

Glstar/Sportsman Window Installation 2014

<https://www.youtube.com/watch?v=A336SG-fsil&t=83s>

Materials

- SCS2000 – SilPruf (Check expiration date – if within 1-2 months of expiration date buy a new tube)
- Cleco – manual wing style, standard ½” grip, size #40 (qty 24)
 - <https://www.aircraftspruce.com/catalog/topages/clecosheetholder4.php>
- Little wood pieces from Home Depot paint stir stick
- Razor blades
- 80 grit sand paper cut and folded/glued into strips
- 3M 2090 blue tape (1” and 2”)
- ¼” masking tape
 - https://www.amazon.com/3M-General-Purpose-Masking-203/dp/B0000G7UW6/ref=mp_s_a_1_1?keywords=3m%20general%20purpose%20masking%20203&qid=1583548686&sr=8-1&fbclid=IwAR3XG7o7ydMO1NPHayhN_BAs_A4YE-jgLR1hJvQVp7JjS7TkE0HtCzwXW1M
- Permatex Ultra Black
- Black Fine point wet erase markers (qty 12)
 - Cut tongue depressor and hot glue to pen cap to create wooden wedge to create a 3/16” gap between marker tip and wedge tip. This is to be used as an edge guide
- Paper towels
- 4” grinder to trim window using 80 grit sand paper

Instructions

Part 1 of video

- Pull off acrylic masking about 2” around window edge
- Set the window into place. Mark the window where it needs to be trimmed.

- Place the window on a bench with a light color cloth underneath. Trim window so that it fits in the window joggle. Always pull grinder towards you when trimming



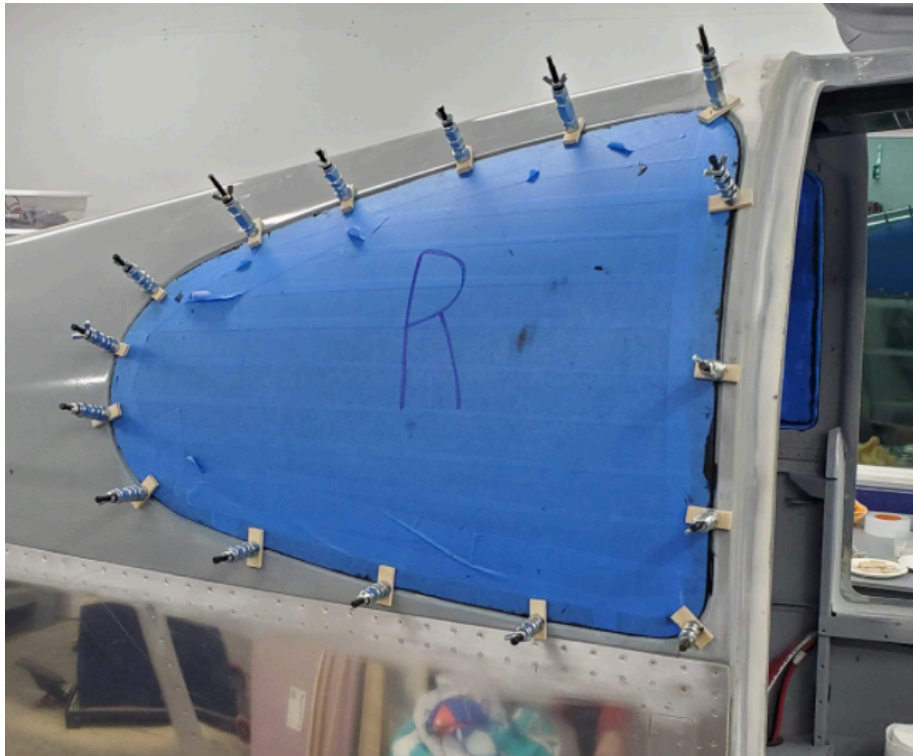
- Placed trimmed window in the joggle and run the marker around the edge with the 3/16" edge guide using a pen marker trim guide similar to the following



- Trim up to black marker on window
- Repeat trimming as necessary until there is a uniform gap of about 3/16" between window and joggle edge. Can use a block sander for final trimming.

