

Pass Through Windows Procedure

1. Remove vinyl coating from all frames.

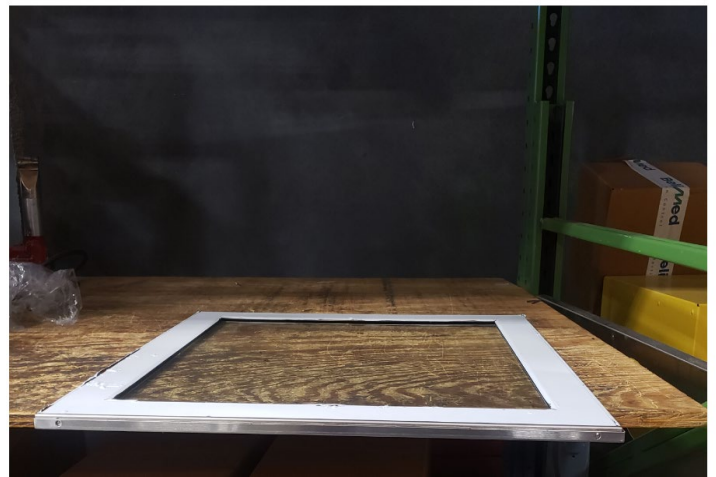
- a. PTW022/027/028/029.



2. Add foam strips inside of frames.

- a. Insert foam strips behind all interior flanges. Ensure there are no gaps at corners.

Note: Cut foam stripping in half for PTW028/029 narrow sides.



3. Install glass (PTW019) between frames.

- a. Use (4) No. 8-32x44 screws with Loctite on PTW022/027.

Note: All Loctite is **blue** unless otherwise specified.

4. Prep (2) spiral bars.

- a. Knock out the pins.
- b. Cut the top portion in half between pin holes.
- c. Remove all burrs and sharp edges.

5. Attach (2) PTW034 block to spiral bar pin hole.

- a. Use (2) No. 2-56 screw with (2) No. 2-56 nylon locknut.
- b. Use (2) No. 8-32x44 screws with Loctite on top hole set of PTW028/029.

- c. Use (2) No. 8-32x3/4 screws with Loctite on bottom hole set to attach (2) spiral bars of PTW028/029.
- d. Place PTW005 frame on table with large flange upwards.



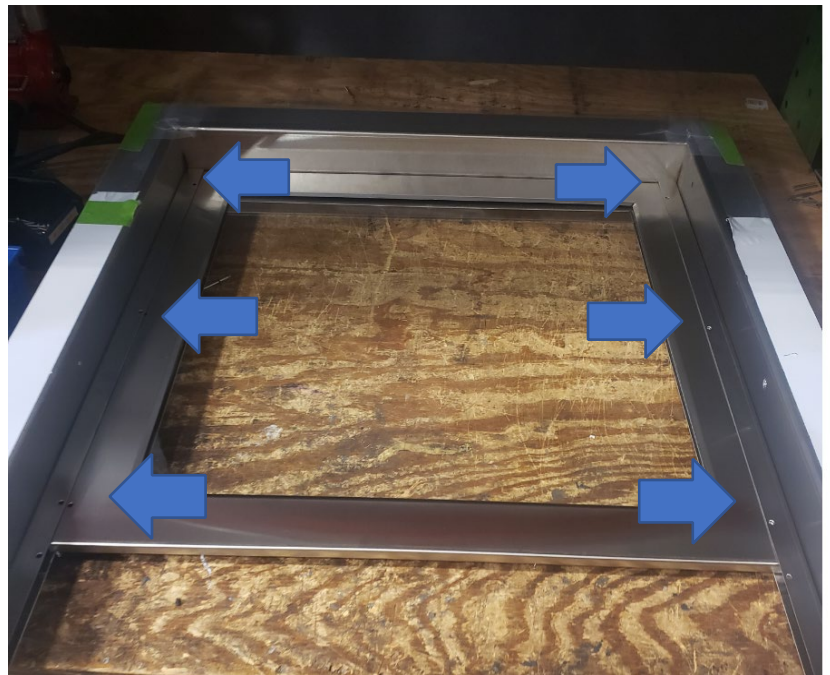
6. Assemble (2) PTW012 channels onto frame.

