

HANDLING, STORING, AND PROTECTION OF ALUMINUM

The material must be protected against damage. The following precautions are recommended to assure early acceptance of your products and workmanship.

A. HANDLE CAREFULLY - Don't drop from the truck. Stack with adequate separation so material will not rub together. Store off the ground. Protect against elements and other construction trades. Wear hand protection to prevent injury due to sharp edges of cut extrusions.

B. KEEP MATERIAL AWAY FROM WATER, MUD AND SPRAY - Prevent cement, plaster, or other materials from damaging the finish.

C. PROTECT THE MATERIALS AFTER ERECTION - Protect by wrapping with Kraft paper or by erecting Visqueen or canvas splatter screen. Cement, plaster, terrazzo, other alkaline solutions and acid based materials used to clean masonry are very harmful to the finish and should be removed with water and mild soap IMMEDIATELY.

GENERAL INSTALLATION NOTES

The following practices are recommended for all installations:

A. CHECK SHOP DRAWINGS, INSTALLATION INSTRUCTIONS and GLAZING INSTRUCTIONS to become thoroughly familiar with the project. The SHOP DRAWINGS take precedence and include specific details for the project. The INSTALLATION INSTRUCTIONS are of a general nature and cover most common conditions.

B. All materials are to be INSTALLED PLUMB, LEVEL, AND TRUE.

C. All work should start from bench marks and/or column lines as established by the ARCHITECTURAL DRAWINGS and the GENERAL CONTRACTOR. Check mullion spacing from both ends of the masonry opening to prevent dimensional buildup of day light opening.

D. Make certain that construction which will receive your materials is in accordance with the contract documents. If not, notify the GENERAL CONTRACTOR IN WRITING and resolve differences before proceeding with your work.

E. Isolate all aluminum to be placed directly in contact with uncured masonry or incompatible materials with a heavy coat of zinc chromate or bituminous paint.

F. Check all materials on arrival for quantity and be sure you have everything required to begin installation.

G. Sealants must be compatible with all materials with which they have contact, including other sealant surfaces. Consult with sealant manufacturer for recommendations relative to joint size, shelf life, compatibility, priming, tooling, adhesion, etc.

H. FASTENING - "Fastening" means any method of securing one part to another or to adjacent materials. These instructions specify only those fasteners used within the system. Due to varying perimeter conditions and job performance requirements, anchor fasteners are not specified in these instructions. For anchor fastening, refer to the Shop Drawings or consult the fastener supplier.

I. CHECK OPENINGS - Make certain that the opening which will receive your materials is in accordance with the contract documents. If not, notify the GENERAL CONTRACTOR IN WRITING and resolve differences before proceeding with your work.

J. BUILDING CODES - Glass and glazing codes governing the design and use of products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility for these design considerations. It is the responsibility of the owner, specifier, architect, general contractor and the installer to make these selections in strict conformance with all applicable codes.

K. EXPANSION JOINTS - Expansion joints and perimeter seals shown in these instructions and in the shop drawings are shown at normal size. Actual dimensions may vary due to perimeter conditions and /or difference in metal temperature between the time of fabrication and time of installation. For example, a 12 foot unrestrained length of aluminum extrusion can expand or contract 3/32" over a 50° F temperature change. Any movement potential should be accounted for at the time of installation.

L. FIELD TESTING - It is recommended that a Water Hose Test be conducted once a sufficient portion of the framing is installed, glazed and caulked to ensure proper installation. The Water Hose Test shall be conducted in accordance with AAMA 501.2. In addition, larger projects should have periodic Water Hose Tests as additional precautionary measures.

SILICONE GLAZING NOTE

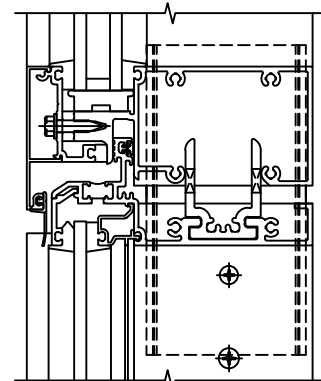
This SSG system requires structural silicone. The glazing installer is responsible for selecting and contacting the silicone manufacturer to determine which type of silicone is to be used and what samples are required to be submitted for adhesion and compatibility testing. The silicone sealant shall not be applied to Kawneer products without the approval of the silicone manufacturer and until all required testing is completed and detailed application instructions have been delivered to the installer by the silicone manufacturer. If you find that silicone manufacturer's installation instructions are not in accordance with Kawneer's installation instructions, it is your responsibility to notify Kawneer of the conflict **prior to glazing**.

Your glass supplier must be made aware that their glass will be used in an SSG application. The application must be approved by the glass supplier **prior to glazing**.

For any structural silicone glazed product application that is not shown in Kawneer's standard literature, the application must be approved.

Vertical mullion splice - Vertical mullions that are structurally glazed must be spliced at a horizontal.

Typical splice location, vision over spandrel horizontal



1600 SS SSG PRE-GLAZED NOTES

1600 SS SSG is available with 1" framing members which accept both 1" and 1/4" infill.

Note: When 1600 SS SSG has Versoleil Outrigger Application glass bite is 3/4" at SSG verticals and 1/2" at captured verticals (jambs) and horizontals. Glass sizes must be calculated from approved shop drawings.

Glass bite is 1" at SSG verticals and 1/2" at captured verticals and horizontals. Glass sizes must be calculated from approved shop drawings. Note special glass size formula at infill below an expansion horizontal.

Unless otherwise specified, it is recommended that silicone sealant be used for all internal seals.

Sealant must be applied per the sealant manufacturer's recommendations and pass all adhesion and compatibility testing. At all joint seals, sealant must adhere to metal, gaskets, thermal separator and joint plug materials. Clean all surfaces prior to application of sealant and prime where necessary to achieve proper adhesion.

If units are to be installed below a head building condition, adequate space must be allowed for unit installation. Unit must be lifted over the lower unit expansion horizontal. Additional space may be required for the hoisting apparatus. Where head anchor clips are installed in the top of the mullions, top lites of glass may need to be field glazed to allow the units to be hoisted.

Perimeter joints at the elevation jambs must be a minimum of 3/4" to allow adequate space for the installation of the jamb patch at expansion horizontals.

CHECK OPENINGS

Elevations and slabs must be within adjustment of anchoring system. See approved shop drawings for allowable adjustment.

Anchoring surfaces of perimeter construction must be level and plumb within the adjustment limits of the head, sill and jamb. See approved shop drawings for allowable adjustment.

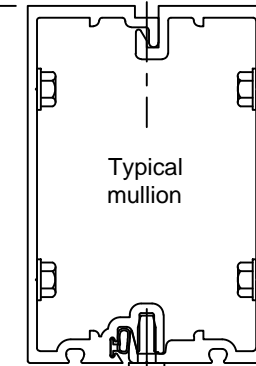
LAYOUT ANCHOR AND MULLIONS CENTERLINES

Use wall lines established by the general contractor. On each floor lay out a reference line to establish in and out wall locations.

Use column center lines established by the general contractor. On each floor lay out mullion center lines and anchor center lines.

Exterior face of beam or floor slab
Varies with job conditions

C/L of mullion ± 1/32"



See approved shop drawings for anchor lay outs. These instructions show the 6" system. The 7 1/2" system is similar.

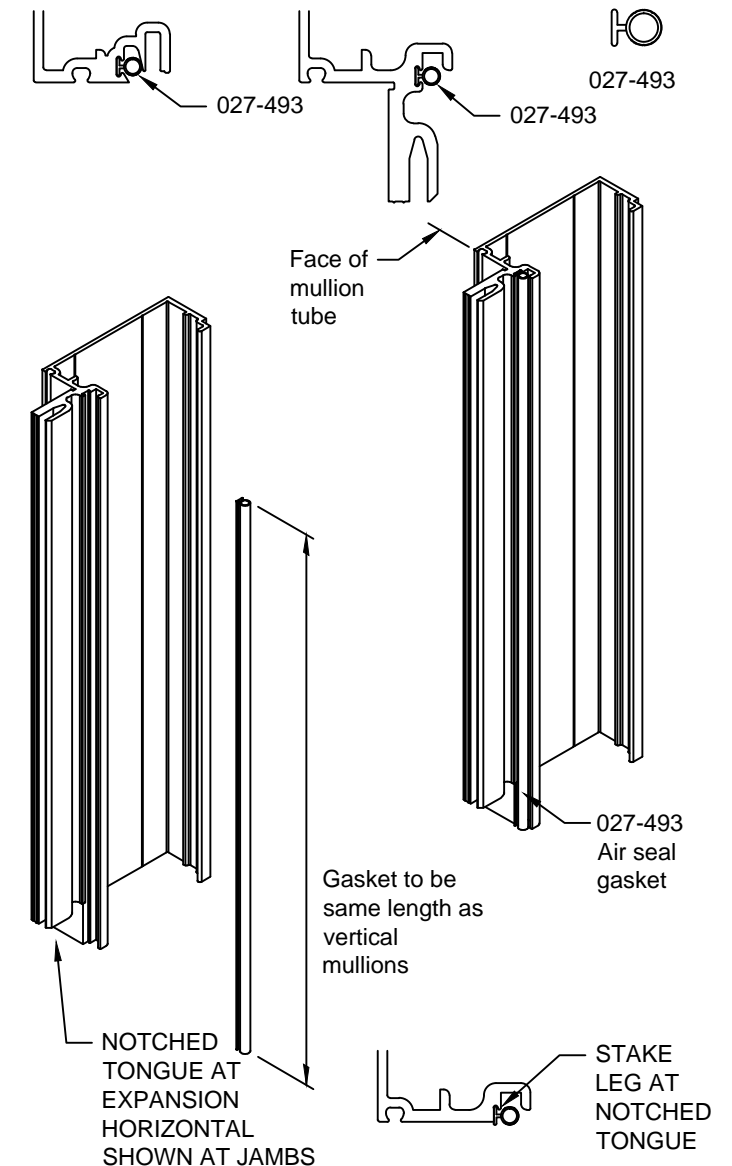
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INSTALL 027-493 VERTICAL AIR SEAL

Install 027-493 air seal into reglet of mullion full length as shown. Spray water on gasket and pull plastic base with pliers to facilitate installation at SSG mullions. Stake into reglet after the gasket is centered in the correct position.

AIR SEAL IS REQUIRED AT ALL CAPTURED AND SSG MULLIONS



1600 SS SSG
PRE-GLAZED
INSTALLATION
INSTRUCTIONS

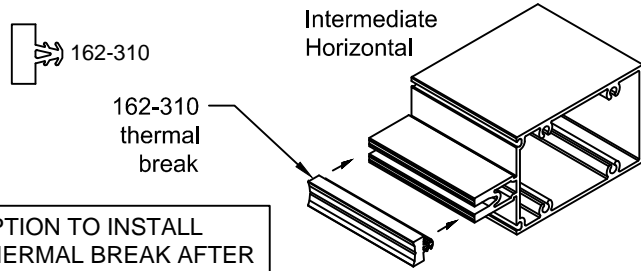
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05/18/12

INSTALL 162-310 THERMAL BREAK AT HORIZONTALS

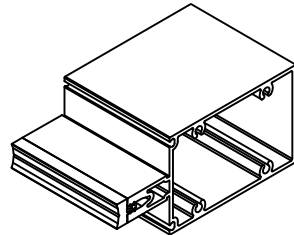
DO NOT STRETCH WHEN REMOVING FROM COIL, CARTON AND DURING INSTALLATION

Do not install thermal break into captured verticals at this time.

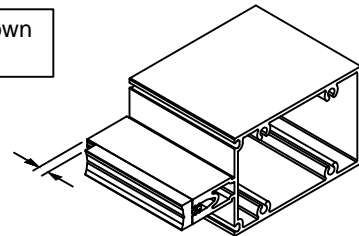


OPTION TO INSTALL THERMAL BREAK AFTER VERTICALS AND HORIZONTALS ARE ASSEMBLED

NOTE: Thermal break to be the same length as the horizontal at SSG verticals



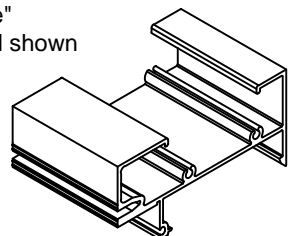
Intermediate horizontals shown Unit sill horizontals similar



Thermal break to be 1/4" short at each end of horizontals

Do not install thermal break into captured verticals or "perimeter type" head and sill horizontals at this time.

"Perimeter type" head horizontal shown

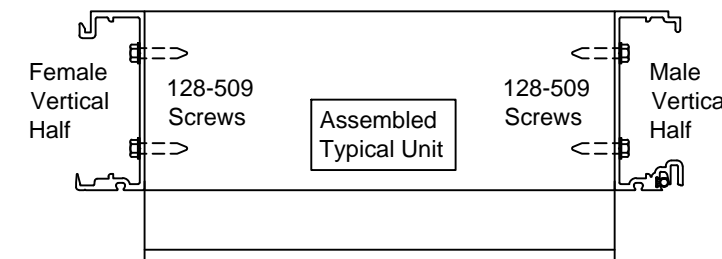
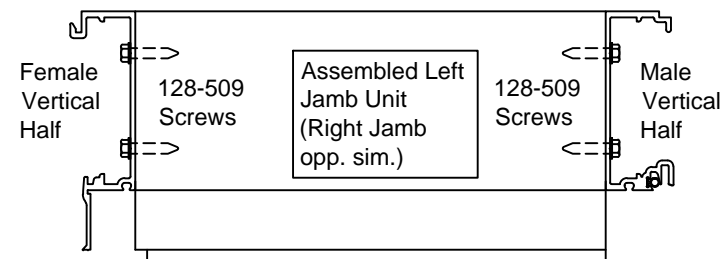
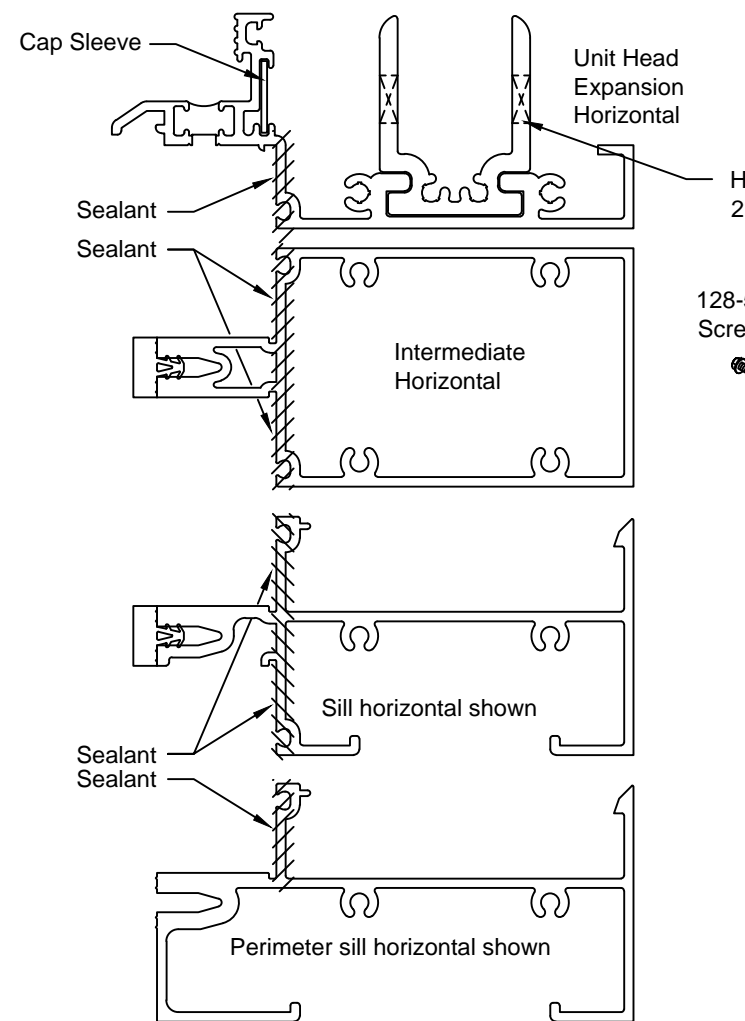


Thermal break to be installed at the same time as joint plugs. The thermal separator will hold joint plugs in place.

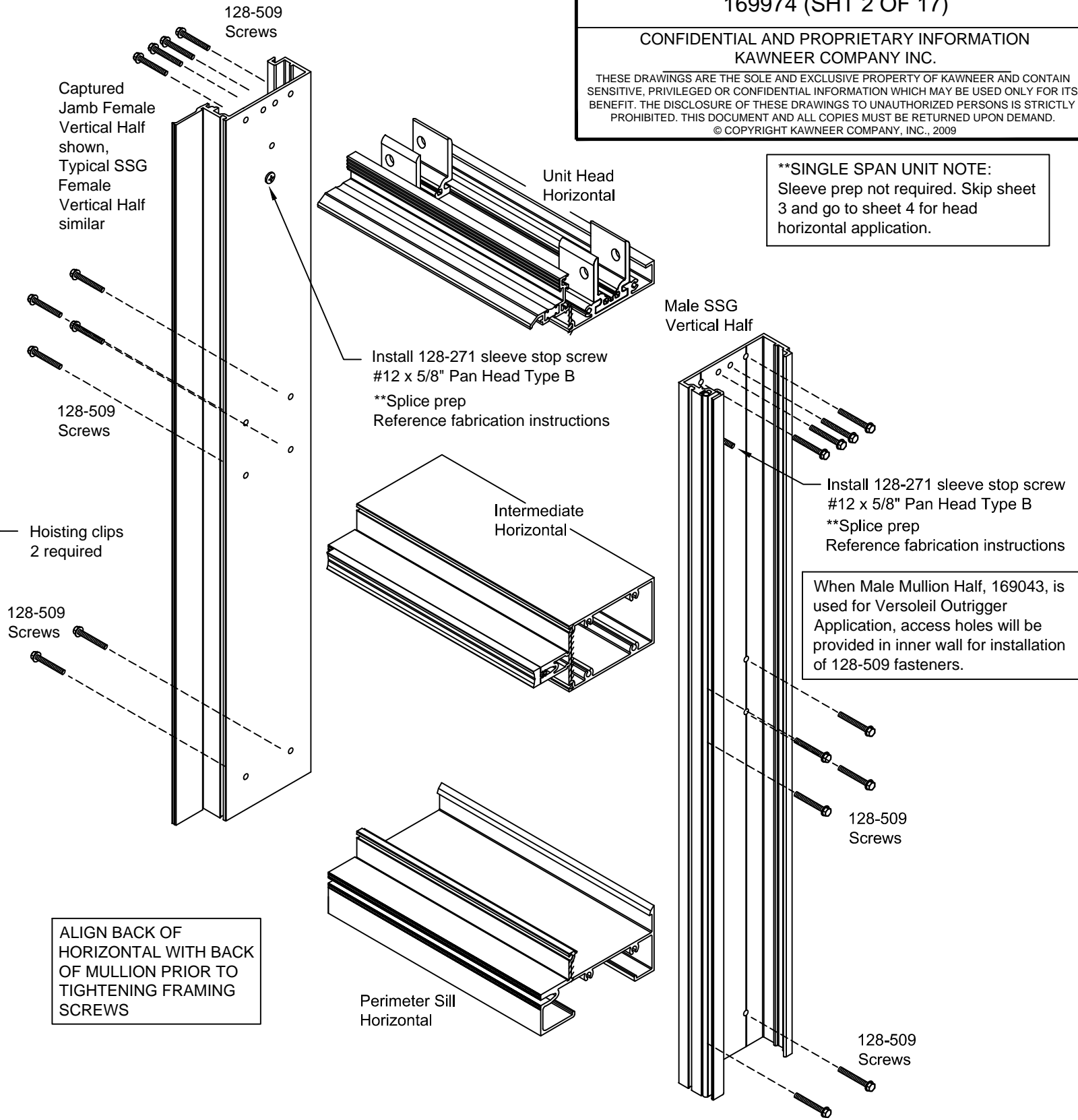
FRAME ASSEMBLY - Bottom Units

- Insert unit hoisting clip in each end of unit head expansion horizontal. Holes in clip are to be towards the end of the horizontal.
- Install 169-222 cap sleeve into right side of all unit head horizontals. Also install a cap sleeve in the left side for a units beginning a run at each level. Tape sleeve in position.
- Install stop screws as noted.
- Assemble verticals to horizontals using 128-509 #12 x 1" Hex Washer Head Type AB. Applying wax to the screw threads will help ease screw installation.
- Frame is shown in the upright position, but may be assembled in any desirable position.
- For both horizontal ends apply sealant as shown below and tool sealant after assembly.

NOTE: Face sealing joints at all 4 corners may be done in lieu of sealing horizontal ends prior to installing glazing gaskets. Refer to page 5 of the installation instructions.



ALIGN BACK OF HORIZONTAL WITH BACK OF MULLION PRIOR TO TIGHTENING FRAMING SCREWS



****SINGLE SPAN UNIT NOTE:**
Sleeve prep not required. Skip sheet 3 and go to sheet 4 for head horizontal application.

When Male Mullion Half, 169043, is used for Versoleil Outrigger Application, access holes will be provided in inner wall for installation of 128-509 fasteners.

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FRAME ASSEMBLY - Intermediate Units

Insert unit hoisting clip in each end of unit head expansion horizontal. Holes in clip are to be towards the end of the horizontal. Install 169-222 cap sleeve into right side of all unit head horizontals. Also install a cap sleeve in the left side for a units beginning a run at each level. Tape sleeve in position.

Install stop screw at mullion top and splice sleeve at mullion bottom as noted.

