

**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.

**2500 PG WALL - 4 SIDE SSG NOTES**

This SSG system is available with 1" and 1/4" framing members. Members are designed for 1" infill at vision and spandrel lites. Members for 1/4" infill are designed for spandrel lites below expansion horizontals.

The glass bite is typically 7/8" at verticals and horizontals. The glass bite at the sill of the units is 1 1/4". At elevation jambs and elevation sills, captured members are used and the glass bite will be 1/2". Glass sizes must be calculated from approved shop drawings.

This system is designed to allow 1/2" total movement at the expansion horizontal.

2500 PG Wall systems are designed to be assembled in your shop. Adequate floor space should be made available for storage of glass and materials, staging, assembly, glazing and packing of units. Accommodations should also be made for handling of glass and glazed units. Retain structural silicone batch numbers and tests performed per sealant manufacturer's recommendations.

If insulation is applied to the units in your shop, additional precautions must be taken to protect it from getting wet during shipping and after installation.

Setting blocks at SSG horizontals should be made of silicone material.

Units should be assembled, packed, shipped and staged at the job site in order of unit installation to reduce additional handling.

Installation of sill starter tracks and anchors must be completed prior to installation of units. Separate aluminum sill starter track and anchors from concrete and steel building substrates.

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.

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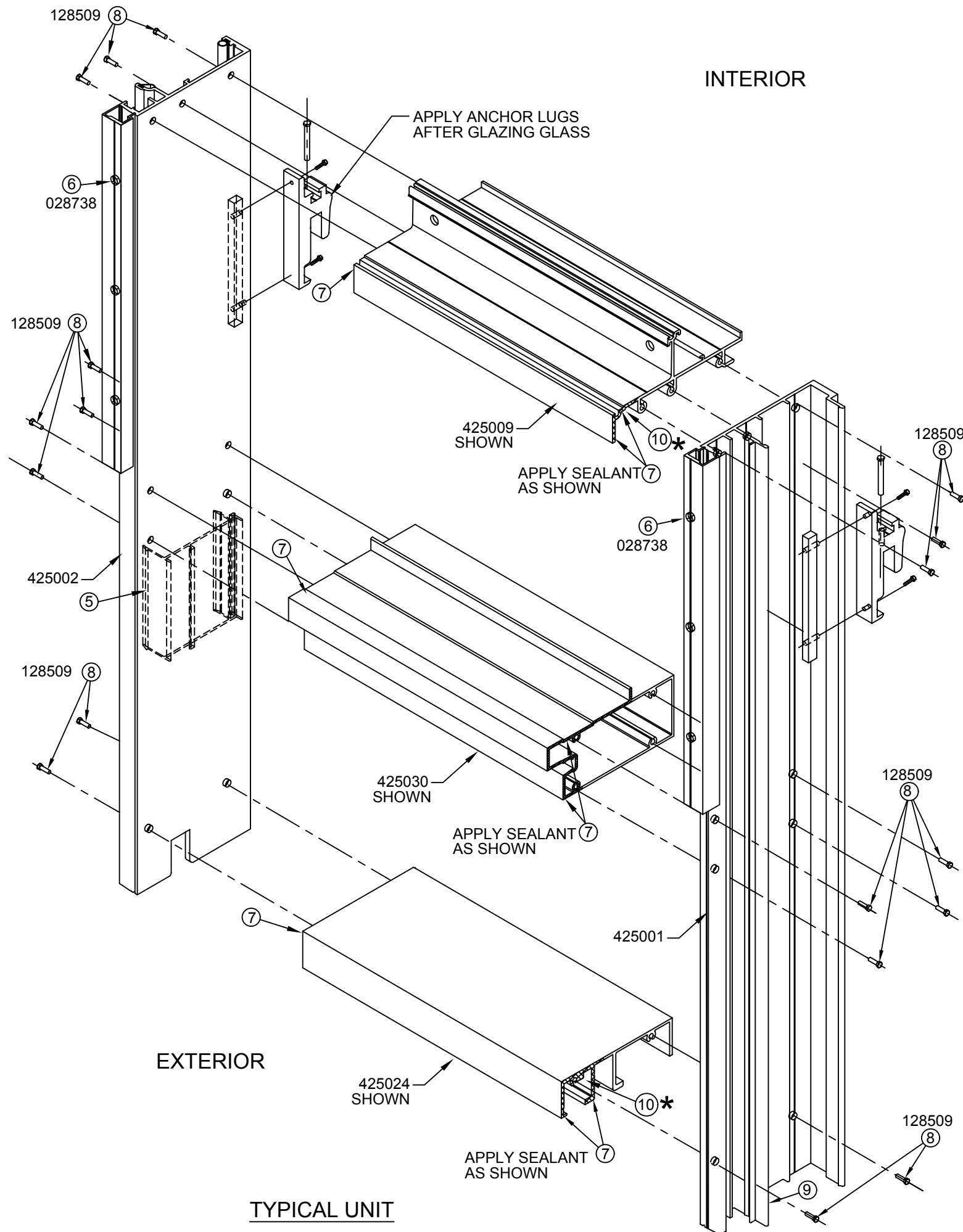
2500 PG WALL  
4 SIDE SSG  
INSTALLATION  
INSTRUCTIONS