Part 2 of video

- Sand joggle flat edge and joggle return edge to make sure to remove all gelcoat
- Sand the inside window opening edges so they look straight
- Place window back in joggle and center. Drill with #40 drill bit. Place drill bit against window and start to drill and then angle drill bit away from window to drill hole all the way through.
- With celcos in the four corners so window can't move trace edge of window onto the joggle edge with a pencil
- Trace the inside edge of the window with marker
- Mark on the joggle by every celco where you will be putting a stand off



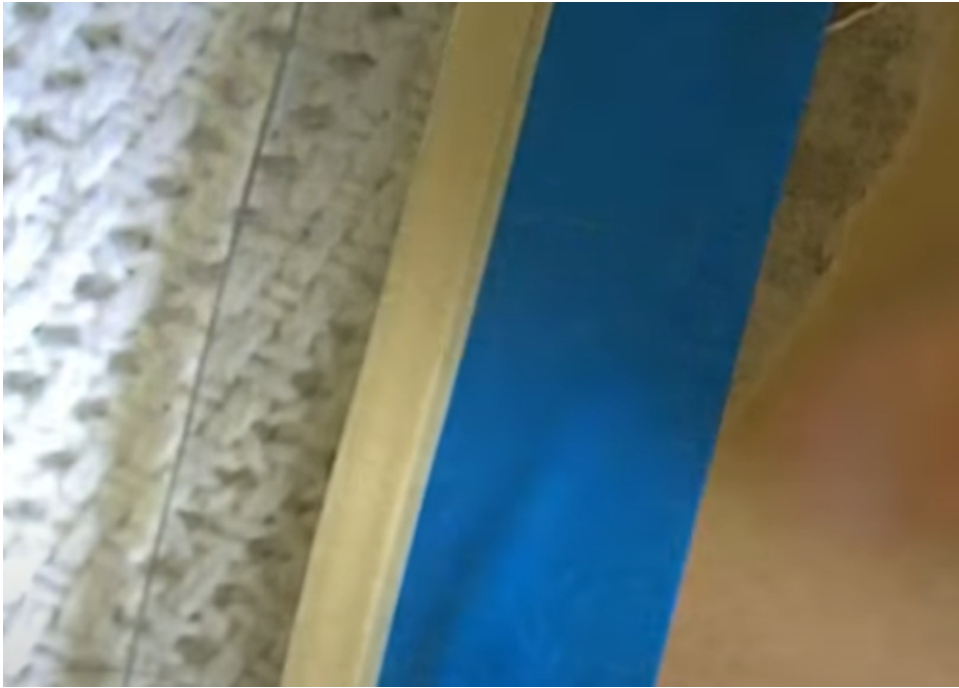


Part 3 of video

- Turn window upside down
- Take 1" blue tape and put it next to line and leave about a 3/16" gap between the line and tape. Can't be more than 1/4" inch because the masking tape has to cover this gap
- Put down 1/4" masking tape as close as possible to the black line but don't cover the black line
- Mark the tail end of this 1/4" tape with a 2



- Take a damp paper towel and remove line from the back of the window
- Add another layer of ¼" masking tape on top of the ¼" masking tape that you just put down. Overlap about 1/16 to the outside edge



