

TITLE

WINDOWS - WINDSHIELD AND COCKPIT SIDE WINDOW FRAME MODIFICATION

EFFECTIVITY

MODEL	SERIAL NUMBERS
525C (CJ4)	-0001 thru -0024, -0026 thru -0028, -0030 thru -0040, -0042, -0044 thru -0072, -0074 thru -0154, -0156 thru -0208, -0210 thru -0230, -0232 thru -0313, -0315 thru -0414

NOTE: Textron Aviation-owned or Textron Aviation-authorized Service Centers are the only facilities that can complete this service document.

The equivalent of this service document has been incorporated on production airplanes -0025, -0029, -0041, -0043, -0073, -0155, -0209, -0231, -0314 and -0415 and On.

REASON

To add new windshield ground plates and sealing to the area around the frame of the windshields and cockpit side windows to decrease the potential for moisture incursion.

DESCRIPTION

This service document provides parts and instructions to inspect the windshield and cockpit side windows installation and install new ground plates.

COMPLIANCE

RECOMMENDED. This service document should be accomplished at a scheduled maintenance period or inspection.

A service document published by Textron Aviation may be recorded as *completed* in an aircraft log only when the following requirements are satisfied:

- 1) The mechanic must complete all of the instructions in the service document, including the intent therein.
- 2) The mechanic must correctly use and install all applicable parts supplied with the service document kit. Only with written authorization from Textron Aviation can substitute parts or rebuilt parts be used to replace new parts.
- 3) The mechanic or airplane owner must use the technical data in the service document only as approved and published.
- 4) The mechanic or airplane owner must apply the information in the service document only to aircraft serial numbers identified in the *Effectivity* section of the document.
- 5) The mechanic or airplane owner must use maintenance practices that are identified as acceptable standard practices in the aviation industry and governmental regulations.

No individual or corporate organization other than Textron Aviation is authorized to make or apply any changes to a Textron Aviation-issued service document or flight manual supplement without prior written consent from Textron Aviation.

Textron Aviation is not responsible for the quality of maintenance performed to comply with this document, unless the maintenance is accomplished at a Textron Aviation-owned Service Center.

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Textron Aviation Customer Service, P.O. Box 7706, Wichita, KS 67277, U.S.A. 1-316-517-5800

This document contains technical data and is subject to U.S. export regulations. This information has been exported from the United States in accordance with export administration regulations. Diversion contrary to U.S. law is prohibited. ECCN: 9E991

APPROVAL

Textron Aviation received FAA approval for the technical data in this publication that changes the airplane type design.

FLIGHT CREW OPERATIONS

No Changes

CONSUMABLE MATERIAL

You must use the consumable materials that follow, or their equivalent, to complete this service document.

NAME	NUMBER	MANUFACTURER	USE
Epoxy Primer	10P8-11 (Base)	Akzo Nobel Aerospace Coatings 1 East Water Street Waukegan, IL 60085	
Color Chemical Film Treatment	U074093 (Bonderite M-CR 1132 Aero pen or Alodine 1132 Touch n Prep)	Textron Aviation Parts Distribution 7121 Southwest Boulevard Wichita, KS 67215	To prepare bare aluminum surface for intermediate primer.
Sealant	U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2)	Textron Aviation Parts Distribution 7121 Southwest Boulevard Wichita, KS 67215	To seal nuts, nut plates, ground plates and fay seal cockpit side window retainers.
Sealant (Type XII, Grade 2)	PR-1425 Class B or PR-1425CF Semkits	PPG Aerospace PRC-DeSoto Int'l Inc. 11601 United Street Mojave, CA 91209	To be used as a windshield and window sealant.
Parting Agent	MoldMates 3460 or equivalent	Textron Aviation Parts Distribution 7121 Southwest Boulevard Wichita, KS 67215	To prevent sealant sticking.
Adhesive	U000370 (3M DP820)	Minnesota Mining and Manufacturing Company Adhesive Coatings and Sealers Division - 3M 3M Center St. Paul, MN 55144	To install rivetless adhesive nutplates.

TOOLING

No specialized tooling is required to complete this service document.

WEIGHT AND BALANCE INFORMATION

Negligible

REFERENCES

Cessna Model 525C Maintenance Manual (Revision 12 or later)

Citation Standard Practices Manual (Revision 6 or later)

Cessna Model 525C Structural Repair Manual (Revision 6 or later)

PUBLICATIONS AFFECTED

Cessna Model 525C Illustrated Parts Catalog

ACCOMPLISHMENT INSTRUCTIONS

1. Remove the windshields and cockpit side window installations.

CAUTION: Make sure to add protective covering to the inside and outside of the windshields and cockpit side windows prior to removal.

- A. Remove the left and right windshield. (Refer to the Model 525C Maintenance Manual, Chapter 56, Windshield - Removal/Installation.)
 - (1) Discard the attaching fasteners.
- B. (Airplanes -0001 thru -0388) Remove the left and right cockpit side window and retainers. (Refer to the Model 525C Maintenance Manual, Chapter 56, Cockpit Side Window - Removal/Installation.)
 - (1) Discard the attaching fasteners.

NOTE: It is permissible to leave the left and right cockpit side windows installed. To prevent them from falling out, after removal of window retainer, loosely reinstall two fasteners on opposite sides to prevent the window from moving.

2. Remove and discard the 7111013-3, 7111013-4, 7111013-9, 7111013-10, 7111013-11, 7111013-12 Ground Plates and fasteners from the airplane structure. (Refer to the Model 525C Structural Repair Manual, Chapter 51, Fastener Installation and Removal.)

3. (Airplanes -0001 thru -0388) Inspect the following areas of the left and right windshield and cockpit side window installations:

CAUTION: Make sure not to damage the paint when removing sealant.

