



## **Enstrom 480B S/N 5134 Leak Repair Procedure**



### **A. Leaking screws at windshield**

1. Remove the leaking screws, nuts and washers.
2. Install screws in wet Dow Corning 732 clear silicone sealer or any similar commercially available silicone sealer.
3. Install washers and nuts. CAUTION, do not over tighten the hardware.
4. Tape the line between the acrylic windshield and the cabin with masking tape along the entire top seam and the bottom seam just under the center window strip..

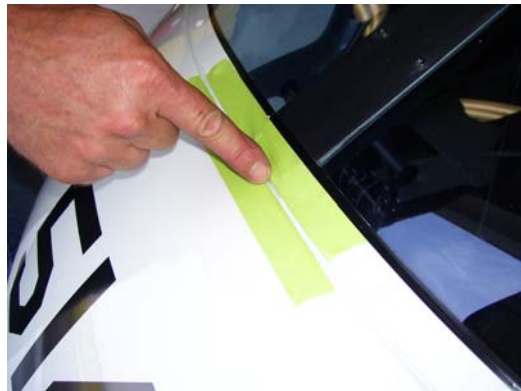


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5. Install a small bead of Dow Corning 732 (clear) (or equivalent silicone sealer) silicone sealer into the groove between the acrylic window and the cabin shell.



6. Use a finger that has been wet with a small amount of water to smooth the silicone sealer.



7. Immediately pull the masking tapes while the silicone is still wet.



- B. Leaks at the opera window fasteners;



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1. Drill out any rivets that are leaking using a #30 drill.
2. Install a new P/N CR91484-4-3 rivet, setting it in wet Dow Corning 732 clear silicone.
3. Seal the center hole in the rivet with poly-urethane putty or epoxy.
4. Touch up the paint on the rivet head.