

## CHAPTER 52

## DOORS AND WINDOWS

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52-1	Forward Door Assembly . . . . .	52.0
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52-11	Windshield Installation . . . . .	52.10

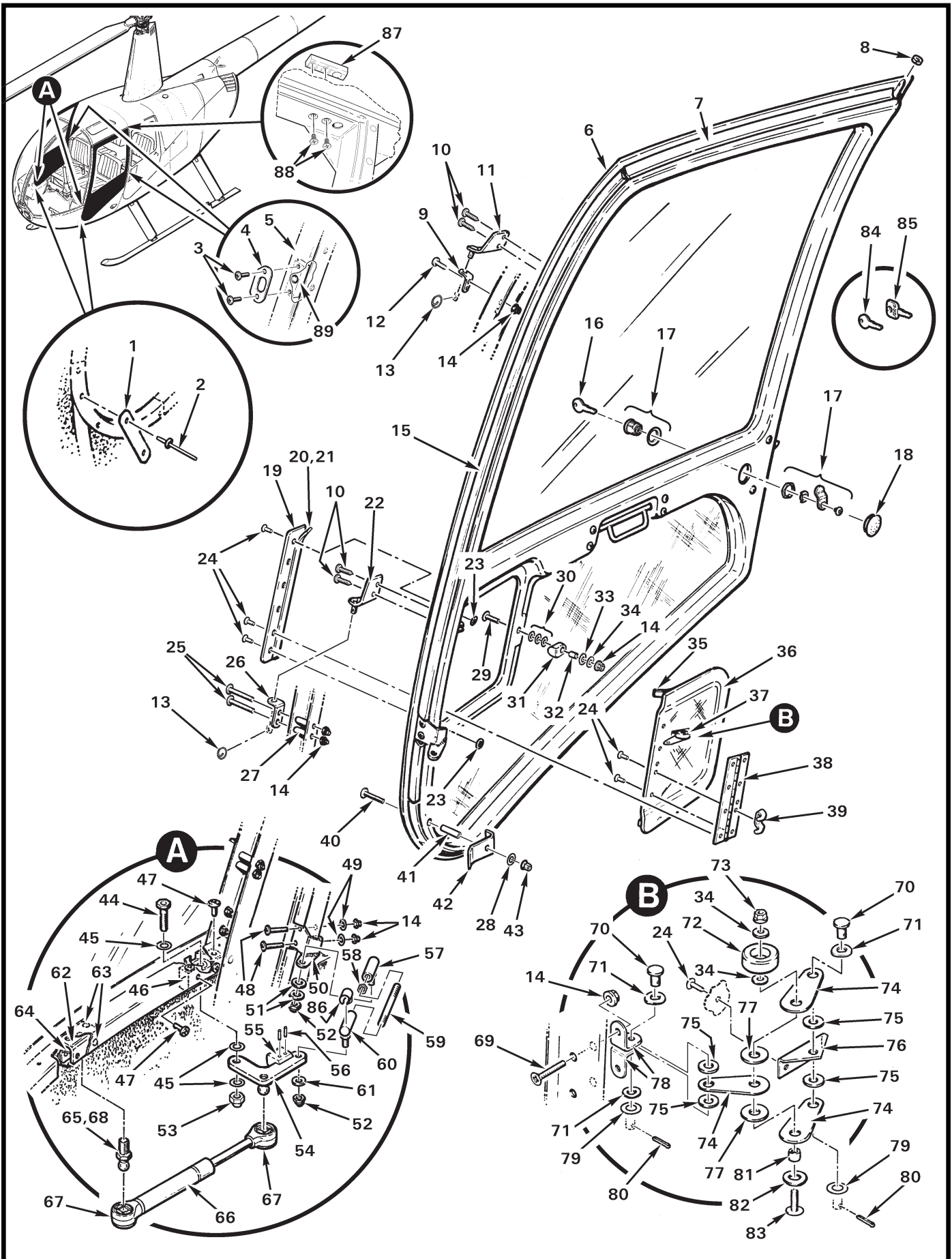


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>FORWARD DOOR ASSEMBLY</b>				
52-1-1	A767-1	Rub Strip (RH and LH) . . . . .	X	2
2	B204-1	Rivet (blind; alternate part no. 1693-0410) . . . . .	X	4
3	AN525-832R6	Screw . . . . .	X	2
4	C538-1	Plate . . . . .	X	1
5	C403	Door Post (Ref)		
6	C026-012*	Door Assembly (RH, clear; Incl items 7, 14, 15, 17 thru 21, 23, 24, 28 thru 43, 48 thru 50, 69 thru 72, and 74 thru 82) . .	X	1
	C026-011*	Door Assembly (LH, clear; Incl items 7, 14, 15, 17 thru 21, 23, 24, 28 thru 43, 48 thru 50, 69 thru 72, and 74 thru 82; not shown) . . . . .	X	1
	C026-022*	Door Assembly (RH, tinted; Incl items 7, 14, 15, 17 thru 21, 23, 24, 28 thru 43, 48 thru 50, 69 thru 72, and 74 thru 82) . .	X	1
	C026-021*	Door Assembly (LH, tinted; Incl items 7, 14, 15, 17 thru 21, 23, 24, 28 thru 43, 48 thru 50, 69 thru 72, and 74 thru 82; not shown) . . . . .	X	1
