2006 Sta.XX
window plate
view from interior

standard flange window prep
(see detail for dims.)

accepts Swagelok p/n SS-600-1-OR-BT fittings

P-3 fuselage O.D. is 136"
window plates are recessed ca. 0.25" from outer skin

Exterior sealing gasket outline is shown in red
window prep for standard flange

view from interior

accepts eight MS21047-3 steel 10/32 nut plates (3/32" rivets)

Drill through and countersink for 3/32" rivets (2 places each)

mill 5.25" dia. O-ring sealing flat

Prep for eight (8) p/n MS21047-3 nut plates, equally spaced on 4.600" dia. circle, mounted on exterior face of window plate

window prep for 9/16-18 male connector fitting

view from interior

accepts Swagelok SS-600-1-OR-BT fitting

Mill 1.06"-dia. O-ring sealing flat

Drill through and tap for 9/16-18 straight thread
WP-3D standard inlet flange

4130N steel aircraft flats, 8"x8"x1/2" stock
Robin Materials, Inc.
www.rmtc.com
(550) 998-1933

for Wicks Aircraft streamline tubing
p/n SL33-14-4
3.372 major axis nom.
1.429 minor axis nom.
0.343" chord fwd. of CL
0.048" wall nom.

Section through major axis of airfoil (centered on flange center)

Drill through clearance for 10-32 screws (8 places, equally spaced on 4.600" dia. circle)

SL33-14-4 tubing weld prep (centered on flange center) groove using 1/8" ball-end mill (see cutaway detail)

Note: all tapped holes must be drilled through

Groove for Parker #2-241 O-ring (internal pressure)
I.D. = 3.659"
O.D. = 4.179"
depth = 0.104 ± 0.003"

Section through minor axis of airfoil (0.343" forward of flange center)
WP-3D standard end cap

4130N steel aircraft flats
Robin Materials, Inc.
www.rmat.com
(650) 966-1533

for Wicks Aircraft streamline tubing
p/n SL33-14-4
3.372 major axis nom.
1.429 minor axis nom.
0.343" chord fwd. of CL
0.049" wall nom.

I.D. of tubing (3.272" nom.)

major axis (3.372" nom.)

0.050" 0.190"

airfoil chord

0.343"

I.D. of tubing (1.329" nom.)

major axis (1.429" nom.)
Standard flange – blank
0.25" thick 6061 AI

Groove for Parker #2–241 O-ring (internal pressure):
  I.D. = 3.859"
  O.D. = 4.178"
  depth = 0.104 ± 0.003

Drill through clearance for 10–32 screws (8 holes, equally spaced on 4.600" dia. circle)

Section A–A