width of about 2 in. (50 mm).
- 5) Make sure windshield (1) is correctly positioned. Reposition if necessary.
- 6) Remove windshield (1).
- 7) Clean the bonding surface of the windshield with isopropyl alcohol (TB 10-002), wait for 10 minutes and apply primer (TB 16-911). Allow to dry.
- 8) Clean the bonding surface of the upper fuselage panel with cleaning agent (TB 11-922).

CAUTION : READ THE TECHNICAL HANDBOOK ON ADHESIVE (TB 08-934) CAREFULLY.

- 9) Apply adhesive (TB 08-934) on the bonding surface of the upper fuselage panel.
NOTE : Apply the adhesive evenly over a 0.08 in. (2 mm) thick layer.
- 10) Apply sealant (TB 09-919) on the seating face of washers (2) - refer to 20-00-09.
- 11) Install the windshield with washers (2) and screws (3). Moderately tighten screws (3) to avoid windshield cracking.
NOTE : Slightly press the windshield periphery to level adhesive.
- 12) Clean excess adhesive around washers (2) with a lintfree clean cloth moistened with isopropyl alcohol (TB 10-002).
- 13) Clean excess adhesive with a lintfree clean cloth moistened with cleaning agent (TB 11-921).
- 14) Allow to dry.
- 15) Protect the windshield panel with adhesive tape (TB 08-919A) so that only the location of sealant bead (4) appears.
- 16) Make sealant bead (4) with sealant (TB 09-917) - refer to 20-00-09.
- 17) Remove adhesive tape from the windshield and the upper fuselage panel after sealant partial drying (12 to 24 hours).
- 18) Wait for complete curing of sealant (TB 09-917).
- 19) Remove the protection of windshield (1).
- 20) Sprinkle windshield (1) to check its tightness.
- 21) Make sure all the tools and materials are removed and the work area is clean and free from debris.
- 22) Install the side upholstery panels of the windshield front former.
- 23) Perform paint touch-ups as required - refer to 20-00-03.
- 24) Clean windshield (1) - refer to 12-22-04.

- 1 - Windshield
- 2 - Washer
- 3 - Screw
- 4 - Sealant bead
- 5 - Rubber stop



Windshield - Removal / Installation
Figure 401

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ABAA
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**REAR TRANSPARENT PANEL
DESCRIPTION AND OPERATION**

1. GENERAL

The rear transparent panels are secured to the fuselage sidewalls.

The rear transparent panels are made of acrylic plastic (polycast).

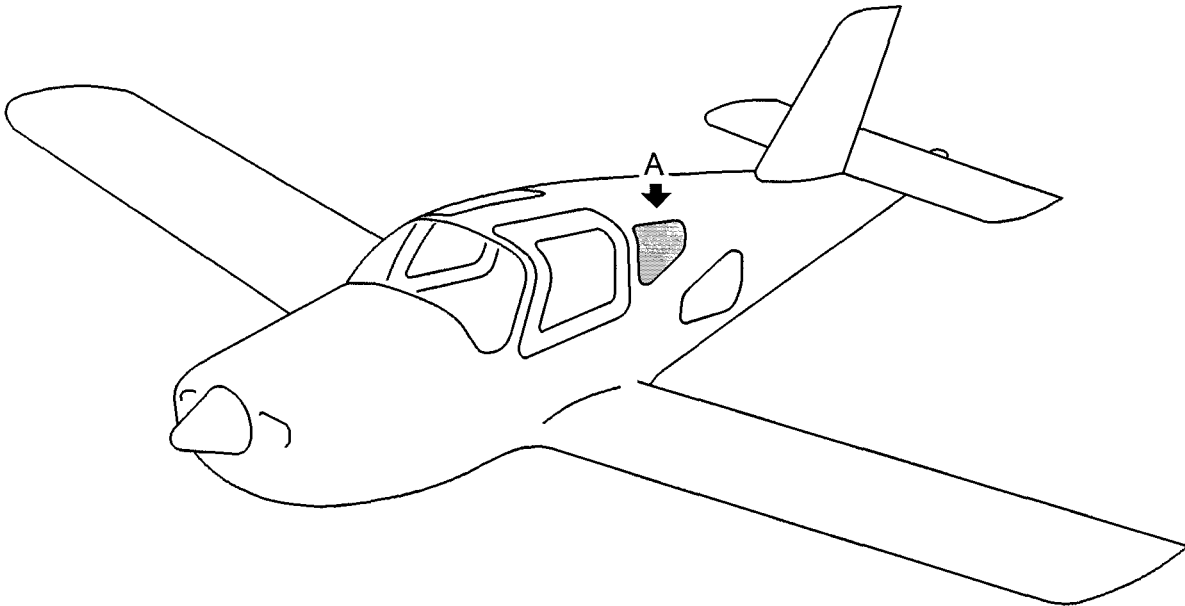
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The rear transparent panels can be equipped with an air cooling scoop.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Rear transparent panel	2	210	/	56-20-00

A - Rear transparent panel



I4560000AAAABYZ14000

Rear transparent panel - Identification and location of components
Figure 1

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REAR TRANSPARENT PANEL

REMOVAL / INSTALLATION

NOTE : This procedure is applicable to L.H. and R.H. installations. Information specific to R.H. installation are given in square brackets.

