



EMB145 - EMB135

AIRCRAFT
MAINTENANCE MANUAL

PASSENGER CABIN WINDOWS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the Passenger Cabin Windows.
- B. The procedures in this section are given in the sequence below. The tasks identified with (♦) are part of the Scheduled Maintenance Requirements Document (SMRD).

TASK NUMBER	DESCRIPTION	EFFECTIVITY
56-20-01-000-801-A	PASSENGER CABIN WINDOWS - RE- MOVAL	ALL
56-20-01-400-801-A	PASSENGER CABIN WINDOWS - INSTAL- LATION	ALL



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TASK 56-20-01-000-801-A

EFFECTIVITY: ALL

2. PASSENGER CABIN WINDOWS - REMOVAL

A. General

(1) This procedure gives the instructions to remove the Passenger Cabin Windows.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-23-01-000-801-A/400	-
AMM TASK 25-23-01-000-802-A/400	-
AMM TASK 25-23-03-000-801-A/400	PASSENGER-CABIN ESCAPE-HATCH LINING - REMOVAL

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
230		Fuselage center section I
240		Fuselage center section II
250		Fuselage center section III
260		Fuselage center section IV

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench	To tighten the screws	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Protective Gloves	For protection of technician's hands	1
Commercially available	Safety Goggles	For protection of technician's eyes	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	In the passenger cabin



I. Preparation

SUBTASK 841-002-A

- (1) Remove the sidewall lining panel (AMM TASK 25-23-01-000-801-A/400 or AMM TASK 25-23-01-000-802-A/400, as applicable).
- (2) Remove the sidewall lining panel of the passenger-cabin escape-hatch (**AMM TASK 25-23-03-000-801-A/400**).

J. Removal (Figure 401)

SUBTASK 020-002-A

- (1) Remove the screws (5), washers (4), and fasteners (3).
- (2) Remove the panes (2).

NOTE: If it is not easy to remove the transparency, pull it out with the aid of a tool without sharp edges.

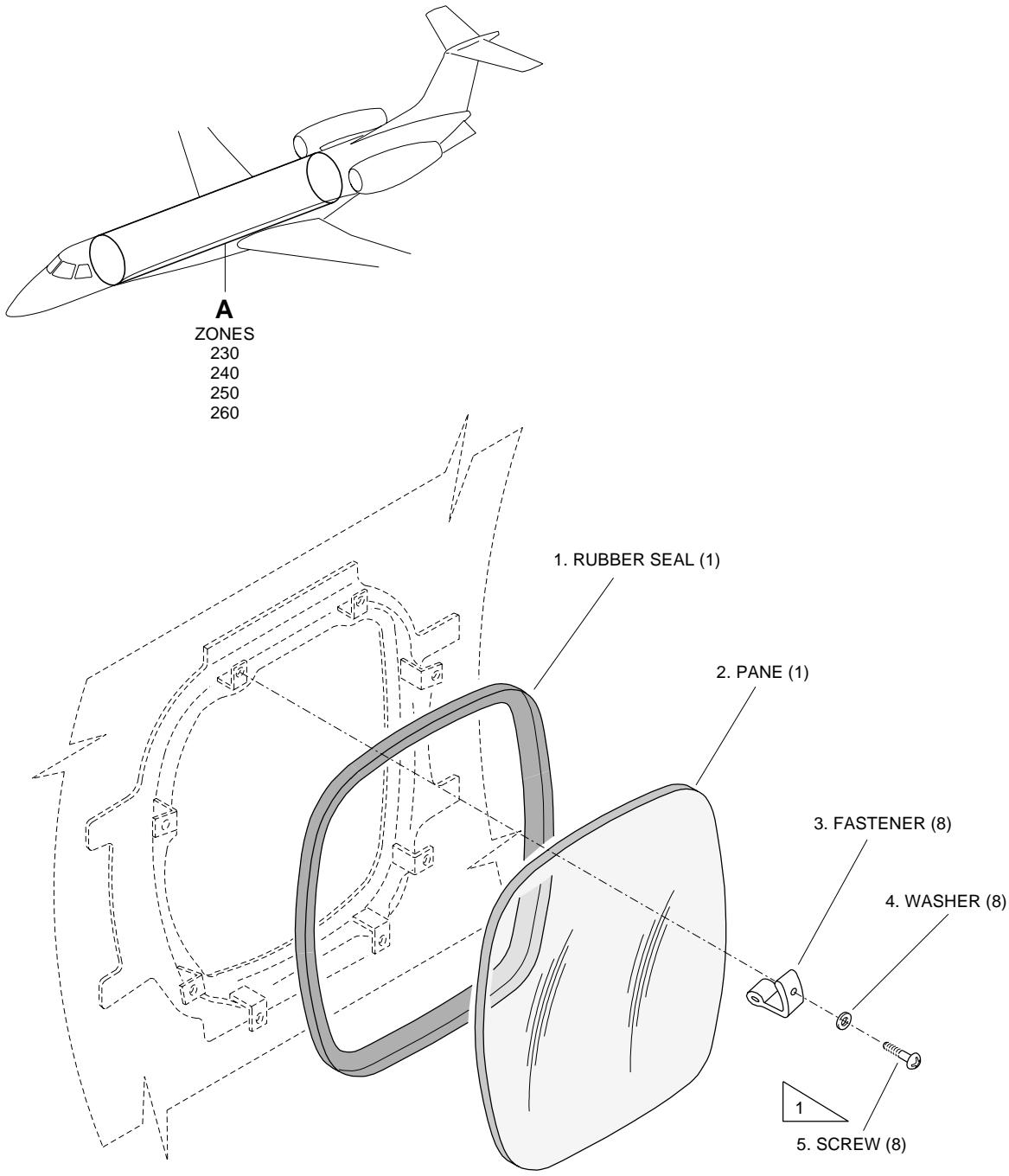
CAUTION: DO NOT REMOVE THE SEALANT APPLIED TO THE OUTER PANE EDGES BY THE MANUFACTURER.

