

CHAPTER 52

DOORS AND WINDOWS

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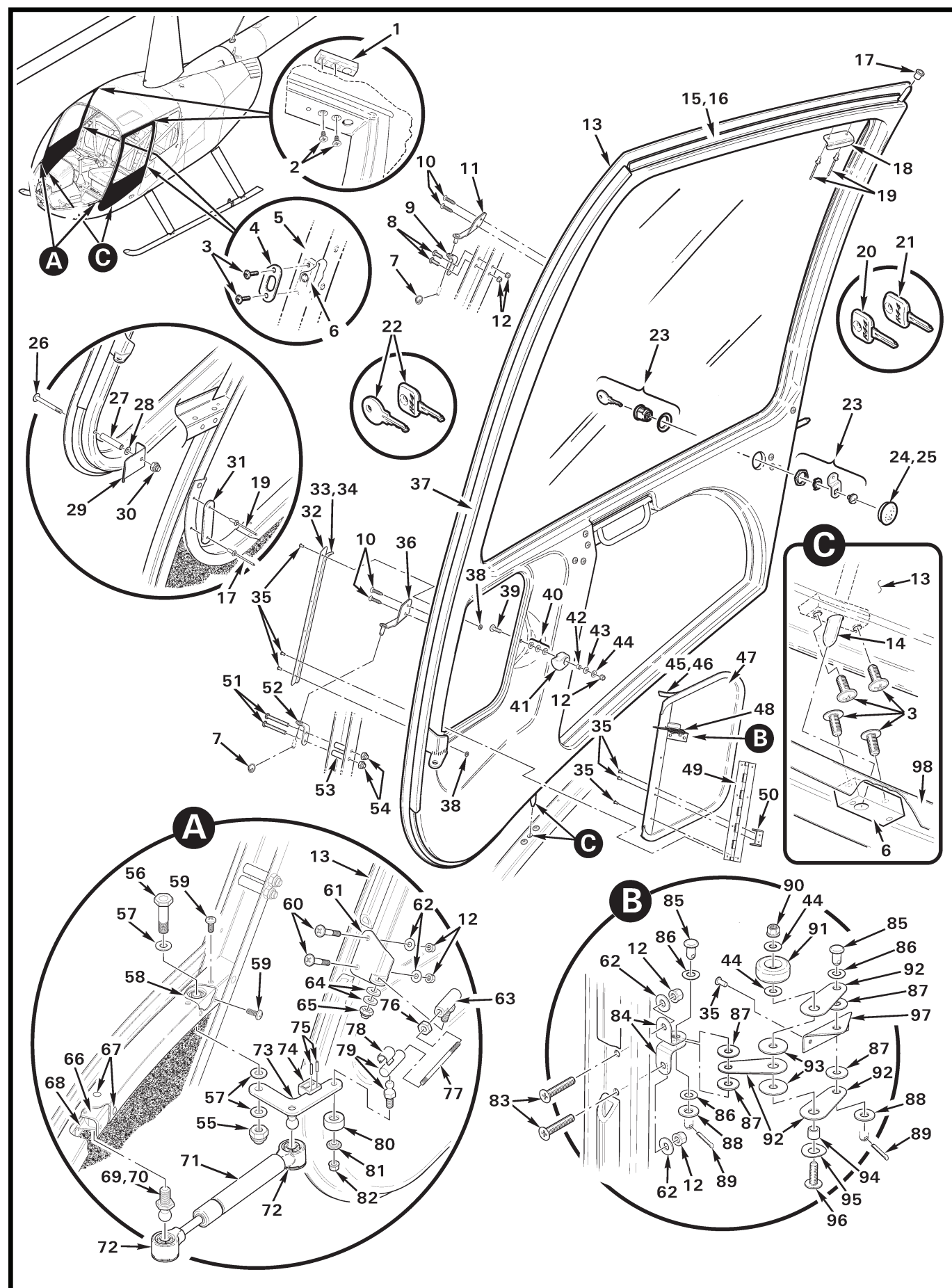