Product Engineering & Development

95500-07  
06/27/08

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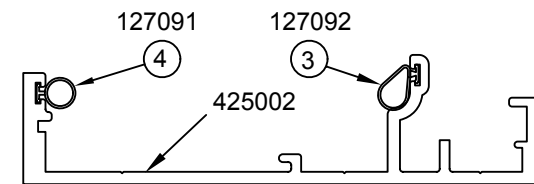
**A UNIT ASSEMBLY**  
VIEWED FROM THE EXTERIOR

**PLEASE NOTE:** TYPICALLY UNITS ARE TO BE ASSEMBLED WITH THE 425002 MULLION HALF ON THE LEFT OF THE UNIT AND WITH THE 425001 MULLION HALF ON THE RIGHT OF THE UNIT (VIEWED FROM EXTERIOR OF UNIT). PLEASE REFER TO SHOP DRAWINGS FOR PROPER MULLION HALF REQUIRED AT LEFT AND RIGHT JAMB UNITS.

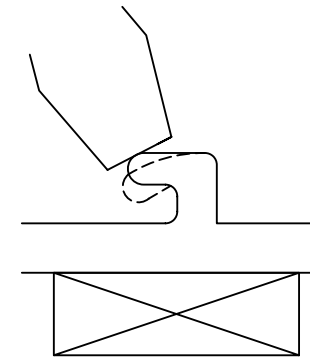
**FOR PROPER FABRICATION & ERECTION, REFER TO THE FABRICATION & SHOP DRAWINGS.**

- ① LAYOUT PARTS.
- ② CHECK THAT ALL PREPS HAVE BEEN APPLIED AND LOCATED IN THE PROPER POSITION PER APPROVED SHOP DRAWINGS.
- ③ SLIDE IN 127092 BULB GASKET AT THE MIDDLE LEG OF THE 425002 MULLION HALF. THE WIDE PART OF THE BULB SHOULD BE TOWARDS THE MULLION HALF SIDE WALL. APPLY SEALANT IN REGLET TO KEEP PART FROM SLIDING OUT DURING UNIT INSTALLATION. GASKET TO RUN FULL LENGTH OF MULLION.
- ④ SLIDE IN 127091 BULB GASKET AT THE BACK OF THE 425002 MULLION HALF. CRIMP IN PLACE OR APPLY SEALANT IN REGLET TO KEEP PART FROM SLIDING OUT DURING UNIT INSTALLATION. GASKET TO RUN FULL LENGTH OF MULLION.

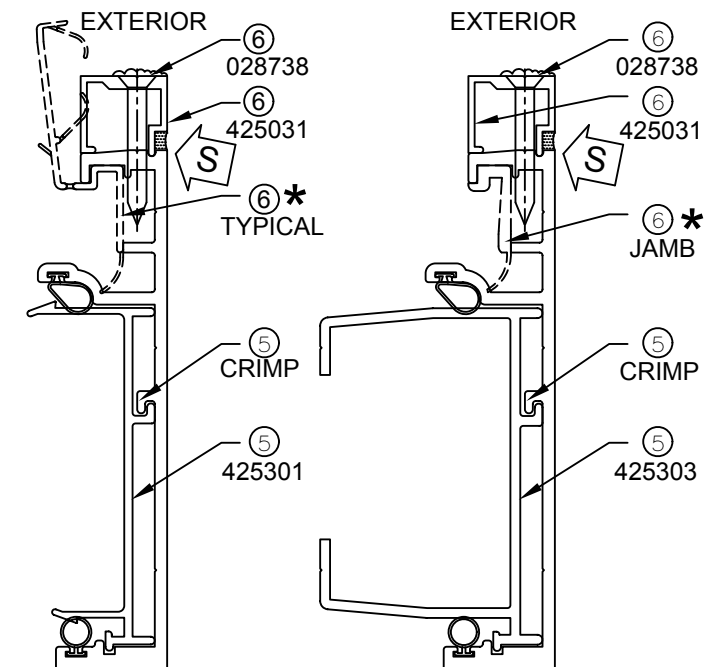
**SPECIAL NOTE**  
DO NOT SPLICE THE 127092 GASKET. THIS WEATHERING WILL CREATE THE AIR AND WATER SEAL.



