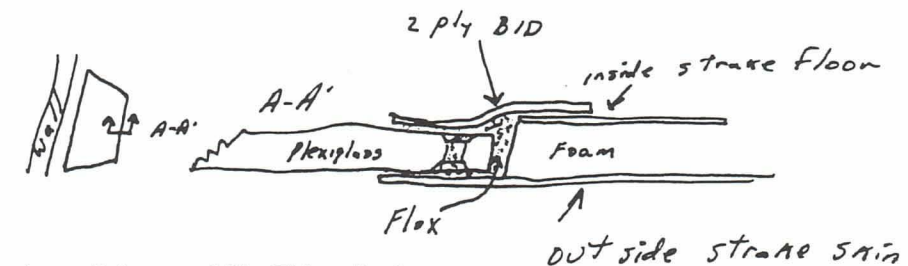


## Strake Windows

ED: - This is how I retrofitted a strake window in my finished Long-EZ without having to repaint the exterior. Burt said anything over .060" Plexiglas was strong enough, but that looked pretty wimpy to me, especially after some use and the material started to get scratched. I choose 1/8" and that has held up fine. Some folks have used 1/4" but that adds about 1 pound excess for each window. I used Lexan and found that was a mistake. It is much more expensive and scratches VERY easily. I would use Plexiglas.

Begin the project inside the strake by measuring inboard of all bulkheads, fuselage sides, leading edge curve,



etc. a distance of 2". This will allow for glass overlap on the Plexiglas and interior surface area to effect a good bond. Sit in the back seat and look through the fuselage wall cut out at the strake floor where the window will appear. Mark that area and only put Plexiglas there. It is pointless to have a huge heavy window if only luggage gets to look through it.

Drill a small hole in each proposed window corner from inside the strake

through the outside skin. Just hold the drill with your thumb and index finger and rotate. This now locates the edges of the hole through all structure. Move outside the airplane and draw a cut line from hole to hole. Cut the outer skin, the foam and inner skin out with a small blade saw like a X-acto etc. Larger teeth may delaminate the outer skin from the foam. Position the blade so cutting action pushes the skin against the foam and does not pull the skin from the foam.

Move inside the plane and remove the inside skin and foam an additional 1" all around the hole. This now gives you a cross section like A-A' above.

Cut Plexiglas to fit inside the strake opening with perhaps 1/8" clearance around for later flox fill. The Plexiglas will later sit in the hole on the "shelf" formed by the outer skin. Drill 1/4" holes through Plexiglas and countersink both sides at 2-3" intervals around the perimeter of the Plexiglas. This allows for flox to form small rivets in the Plexiglas which helps hold the Plexiglas to the skin and to the flox fill under the 2 ply BID reinforcement.

Mask Plexiglas to protect it from resin. Sand all areas to be bonded. Sand the Plexiglas area to be attached to the fiberglass. Bed the Plexiglas in flox in the strake cutout. Fill the "rivet" holes so they all bond to the flox on the outer skin "shelf". Lay up 2 ply BID at 45 degrees overlapping 1" over the Plexiglas and 1" over the inside skin. The 2 ply BID lay up is easier if you wet it out and squeegee it on a piece of Saran Wrap before putting it in the strake area. Leave the Saran in place to act as a "carrier" for the wet BID. Place the wet BID in place and remove the Saran Wrap. Peel ply and wait for partial cure. Before complete cure, remove the masking tape. Pull the tape back over the wet resin so no resin gets on Plexiglas.

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