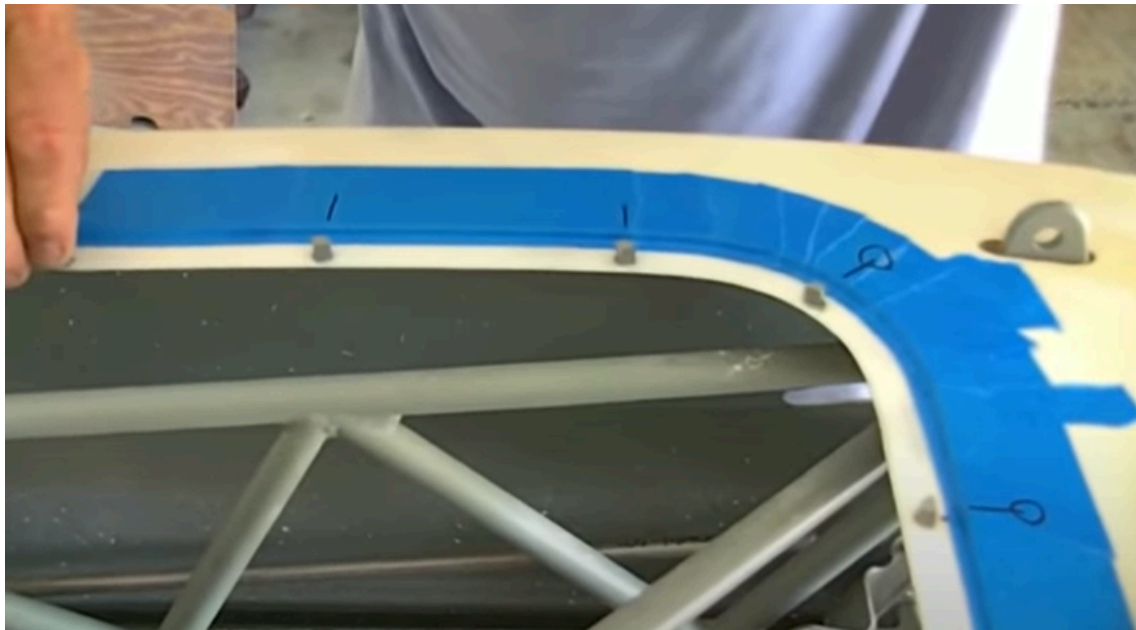
- Sand window edge with 80 grit to remove all grinding nicks
- Sand window edge with 120 grit and round the outside edge. Make sure to eliminate all serrations.
- Place the window outside edge up. Place 2" blue top on the outer edge of window and trim tape to window edge
- Sand inside edge of window with 80 grit making sure to not sand the ¼" masking tape

Part 4 of Video

- Wipe clean inside window edge
- Apply a thin bead of silpruf on inside edge - smooth with your finger
- Remove #1 ¼" masking tape ***IMPORTANT TO PULL OFF BEFORE SILPRUF CURES ***
- Let SilPruf cure 12 – 24 hours
- Lay some beads of SilPruf on a piece of aluminum and let dry for 3 days (these will be used as standoffs)
- Tape outer edge of door opening to pencil line



- Using the Permatex Ultra Black, glue the standoffs to the window opening. Let dry for 1-2 hours



- Tape and trim the back side of the window opening to prevent SilPruf from getting on interior of fuselage/doors