**CRIMP NOTE**  
DURING ALL CRIMPING OPERATIONS, BEND EXTENDED LEG ONLY. PROVIDE SUPPORT ON OPPOSITE SIDE TO PREVENT CRAZING OF VISIBLE ANODIZED OR PAINTED SURFACES.



- ⑤ INSTALL (3) 425301 MULLION INTERLOCK CLIPS INTO THE 425002 MULLION HALF. LOCATE C/L OF CLIPS AT 1/3 POINTS BETWEEN ANCHOR PREP AND BOTTOM OF MULLION AND 6" FROM BOTTOM OF MULLION. CRIMP IN PLACE. AT JAMBS, INSTALL (3) 425303 JAMB LOCK CLIPS INTO THE 425002 MULLION HALF. LOCATE C/L OF CLIPS 6" FROM TOP AND BOTTOM AND AT CENTER OF JAMB MULLION. CRIMP IN PLACE. NOTE: IF CLIPS LAND AT AN ANCHOR LUG OR HORIZONTAL LOCATION, CRIMP CLIPS IN PLACE JUST ABOVE OR BELOW TO ALLOW FOR TAPPING BAR OR SCREW INSTALLATION.
- ⑥ AT 1/4" SPANDREL AREAS, APPLY 425031 VERTICAL ADAPTER TO MULLION HALVES. REFERENCE APPROVED SHOP DRAWINGS FOR LOCATIONS. MATCH DRILL .166" DIA. (#19 DRILL) HOLES IN MULLIONS FOR 028738 #10 x 1 1/2" AB FHTF FASTENER @ 18" ON CENTER AND APPLY ADAPTER.
  - \* NOTE: 028738 SCREWS MUST NOT INTERFERE WITH THE APPLICATION OF ISOLATORS. CLEAN AND APPLY SEALANT BETWEEN MULLION AND ADAPTER. TOOL SEALANT. SEAL OVER FASTENER HEADS AND TOOL FLAT. KEEP SEALANT, WHERE GLAZING TAPE IS APPLIED, TO A MINIMUM TO ASSURE TAPE ADHESION.



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2500 PG WALL  
4 SIDE SSG  
INSTALLATION  
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REFERENCE TYPICAL UNIT DETAIL ON PREVIOUS SHEET FOR STEPS 7 THROUGH 10.

- 7 CLEAN, PRIME AND BUTTER BOTH ENDS OF HORIZONTALS WITH SEALANT PER TYP. UNIT DETAIL AND APPROVED SHOP DRAWINGS.

HEAD HORIZONTAL: SEAL AT THE FRONT LEG AND 1" BACK AT TOP OF FRONT LEG.  
INTERMEDIATE HORIZONTALS: SEAL AT THE FRONT OF TUBE BACK TO 1ST SCREW SPLINES.  
SILL HORIZONTAL: SEAL AT THE FRONT LEG, 1ST INTERMEDIATE LEG AND 2" BACK ALONG TOP OF HORIZONTAL.

- 8 POSITION HORIZONTAL MEMBERS ALIGNING SPLINES WITH SCREW HOLES AND ASSEMBLE WITH 128509 #12 x 1" AB HWHTF FASTENERS. WAX SCREWS PRIOR TO INSTALLATION. WHEN APPLYING OPPOSITE SIDE MULLION HALF, DO NOT TIGHTEN SCREWS UNTIL ALL HORIZONTALS HAVE BEEN APPLIED TO KEEP FROM WIPING OFF THE SEALANT WITH MULLION DURING HORIZONTAL INSTALLATION. WIPE OFF EXCESS SEALANT AT VISION AREAS. THOROUGHLY SEAL OVER ALL FASTENER HEADS.

\* NOTE: DO NOT BUILD UP SEALANT ENOUGH TO INTERFERE WITH THE INSTALLATION OF OF ISOLATORS AND KEEP SEALANT OUT OF POCKET FOR ISOLATORS.