1. REMOVAL OF THE REAR TRANSPARENT PANEL (Figure 401)

A. Tools and consumable materials

- Spatulas
- Warm air generator
- Adhesive tape (TB 08-919A)

B. Procedure

- 1) Open the access door.
- 2) Remove the upholstery panel of rear transparent panel (4) [5].
- 3) Protect the paint of upper fuselage panel around rear transparent panel (4) [5] with adhesive tape (8) (TB 08-919A).
- 4) Remove screws (3) and washers (2).
- 5) Moderately heat sealant bead (9) with a warm air generator to soften sealant. Remove sealant bead (9) using a spatula.

CAUTION : UNBOND THE REAR TRANSPARENT PANEL LENGTHWISE IN ORDER NOT TO DAMAGE ITS BEARING SURFACE.

- 6) Unbond rear transparent panel (4) [5] with spatulas. Begin with the front side then unbond lengthwise.
- 7) Remove and discard rear transparent panel (4) [5].

2. INSTALLATION OF THE REAR TRANSPARENT PANEL (Figure 401)

A. Tools and consumable materials

- Abrasive cloth (TB 05-916A)
- Adhesive tape (TB 08-919A)
- Cleaning agent (TB 11-922)
- Primer (TB 16-911)
- Cleaning agent (TB 11-921)
- Adhesive (TB 08-934)
- Sealant (TB 08-004B)
- Sealant (TB 09-917)
- Lintfree clean cloths
- Isopropyl alcohol (TB 10-002)
- Sealant (TB 09-919)

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- Loctite (TB 08-908)

B. Procedure

- 1) Remove any adhesive and sealant residues from the upper fuselage panel and rubber stops (10). Inspect the bonding surface for condition.
- 2) Bond new rubber stops (10) on upper fuselage panel with loctite (TB 08-908) – refer to 20-00-08.
- 3) Install rear transparent panel (4) [5] with screws (3) and washers (2). Do not tighten screws (3).

NOTE : Clear the protection of rear transparent panel (4) [5] over a width of about 2 in. (50 mm).

- 4) Make sure rear transparent panel (4) [5] is correctly positioned. Reposition if necessary.
- 5) Remove rear transparent panel (4) [5].
- 6) Clean the bonding surface of rear transparent panel (4) [5] with isopropyl alcohol (TB 10-002), wait for 10 minutes and apply primer (TB 16-911). Allow to dry.
- 7) Bond new seal (6) to rear transparent panel (4) [5] with sealant (TB 08-004B). Allow to dry.
- 8) Sand the bonding surface of the upper fuselage panel with abrasive cloth (TB 05-916A). Clean the bonding surface with cleaning agent (TB 11-922).
- 9) Using adhesive tape (TB 08-919A), protect contact surface (7) of seal (6) of rear transparent panel (4) [5] on the upper fuselage panel bonding surface.

CAUTION : READ THE TECHNICAL HANDBOOK ON ADHESIVE (TB 08-934) CAREFULLY.

- 10) Apply adhesive (TB 08-934) on the bonding surface of the upper fuselage panel.

NOTE : Apply the adhesive evenly over a 0.08 in. (2 mm) thick layer.

- 11) Remove adhesive tape from contact surface (7).
- 12) Apply sealant (TB 09-919) on the seating face of washers (2) – refer to 20-00-09.
- 13) Install rear transparent panel (4) [5] with washers (2) and screws (3). Moderately tighten screws (3) to avoid rear transparent panel cracking.

NOTE : Slightly press the rear transparent panel periphery to level adhesive.

- 14) Clean excess sealant around washers (2) with a lintfree clean cloth moistened with isopropyl alcohol (TB 10-002).
- 15) Clean excess adhesive with a lintfree clean cloth moistened with cleaning agent (TB 11-921).
- 16) Allow to dry.
- 17) Protect the rear transparent panel with adhesive tape (TB 08-919A) so that only the location of sealant bead (9) appears.
- 18) Make sealant bead (9) with sealant (TB 09-917) – refer to 20-00-09.
- 19) Remove adhesive tape from the rear transparent panel and the upper fuselage panel after sealant partial drying (12 to 24 hours).
- 20) Wait for complete curing of sealant (TB 09-917).
- 21) Remove the protection of rear transparent panel (4) [5] and close the access door.
- 22) Sprinkle the rear transparent panel (4) [5] to check its tightness.
- 23) Make sure all the tools and materials are removed and the work area is clean and free from debris.

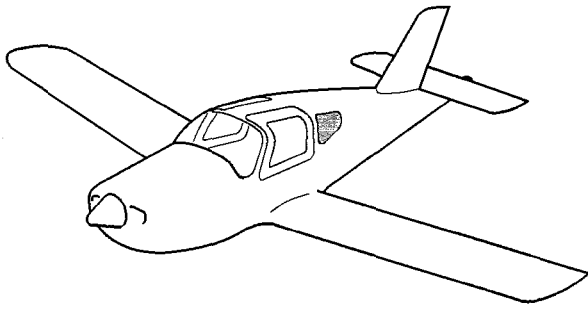
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- 24) Install the upholstery panel of the rear transparent panel.
- 25) Perform paint touch-ups as required - refer to 20-00-03.
- 26) Clean rear transparent panel (4) [5] - refer to 12-22-04.