- A. Remove any remaining fillet seal from the fuselage skin using best shop practices to prevent damaging the paint or primer.
- B. Visually inspect the fuselage skins and structure under and around the windshields and side window retainers and paint up to 2.0 inches outward from the edge of the retainers for bubbling, blistering or chipping of paint, or any signs of corrosion.

NOTE: Removal of paint to perform the inspection is not required.

- C. Visually inspect for any previous skin repairs under the windshields and side window retainers. Verify any identified repairs have been addressed by an approved field repair.
 - (1) If skin repairs are found with no approved field repair, report damage to Team Structures using the online Web SDR Form located at <https://ww2.txtav.com/service/tasdaq>.
- D. Visually inspect the bores of all open holes from the removed screws and fasteners for any signs of corrosion. (Refer the Model 525C Structural Repair Manual, Chapter 51, Crack, Scratch, Gouge and Corrosion.)

NOTE: Make sure to inspect the two fastener holes that are loosely holding the cockpit side windows in place from the NOTE in Step 1.B.

NOTE: The holes may need to be cleaned using best shop practices to remove sealant for proper inspection.

- E. If any corrosion is found, report damage to Team Structures using the online Web SDR Form located at <https://ww2.txtav.com/service/tasdaq>.
- F. If no corrosion is found, go to Step 5.

4. (Airplanes -0389 thru -0414) Inspect the following areas of the left and right windshield installations:

CAUTION: Make sure not to damage the paint when removing sealant.

- A. Remove any remaining fillet seal from the fuselage skin using best shop practice to prevent damaging the paint or primer.

- B. Visually inspect the fuselage skins and structure under and around the windshields and paint up to 2.0 inches outward from the edge of the retainers for bubbling, blistering or chipping of paint or any signs of corrosion.

NOTE: Removal of paint to perform the inspection is not required.

- C. Visually inspect for any previous skin repairs under the windshields. Verify any identified repairs have been addressed by an approved field repair.

(1) If skin repairs are found with no approved field repair, report damage to Team Structures using the online Web SDR Form located at <https://ww2.txtav.com/service/tasdaq>.

- D. Visually inspect the bores of all open holes from the removed screws and fasteners for any signs of corrosion. (Refer the Model 525C Structural Repair Manual, Chapter 51, Crack, Scratch, Gouge and Corrosion.)

NOTE: Holes may need to be cleaned using best shop practices to remove sealant for proper inspection.

- E. If any corrosion is found, report damage to Team Structures using the online Web SDR Form located at <https://ww2.txtav.com/service/tasdaq>.

- F. If no corrosion is found, go to Step 5.

5. (Refer to Figure 1, Detail A, Detail B, View A-A, View B-B, View C-C, View D-D, View E-E, View F-F and Figure 2, Detail A and View A-A.) Install a new 7111013-13 Left Upper Mid Outboard Ground Plate, 7111013-14 Right Upper Mid Outboard Ground Plate, 7111013-15 Left Upper Outboard Ground Plate, 7111013-16 Right Upper Outboard Ground Plate, 7111013-17 Left Lower Mid Outboard Ground Plate, 7111013-18 Right Lower Mid Outboard Ground Plate, 7111013-19 Left Upper Inboard Ground Plate, 7111013-20 Right Upper Inboard Ground Plate, 7111013-23 Left Lower Inboard Ground Plate and 7111013-24 Right Lower Inboard Ground Plate.

- A. Temporarily locate each ground plate on the airplane structure.

- B. Locate and mark existing skin bond assembly fasteners that will need to be removed to secure each new ground plate.

- C. Remove the ground plates from the airplane structure.

- D. Carefully remove all identified existing fasteners at each new ground plate location.

(1) When removing existing fasteners, create and save conical washers for use during installation of bonding plates.

- E. Clean the removed fastener holes with Methyl n-Propyl Ketone. (Refer to the Model 525C Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)

- F. Apply U074093 color chemical film treatment to the holes at the removed fastener locations.

- G. Temporarily locate each ground plate on the airplane structure.

NOTE: The ground plate is non-structural. The edge distance can not be less than 0.16 inch.

(1) (Refer to Figure 1, View A-A and Detail B.) Locate the new 7111013-13 Left Upper Mid Outboard Ground Plate, 7111013-14 Right Upper Mid Outboard Ground Plate, 7111013-15 Left Upper Outboard Ground Plate, 7111013-16 Right Upper Outboard Ground Plate, 7111013-17 Left Lower Mid Outboard Ground Plate, 7111013-18 Right Lower Mid Outboard Ground Plate, 7111013-19 Left Upper Inboard Ground Plate and 7111013-20 Right Upper Inboard Ground Plate.

(a) Center the cutouts around the existing windshield bolt holes and locate them 0.5 inches from the center of the existing bolt hole to the outside edge of the ground plate.

(2) (Refer to Figure 1, View A-A and Detail B.) Locate the new 7111013-23 Left Lower Inboard Ground Plate and 7111013-24 Right Lower Inboard Ground Plate with the curved edge of the

plate matching the curvature of the windshield skin opening. The plate should be rotated to center the ground plate cutouts between the existing windshield bolt holes.

