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KAWNEER COMPANY INC.

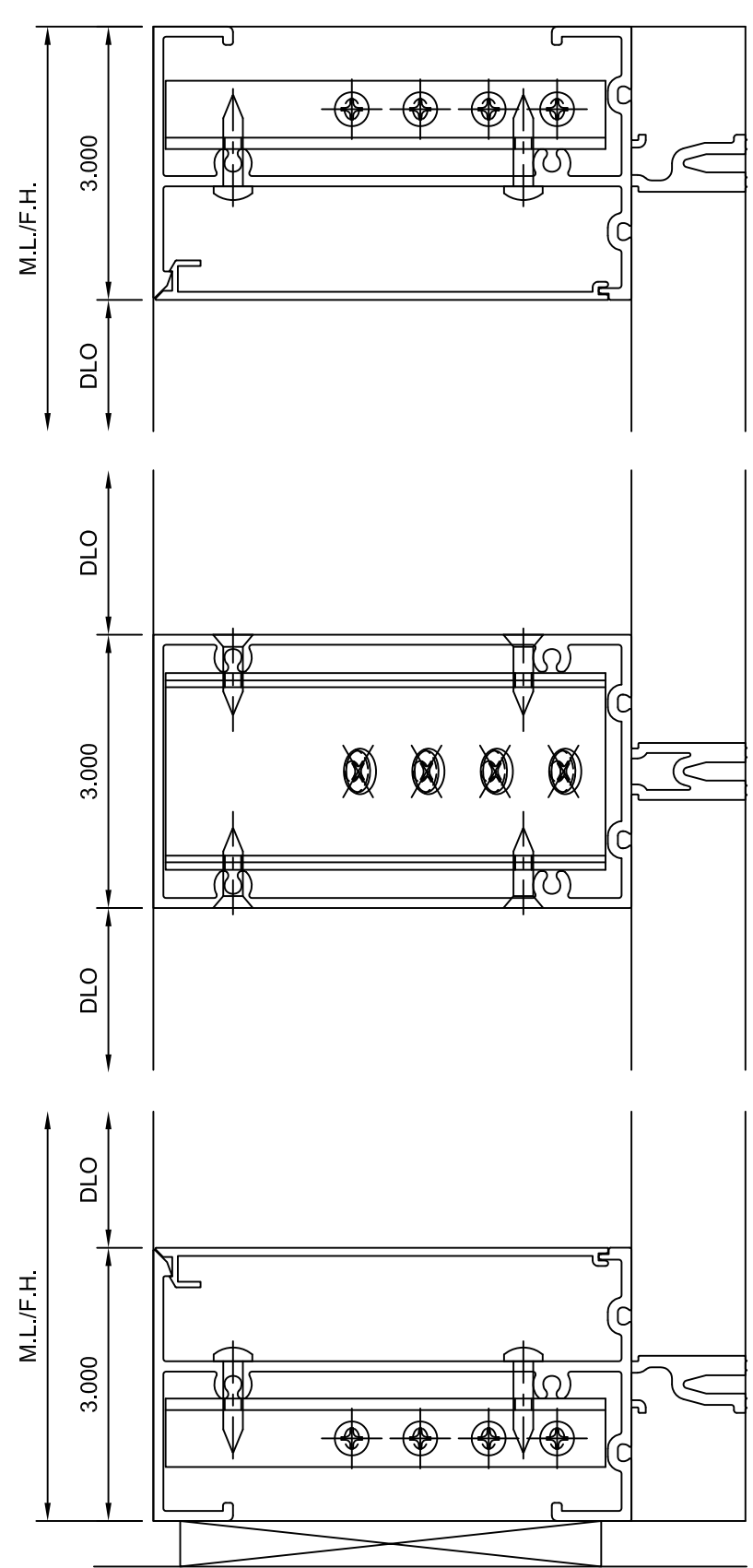
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USE THESE INSTRUCTIONS IN CONJUNCTION WITH 1600 SYSTEM 1 CORNER INSTALLATION INSTRUCTIONS 162972. USE STANDARD 162388 MULLION END CAPS AT CORNER MULLIONS IN LIEU OF CORNER END CAPS SHOWN IN THESE INSTRUCTIONS.