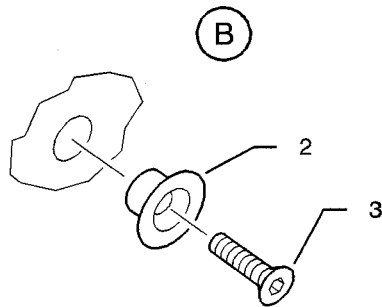
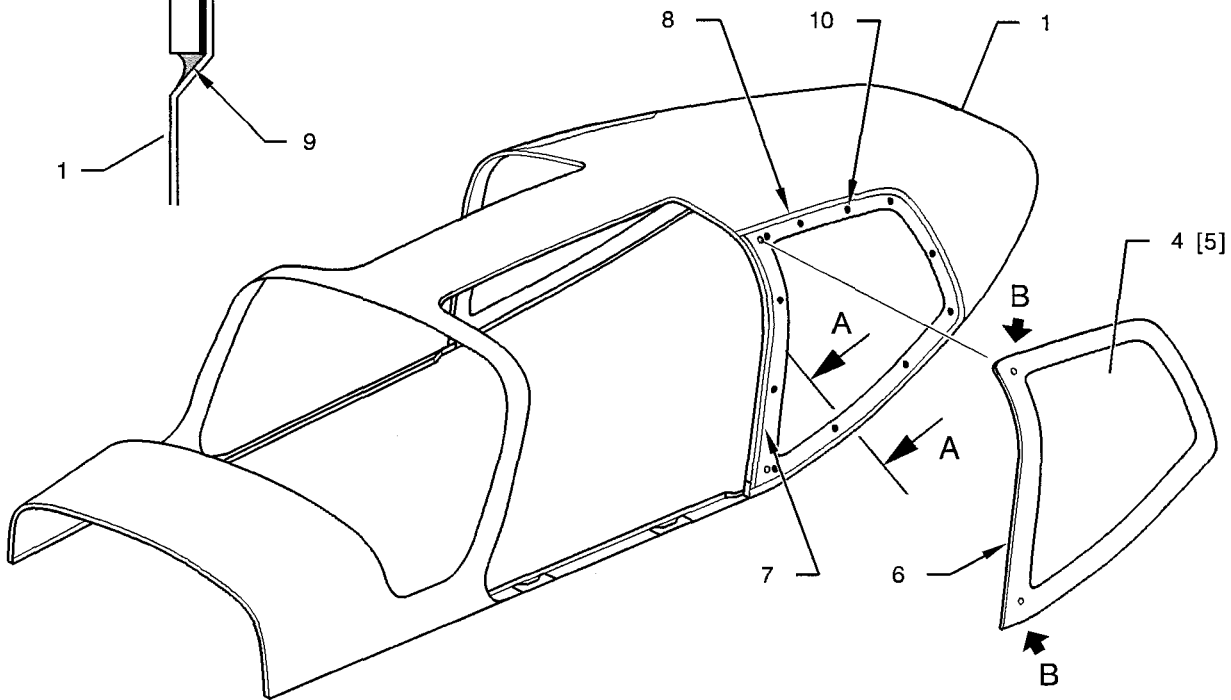
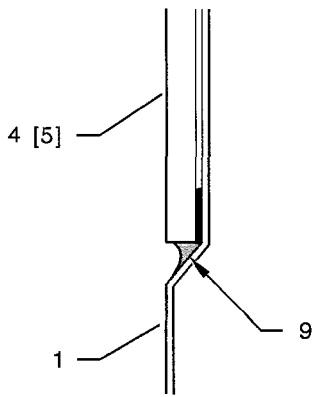
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- 1 - Upper fuselage panel
- 2 - Washer
- 3 - Screw
- 4 - L.H. rear transparent panel
- 5 - R.H. rear transparent panel
- 6 - Seal
- 7 - Contact surface
- 8 - Adhesive tape
- 9 - Sealant bead
- 10 - Rubber stop

A - A



Rear transparent panel - Removal / Installation
Figure 401

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**DOOR TRANSPARENT PANEL
DESCRIPTION AND OPERATION**

1. GENERAL

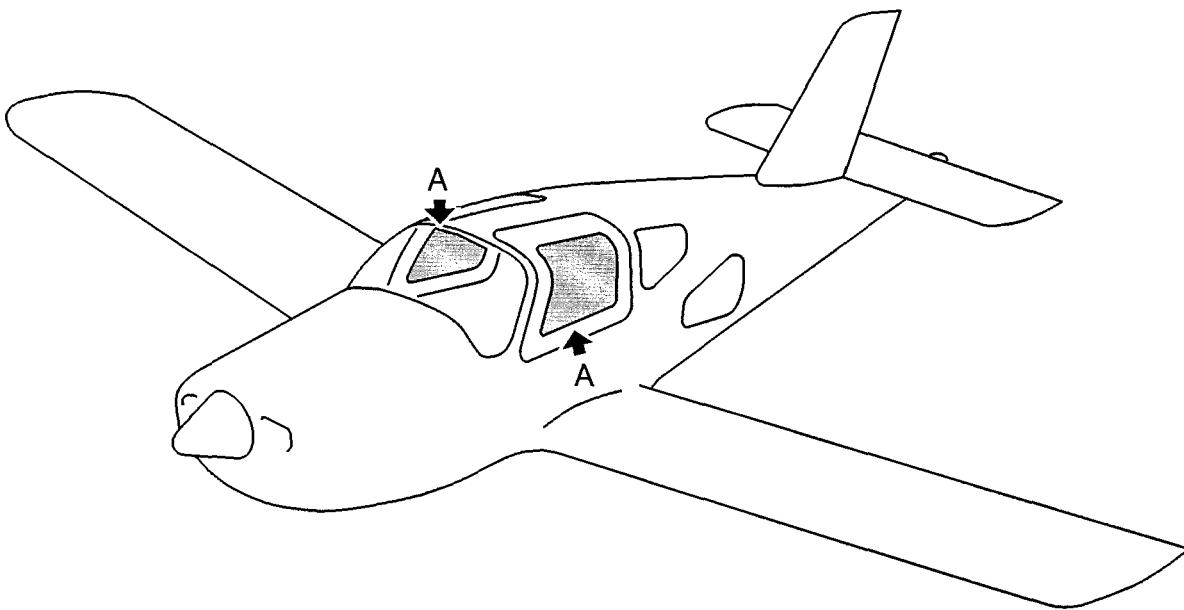
The door transparent panels are secured to the access doors.