	C026-032*	Door Assembly (RH, bubble, clear; Incl items 7, 14, 15, 17 thru 21, 23, 24, 28 thru 43, 48 thru 50, 69 thru 72, and 74 thru 82; not shown) . . . . .	X	1
	C026-031*	Door Assembly (LH, bubble, clear; Incl items 7, 14, 15, 17 thru 21, 23, 24, 28 thru 43, 48 thru 50, 69 thru 72, and 74 thru 82; not shown) . . . . .	X	1
	C026-042*	Door Assembly (RH, bubble, tinted; Incl items 7, 14, 15, 17 thru 21, 23, 24, 28 thru 43, 48 thru 50, 69 thru 72, and 74 thru 82; not shown) . . . . .	X	1
	C026-041*	Door Assembly (LH, bubble, tinted; Incl items 7, 14, 15, 17 thru 21, 23, 24, 28 thru 43, 48 thru 50, 69 thru 72, and 74 thru 82; not shown) . . . . .	X	1
7	A226-2	Seal (install using B270-8qt adhesive) . . . . .	X	A/R
	B270-8qt	Adhesive (or B270-8qt) . . . . .	X	A/R
8	NAS557-4B	Grommet . . . . .	X	1
9	A228-1	Hinge Assembly (RH and LH, upper) . . . . .	X	1
10	MS51861-37C	Screw (self-tapping) . . . . .	X	4
11	C227-4	Hinge Assembly (RH, upper) . . . . .	X	1
	C227-3	Hinge Assembly (LH, upper) . . . . .	X	1
12	MS27039C0807	Screw . . . . .	X	2
13	B427-1	Ring - Cotter . . . . .	X	2