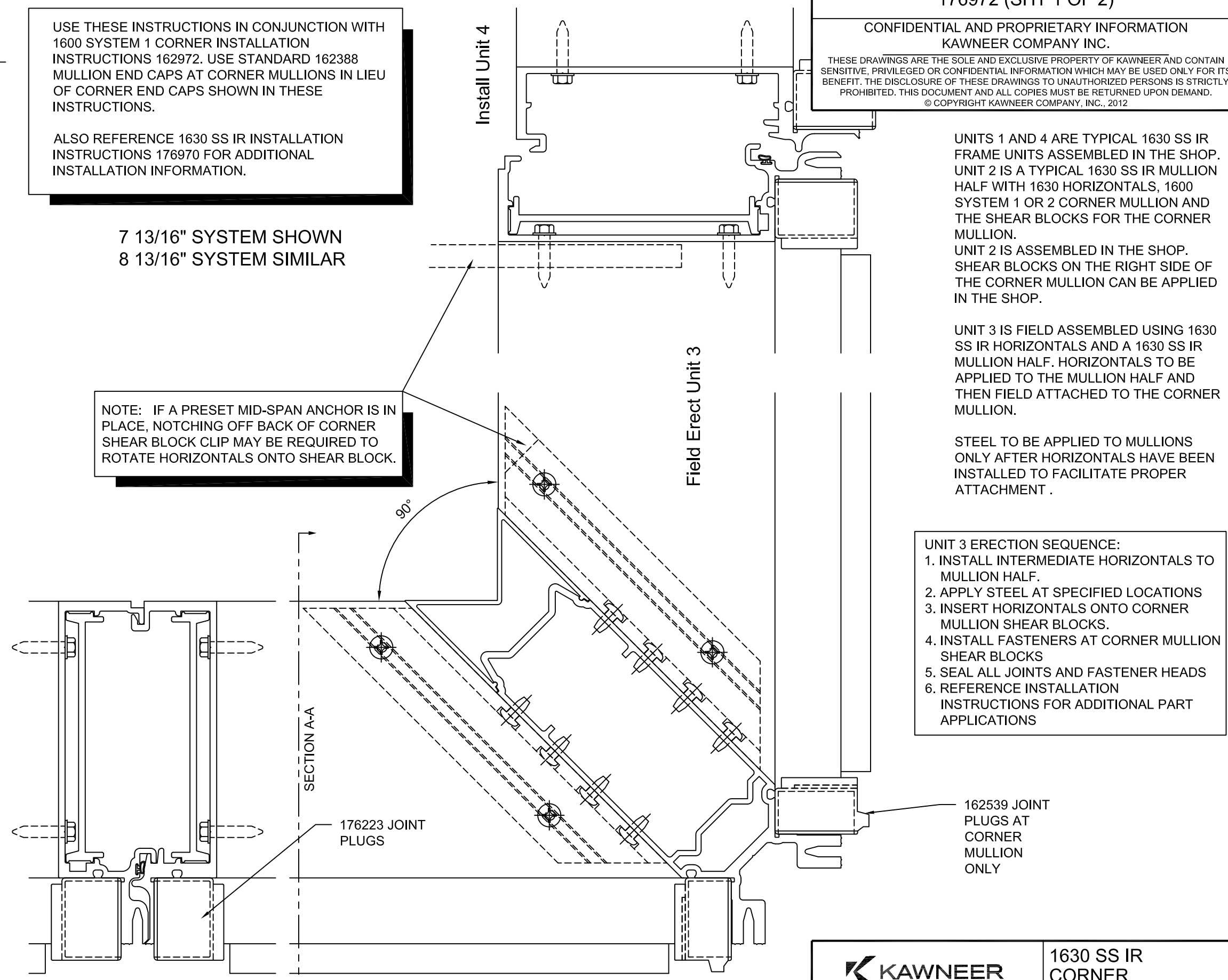
ALSO REFERENCE 1630 SS IR INSTALLATION INSTRUCTIONS 176970 FOR ADDITIONAL INSTALLATION INFORMATION.

7 13/16" SYSTEM SHOWN
8 13/16" SYSTEM SIMILAR

NOTE: IF A PRESET MID-SPAN ANCHOR IS IN PLACE, NOTCHING OFF BACK OF CORNER SHEAR BLOCK CLIP MAY BE REQUIRED TO ROTATE HORIZONTALS ONTO SHEAR BLOCK.



