

Remove the old glass, and the abrasion strip from the fiberglass frame. This is most easily done using a sharp wood chisel.



Clamp the frame back in the door opening so that it fits the cabin shape. If it is really warped, it can be repaired by cutting slots in the frame until it relaxes and then repairing it with some fiberglass.



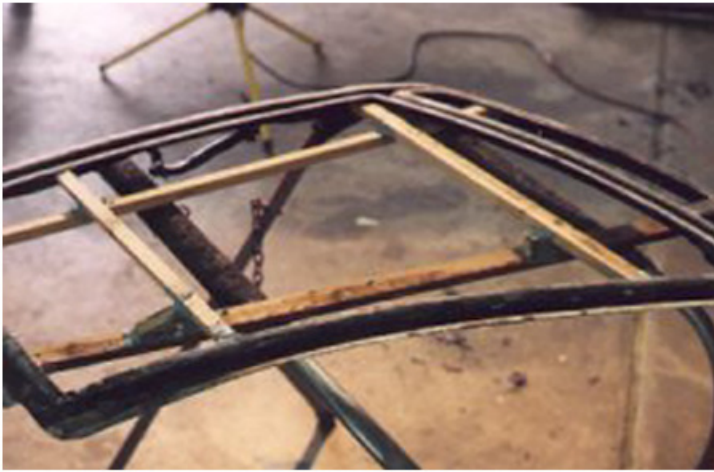
The next step is to attach a "ladder back" to the door frame while it is clamped in the door opening.

Cut some small sticks, about 1" square and attach them across the door frame using globs of bondo.



Also attach them to each other using small pieces of stick and bondo.

This will create a stiff frame that can be removed from the helicopter and laid on a bench while holding its shape.



Lay the door frame on saw horses, and lay the glass on top. Mask off the areas not to be glued or painted. Sand the areas of the glass that will be glued.

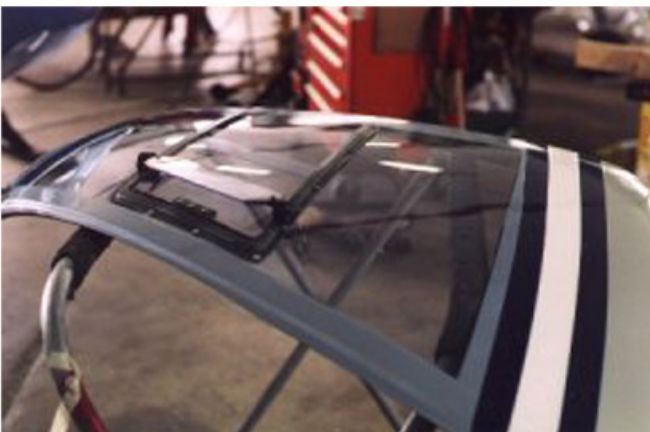




Bond the glass to the frame using one of the flexible adhesives, such as PRC or Scotch 801. Use enough clamps to evenly distribute the clamping pressure.



After the glue has dried, use a small hammer to break off the sticks, and the wood chisel to clean the bondo off of the door frame.



Glue the abrasion strip on