



AERO PLASTICS INC.

Heavy Gauge Side Window Installation

Report No. 409/CON

Installation Drawing List

Applicable Aircraft Models

Piper PA-24 s/n 24-1 through 24-102
PA-24-250 s/n 24-103 through 24-3687, except 24-3642
PA-24-400 s/n 26-2 through 26-148
PA-24-260 s/n 24-3642, 24-4000 through 24-5028
PA-30 s/n 30-2 through 30-2000
PA-39 s/n 39-1 through 39-155

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Revision Control Page

Revision	Date	Pages Affected	Remarks
1	1/28/97	1, 4	Added right door vent window, revised s/n listing p/n 117.125, 117.187, 117.250, 117.125WV, 117.187WV, 117.250WV, 118, 118.312, 118.375



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**INSTALLATION INSTRUCTIONS FOR SIDE WINDOWS
.125", .187" AND .250" THICKNESS**

Applicable to: Piper PA-24
PA-30
PA-39

REMOVAL OF SIDE WINDOWS

1. Remove the retainer molding from around the window by removing the NAS387-4-3 attachment screws and NAS391-4 washers.
2. Carefully remove the window from the frame.
3. Remove all the tape and sealant residue from the window frame.

INSTALLATION OF SIDE WINDOWS

1. Check the size and contour of the new window against the window which was removed from your aircraft as well as checking the fit of the new window inside the airframe. Trim the new window to fit if necessary.
2. Apply Behr-Manning vinyl foam sealing tape no. 560 or equivalent to both sides of the window around the outer edges. The foam tape measuring 1 1/4" x 1/16" may be centered along the edge of the window and then folded down on both the inside and outside surface of the window.
3. In addition to or in place of the foam sealing tape, you may apply Behr-Manning sealant no. PRC 5000, Dow Corning RTV-732 or equivalent around the outer surface of the window at all attachment flanges and mating surfaces. Before applying sealants to the window, align the window in the airframe opening and mask both the window and the fuselage skin. This will protect both and aid in clean up of excess sealant which will squeeze out when the window is pressed into place.
4. Insert the window into the frame and install the retainer moldings. These retainers may or may not need repositioned slightly to accommodate the thicker window. If drilling new holes, position them no closer than 4 diameters from the existing holes. Secure the window moldings with the NAS387-4-3 attachment screws and NAS391-4 washers.
5. Remove any of the excess sealant or tape.
6. Complete the 337 form and perform weight and balance. (See Window Application Chart on page 4.)
7. Follow the guidelines on acceptable maintenance procedures in the FAA Advisory Circular AC 43.13-1A, or latest revision, in completing all phases of the installation.

WINDOW APPLICATION CHART

Part No.	WT	Window Location	Applicability
409.125 409.187 409.250	44 oz 62 oz 81 oz	Left Front Pilot Window Assembly	Piper PA-24, PA-24-250, PA-24-260 s/n 24-1 through 24-5028
401.125 401.187 401.250	36 oz 53 oz 71 oz	Left Front Pilot Window	PA-24-400 s/n 26-2 through 26-148 PA-30 s/n 30-2 through 30-2000 PA-39 s/n 39-1 through 39-155
460.250 460.312 460.375	5 oz 6 oz 7 oz	Vent Window	
181.125 181.187 181.250	33 oz 49 oz 65 oz	Right Front Door Window	
117.125 117.187 117.250	31 oz 47 oz 63 oz	Right Front Door Window* (*With vent opening cutout)	
117.125WV 117.187WV 117.250WV	39 oz 56 oz 73 oz	Right Front Door Window assembly** (**Vent window installed)	
118 118.312 118.375	5 oz 6 oz 7 oz	Vent Window	
183.125 183.187 183.250	25 oz 40 oz 53 oz	Right Rear Window	PA-24, PA-24-250, PA-24-260 s/n 24-1 through 24-4246 s/n 24-4248 through 24-4299
185.125 185.187 185.250	25 oz 40 oz 53 oz	Left Rear Window	PA-24-400 s/n 26-2 through 26-148 PA-30 s/n 30-2 through 30-852 s/n 30-854 through 30-901
769.125 769.187 769.250	26 oz 39 oz 52 oz	Left Center Window	PA-24-260 s/n 24-4247 s/n 24-4300 through 24-5028 PA-30 s/n 30-853 s/n 30-902 through 30-2000
770.125 770.187 770.250	26 oz 39 oz 52 oz	Right Center Window	PA-39 s/n 39-1 through 39-155
772.125 772.187 772.250	20 oz 29 oz 39 oz	Left Rear Window	
773.125 773.187 773.250	20 oz 29 oz 39 oz	Right Rear Window	

Note: Window weights are average.