The door transparent panels are made of acrylic plastic (polycast).

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Door transparent panel	2	210	/	56-30-00

A - Door transparent panel



1456000AAA BYZ14100

Door transparent panel - Identification and location of components
Figure 1

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Validity : S / N 1 - 9999

DOOR TRANSPARENT PANEL

REMOVAL / INSTALLATION

NOTE : This procedure is applicable to L.H. and R.H. installations. Information specific to R.H. installation are given in square brackets.

1. REMOVAL OF THE DOOR TRANSPARENT PANEL (Figure 401)

A. Tools and consumable materials

- Drill No. 22 (dia. 4 mm)
- Spatulas

B. Procedure

- 1) Remove access door (5) [6] - refer to 52-10-00.
- 2) Remove the upholstery panel of access door (5) [6].
- 3) Remove the rivets securing transparent panel (1) [2] using a drill No. 22 (dia. 4 mm) - refer to 51-40-02.

NOTE : Discard rivet washers (3).

CAUTION : UNBOND THE TRANSPARENT PANEL LENGTHWISE IN ORDER NOT TO DAMAGE ITS BEARING SURFACE.

- 4) Unbond transparent panel (1) [2] with spatulas. Begin with L.H. and R.H. sides then unbond lengthwise.
- 5) Remove and discard transparent panel (1) [2].

2. INSTALLATION OF THE DOOR TRANSPARENT PANEL (Figure 401)

A. Tools and consumable materials

- Adhesive tape (TB 08-919A)
- Cleaning agent (TB 11-916)
- Cleaning agent (TB 11-003)
- Sealant (TB 09-908)
- Sealant (TB 09-900)
- Drill No. 22 (dia. 4 mm)
- Drill No. 12 (dia. 4.8 mm)
- Pin, 5/32" (dia. 4 mm)
- Countersink
- Shim AU4G, thickness 0.04 in (1 mm)
- Lintfree clean cloths
- Spatulas
- Scriber

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Validity : S / N 1 - 764, 766 - 878

B. Procedure

- 1) Remove any sealant residues from access door (5) [6] using a lintfree clean cloth moistened with cleaning agent (TB 11-003).
- 2) Inspect access door (5) [6] posts for deformation.
- 3) Position transparent panel (1) [2] on access door (5) [6] and check for correct seating.
- 4) Check transparent panel (1) [2] for correct centering on access door (5) [6], adjust if necessary.
- 5) Back-drill two diametrically opposite holes with a drill No. 22 (dia. 4 mm).
- 6) Remove transparent panel (1) [2] and clear the protection from the attachment holes area.
- 7) Position transparent panel (1) [2] on access door (5) [6] and attach with pins.

NOTE : Insert 0.04 in (1 mm) shims to take into account the thickness of sealant (4) (TB 09-908).

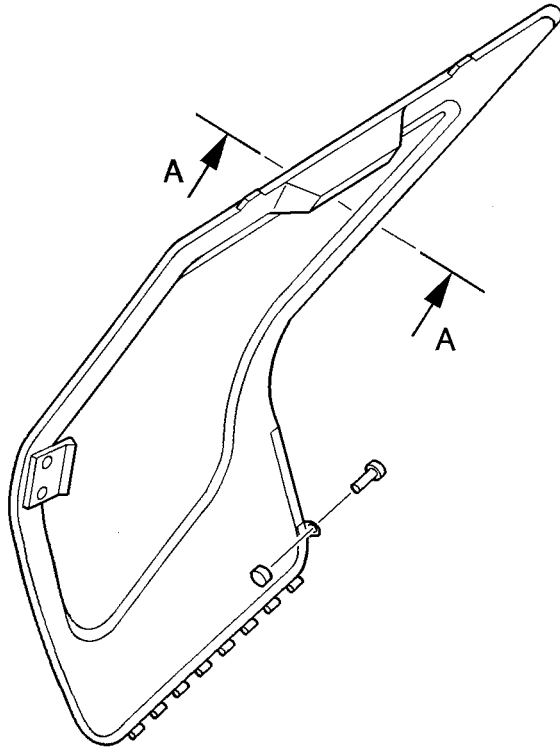
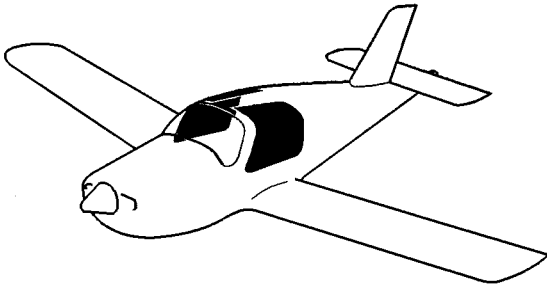
- 8) Back-drill the attachment holes in transparent panel (1) [2] with a drill No. 22 (dia. 4 mm). Start at the door centerline, then drill alternately so that transparent panel (1) [2] seats without stress. Temporarily secure with pins as you drill.
- 9) Remove the pins and transparent panel (1) [2].
- 10) Counterdrill the attachment holes of transparent panel (1) [2] with a drill No. 12 (dia. 4.8 mm).
- 11) Deburr the attachment holes of transparent panel (1) [2] with a countersink.
- 12) Deburr and slightly chamfer the periphery of transparent panel (1) [2].
- 13) Vacuum-clean the drilling chips from the work area.
- 14) Clean the seating surface of access door (5) [6] with a lintfree clean cloth moistened with cleaning agent (TB 11-003).
- 15) Apply sealant (4) (TB 09-908) on the seating surface of access door (5) [6].
- 16) Perforate the attachment holes in sealant (4) (TB 09-908) using a scribe.
- 17) Clean the seating surface of transparent panel (1) [2] with a lintfree clean cloth moistened with cleaning agent (TB 11-916).
- 18) Remove the protection paper from sealant (4) (TB 09-908).
- 19) Position transparent panel (1) [2] on access door (5) [6] and attach with pins.
- 20) Secure transparent panel (1) [2] with rivets (7) and new rivet washers (3) - refer to 51-40-02.
- 21) Blank off the internal pin holes of rivets (7) with sealant (TB 09-900) - refer to 20-00-09.
- 22) Clean the periphery of transparent panel (1) [2] with a lintfree clean cloth moistened with cleaning agent (TB 11-916).
- 23) Protect transparent panel (1) [2] with adhesive tape (9) (TB 08-919A) so that only the 0.2 in (5 mm) location of sealant bead (8) appears.
- 24) Make sealant bead (8) with sealant (TB 09-900) - refer to 20-00-09.
- 25) Remove adhesive tape (9) from transparent panel (1) [2] after sealant partial drying (12 to 24 hours).
- 26) Wait for complete curing of sealant (TB 09-900).

