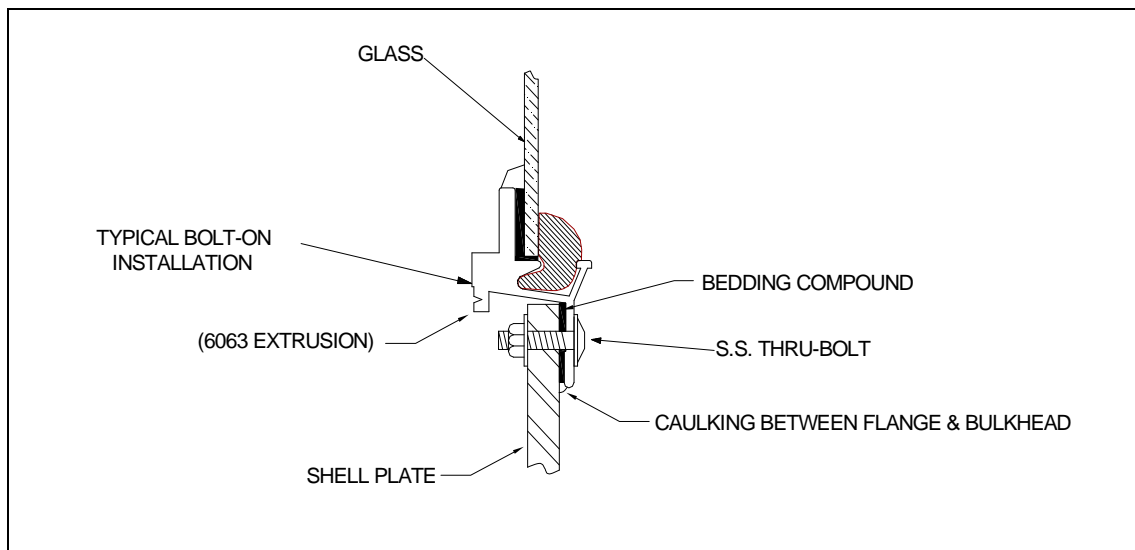


1. Ensure that both the material around the cutout and the inside face of the window flange are clean.
2. Dry-fit the window to ensure the heel of the window frame fits inside the bulkhead cutout. Ensure the window is centered (shims might be required to center the window). Also ensure there is sufficient coverage for bolt pattern. If holes are pre-drilled in window flange move to step #4.
3. If holes are not pre-drilled, lay-out the bolt pattern on the window flange.
4. Drill holes and thru-bolt one fastener in or near each corner to ensure the frame will not move when drilling remaining holes.
5. Inspect and note any low spots in the bulkhead. Mark the low spots so they can be filled with extra bedding compound.
6. Run a continuous bead of bedding compound around bulkhead (or inside face of window flange) and proceed to install window. Do not over-tighten bolts; seat frame in bedding with even pressure.
7. 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*