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		FORWARD DOOR ASSEMBLY		
52-1-1	C537-16	Block	X	2
2	93195A322	Screw	X	4
3	AN525-832R6	Screw	X	2
4	C538-1	Plate	X	1
5	C403	Door Post (Ref)		
6	C537-11	Block	X	2
7	B427-1	Ring – Cotter	X	2
8	MS27039C0807	Screw	X	2
9	A228-1	Hinge 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	MS21042L08	Nut	X	7
13	C026-012*	Door Assembly** (RH, clear; includes items 7, 14, 15, 18 thru 22, 24, 26, 30 thru 47, 52 thru 54, 73 thru 76, and 78 thru 86)	X	1
	C026-011*	Door Assembly** (LH, clear; includes items 7, 14, 15, 18 thru 22, 24, 26, 30 thru 47, 52 thru 54, 73 thru 76, and 78 thru 86; not shown)	X	1
	C026-022*	Door Assembly** (RH, light tint; includes items 7, 14, 15, 18 thru 22, 24, 26, 30 thru 47, 52 thru 54, 73 thru 76, and 78 thru 86; not shown)	X	1
	C026-021*	Door Assembly** (LH, light tint; includes items 7, 14, 15, 18 thru 22, 24, 26, 30 thru 47, 52 thru 54, 73 thru 76, and 78 thru 86; not shown)	X	1
	C026-032*	Door Assembly** (RH, bubble, clear; includes items 7, 14, 15, 18 thru 22, 24, 26, 30 thru 47, 52 thru 54, 73 thru 76, and 78 thru 86; not shown)	X	1
	C026-031*	Door Assembly** (LH, bubble, clear; includes items 7, 14, 15, 18 thru 22, 24, 26, 30 thru 47, 52 thru 54, 73 thru 76, and 78 thru 86; not shown)	X	1
	C026-042*	Door Assembly** (RH, bubble, tinted; includes items 7, 14, 15, 18 thru 22, 24, 26, 30 thru 47, 52 thru 54, 73 thru 76, and 78 thru 86; not shown)	X	1
	C026-041*	Door Assembly** (LH, bubble, tinted; includes items 7, 14, 15, 18 thru 22, 24, 26, 30 thru 47, 52 thru 54, 73 thru 76, and 78 thru 86; not shown)	X	1
NOTES * Will be shipped painted white. ** Ship S/N 2380 and prior, S/N 10001 thru 13760 may require KI-244, unless kit was previously installed, or doors with item 14 were factory-installed.				

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		FORWARD DOOR ASSEMBLY (Cont'd)		
52-1-14	C224-13	Rod Assembly (Ref)		
15	A226-2	Seal (bond using item 16)	X	A/R
16	B270-18	Adhesive (5-oz. tube)	X	A/R
17	2017	Bushing	X	1
	NAS557-4B	Grommet (earlier R44s)	X	1
18	C223-1	Angle	X	2
19	B204-1 *	Rivet (blind; alternate part no. 01610-11041)	X	A/R
20	D768-2	Key – Blank (black plastic-coated brass key, "R44" logo)	X	2
21	D768-10	Key – Blank (black plastic-coated, "R44" logo; earlier R44s) . .	O	1
22	R8427	Key – Duplicate (black plastic-coated brass key, "R44" logo)	X	1
	R8096	Key – Duplicate (small brass key without black plastic coating or "R44" logo)	X	1
23	A556-1	Door Lock (with 2 keys, round head)	X	1
	A556-3	Door Lock (with 2 keys, square head; earlier R44s, not shown)	O	1
24	2713	Hole Plug (bond using item 25)	X	1
25	B270-9	Adhesive (2-oz. kit)	X	A/R
26	AN525-832R24 *	Screw	X	1
27	C130-19 *	Spacer	X	1
28	NAS1149FN816P	Washer (as required for shimming)	X	A/R
29	A768-2 *	Clip (RH)	X	1
	A768-1 *	Clip (LH; not shown)	X	1
30	B340-4 *	Nut	X	2
31	A767-1 *	Rub Strip (RH and LH)	X	2
32	C682-2	Barrier	X	1
33	A226-3	Seal (bond using item 34)	X	A/R
34	B270-8.2OZ	Adhesive (2-oz. container)	X	A/R
35	MS20470AD3	Rivet	X	13
36	C227-2	Hinge Assembly (RH, lower)	X	1
	C227-1	Hinge Assembly (LH, lower)	X	1
37	A226-6	Seal (forward door edge, self-adhesive)	X	A/R
38	NAS1149FN232P	Washer	X	2

NOTES * Earlier doors (C026 Rev AG or prior).

