



Aerospace Maintenance Competition – Glass Window Plug Replacement Procedure

Glass window (NP165333B1 / B2) Replacement Procedure

NOTE: This procedure allows operators the opportunity on part number (NP165333A1/A2) to replace only the glass window plug as an alternative to replacing full assembly

(1) Materials

NOTE: The sealant used to accomplish this task is PR 1425 or PR 1425CF (recommended). Equivalent substitutes may be used.

| PART LIST | | | | |
|-----------------------|------------------------------|----------|------|---------------------|
| Item | Part Number | Quantity | Item | Applicable on NP |
| Glass Plug- LH | NP165333B1 | 1 | 1 | NP165333A3 & A1 |
| Glass Plug- RH | NP165333B2 | 1 | 1 | NP165333A4 & A2 |
| Hi-Lok Pin | HL49-6-16 / D090-415-1523 | 45 | 2 | NP165333A1/A2-A3/A4 |
| Nut | MS-21043-3 / D090-415-2104 | 45 | 3 | NP165333A1/A2-A3/A4 |
| Washer | NAS-620-C-10 / D095-416-2037 | 45 | 4 | NP165333A1/A2-A3/A4 |
| Spacer | D090-408-1838 | 45 | 5 | NP165333A1/A2-A3/A4 |
| Inboard Retainer- LH | D090-787-2709 | 1 | 6 | NP165333A3 & A1 |
| Outboard Retainer -LH | D090-787-2710 | 1 | 7 | NP165333A3 & A1 |
| Gasket - LH | D090-743-5400 | 1 | 8 | NP165333A3 & A1 |
| Inboard Retainer- RH | D090-787-2712 | 1 | 6 | NP165333A4 & A2 |
| Outboard Retainer -RH | D090-787-2714 | 1 | 7 | NP165333A4 & A2 |
| Gasket - RH | D090-743-5401 | 1 | 8 | NP165333A4 & A2 |

(2) Replacement Procedure (Reference Figure 1)

Start Here

- a) Remove 6 outer row of fasteners to remove window from cockpit and set to the side.
- b) Using provided suction mount, remove window from cockpit and place on table inboard side up.
- c) Unscrew the 6 Hi-lok pins and nuts (Items 2 & 3).
- d) Keep all hardware (pins, nuts, washers and spacers) (Item 5).
- e) Remove the inboard retainer (Item 6).
- f) Clean the outboard retainer gasket with isopropyl alcohol.
- g) Replace the glass window plug (Item 1).
- h) Install 6 spacers, 6 Hi-lok pins, 6 washers, and 6 nuts to center and secure the glass window plug. (no torque requirement – tighten until secure)
- i) Using provided suction mount, place window assembly back into cockpit.
- j) Install 6 outer row of fasteners at specified locations and tighten until secure.

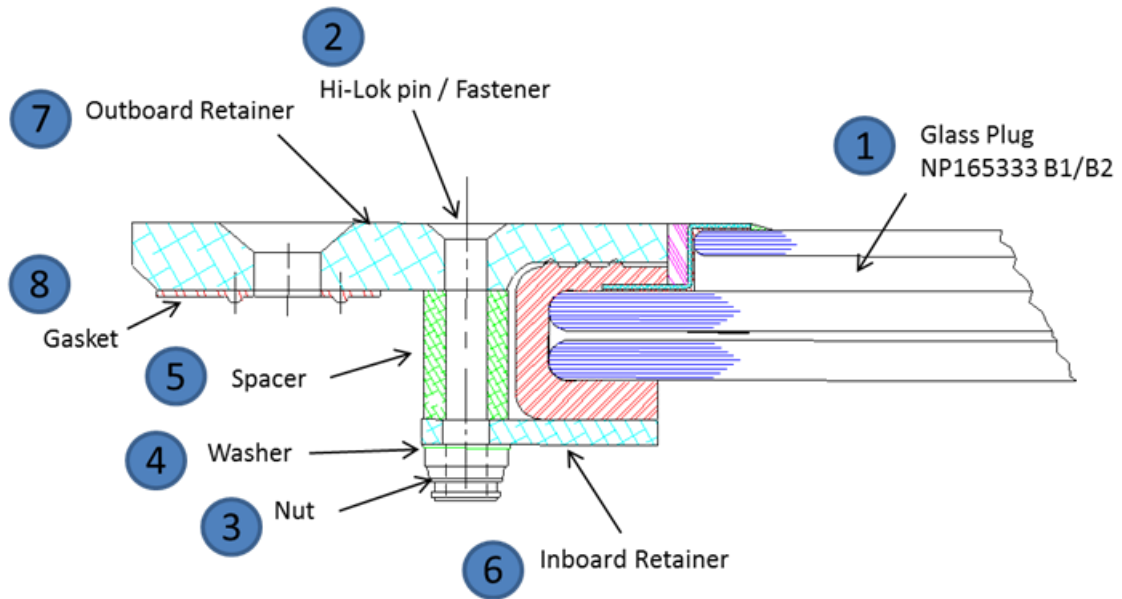


Figure 1 – Window Glass Plug/Retainer Diagram

The event will be judged on time and penalties will be assessed as follows according to the AMC score sheet:

- Failure to properly store tools and/or equipment (+30 seconds)
 - Missing spacer, pin, washer and/or nuts
- Failure to follow procedures or safety-related warnings or cautions (+60 seconds each)
 - Improper hardware placement in marked areas
 - Cleaning of inboard retainer with isopropyl alcohol

****If any step in process is omitted, there will be a 5 minute penalty per step****