

MANDATORY SERVICE BULLETIN**NUMBER:** SB12-08**REVISION:** 02**DATE:** May 16, 2013**SUBJECT:** Windshield Securing System Installation**EFFECTIVITY:**

KODIAK 100 Series Aircraft Serial Numbers: 100-0001 through 100-0076

SUMMARY:

The accompanying field service instruction provides guidance for installing the windshield securing screws and windshield seal, to implement a redundant fastening system.

Quest Aircraft Company will supply one (1) Service Kit per aircraft at no cost to aircraft owner. Contact Quest Customer Service for Service Kit P/N FSI-044.

COMPLIANCE:

This Mandatory Service Bulletin must be complied with on or before the next 100 Hour Inspection or Annual Inspection whichever comes first.

ATTACHED DOCUMENTS:

Document #:	Revision:	Document Title:
FSI-044	03	Windshield Securing System Installation

FAA APPROVAL STATUS:

The instructions attached to this Service Bulletin have demonstrated compliance with all applicable Federal Aviation Regulations and are approved by the Federal Aviation Administration.

CREDIT AND WARRANTY INFORMATION:

Quest Aircraft Company will reimburse for the cost of this modification up to \$595.00 for aircraft under factory warranty. For reimbursement send Quest Aircraft Company a copy of the maintenance record, completed KODIAK 100 Warranty Claim Form, and an invoice that does not exceed the amount listed above.

Quest Customer Service**Service Bulletin: SB12-08****Phone:** (208)263-1111 Toll Free: 1(866)263-1112**Email:** Customerservice@questaircraft.com**SPECIAL INSTRUCTIONS:**

N/A

MANDATORY SERVICE BULLETIN***MANDATORY SERVICE BULLETIN***



FIELD SERVICE INSTRUCTION

TITLE:

Windshield Securing System Installation

SERIAL RANGE:

As Required

JASC CODE: 5600

PAGE:

1 of 18

REPORT NO.:

FSI-044

REVISION:

03

SUBJECT

This field service instruction provides guidance for installing the windshield securing screws and windshield seal, to implement a redundant fastening system.

AFFECTED MANUALS AND PUBLICATIONS

None

INDUSTRY REFERENCES

None

WEIGHT AND BALANCE

Negligible

MANPOWER

The estimated man-hours and minimum number of persons required to perform this field service instruction are listed below. The "Minimum Persons" refers only to maintenance personnel or installers and, unless otherwise specified within this instruction, does not include additional personnel that may be needed solely to comply with safety requirements (for example, safety observers that are not performing tasks within this instruction). It is the responsibility of maintenance personnel to comply with safety requirements, including having a safety observer available as needed.

Estimated Man-hours: 7 hours

Minimum Persons: 2 persons

If more than the minimum personnel perform this instruction, the actual man-hours required may be reduced due to increased efficiencies. As appropriate, Quest encourages the use of additional personnel; man-hour estimates are based on the minimum personnel required.

RECORD OF COMPLETION

- Update the appropriate maintenance records.
- Ensure the *KODIAK 100 Airplane Maintenance Manual* is up-to-date with the latest revision applicable to your airplane.
- Ensure the *KODIAK 100 Pilot's Operating Handbook/Airplane Flight Manual* is up-to-date with the latest revision applicable to your airplane.

Quest Aircraft Company, LLC
1200 Turbine Drive
Sandpoint, ID 83864



REVISION RECORD

REV	PAGE	CHANGE DESCRIPTION
00	All	Initial Release
01	All	Update Title Block to Revision 01 Updated formatting of document to correspond with current style standards.
	5	Increase quantity of 100-990-0065-D01 from 180 in to 185 in.
	5, 10	Reduce quantity of AN525-10R18 from 4 to 2. References to AN525-10R18 being used for safety clip installation replaced with AN525-10R14 fasteners. Add 2x AN525-10R14 to Table 2-1.
	8	Figure 5-1 updated with new image.
	9	Figure 5-4 updated with new image.
	10	Figure 5-5 updated with new image.
	11-14	Section 5.2.1 steps 2 and 3 are added. Existing steps in section are re-numbered.
	15	Note added. "Fit and install..."
	16	Note added. "If the airplane's..."
	17	Figure 5-14 Resized to fit on page with note addition.
	17	Section 5.4 Step #1 broken down into 4 different steps.
	18	Section 5.5 Step #8, "If" statements subdivided into separate steps.
02	12	<i>Change edge distance on hole in acrylic.</i> Step 7 was "Ensure hole is a minimum of 0.5" ...". Step 7 is "Ensure hole is a minimum of 0.37...". Note Updated: Note was "If 0.5" cannot be..." Note is "If 0.37" cannot be..."
03	All	Update Title Block to Revision 03 Updated formatting of document to correspond with current style standards.
	1	Estimated Man-hours changed. Was: 8, Is: 7.
	5	Table 2-2 edited. Increased Qty count for Part No. AN525-10R14. Was: 2 Is: 4
	10	Step 9, change screw part number. Was: P/N AN525-10R18 Is: P/N AN525-10R14. Following step 9, Note added.
	11	Section 5.2.1 Step 1: Deleted instruction to remove the standby airspeed indicator. Added: "The pitot static tubes may need to be shifted in order to..." Following step 1, Caution added.
	13	Step 12 edited to add: "Dry fit the screw to ensure proper length screw was selected." Following step 12, added Note referring to proper screw length selection. Step 13 edited to add option for longer screw (P/N AN525-10R14 or P/N AN525-10R18)
	17	Section 5.4 Step 2: Edited. Was: "Reinstall any removed..." Is: "Reinstall any disconnected...". Step 4: Deleted instruction to reinstall standby airspeed indicator. Step 5: Edited. Was: "Ensure the pitot and" Is: "If the pitot-static system was disconnected, ensure..."