SECTION A-A



Install Unit 1

Install Unit 2
INTERMEDIATE MULLION, HORIZONTALS & CORNER MULLION

Field Erect Unit 3

Install Unit 4

UNITS 1 AND 4 ARE TYPICAL 1630 SS IR FRAME UNITS ASSEMBLED IN THE SHOP. UNIT 2 IS A TYPICAL 1630 SS IR MULLION HALF WITH 1630 HORIZONTALS, 1600 SYSTEM 1 OR 2 CORNER MULLION AND THE SHEAR BLOCKS FOR THE CORNER MULLION. UNIT 2 IS ASSEMBLED IN THE SHOP. SHEAR BLOCKS ON THE RIGHT SIDE OF THE CORNER MULLION CAN BE APPLIED IN THE SHOP.

UNIT 3 IS FIELD ASSEMBLED USING 1630 SS IR HORIZONTALS AND A 1630 SS IR MULLION HALF. HORIZONTALS TO BE APPLIED TO THE MULLION HALF AND THEN FIELD ATTACHED TO THE CORNER MULLION.

STEEL TO BE APPLIED TO MULLIONS ONLY AFTER HORIZONTALS HAVE BEEN INSTALLED TO FACILITATE PROPER ATTACHMENT .

- UNIT 3 ERECTION SEQUENCE:
1. INSTALL INTERMEDIATE HORIZONTALS TO MULLION HALF.
 2. APPLY STEEL AT SPECIFIED LOCATIONS
 3. INSERT HORIZONTALS ONTO CORNER MULLION SHEAR BLOCKS.
 4. INSTALL FASTENERS AT CORNER MULLION SHEAR BLOCKS
 5. SEAL ALL JOINTS AND FASTENER HEADS
 6. REFERENCE INSTALLATION INSTRUCTIONS FOR ADDITIONAL PART APPLICATIONS

162539 JOINT PLUGS AT CORNER MULLION ONLY

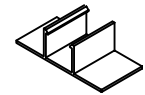


1630 SS IR
CORNER
INSTALLATION
INSTRUCTIONS

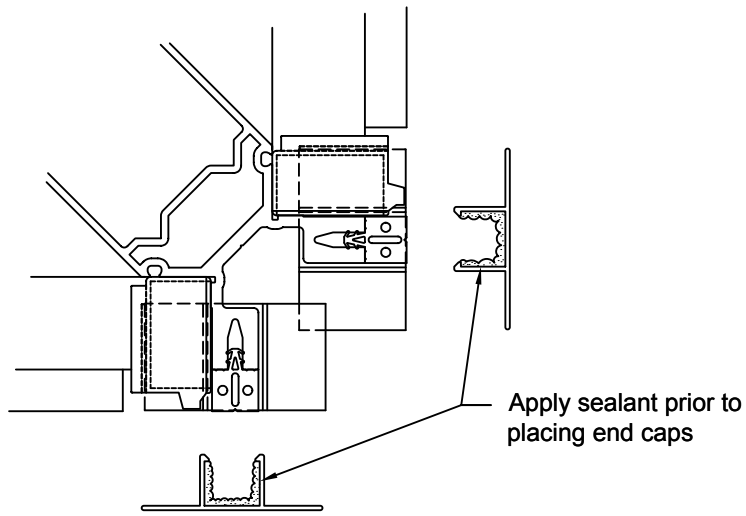
Product Engineering & Development

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02/22/13

INSTALL HEAD AND SILL END CAPS WHERE APPLICABLE

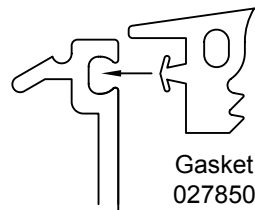


171309 End Cap
Set in sealant



**INSTALL EXTERIOR GASKETS INTO CORNER
PRESSURE PLATES**

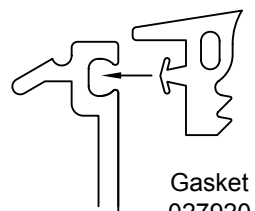
Typical 1630 SS IR gaskets have a larger than normal width and will interfere with the thermal separator during installation. Standard 1600 System 1 gaskets must be used at corners. Reference gasket notes in the 176970 installation instructions. Same notes apply.



