2006 Sta.XX
window plate
view from interior

standard flange window prep
(see detail for dims.)

Ø 3.750" through

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

P-3 fuselage O.D. is 136"
window plates are recessed
c. 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 0.688" 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-DR-BT fitting

Mill 1.06"-dia. O-ring sealing flat

Drill through and tap for 9/16–18 straight thread
4130N steel aircraft flats, 8"x8"x1/2" stock
Robin Materials, Inc.
www.rmit.com
(550) 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.

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 details)

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 airfoil

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.
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.
Standard flange – blank
0.25" thick 6061 Al

Groove for Parker #2-241 O-ring (external pressure):
I.D. = 3.859"
O.D. = 4.176"
depth = 0.104 ± 0.003

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

Ø 5.125"

Section A–A

5.125"

0.250"