Part 5 of Video

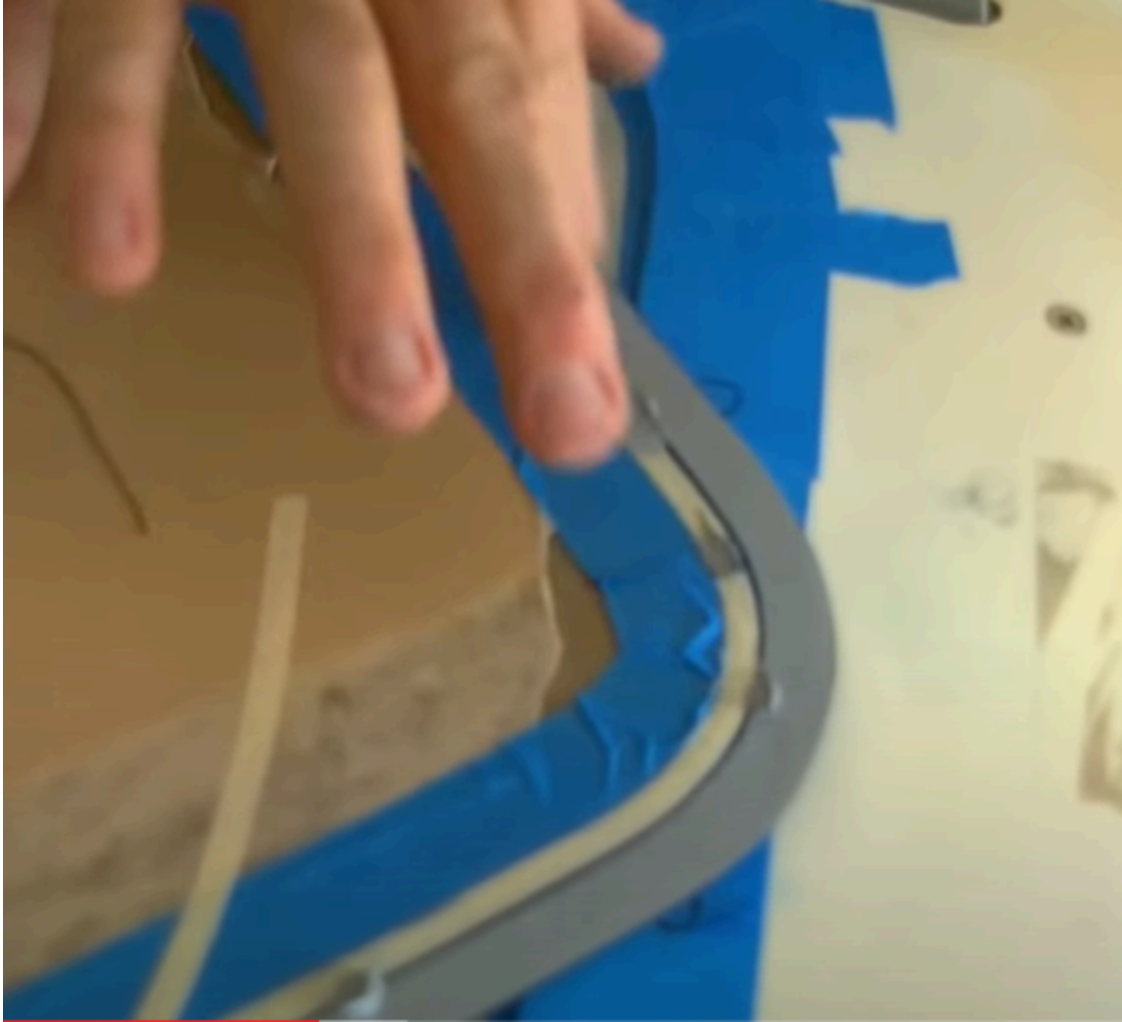
- Clean silpruf off edge of window with razor blade



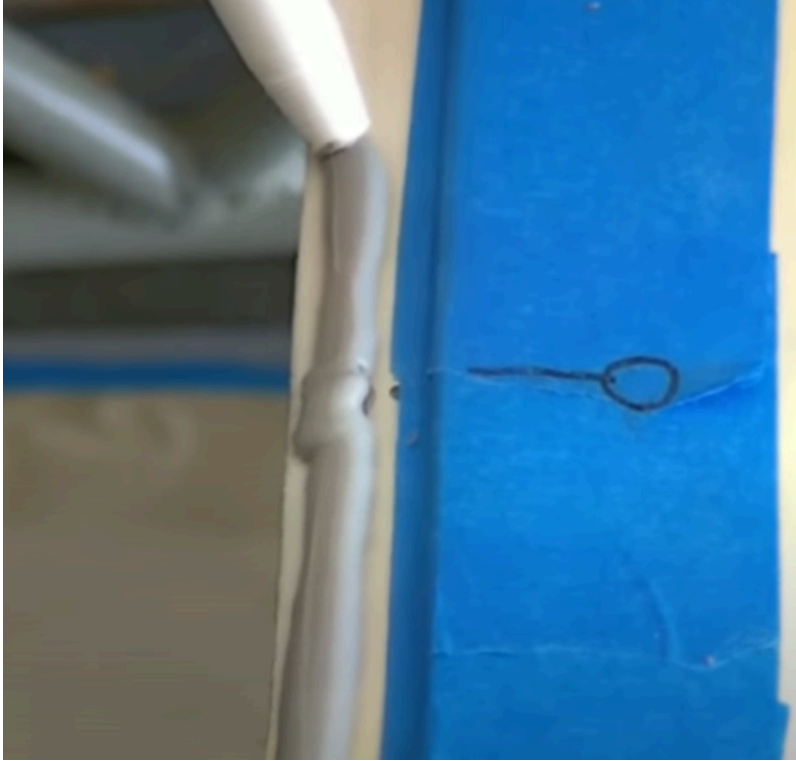
- Trim standoffs so the window fits flush with fuselage - tests flushness with back or razor



