

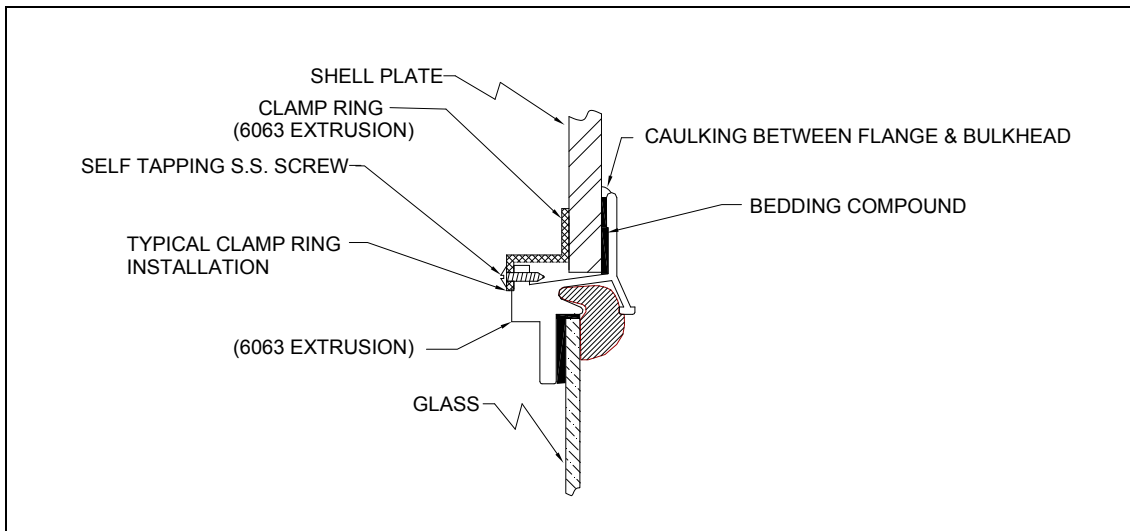


DIAMOND / SEA-GLAZE

WINDOW INSTALLATION INSTRUCTIONS

(Clamp Ring Style)

1. Ensure that both the material around the cutout and the inside face of the window flange are clean of grease and dirt.
2. With clamp ring removed, dry-fit the window to ensure the heel of the window frame fits inside the bulkhead cutout. Ensure the window is centered (shims might be required to center the window). It is often helpful to trace the window perimeter so there is a reference line to ensure the window is centered during final installation. From the inside of the cabin, dry-fit the trim ring as well to ensure suitable clearance.
3. Inspect and note any low spots in the bulkhead. Mark the corresponding low spots so any voids can be filled with extra bedding compound.
4. Run a continuous bead of bedding compound around bulkhead (or inside face of window flange) and proceed to install window. Do not over-tighten clamp ring; seat frame in bedding with even pressure.
5. If butyl tape is used as a bedding compound it is recommended to run a bead of silicone around perimeter of window flange to seal between the flange and the bulkhead (masking is advisable). This step improves the seal and prevents the butyl tape from bleeding down the bulkhead.



D5 fixed window depicted above

6. Clean as required with methyl-hydrate.
7. Urethane and/or Silicone will require approximately 24 hours to properly set.