TABLE OF CONTENTS

REVISION RECORD.....	2
TABLE OF CONTENTS.....	3
1. Special Safety Instructions.....	5
1.1 Warnings	5
1.2 Cautions	5
1.3 Notes.....	5
2. Parts, Tools, and Equipment	5
Table 2-1: Parts and Tools Included in the Service Kit.....	5
Table 2-2: Consumables Included in the Service Kit.....	5
Table 2-3: Serial-Number-Specific Parts Included in the Service Kit	5
Table 2-4: Parts and Tools NOT Included in the Service Kit	6
3. General.....	7
Figure 3-1: Overview of Windshield Securing Points	7
4. Preparation	7
5. Instructions.....	7
5.1 Installing the Upper Windshield Clips	8
Figure 5-1: Upper Screw and Clip Installed.....	8
5.1.1 Installing the Pilot Side Clip	8
Figure 5-2: Surfaces of Clip to be Covered with Rubber	8
Figure 5-3: Marked Location of Clip, Pilot Side.....	9
Figure 5-4: Clip Alignment with Windshield Frame	9
Figure 5-5: Pilot Side Upper Screw and Clip Installed	10
5.1.2 Installing the Copilot Side Clip.....	10
5.2 Installing the Lower Screws into the Boot Cowl	11
5.2.1 Installing the Pilot Side Boot Cowl Screw	11
Figure 5-6: Measuring Boot Cowl for Screw Location, Copilot Side.....	11
Figure 5-7: Drilling Pilot Hole for Lower Windshield Screw.....	12
Figure 5-8: Drilling Through the Windshield and Boot Cowl	12
Figure 5-9: Enlarging the Aluminum for the Lower Screw	13
Figure 5-10: Lower Screw Installed (Inside View).....	14
Figure 5-11: Lower Screw Installed (Outside View)	14
5.2.2 Installing the Copilot Side Boot Cowl Screw	14
5.3 Install Rubber Windshield Stripping.....	15
Figure 5-12: Masking Off 0.85" Measurement	15
Figure 5-13: Installing the New Windshield Stripping	16
Figure 5-14: Installed Windshield Stripping	17
5.4 Reassemble Parts	17
5.5 Continued Inspections	17

6. Completion.....18

 QUEST AIRCRAFT COMPANY	FIELD SERVICE INSTRUCTION TITLE: Windshield Securing System Installation SERIAL RANGE: As Required JASC CODE: 5600	PAGE: 5 of 18 REPORT NO.: FSI-044 REVISION: 03
---	--	---

1. Special Safety Instructions

1.1 Warnings

Failure to comply with “Warnings” contained in this instruction may result in financial loss, significant delay in the completion time, and/or serious injury to personnel.

1.2 Cautions

Failure to comply with “Cautions” contained in this instruction may result in the destruction of components, unnecessary complications, the need to reverse completed work, and/or delays in the completion time.

1.3 Notes

“Notes” are provided when additional information may lead to an increase in efficiency.

2. Parts, Tools, and Equipment

The following tables describe the parts, tools, and equipment necessary to successfully complete this instruction. Where applicable, reference to drawings provided with this instruction is provided.

Table 2-1: Parts and Tools Included in the Service Kit

Item #	Part No.	Qty	Description	Drawing No.	Dwg Item #
2-1-1	100-210-7110-01	1	Upper Safety Clip, Pilot Side	N/A	N/A
2-1-2	100-210-7110-02	1	Upper Safety Clip, Copilot Side	N/A	N/A
2-1-3	440S	6 in	Anti-chafe Rubber, 1.4" wide strip	N/A	N/A
2-1-4	100-000-0070-0001	1	Hole Saw	N/A	N/A
2-1-5	SP-D732	1	7/32" Acrylic Drill Bit	N/A	N/A
2-1-6	AN525-10R18	2	Screw ¹	N/A	N/A
2-1-7	94733A707	4	Sealing Washer	N/A	N/A
2-1-8	NAS1149F0316P	2	Washer	N/A	N/A
2-1-9	MS21083N3	4	Nut	N/A	N/A
2-1-10	100-210-7115	2	Abrasion Washer	N/A	N/A
2-1-11	AN970-3	2	Large Area Washer	N/A	N/A
2-1-12	100-990-0065-D01	185 in	Rubber Windshield Stripping	N/A	N/A
2-1-13	AN525-10R14	4	Screw	N/A	N/A

1: Two (2) extra screws (AN525-10R18) are provided if needed.