NOTES \* Will be shipped painted white.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
FORWARD DOOR ASSEMBLY (Cont'd)				
52-1-14	MS21042L08	Nut . . . . .	X	7
15	A226-6	Seal (forward door edge, self-adhesive) . . . . .	X	A/R
16	—	Key (metal) . . . . .	O	1
17	A556-1	Lock Set (RH and LH, set of two; includes item 16 [4]) . . . . .	X	1
18	2713	Hole Plug (install using B270-9 adhesive) . . . . .	X	1
	B270-9	Adhesive (2-oz kit) . . . . .	X	A/R
19	C682-2	Barrier . . . . .	X	1
20	A226-3	Seal (install using item 21) . . . . .	X	A/R
21	B270-4	Adhesive (10-oz tube) . . . . .	X	A/R
22	C227-2	Hinge Assembly (RH, lower) . . . . .	X	1
	C227-1	Hinge Assembly (LH, lower) . . . . .	X	1
23	NAS1149FN232P	Washer . . . . .	X	2
24	MS20470AD3	Rivet . . . . .	X	13
25	MS27039C0824	Screw . . . . .	X	2
26	C228-1	Hinge (RH and LH, lower) . . . . .	X	1
27	C130-37	Spacer . . . . .	X	2
28	NAS1149FN816P	Washer (as required for shimming) . . . . .	X	A/R
29	AN525-832R10	Screw . . . . .	X	1
30	NAS1149FN816P	Washer (or NAS1149FN832P as required for proper seal compression) . . . . .	X	A/R
31	C285-1	Knob . . . . .	X	1
32	C130-5	Spacer . . . . .	X	1
33	U216-0100-S	Spring Washer . . . . .	X	1
34	NAS1149FN816P	Washer . . . . .	X	2
35	A226-7	Seal (self-adhesive, 3 sides of vent door) . . . . .	X	A/R
36	C425-2	Vent Door (RH, door only) . . . . .	X	1
	C425-1	Vent Door (LH, door only) . . . . .	X	1
37	A425-17	Arm Assembly (Incl items 14, 34, and 70 thru 83) . . . . .	X	1
38	C425-5	Hinge (RH and LH) . . . . .	X	1
39	B242-2	Stop (RH and LH) . . . . .	X	1
40	AN525-832R24	Screw . . . . .	X	1

NOTES

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
FORWARD DOOR ASSEMBLY (Cont'd)				
52-1-41	C130-19	Spacer . . . . .	X	1
42	A768-1	Clip (LH) . . . . .	X	1
43	B340-4	Nut . . . . .	X	2
44	NAS6604-12	Bolt . . . . .	X	1
45	NAS1149F0432P	Washer . . . . .	X	3
46	D573-1	Block . . . . .	X	1
47	MS27039C0806	Screw . . . . .	X	4
48	AN525-832R16	Screw . . . . .	X	2
49	NAS1149FN832P	Washer . . . . .	X	2
50	D574-3	Bracket (LH, not shown) . . . . .	X	1
	D574-4	Bracket (RH) . . . . .	X	1
51	NAS1149F0363P	Washer . . . . .	X	2
52	B340-8	Nut . . . . .	X	2
53	B340-10	Nut . . . . .	X	1
54	D574-1	Arm Assembly (LH, not shown; Incl items 55 and 56) . . . . .	X	1
	D574-2	Arm Assembly (RH; Incl items 55 and 56) . . . . .	X	1
55	D573-7	Bumper . . . . .	X	1
56	MS16562-4	Spring Pin . . . . .	X	2
57	D575-3	Ball Joint . . . . .	X	1
58	AN315-3R	Nut . . . . .	X	1
59	D573-4	Rod . . . . .	X	1
60	D575-2	Ball Joint . . . . .	X	1
61	NAS1149F0363P	Washer . . . . .	X	1
62	D573-3	Block (install using item 63) . . . . .	X	1
63	MS20470AD4	Rivet . . . . .	X	6
64	D573-5	Angle . . . . .	X	1
65	C394-2	Ball Stud (use item 68 on threads) . . . . .	X	1
66	D575-1	Gas Spring . . . . .	X	1
67	PS130	End Connector . . . . .	X	2
68	B270-10	Adhesive (1.69-oz) . . . . .	X	A/R
69	MS24694-S11	Screw . . . . .	X	2

NOTES

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>FORWARD DOOR ASSEMBLY (Cont'd)</b>				
52-1-70	MS20392-2C7	Pin . . . . .	X	2
71	U190-0090S	Spring Washer . . . . .	X	3
72	A431-1	Knob . . . . .	X	1
73	MS21042L08	Nut . . . . .	X	1
74	A425-7	Arm . . . . .	X	3
75	A141-8	Washer . . . . .	X	4
76	A425-13	Angle (RH and LH) . . . . .	X	1
77	A141-7	Washer . . . . .	X	2
78	A425-19	Clip . . . . .	X	2
79	NAS1149F0332P	Washer . . . . .	X	2
80	MS24665-132	Cotter Pin . . . . .	X	2
81	A105-7	Journal . . . . .	X	1
82	U250-0185	Spring Washer . . . . .	X	1
83	AN525-832R8	Screw . . . . .	X	1
84	R8096	Key - Duplicate (specify ship S/N and "PK" numbers when ordering) . . . . .	X	1
85	D768-2	Key (blank; black plastic-coated, "R44" logo) . . . . .	X	1
86	P-8100	Clip . . . . .	X	1
87	C537-16	Block . . . . .	X	2
88	93195A322	Screw . . . . .	X	4
89	C537-11	Block . . . . .	X	2