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		FORWARD DOOR ASSEMBLY (Cont'd)		
52-1-39	AN525-832R10	Screw	X	1
40	NAS1149FN816P	Washer (or NAS1149FN832P for proper seal compression) . .	X	A/R
41	C285-1	Knob	X	1
42	C130-5	Spacer	X	1
43	U216-0100-S	Spring Washer (alternate part no. U216-0100S or U216-0100)	X	1
44	NAS1149FN816P	Washer	X	2
45	A226-7	Seal (bond using item 46; 3 sides of vent door)	X	A/R
46	B270-8.2OZ	Adhesive (2-oz. container)	X	A/R
47	C425-2	Vent Door (RH, forward; door only)	X	1
	C425-1	Vent Door (LH, forward; door only)	X	1
48	A425-17	Arm Assembly (LH and RH; includes items 44, and 84 thru 97)	X	1
49	C425-5	Hinge	X	1
50	B242-2	Stop	X	1
51	MS27039C0824	Screw	X	2
52	C228-1	Hinge Assembly	X	1
53	C130-37	Spacer	X	2
54	B340-4	Nut	X	4
55	B340-10	Nut	X	1
56	NAS6604-12	Bolt	X	1
57	NAS1149F0432P	Washer	X	3
58	D573-1	Block	X	1
59	MS27039C0806	Screw	X	4
60	AN525-832R16	Screw	X	2
61	D574-4	Bracket (RH)	X	1
	D574-3	Bracket (LH, not shown)	X	1
62	NAS1149FN832P	Washer	X	2
63	D575-3	Ball Joint	X	1
64	NAS1149F0363P	Washer	X	2
65	B340-8	Nut	X	2
66	D573-3	Block (install using item 67)	X	1
NOTES				
Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
FORWARD DOOR ASSEMBLY (Cont'd)				
52-1-67	MS20470AD4	Rivet	X	6
68	D573-5	Angle	X	1
69	C394-2	Ball Stud (use item 70 on threads)	X	1
70	B270-10	Adhesive (1.69-oz. bottle)	X	A/R
71	D575-1	Gas Spring	X	1
72	PS130	End Connector	X	2
73	D574-2	Arm Assembly (RH; includes items 74 and 75)	X	1
	D574-1	Arm Assembly (LH, not shown; includes items 74 and 75)	X	1
74	D573-7	Bumper	X	1
75	MS16562-4	Spring Pin	X	2
76	AN315-3R	Nut	X	1
77	D573-4	Rod	X	1
78	P-8100	Clip	X	1
79	D575-2	Ball Joint (Incl item 78)	X	1
80	C119-3	Bumper	X	1
81	B138-2	Spacer	X	1
82	D210-3	Nut	X	2
83	MS24694-S11	Screw	X	2
84	A425-19	Clip	X	2
85	MS20392-2C7	Pin	X	2
86	U190-0090-S	Spring Washer (alternate part no. U190-0090S)	X	3
87	A141-8	Washer	X	4
88	NAS1149F0332P	Washer	X	2
89	MS24665-151	Cotter Pin	X	2
90	MS21042L08	Nut	X	1
91	A431-1	Knob	X	1
92	A425-7	Arm	X	3
93	A141-7	Washer	X	2
94	A105-7	Journal	X	1
95	CRV-26152	Spring Washer (alternate part no. U250-0185-S or U250-0185)	X	1
96	AN525-832R8	Screw	X	1
NOTES				
Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		FORWARD DOOR ASSEMBLY (Cont'd)		
52-1-97	A425-13	Angle	X	1
98	C238-8	Sill (Ref, RH)		
	C238-7	Sill (Ref, LH; not shown)		
		* * *		
99	KI-244*	R44-series Forward Door Kit (Ref, not shown)	X	1
NOTES * Ship S/N 2380 and prior, S/N 10001 thru 13760 may require KI-244, unless kit was previously installed, or doors with item 14 were factory-installed.				