Table 2-2: Consumables Included in the Service Kit

Item #	Part No.	Qty	Description	Drawing No.	Dwg Item #
2-2-1	RTV732-10-30ZCL	10oz	Dow Corning® 732 RTV Sealant (Alternate: RTV108) ¹	N/A	N/A

1: Consumables may be shipped separately from the primary kit.

Table 2-3: Serial-Number-Specific Parts Included in the Service Kit

Item #	Part No.	Qty	Description	Drawing No.	Dwg Item #
2-3-1	N/A	N/A	N/A	N/A	N/A



FIELD SERVICE INSTRUCTION

TITLE: Windshield Securing System Installation

SERIAL RANGE: As Required

JASC CODE: 5600

PAGE: 6 of 18

REPORT NO.: FSI-044

REVISION: 03

Table 2-4: Parts and Tools NOT Included in the Service Kit

Item #	Part No.	Qty	Description	Drawing No.	Dwg Item #
2-4-1	Commercially Available	AR	Masking Tape (or equivalent)	N/A	N/A
2-4-2	Commercially Available	1	Measuring Tool (such as a ruler)	N/A	N/A
2-4-3	Commercially Available	1	Right-Angle Drill, Low RPM	N/A	N/A
2-4-4	Commercially Available	1	0.098" (#40) Drill Bit, 6.0" length	N/A	N/A
2-4-5	Commercially Available	AR	Acetone or Methyl Ethyl Ketone (MEK)	N/A	N/A
2-4-6	Commercially Available	1	Trimming Tool (such as scissors or a knife)	N/A	N/A
2-4-7	Commercially Available	AR	Dish Soap	N/A	N/A
2-4-8	Commercially Available	AR	Isopropyl Alcohol (IPA)	N/A	N/A
2-4-9	Commercially Available	1	Mini-Cone Chuck	N/A	N/A

3. General

This Field Service Instruction provides guidance for installing the windshield securing system. See **Figure 3-1** below for an overview of the windshield securing points.

▲ NOTE ▲

If replacing a windshield with previously installed safety clips, not all steps in this FSI will be applicable. Follow applicable steps as needed for your airplane.

