



A I R C R A F T

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CUSTOM KIT

CK-AG-50

Initial Release: 06/03/2020

Impact Resistant Windshield

AIRPLANES AFFECTED:

MODEL

SERIAL NUMBERS

S2R-T34

ALL

S2RHG-T65

ALL

S2R-G10

ALL

S2RHG-T34

ALL

S2R-T660

ALL

S2R-H80

ALL

S2R-R1340

ALL

Levan Tabidze

Vice President of Engineering

LOG OF REVISIONS

NOTE: Reformatting and correction of typographical errors is not considered revision. True revisions are indicated by a dark vertical line at the right margin of the lines revised.

Rev.	Page	Description of Revision	By:
IR	All	New Document Initial Release.	T. Vicks 06/03/2020

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1. PURPOSE/REASON FOR PUBLICATION:

This Custom Kit provides instructions and parts information for the installation of the impact resistant windshield (Part Number: 561160001-001).

2. SCOPE/COMPLIANCE:

This Custom Kit is approved for the following Thrush models:

S2R-T34	S2R-T660
S2RHG-T65	S2R-H80
S2R-G10	S2R-R1340
S2RHG-T34	

3. BY WHOM WORK WILL BE ACCOMPLISHED:

The work is to be accomplished by an FAA Certified A&P mechanic or foreign equivalent.

4. APPROVAL:

This Custom Kit is approved by the Vice President of Engineering at Thrush Aircraft, LLC

5. MAN HOURS:

6 hours will be required.

6. SPECIAL TOOLS:

No special tools required.

7. WEIGHT AND BALANCE:

No change.

8. PARTS LIST

QUANTITY	PART NUMBER	DESCRIPTION	SUPPLIER
1	561160001-001	Center Windshield	Thrush Aircraft, LLC
A/R	PR-1422	Sealant Per AMS-S-8802*	PPG Aerospace (Pro-Seal)
	P/S 890	Sealant Per AMS-S-8802*	PPG Aerospace (Pro-Seal)
	CS3204	Sealant Per AMS-S-8802*	Flamemaster Corporation (Chem Seal)

*May be purchased locally

9. ACCOMPLISHMENT INSTRUCTIONS:

NOTE: Follow sealant manufacturer's instructions for mixing and curing times.

NOTE: Be sure to apply enough sealant to the windshield or windshield frame to fill any air gaps, but do not over apply allowing the sealant to squeeze out of the frame and moldings.

CAUTION: The windshield's installation orientation is critical. There is an outside and inside face to the windshield that is marked on the windshield but is undetectable to the naked eye. Be certain during installation that the outside face of the windshield is to the outside of the aircraft. If the windshield markings have been removed or are illegible at time of installation, contact Thrush Aircraft for assistance.

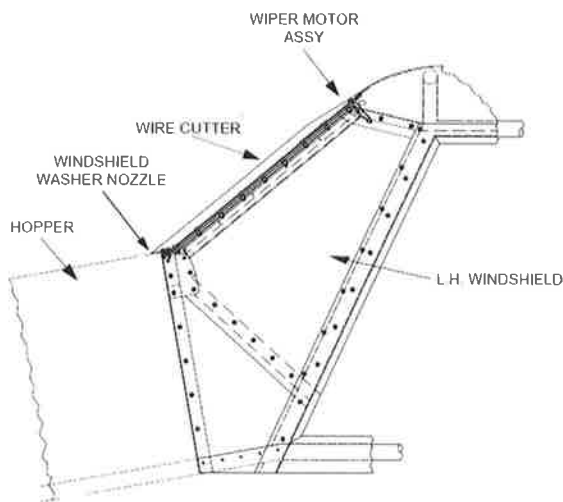


Figure 8-1: LH Windshield

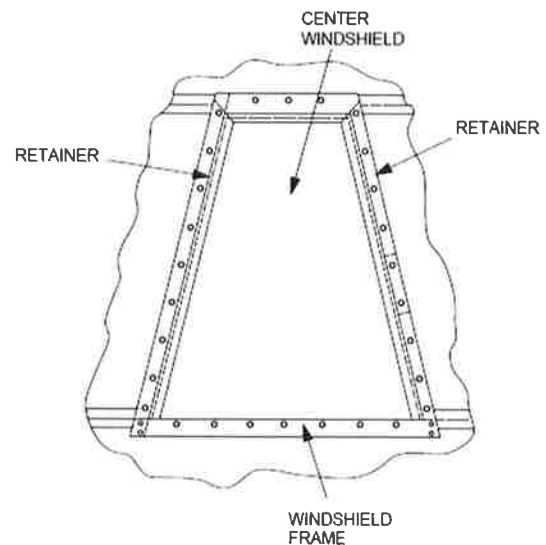


Figure 8-2: Center Windshield

1. Windshield Removal

- 1.1. Remove wiper motor shroud.
- 1.2. Remove wiper motor.
- 1.3. Remove wire cutter and molding from right side.
- 1.4. Remove handle and molding from left side.
- 1.5. Remove upper and lower moldings.
- 1.6. Remove sealant.
- 1.7. Remove windshield retaining frame.
- 1.8. Remove windshield, being careful to avoid windshield washer nozzle.

