RV-10 WINDOWS INSTALL SIKAFLEX

May 2024 By Yannick Bovier, based on Zach Chase Glastar Window Installation 5 videos

room temperature 23 degrees
do not use a saw of any kind
do not leave the edge rough
do not leave tape more 2 days
check sikaflex expiration date
window flush to 0.25 mm recessed
no solvent on acryl ! Wipe it with tissue only
do not pull tension on fine line tape
activator 205 is extremly thin, apply with paper towel
primer, shake 1 minutes, apply in one thin layer

PREPARE WINDOW AND JOGGLE

1   trim the window frame to 1.9 cm
2   peel back window protection 5 cm
3   trim the window initially to just fit opening with little bit of movement
    always grind it towards you, pressure and speed control the amount taken
4   rub the edge with tongue depressor to avoid cut
5   remove pen mark with moist paper tissue
6   mark outer edge with pen slightly above wood triangle held 90 deg to edge
7   grind to the line, do not touch line
    always grind it towards you, pressure and speed control
8   remove black line
9   remark and retrim some corner if needed
10 lightly sand the joggle not shinny, the flat and return edge with 220 grit or green scotch brite
11 sand akryl with 220 grit
12 drill #40 perimeter just next acryl and cleco as things progress
13 smooth the edge of acryl with up to 220 grit and check for damage
14 radius the outside edge to 1 mm by sanding by hand with 100 grit

15   make a line (outside face) around acryl on the joggle

16   make a line (inside face) around the joggle on the akryl

TAPE THE INSIDE OF WINDOW

1   blue tape inside 4 mm from the line

2   mask tape precicely inside next to line to ovelay blue tape. Start inside of window
past the tail
do not cover black line at any time

3   remove black line with moist paper

4   protect inside window

TAPE THE OUTSIDE OF WINDOW

1   blue tape outside 2 inches and go over board

2   bevel cut and angle razor towards inside
arrange to be able to peal everything off

3   protect outside window

4   sand inside on acryl close to tape

5   dedust it (hoover and air)

PREPARE THE FUSE

1   blue tape outside 2 inches to the line (more or less) and round with a pen

2   mark the standoff location and clecos on cabin top

3   apply activator 205 at standoff location, wait 15 minutes (10 min to 2 hours)

4   apply primer 209 at standoff location, wait 40 minutes (30 min to 24 hours)

3   built the standoff at each cleco location with sikaflex, wait 2 days

4   backtape the inside of fuse with white tape (stronger)

5   cut around with razor blade

6   drill the #40 hole in the tape

7   after 3 days trim the standoff to have window flush

GLUEING PROCESS (PRIMER 209 ON ALL SIKAFLEX AREA !)

1   apply primer 209 on window with foam from a cup, wait 55 minutes (30 min to 24 hours)
3   apply activator (cleaner) 205 on joggle, wait 15 minutes (10 min to 2 hours) papier ménage
4   apply primer 209 on joggle, wait 40 minutes (30 min to 24 hours)
5   apply Sika bead (1cm) in joggle (better more than not enough)
6   press where cleco will be and clean area of exces
7   cleco all around
8   pull tape outside, remove cleco, turn wood, reinstall cleco. Do so all around (better to do)
9   on inside, clean smooth excess, do not remove it and hold spatule at 90 not to go under edge
10 add sikaflex at places if needed
11 pull tape inside
12 leave cleco for 3 days (4 day for windshield)

AFTER PAINT

1   blue tape outside and cut with razor blade at angle
2   blue tape akryl and cut with razor blade at angle
3   fill gap with Sikaflex
4   use tong deperssor for the joint, final once all around without lifting