

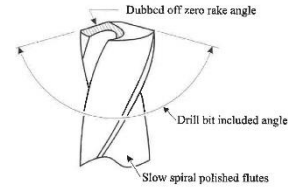


S/N AFFECTED: All
ENSTROM TECH TIP

INSTALLING WINDOWS IN ENSTROM HELICOPTERS

I. Tools and procedures.

- a. Drilling plexiglass. Drilling acrylics must be done with drills manufactured for, or modified for drilling acrylics.
- b. Cutting plexiglass. Cutting acrylics is best done with a “Oscillating Saw” (Bone Saw) or a die grinder with a 1/16 cut-off wheel.



Bone Saw



Die Grinder

II. Fitting New Window.

- a. Place the new window over the cabin opening and use tape or a marker to outline the outside of the opening on the window. (Secure the window to the cabin with tape so it does not move while marking). For the first cut leave about an inch extra acrylic on the outside of the new window. Cut around the tape or line and discard the extra acrylic.





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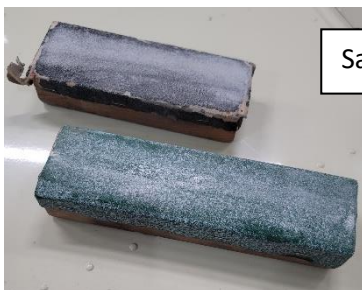
- b. Support the tail of the acrylic while cutting to prevent the tail from breaking off and cracking the acrylic.

- c. Place the new window back over the opening and secure with tape. Mark the edge of the finished window with tape or a fine marker.

Cut on this side of the tape.



- d. Carefully cut the window to size, use the cut off tools or sandpaper on a block to finish size the window, and to smooth and round the outside edge of the window. (A bench belt sander also works). There should be about 1/8 inch gap between the edge of the window and the and the joggle edge of the cabin.



Sanding Blocks



- e. Place the window back into the cabin and tape it in place. Use a small pilot drill bit to mark the position of the holes in the cabin structure. Do not drill the holes all the way through the acrylic at this time.
- f. Remove the window from the cabin and place on a padded table or sawhorses.
- g. The finished diameter of the hole should be approximately 1/8 inch larger than the diameter of the attaching screw or rivet.



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- h. Use a small block of wood to support the back side of the window when drilling holes through the acrylic. Most cracks resulting from drilling acrylic occur when the drill bit breaks through the back side of the acrylic. If the block is held tight to the window the acrylic will not crack.



- i. Use a 9/32 (7.14 mm) drill bit to open the hole to finished dimensions.



Rotary Grindstone

- j. Smooth (chamfer) the top and bottom edges of the holes with a rotary grindstone.
- k. Install the windows into the cabin in accordance with section 8-47 of the maintenance manual.