



AERO PLASTICS INC.

Heavy Gauge Side Window Installation

Report No. PA28/CON

Installation Drawing List

Applicable Aircraft Models

Piper PA-28-140	S/N 28-20002 through 28-7725290
PA-28-150, -160, -180	S/N 28-1 through 28-4377
PA-28-151	S/N 28-7415001 through 28-7715314
PA-28-161	S/N 28-7716001 through 28-8616057
PA-28-161	S/N 2816001 and up
PA-28-161	S/N 2841001 and up
PA-28-180	S/N 28-4378 through 28-7505261
PA-28R-180	S/N 28R-30005 through 28R-7130019
PA-28-181	S/N 28-7690001 through 28-869056
PA-28-181	S/N 2890001 and up
PA-28R-200	S/N 28R-35001 through 28R-7635545
PA-28-201T	S/N 28-7921001 through 28-7921095
PA-28R-201	S/N 28R-7737002 through 28R-7837317
PA-28R-201	S/N 2837001 through 2837061
PA-28R-201T	S/N 28R-7703001 through 28R-7803372
PA-28R-201T	S/N 2803001 through 2803015
PA-28RT-201	S/N 28R-7918001 through 28R-8218039
PA-28RT-201T	S/N 28R-7931001 through 28R-8631004
PA-28RT-201T	S/N 2831001 through 2831038
PA-28-235	S/N 28-10003 through 28-7710089
PA-28-236	S/N 28-7911001 through 28-861108
PA-28-236	S/N 2811001 and up
PA-44-180	S/N 44-7995001 through 44-8195026
PA-44-180	S/N 4495001 through 4495013
PA-44-180T	S/N 44-8107001 thru 44-8207020

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Revision Control Page

Revision	Date	Pages Affected	Remarks
1	12/6/96	1, 4, 5, 6, 7, 8	Added right door vent window, revised s/n listings p/n 916, 916.187, 916.250, 916WV, 916.187WV, 916.250WV, 935, 935.312, 935.375, 944, 944.187, 944.250, 944WV, 944.187WV, 944.250WV, 945, 945.312, 945.375, 963, 963.187, 963.250, 963WV, 963.187WV, 963.250WV, 964, 964.187, 964.250, 964WV, 964.187WV, 964.250WV,



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February 6, 1993

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

Applicable to: Piper PA-28
PA-44

REMOVAL OF SIDE WINDOWS

1. Remove the retainer molding from around the window by removing the attachment screws.
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. In order to allow the door window to fit more flush with the aircraft skin, you may position the door window in the frame and mark the position of each rivet tail in contact with the window outer surface. Use a countersink to drill the outside surface of the window to allow clearance for each rivet tail when window is installed.
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 or equivalents.
5. Remove any of the excess sealant or tape.
6. Complete 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	Applicable to Piper Models
941	53 oz	Left front pilot window assembly	PA-28-140 s/n 28-20002 through 28-7725290
941.187	76 oz		PA-28-150, -160, -180 s/n 28-1 through 28-4377
941.250	94 oz		PA-28-235 s/n 28-10003 through 28-11039
157	39 oz	Left front pilot window	
157.187	61 oz		
157.250	78 oz		
155	5 oz	Vent window - use with p/n 157	
155.312	6 oz	Vent window - use with p/n 157.187	
155.375	7 oz	Vent window - use with p/n 157.250	
778.125	27 oz	Left rear window	PA-28-140 s/n 28-20002 through 28-7325684
778.187	41 oz		PA-28-150, -160, -180 s/n 28-1 through 28-4377
778.250	55 oz		PA-28-235 s/n 28-10003 through 28-11039
779.125	27 oz	Right rear window	
779.187	41 oz		
779.250	55 oz		
909	29 oz	Left rear window	PA-28-140 s/n 28-7425001 through 28-7725290
909.187	43 oz		
909.250	58 oz		
911	30 oz	Right rear window	
911.187	44 oz		
911.250	60 oz		

Note: All window weights are average.