2. Surface Preparation

- 2.1. Remove all old sealant residue from frame and moldings with non-metallic tools. Be careful not to damage painted surfaces. Clean windshield moldings and frame with solvent such as MEK.
- 2.2. Dry all surfaces with a clean rag before solvent evaporates.

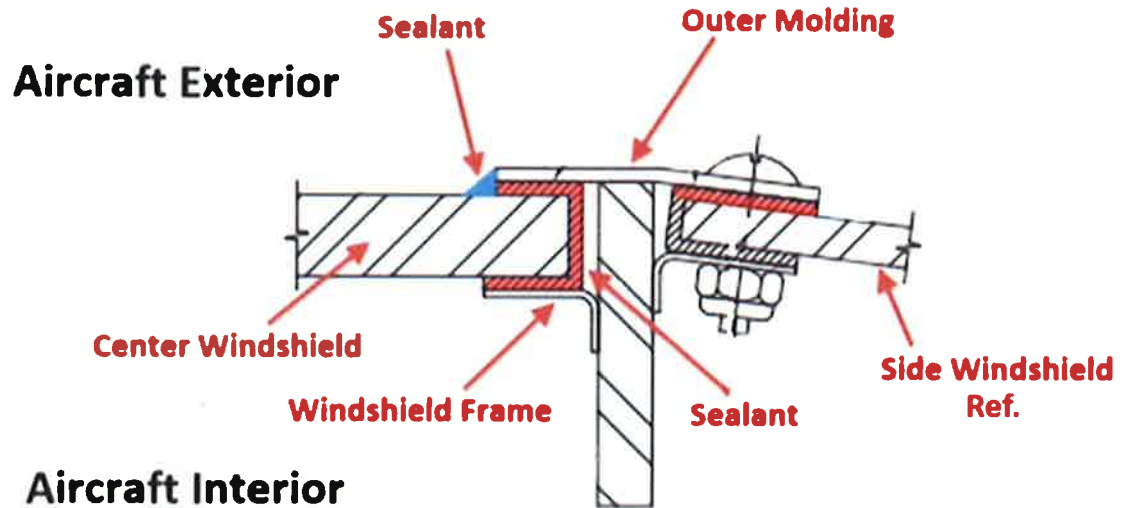


Figure 8-3: Windshield Installation Cross-Section

- 2.3. Touch up any paint that was damaged during removal.
3. Windshield Installation
 - 3.1. Reference Figure 8-3 for correct application of windshield sealants.
 - 3.2. Apply sealant to edges of center windshield that will make contact with the windshield frame and moldings.
 - 3.3. Install windshield into windshield frame while paying special attention to the windshield orientation marking(s) (outside/inside).
 - 3.4. Apply sealant to edges of side windshields that may have been exposed by the removal of windshield moldings, reference Figure 8-3. (Be sure to follow sealant manufacturer instructions to ensure proper curing.)
 - 3.5. Install handle and molding on left side.
 - 3.6. Install wire cutter and molding on right side.
 - 3.7. Install upper and lower moldings.
 - 3.8. Install screws around perimeter of windshield moldings.
 - 3.9. Apply sealant where moldings meet center and side windshields, reference Figure 8-3.
 - 3.10. Reinstall screws securing windshield frame. (AN526-1032-14 if new screws are needed.)
 - 3.11. Reinstall nuts securing wiper motor.
 - 3.12. Reinstall wiper motor shroud.
4. Return to service
 - 4.1. Allow windshield sealant to cure for the manufacturer's recommended amount of time prior to returning the aircraft to service.

9. RECORD OF COMPLIANCE:

Make appropriate entry in airplane maintenance records as follows:

"Thrush Custom Kit CK-AG-50 Rev. IR complied with at _____ total hours on aircraft."

Modification accomplished by:

Name & Certificate #

Date

10. RESPONSE CARD

The final step in compliance with this Custom Kit is to complete and return the compliance card on the next page. It may be mailed, faxed, or scanned and e-mailed.

Fax to:

Ed Rusk

229-439-9790

Email to:

Ed Rusk

ed.rusk@thrushaircraft.com

Custom Kit CK-AG-50 Rev. IR Compliance Report

Aircraft S/N:	Aircraft Owner:
Aircraft Registration #:	Address of Owner:
Airframe total time:	City & State:
Engine total time:	Physical location:
Complied with by:	Date of Compliance:
Signature:	Certificate #:

PLEASE RETURN THIS REPORT ONLY AFTER MODIFICATION IS MADE

This response card may be mailed, faxed, or emailed.

Fax: 229-439-9790 Attn: Ed Rusk

Email: ed.rusk@thrushaircraft.com

Fold, Tape & Mail (Do Not Staple)

Return Address

Thrush Aircraft, LLC
Attn: Ed Rusk
300 Old Pretoria Road
Albany, GA 31721