- H. Mark hole locations on each ground plate to match existing hole locations on the airplane structure.
- I. Remove the ground plates from the airplane structure.
- J. Drill three 0.1625 to 0.1645 inch-diameter holes in the marked locations in the 7111013-13 Left Upper Mid Outboard Ground Plate and 7111013-14 Right Upper Mid Outboard Ground Plate.
 - (1) Countersink the 0.1625 to 0.1645 inch-diameter holes 100° x 0.290 inch-diameter.
- K. Drill three Number 30 (0.128 inch-diameter) holes in the marked locations in the 7111013-15 Left Upper Outboard Ground Plate and 7111013-16 Right Upper Outboard Ground Plate.
 - (1) Countersink the Number 30 (0.128 inch-diameter) holes 100° x 0.225 inch-diameter.
- L. Drill two 0.1625 to 0.1645 inch-diameter holes in the marked locations in the 7111013-17 Left Lower Mid Outboard Ground Plate and 7111013-18 Right Lower Mid Outboard Ground Plate.
 - (1) Countersink the 0.1625 to 0.1645 inch-diameter holes 100° x 0.290 inch-diameter.
- M. Drill two Number 30 (0.128 inch-diameter) holes in the marked locations in the 7111013-19 Left Upper Inboard Ground Plate and 7111013-20 Right Upper Inboard Ground Plate.
 - (1) Countersink the Number 30 (0.128 inch-diameter) holes 100° x 0.225 inch-diameter.
- N. Drill four Number 30 (0.128 inch-diameter) holes in the marked locations in the 7111013-23 Left Lower Inboard Ground Plate and 7111013-24 Right Lower Inboard Ground Plate.
 - (1) Countersink the Number 30 (0.128 inch-diameter) holes 100° x 0.225 inch-diameter.
- O. Deburr the holes that were drilled.
- P. Clean the holes with Methyl n-Propyl Ketone and apply U074093 color chemical film treatment. (Refer to the Model 525C Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)
- Q. Lightly clean the ground plates with Methyl n-Propyl Ketone. (Refer to the Model 525C Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)

NOTE: Lightly cleaning the ground plates will make sure the color chemical film treatment will not be removed.
- R. Polish the areas of the windshield retainer and skin to the base metal that will be in contact with the grounding plates. (Refer the Model 525C Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)
 - (1) Do not remove any metal material.
 - (2) Only remove the protective finish.
 - (3) Polish the skins and retainers by hand with a very fine scotch brite pad.
- S. Apply U074093 color chemical film treatment to any bare aluminum under and around the ground plates. (Refer to the Citation Standard Practices Manual, Chapter 20, Exterior Finish - Cleaning/Painting.)
- T. Locate the conical washers created in Step 5.D or fabricate 10 conical washers from the heads of CM3827AD4 Rivets and 10 conical washers from the heads of CM3827AD5 Rivets.

NOTE: The conical washers must be made from driven rivets for proper shape.
- U. Install the 7111013-13 Left Upper Mid Outboard Ground Plate and 7111013-14 Right Upper Mid Outboard Ground Plate.
 - (1) Apply U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2) Sealant to the 7111013-13 Left Upper Mid Outboard Ground Plate and 7111013-14 Right Upper Mid Outboard Ground Plate to make a fay seal between each grounding plate and skin. (Refer to the Citation

- Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure, and High-Temperature Sealing - Maintenance Practices.)
- (2) Attach the 7111013-13 Left Upper Mid Outboard Ground Plate and 7111013-14 Right Upper Mid Outboard Ground Plate to the airplane structure with three each conical washers (made in Step 5.D or from CM3827AD5 Rivet heads made in Step 5.T), HL19PB-5-5 Hi-Lok Pins and HL70-5 Hi-Lok Collars. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Pressure, Weather and High Temperature Sealing - Maintenance Practices.)
- V. Install the 7111013-15 Left Upper Outboard Ground Plate and 7111013-16 Right Upper Outboard Ground Plate.
- (1) Apply U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2) Sealant to make a fay seal between each grounding plate and skin. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure, and High-Temperature Sealing - Maintenance Practices.)
- (2) Attach the 7111013-15 Left Upper Outboard Ground Plate and 7111013-16 Right Upper Outboard Ground Plate to the airplane structure with three each conical washers (made in Step 5.D or from CM3827AD4 Rivet heads made in Step 5.T) and CM3827AD4 Rivets. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Pressure, Weather and High Temperature Sealing - Maintenance Practices.)
- W. Install the 7111013-17 Left Lower Mid Outboard Plate and 7111013-18 Right Lower Mid Outboard Plate.
- (1) Apply U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2) Sealant to make a fay seal between each grounding plate and skin. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure, and High-Temperature Sealing - Maintenance Practices.)
- (2) Attach the 7111013-17 Left Lower Mid Outboard Ground Plate and 7111013-18 Right Lower Mid Outboard Ground Plate with two each conical washers (made in Step 5.D or from CM3827AD5 Rivet heads made in Step 5.T), HL19PB5-5 Hi-Lok Pins and HL70-5 Hi-Lok collars. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Pressure, Weather and High Temperature Sealing - Maintenance Practices.)
- X. Install the 7111013-19 Left Upper Inboard Ground Plate and 7111013-20 Right Upper Inboard Ground Plate.
- (1) Apply U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2) Sealant to make a fay seal between each grounding plate and skin. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure, and High-Temperature Sealing - Maintenance Practices.)
- (2) Attach the 7111013-19 Left Upper Inboard Ground Plate and 7111013-20 Right Upper Inboard Ground Plate to the airplane structure with two each conical washers (made in Step 5.D or from CM3827AD4 Rivet heads made in Step 5.T) and CM3827AD4 Rivets. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Pressure, Weather and High Temperature Sealing - Maintenance Practices.)
- Y. Install the 7111013-23 Left Lower Inboard Ground Plate and 7111013-24 Right Lower Inboard Ground Plate.
- (1) Apply U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2) Sealant to make a fay seal between each grounding plate and skin. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure, and High-Temperature Sealing - Maintenance Practices.)
- (2) Attach the 7111013-23 Left Lower Inboard Ground Plate and 7111013-24 Right Lower Inboard Ground Plate to the airplane structure with four CM3827AD4 Rivets. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Pressure, Weather and High Temperature Sealing - Maintenance Practices.)
- Z. Plug any holes left open at the previous ground plate locations with CM3827AD4 Rivets installed wet with U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2) Sealant. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Pressure, Weather and High Temperature Sealing - Maintenance Practices.)