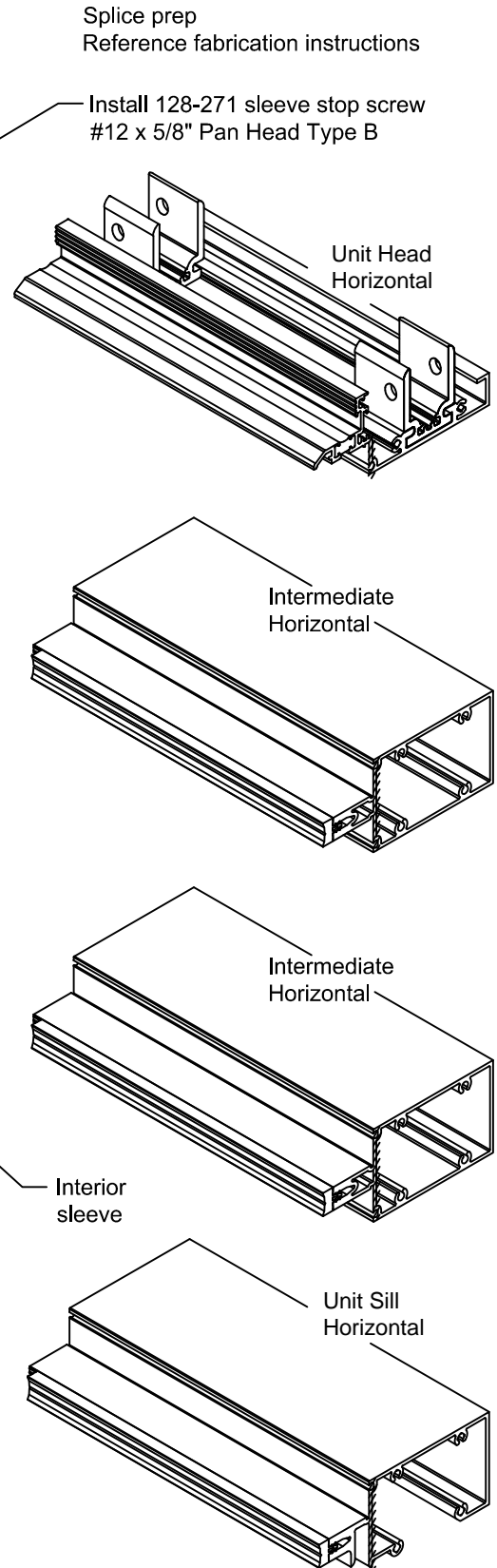
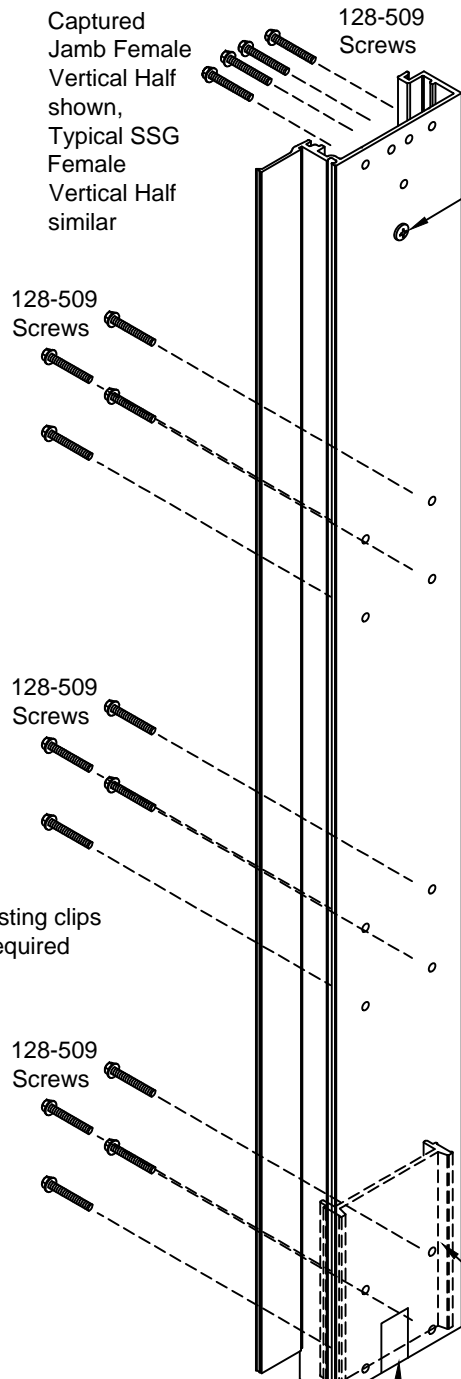
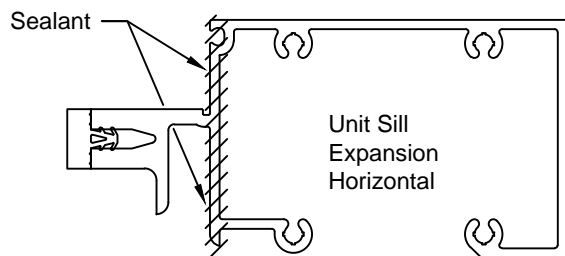
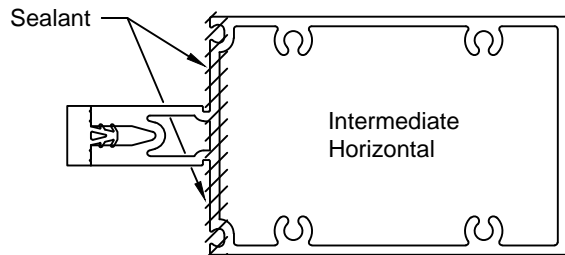
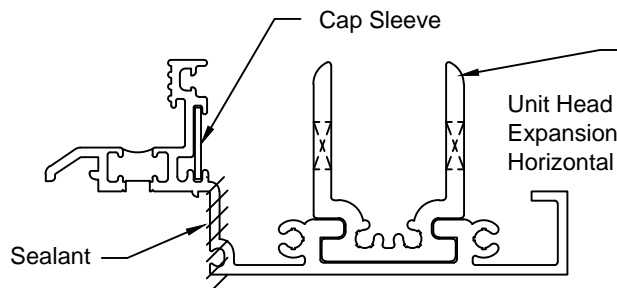
Assemble verticals to horizontals using 128-509 #12 x 1" Hex Washer Head Type AB. Applying wax to the screw threads will help ease screw installation.

Frame is shown in the upright position, but may be assembled in any desirable position.

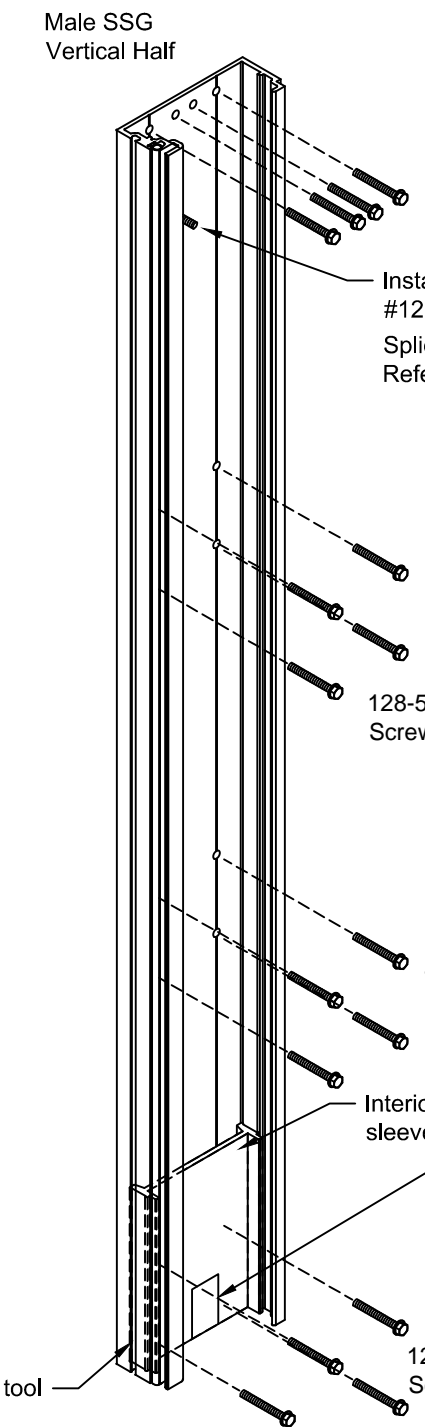
For both horizontal ends apply sealant as shown below and tool sealant after assembly.

NOTE: Face sealing joints at all 4 corners may be done in lieu of sealing horizontal ends prior to installing glazing gaskets. Refer to page 5 of the installation instructions.

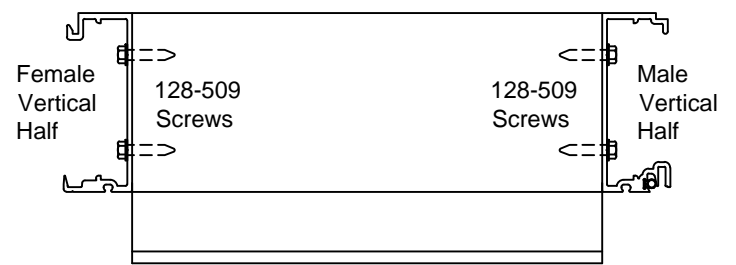
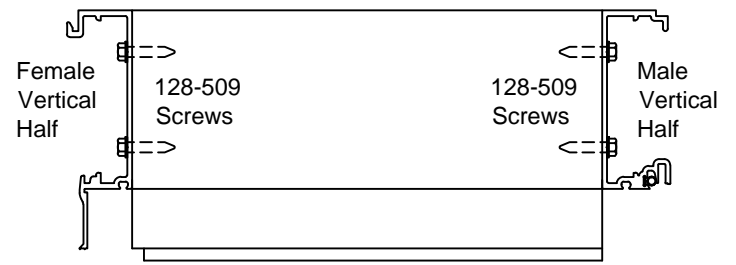
At bottom of mullions, fill gasket reglets from bottom of mullions up 2" and tool flat with face of mullion.



ALIGN BACK OF HORIZONTAL WITH BACK OF MULLION PRIOR TO TIGHTENING FRAMING SCREWS



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Note: When Male Mullion Half, 169043, is used for Versoleil Outrigger Application, access holes will be provided in inner wall for installation of 128-509 fasteners.
 When Male Mullion Half, 169043, is used; Interior Sleeve, 494393, must be used.

Tape sleeves into the bottom of the top mullion half. Apply after installation of horizontal.

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FRAME ASSEMBLY - Top Units

Assemble verticals to horizontals using 128-509 #12 x 1" Hex Washer Head Type AB. Applying wax to the screw threads will help ease screw installation.

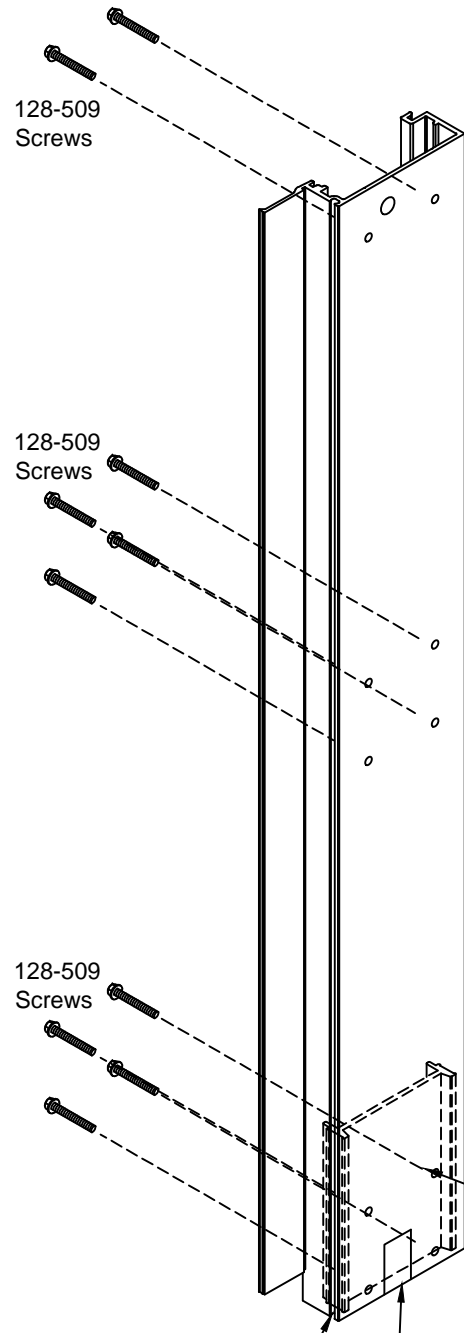
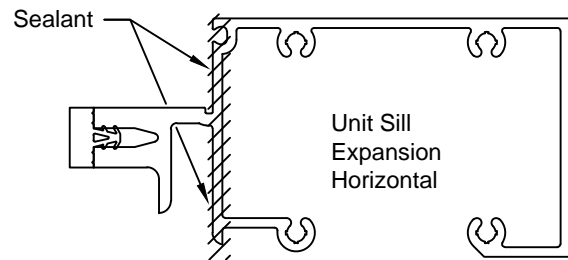
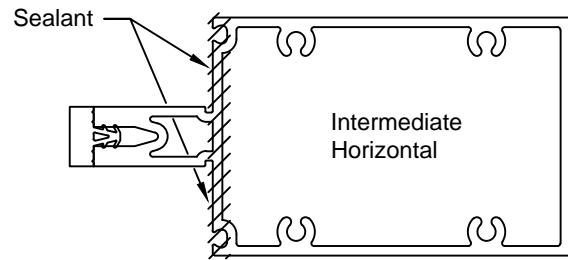
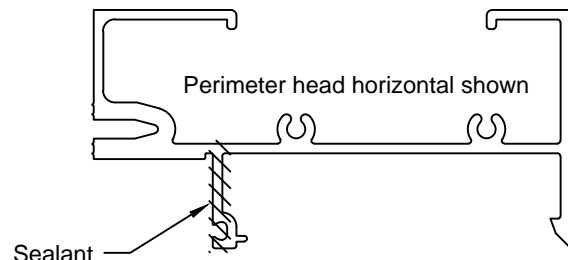
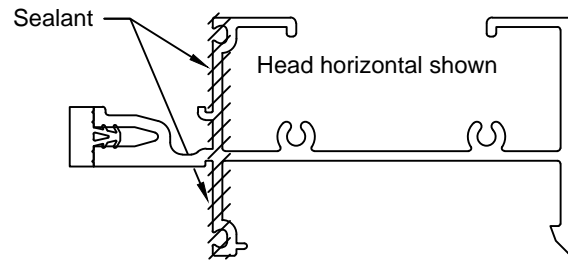
Frame is shown in the upright position, but may be assembled in any desirable position.

For both horizontal ends apply sealant as shown below and tool sealant after assembly.

NOTE: Face sealing joints at all 4 corners may be done in lieu of sealing horizontal ends prior to installing glazing gaskets. Refer to page 5 of the installation instructions.

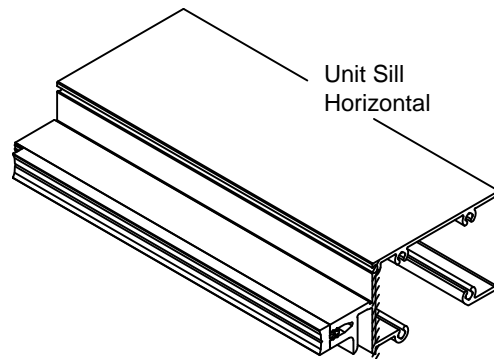
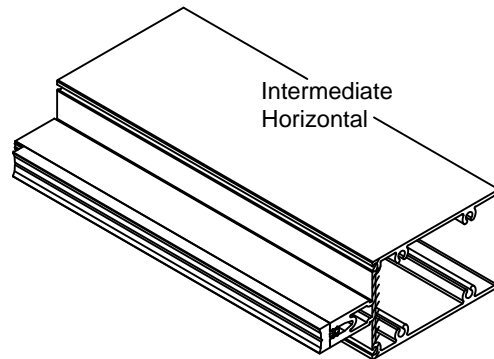
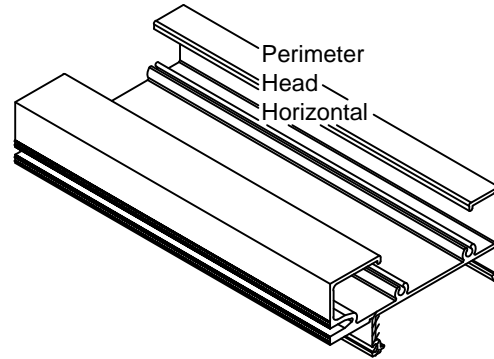
Install splice sleeve at mullion bottom as noted.

At bottom of mullions, fill gasket reglets from bottom of mullions up 2" and tool flat with face of mullion.



Captured Jamb Female Vertical Half shown, Typical SSG Female Vertical Half similar

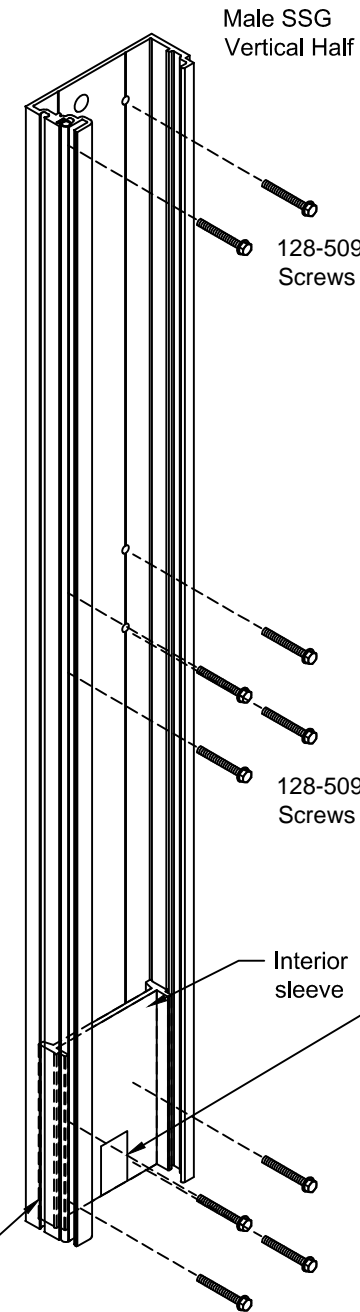
ALIGN BACK OF HORIZONTAL WITH BACK OF MULLION PRIOR TO TIGHTENING FRAMING SCREWS



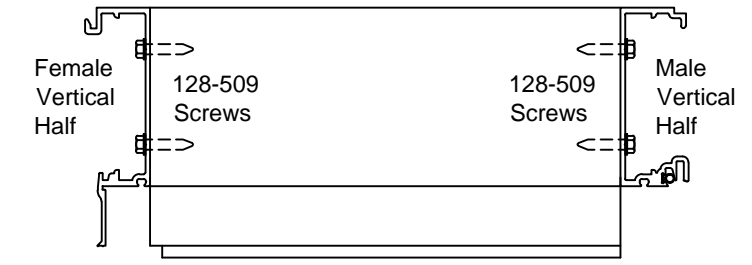
Seal reglet 2" and tool flush

Tape sleeves into the bottom of the top mullion half. Apply after installation of horizontal.

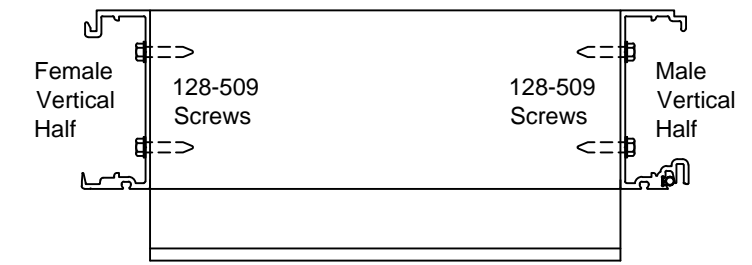
Seal reglet 2" and tool flush



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Assembled Left Jamb Unit (Right Jamb opp. sim.)



Assembled Typical Unit

Note: When Male Mullion Half, 169043, is used for Versoleil Outrigger Application, access holes will be provided in inner wall for installation of 128-509 fasteners.
When Male Mullion Half, 169043, is used; Interior Sleeve, 494393, must be used.

Tape sleeves into the bottom of the top mullion half. Apply after installation of horizontal.

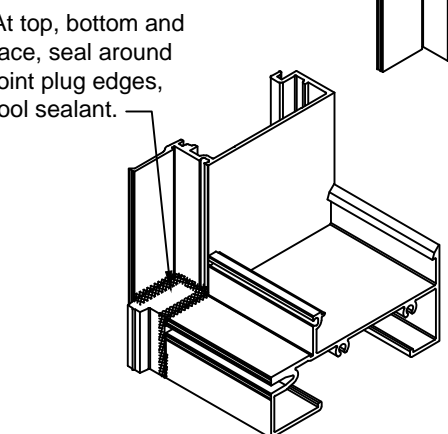
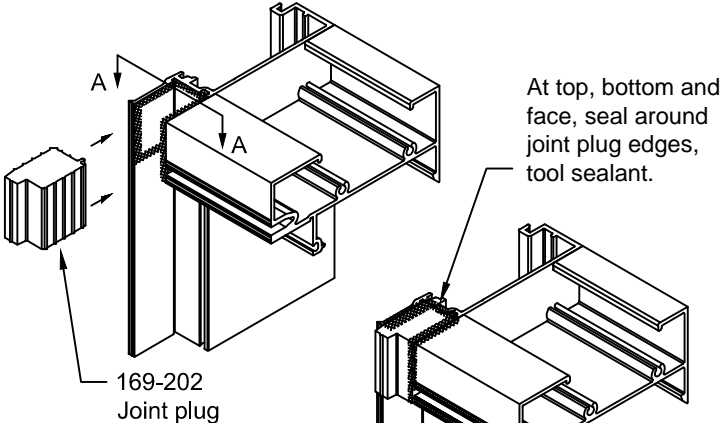
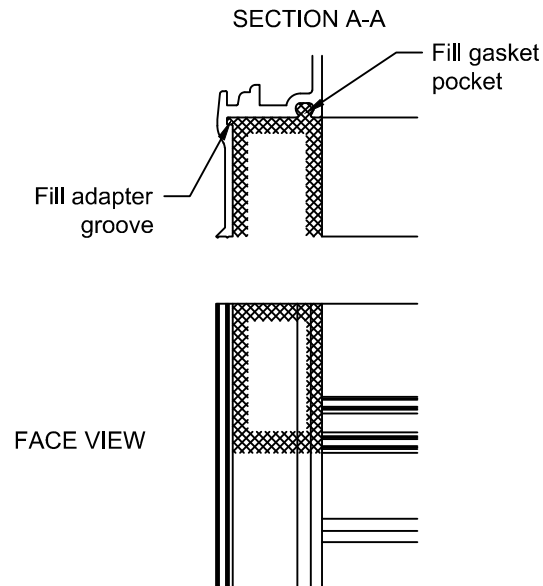
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INSTALL "PERIMETER TYPE" HORIZONTAL HEAD AND SILL JOINT PLUGS AT CAPTURED VERTICALS

All surfaces and grooves must be cleaned per the sealant manufacturer's recommendations.

Just before installing joint plugs apply sealant as shown filling gasket pocket and adapter groove.

Joint plugs for SSG verticals must be applied after unit installation.

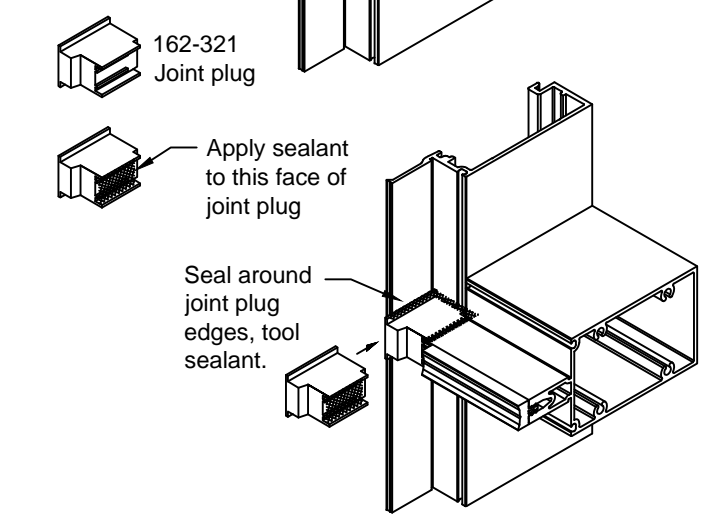
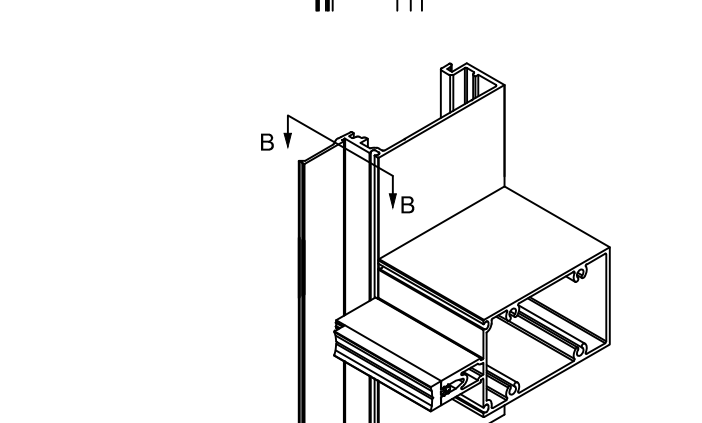
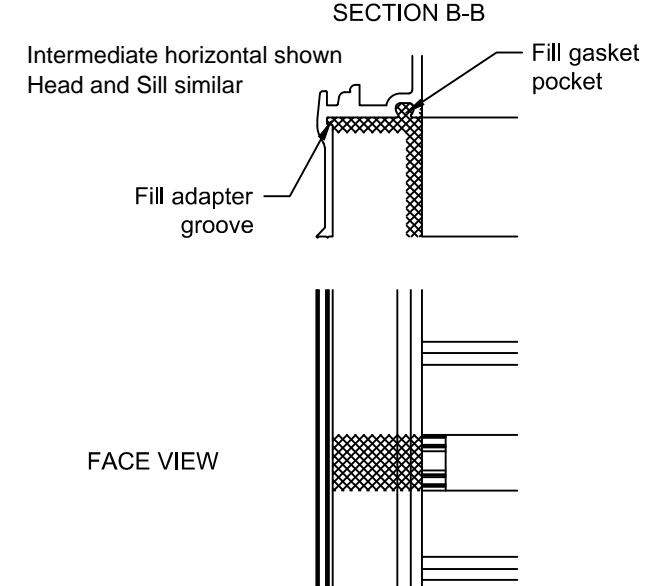


INSTALL HEAD, SILL AND INTERMEDIATE JOINT PLUGS AT CAPTURED VERTICALS

All surfaces and grooves must be cleaned per the sealant manufacturer's recommendations.