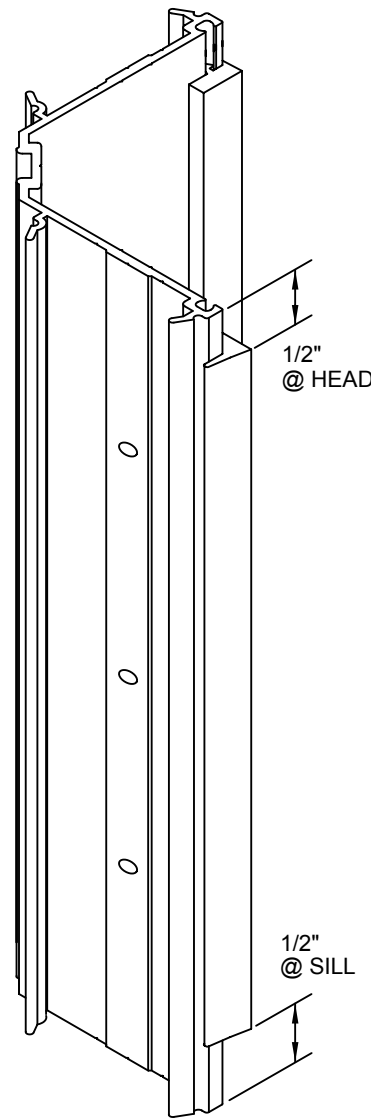
Gasket
027850

VERTICAL GASKETS ARE TO RUN CONTINUOUS EXCEPT AT HEAD AND SILL CONDITIONS THE GASKET IS TO BE CUT 1/2" SHORT. THIS IS FOR THE SEAL AT SECTION D-D SHEET # 11 in 176970 INSTRUCTIONS.

FOR LEVEL E WITH 0.18" INTERLAYER GLASS, USE 027920 GASKET

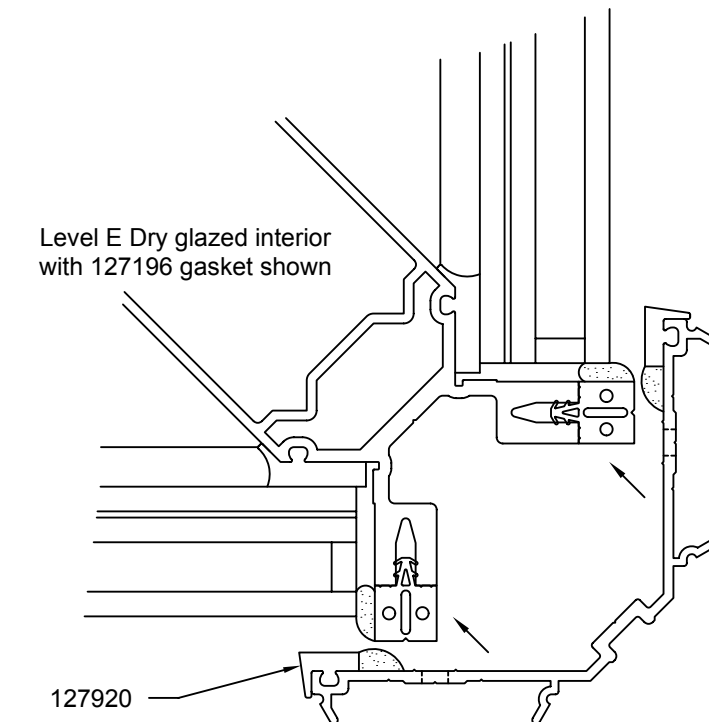
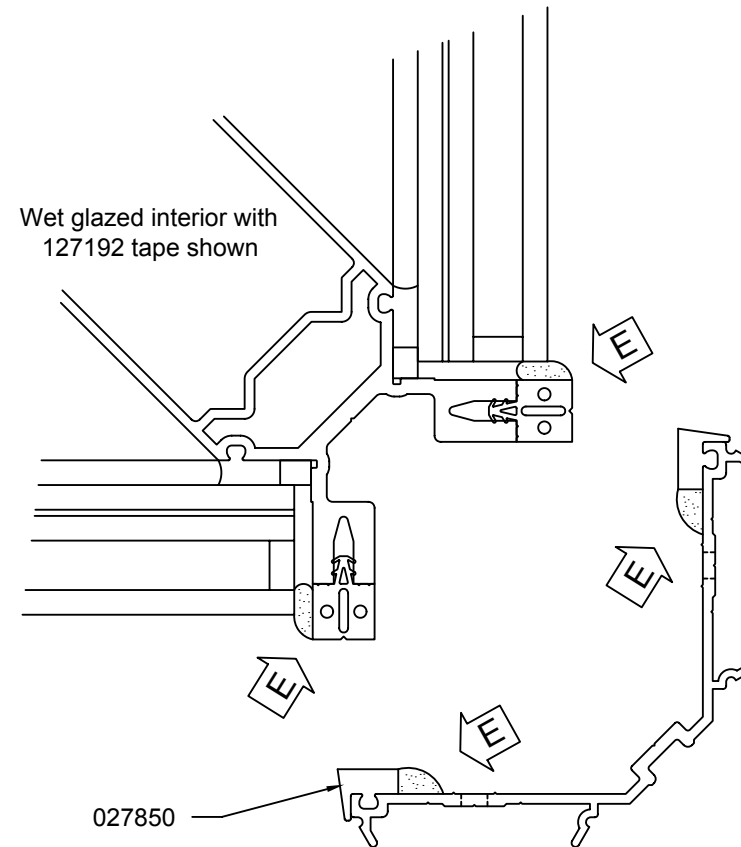