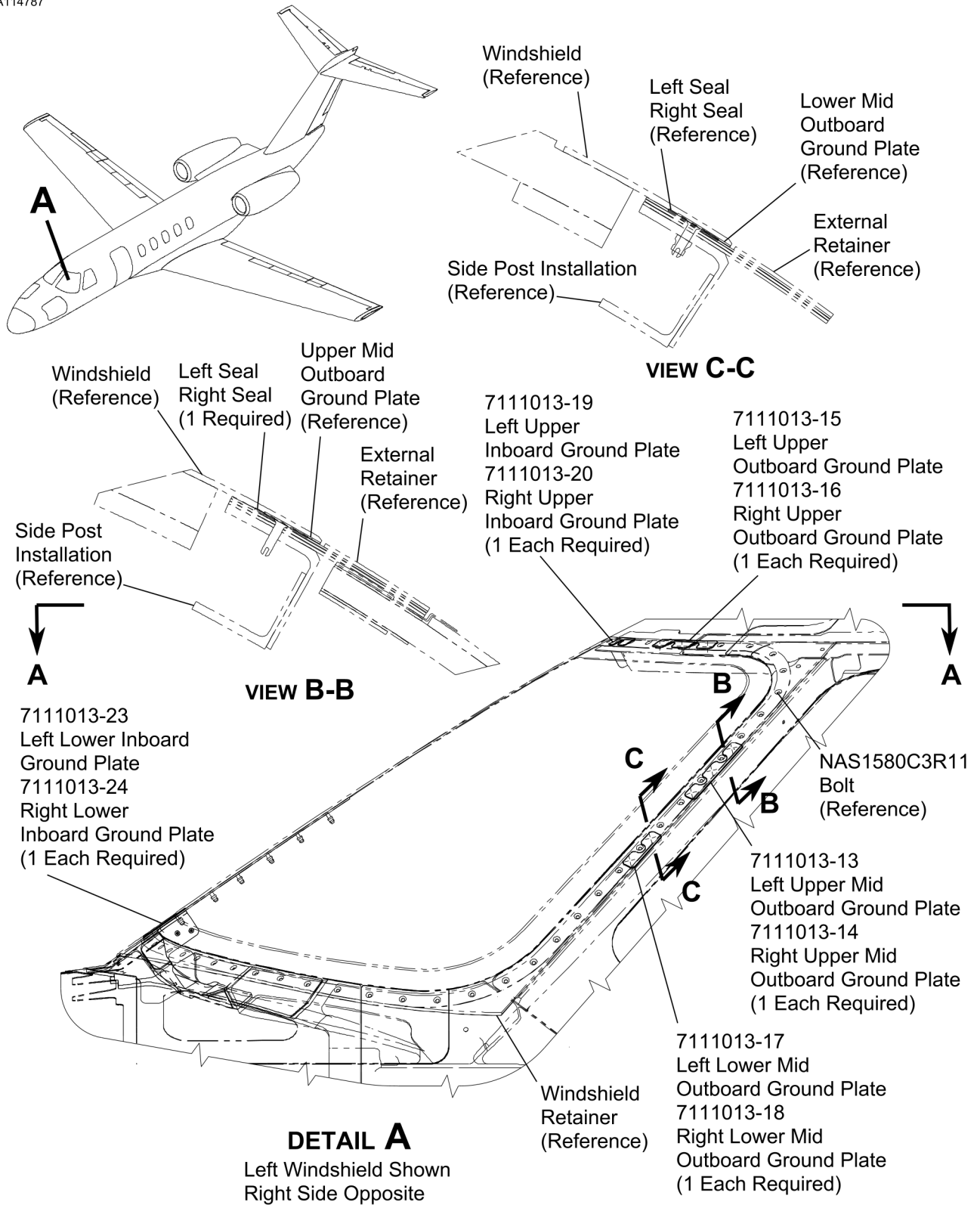
- AA. Do a Type I electrical bond check between each grounding plate and the surrounding skin structure. (Refer to the Citation Standard Practices Manual, Chapter 20, Electrical Bonding and Grounding - Maintenance Practices.)
- AB. Apply U074093 color chemical film treatment to any bare aluminum around the new ground plates and where the removed ground plates were located. (Refer to the Model 525C Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)
- AC. Touch up any bare aluminum around the new ground plates and where the removed ground plates were located with 10P8-11 corrosion resistant primer. (Refer to the Model 525C Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)
- NOTE:** The surfaces of the grounding plates that will mate directly with the windshield retainer should have color chemical film treatment only and no primer.
- AD. Fillet seal around the new ground plates with U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2) Sealant. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure, and High-Temperature Sealing - Maintenance Practices.)
- AE. Apply U470637 (Type I, Class B1/2) or U470642 (Type I, Class B2) Sealant to the driven head of the installed fasteners to create a dome seal. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure, and High-Temperature Sealing - Maintenance Practices.)
6. (Refer to Figure 1, Detail A.) Inspect the rivetless nutplates.
- A. If the rivetless nutplates are all secure, go to Step 7.
- B. If any of the rivetless nutplates have come loose, replace the applicable rivetless nutplate(s). (Refer to the Model 525C Structural Repair Manual, Chapter 51, Fastener Installation and Removal.)
- (1) Inspect for the presence of the correct 10P8-11 corrosion resistant primer in the windshield bolt holes. If the primer is damaged or not present, corrosion resistant primer needs to be added.
7. Apply corrosion resistant primer and seal the windshields prior to installation. (Refer to the Model 525C Maintenance Manual, Chapter 56, Windshield - Removal/Installation.)
- NOTE:** The surfaces of the grounding plates that will mate directly with the windshield retainer should have color chemical film treatment only and no primer.
8. Install the left and right windshield with new NAS1580C3R11 Bolts. (Refer to the Model 525C Maintenance Manual, Chapter 56, Windshield - Removal/Installation.)
- A. Do a Type I electrical bond check of the windshield retainers. (Refer to the Citation Standard Practices Manual, Chapter 20, Electrical Bonding and Grounding - Maintenance Practices.)
9. (Airplanes -0001 thru -0388) Apply corrosion resistant primer and seal the left and right cockpit side window retainers prior to installation. (Refer to the Model 525C Maintenance Manual, Chapter 56, Cockpit Side Window - Removal/Installation.)
10. (Airplanes -0001 thru -0388) (Refer to Figure 2, Detail A, View A-A.) Install the left and right cockpit side windows and retainers with new NAS1580C3R4 Bolts, NAS1580C3R15 Bolts, NAS1149F0363P Washers and MS21044N3 Nuts. (Refer to the Model 525C Maintenance Manual, Chapter 56, Cockpit Side Window - Removal/Installation.)
- A. Use two NAS1149F0636P Washers on each NAS1580C3R15 Bolt during installation to achieve proper torque.
11. Do the Windshield Temperature Controller Operational Check. (Refer to the Model 525C Maintenance Manual, Chapter 30, Windshield Temperature Controller - Adjustment/Test.)
12. Do the Pressure Vessel Leak Check. (Refer to the Model 525C Maintenance Manual, Chapter 21, Pressurization - Inspection/Check.)
- A. After completing the pressure vessel leak check, do a one time re-torque of all windshield bolts to 38-40 inch-pounds. (Refer to the Citation Standard Practices Manual, Chapter 20, Torque Data - Maintenance Practices.)