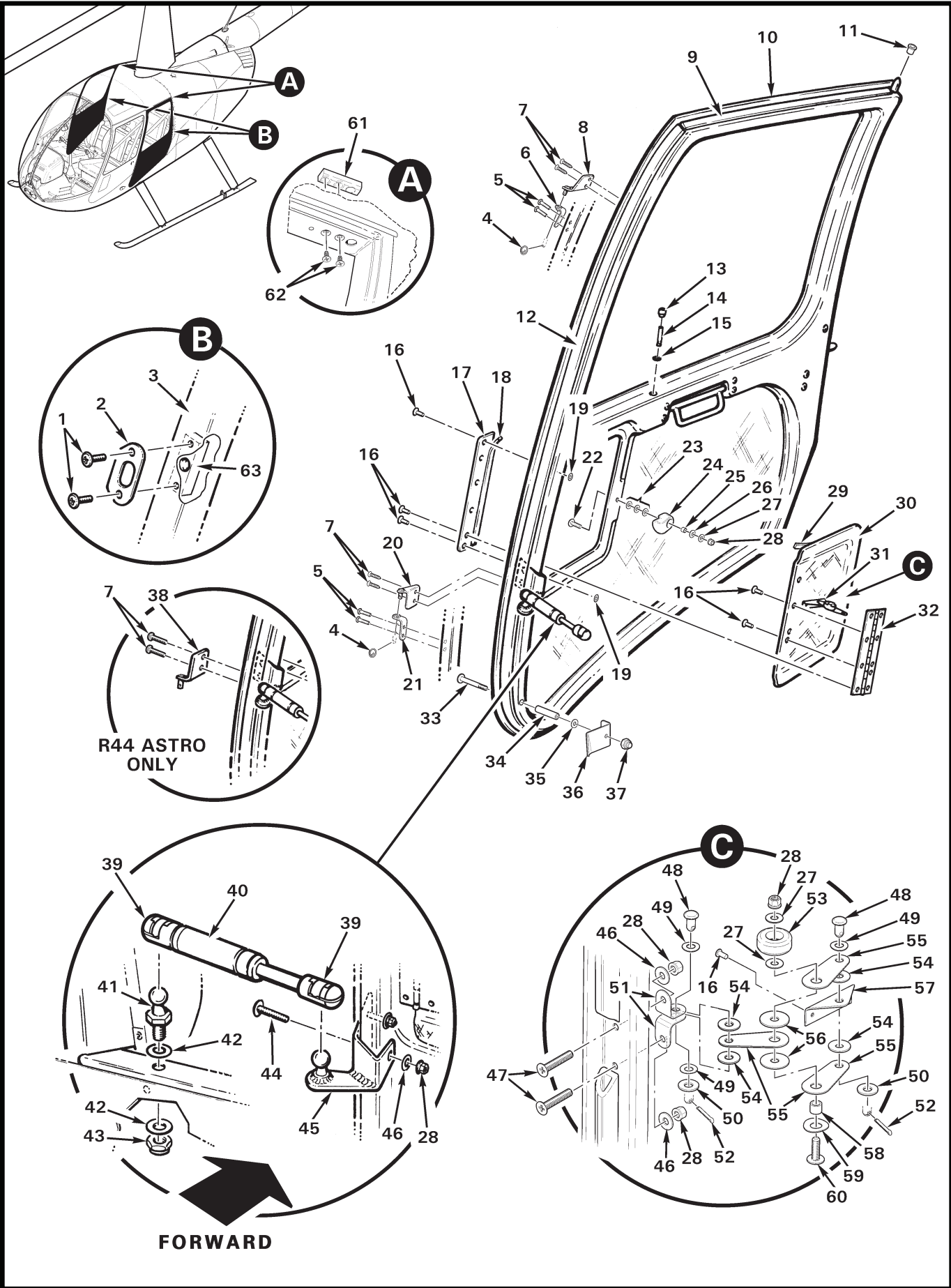


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		AFT DOOR ASSEMBLY*		
52-7-1	AN525-832R6	Screw	X	2
2	C538-1	Plate	X	1
3	C238	Door Jamb (Ref)		
4	B427-1	Ring – Cotter	X	2
5	MS27039C0809	Screw	X	4
6	A228-1	Hinge	X	1
7	MS51861-37C	Screw	X	4
8	C389-4	Hinge Assembly (RH, upper)	X	1
	C389-3	Hinge Assembly (LH, upper)	X	1
9	A226-2	Seal (bond using item 10)	X	A/R
10	B270-18	Adhesive (5-oz. tube)	X	A/R
11	C026-014**	Door Assembly (RH, clear; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50)	X	1
	C026-013**	Door Assembly (LH, clear; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-024**	Door Assembly (RH, light tint; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-023**	Door Assembly (LH, light tint; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-034**	Door Assembly (RH, bubble, clear; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-033**	Door Assembly (LH, bubble, clear; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-044**	Door Assembly (RH, bubble, light tint; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-043**	Door Assembly (LH, bubble, light tint; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-054**	Door Assembly (RH, dark tint; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-053**	Door Assembly (LH, dark tint; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-064**	Door Assembly (RH, bubble, dark tint; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
	C026-063**	Door Assembly (LH, bubble, dark tint; includes items 9, 13 thru 22, 25 thru 34, 36, 37 thru 41, and 48 thru 50; not shown)	X	1
NOTES * Ship S/N 0001 thru 9999, and S/N 10001 thru 29999. ** Will be shipped painted white.				
				Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		AFT DOOR ASSEMBLY (Cont'd)		
52-7-12	2017	Bushing	X	1
	NAS557-4B	Grommet (not shown, earlier R44s)	X	1
13	A226-6	Seal (forward door edge, self-adhesive)	X	A/R
14	A431-2	Knob (door lock).	X	1
	1770	Knob (not shown, earlier R44s)	O	1
15	C544-1	Pin	X	1
16	C26005	Washer (bond using item 17)	X	1
17	B270-9	Adhesive (2-oz. kit)	X	A/R
18	MS20470AD3	Rivet	X	13