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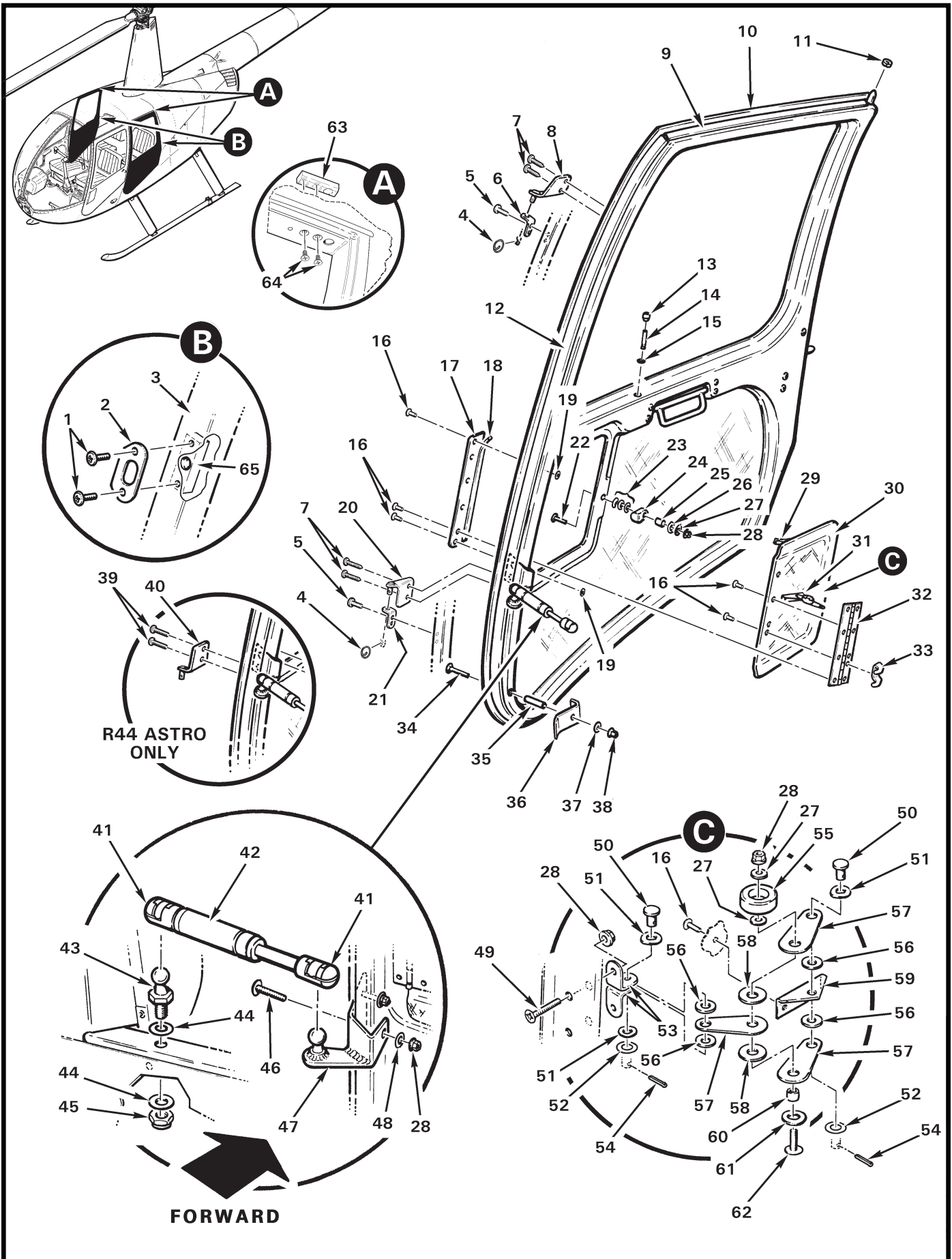




FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>AFT DOOR ASSEMBLY</b>				
52-7-1	AN525-832R6	Screw . . . . .	X	2
2	C538-1	Plate . . . . .	X	1
3	C238	Door Jamb (Ref)		
4	B427-1	Ring – Cotter . . . . .	X	2
5	MS27039C0808	Screw . . . . .	X	4
6	A228-1	Hinge . . . . .	X	1
7	MS51861-37C	Screw (self-tapping) . . . . .	X	4
8	C389-4	Hinge Assembly (RH, upper) . . . . .	X	1
	C389-3	Hinge Assembly (LH, upper) . . . . .	X	1
9	A226-2	Seal (install using B270-8qt adhesive) . . . . .	X	A/R
	B270-8qt	Adhesive (one-quart can) . . . . .	X	A/R
10	C026-014*	Door Assembly (RH, clear; Incl items 9, 12 thru 19, 22 thru 30, 32, 34 thru 38, and 46 thru 48) . . . . .	X	1
	C026-013*	Door Assembly (LH, clear; Incl items 9, 12 thru 19, 22 thru 30, 32, 34 thru 38, and 46 thru 48) . . . . .	X	1
	C026-024*	Door Assembly (RH, tinted; Incl items 9, 12 thru 19, 22 thru 30, 32, 34 thru 38, and 46 thru 48; not shown) . . . . .	X	1
	C026-023*	Door Assembly (LH, tinted; Incl items 9, 12 thru 19, 22 thru 30, 32, 34 thru 38, and 46 thru 48; not shown) . . . . .	X	1
	C026-034*	Door Assembly (RH, bubble, clear; Incl items 9, 12 thru 19, 22 thru 30, 32, 34 thru 38, and 46 thru 48) . . . . .	X	1
	C026-033*	Door Assembly (LH, bubble, clear; Incl items 9, 12 thru 19, 22 thru 30, 32, 34 thru 38, and 46 thru 48) . . . . .	X	1
	C026-044*	Door Assembly (RH, bubble, tinted; Incl items 9, 12 thru 19, 22 thru 30, 32, 34 thru 38, and 46 thru 48) . . . . .	X	1
	C026-043*	Door Assembly (LH, bubble, tinted; Incl items 9, 12 thru 19, 22 thru 30, 32, 34 thru 38, and 46 thru 48) . . . . .	X	1
11	NAS557-4B	Grommet . . . . .	X	1
12	A226-6	Seal (self-adhesive, front edge of door only) . . . . .	X	A/R
13	1770	Knob (install using B270-10 adhesive) . . . . .	X	1
	B270-10	Adhesive (1.69-oz tube) . . . . .	X	A/R
14	C544-1	Pin . . . . .	X	1
15	C26005	Washer (install using B270-9 adhesive) . . . . .	X	1
	B270-9	Adhesive (2-oz kit) . . . . .	X	A/R
16	MS20470AD3	Rivet . . . . .	X	13
17	C682-1	Barrier . . . . .	X	1