13. Make an entry in the airplane logbook that states compliance and method of compliance with this service document.

NOTE: Textron Aviation recommends that compliance with all service documents is reported to a maintenance tracking system provider.

- Complete a record of compliance. (Maintenance Transaction Report, Log Book Entry, or other record of compliance)
- Put a copy of the completed record of compliance in the airplane logbook.
- Send a copy of the completed record of compliance to the maintenance tracking system provider used.

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7110T1001

Figure 1. Windshield Frame Ground Plate Installation (Sheet 1)

A114788

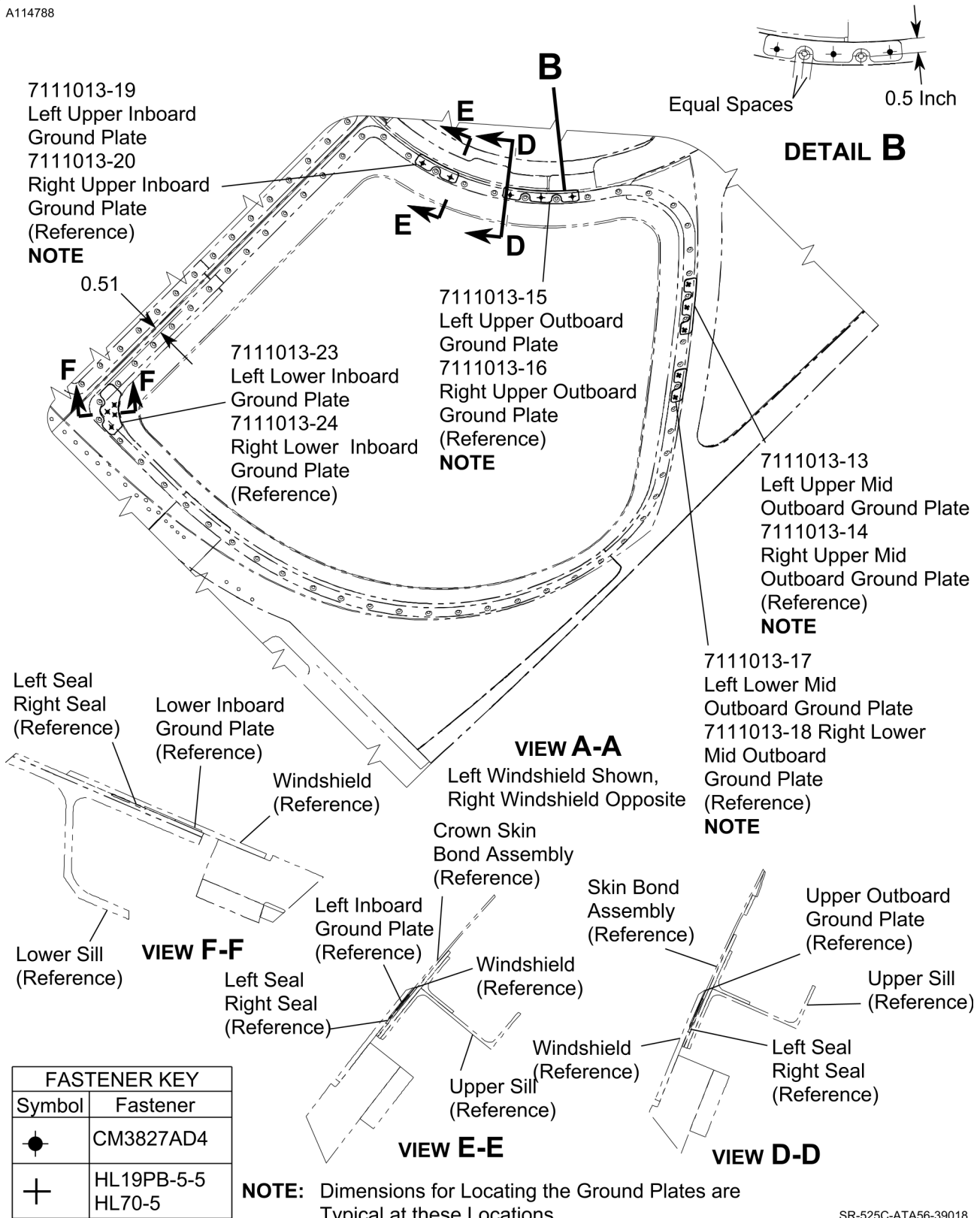
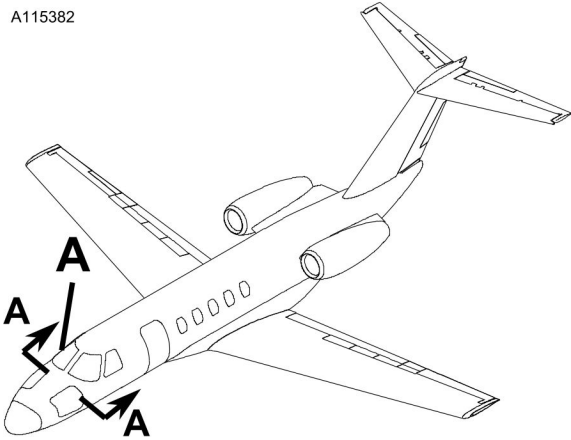