- Add silpruf to inside of window to cover gap made by removing tape #1



- Add silpruf to window joggle



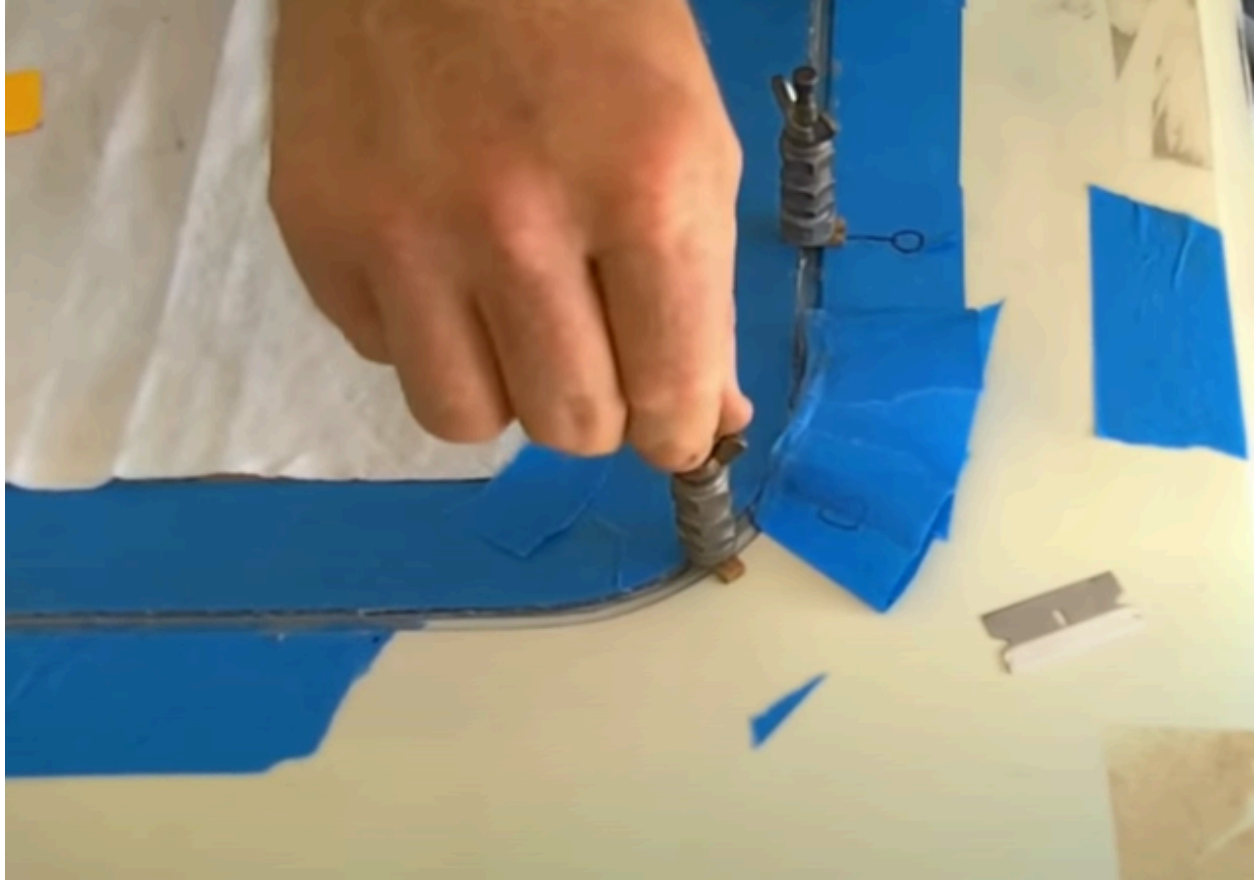
- Place window and make sure there is enough silpruf. Clean silpruf out of joogle. Drill through holes that are covered on the inside of the window.



Place wing style clecko



- Remove outside window tape before silpruf sets up. When you come up to the wingnut cleco, remove it and flip over wood spacer so clean wood side will mates with the now exposed fuselage so no silpruf residue will remain on the outside of the fuselage.



- Scrap excess Silpruf on the inside the of window around the perimeter. Make sure to leave a thin film coat of silpruf so that window is covered.



Pull off tape #2

Leave cleco's in for a minimum of 2 days (4 days is recommended)

DONE!