Gasket
027920
(Alt. gasket when using
Level E interlayer glass)



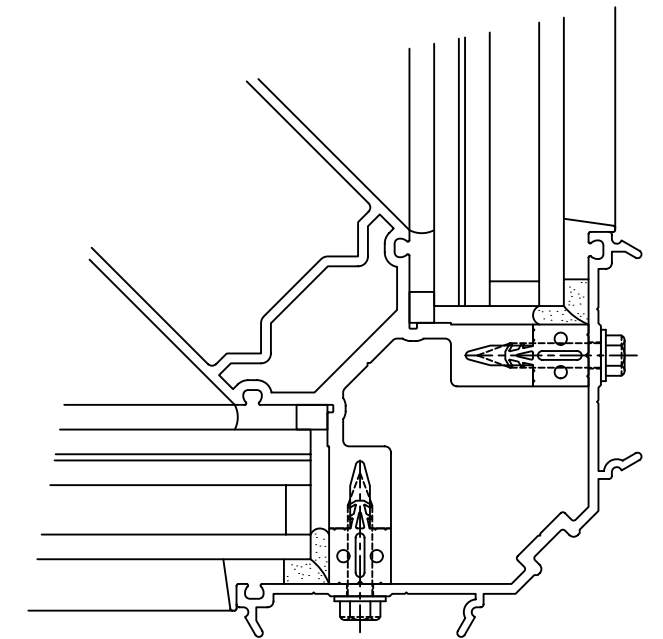
**INSTALL EXTERIOR GASKET SEAL AT LMI CORNER
PRESSURE PLATES**

Apply structural sealant at glass edge and along pressure plate gaskets. This is required to simulate the larger width gaskets. The larger width is needed to assist with stabilizing glass in the glazing pocket during impact and cycling events. After sealant is applied, install pressure plate as noted in standard installation instructions. Some sealant material will scrap off onto the face of the thermal separator during installation.

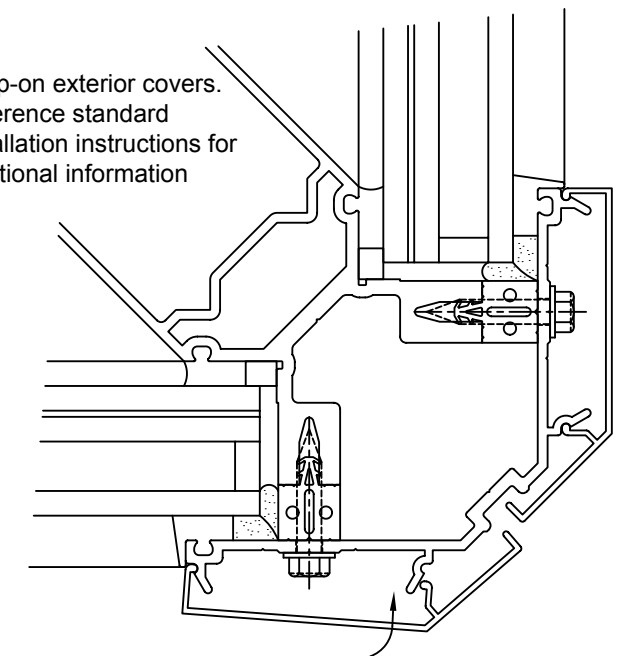


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Snap-on exterior covers.
Reference standard
installation instructions for
additional information



1630 SS IR
CORNER
INSTALLATION
INSTRUCTIONS

Product Engineering & Development

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07/19/13