Figure 1. Windshield Frame Ground Plate Installation (Sheet 2)

SR-525C-ATA56-39018

A115382



Ground Plates
(Reference)

VIEW A-A
Looking Aft

Figure 2. Ground Plate Locations (Sheet 1)

A115383

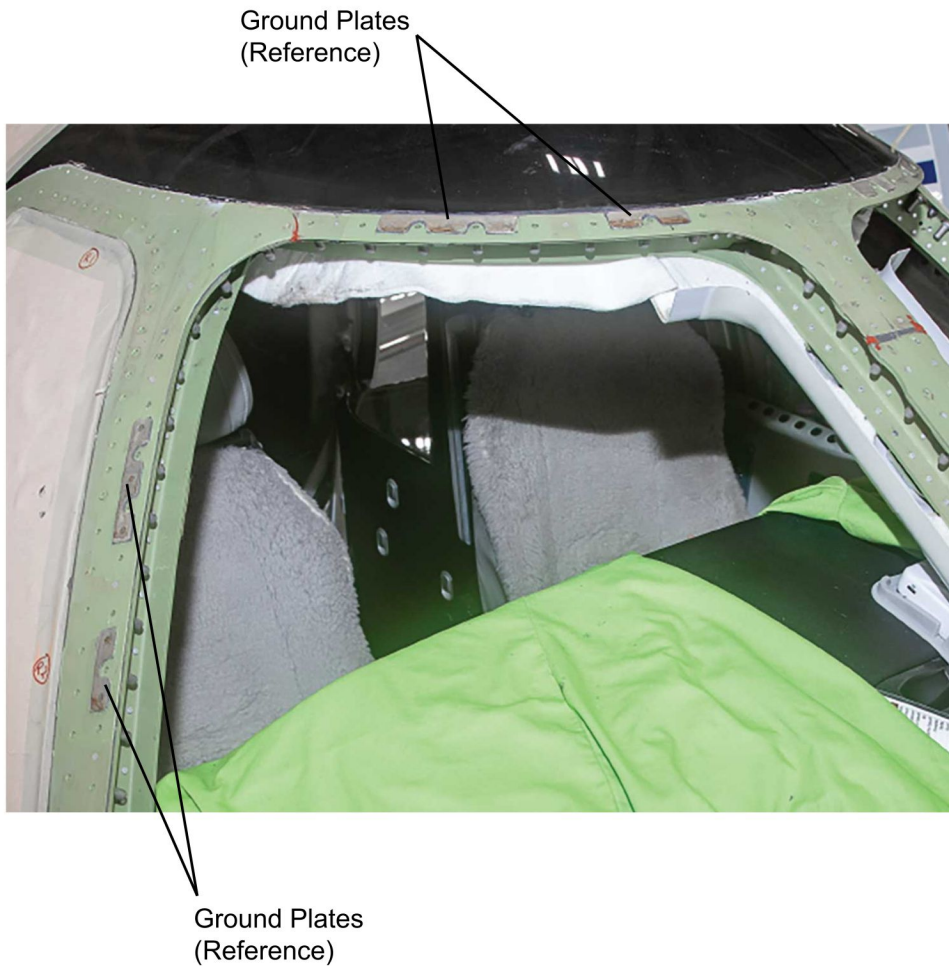


Figure 2. Ground Plate Locations (Sheet 2)

A115384



Ground Plates
(Reference)

DETAIL A
Right Side Shown,
Left Side Opposite

Figure 2. Ground Plate Locations (Sheet 3)

A115385



DETAIL A
Right Side Shown,
Left Side Opposite

Figure 2. Ground Plate Locations (Sheet 4)