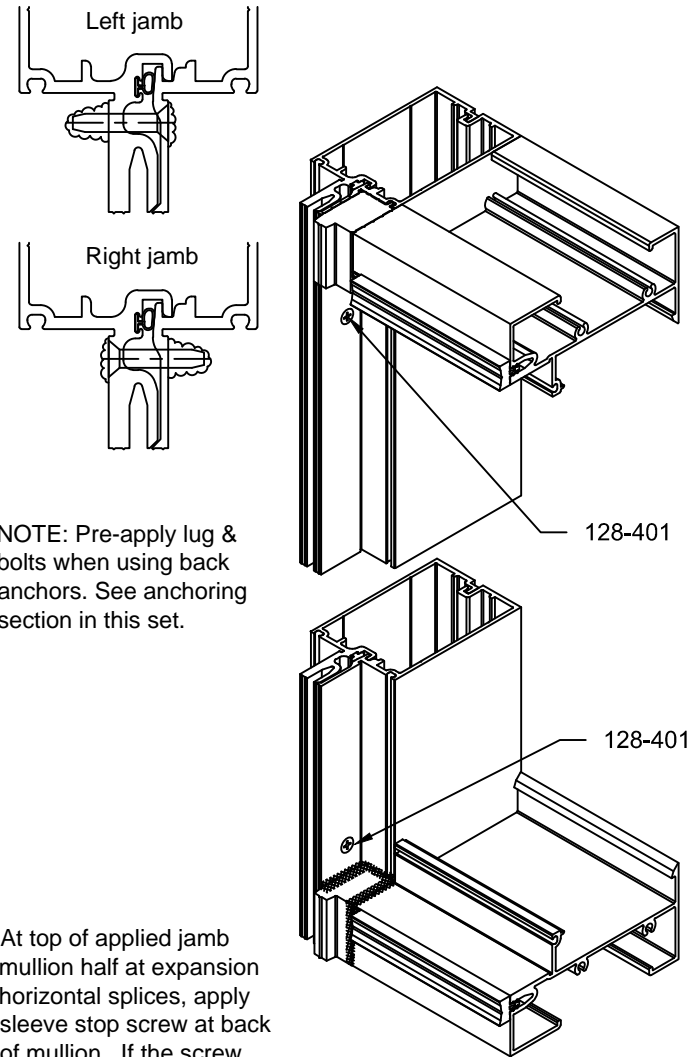
Just before installing joint plugs apply sealant as shown filling gasket pocket and adapter groove.

Joint plugs for SSG verticals must be applied after unit installation.



JAMB UNITS

At jamb units, mate male and female mullions together. Match drill .154 dia. holes (#23 drill) and fix with 128-401 # 10 x 1" flat head fasteners. Fastener locations are 4" from each end and 48" on center. Seal over fastener head and fastener shaft on both sides of the tongue. Tool sealant.



At top of applied jamb mullion half at expansion horizontal splices, apply sleeve stop screw at back of mullion. If the screw head prevents the frame from laying flat during glazing, leave this step for later. Install splice sleeves and seal at mullion face at bottom. Reference previous instruction for additional information similar.

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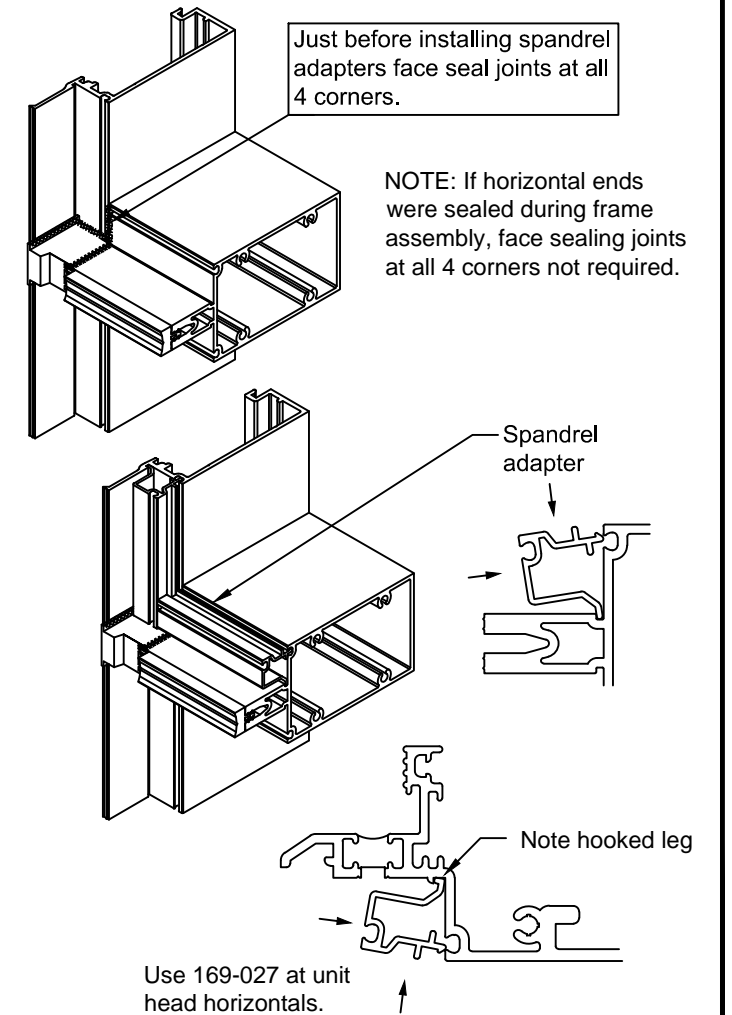
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INSTALL SPANDREL ADAPTERS WHERE APPLICABLE AT CAPTURED VERTICALS AND HORIZONTALS

All surfaces and grooves must be cleaned per the sealant manufacturer's recommendations.

Do not install perimeter fillers at this time. Perimeter fillers must be installed in the field.

NOTE: Adapters are typically centered on DLO. Vertical adapter above a expansion horizontal extends only 7/16" into glazing pocket to clear expansion joint plug application that is installed in the field.



1600 SS SSG
PRE-GLAZED
INSTALLATION
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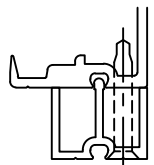
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INSTALL SPANDREL ADAPTERS WHERE APPLICABLE AT SSG VERTICALS

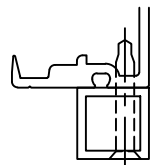
All surfaces and grooves must be cleaned per the sealant manufacturer's recommendations.

NOTE: IF HORIZONTAL ENDS WERE SEALED DURING FRAME ASSEMBLY, FACE SEALING JOINTS AT ALL 4 CORNERS NOT REQUIRED.

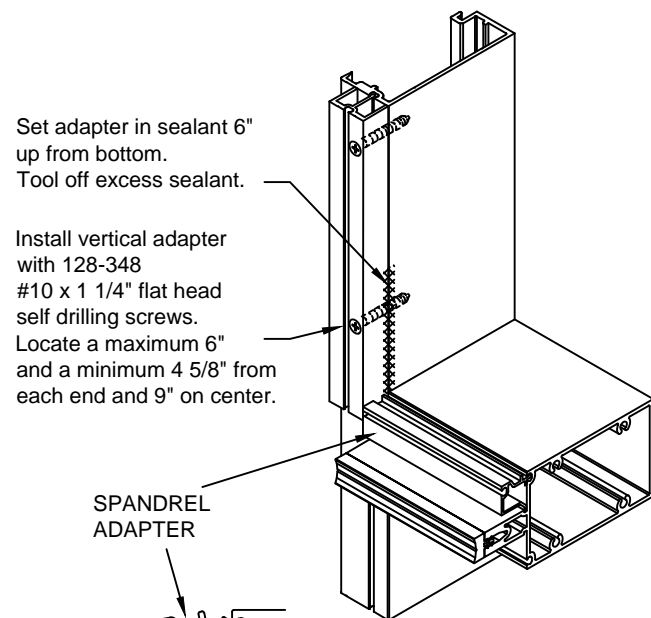
Just before installing spandrel adapters face seal joints at all 4 corners. See previous step.



Standard Adapter Application



494022 Adapter for Versoleil Application



SPANDREL ADAPTER

Seal the bottom adapter continuous

Seal all 4 spandrel adapter corners

INSTALL INTERIOR GLAZING GASKETS

Prior to installing gaskets, make sure all gasket grooves and pockets should be clean.

Gaskets can become deformed during storage in cartons. They should be removed from cartons several hours prior to installation and laid flat or hung to allow recovery of correct shape. Temperatures should be at least 50° F to allow this.

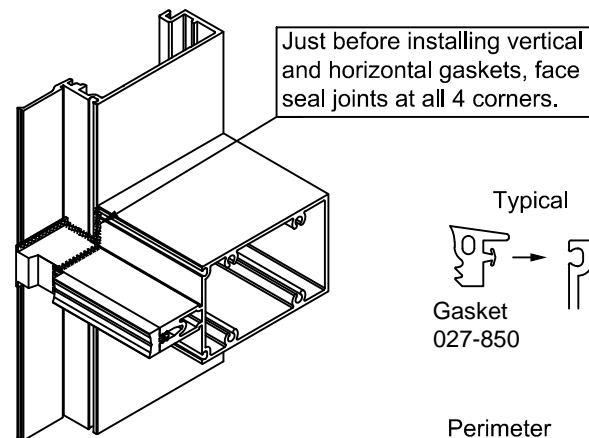
Gasket installed length to be daylight opening. Gaskets to be cut long for some "crowd in". Gaskets should never be "stretched to fit".

"Crowd in" to be 1/8" per foot up to 5'-0", 3/16" per foot up to 8'-0", 1/4" per foot over 8'-0".

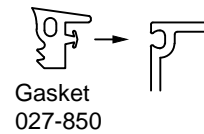
NOTE: In temperatures colder than 50° f, gaskets should be warmed and installed just prior to glazing. This will prevent excessive glazing pressure on the glass due to cold, stiff rubber gaskets.

NOTE: If horizontal ends were sealed during frame assembly, face sealing joints at all 4 corners not required.

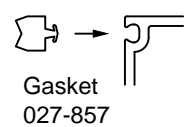
CAPTURED VERTICALS



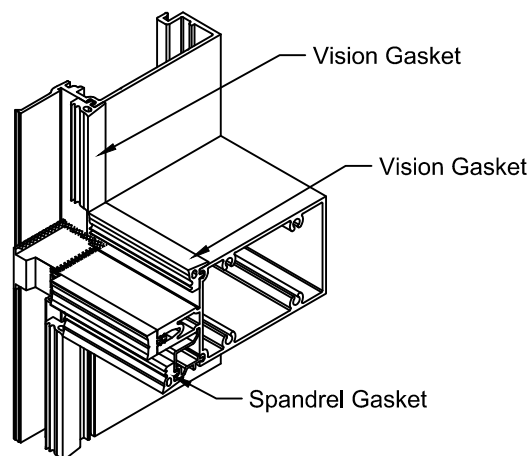
Typical



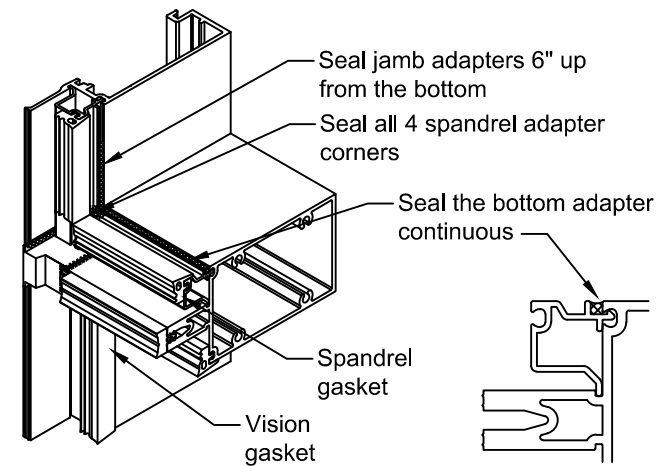
Perimeter Where applicable



Install perimeter gasket where applicable. Reference shop drawings. At jambs at expansion horizontals, stop gasket short 2" at bottom of unit. Top of gasket is flush with top of mullion and flush with bottom of mullion at the elevation sill.



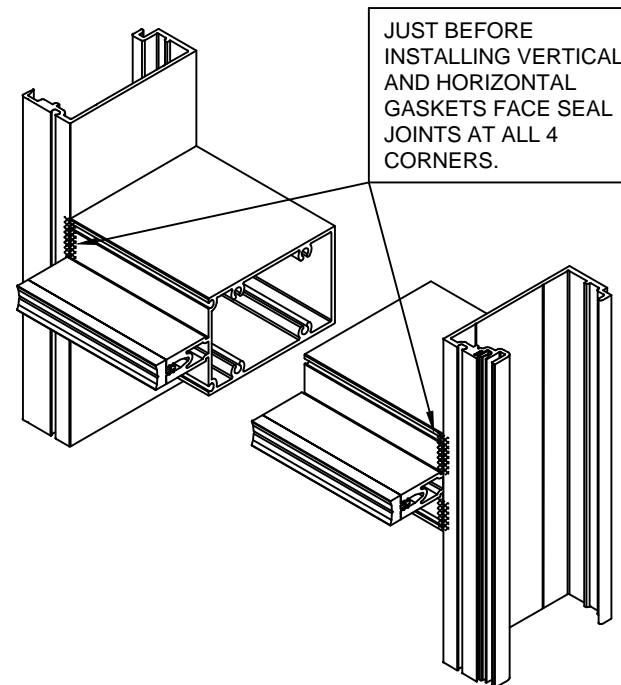
INSTALL INTERIOR GLAZING GASKETS



STRUCTURAL GLAZED VERTICALS

All surfaces and grooves must be cleaned per the sealant manufacturer's recommendations.

NOTE: If horizontal ends were sealed during frame assembly, face sealing joints at all 4 corners not required.

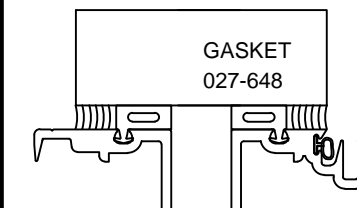


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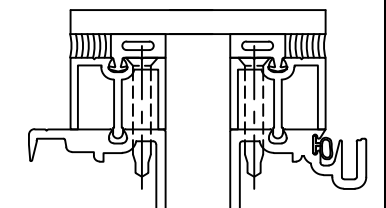
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INSTALL INTERIOR GLAZING GASKETS

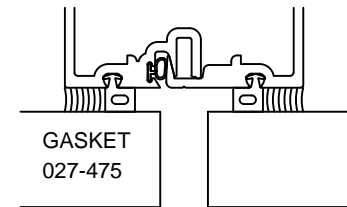
VERTICAL GASKETS TO RUN DAYLIGHT OPENING PLUS 7/8"



1" INFILL STRUCTURAL SEAL

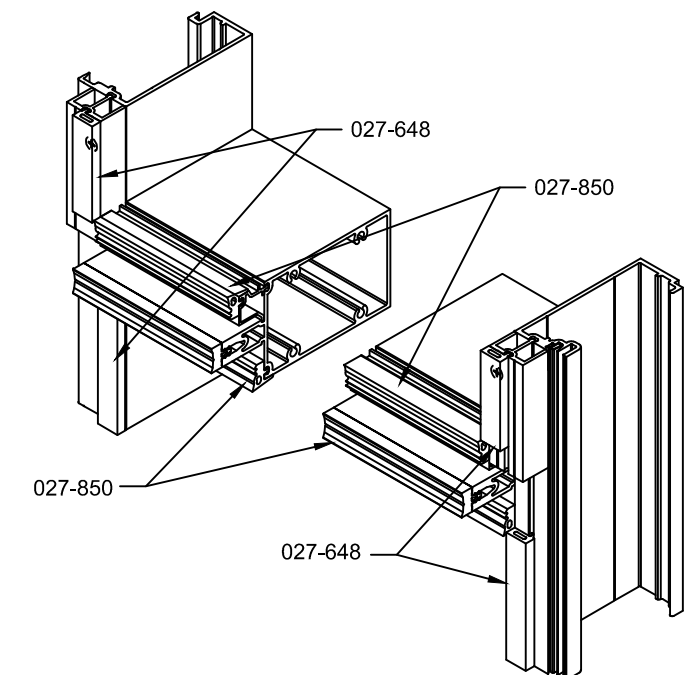


1/4" INFILL STRUCTURAL SEAL



FIELD RE-GLAZING SEAL FROM INTERIOR

For Versoleil Outrigger Application refer to Approved Shop Drawings and Versoleil Outrigger Installation Instructions, 494974, for correct Gaskets and Structural Seals.

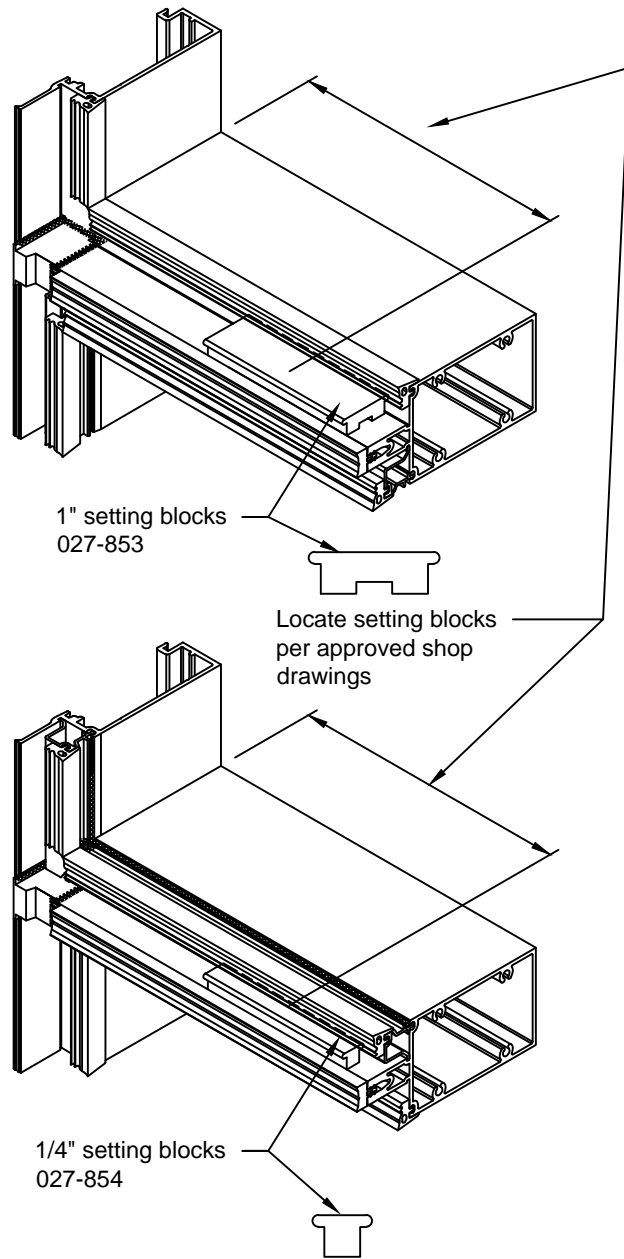


1600 SS SSG PRE-GLAZED INSTALLATION INSTRUCTIONS

Product Engineering & Development

95505-17
05/18/12

INSTALL SETTING BLOCKS



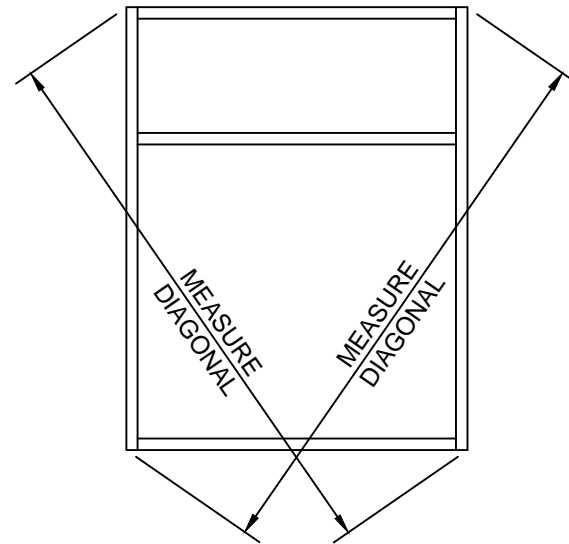
INSTALL GLASS

LAY THE UNIT ON A FLAT SURFACE WITH THE EXTERIOR FACING UP. TABLE MUST BE FLAT AND MUST SUPPORT FRAME AT ALL LOCATIONS.

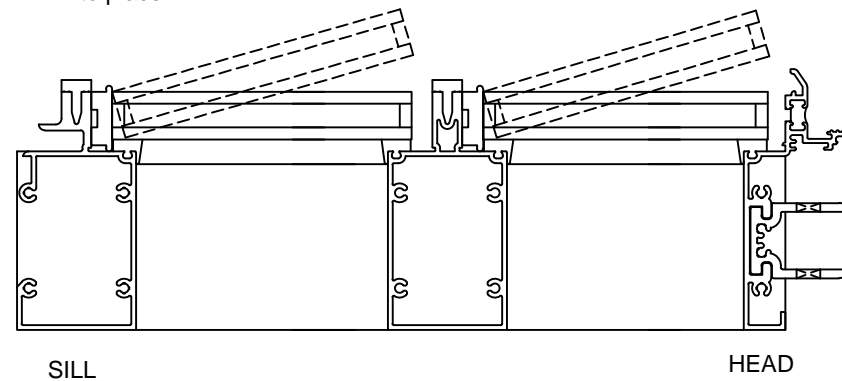
CRITICAL:

SECURE FRAME. CHECK SQUARENESS OF FRAME BY MEASURING DIAGONALS. THE MAXIMUM DIFFERENCE BETWEEN DIAGONALS IS 1/16". SIGHT DOWN MULLIONS TO MAKE SURE UNIT IS NOT BOWED OR DEFLECTED.

A UNIT GLAZED IN A "OUT OF SQUARE", DEFLECTED OR BOWED POSITION WILL CAUSE INSTALLATION PROBLEMS.



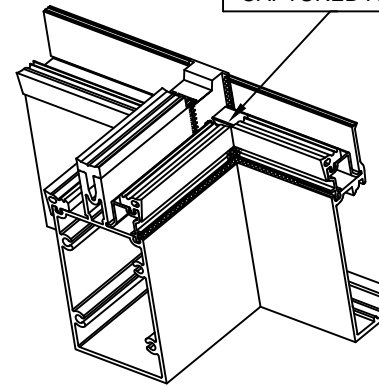
Install glass by pushing bottom edge against both setting blocks and lower into place.



Reference shop details and glazing details for non-typical conditions.