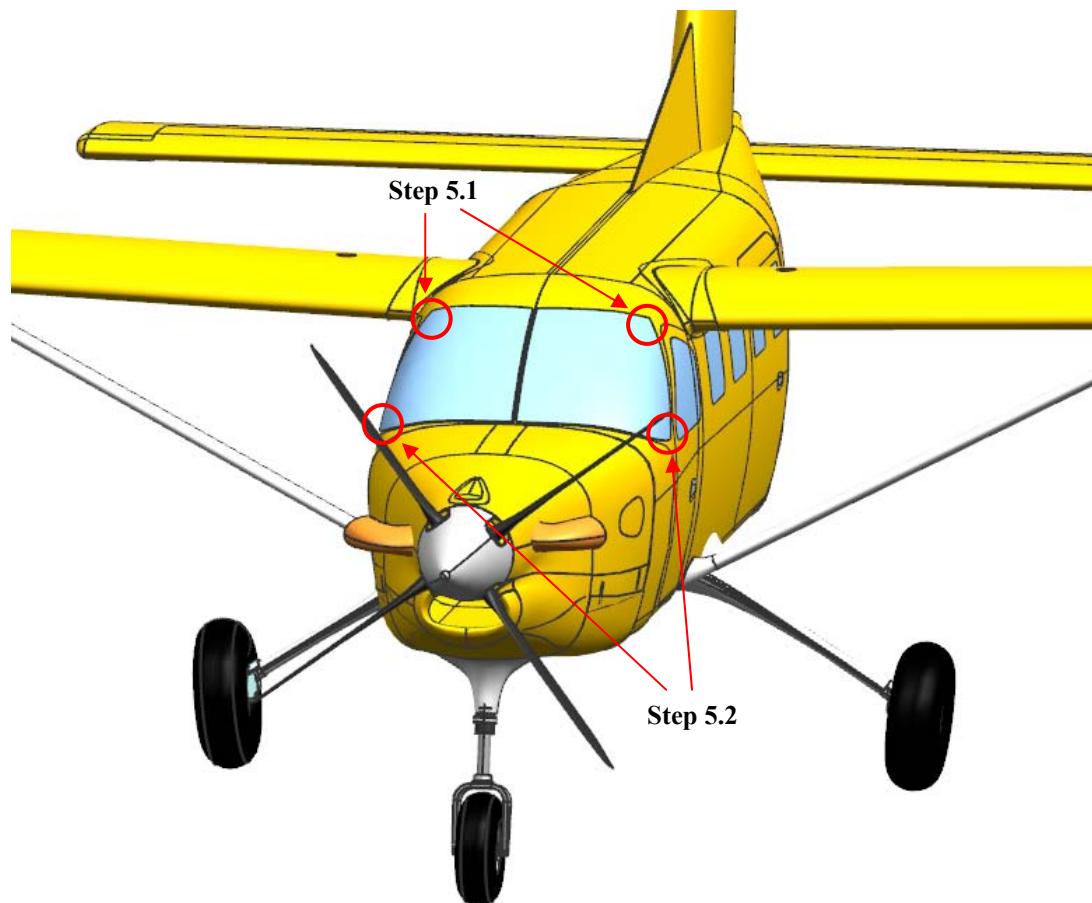


Figure 3-1: Overview of Windshield Securing Points

4. Preparation

1. Remove the forward crew ceiling interior, side grab handle, and the side interior covers next to the windshield, as shown in the *KODIAK 100 Maintenance Manual*, Chapter 25.
2. Mask off the top outboard corners of the windshield on the inside, in preparation to mark where the screw holes will go, without marking on the windshield itself.

5. Instructions

The following instructions define steps for installing two safety clips in the upper outboard corners of the windshield using two (2) AN525 screws, as well as installing two (2) AN525 screws in the lower corners of the windshield.

5.1 Installing the Upper Windshield Clips

Use the following steps to install the two (2) upper windshield screws and safety clips, one (1) per windshield. **Figure 5-1** shows an installed screw and clip.



Figure 5-1: Upper Screw and Clip Installed

5.1.1 Installing the Pilot Side Clip

1. Cut anti-chafe rubber with adhesive backing (P/N 440S) to fit on the surfaces of the pilot side upper safety clip (P/N 100-210-7110-01), as shown in **Figure 5-2**. Ensure the rubber covers the entirety of each face, starting at the radius of the curve.

▲ NOTE ▲

The pilot and co-pilot clips have different curvatures to mate to the windshield. Ensure the correct clip is used; it will be apparent if the wrong clip is used as it will not sit evenly on the windshield.

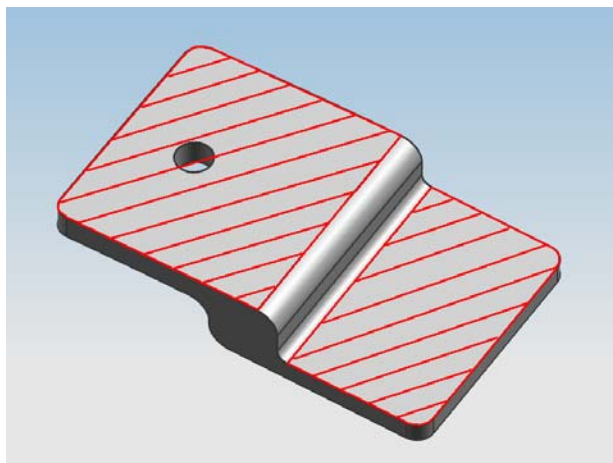


Figure 5-2: Surfaces of Clip to be Covered with Rubber

2. Apply the rubber to the clip. Cut a hole in the rubber to allow the screw to go through the hole in the clip.
3. On the inside of the windshield, measure 1.00" (± 0.050 ") down from the upper edge of the top frame and mark this measurement on the masking tape.
4. On the inside of the windshield, measure 1.160" (± 0.030 ") in from the outside edge of the outboard frame and mark this measurement on the masking tape. Refer to **Figure 5-3** for an illustration of the clip measurement. The cross hatch is the intended location for drilling.

