

## 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 - REMOVAL	ALL
56-20-01-400-801-A	PASSENGER CABIN WINDOWS - INSTALLATION	ALL

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	-
<a href="#">AMM TASK 25-23-03-000-801-A/400</a>	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.

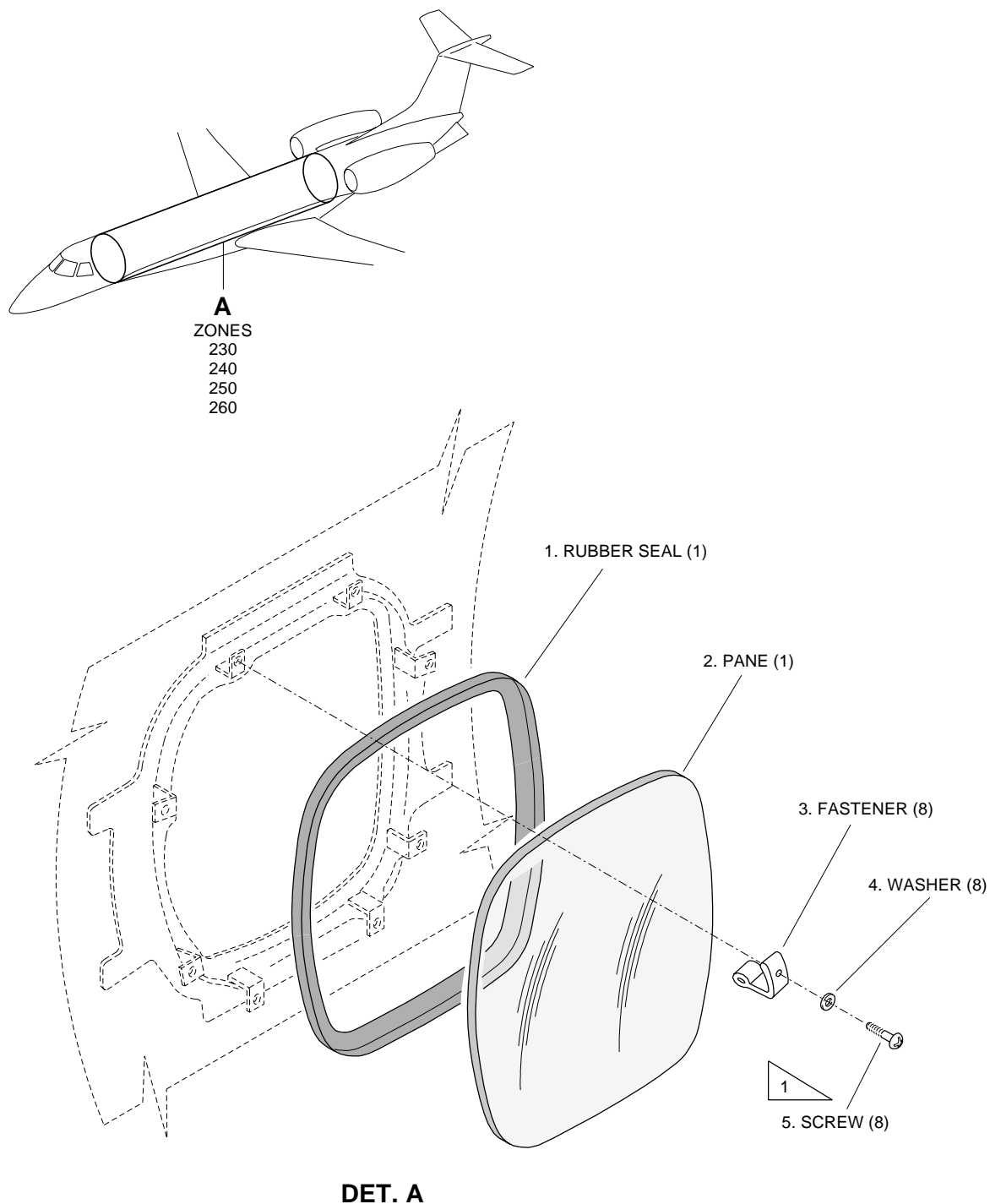
CAUTION: DO NOT REMOVE THE SEALANT APPLIED TO THE OUTER PANE EDGES BY THE MANUFACTURER.

- (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	-
<a href="#">AMM TASK 25-23-03-400-801-A/400</a>	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

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](#)).