NOTES \* Will be shipped painted white.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
AFT DOOR ASSEMBLY (Cont'd)				
52-7-18	A226-3	Seal (install using B270-4 adhesive) . . . . .	X	A/R
	B270-4	Adhesive (10-oz tube) . . . . .	X	A/R
19	NAS1149FN232P	Washer . . . . .	X	2
20	C389-9	Hinge Assembly (LH, lower) . . . . .	X	1
	C389-10	Hinge Assembly (RH, lower) . . . . .	X	1
21	A228-2	Hinge . . . . .	X	1
22	AN525-832R10	Screw . . . . .	X	1
23	NAS1149FN816P	Washer (or NAS1149FN832P as required for proper seal compression) . . . . .	X	A/R
24	C285-1	Knob . . . . .	X	1
25	C130-5	Spacer . . . . .	X	1
26	U216-0100-S	Spring Washer . . . . .	X	1
27	NAS1149FN816P	Washer . . . . .	X	3
28	MS21042L08	Nut . . . . .	X	6
29	A226-7	Seal (self-adhesive, 3 sides of vent door) . . . . .	X	A/R
30	C425-4	Vent Door (RH) . . . . .	X	1
	C425-3	Vent Door (LH) . . . . .	X	1
31	A425-17	Arm Assembly (Incl items 27, 28, and 50 thru 62) . . . . .	X	1
32	C425-5	Hinge . . . . .	X	1
33	B242-2	Stop (earlier R44s only) . . . . .	X	1
34	AN525-832R24	Screw . . . . .	X	1
35	C130-19	Spacer . . . . .	X	1
36	A768-2	Clip (RH) . . . . .	X	1
	A768-1	Clip (LH) . . . . .	X	1
37	NAS1149FN816P	Washer (as required for shimming) . . . . .	X	A/R
38	B340-4	Nut . . . . .	X	1
39	MS51861-37C	Screw (self-tapping) . . . . .	X	4
40	C389-1	Hinge Assembly (LH, lower; R44 Astro only) . . . . .	X	1
	C389-2	Hinge Assembly (RH, lower; R44 Astro only) . . . . .	X	1
41	PC1249-2	End Connector . . . . .	X	2
42	C394-1	Gas Spring (includes clips and item 41 as shown) . . . . .	X	1
43	C394-2	Ball Stud . . . . .	X	1
44	C141-15	Washer . . . . .	X	2
45	21FKF-518	Nut . . . . .	X	1
46	MS27039C0816	Screw . . . . .	X	2

NOTES

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>AFT DOOR ASSEMBLY (Cont'd)</b>				
52-7-47	C393-2	Bracket (RH) . . . . .	X	1
	C393-1	Bracket (LH, not shown) . . . . .	X	1
48	NAS1149FN832P	Washer . . . . .	X	2
49	MS24694-S11	Screw . . . . .	X	2
50	MS20392-2C7	Pin . . . . .	X	2
51	U190-0090S	Spring Washer . . . . .	X	3
52	NAS1149F0332P	Washer . . . . .	X	2
53	A425-19	Clip . . . . .	X	2
54	MS24665-132	Cotter Pin . . . . .	X	2
55	A431-1	Knob . . . . .	X	1
56	A141-8	Washer . . . . .	X	2
57	A425-7	Arm . . . . .	X	3
58	A141-7	Washer . . . . .	X	2
59	A425-13	Angle (RH and LH) . . . . .	X	1
60	A105-7	Journal . . . . .	X	1
61	U250-0185	Spring Washer . . . . .	X	1
62	AN525-832R8	Screw . . . . .	X	1
63	C537-16	Block . . . . .	X	2
64	93195A322	Screw . . . . .	X	4
65	C537-11	Block . . . . .	X	2