A114789

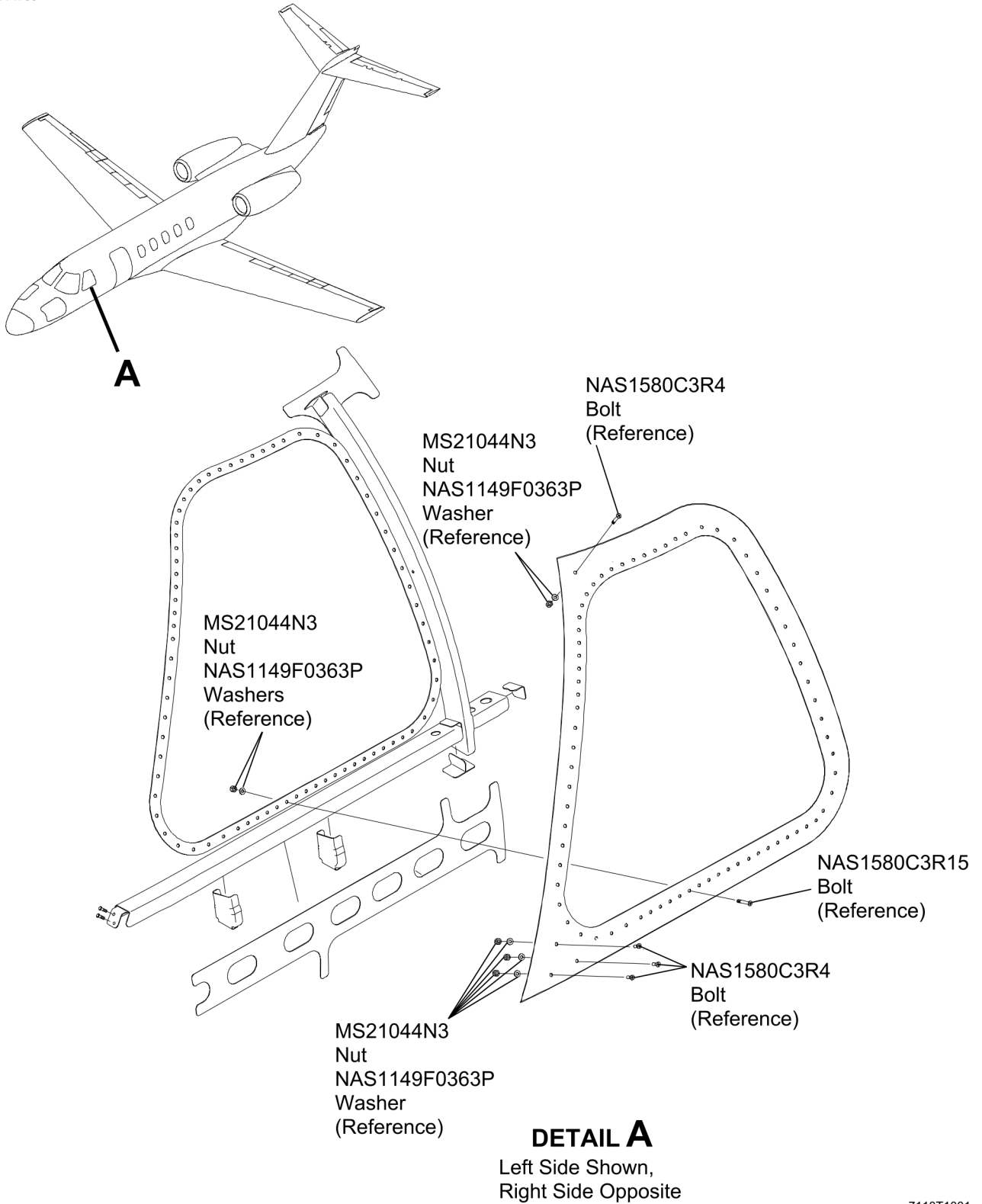
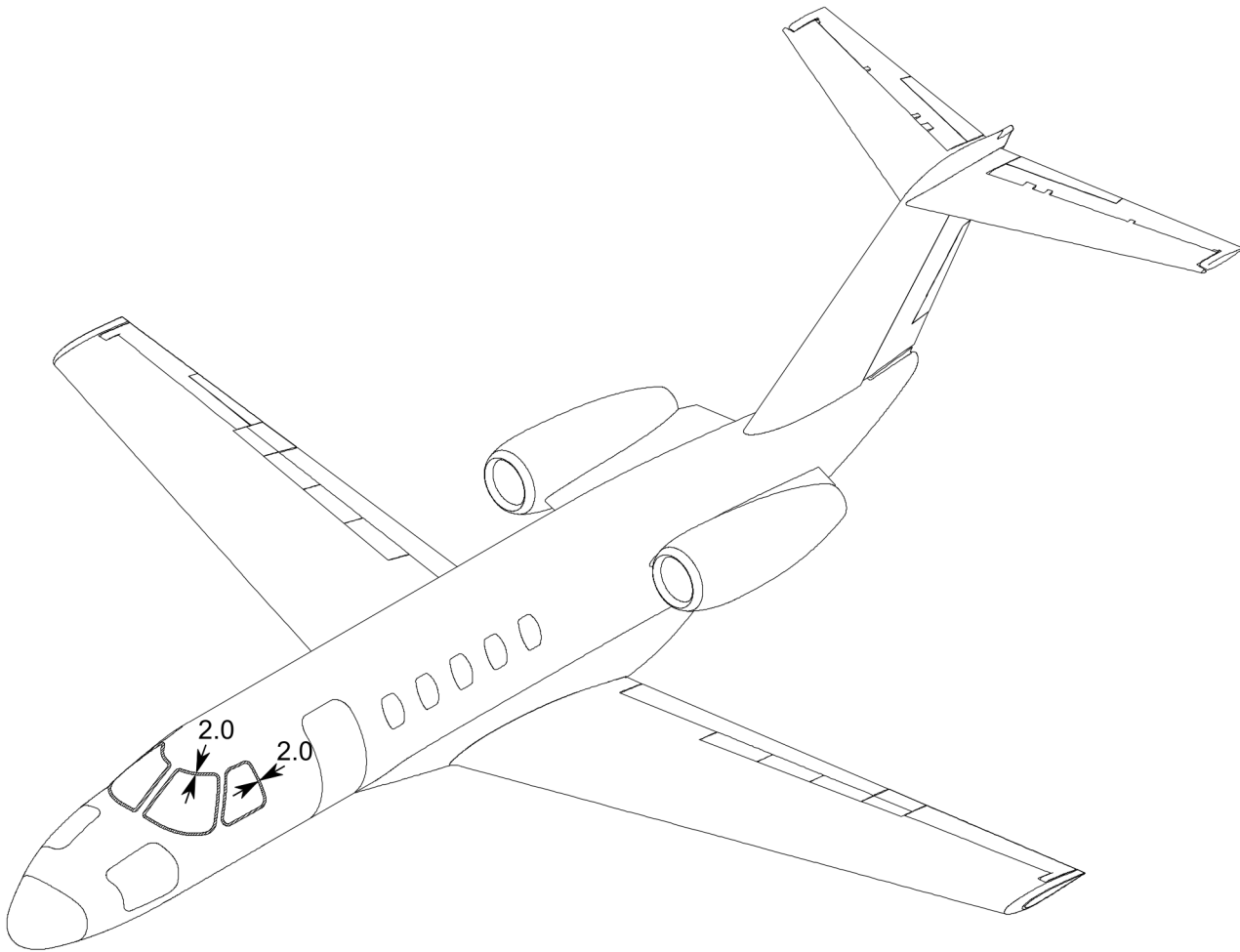


Figure 3. Cockpit Side Window Frame Sealing (Sheet 1)

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A7111T1099

A115014



Corrosion Inspection For The Left and Right Windshields and Cockpit Side Windows

7110T1001

Figure 4. Windshield And Side Window Corrosion Inspection (Sheet 1)

MATERIAL INFORMATION

Order the kit/parts below to install this modification.