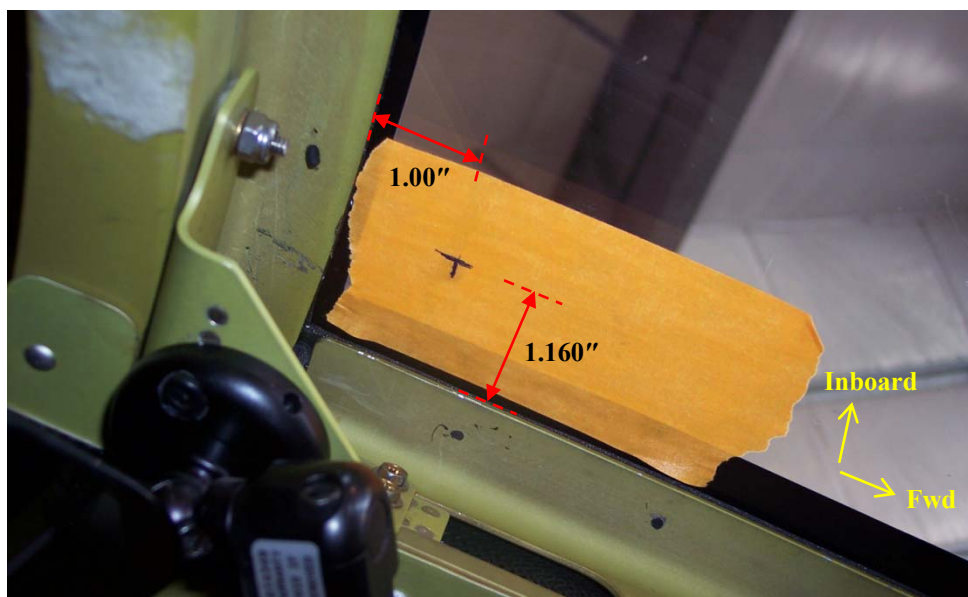


Figure 5-3: Marked Location of Clip, Pilot Side

5. Align the clip on the windshield so the screw hole is centered on the cross-hatch mark from step 4 above. Ensure the clip is square with the edge of the outboard side frame and verify a minimum gap of 0.160" (refer to **Figure 5-4**).

▲ NOTE ▲

Once installed, the clip should be touching the windshield but NOT the machined windshield frame.

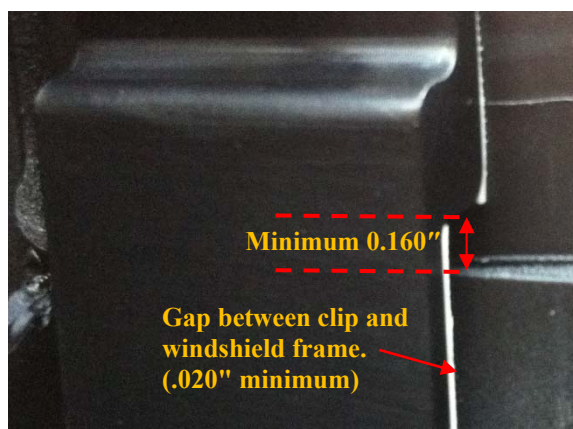


Figure 5-4: Clip Alignment with Windshield Frame

6. Remove the clip and, using a 7/32" acrylic drill bit (P/N SP-D732), drill through the windshield from the inside, using the mark made for guidance. Remove the masking tape.

▲ NOTE ▲

Ensure the drill is perpendicular to the surface before drilling.

7. Deburr the hole, ensuring no sharp edges.
8. Install a sealing washer (P/N 94733A707) onto a screw (P/N AN525-10R14).
9. Using RTV sealant (P/N RTV732-10-30ZCL), wet install the screw (P/N AN525-10R14) from the outside. On the inside, install the safety clip (P/N 100-210-7110-01), washer (P/N NAS1149F0316P) and nut (P/N MS21083N3).

▲ NOTE ▲

When properly installed a minimum of 2 thread lengths will be visible after the nut is installed.

10. Square the clip to the upper machined frame and tighten the nut until the rubber grommet begins to squeeze out around the screw head (5 – 10 in-lb). Refer to **Figure 5-5** for a view of the installed screw and clip.
11. Ensure the clip is square with the edge of the outboard side frame and verify a minimum gap of 0.160" (refer to **Figure 5-4**).



Figure 5-5: Pilot Side Upper Screw and Clip Installed

5.1.2 Installing the Copilot Side Clip

Repeat the steps given in **Section 5.1.1** on the upper corner of the copilot side of the windshield, using the copilot side safety clip (P/N 100-210-7110-02).

5.2 Installing the Lower Screws into the Boot Cowl

Use the following steps to install the two (2) lower windshield screws, one (1) per windshield. The lower windshield screws install through the boot cowl and windshield.

5.2.1 Installing the Pilot Side Boot Cowl Screw

1. Remove the standby attitude indicator on the pilot's side, as shown in the *KODIAK 100 Maintenance Manual*, Chapter 34. The pitot static tubes may need to be shifted in order to access the hole location.

⚠ CAUTION ⚠

Do NOT disconnect the pitot static tubes. If the pitot static tubes are disconnected the Pitot System Inspection and Leak Test is required following reassembly. (Refer to the *KODIAK 100 Maintenance Manual*, Chapter 34).

2. Remove insulating foam from the local work area (refer to **Figure 5-6**).
3. Remove residual adhesive and residue using isopropyl alcohol (IPA).
4. Measure 2.90" (± 0.050 ") from the front of the vertical frame and mark this location (refer to **Figure 5-6**).
5. Measure down 0.550" (± 0.030 ") from the bend on the boot cowl, intersecting this location with your previous mark, to find the drill location for the hole (refer to **Figure 5-6**).

