

No. 65-12

Issued: May, 1965

WINDSHIELD REPLACEMENT

MODELS AFFECTED: BEECHCRAFT Musketeer - Model 23 and A-23.

This letter outlines a step by step procedure to facilitate replacing the windshield, if such becomes necessary in the field.

Remove the windshield as follows:

1. Remove compass, glareshield and upholstery trim around windshield. The Outside Air Temperature indicator should be removed at this time.

2. Drill out all rivets which secure the windshield in place.

NOTE

Position a cloth over the instrument panel to catch rivets and foreign fragments. Remove the upper seven AN525-8R9 bolts on each side of the windshield frame. Disconnect speaker wire if clamped to windshield frame.

3. Loosen the windshield by slowly working a thin phenolic strip all the way around between the windshield frame and the fuselage. Be very careful during this operation so as not to bend or damage the skin of the airframe.

4. Remove the windshield from the fuselage.

Installation of the Windshield:

1. Remove all the old bonding material from the airframe.

2. Trim the frame edges of the windshield as neces-

sary for fitting.

3. Position the new windshield to the fuselage. Normally 1/16 inch clearance should exist between the plexiglass and the upper fuselage frame at station 94.00 on inside of the cabin.

4. Firmly hold windshield in position with pressure exerted on the outside of the windshield. The windshield should then be back-drilled through the existing holes in the airframe. A #30 hole duplicator may be used on the lower front windshield frame to facilitate drilling. If necessary 1/8 inch rivets may be replaced by 5/32 inch rivets where a hole has been elongated. It is recommended that after drilling each hole, the windshield be further clamped with a cleco before drilling the next hole.

5. After the windshield frame has been drilled and fitted, remove the windshield and deburr.

6. Position the windshield in place with clecos to make certain that a good fit has been made after deburring. Trim any rough edges.

7. The windshield may now be removed and EC-1792 (product of Minnesota Mining and Manufacturing Co., Minneapolis, Minnesota) or equivalent, should be applied in liberal amounts to the windshield frame.

8. Properly locate the windshield to the fuselage and cleco in position.

9. Secure the windshield to the airframe with rivets as soon as possible after the component has been firmly positioned.

10. Allow 24 hours curing time before the windshield frame is cleaned up and painted. Reinstall the Temperature Indicator, compass, glareshield, upholstery, etc.

Spare windshields assemblies (including bonding material and attaching parts) may be ordered by P/N 169-420005-201.

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