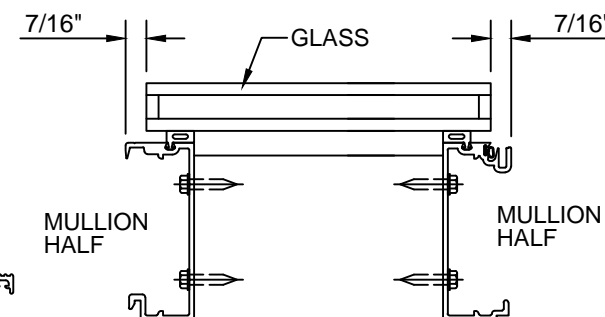
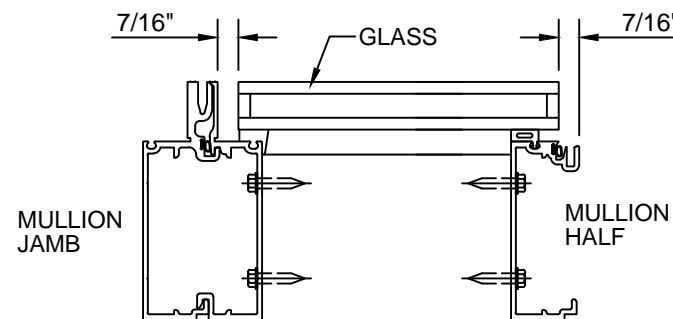
NOTE: If a tongue adapter is required at a SSG mullion, glass will have to be field installed. See sheet 10.

JUST BEFORE INSTALLING GLASS, SEAL ALL (4) GASKET CORNERS AT CAPTURED AND SSG VERTICALS.



NOTE: After glass is set, tool sealant around glass edge at expansion joint plug locations. Sealant may interfere with plug installation in field.

Line up glass as shown below. Locate glass widthwise.



For Versoleil Outrigger Application refer to Approved Shop Drawings and Versoleil Outrigger Installation Instructions, 494974, for correct Gaskets and Structural Seals.

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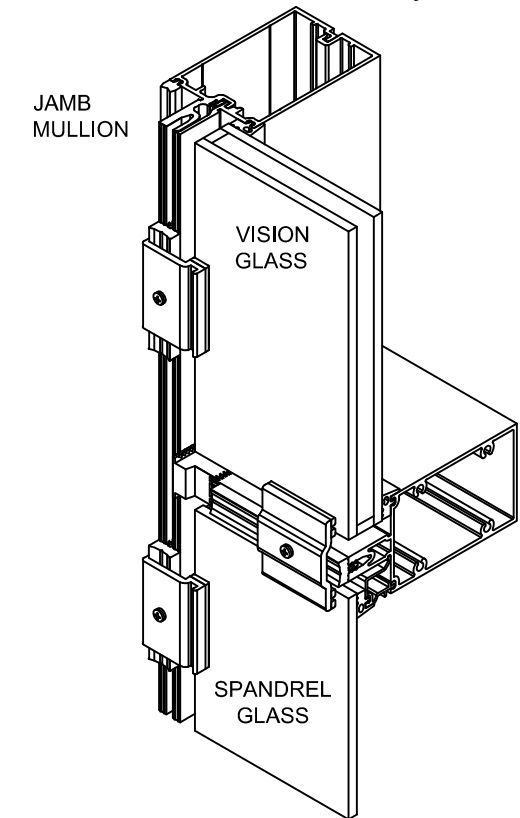
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APPLY GLASS TEMPORARIES - CAPTURED VERTICALS AND HORIZONTALS

Install short pieces of thermal separator 162-310 in jamb mullion assembly tongue. Use 162-350 glazing temporaries at vertical jambs and unit sill as required. Use 128-406 screws.



Use 162-353 glazing temporaries at intermediate horizontals as required. Use 128-406 screws.



MAXIMUM TEMPORARY SPACING IS 30". AFTER UNIT INSTALLATION, IF WINDS GREATER THAN 50 MPH (80KPH) ARE EXPECTED, ADDITIONAL TEMPORARIES MAY BE REQUIRED. CONSULT YOUR SEALANT AND/OR INFILL SUPPLIER FOR SPACING RECOMMENDATIONS. INSTALL PRESSURE PLATES WHERE POSSIBLE.



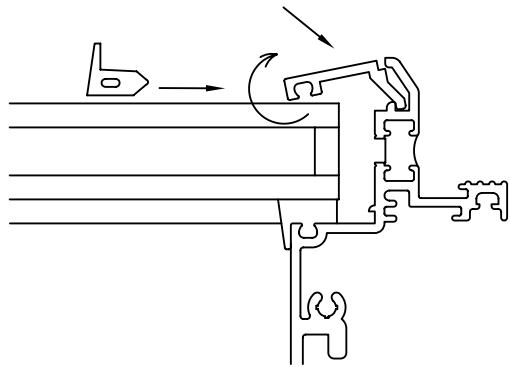
1600 SS SSG
PRE-GLAZED
INSTALLATION
INSTRUCTIONS

Product Engineering & Development

95505-17
05/18/12

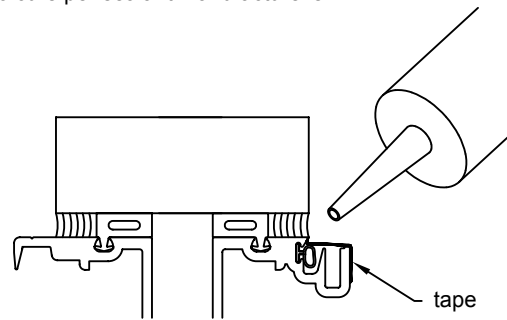
INSTALL GLASS RETAINER - UNIT HEAD HORIZONTAL

Install glass temps first to secure glass position. At the unit head horizontal, insert leg of glass retainer into horizontal. Rotate glass retainer into place. Align retainer with ends of head horizontal. At captured jambs, the retainer starts 3/8" from end of horizontal. Apply a few 1" long pieces of 027-851 wedge gasket between glass and retainer to temp part in place. Apply 027-851 wedge gasket full length of glass retainer.



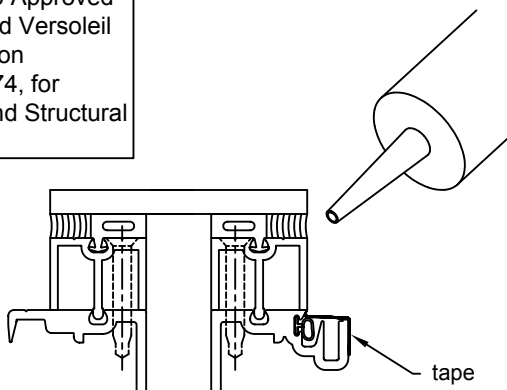
INSTALL STRUCTURAL SEALS

Kawneer does not supply sealant. Sealant to be silicone as recommended by the sealant manufacturer. Infill and metal to be cleaned per the sealant manufacturer's recommendations. Tape over gasket and engagement pockets for easy clean-up after tooling. Apply structural seal as shown. Tool sealant. Allow structural seal to cure per sealant manufacturer's recommendations.



1" INFILL STRUCTURAL SEAL

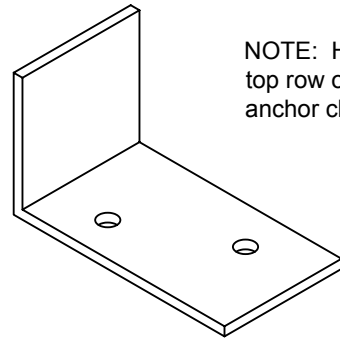
For Versoleil Outrigger Application refer to Approved Shop Drawings and Versoleil Outrigger Installation Instructions, 494974, for correct Gaskets and Structural Seals.



1/4" INFILL STRUCTURAL SEAL

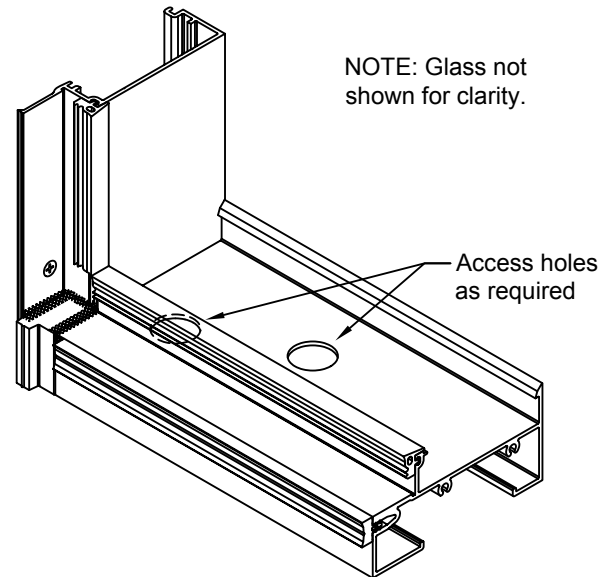
ANCHORING OPTIONS

Where aluminum angle head and sill anchors are required, prep for perimeter fasteners per approved shop drawings.



NOTE: Hoisting hole in top of mullion at top row of units can not be used with anchor clips in place.

NOTE: Head and sill horizontals will require access holes to install perimeter fasteners.



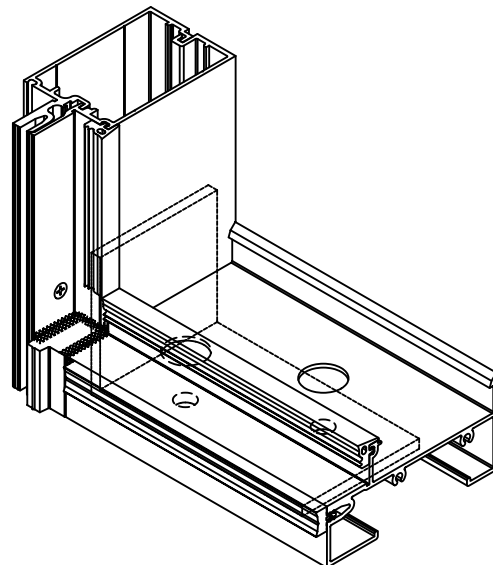
NOTE: Glass not shown for clarity.

INSTALL UNITS AT 1ST LEVEL

Install assembled frames according to erection drawings.

Install anchors into top and bottom of mullions as shown below.

Bring first unit into place and measure opening to make sure you will have a minimum of 1/2" shim space at terminating jamb before anchoring.



INSTALL UNITS AT 1ST LEVEL

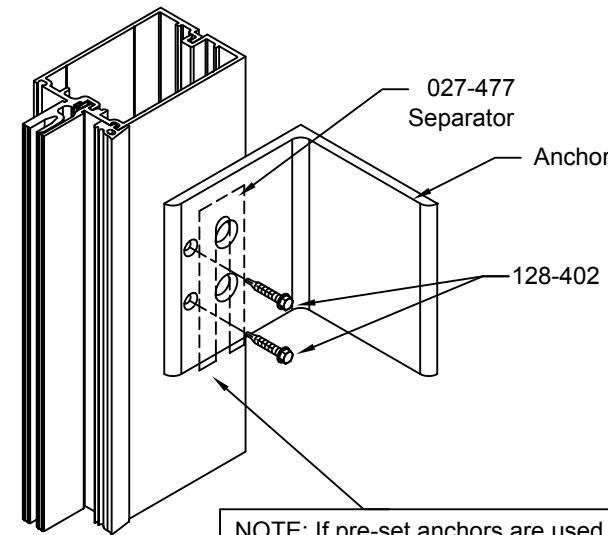
Reference approved shop drawings for anchoring.

All steel anchors must be separated from aluminum mullions. Use 027-477 separators.

Units must be installed level, plumb and square. Use hole in hoist clip that is closest to the glass for lifting units.

Shim unit at sill, secure frame with clamps and apply two 128-402 1/4-14 x 1" HWHSD to temporarily fix frame in place. Install next frame prior to match drilling mullion and applying thru bolts.

Note: Temporary fasteners must be removed after thru bolting mullions at all wind load anchors.

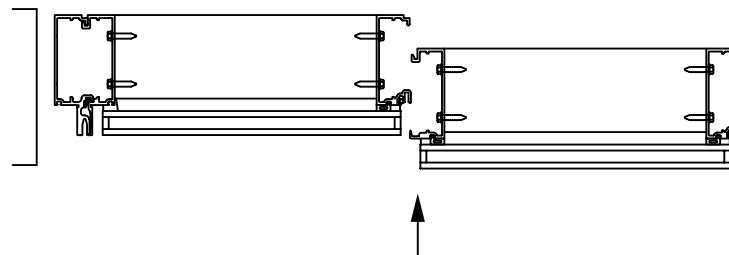


NOTE: Glass not shown for clarity.

NOTE: If pre-set anchors are used, allow for an additional 1/8" between anchors at this side for unit frame installation. Shim as required.

Install the next unit into place per approved shop drawings. Straps applied to units for hoisting should not interfere with mullion engagement.

NOTE: Check overall frame dimensions about every five units on long runs to avoid dimensional build-up.



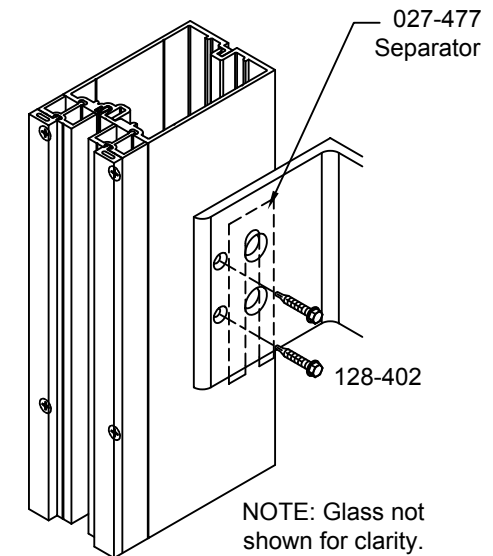
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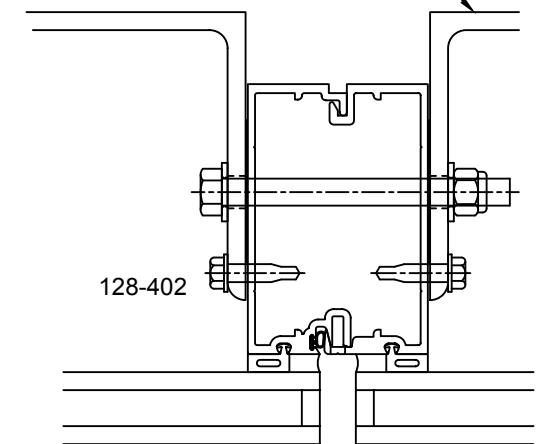
INSTALL UNITS AT 1ST LEVEL

Shim next unit at sill and clamp units together at top. Apply 128-402 1/4-14 x 1" HWHSD to temporarily fix frame in place. Install next unit prior to match drilling mullion and applying thru bolts.

Note: Temporary fasteners must be removed after thru bolting mullions at all wind load anchors.



NOTE: Glass not shown for clarity.



Note: When 1600 SS SSG has Versoleil Outrigger Application glass bite is 3/4" at SSG verticals and 1/2" at captured verticals (jamb) and horizontal. Glass sizes must be calculated from approved shop drawings.



1600 SS SSG
PRE-GLAZED
INSTALLATION
INSTRUCTIONS

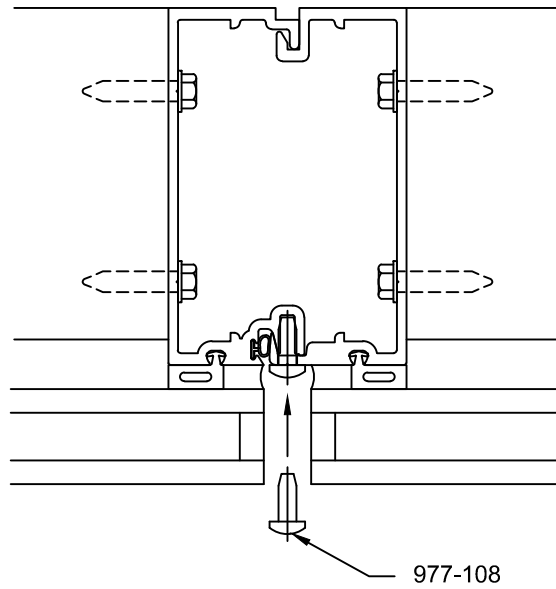
Product Engineering & Development

95505-18
09/21/12

INSTALL UNITS

Secure unit frames together. Install 977-108 #10 x 1/2" PHTF screws at 24" O.C.

Seal over fastener heads.



INSTALL UNITS USING BACK ANCHORS

Reference approved shop drawings for anchoring.

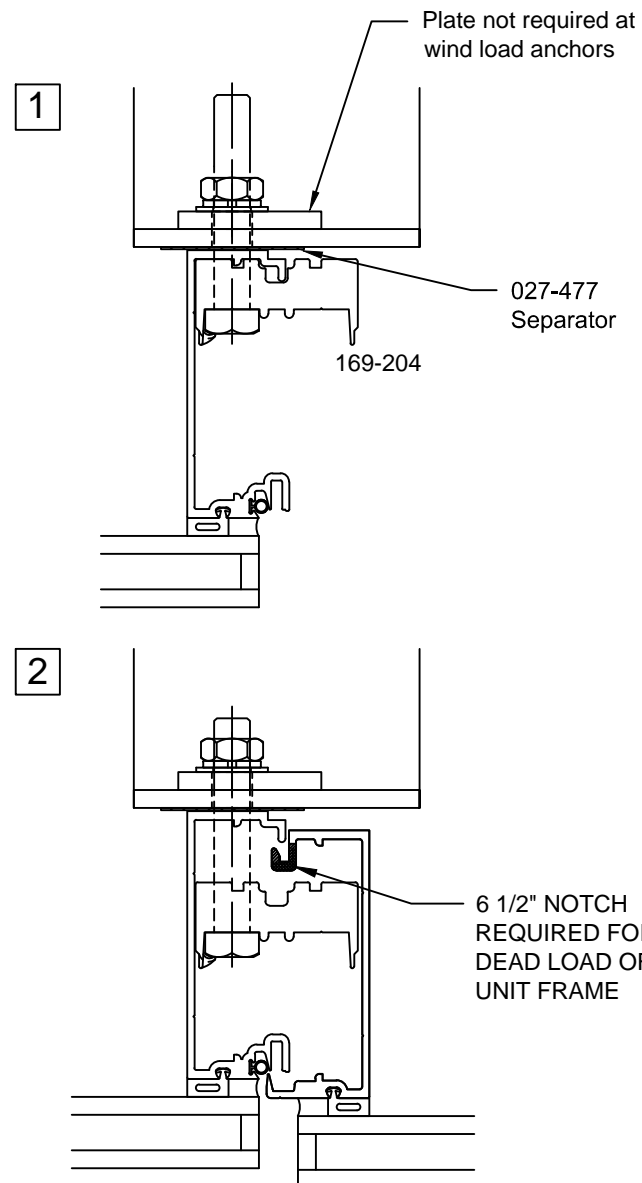
NOTE: Back Anchors **cannot** be used with Versoleil Outrigger Application.

All steel anchors must be separated from aluminum mullions. Use 027-477 separators.

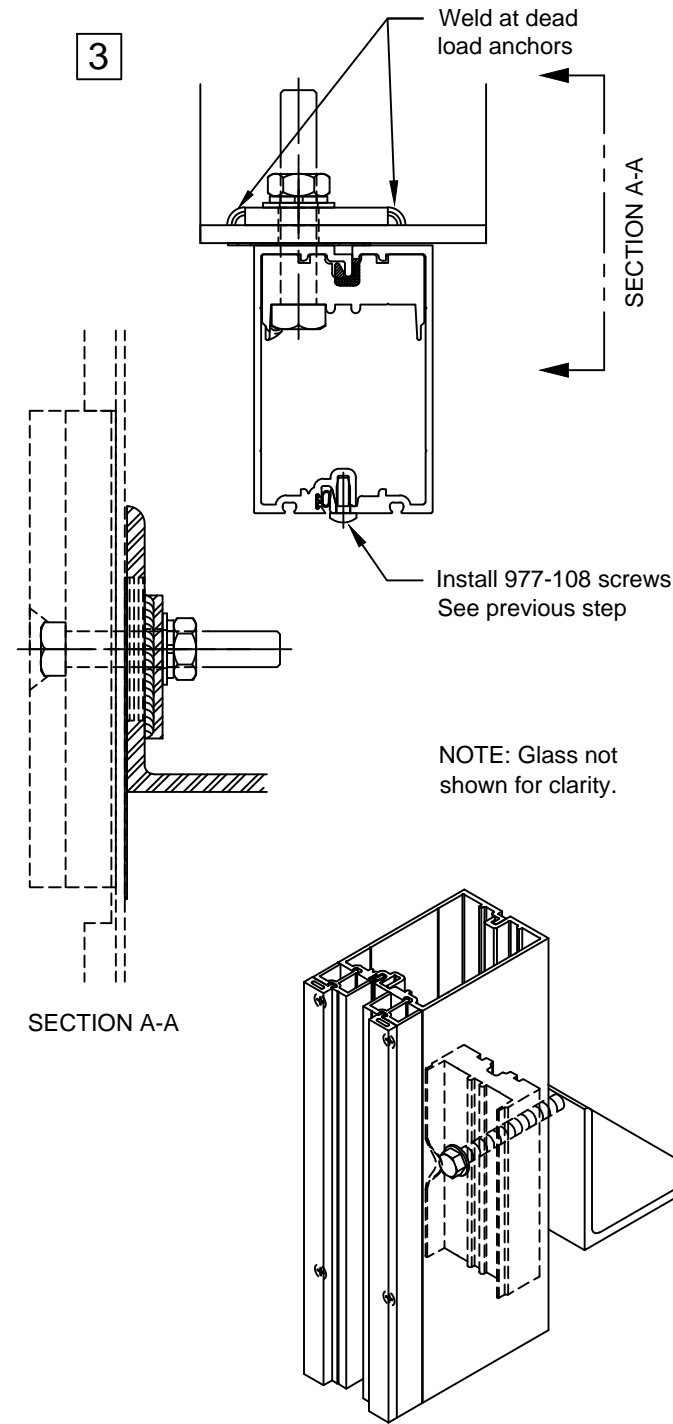
Units must be installed level, plumb and square.

Apply 128-935 1/2-13 x 3" Grade 5 HHMS to 169-204 back anchor lug and crimp into place.

1. Install unit into place. Apply 169-204 back anchor lug inside mullion half and fasten back to anchor per approved shop drawings.
2. When next unit is being installed, secure installed unit and loosen back anchor lug enough to engage next unit as shown. Notch in next unit should align with back anchor lug.
3. Tighten back anchor lug securing both units in place.



3



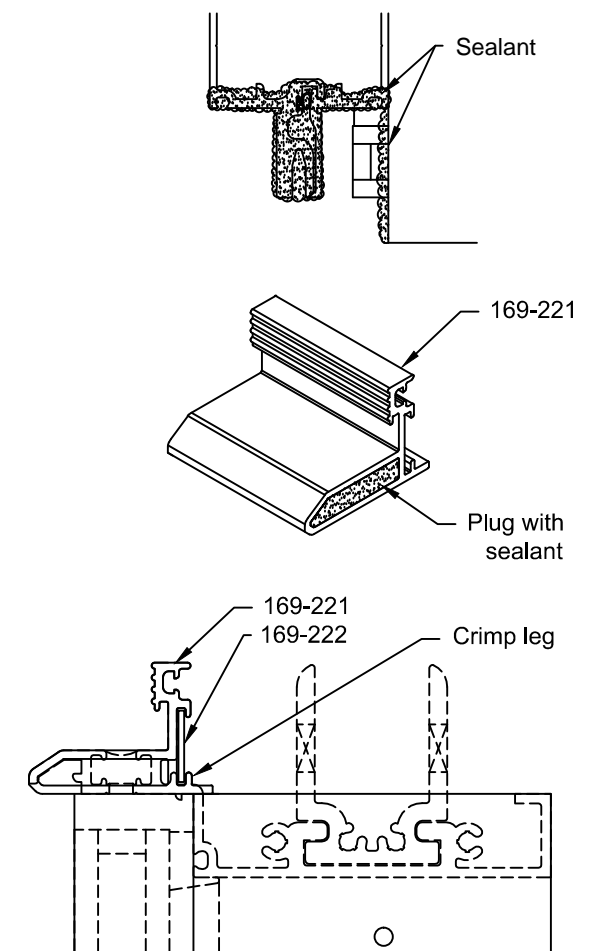
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INSTALL UNIT HEAD CAP - CAPTURED JAMBS

Prior to installing next level of units, install mullion cap, sleeve and air seal gasket at top of units.