WINDOW APPLICATION CHART

Part No.	WT	Window Location	Applicable to Piper Models
941 941.187 941.250	53 oz 76 oz 94 oz	Left front pilot window assembly	PA-28-180 s/n 28-4378 through 28-7205328 PA-28R-180 s/n 28R-30005 through 28R-7130019 PA-28R-200 s/n 28R-35001 through 28R-7135238 PA-28-235 s/n 28-11040 through 28-7210033
157 157.187 157.250	39 oz 61 oz 78 oz	Left front pilot window	
793 793.187 793.250	66 oz 92 oz 120 oz	Left front pilot window assembly	PA-28-180 s/n 28-7305001 through 28-7305611 PA-28R-200 s/n 28R-7235001 through 28R-7335455 PA-28-235 s/n 28-7310001 through 28-7310187
792 792.187 792.250	52 oz 77 oz 104 oz	Left front pilot window	
155 155.312 155.375	5 oz 6 oz 7 oz	Vent window - use with p/n 157 p/n 792 Vent window - use with p/n 157.187 p/n 792.187 Vent window - use with p/n 157.250 p/n 792.250	PA-28-180 s/n 28-4378 through 28-7305611 PA-28R-180 s/n 28R-30005 through 28R-7130019 PA-28R-200 s/n 28R-35001 through 28R-7335455 PA-28-235 s/n 28-11040 through 28-7310187
783.125 783.187 783.250	30 oz 45 oz 60 oz	Left center window	PA-28-180 s/n 28-4378 through 28-7305611 PA-28R-180 s/n 28R-30005 through 28R-7130019 PA-28R-200 s/n 28R-35001 through 28R-7335455 PA-28-235 s/n 28-11040 through 28-7310187
784.125 784.187 784.250	30 oz 45 oz 60 oz	Right center window	
786.125 786.187 786.250	15 oz 22 oz 29 oz	Left rear window	
787.125 787.187 787.250	15 oz 22 oz 29 oz	Right rear window	

Note: All window weights are average.

WINDOW APPLICATION CHART

Part No.	WT	Window Location	Applicable to Piper Models
793	66 oz	Left front pilot window assembly	PA-28-151 s/n 28-7415001 through 28-7715314
793.187	92 oz		PA-28-161 s/n 28-7716001 through 28-8616057
793.250	120 oz		PA-28-161 s/n 2816001 and up
792	52 oz	Left front pilot window	PA-28-161 s/n 2841001 and up
792.187	77 oz		PA-28-180 s/n 28-7405001 through 28-7505261
792.250	104 oz		PA-28-181 e/n 28-7690002 through 28-8690056
			PA-28-181 s/n 2890001 and up
155	5 oz	Vent window - use with p/n 792	PA-28R-200 e/n 28R-7435001 through 28R-7635545
155.312	6 oz	Vent window - use with p/n 792.187	PA-28-201T s/n 28-7921001 through 28-7921095
155.375	7 oz	Vent window - use with p/n 792.250	PA-28R-201 s/n 28R-7737002 through 28R-7837317
			PA-28R-201 s/n 2837001 through 2837061
909	29 oz	Left center window or Left rear window - PA-161 Cadet	PA-28R-201T s/n 28R-7703001 through 28R-7803372
909.187	43 oz		PA-28R-201T s/n 2803001 through 2803015
909.250	58 oz		PA-28RT-201 e/n 28R-7918001 through 28R-8218039
			PA-28RT-201T s/n 28R-7931001 through 28R-8631004
911	30 oz	Right center window or Right rear window - PA-161 Cadet	PA-28RT-201T s/n 2831001 through 2831038
911.187	44 oz		PA-28-235 s/n 28-7410001 through 28-7710089
911.250	60 oz		PA-28-236 s/n 28-7911001 through 28-8611008
			PA-28-236 s/n 2811001 and up
913	15 oz	Left rear window	
913.187	23 oz		
913.250	31 oz		
915	15 oz	Right rear window	
915.187	22 oz		
915.250	29 oz		

Note: All window weights are average.