- 27) Remove the protection of transparent panel (1) [2].
- 28) Install access door (5) [6] - refer to 52-10-00.
- 29) Sprinkle access door (5) [6] to check its tightness.
- 30) Make sure all the tools and materials are removed and the work area is clean and free from debris.
- 31) Perform paint touch-ups - refer to 20-00-03.
- 32) Install the upholstery panel of access door (5) [6].
- 33) Clean the transparent panel (1) [2] - refer to 12-22-04.

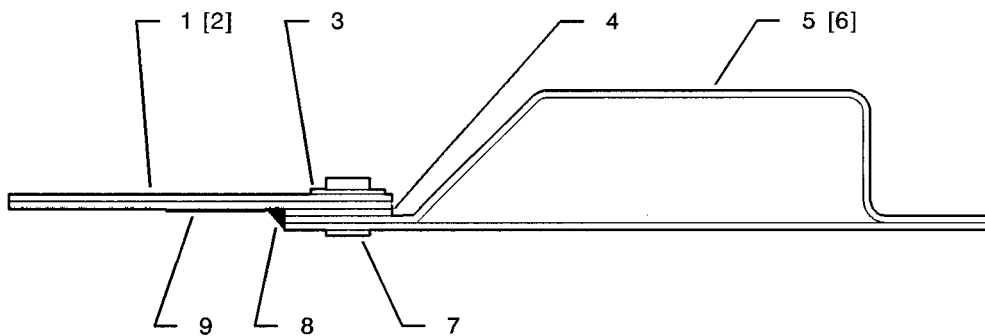
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- 1 - L.H. transparent panel
- 2 - R.H. transparent panel
- 3 - Rivet washer
- 4 - Sealant
- 5 - L.H. access door
- 6 - R.H. access door
- 7 - Rivet
- 8 - Sealant bead
- 9 - Adhesive tape



A - A



Access door transparent panel - Removal / Installation
Figure 401

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DOOR TRANSPARENT PANEL

REMOVAL / INSTALLATION

NOTE : This procedure is applicable to L.H. and R.H. installations. Information specific to R.H. installation are given in square brackets.

1. REMOVAL OF THE DOOR TRANSPARENT PANEL (Figure 401)

A. Tools and consumable materials

- Warm air generator
- Spatulas

B. Procedure

- 1) Remove access door (6) [7] - refer to 52-10-00.
- 2) Moderately heat sealant beads (5) and (9) with a warm air generator to soften sealant. Remove sealant beads (5) and (9) using a spatula.

CAUTION : UNBOND THE TRANSPARENT PANEL LENGTHWISE IN ORDER NOT TO DAMAGE ITS BEARING SURFACE.

- 3) Unbond transparent panel (1) [2] with spatulas. Begin with L.H. and R.H. sides then unbond lengthwise.
- 4) Remove and discard transparent panel (1) [2].

2. INSTALLATION OF THE DOOR TRANSPARENT PANEL (Figure 401)

A. Tools and consumable materials

- Adhesive tape (TB 08-919A)
- Cleaning agent (TB 11-916)
- Cleaning agent (TB 11-003)
- Sealant (TB 09-908)
- Sealant (TB 09-900)
- Clamps
- Lintfree clean cloths
- Spatulas

B. Procedure

- 1) Remove any sealant residues from access door (6) [7] using a lintfree clean cloth moistened with cleaning agent (TB 11-003).
- 2) Inspect access door (6) [7] posts for deformation.
- 3) Position transparent panel (1) [2] on access door (6) [7] and check for correct seating.

NOTE : Clear the protection of transparent panel (1) [2] over a width of about 2 in. (50 mm).