Apply sealant across top front face of mullion tube and top of mullion tongue. Completely seal around the ends of the horizontals at the same location. Plug 169-221 cap hollow ends with sealant. Apply 169-221 cap into sealant and slide 169-222 cap sleeve over to engage cap and horizontal on opposite side. Crimp cap sleeve in place at end of sleeve. Tool sealant across face of cap and around all joints. Remove excess sealant at push-in air seal gasket reglet and at splice sleeve engagement at inside face of mullion.



1600 SS SSG
PRE-GLAZED
INSTALLATION
INSTRUCTIONS

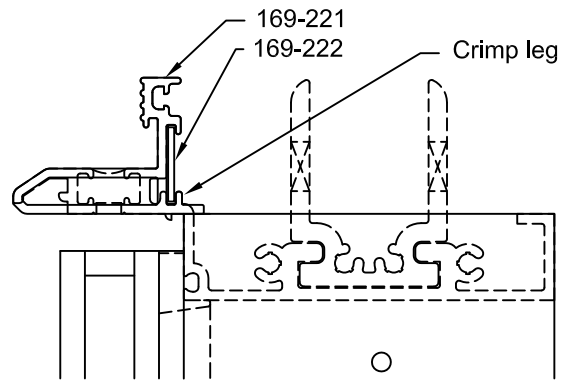
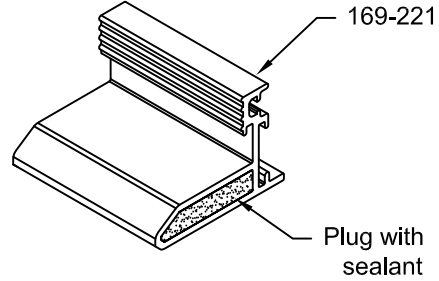
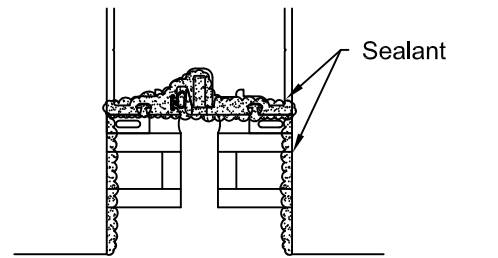
Product Engineering & Development

95505-17
05/18/12

INSTALL UNIT HEAD CAP - SSG INTERMEDIATES

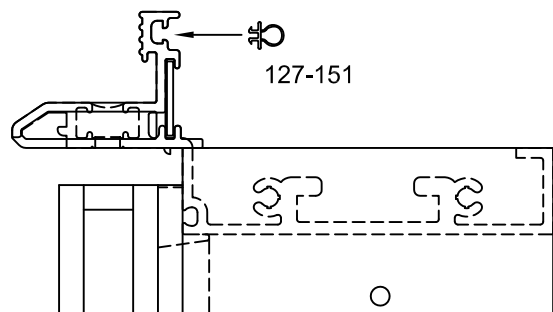
Prior to installing next level of units, install mullion cap, sleeve and air seal gasket at top of units.

Apply sealant across top front face of mullion tube. Completely seal around the ends of the horizontals at the same location. Plug 169-221 cap hollow ends with sealant. Apply 169-221 cap into sealant and slide 169-222 cap sleeve over to engage cap and horizontal on opposite side. Crimp cap sleeve in place at end of sleeve. Tool sealant across face of cap and around all joints. Remove excess sealant at push-in air seal gasket reglet and at splice sleeve engagement at inside face of mullion.



INSTALL AIR SEAL GASKET

Push-in 127-151 air seal gasket continuously across elevation. If a splice is required, seal ends of spliced gasket. Check gasket to make sure both snap legs are engaged in place.

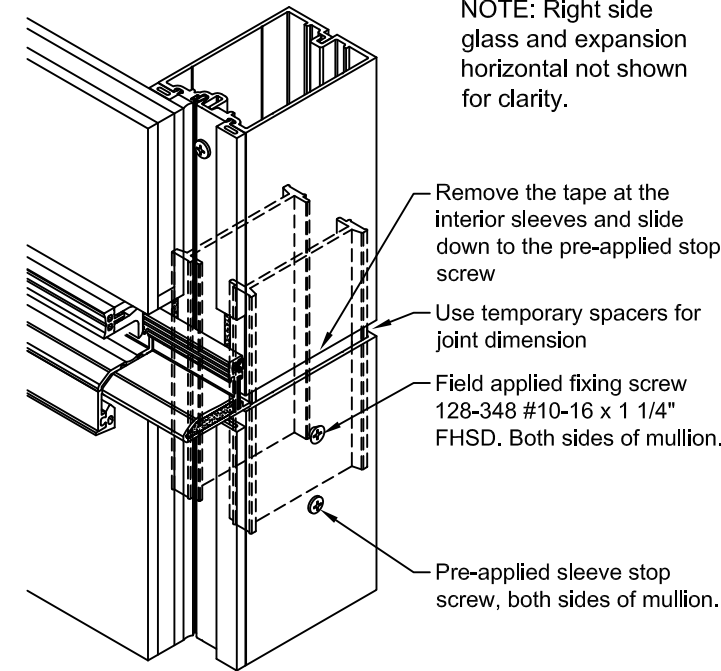


INSTALL UNITS AT NEXT LEVEL

Before proceeding to the next floor, inspect all horizontal joints to ensure they are watertight. Reference previous steps similar and additional information below. For top row of units, use holes in top of mullion halves for hoisting units where applicable. Shim unit at expansion horizontal between mullions and clamp units together at top. Apply 128-402 #12 x 1" HHSD to temporarily fix frame in place at anchors. Install next unit prior to match drilling mullion and applying thru bolts.

Note: Temporary fasteners must be removed after thru bolting mullions at all wind load anchors.

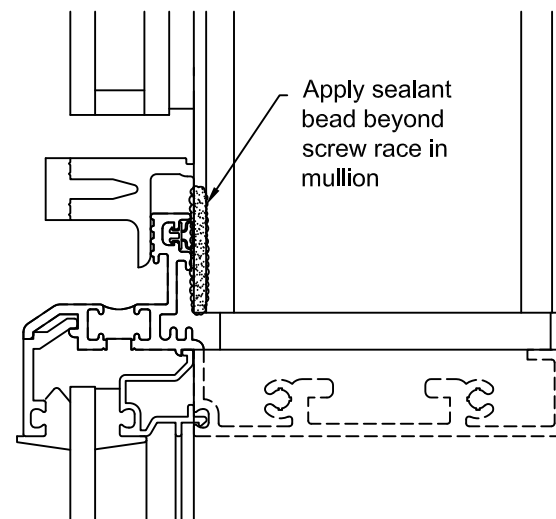
AT MULLION SPLICE LOCATIONS



NOTE: Right side glass and expansion horizontal not shown for clarity.

INSTALL SEAL AT UNIT INTERSECTION

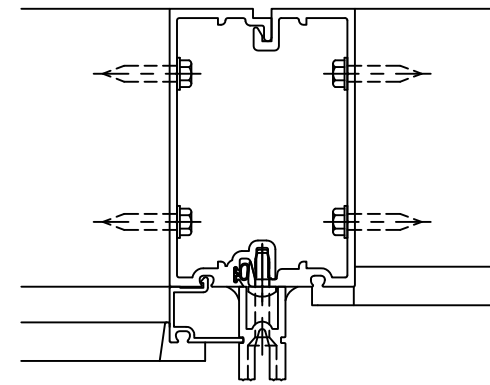
Just prior to the installation of the next unit, at a 4-way intersection, run a 1" long bead of sealant along the 027493 vertical gasket at the bottom of the unit previously installed.



INSTALL SSG TONGUE ADAPTER WHERE REQUIRED

Clamp tongue to mullion. Match drill .201 [#7 drill] dia. holes @ 6" on center in female mullion half only. Apply SSG tongue adapter with 028-761 #10 x 1 1/4" FHTF screws. Seal across top of tongue and down both sides where adapter contacts the face of the mullion.

Snap in 1/4" adapters and apply gaskets as required.

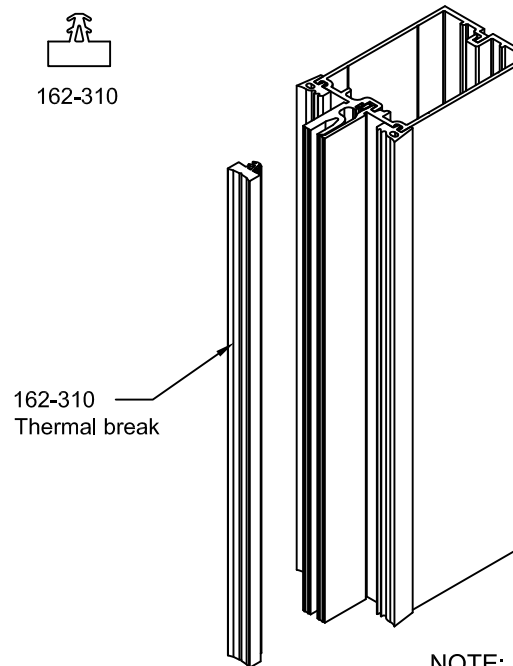


INSTALL 162-310 THERMAL BREAK AT CAPTURED VERTICALS

Do not stretch when removing from coil, carton and during installation.

Insert thermal break (162-310) along the full length of the vertical mullion tongue and trim flush at top and bottom of part except at bottom of typical units at expansion horizontals. Extend the thermal separator 1" beyond the notched tongue at this area and remove 1" of the dart at the bottom.

At top of unit under mullion cap, pull back thermal separator and apply sealant inside tongue race and push thermal separator into place. Seal all around top of thermal separator to mullion cap.

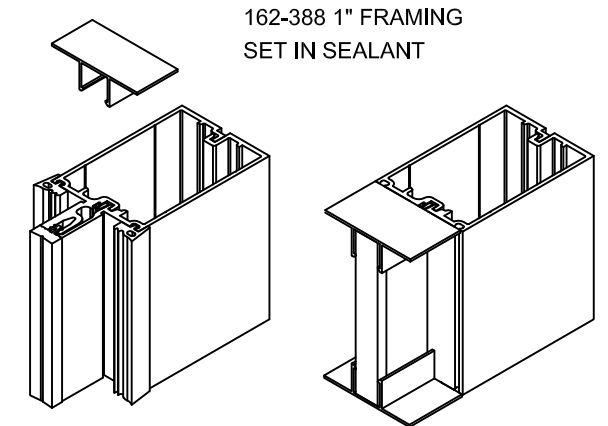


NOTE: Glass not shown for clarity.

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INSTALL HEAD AND SILL END CAPS WHERE APPLICABLE



162-388 1" FRAMING
SET IN SEALANT

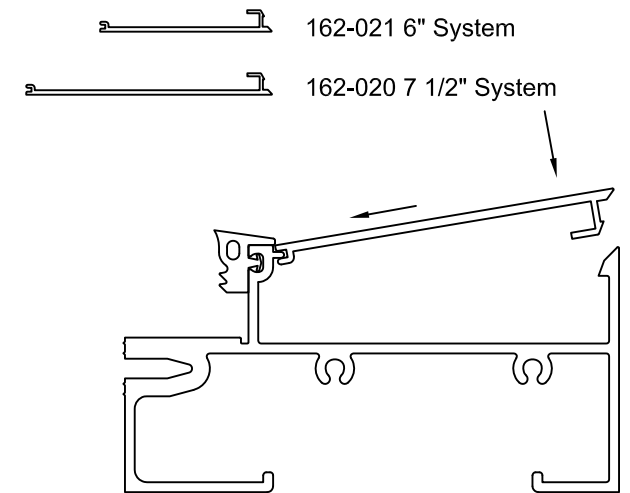
NOT REQUIRED WHEN PERIMETER HORIZONTALS ARE USED AND AT OPTIONAL PERIMETER FILLER 162-022. JOINT PLUG WILL SEAL OFF TOP OF MULLION GLAZING POCKETS.

INSTALL INTERIOR FILLERS WHERE APPLICABLE

Fillers used at exposed areas only.

Sill shown, head opposite.

Perimeter horizontal shown, other similar.



162-021 6" System

162-020 7 1/2" System



1600 SS SSG
PRE-GLAZED
INSTALLATION
INSTRUCTIONS

Product Engineering & Development

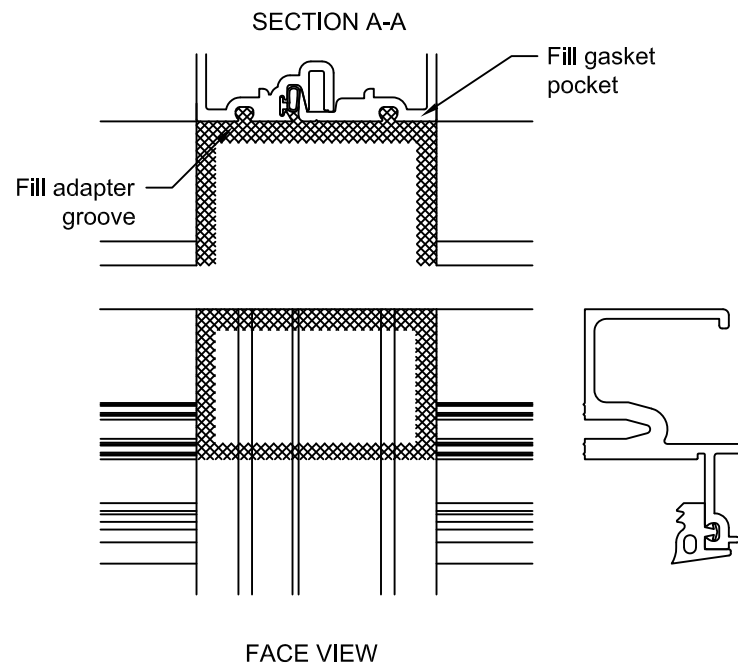
95505-020
10/07/13

INSTALL "PERIMETER TYPE" HORIZONTAL HEAD AND SILL JOINT PLUGS AT SSG VERTICALS AND THERMAL SEPARATOR

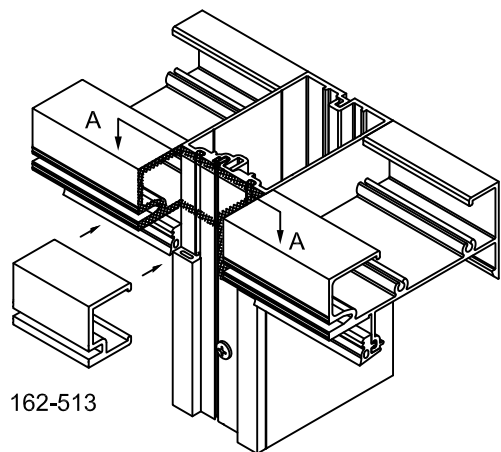
All surfaces and grooves must be cleaned per the sealant manufacturer's recommendations.

Just before installing joint plugs apply sealant as shown filling gasket pocket and adapter groove.

Joint plugs for SSG verticals must be applied after unit installation.



NOTE: Glass not shown for clarity.

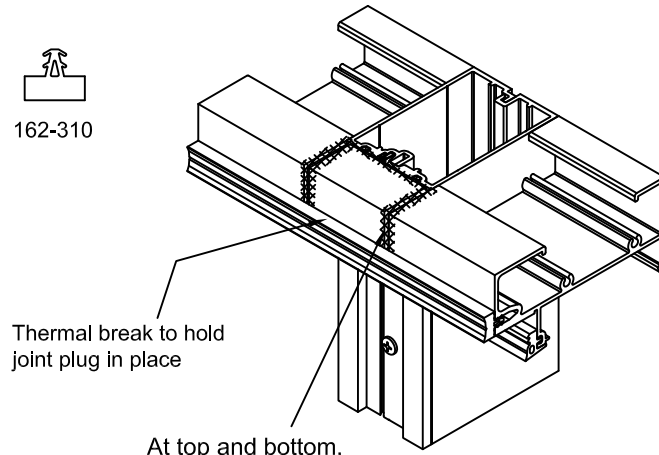


162-513

INSTALL "PERIMETER TYPE" HORIZONTAL HEAD AND SILL JOINT PLUGS AT SSG VERTICALS AND THERMAL SEPARATOR

Install 162-310 thermal separator. Reference sheet 2 for par lengths.

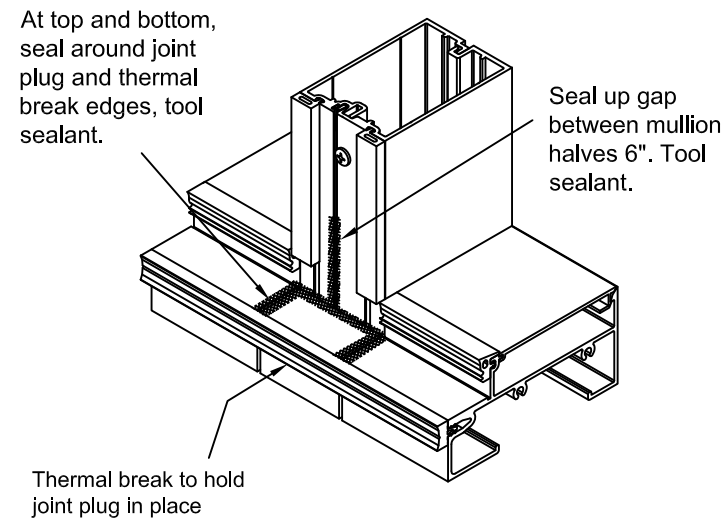
DO NOT STRETCH WHEN REMOVING FROM COIL, CARTON AND DURING INSTALLATION



162-310

At top and bottom, seal around joint plug and thermal break edges, tool sealant.

NOTE: Glass not shown for clarity.



Thermal break to hold joint plug in place

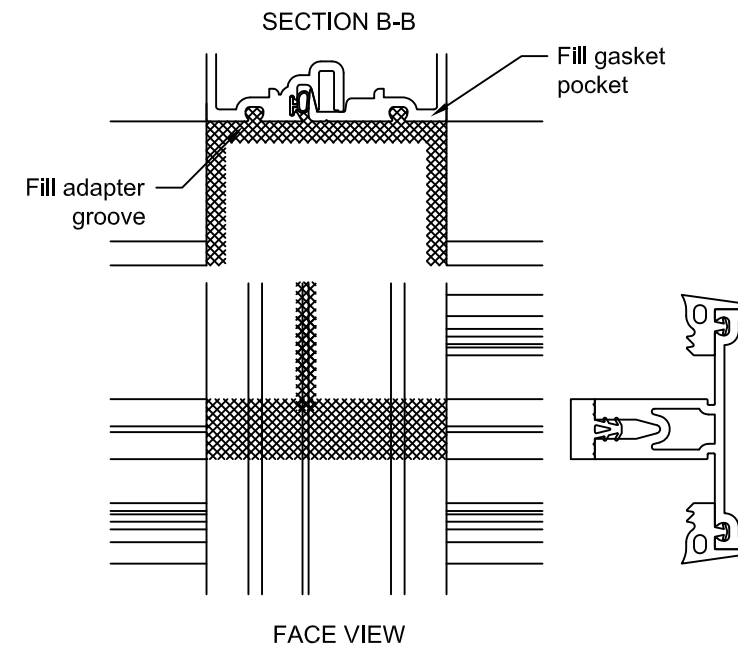
INSTALL HEAD, SILL AND INTERMEDIATE JOINT PLUGS AT SSG VERTICALS

All surfaces and grooves must be cleaned per the sealant manufacturer's recommendations.

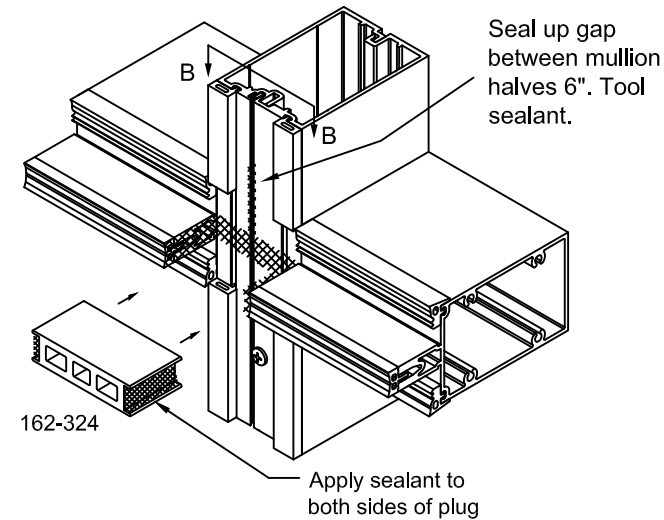
Just before installing joint plugs apply sealant as shown filling gasket pocket and adapter groove.

Joint plugs for SSG verticals must be applied after unit installation.

Intermediate shown, typical head and sill similar.



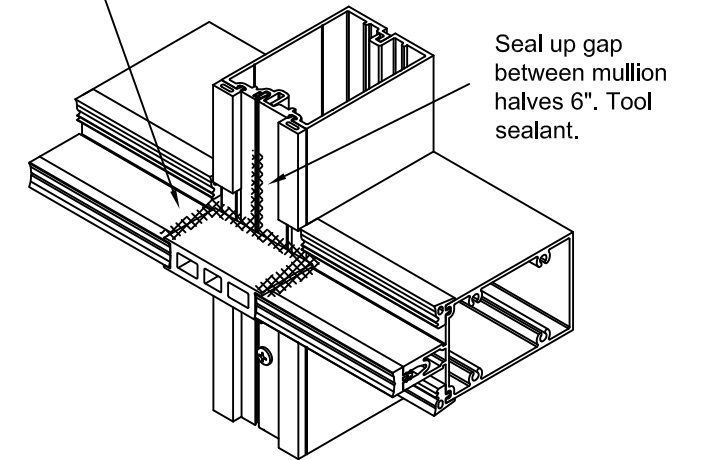
NOTE: Glass not shown for clarity.



162-324

INSTALL HEAD, SILL AND INTERMEDIATE JOINT PLUGS AT SSG VERTICALS

At top and bottom, seal around joint plug and thermal break edges, tool sealant.