NOTES

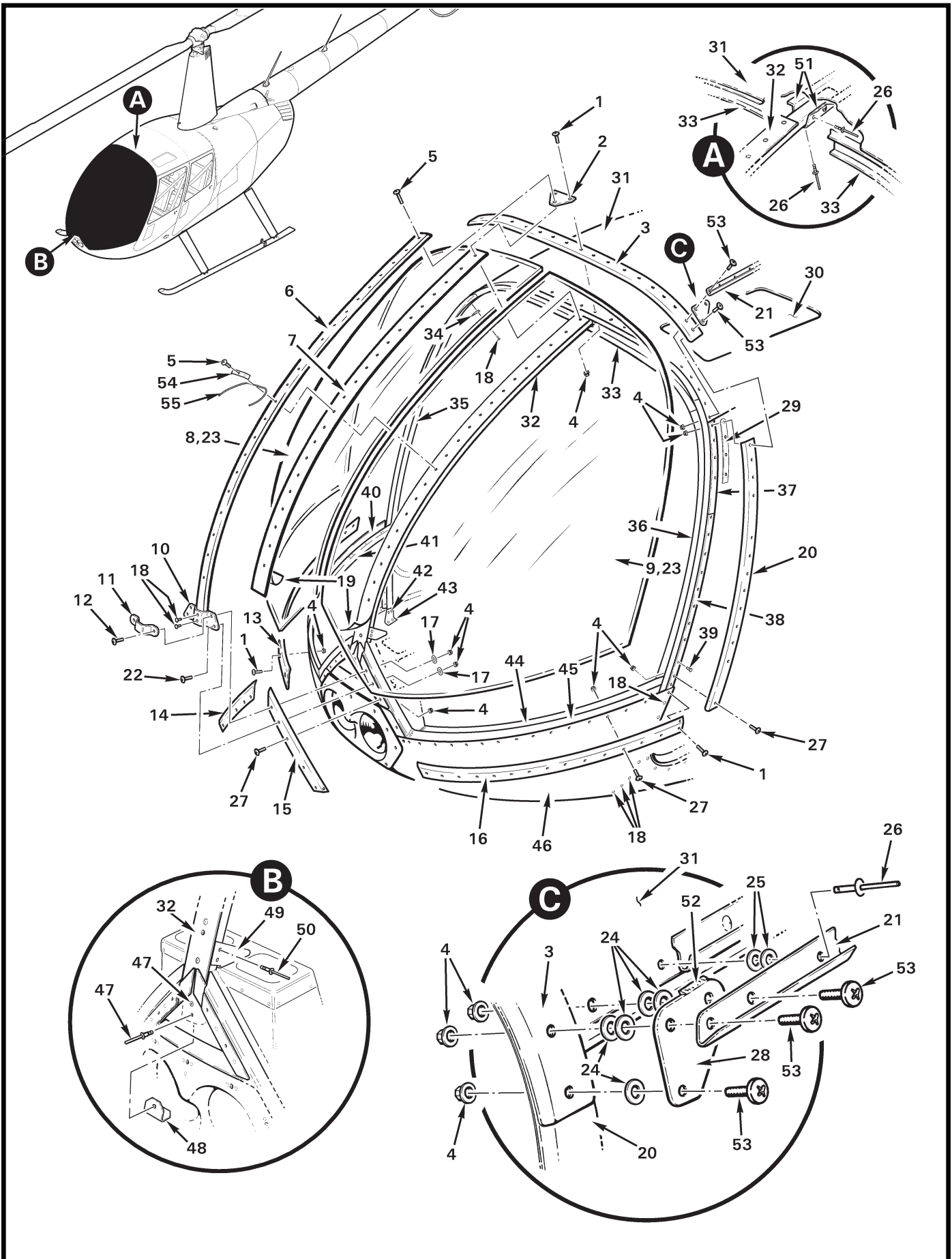


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>WINDSHIELD INSTALLATION</b>				
52-11-1	AN526C832R9	Screw (do not substitute MS27039 screws) . . . . .	X	10
2	B409-5	Gusset . . . . .	X	1
3	C238-29*	Retainer (apply item 52 to edges) . . . . .	X	1
4	MS21042L08	Nut . . . . .	X	90
5	AN526C832R12	Screw (do not substitute MS27039 screws) . . . . .	X	22
6	C367-12	Stiffener . . . . .	X	1
7	C367-10*	Retainer . . . . .	X	1
8	C274-2	Windshield** (RH, clear; install using item 23) . . . . .	X	1
	C274-4	Windshield** (RH, tinted; install using item 23) . . . . .	X	1
9	C274-1	Windshield** (LH, clear; install using item 23) . . . . .	X	1
	C274-3	Windshield** (LH, tinted; install using item 23) . . . . .	X	1
10	C366-8	Retainer . . . . .	X	1
11	C366-5	Bracket . . . . .	X	1
12	MS27039C0810	Screw . . . . .	X	4
13	C367-6*	Retainer (RH) . . . . .	X	1
14	C367-8*	Retainer (RH) . . . . .	X	1
15	C367-7*	Retainer (LH) . . . . .	X	1
16	C367-5*	Retainer (LH) . . . . .	X	1
17	NAS1149FN832P	Washer . . . . .	X	4
18	MS20470AD4	Rivet . . . . .	X	38
19	C367-11	Tape . . . . .	X	A/R
20	C238-27*	Retainer (LH) . . . . .	X	1
	C238-28*	Retainer (RH; not shown) . . . . .	X	1
21	C230-8*	Rain Gutter (RH; apply item 52 to edges) . . . . .	X	1
	C230-7*	Rain Gutter (LH; apply item 52 to edges) . . . . .	X	1
22	MS27039C0809	Screw . . . . .	X	2
23	B270-26	Sealant (silicone, 3-oz tube) . . . . .	X	A/R
24	NAS1149FN832P	Washer . . . . .	X	A/R
25	NAS620-5	Washer . . . . .	X	A/R
26	NAS9301B-4-02	Rivet (blind) . . . . .	X	5
27	AN526C832R8	Screw . . . . .	X	78
28	D805-2	Restraint (LH and RH. Use item 52 to fill gap between items 21, 28, and 31. To retrofit earlier R44s, order KI-125 kit.) . . . . .	X	2