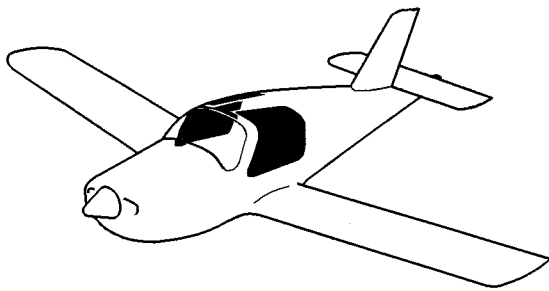
- 4) Make sure transparent panel (1) [2] is correctly positioned on access door (6) [7]. Reposition if necessary.

ABAB

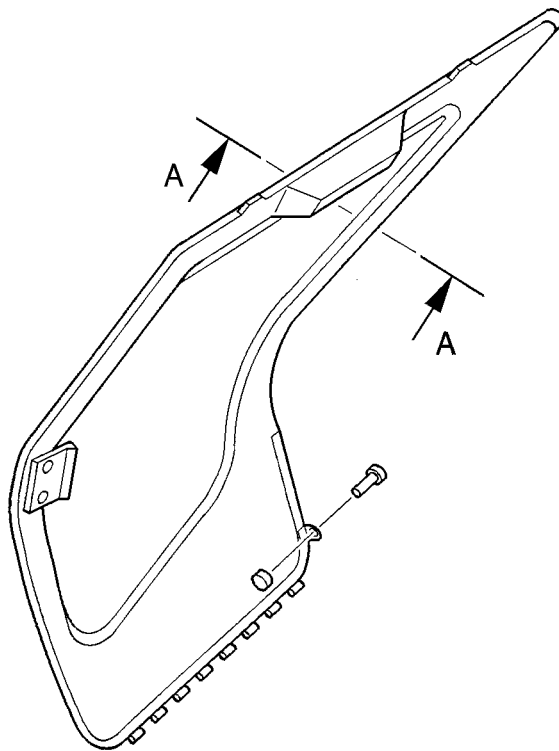
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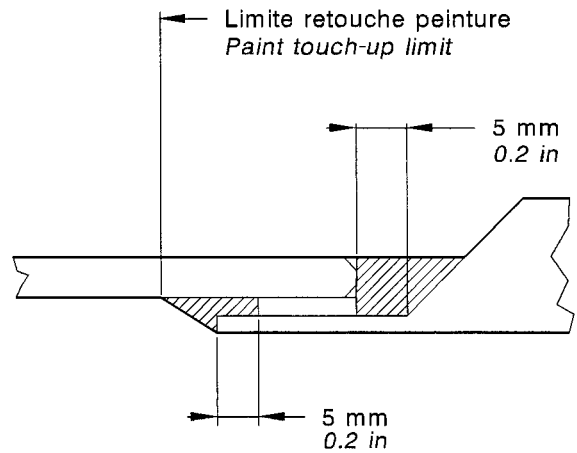
- 5) Hold transparent panel (1) [2] on access door (6) [7] with clamps.
- 6) Delimit the internal periphery of transparent panel (1) [2] with adhesive tape (3) (TB 08-919A) so as to obtain a clearance of 0.2 in [+ 0.04 ; - 0] (5 mm [+ 1 ; - 0]) - refer to Detail B.
- 7) Protect transparent panel (1) [2] with adhesive tape (8) (TB 08-919A) so that only the location of 0.2 in. (5 mm) of sealant bead (9) appears.
- 8) Remove transparent panel (1) [2].
- 9) Cut out transparent panel (1) [2] along the limit marked by adhesive tape (3) (TB 08-919A). Deburr and slightly chamfer the periphery of transparent panel (1) [2].
- 10) Clean the seating surface of access door (6) [7] with a lintfree clean cloth moistened with cleaning agent (TB 11-003).
- 11) Apply sealant (4) (TB 09-908) on the seating surface of access door (6) [7] - refer to Detail B.
- 12) Clean the seating surface of transparent panel (1) [2] with a lintfree clean cloth moistened with cleaning agent (TB 11-916).
- 13) Remove the protection paper from sealant (4) (TB 09-908).
- 14) Install transparent panel (1) [2] on access door (6) [7] and secure with clamps.
- 15) Make sealant bead (9) with sealant (TB 09-900) - refer to 20-00-09.
- 16) Make sealant bead (5) with sealant (TB 09-900) - refer to 20-00-09.
- 17) Remove adhesive tapes (3) and (8) from transparent panel (1) [2] after sealant partial drying (12 to 24 hours).
- 18) Wait for complete curing of sealant (TB 09-900).
- 19) Remove clamps and remove the protection of transparent panel (1) [2].
- 20) Install access door (6) [7] - refer to 52-10-00
- 21) Sprinkle access door (6) [7] to check its tightness.
- 22) Make sure all the tools and materials are removed and the work area is clean and free from debris.
- 23) Perform paint touch-ups as required - refer to 20-00-03.
- 24) Clean transparent panel (1) [2] - refer to 12-22-04.