19	C682-1	Barrier	X	1
20	A226-3	Seal (bond using item 21)	X	A/R
21	B270-8.2OZ	Adhesive (2-oz. container)	X	A/R
22	NAS1149FN232P	Washer	X	2
23	C389-10	Hinge Assembly (RH, lower)	X	1
	C389-9	Hinge Assembly (LH, lower; not shown)	X	1
24	A228-2	Hinge	X	1
25	AN525-832R10	Screw	X	1
26	NAS1149FN816P	Washer (or NAS1149FN832P for proper seal compression)	X	A/R
27	C285-1	Knob	X	1
28	C130-5	Spacer	X	1
29	U216-0100-S	Spring Washer (alternate part no. U216-0100S or U216-0100)	X	1
30	NAS1149FN816P	Washer	X	3
31	MS21042L08	Nut	X	6
32	A226-7	Seal (bond using item 33; 3 sides of vent door)	X	A/R
33	B270-8.2OZ	Adhesive (2-oz. container)	X	A/R
34	C425-4	Vent Door (RH, aft; door only)	X	1
	C425-3	Vent Door (LH, aft; door only)	X	1
35	A425-17	Arm Assembly (LH and RH; includes items 30, 31, and 52 thru 64)	X	1
36	C425-5	Hinge	X	1
37	AN525-832R24*	Screw	X	1
NOTES * Earlier R44s. Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		AFT DOOR ASSEMBLY (Cont'd)		
52-7-38	C130-19*	Spacer	X	1
39	NAS1149FN816P*	Washer (as required for shimming)	X	A/R
40	A768-2*	Clip (RH)	X	1
	A768-1*	Clip (LH; not shown)	X	1
41	B340-4*	Nut	X	1
42	C389-2	Hinge Assembly (RH, lower; R44 Astro only)	X	1
	C389-1	Hinge Assembly (LH, lower; R44 Astro only)	X	1
43	PC1249-2	End Connector	X	2
44	C394-1	Gas Spring (includes clips and item 43 as shown)	X	1
45	C394-2	Ball Stud	X	1
46	C141-15	Washer	X	2
47	21FKF-518	Nut	X	1
48	MS27039C0816	Screw	X	2
49	C393-2	Bracket (RH)	X	1
	C393-1	Bracket (LH, not shown)	X	1
50	NAS1149FN832P	Washer	X	2
51	MS24694-S11	Screw	X	2
52	MS20392-2C7	Pin	X	2
53	U190-0090-S	Spring Washer (alternate part no. U190-0090S)	X	3
54	NAS1149F0332P	Washer	X	2
55	A425-19	Clip	X	2
56	MS24665-151	Cotter Pin	X	2
57	A431-1	Knob	X	1
58	A141-8	Washer	X	2
59	A425-7	Arm	X	3
60	A141-7	Washer	X	2
61	A425-13	Angle	X	1
62	A105-7	Journal	X	1
63	CRV-26152	Spring Washer (alternate part no. U250-0185-S or U250-0185)	X	1
64	AN525-832R8	Screw	X	1
65	C537-16	Block	X	2
NOTES * Earlier R44s. Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
52-7-66 67	93195A322	AFT DOOR ASSEMBLY (Cont'd) Screw	X	4
	C537-11	Block	X	2
NOTES				