29	C396-1	Shim (LH and RH) . . . . .	X	A/R
30	C273-3	Window (clear acrylic) . . . . .	X	1

NOTES \* Install using item 52.  
 \*\* See Figure 99-23 for shipping crate.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
WINDSHIELD INSTALLATION (Cont'd)				
52-11-31	C273-1	Roof (Incl item 30) . . . . .	X	1
32	C238-2	Bow Assembly (includes wires) . . . . .	X	1
33	C238-16	Frame (forward; roof) . . . . .	X	1
34	C211-3	Gusset (LH and RH) . . . . .	X	2
35	C238-4	Door Jamb – RH (attach to cabin using items 11, 39, 42, and 43)	X	1
36	C238-3	Door Jamb – LH (attach to cabin using items 11, 39, 42, and 43)	X	1
37	C238-34	Spacer (LH and RH, 0.125 in. thick polycarbonate. Attach to items 35/36 using item 39.) . . . . .	X	2
38	D661-1	Spacer (LH and RH, 0.125 in. thick polycarbonate. Attach to items 35/36 using item 39.) . . . . .	X	2
39	MS20426AD3	Rivet (flush) . . . . .	X	56
40	C367-2	Retainer (RH) . . . . .	X	1
41	C238-18	Frame (RH; attach with item 40 to chin [item 46] using item 39) . .	X	1
42	MS20470AD3	Rivet . . . . .	X	8
43	A414-1	Angle (LH, not shown) . . . . .	X	1
	A414-2	Angle (RH) . . . . .	X	1
44	C238-17	Frame (LH; attach with item 45 to chin [item 46] using item 39) .	X	1
45	C367-1	Retainer (LH) . . . . .	X	1
46	C272-1	Chin . . . . .	X	1
47	NAS9301B-4-03	Rivet (blind) . . . . .	X	2
48	C366-6	Cap . . . . .	X	1
49	C358-2	Support (Ref)		
50	NAS9301B-4-02	Rivet (blind; or NAS9301B-4-03 as required) . . . . .	X	4
51	C238-23	Support . . . . .	X	1
52	B270-1	Sealant . . . . .	X	A/R
53	AN526C832R9	Screw (or AN526C832R10 thru AN526C832R12 to obtain one thread minimum beyond nut) . . . . .	X	6
54	B295-1	Clip . . . . .	X	1
55	—	Yaw/Trim String (Ref; yarn, white acrylic, 0.10-inch dia., 3-inch length each side of clip. Source Locally.)		

NOTES