WINDOW APPLICATION CHART

Part No.	WT	Window Location	Applicable to Piper Models
939	38 oz	Right front door window	PA-28-140 s/n 28-20002 through 28-7625030
939.187	57 oz		PA-28-150, -160 s/n 28-1 through 28-4377
939.250	76 oz		PA-28-180 s/n 28-1 through 28-7205328
944	34 oz	Right front cabin door window* (*With vent opening cutout)	PA-28R-180 s/n 28R-30005 through 28R-7130019
944.187	51 oz		PA-28R-200 s/n 28R-35001 through 28R-7135238
944.250	69 oz		PA-28-235 s/n 28-10003 through 28-7210033
944WV	49 oz	Right front door window assembly** (**Vent window installed)	
944.187WV	67 oz		
944.250WV	86 oz		
954	35 oz	Right front door window	PA-28-140 s/n 28-7625031 through 28-7725290
954.187	52 oz		
954.250	70 oz		
963	34 oz	Right front door window* (*With vent opening cutout)	
963.187	51 oz		
963.250	69 oz		
963WV	49 oz	Right front door window assembly** (**Vent window installed)	
963.187WV	67 oz		
963.250WV	86 oz		
917	44 oz	Right front door window	PA-28-151 s/n 28-7415001 through 28-7615001
917.187	65 oz		PA-28-180 s/n 28-7305001 through 28-7505261
917.250	88 oz		PA-28-181 s/n 28-7690001
916	40 oz	Right front cabin door window* (*With vent opening cutout)	PA-28R-200 s/n 28R-7235001 through 28R-7635017
916.187	59 oz		PA-28-235 s/n 28-7310001 through 28-7610020
916.250	81 oz		
916WV	55 oz	Right front door window assembly** (**Vent window installed)	
916.187WV	75 oz		
916.250WV	98 oz		
935	5 oz	Vent window-use with 916	
935.312	6 oz	Vent window-use with 916.187	
935.375	7 oz	Vent window-use with 916.250	
956	42 oz	Right front door window	PA-28-151 s/n 28-7615002 through 28-7715314
956.187	63 oz		PA-28-161 s/n 28-7716001 through 28-8616057
956.250	84 oz		PA-28-161 s/n 2816001 and up
964	42 oz	Right front cabin door window* (*With vent opening cutout)	PA-28-161 s/n 2841001 and up
964.187	63 oz		PA-28-181 s/n 28-7690002 through 28-8690056
964.250	84 oz		PA-28-181 s/n 2890002 and up
964WV	57 oz	Front door window assembly** (**Vent window installed)	PA-28R-200 s/n 28R-7635018 through 28R-7635545
964.187WV	79 oz		PA-28-201T s/n 28-7921001 through 28-7921095
964.250WV	101 oz		PA-28R-201 s/n 28R-7737002 through 28R-7837317
			PA-28R-201 s/n 2837001 through 2837061
			PA-28R-201T s/n 28R-7703001 through 28R-7803372
			PA-28R-201T s/n 2803001 through 2803015
			PA-28RT-201 s/n 28R-7918001 through 28R-8218039
			PA-28RT-201T s/n 28R-7931001 through 28R-8631004
			PA-28RT-201T s/n 2831001 through 2831038
			PA-28-235 s/n 28-7610021 through 28-7710089
			PA-28-236 s/n 28-7911001 through 28-8611008
			PA-28-236 s/n 2811001 and up
945	5 oz		Vent window-use with 944, 963, 964
945.312	6 oz	Vent window-use with 944.187, 963.187, 964.187	963
945.375	7 oz	Vent window-use with 944.250, 963.250, 964.250	964

Note: All window weights are average.

WINDOW APPLICATION CHART

Part No.	WT	Window Location	Applicable to Piper Models
882 882.187 882.250	59 oz 81 oz 120 oz	Left front pilot window assembly	PA-44-180 s/n 44-7995001 through 44-8195026 PA-44-180 s/n 4495001 through 4495013 PA-44-180T s/n 44-8107001 through 44-8207020
824 824.187 824.250	45 oz 66 oz 90 oz	Left front pilot window	
155 155.312 155.375	5 oz 6 oz 7 oz	Vent window Vent window - use with p/n 824.187 Vent window - use with p/n 824.250	
956.187 956.250	63 oz 84 oz	Right front door window	
964 964.187 964.250	42 oz 63 oz 84 oz	Right front cabin door window* (*With vent opening cutout)	
964WV 964.187WV 964.250WV	57 oz 79 oz 101 oz	Front door window assembly** (**Vent window installed)	
945 945.312 945.375	5 oz 6 oz 7 oz	Vent window-use with 964 Vent window-use with 964.187 Vent window-use with 964.250	
909.187 909.250	43 oz 58 oz	Left center window	
911.187 911.250	44 oz 60 oz	Right center window	
913.187 913.250	23 oz 31 oz	Left rear window	
915.187 915.250	22 oz 29 oz	Right rear window	

Note: All window weights are average.