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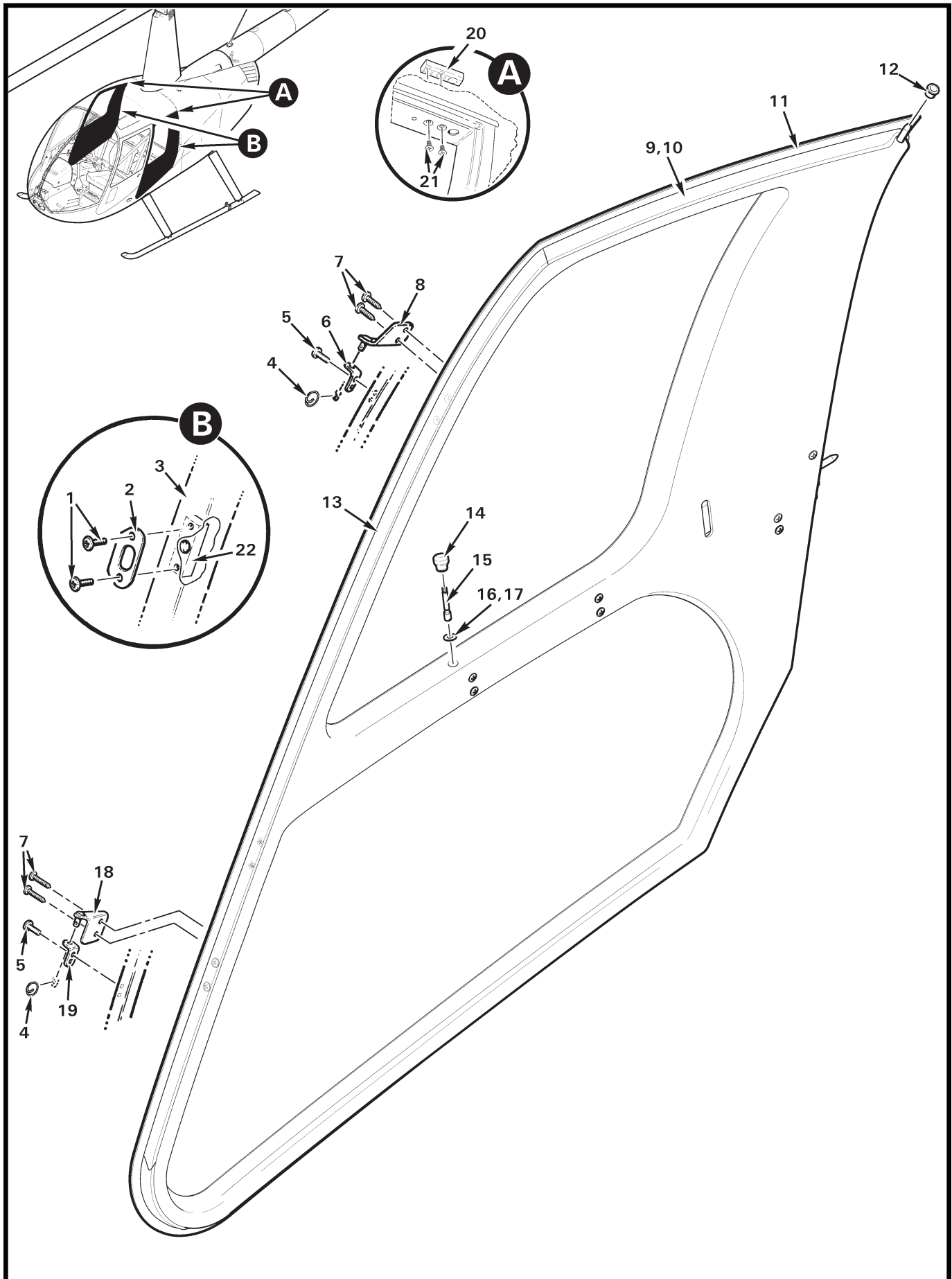


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		AFT DOOR ASSEMBLY – R44 CADET*		
52-13-1	AN525-832R6	Screw	X	2
2	C538-1	Plate	X	1
3	C238	Door Jamb (Ref)		
4	B427-1	Ring – Cotter	X	2
5	MS27039C0809	Screw	X	4
6	A228-1	Hinge	X	1
7	MS51861-37C	Screw (self-tapping)	X	4
8	C389-4	Hinge Assembly (RH, upper)	X	1
	C389-3	Hinge Assembly (LH, upper; not shown)	X	1
9	A226-2	Seal (install using item 10)	X	A/R
10	B270-18	Adhesive (5-oz. tube)	X	A/R
11	C026-224**	Door Assembly (RH, light tint; includes items 9, 13 thru 16) . . .	X	1
	C026-223**	Door Assembly (LH, light tint; includes items 9, 13 thru 16) . . .	X	1
	C026-254**	Door Assembly (RH, dark tint; includes items 9, 13 thru 16) . . .	X	1
	C026-253**	Door Assembly (LH, dark tint; includes items 9, 13 thru 16) . . .	X	1
12	2017	Bushing	X	1
	NAS557-4B	Grommet (not shown, earlier R44s)	X	1
13	A226-6	Seal (self-adhesive, front edge of door only)	X	A/R
14	A431-2	Knob (door lock)	X	1
	1770	Knob (not shown, earlier R44s)	O	1
15	C544-1	Pin	X	1
16	C26005	Washer (bond using item 17)	X	1
17	B270-9	Adhesive (2-oz. kit)	X	A/R
18	C389-10	Hinge Assembly (RH, lower)	X	1
	C389-9	Hinge Assembly (LH, lower; not shown)	X	1
19	A228-2	Hinge	X	1
20	C537-16	Block	X	2
21	93195A322	Screw	X	4
22	C537-11	Block	X	2
NOTES * Ship S/N 30001 and subsequent. ** Will be shipped painted white.				