NEW P/N	QUAN- TITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
SB525C-56-01	1	Kit , consisting of the following parts:		
CM3827AD4-10	84	Rivet		
CM3827AD5-10	15	Rivet		
HL19PB-5-5	10	Hi-Lok Pin		
HL70-5	10	Hi-Lok Collar		
MS21044N3	154	Nut		
NAS1149F0363P	308	Washer		
NAS1580C3R4	8	Bolt		
NAS1580C3R11	122	Bolt		
NAS1580C3R15	146	Bolt		
7111013-13	1	Left Upper Mid Outboard Ground Plate		
7111013-14	1	Right Upper Mid Outboard Ground Plate		
7111013-15	1	Left Upper Outboard Ground Plate		
7111013-16	1	Right Upper Outboard Ground Plate		
7111013-17	1	Left Lower Mid Outboard Ground Plate		
7111013-18	1	Right Lower Mid Outboard Ground Plate		
7111013-19	1	Left Upper Inboard Ground Plate		
7111013-20	1	Right Upper Inboard Ground Plate		
7111013-23	1	Left Lower Inboard Ground Plate		
7111013-24	1	Right Lower Inboard Ground Plate		
SB525C-56-01	1	Instructions		

It may be necessary to order the parts below to install this modification.

NEW P/N	QUAN- TITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
CB6008CR3-4P	As Required	Rivetless Nutplate		
CB6008CR3-5P	As Required	Rivetless Nutplate		
CB6008CR3-6P	As Required	Rivetless Nutplate		
R441257	300 inches	Seal		
R881500	300 inches	Seal		

* Please contact your Regional Textron Aviation Parts Distribution Customer Support Team for current cost and availability of parts listed in this service document. Phone at 1-800-835-4000 (Domestic) or 1-316-517-5603 (International).

For more information, please visit the TAPD Support & Aftermarket Account Management website at <https://ww2.txtav.com/Parts/Promos/TAPD>.

Based on availability and lead times, parts may require advanced scheduling.

TITLE

WINDOWS - WINDSHIELD AND COCKPIT SIDE WINDOW FRAME MODIFICATION

TO:

Cessna CJ4 Model Aircraft Owner

REASON

To add new windshield ground plates and sealing to the area around the frame of the windshields and cockpit side windows to decrease the potential for moisture incursion.

COMPLIANCE

RECOMMENDED. This service document should be accomplished at a scheduled maintenance period or inspection.

LABOR HOURS

WORK PHASE	LABOR-HOURS
Modification	162.0

MATERIAL AVAILABILITY

PART NUMBER	AVAILABILITY	COST
SB525C-56-01	*	*
CB6008CR3-4P	*	*
CB6008CR3-5P	*	*
CB6008CR3-6P	*	*
R441257	*	*
R881500	*	*

* Please contact your Regional Textron Aviation Parts Distribution Customer Support Team for current cost and availability of parts listed in this service document. Phone at 1-800-835-4000 (Domestic) or 1-316-517-5603 (International).

For more information, please visit the TAPD Support & Aftermarket Account Management website at <https://ww2.txtav.com/Parts/Promos/TAPD>.

Based on availability and lead times, parts may require advanced scheduling.

WARRANTY

This service document is *recommended*. Eligible airplanes may qualify for parts and labor coverage to the extent noted in the *Labor Hours* and *Material Availability* sections of this document.

April 29, 2024

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Eligibility: Airplanes identified within the serial number effectivity of this service document must have active Airframe warranty coverage on the original issue date of this document.

Parts Coverage: Textron Aviation-owned and Textron Aviation-authorized Service Facilities, operators, or other maintenance facilities may submit a claim for the parts required to accomplish this service document as defined in the *Material Availability* section of this document.

Labor Coverage: Textron Aviation-owned and Textron Aviation-authorized Service Facilities rated to perform maintenance on the specific model of Cessna Aircraft may submit a claim for the labor necessary to accomplish this service document as defined in the *Labor Hours* section of this document.

Credit Application: After this service document has been accomplished, a claim must be submitted to Textron Aviation within 30 days of the service document completion. Claims for compliance of this service document are to be filed as a W4 type claim.

Please submit your claim form online at ww2.txtav.com/Parts or email the completed Textron Aviation Claim Form to warranty@txtav.com. If submitted on-line a Return Authorization will be provided. If a paper claim is submitted your claim will be entered into the system and a Return Authorization will be sent to you.

The Return Authorization must accompany any required return parts (see *Material Availability*), to the point of purchase.

Parts to be returned to Textron Aviation should be forwarded to:

TEXTRON AVIATION INC
CORE RETURNS
201 N GREENWICH RD BLDG 94
Wichita, KS 67206-2558

Expiration: April 29, 2029 (After this date the owner/operator assumes the responsibility for compliance costs.)

Textron Aviation reserves the right to void continued airplane warranty coverage for the parts affected by this service document until the service document is accomplished.

NOTE: As a convenience, service documents are now available online to all our customers through a simple, free-of-charge registration process. If you would like to sign up, please visit the Customer Access link at support.txtav.com to register.