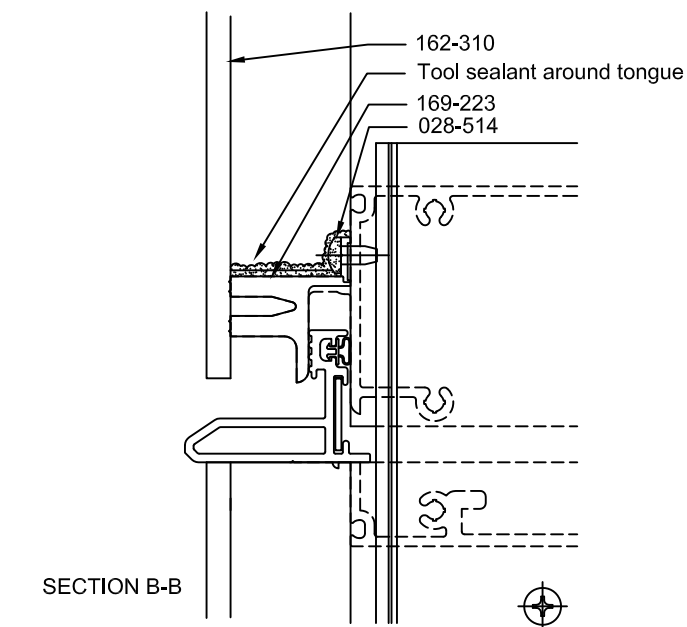
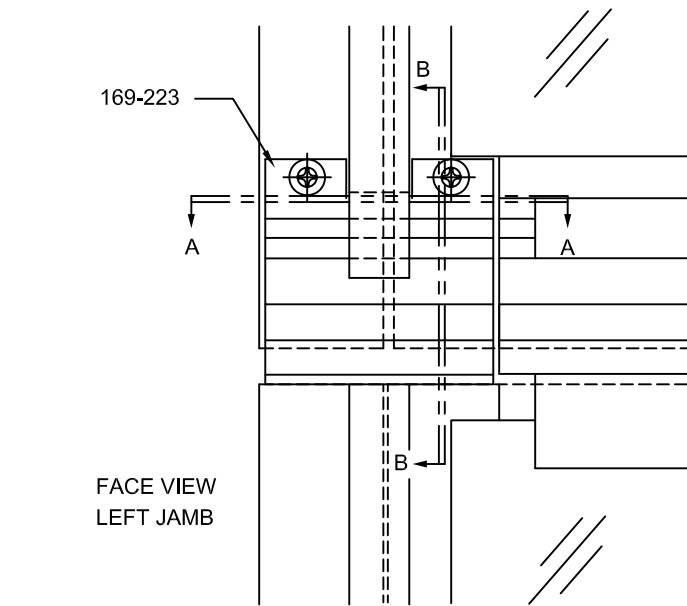
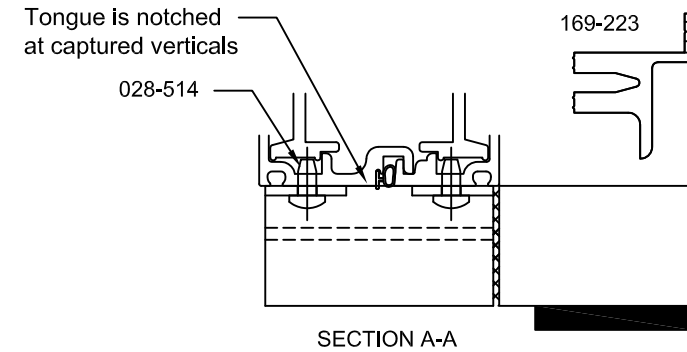


NOTE: Glass not shown for clarity.

Note: When Versoleil Outrigger Application is used; Joint Plug, 494406, is used in Mounting Stem Locations. See Approved Shop Drawings and Versoleil Outrigger Installation Instructions, 494974, for details.

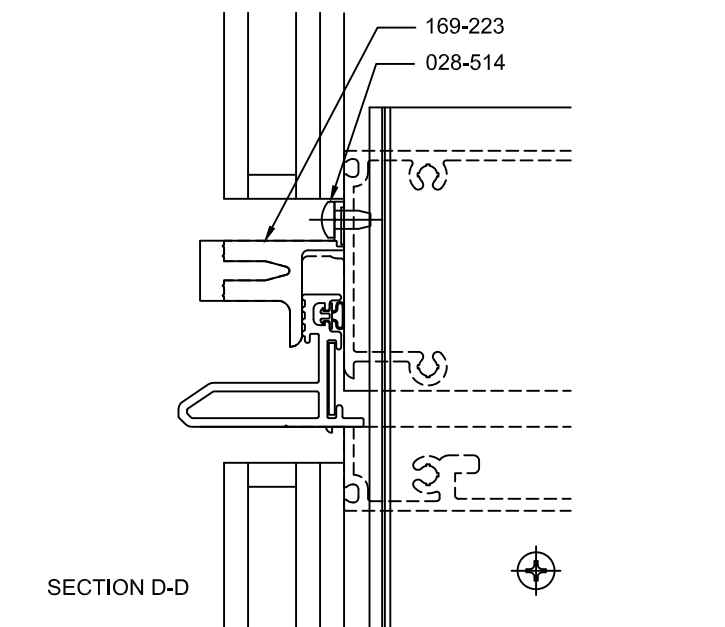
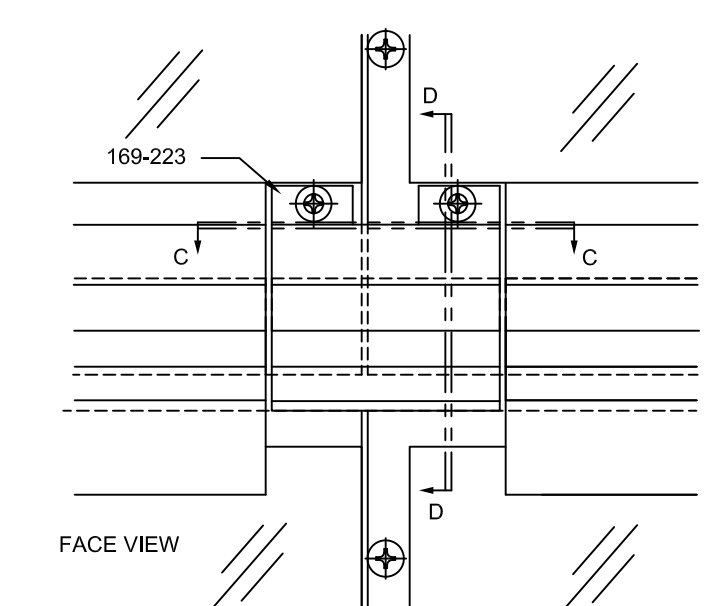
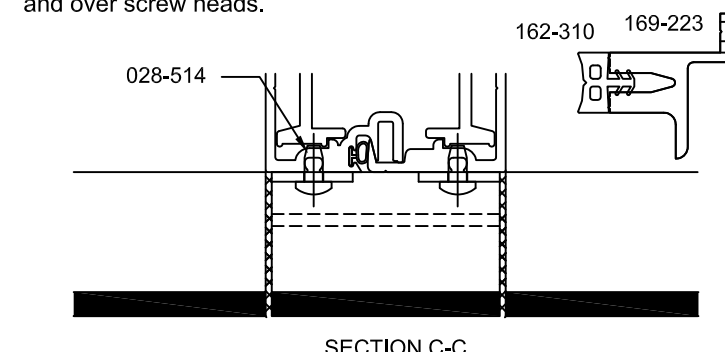
INSTALL 169-223 JOINT PLUGS AT EXPANSION HORIZONTALS AT CAPTURED JAMBS

Apply sealant at face of mullion along vertical air seal gasket below notched tongue and tool flat. Apply sealant across back of screw hole legs, on both side of joint plug completely and seal bottom of mullion tongue from front to back and along vertical air seal gasket. Install joint plug with two 028-514 screws into face of mullion. Tool sealant all around across joints and over screw heads.



INSTALL 169-223 JOINT PLUGS AT EXPANSION HORIZONTALS AT SSG INTERMEDIATES

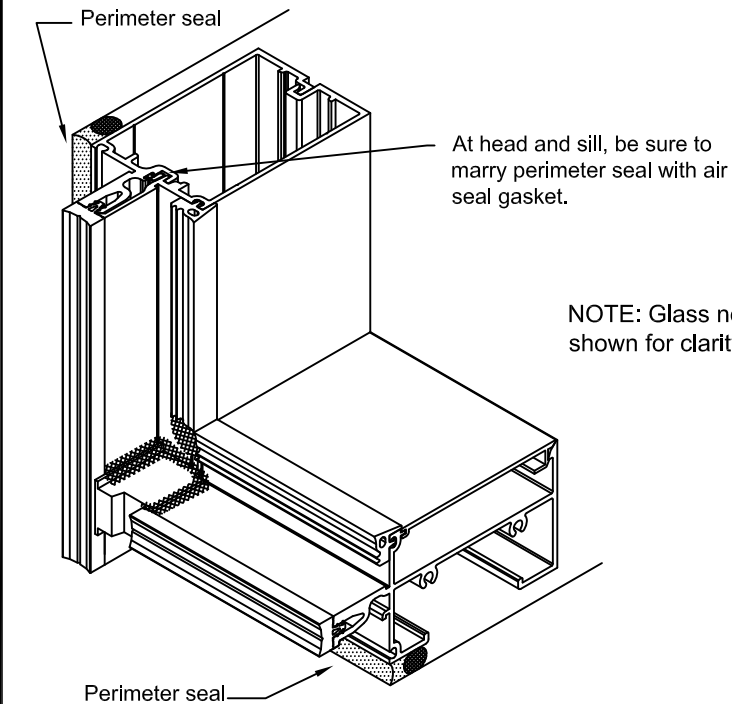
Apply 162-310 to face of joint plug. Apply sealant at face of mullion along vertical air seal gasket below notched tongue and tool flat. Apply sealant across back of screw hole legs, on both side of joint plug completely and seal bottom of mullion tongue from front to back and along vertical air seal gasket. Install joint plug with two 028-514 screws into face of mullion. Tool sealant all around across joints and over screw heads.



PERIMETER SEAL AT FACE OF MULLION TUBES OPTIONAL

Apply backer rod and primary perimeter seal as shown where specified. Please note this seal must be stopped and started 3" above and below the expansion horizontal. Area will be completed after the jamb patch is applied. All surfaces and grooves must be cleaned and sealant applied per the sealant manufacturer's recommendations. Tool sealant.

Perimeter seals required at pressure plates will be completed on a later step.

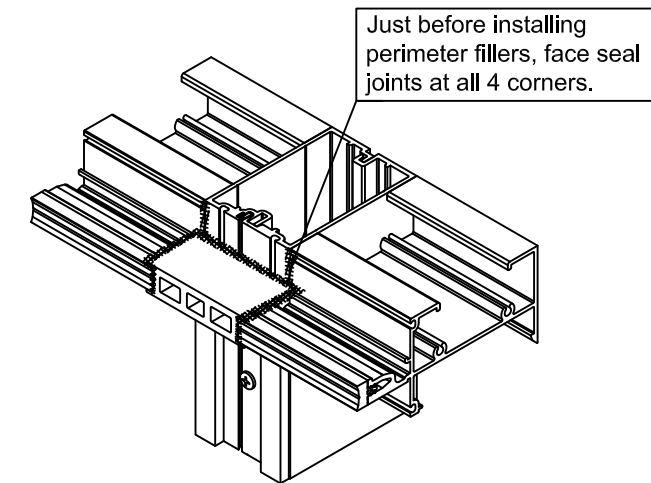


NOTE: Glass not shown for clarity.

INSTALL PERIMETER FILLERS WHERE APPLICABLE

All surfaces and grooves must be cleaned per the sealant manufacturer's recommendations.

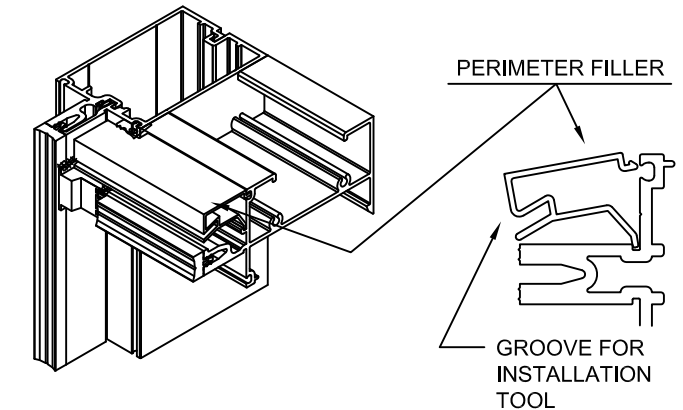
NOTE: If horizontal ends were sealed during frame assembly, face sealing joints at all 4 corners not required.



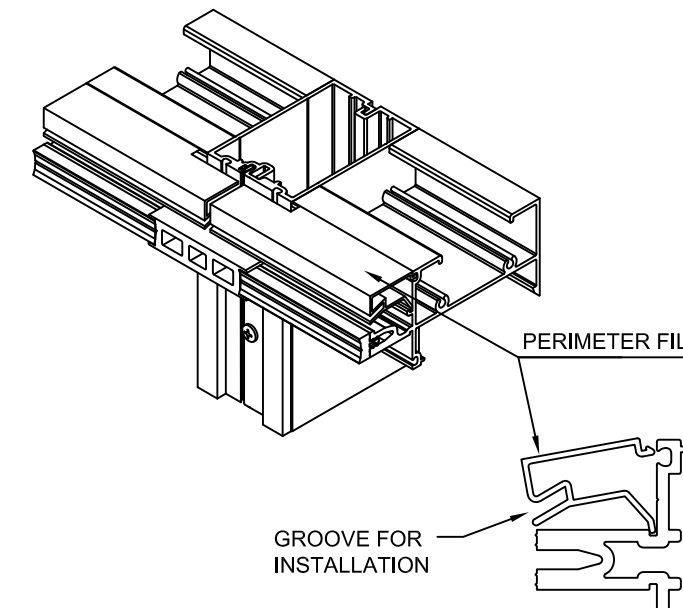
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INSTALL PERIMETER FILLERS WHERE APPLICABLE



USE PUTTY KNIFE,
SMALL PRY BAR
OR SCREW DRIVER



NOTE: Glass not shown for clarity.



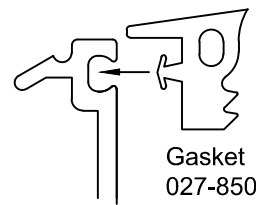
1600 SS SSG
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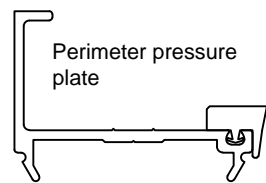
INSTALL EXTERIOR GASKETS INTO PRESSURE PLATES

Reference previous gasket notes, same notes apply

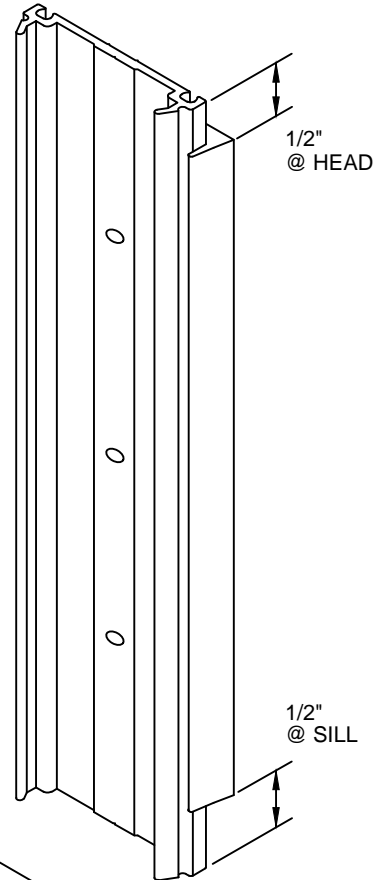


Gasket 027-850

VERTICAL GASKETS ARE TO RUN CONTINUOUS AT PRESSURE PLATE LENGTH EXCEPT AT ELEVATION HEAD AND SILL CONDITIONS. THE GASKET IS TO BE CUT 1/2" SHORT. THIS IS FOR THE SEAL AT SECTION D-D SHEET # 15.



Perimeter pressure plate



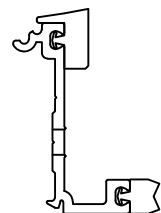
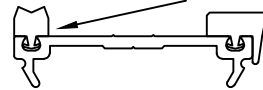
1/2" @ HEAD

1/2" @ SILL

Horizontal gasket to be same length as pressure plate.

PERIMETER WHERE APPLICABLE

Gasket 027-857 at one side. Do not cut short.



EXPANSION HORIZONTAL PRESSURE PLATE

Use 027-850 at top and 027-857 at bottom.

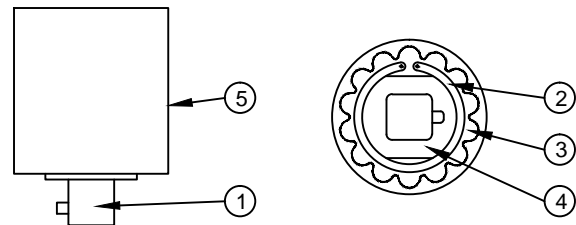
INSTALL EXTERIOR PRESSURE PLATES

Recommend using torque limit tool 162-399 see note.

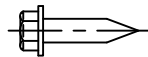


HOW TO SET TORQUE LIMIT

1. Attach any calibrated torque indicator to output stub (1) and determine present torque setting while holding the body (5), or vice-versa.
2. Remove snap ring (2) and locking plate (3).
3. Adjust nut (4) with open-end wrench : clockwise to increase torque, counter-clockwise to decrease torque.
4. Obtain new torque reading with the calibrated torque indicator. repeat preceding step if more adjustment is necessary to reach desired limit.
5. Replace locking plate into notches and install snap ring. If locking plate does not "seat", move the adjusting nut slightly until it drops in place. the direction is best determined by whether a minimum torque application or a maximum one is desired.



Install pressure plates using screws 128-406 1/4-14 x 1" hex washer head type AB.



Screws are to be located 9" on center. Always locate a screw as close as possible to a horizontal joint. This will provide maximum pressure for the critical joint seals.

Install horizontal pressure plates with the weep holes towards the top of the horizontal.

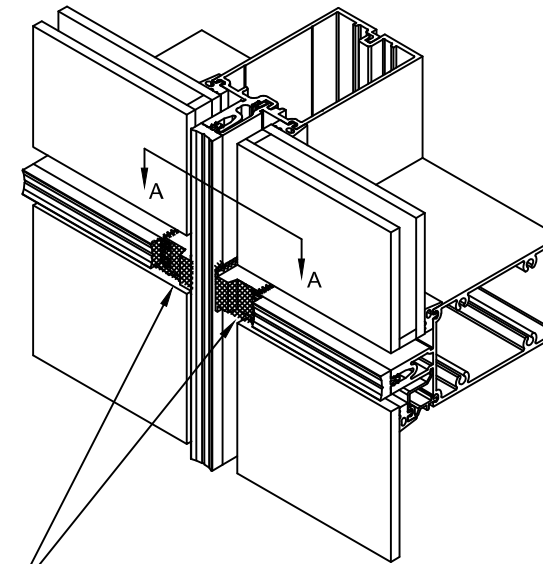
At each horizontal and vertical pressure plate install two screws part way, then install the third screw all the way and then tighten the first two screws. This eliminates lateral walking of the pressure plate position.

Torque all screws to 95 to 100 inch pounds. During cold weather torque screws to 50 inch pounds until all 4 sides have been clamped. Then torque screws to 95 to 100 inch pounds.

INSTALL VERTICAL EXTERIOR PRESSURE PLATES

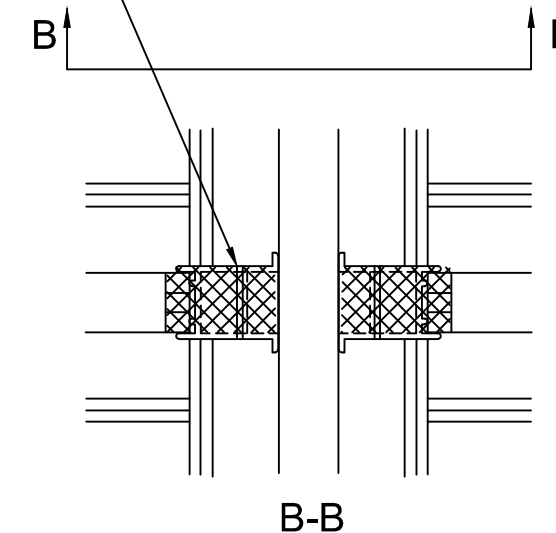
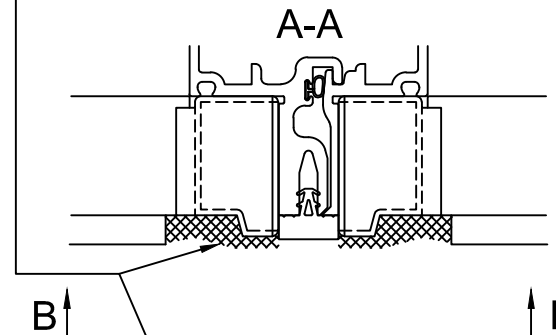
Intermediate horizontal vision over spandrel

Head and sill similar



Just before installing vertical pressure plates apply a generous amount of sealant to the joint plug face filling joints as shown.

Clean joint per sealant manufacturer's recommendations



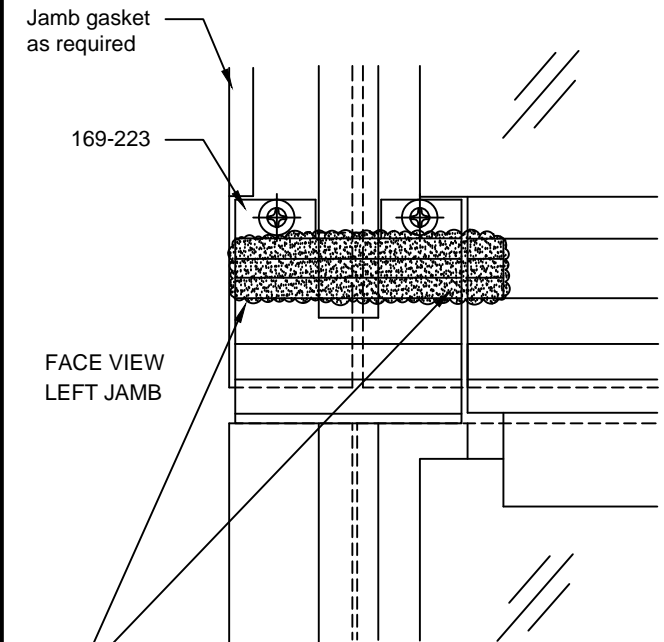
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INSTALL VERTICAL EXTERIOR PRESSURE PLATES

Expansion horizontal joint plugs at vertical pressure plate applications only

Clean joint per sealant manufacturer's recommendations



Jamb gasket as required

169-223

FACE VIEW LEFT JAMB

Just before installing vertical pressure plates apply a generous amount of sealant to the joint plug tongue face, filling screw race and joints as shown. Pull up thermal separator and seal behind.



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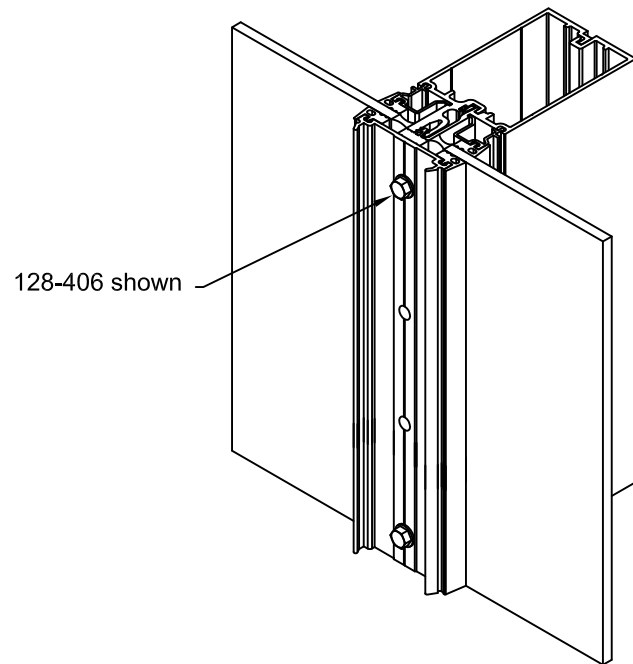
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INSTALL VERTICAL EXTERIOR PRESSURE PLATES

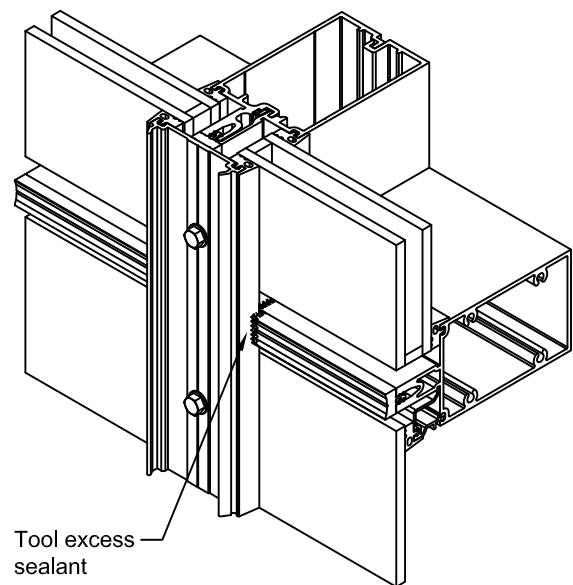
Install vertical pressure plates where required. Reference sheet 13 for additional information for the installation of pressure plate screws at 9" on center.