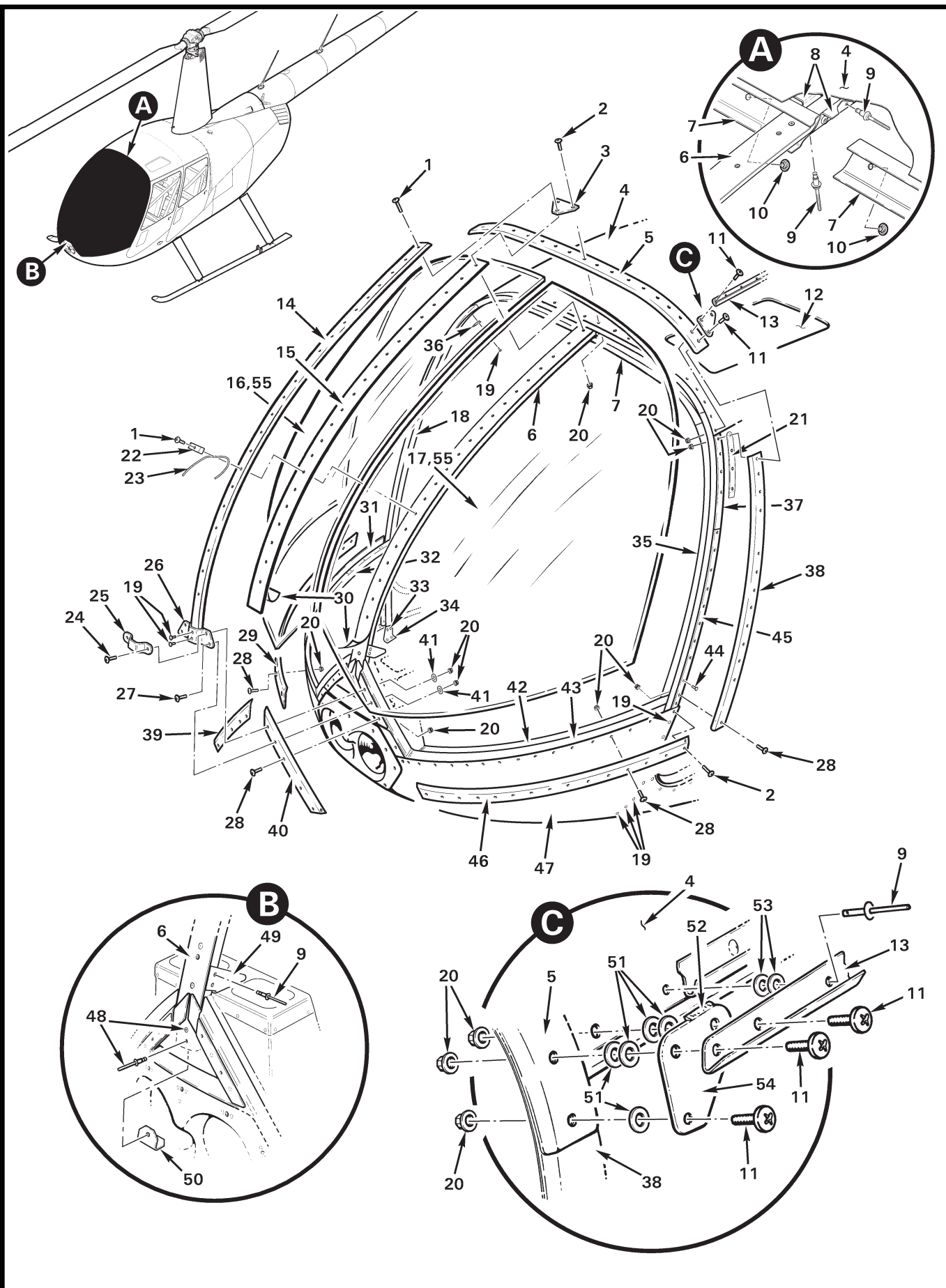


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		WINDSHIELD INSTALLATION		
52-15-1	AN526C832R12	Screw (do not substitute MS27039 screws)	X	22
2	AN526C832R9	Screw (do not substitute MS27039 screws)	X	10
3	B409-5	Gusset	X	1
4	C273-1	Roof (Incl item 12)	X	1
5	C238-29*	Retainer (apply item 52 to edges)	X	1
6	C238-2	Bow Assembly (includes wires)	X	1
7	C238-16	Frame (forward, roof)	X	1
8	C238-23	Support	X	1
9	NAS9301B-4-02	Rivet (blind; or NAS1919B04S02 as required)	X	9
10	BPF-5MM	Plug	X	8
11	AN526C832R9	Screw (or AN526C832R10 thru AN526C832R12 to obtain one thread minimum beyond nut)	X	6
12	C273-3	Window (clear acrylic)	X	1
13	C230-8*	Rain Gutter (RH, apply item 52 to edges)	X	1
	C230-7*	Rain Gutter (LH, apply item 52 to edges)	X	1
14	C367-12	Stiffener	X	1
15	C367-10*	Retainer	X	1
16	C274-2	Windshield** (RH, clear; install using item 55)	X	1
	C274-4	Windshield** (RH, tinted; install using item 55)	X	1
17	C274-1	Windshield** (LH, clear; install using item 55)	X	1
	C274-3	Windshield** (LH, tinted; install using item 55)	X	1
18	C238-4	Door Jamb (RH, forward; attach to cabin using items 25, 44, 33, and 34)	X	1
19	MS20470AD4	Rivet	X	38
20	MS21042L08	Nut	X	90
21	C396-1	Shim	X	A/R
22	B295-1	Clip (installed at 7th screw, from item 26, 8th screw with 10-hole console)	X	1
23	—	Yaw/Trim String (Ref; yarn, white acrylic, 0.10 inch dia., 3-inch length each side of clip. Source locally.)		
24	MS27039C0810	Screw	X	4
25	C366-5	Bracket	X	1
26	C366-8	Retainer	X	1
27	MS27039C0809	Screw	X	2
NOTES * Install using item 52. ** See Figure 99-15 for shipping crate.				
Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