- (3) Carefully remove the rubber seal (1) applied to the outer pane (2) edges. If necessary, replace the rubber seal (1).
- (4) With a clean and dry cloth, remove all moisture along the pane (2) edge, rubber seal (1), and frame.

EFFECTIVITY: ALL

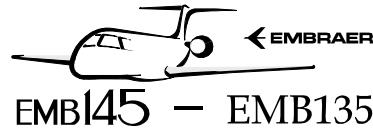
Passenger Cabin Windows - Installation

Figure 401



 1 TORQUE: 1.4 N.m – 1.7 N.m (12 lbf.in – 15 lbf.in)

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TASK 56-20-01-400-801-A

EFFECTIVITY: ALL

3. PASSENGER CABIN WINDOWS - INSTALLATION

A. General

(1) This procedure gives the instructions to install the Passenger Cabin Windows.

B. References

REFERENCE	DESIGNATION
AMM TASK 21-31-00-700-805-A/500	-
AMM TASK 21-31-00-700-808-A/500	-
AMM TASK 25-23-01-400-801-A/400	-
AMM TASK 25-23-01-400-802-A/400	-
AMM TASK 25-23-03-400-801-A/400	PASSENGER-CABIN ESCAPE-HATCH LINING - INSTALLATION
IPC 56-20-00	PASSENGER COMPARTMENT

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
230		Fuselage center section I
240		Fuselage center section II
250		Fuselage center section III
260		Fuselage center section IV

D. Tools and Equipment

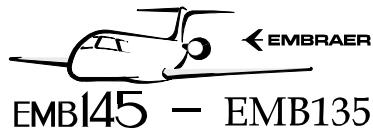
ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench	To tighten the screws	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Protective Gloves	For protection of technician's hands	1
Commercially available	Safety Goggles	For protection of technician's eyes	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
A-A-59173	Grease, Molykote, DC-33 light	AR
TT-I-735	Isopropyl alcohol	AR



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G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Rubber Seal	IPC 56-20-00	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	In the passenger cabin

I. Installation (Figure 401)

SUBTASK 420-002-A

WARNING: BE CAREFUL WHEN YOU USE SOLVENTS BECAUSE THEY ARE A HEALTH AND FIRE HAZARD. USE SAFETY GOGGLES AND PROTECTIVE CLOTHING WHEN YOU HANDLE THEM. DO NOT BREATHE THEIR GASES AND WORK IN A WELL VENTILATED AREA.

- (1) With a cloth soaked in Isopropyl alcohol, clean the frame surface.
- (2) Cover the outer pane (2) edge with the rubber seal (1).
- (3) Apply a coat of DC-33 silicone grease to the edges of the rubber seal (1) to help install the outer pane (2) into the frame.
- (4) Install the pane (2) to the fuselage.
- (5) Install the fasteners (3), washers (4), and screws (5).

NOTE: Apply a torque from 1.4 to 1.7 N.m (12 - 15 lbf.in). Refer to (Figure 401) and IPC 56-20-00.

J. Follow-on

SUBTASK 842-002-A

- (1) Do a functional test of the cabin pressurization system (AMM TASK 21-31-00-700-805-A/500) or (AMM TASK 21-31-00-700-808-A/500)
- (2) Make sure that there is no air leakage through the passenger window seal.
- (3) Install the sidewall lining panel (AMM TASK 25-23-01-400-801-A/400 or AMM TASK 25-23-01-400-802-A/400, as applicable).
- (4) Install the sidewall lining panel of the passenger-cabin escape-hatch ([AMM TASK 25-23-03-400-801-A/400](#)).