AERO PLASTICS INC.

Heavy Gauge Side Window Installation

Report No. 952/CON

Installation Drawing List

Applicable Aircraft Models

Piper PA-32-260	s/n 32-1 through 32-7800008
PA-32-300	s/n 32-40000 through 32-7940282
PA-32R-300	s/n 32R-7680001 through 32R-7880068
PA-32RT-300	s/n 32R-7885001 through 32R-7985125
PA-32RT-300T	s/n 32R-7887001 through 32R-7987146
PA-32-301	s/n 32-8006001 and up
PA-32-301T	s/n 32-8024001 and up
PA-32R-301	s/n 32R-8013001 and up
PA-32R-301T	s/n 32R-8029001 and up
PA-34-200	s/n 34-7250001 through 34-7450220
PA-34-200T	s/n 34-7570001 through 34-8170092
PA-34-220T	s/n 34-8133001 through 34-8633031
PA-34-220T	s/n 3433001 and up
PA-34-220T	s/n 3448005 and up

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2/20/92

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Revision Control Page

Revision	Date	Pages Affected	Remarks
1	8/1/95	All pages	Expanded model applicability, added storm window to right front door windows Added additional windows for expanded applicability, revised instructions



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Revision 1, 8/1/95

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

Applicable to: Piper PA-32 series
PA-34 series

REMOVAL OF SIDE WINDOWS

1. Remove the retainer molding from around the window by removing the attachment screws.
2. Carefully remove the window from the frame.
3. Remove all 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. A paper overlay may be used to duplicate the exact size. Trim the new window to fit. In order to allow the door window to fit more flush with the aircraft skin, you may position the door window in the frame and mark the position of each rivet tail in contact with the window outer surface. Use a countersink to drill the outside surface of the window to allow clearance for each rivet tail when window is installed.
2. Before applying sealants to the window, trial fit the window in the airframe opening. The 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. 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. Additional sealant may be applied after the trial fit.
3. 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. 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.
4. Insert the window into the frame and install the retainer moldings. Secure the window moldings with the NAS387-4-3 attachment screws and NAS391-4 washers or equivalents.
5. Remove any of the excess sealant or tape.
6. Complete 337 form and perform weight and balance computations. (See Window Application Chart on page 4, 5, and 6.)
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	Applicable to Piper Models
920 920.187 920.250	39 oz 61 oz 78 oz	Left front pilot window	PA-32-260 s/n 32-1 thru 32-7300076 PA-32-300 s/n 32-40000 thru 32-7340201 PA-34-200 s/n 34-7250001 thru 34-7350363
930 930.187 930.250	53 oz 76 oz 94 oz	Left front pilot window assembly* (*Vent window installed)	
921.125 921.187 921.250	31 oz 47 oz 63 oz	Center window - left	
922.125 922.187 922.250	31 oz 47 oz 63 oz	Center window - right	
923.125 923.187 923.250	25 oz 37 oz 49 oz	Rear window - right	
155 155.312 155.375	5 oz 6 oz 7 oz	Vent window-use with 920 Vent window-use with 920.187 Vent window-use with 920.250	PA-32-260 s/n 32-1 thru 32-7800008 PA-32-300 s/n 32-40000 thru 32-7940282 PA-32R-300 s/n 32R-7680001 thru 32R-7880068 PA-32RT-300 s/n 32R-7885001 thru 32R-7985125 PA-32-RT-300T s/n 32R-7887001 thru 32R-7987146
940 940.187 940.250	24 oz 36 oz 48 oz	Aft cabin door window	PA-32-301 s/n 32-8006001 and up PA-32-301T s/n 32-8024001 and up PA-32R-301 s/n 32R-8013001 and up PA-32R-301T s/n 32R-8029001 and up PA-34-200 s/n 34-7250001 thru 34-7450220 PA-34-200T s/n 34-7570001 thru 34-8170092 PA-34-220T s/n 34-8133001 thru 34-8633031 s/n 3433001 and up s/n 3448005 and up