WINDSHIELD INSTALLATION (Cont'd)				
52-15-28	AN526C832R8	Screw (do not substitute MS27039 screws)	X	78
29	C367-6*	Retainer (RH)	X	1
30	C367-11	Tape	X	A/R
31	C367-2	Retainer (RH)	X	1
32	C238-18	Frame (RH; attach with item 31 to chin [item 47] using item 44)	X	1
33	MS20470AD3	Rivet	X	8
34	A414-2	Angle (RH)	X	1
	A414-1	Angle (LH, not shown)	X	1
35	C238-3	Door Jamb (LH, forward; attach to cabin using items 25, 44, 33, and 34)	X	1
36	C211-3	Gusset	X	2
37	C238-34	Spacer (LH and RH, 0.118 in. [3mm] or 0.125 in. thick polycarbonate. Attach to items 18 and 35 using item 44.)	X	2
38	C238-27*	Retainer (LH)	X	1
	C238-28*	Retainer (RH; not shown)	X	1
39	C367-8*	Retainer (RH)	X	1
40	C367-7*	Retainer (LH)	X	1
41	NAS1149FN832P	Washer	X	4
42	C238-17	Frame (LH; attach with item 43 to chin [item 47] using item 44)	X	1
43	C367-1	Retainer (LH)	X	1
44	MS20426AD3	Rivet (flush)	X	56
45	D661-1	Spacer (LH and RH, 0.118 in. [3mm] or 0.125 in. thick polycarbonate. Attach to items 18 and 35 using item 44.)	X	2
46	C367-5*	Retainer (LH)	X	1
47	C272-1	Chin	X	1
48	NAS9301B-4-03	Rivet (blind)	X	2
49	C358-2	Support (Ref)		
50	C366-6	Cap	X	1
51	NAS1149FN832P	Washer	X	A/R
52	B270-1	Sealant	X	A/R
53	NAS620-5	Washer	X	A/R

NOTES * Install using item 52.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		WINDSHIELD INSTALLATION (Cont'd)		
52-15-54	D805-2	Restraint (LH and RH. Use item 52 to fill gap between items 13, 54, and 4. To retrofit earlier R44s, order KI-125 kit.) . .	X	2
55	B270-26	Sealant (polysulfide, 2-part; see MM § 1.480)	O	A/R
	B270-13	Sealant (silicone, 3-oz. tube)	X	A/R
NOTES				

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