Align bottom of pressure with elevation sill and top of pressure plate with elevation head. See next sheet for vertical pressure plates at expansion joints.

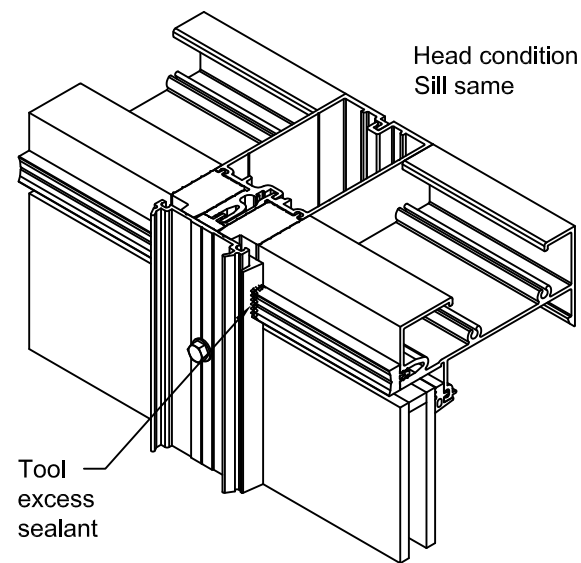
Note - The torque limit tool was designed to be used with a hand driven device. The tool can be adapted to a drill motor if used at a maximum speed of approx. 300 rpm. Higher speeds can cause overheating and affect the accuracy. After approx. 1 hour of tool usage check torque settings with a torque wrench.



Intermediate horizontal vision over spandrel

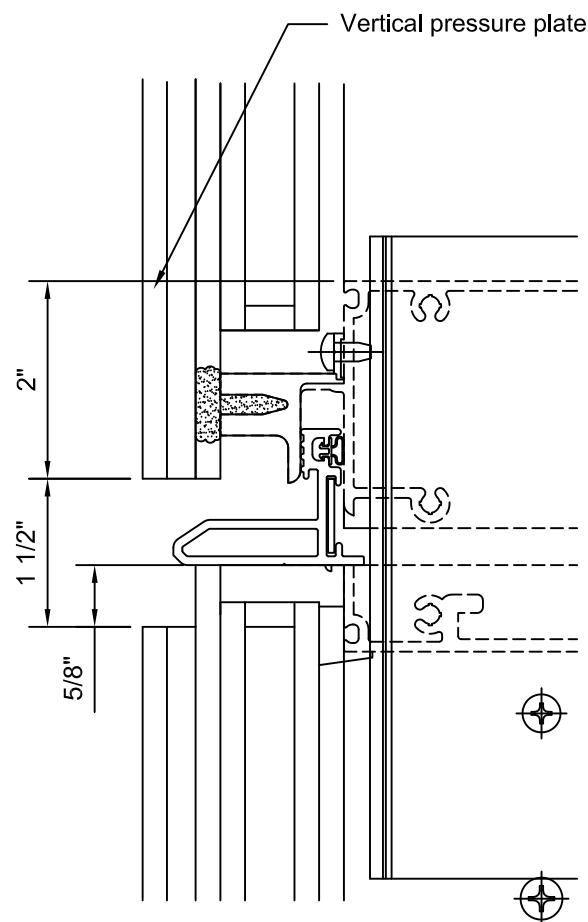


INSTALL VERTICAL EXTERIOR PRESSURE PLATES



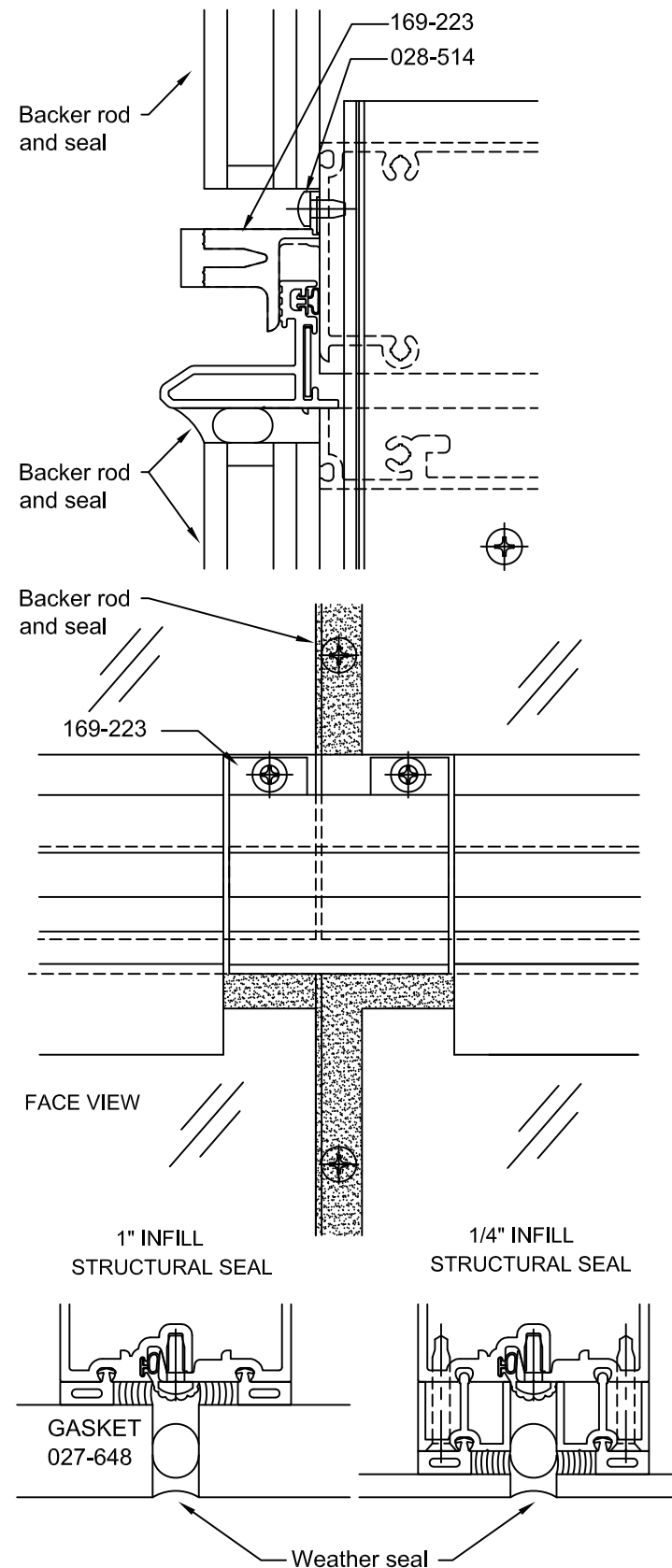
Install vertical pressure plates between expansion horizontals where required. Reference sheet 13 for additional information for the installation of pressure plate screws at 9" on center.

Bottom of pressure is to be located 2" below the top of the unit sill horizontal. The top of the pressure plate is located 5/8" below the cap or top of mullion at the unit head.



INSTALL WEATHER SEALS AT SSG VERTICALS

At the top of the glass at expansion horizontals, apply 1/2" backer rod between glass and cap. Seal cap to glass and tie seal to ends of glass retainer and gasket. Also apply weather seal between glass vertically similar as shown. Tool sealant.



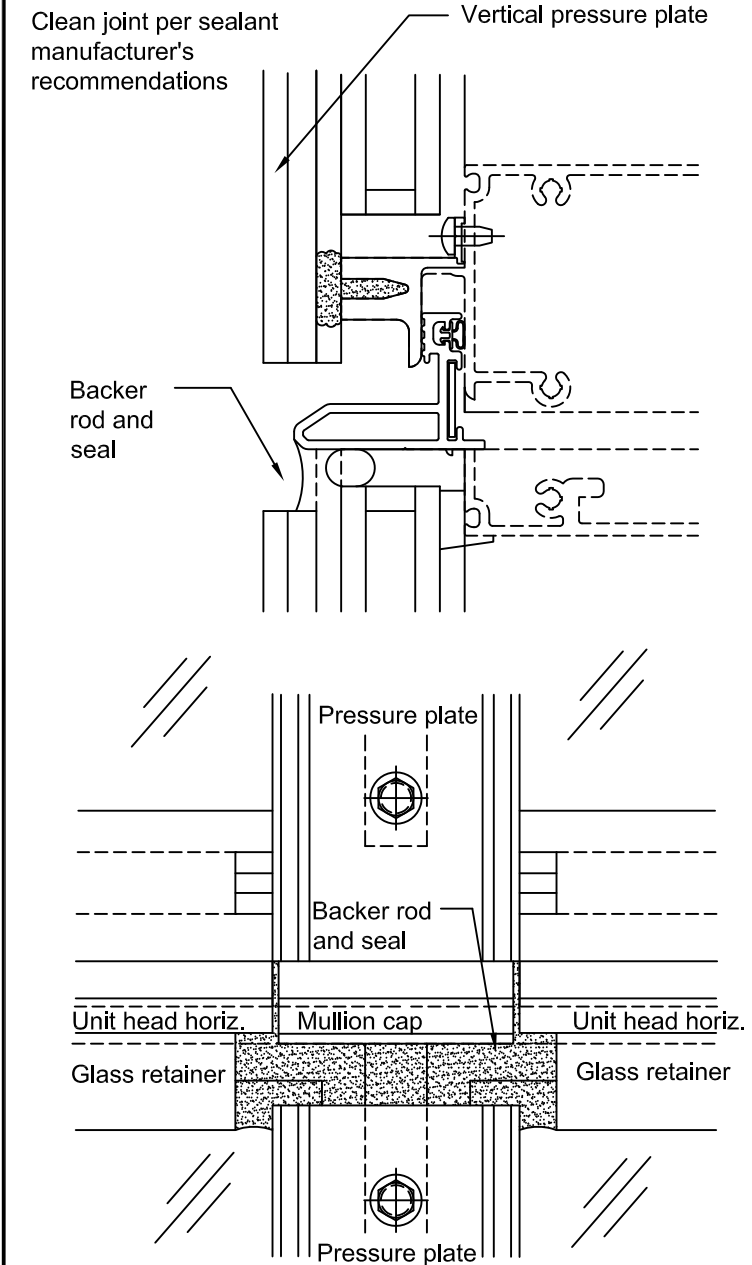
For Versoleil Outrigger Application refer to Approved Shop Drawings and Versoleil Outrigger Installation Instructions, 494974, for correct Gaskets and Structural Seals.

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INSTALL WEATHER SEALS AT CAPTURED VERTICALS

At the top of the pressure plate at expansion horizontals, apply 1/2" backer rod between pressure plate and cap. Seal cap to pressure plate and tie seal to ends of glass retainer and vertical pressure plate. Do not let the seal interfere with the cover snap. Tool sealant.



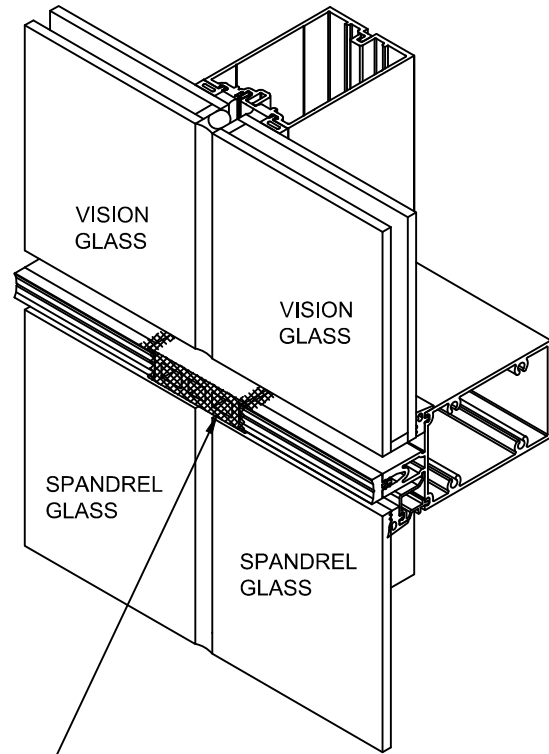
1600 SS SSG
PRE-GLAZED
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10/07/13

INSTALL EXTERIOR HORIZONTAL PRESSURE PLATES AT SSG VERTICALS

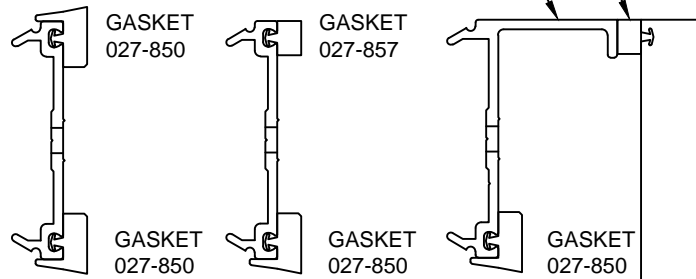
Note - The torque limit tool was designed to be used with a hand driven device. The tool can be adapted to a drill motor if used at a maximum speed of approx. 300 rpm. Higher speeds can cause overheating and affect the accuracy. After approx. 1 hour of tool usage check torque settings with a torque wrench.



Just before installing vertical pressure plates apply a generous amount of sealant to the joint plug face filling joints as shown.

Just before installing perimeter horizontal pressure plates, apply a generous amount of sealant between ends of perimeter gasket at face of mullion. Tool sealant.

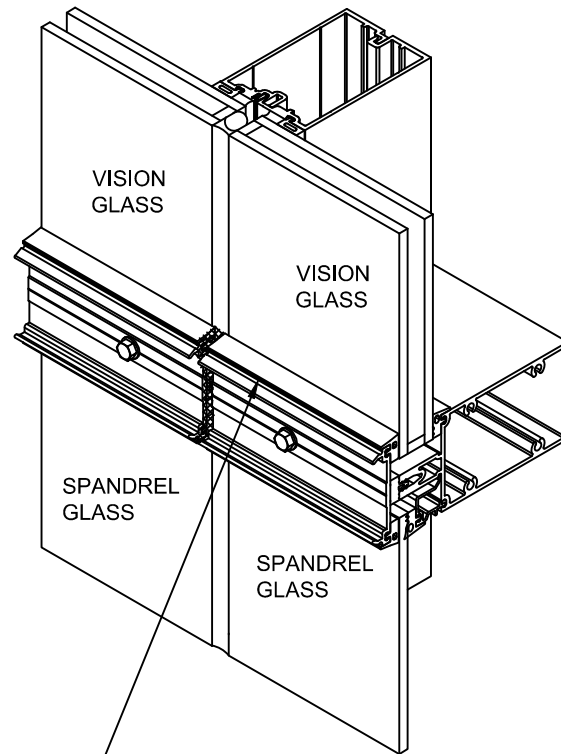
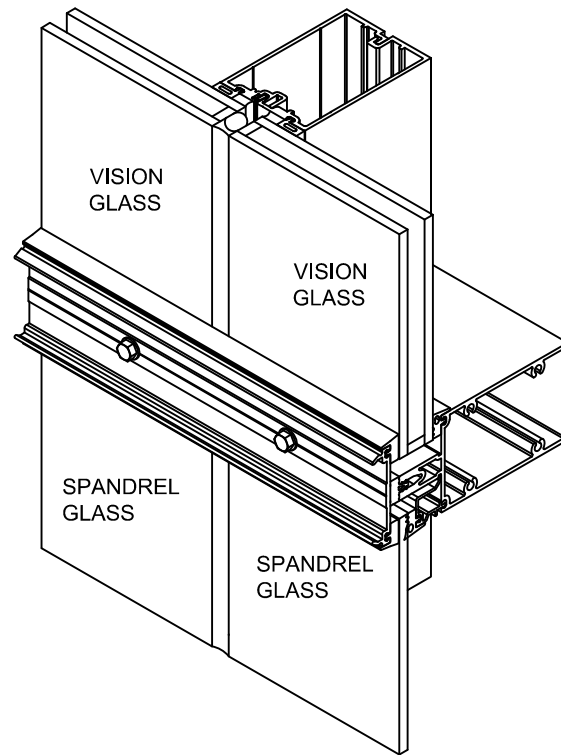
Seal between spliced perimeter pressure plates. Tool sealant.



INTERMEDIATE PERIMETER PERIMETER

Face of SSG mullion

INSTALL EXTERIOR HORIZONTAL PRESSURE PLATES AT SSG VERTICALS

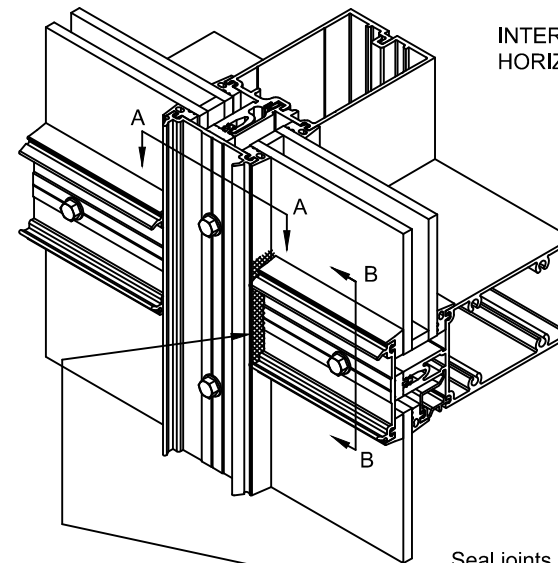


Completely seal horizontal pressure plate joint. Do not let sealant interfere with cover snap.

Clean joint per sealant manufacturer's recommendations.

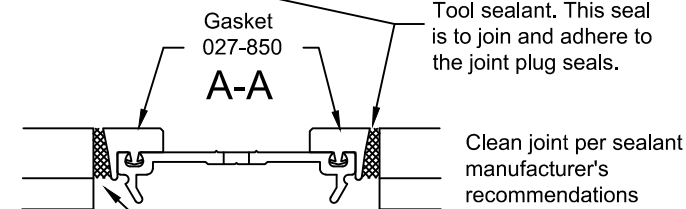
INSTALL HORIZONTAL EXTERIOR PRESSURE PLATES AT CAPTURED VERTICALS

CENTER HORIZONTAL PRESSURE PLATES SO END GAPS ARE EQUAL.

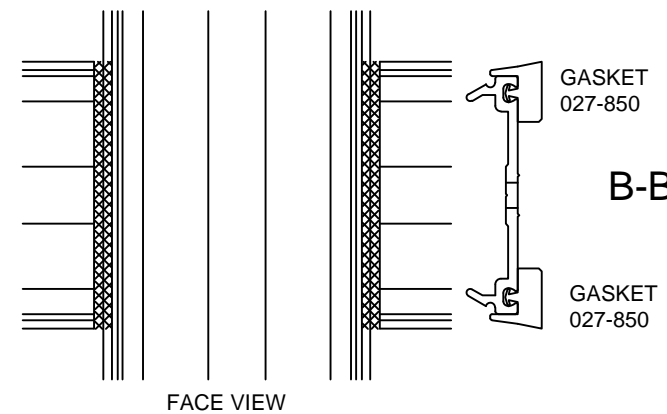


INTERMEDIATE HORIZONTAL

Seal joints as shown. Tool sealant. This seal is to join and adhere to the joint plug seals.



DO NOT LET THE SEAL INTERFERE WITH THE COVER SNAP.

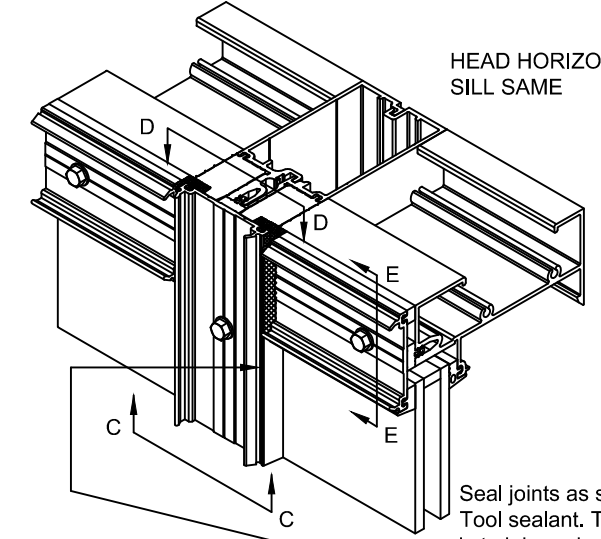


FACE VIEW

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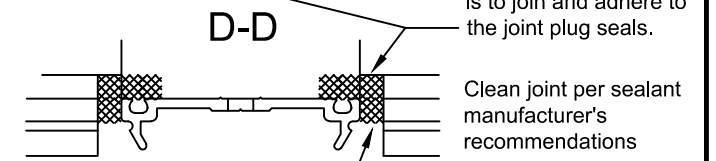
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INSTALL HORIZONTAL EXTERIOR PRESSURE PLATES AT CAPTURED VERTICALS



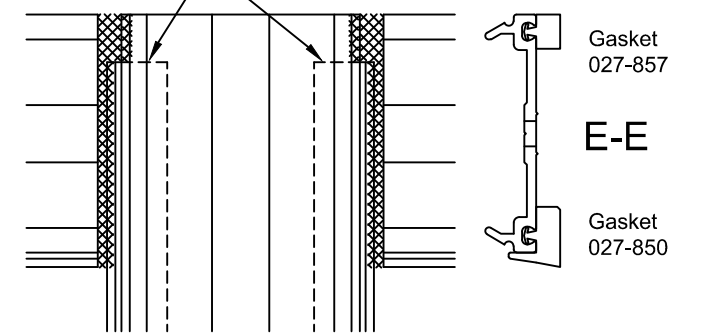
HEAD HORIZONTAL SILL SAME

Seal joints as shown. Tool sealant. This seal is to join and adhere to the joint plug seals.



VERTICAL GASKET STOPS 1/2" SHORT OF END.

DO NOT LET THE SEAL INTERFERE WITH THE COVER SNAP.