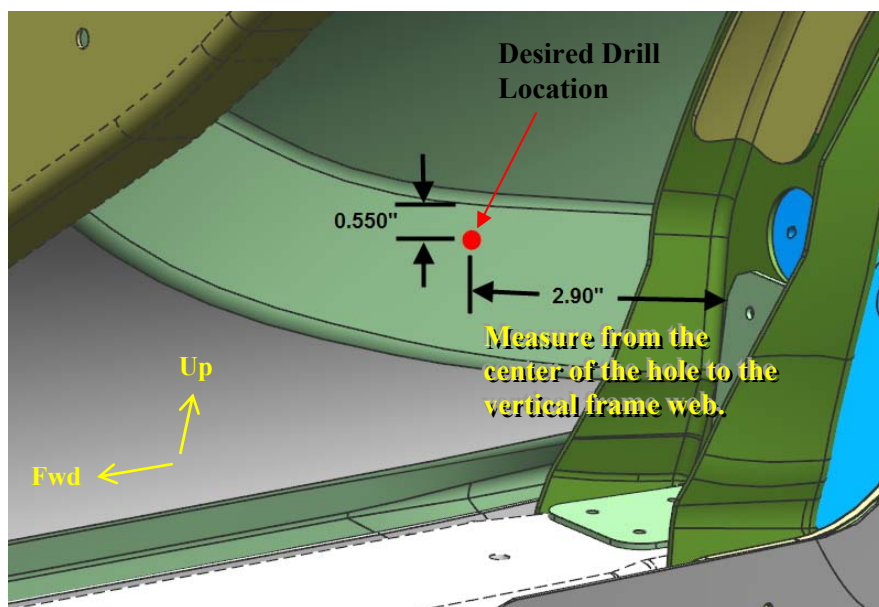


Figure 5-6: Measuring Boot Cowl for Screw Location, Copilot Side

6. Using a 0.098" (#40) drill bit, drill from the inside of the airplane through the spot determined by your measurements (refer to **Figure 5-7**). A low RPM, right-angle drill is recommended for this step.



Figure 5-7: Drilling Pilot Hole for Lower Windshield Screw

7. Ensure hole is a minimum of 0.37" from the edge of the windshield.

▲ NOTE ▲

If 0.37" cannot be achieved, contact Quest Customer Service for further instructions.

8. Using a 7/32" acrylic drill bit (P/N SP-D732), drill from the outside of the windshield back through the hole previously opened from the inside. Drill through the windshield and the boot cowl (refer to **Figure 5-8**).

▲ NOTE ▲

Ensure the drill is perpendicular to the surface while drilling.



Figure 5-8: Drilling Through the Windshield and Boot Cowl

9. Using a piloted hole saw (P/N 100-000-0070-0001) and a low RPM right-angle drill, enlarge the 7/32" hole from the inside, ensuring to cut out ONLY the aluminum (refer to **Figure 5-9**).

⚠ CAUTION ⚠

Be very careful to ONLY cut the aluminum; do NOT score the windshield. If the windshield is scored, contact Quest Customer Service for further instructions.

⚠ NOTE ⚠

A low RPM drill is highly recommended, as hole saws tend to chatter at higher RPMs and will make it extremely difficult to accurately perform this step.

10. Deburr the windshield, ensuring no sharp edges.
11. Deburr the aluminum on the inside, ensuring no sharp edges.



Figure 5-9: Enlarging the Aluminum for the Lower Screw

12. Install a sealing washer (P/N 94733A707) onto a screw (P/N AN525-10R14). Dry fit the screw to ensure proper length screw was selected.

⚠ NOTE ⚠

Due to the variable thickness of the windshield adhesive a longer screw (P/N AN525-10R18) may be required. When properly installed a minimum of two thread lengths will be visible after nut is installed.

13. Using RTV sealant (P/N RTV732-10-30ZCL), wet install the screw (P/N AN525-10R14 or P/N AN525-10R18) on the outside. On the inside, install the abrasion washer (P/N 100-210-7115), large area washer (P/N AN970-3), and nut (P/N MS21083N3) (refer to **Figure 5-10**).

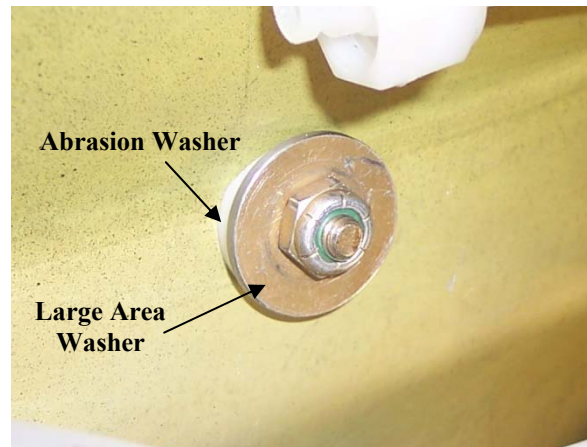


Figure 5-10: Lower Screw Installed (Inside View)

14. Tighten the nut until the sealing washer begins to squeeze out around the screw head (max torque 10 in-lb). Refer to **Figure 5-11** for a view of the installed lower screw from the outside.

