



2244 Airport Way, Redmond, Oregon 97756 Phone 541 923-2233 Fax 541 923-2255

SERVICE BULLETIN

SB040-1197

Subject: Lancair IV-P Cabin Door Window

Date: 10 Dec., 97

Ref: None

Pages: 2

Status: Mandatory- Update for previous SB040

Background:

On two occasions, Lancair IV-P's, while pressurized, have experienced cracks in the cabin door windows. In both cases the cracks originated at the screws securing the two middle cabin door latches (the screws penetrate the window at the two center latches). In both cases, the cracks propagated outward and caused parts of the window to break loose. **The following fix is considered mandatory prior to pressurized flight.**

Action:

Parts Needed:

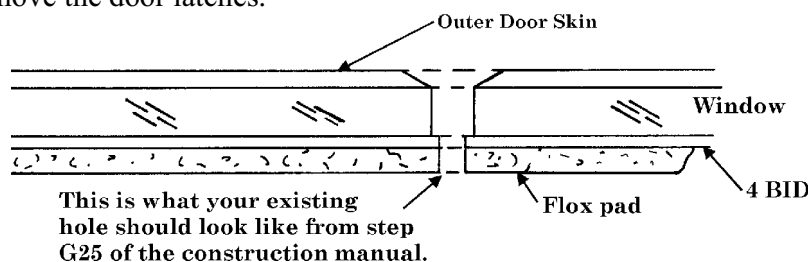
- (4) A3235-028-935 tinnerman washers
- (4) MS24694 screws (length varies, make appropriate selection)
- (4) AN365-1032A nuts
- (4) AN960-10 washers
- (4) AN960-10L washers
- Hysol- small amount
- Flox- small amount

#08860108 two flute straight-shank counter-bore bit; these can be ordered from the 97/98 MSC Catalogue. Phone# 1-800-645-7270 For those who cannot access MSC, we have a small supply of these counter bore bits, at a cost of \$7.00 each.

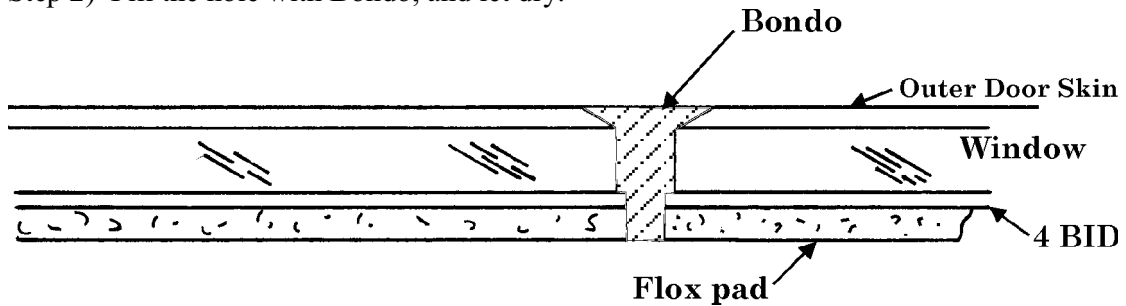
Procedure:

This procedure is written for existing installations. If you have not completed this section yet, follow the instructions of the next set of revisions to be sent out.

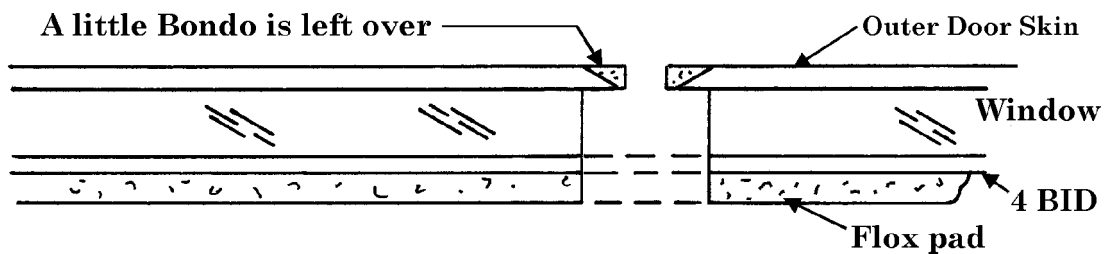
Step 1) Remove the door latches.



Step 2) Fill the hole with Bondo, and let dry.



Step 3) Drill the hole out from the inside with a 3/16" diameter drill bit. This will serve as a pilot hole.



Step 4) Drill out the hole with the counter bore (#08860108) bit. As you approach the carbon with your bit, slow down and carefully watch for black shavings. As soon as you see black, stop drilling. Inspect the bottom of the hole carefully with a flashlight, you must drill completely through the window, removing as little of the carbon skin as possible.

Step 5) Countersink the hole (on the outboard side!) as necessary to accept the A3135 - 017-24A tinnerman washer. Get everything ready to re-assemble. Wax the MS24694 screws with candle wax.

Step 6) Fill the holes with Hysol/flox and re-assemble.