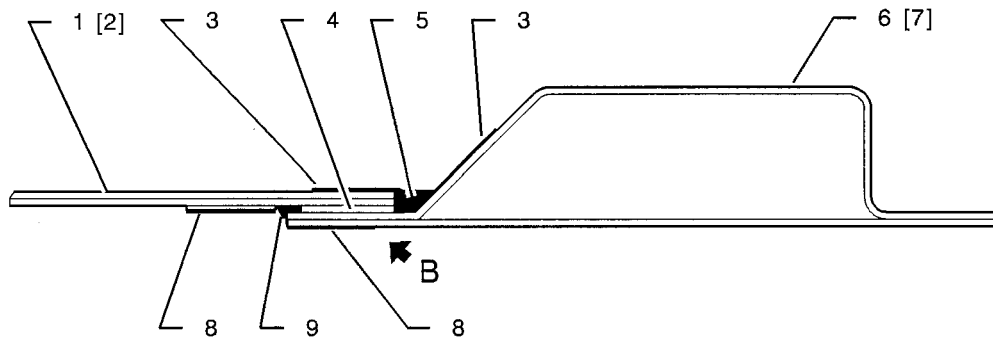
- 1 - L.H. transparent panel
- 2 - R.H. transparent panel
- 3 - Adhesive tape
- 4 - Sealant
- 5 - Sealant bead
- 6 - L.H. access door
- 7 - R.H. access door
- 8 - Adhesive tape
- 9 - Sealant bead



(B)



A - A



Access door transparent panel - Removal / Installation
Figure 401

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DOOR TRANSPARENT PANEL

REMOVAL / INSTALLATION

NOTE : This procedure is applicable to L.H. and R.H. installations. Information specific to R.H. installation are given in square brackets.

1. REMOVAL OF THE DOOR TRANSPARENT PANEL (Figure 401)

A. Tools and consumable materials

- Spatulas
- Warm air generator
- Adhesive tape (TB 08-919A)

B. Procedure

- 1) Close access door (1) [2].
- 2) Remove the upholstery panel of access door (1) [2].
- 3) Protect the paint of access door (1) [2] around transparent panel (5) [6] with adhesive tape (9) (TB 08-919A).
- 4) Remove screws (4) and washers (3).
- 5) Moderately heat sealant bead (10) with a warm air generator to soften sealant. Remove sealant bead (10) using a spatula.

CAUTION : UNBOND THE TRANSPARENT PANEL LENGTHWISE IN ORDER NOT TO DAMAGE ITS BEARING SURFACE.

- 6) Unbond transparent panel (5) [6] with spatulas. Begin with L.H. and R.H. sides then unbond lengthwise.
- 7) Remove and discard transparent panel (5) [6].

2. INSTALLATION OF THE DOOR TRANSPARENT PANEL (Figure 401)

A. Tools and consumable materials

- Abrasive cloth (TB 05-916A)
- Adhesive tape (TB 08-919A)
- Cleaning agent (TB 11-922)
- Primer (TB 16-911)
- Cleaning agent (TB 11-921)
- Sealant strip (TB 09-908B)
- Adhesive (TB 08-934)
- Sealant (TB 08-004B)
- Sealant (TB 09-900)
- Lintfree clean cloths
- Isopropyl alcohol (TB 10-002)

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- Sealant (TB 09-002A)
- Loctite (TB 08-908)

B. Procedure

- 1) Remove any adhesive and sealant residues from access door (1) [2] and rubber stops (11). Inspect the bonding surface for condition.
- 2) Bond new rubber stops (11) on access door (1) [2] with loctite (TB 08-908) – refer to 20-00-08.
- 3) Install transparent panel (5) [6] on access door (1) [2] with screws (4) and washers (3). Do not tighten screws (4).

NOTE : Clear the protection of transparent panel (5) [6] over a width of about 2 in. (50 mm).

- 4) Make sure transparent panel (5) [6] is correctly positioned. Reposition if necessary.
- 5) Remove transparent panel (5) [6].
- 6) Clean the bonding surface of transparent panel (5) [6] with isopropyl alcohol (TB 10-002), wait for 10 minutes and apply primer (TB 16-911). Allow to dry.
- 7) Bond sealant strips (7) (TB 09-908B) to transparent panel (5) [6] with sealant (TB 08-004B). Allow to dry.
- 8) Sand the bonding surface of access door (1) [2] with abrasive cloth (TB 05-916A). Clean the bonding surface with cleaning agent (TB 11-922).
- 9) Using adhesive tape (TB 08-919A), protect contact surfaces (8) of sealant strips (7) (TB 09-908B) of transparent panel (5) [6] on access door (1) [2].

CAUTION : READ THE TECHNICAL HANDBOOK ON ADHESIVE (TB 08-934) CAREFULLY.

- 10) Apply adhesive (TB 08-934) on the bonding surface of access door (1) [2].

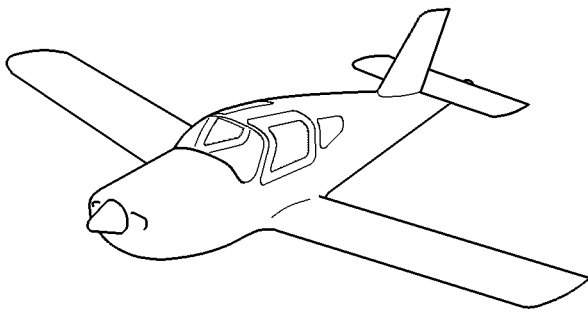
NOTE : Apply the adhesive evenly over a 0.08 in. (2 mm) thick layer.

- 11) Remove adhesive tape from contact surfaces (8).
- 12) Apply sealant (TB 09-002A) on the seating face of washers (3) – refer to 20-00-09.
- 13) Install transparent panel (5) [6] with washers (3) and screws (4). Moderately tighten screws (4) to avoid transparent panel cracking.

NOTE : Slightly press the transparent panel periphery to level adhesive.