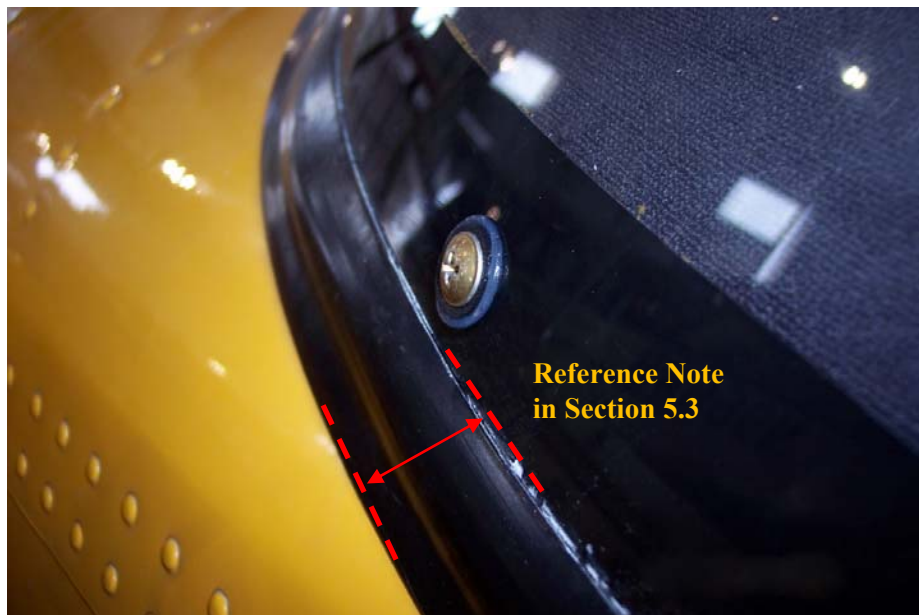


Figure 5-11: Lower Screw Installed (Outside View)

5.2.2 Installing the Copilot Side Boot Cowl Screw

1. On the copilot side, remove the turn coordinator as shown in the *KODIAK 100 Maintenance Manual*, Chapter 22. The pitot static tubes may need to be disconnected in order to access the hole location as shown in the *KODIAK 100 Maintenance Manual*, Chapter 34.
2. Repeat steps 2 through 14 from **Section 5.2.1** to mark the hole location, drill the hole, drill out the aluminum on the inside, and install the fastener.

5.3 Install Rubber Windshield Stripping

▲ NOTE ▲

If the airplane is equipped with 1.3" wide (or less) molding, the procedure in **Section 5.3** is mandatory (refer to **Figure 5-11**). If the airplane has 1.7" wide molding installed, proceed to **Section 5.4**. 1.7" wide molding (P/N 100-210-7012-01/-02) can be ordered by contacting Quest Customer Service.

1. Remove the outer windshield center post cover as shown in the *KODIAK 100 Maintenance Manual*, Chapter 56.
2. Measure 0.85" (± 0.050 ") from the edge of the molding on the top, outside, and bottom edges of the windshield. Mark this measurement by laying masking tape as you go (refer to **Figure 5-12**).

▲ NOTE ▲

Fit and install the windshield stripping along the full length of the existing windshield molding. When complete, the windshield stripping will extend under the outer windshield center post cover.



Figure 5-12: Masking Off 0.85" Measurement

3. Temporarily align the rubber windshield stripping (P/N 100-990-0065-D01) along the marked edges. Trim pieces of the windshield stripping into three separate lengths (one for the top, one for the bottom and one for the outside edge). Trim the corners of the stripping to ensure no overlap and trim around the fastener (refer to **Figure 5-14**). Mitering the corners is acceptable with a trim tool, such as scissors or a knife.
4. Remove and set aside the windshield stripping.

5. Clean the area between the masking tape and the edge of the windshield molding:
 - a. Use a mixture of dish soap and water to remove general contaminants on the surface.
 - b. Using a lint free cloth, wipe down the surface with isopropyl alcohol (IPA).
 - c. Let the IPA dry by flashing off the surface.
6. Install the new windshield stripping (P/N 100-990-0065-D01), slowly removing the adhesive tape and applying the seal to the windshield as you work (refer to **Figure 5-13**).

⚠ CAUTION ⚠

Be careful not to stretch the seal during application.

⚠ NOTE ⚠

The windshield periphery shall continue to be inspected and monitored in accordance with the latest revision of the *KODIAK 100 Maintenance Manual*, at the interval specified within the manual. The primer can be inspected by lifting the outside edge of the UV stripping and visually inspecting the black primer. Once all inspections are completed, the windshield molding can again be lifted and the stripping outside edge can be tucked under the windshield molding; refer to **Section 5.3, Step 7**.



Figure 5-13: Installing the New Windshield Stripping

7. Slide the edge of the windshield stripping underneath the already-installed molding. Refer to **Figure 5-14** for a final view of the installed stripping.

⚠ NOTE ⚠

If the airplane's existing windshield molding is glued to the windshield, light hand pressure or light force using a non-metallic scraper will free the molding from the windshield.