WINDOW APPLICATION CHART

Part No.	Wt.	Window Location	Applicable to Piper Models
952.187 952.250	52 oz 70 oz	Left front pilot window	PA-32-260 s/n 32-7400001 thru 32-7800008 PA-32-300 s/n 32-7440001 thru 32-7940282 PA-32R-300 s/n 32R-7680001 thru 32R-7880068
992 992.187 992.250	44 oz 61 oz 80 oz	Left front pilot window assembly* *(Vent window installed)	PA-32RT-300 s/n 32R-7885001 thru 32R-7985125 PA-32RT-300T s/n 32R-7887001 thru 32R-7987146 PA-32-301 s/n 32-8006001 and up PA-32-301T s/n 32-8024001 and up PA-32R-301 s/n 32R-8013001 and up PA-32R-301T s/n 32R-8029001 and up
932.187 932.250	42 oz 56 oz	Left center window	PA-34-200 s/n 34-7450001 thru 34-7450220 PA-34-200T s/n 34-7570001 thru 34-8170092 PA-34-220T s/n 34-8133001 thru 34-8633031 s/n 3433001 and up s/n 3448005 and up
934.187 934.250	42 oz 56 oz	Right middle window-forward	
936.187 936.250	48 oz 64 oz	Right middle window-rearward	
938.187 938.250	16 oz 22 oz	Right rear window	
943.187 943.250	15 oz 20 oz	Cargo door window	

WINDOW APPLICATION CHART

Part No.	Wt.	Window Location	Applicable to Piper Models
939 939.187 939.250	35 oz 52 oz 70 oz	Right front cabin door window	PA-32-260 s/n 32-1 thru 32-7600001 PA-32-300 s/n 32-40000 thru 32-7640029 PA-32R-300 s/n 32R-7680001 thru 32R-7680013 PA-34-200 s/n 34-7250001 thru 34-7450220 PA-34-200T s/n 34-7570001 thru 34-7670063
944 944.187 944.250	34 oz 51 oz 69 oz	Right front cabin door window* (*With vent opening cutout)	
944WV 944.187WV 944.250WV	49 oz 67 oz 86 oz	Right front door window assembly** (**Vent window installed)	
954.187 954.250	52 oz 70 oz	Right front cabin door window	PA-32-260 s/n 32-7600002 thru 32-7800008 PA-32-300 s/n 32-7640030 thru 32-7940282 PA-32R-300 s/n 32R-7680014 thru 32R-7880068 PA-32RT-300 s/n 32R-7885001 thru 32R-7985125 PA-32RT-300T s/n 32R-7887001 thru 32R-7987146 PA-32-301 s/n 32-8006001 and up PA-32-301T s/n 32-8024001 and up PA-32R-301 s/n 32R-8013001 and up PA-32R-301T s/n 32R-8029001 and up PA-34-200T s/n 34-7670064 thru 34-8170092 PA-34-220T s/n 34-8133001 thru 34-8633031 s/n 3433001 and up s/n 3448005 and up
963 963.187 963.250	34 oz 51 oz 69 oz	Right front cabin door window* (*With vent opening cutout)	
963WV 963.187WV 963.250WV	49 oz 67 oz 86 oz	Right front door window assembly** (**Vent window installed)	
945 945.312	5 oz 6 oz	Vent window-use with 944, 963 Vent window-use with 944.187, 963.187	PA-32-260 s/n 32-1 thru 32-7800008 PA-32-300 s/n 32-40000 thru 32-7940282 PA-32R-300 s/n 32R-7680001 thru 32R-7880068 PA-32RT-300 s/n 32R-7885001 thru 32R-7985125 PA-32-RT-300T s/n 32R-7887001 thru 32R-7987146 PA-32-301 s/n 32-8006001 and up PA-32-301T s/n 32-8024001 and up PA-32R-301 s/n 32R-8013001 and up PA-32R-301T s/n 32R-8029001 and up PA-34-200 s/n 34-7250001 thru 34-7450220 PA-34-200T s/n 34-7570001 thru 34-8170092 PA-34-220T s/n 34-8133001 thru 34-8633031 s/n 3433001 and up s/n 3448005 and up
945.375	7 oz	Vent window-use with 944.250, 963.250	