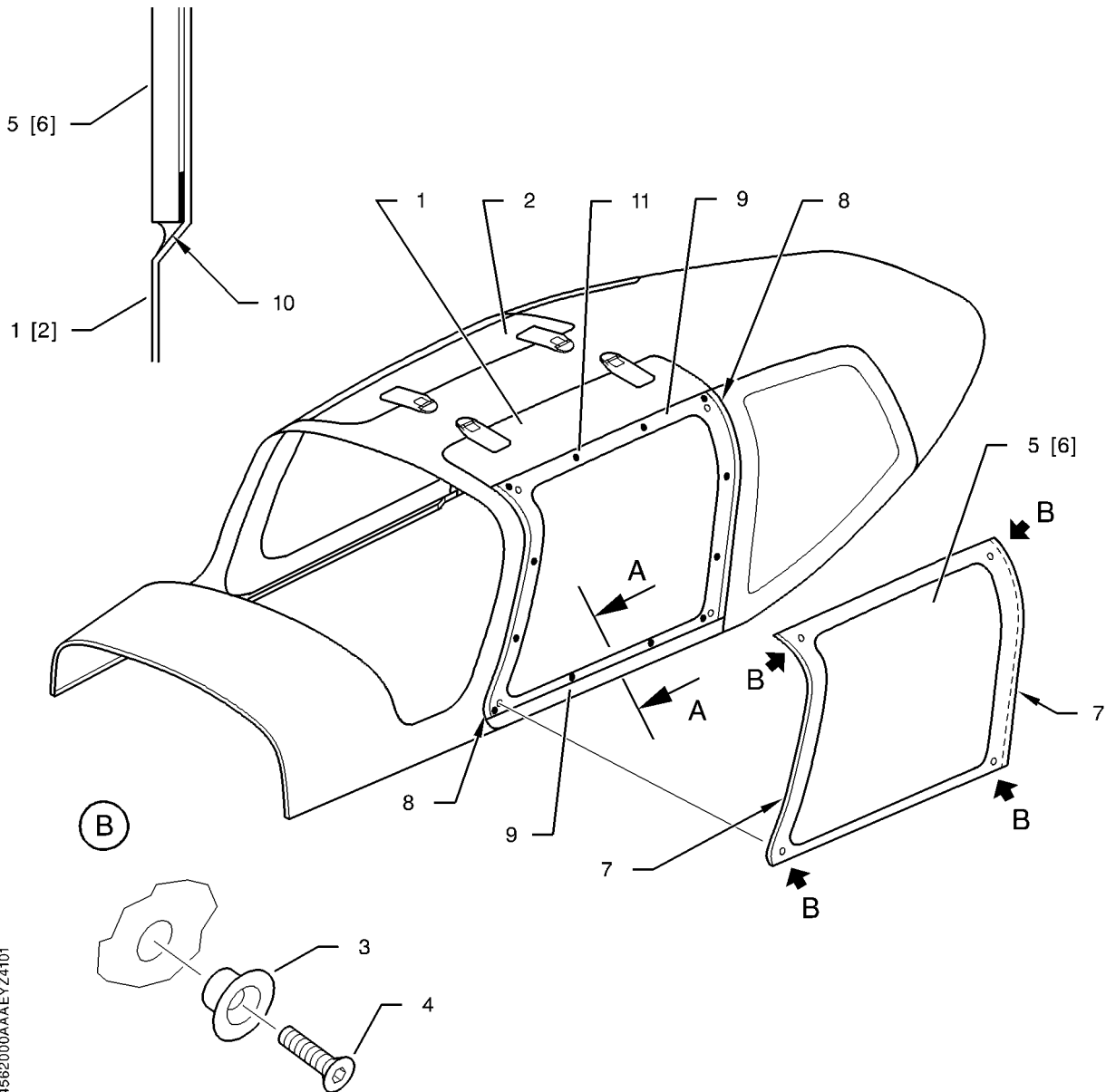
- 14) Clean excess sealant around washers (3) with a lintfree clean cloth moistened with isopropyl alcohol (TB 10-002).
- 15) Clean excess adhesive with a lintfree clean cloth moistened with cleaning agent (TB 11-921).
- 16) Allow to dry.
- 17) Protect transparent panel (5) [6] with adhesive tape (TB 08-919A) so that only the location of sealant bead (10) appears.
- 18) Make sealant bead (10) with sealant (TB 09-900) – refer to 20-00-09.
- 19) Remove adhesive tape from access door (1) [2] and transparent panel after sealant partial drying (12 to 24 hours).
- 20) Wait for complete curing of sealant (TB 09-900).
- 21) Remove the protection of transparent panel (5) [6] and check access door (1) [2] for correct operation. Close the access door.

- 22) Sprinkle access door (1) [2] to check its tightness.
- 23) Make sure all the tools and materials are removed and the work area is clean and free from debris.
- 24) Install the upholstery panel on access door (1) [2].
- 25) Perform paint touch-ups as required - refer to 20-00-03.
- 26) Clean transparent panel (5) [6] - refer to 12-22-04.



- 1 - L.H. access door
- 2 - R.H. access door
- 3 - Washer
- 4 - Screw
- 5 - L.H. transparent panel
- 6 - R.H. transparent panel
- 7 - Sealant strip
- 8 - Contact surface
- 9 - Adhesive tape
- 10 - Sealant bead
- 11 - Rubber stop

A - A



Access door transparent panel - Removal / Installation
Figure 401

14562000AAEYZ4101