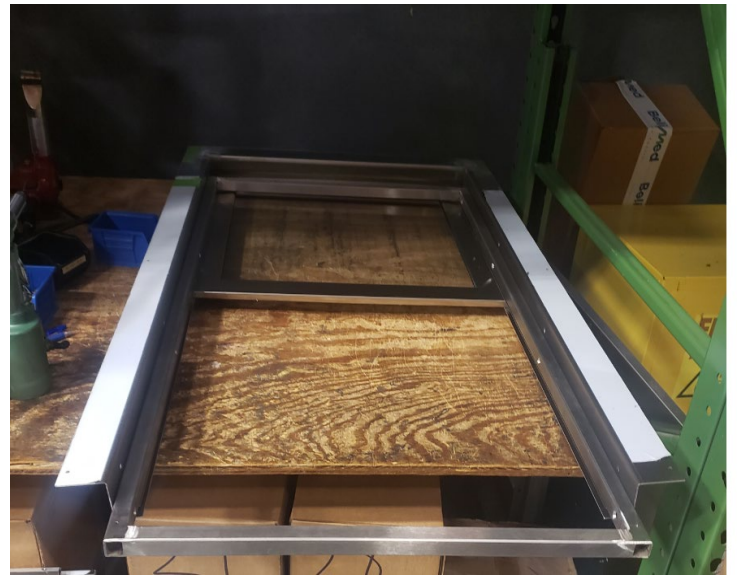
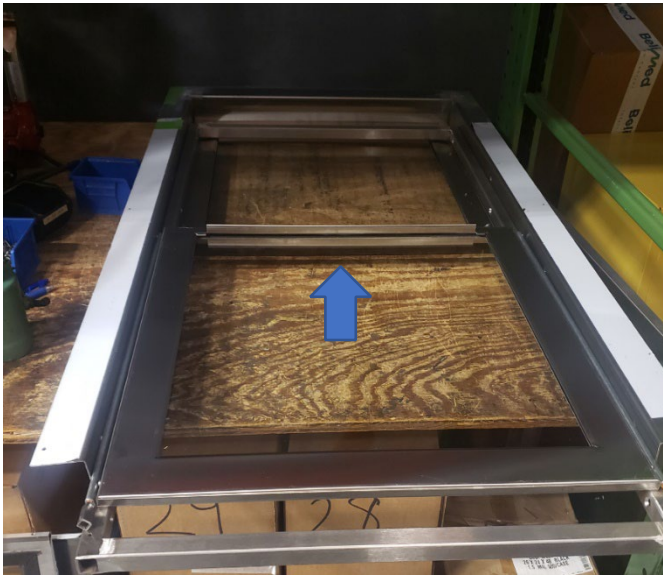
- a. Ensure holes are facing up using 3/16 pop rivets.

Important: Rivets are inserted from outside of PTW005 frame into PTW012 channels.

Note: Use V4 yellow rivet gun.

- b. Slide the PTW022/027 assembly into PTW012 channels.
- c. Align (6) holes and use 3/16 pop rivets to secure assembly.





7. Install PTW001 weldment inside PTW005 frame

- a. Install (2) No. 10-32 halfhex inserts into PTW001 weldment toward bottom of frame, facing upwards.
- b. Lay (PTW001) weldment inside PTW005 frame.
- c. Apply (4) slip trim strips to outside vertical edges of PTW028/029 on both sides of assembly.

8. Place PTW028/029 assembly onto weldment with flange towards top of frame.

- a. Turn the block on spiral bar (7-8) full turns.
Keep Tension.



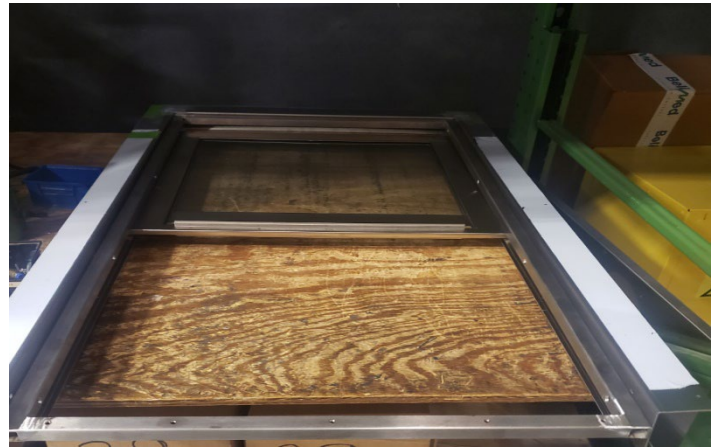
- b. Assemble to hole PTW001 weldment using hardware 10-32-3/4 screw with Loctite.

Note: Assembly must match frontal orientation when PTW001/028/029 assembly is flipped.



- 9. Flip the PTW001 frame tube/ PTW028/029 window assembly into large frame.**
 - a. Pin the assembled window frame between PTW001 weldment and the large frame assembly.

- 10. Assemble PTW001 weldment to PTW005.**
 - a. Secure (4) No. 1/4-20x1.25 screws with Loctite.



- 11. Stand the entire window up vertically.**
 - a. Ensure the movable window frame does not slam down and spiral bars maintain proper tension.