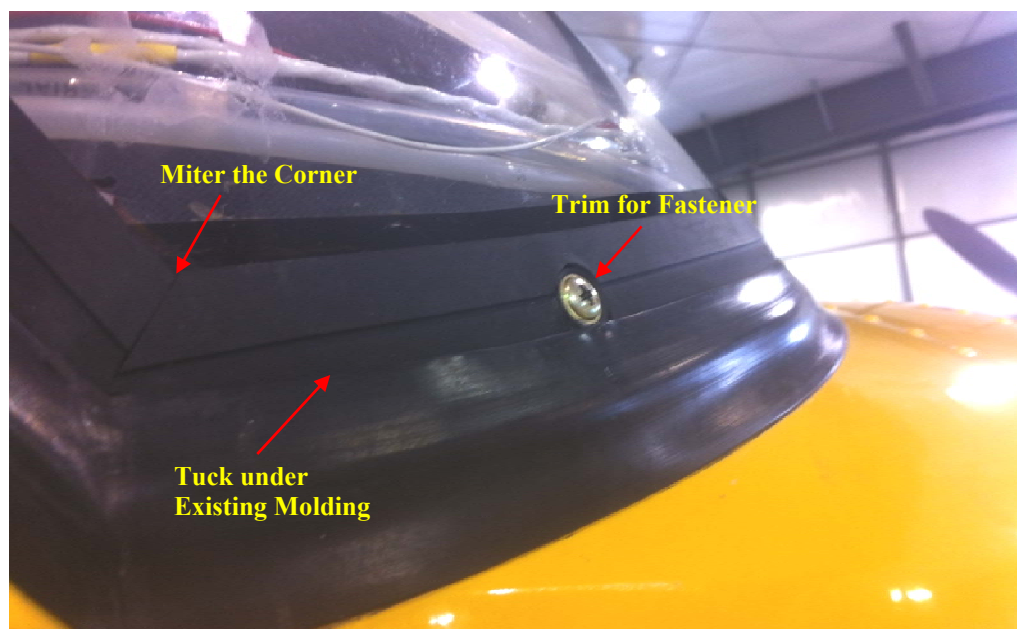


Figure 5-14: Installed Windshield Stripping

5.4 Reassemble Parts

1. Reinstall the outer center post cover as shown in the *KODIAK 100 Maintenance Manual*, Chapter 56.
2. Reinstall any disconnected pitot static tubes, as shown in the *KODIAK 100 Maintenance Manual*, Chapter 34.
3. Reinstall the turn coordinator as shown in the *KODIAK 100 Maintenance Manual*, Chapter 22.
4. Reinstall the standby attitude indicator, as shown in the *KODIAK 100 Maintenance Manual*, Chapter 34.
5. If the pitot-static system was disconnected, ensure the pitot and static systems are working properly by performing the following checks (refer to the *KODIAK 100 Maintenance Manual*, Chapter 34):
 - a. Static System Purging Procedure
 - b. Pitot System Inspection and Leak Test
 - c. Static System Inspection and Leak Test
6. Reinstall the forward crew ceiling interior, side interior covers, and grab handles, as shown in the *KODIAK 100 Maintenance Manual*, Chapter 25.
7. Clean the forward fuselage area of any foreign objects or debris.

5.5 Continued Inspections

The following inspections are required after the installation defined within this Field Service Instruction. The interval for inspection shall be the same as defined for “Windshield and Windows” in the *KODIAK 100 Maintenance Manual*, Chapter 5 (100 hr interval).



FIELD SERVICE INSTRUCTION

TITLE:

Windshield Securing System Installation

SERIAL RANGE:

As Required

JASC CODE:

5600

PAGE:

18 of 18

REPORT NO.:

FSI-044

REVISION:

03

1. Perform Windshield Inspection Procedures as defined in the *KODIAK 100 Maintenance Manual*, Chapter 56. The windshield stripping or molding must be pulled back to inspect for primer de-bonding.
2. Inspect the acrylic for signs of crazing, specifically at the bolt hole locations.
3. Ensure clip clearance, as shown in **Figure 5-4**. Correct as required.
4. Inspect for condition and security of the windshield stripping (P/N 100-990-0065-D01), if installed. Replace as necessary.

▲ NOTE ▲

If the airplane is equipped with 1.3" wide (or less) molding, installation of the windshield stripping (P/N 100-990-0065-D01) is mandatory. Refer to **Section 5.3**.

5. Inspect the interior at the acrylic and frame, as applicable, for signs of water intrusion.
6. Inspect the aluminum structure around the safety clip for signs of wear or rubbing.
7. Inspect the safety clip bolt to ensure a 5 – 10 in-lb torque and intact sealant.
8. Inspect the lower screws to ensure it is greater than hand tight and intact sealant.
 - a) If water intrusion is found, remove and reinstall the bolt in accordance with **Section 5.1** or **5.2**, as applicable.
 - b) If the sealing washer is found not seated properly, tighten the bolt until seated properly (maximum 10 in-lb).
 - c) If the sealing washer does not seat properly, replace with a new part (P/N 94733A707).
 - d) If crazing, wear, rubbing, other anomalies, or questions present themselves, contact Quest Customer Service for further instructions.

6. Completion

Record all work performed in the appropriate maintenance records.

---END---