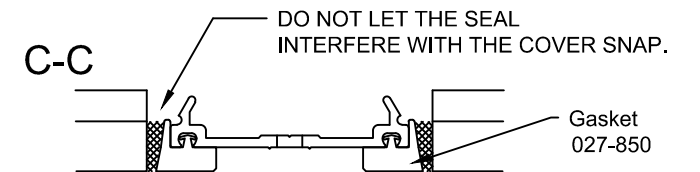


Gasket 027-857

E-E

Gasket 027-850

FACE VIEW



C-C

Gasket 027-850



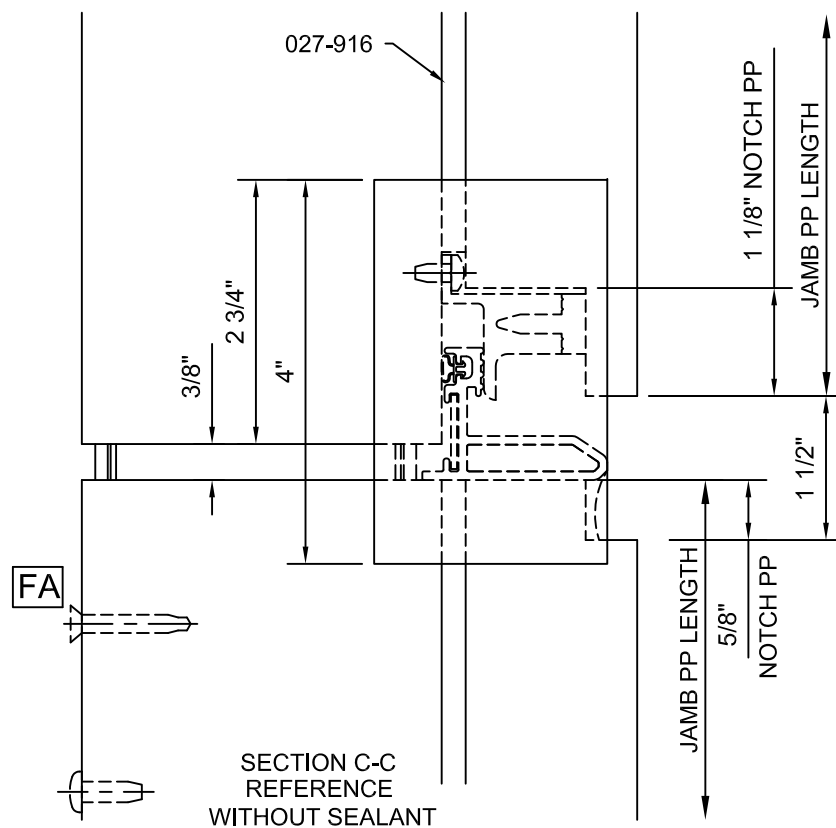
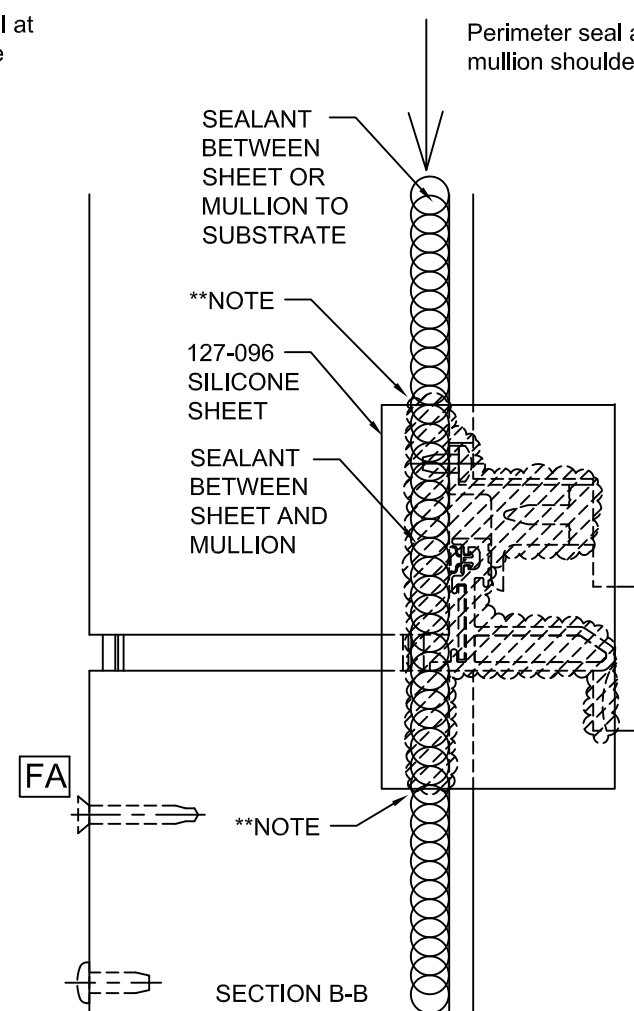
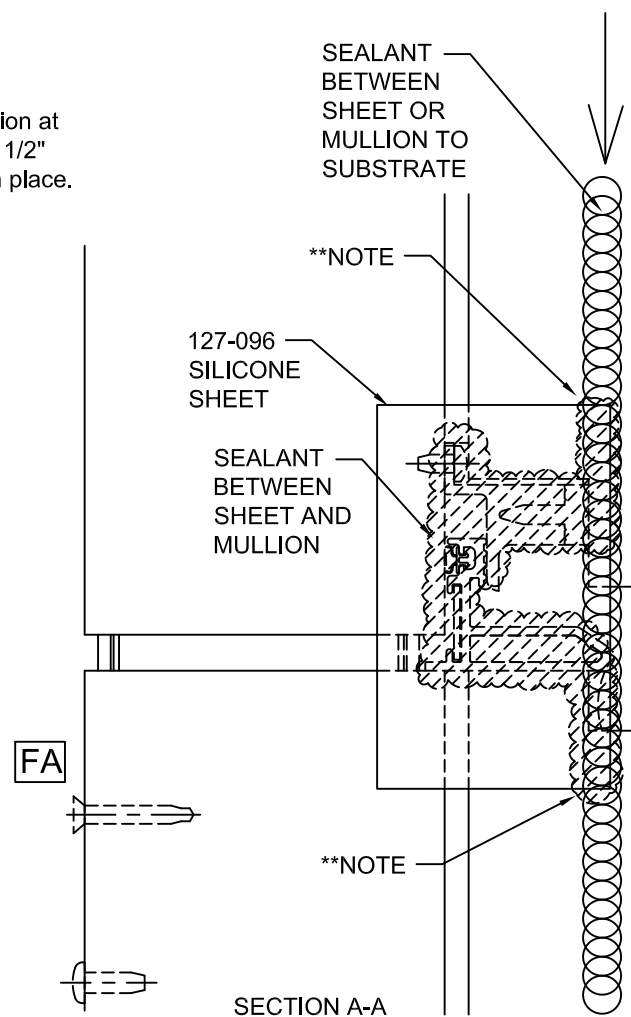
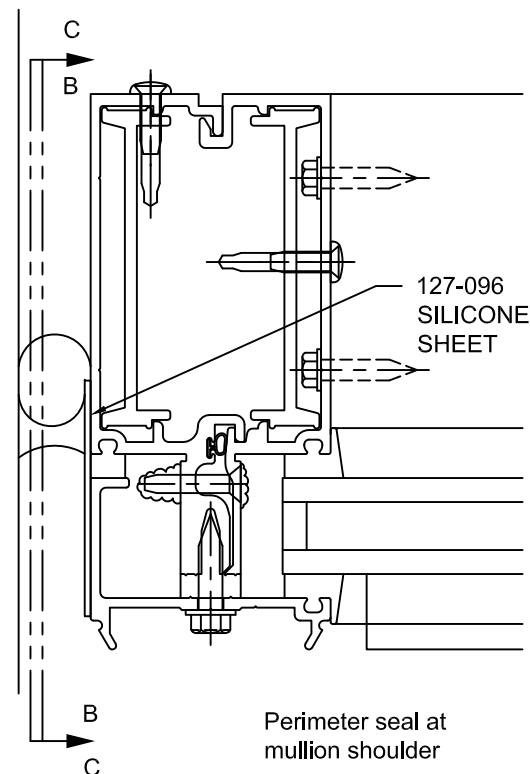
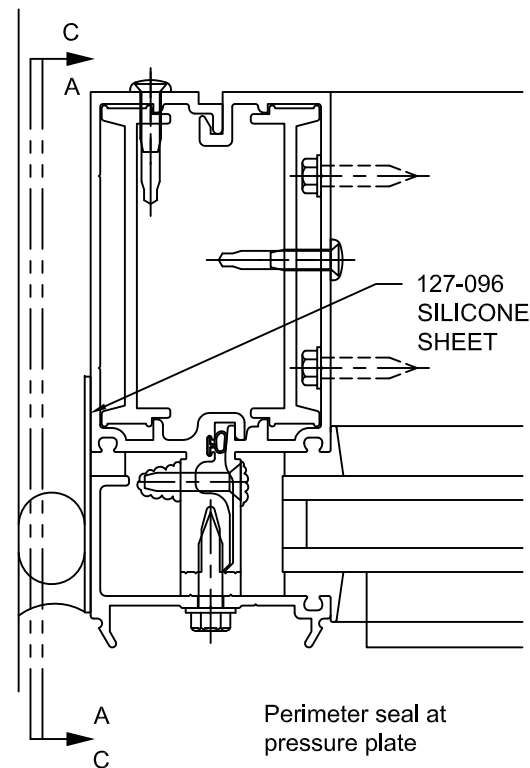
1600 SS SSG
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APPLY 127-096 SILICONE SHEET PATCH AT JAMBS AT EXPANSION HORIZONTALS

At jambs at expansion horizontals, clean area per manufacturer's recommendations. Apply sealant with a spatula to jamb side of mullion at joint per application required. Apply a piece of 127-096 (4" wide x 2 1/2" long) silicone sheet across end of expansion joint and press firmly in place.



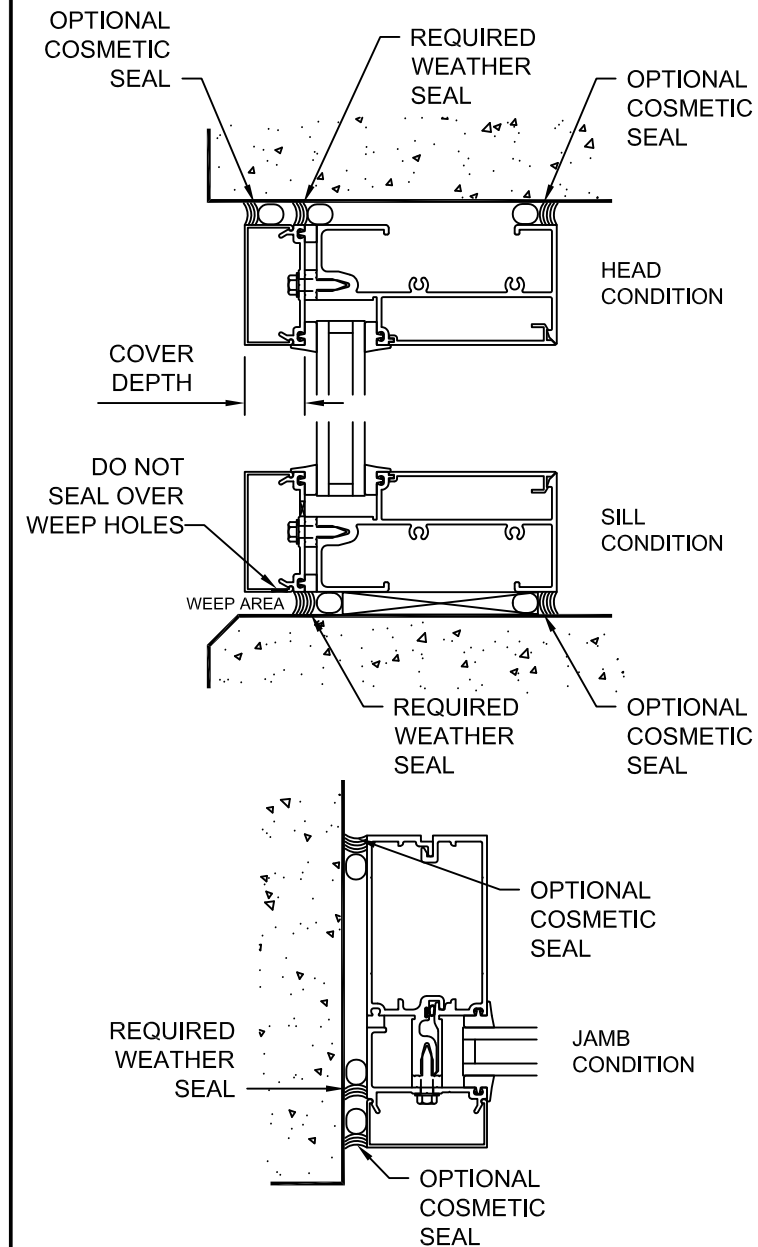
**** NOTE: SEALANT BETWEEN SHEET AND MULLION MUST EXTEND TO THE EDGE OF THE SHEET AT THIS LOCATION TO TIE TO PERIMETER SEAL.**

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INSTALL PERIMETER SEALS AT PRESSURE PLATE

Perimeter weather seals are installed at the pressure plate location as detailed below. (This seal should be installed before covers are applied when covers deeper than 3/4" are used) Exterior cosmetic seals at the cover may be applied at the head and jambs only. Sill covers must remain open to allow water drainage to the exterior.



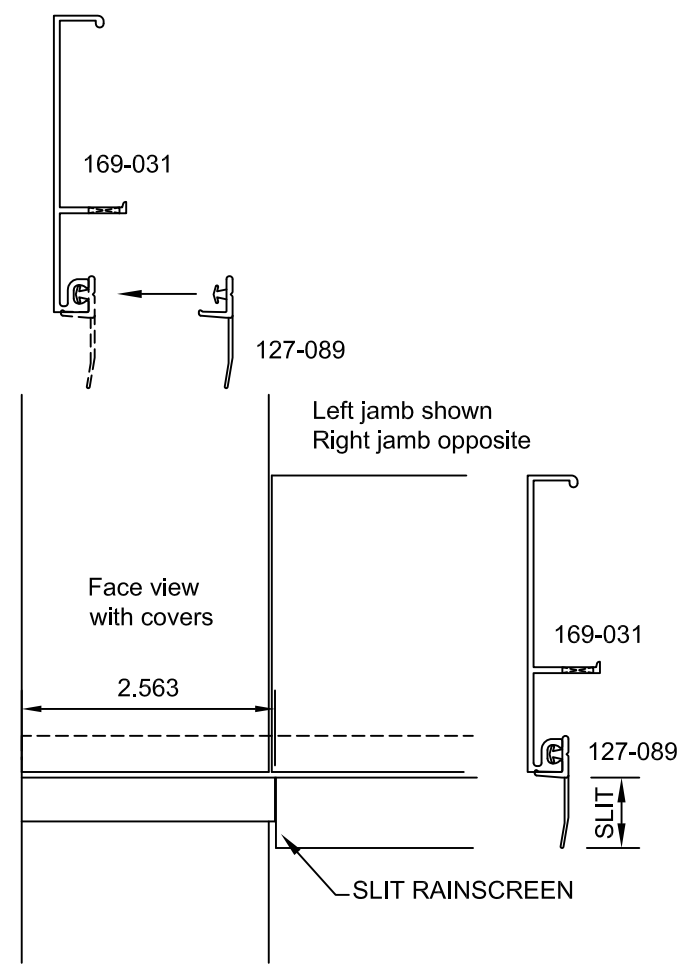
1600 SS SSG
PRE-GLAZED
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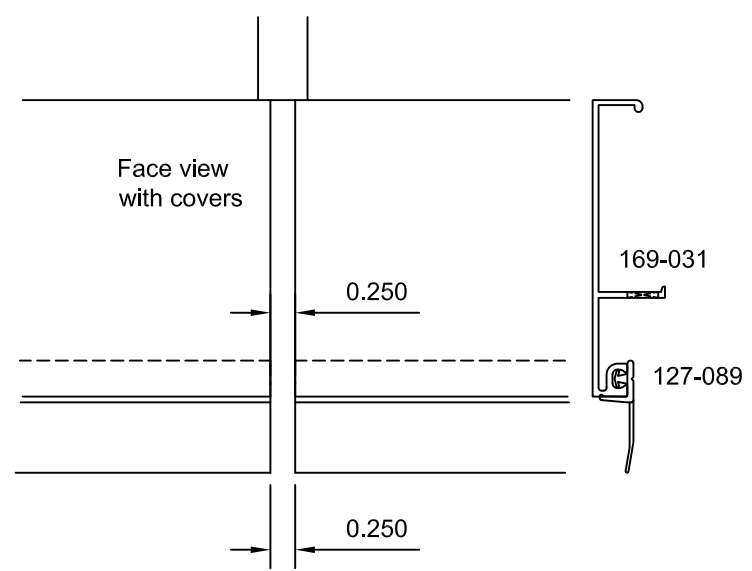
95505-019
04/26/13

APPLY 127-089 RAINSCREEN GASKET TO 169-031 HORIZONTAL COVERS

At left jamb units, gasket length is DLO + 3 11/16". Slit flap 2 9/16" from the left end and slit flap 1 1/4" from the right end for expansion joint movement. Right jamb units are opposite.

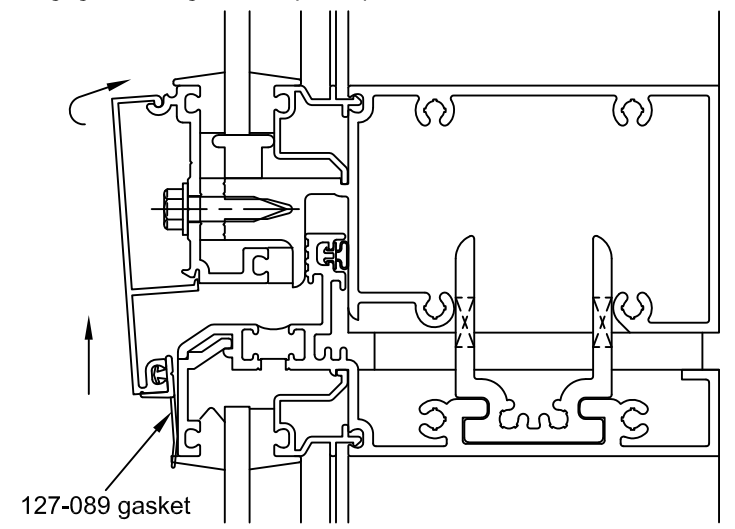


At intermediate SSG at a cover splice, gasket length is DLO + 2 1/4". Gasket runs thru at verticals where splice does not occur.

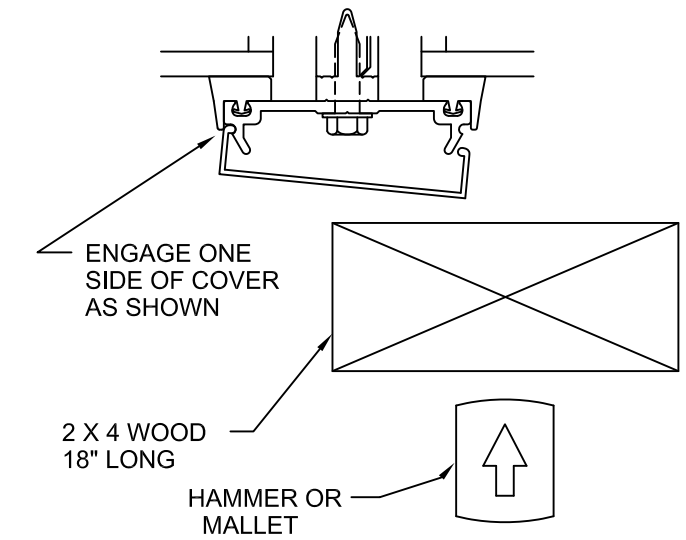


INSTALL EXTERIOR COVERS

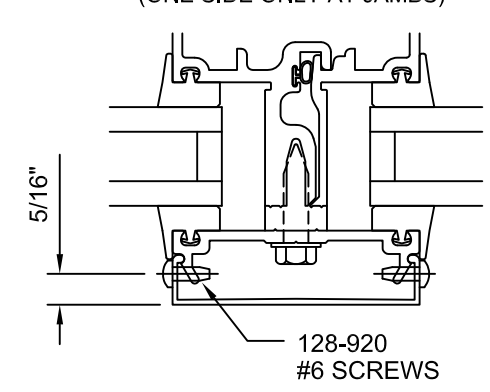
Care must be taken to avoid damage to covers during installation. Use a 18" long piece of 2 x 4 wood along with a hammer or mallet to seat the cover. Install expansion horizontal covers first due to 127-089 extensions at verticals. When applying cover, locate snap at top in lower engagement area and rotate lower half of the cover against glass. Slide cover up keeping hook leg in towards the bottom of the pressure plate. Rotate top over pressure plate engagement leg and snap into place.



Apply vertical covers where required. The 127-089 gasket extension is to be on the interior side of the bottom of the vertical cover at expansion horizontals.



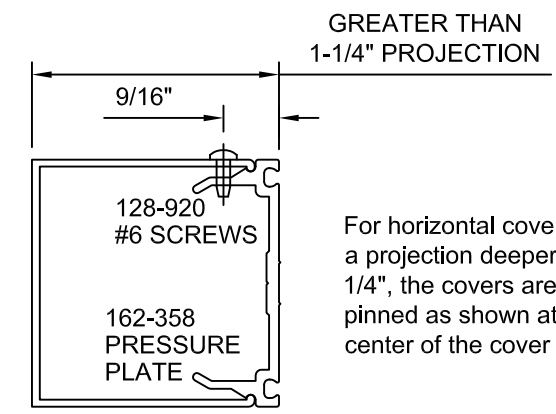
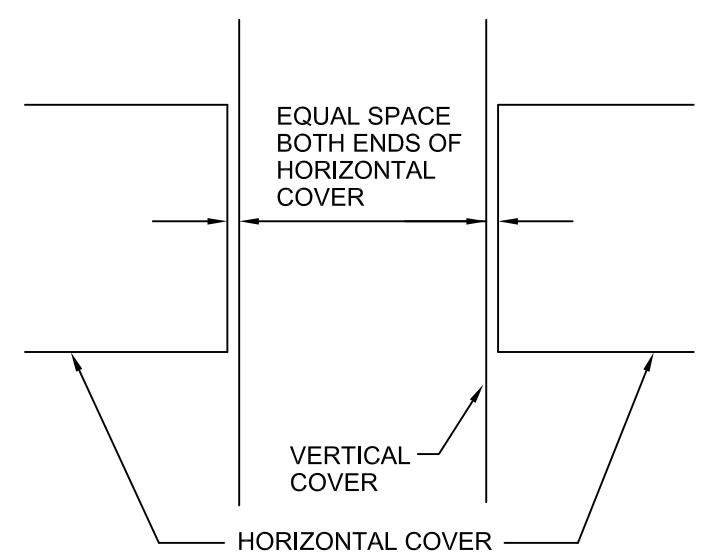
Pinning of all vertical covers is required for both sides. Drill a .106 dia. hole (#36 drill) and install 128-920 screws #6 x 3/8" pan head type b locate pinning at a horizontal closest to the cover height center. (ONE SIDE ONLY AT JAMBS)



INSTALL EXTERIOR COVERS

Apply horizontal covers.

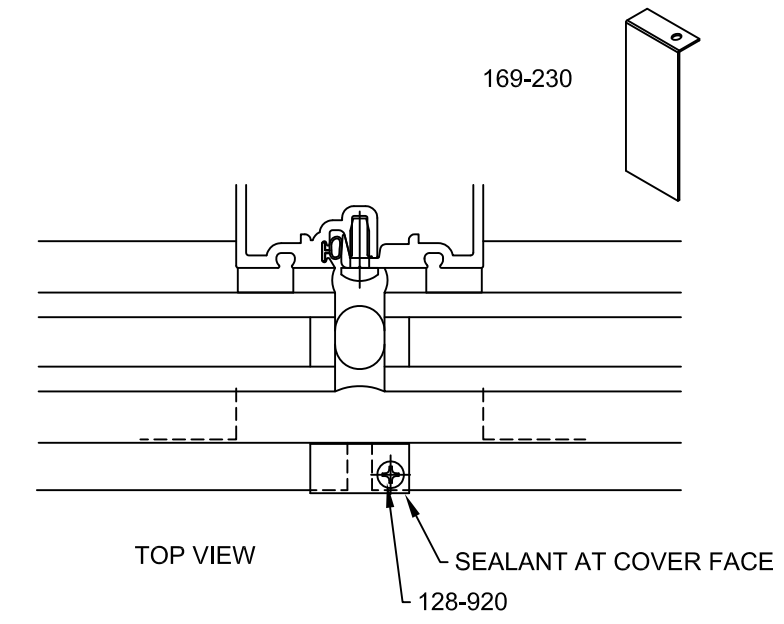
INSTALL HORIZONTAL COVERS WITH THE WEEP HOLES DOWN



For horizontal covers with a projection deeper than 1 1/4", the covers are to be pinned as shown at the center of the cover width.

APPLY 169-230 EXPANSION HORIZONTAL COVER SLEEVE

At expansion horizontal cover splices, match drill a .110 dia. [35 drill] hole in top of cover. Fix 169-230 cover sleeve to exterior of cover with one 128-920 #6 pan head. Also apply a small amount of sealant to face of cover on fixed side to secure in place.



REMOVING COVERS

Covers can be saved if tolerances are not too tight and the cover is removed with extreme care