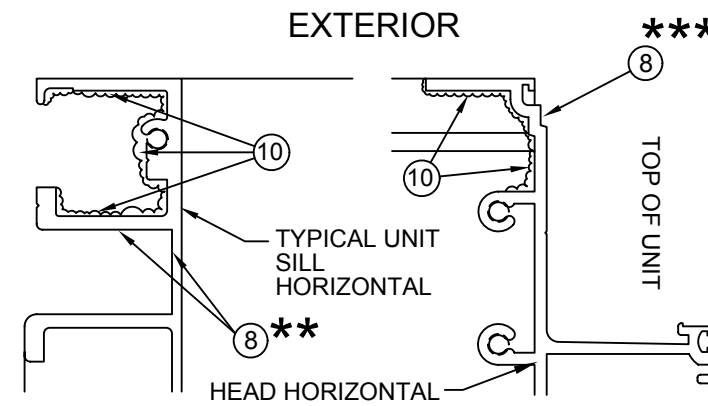
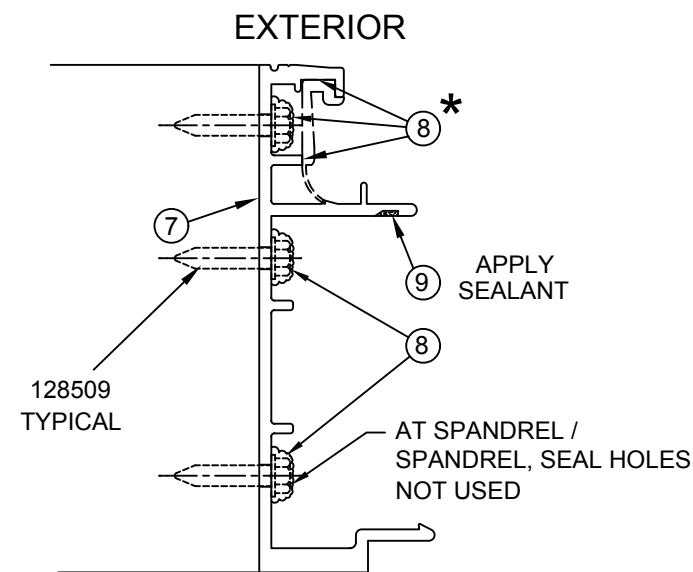
\*\* NOTE: TOOL EXCESS SEALANT FLAT.

\*\*\* NOTE: TOOL EXCESS SEALANT FLAT AT TOP OF MULLION.

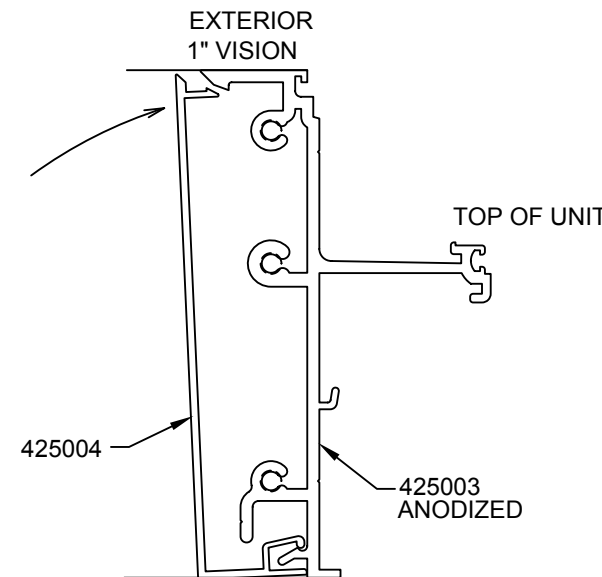
**CRITICAL:**

- 9 APPLY SEALANT IN GROOVE FROM BOTTOM OF 425001 MULLION HALF UP 4" AND TOOL FLUSH.

- 10 FILLET SEAL THE INSIDE OF THE HEAD AND SILL HORIZONTALS TO VERTICAL. TOOL SEALANT. CHECK ALL SEALS AROUND HORIZONTALS TO VERTICALS AND APPLY SEALANT TO ANY AREAS WHERE SEALANT MAY HAVE BEEN WIPED OFF DURING ASSEMBLY.



- 11 WHEN THE TOP LITE OF GLASS IN A UNIT IS 1" VISION, HOOK AND SNAP 425004 INTERIOR SNAP TRIM TO THE UNDERSIDE OF HEAD HORIZONTAL.



- 12 INSTALL BACK PANS IN SPANDREL LITES AS REQUIRED. SEE APPROVED SHOP DRAWINGS. SHIM AND SEAL AS REQUIRED.

- 13 INSTALL INSULATION IN SPANDREL LITES AS REQUIRED. APPLY BACK-UP ANGLES, IMPALING PINS AND INSULATION PER MANUFACTURER'S RECOMMENDATIONS AND APPROVED SHOP DRAWINGS.

- 14 INSTALL STEEL OR ALUMINUM REINFORCING AS REQUIRED TO THE MULLION HALVES PER APPROVED SHOP DRAWINGS. SHIM AND FASTEN AS REQUIRED. COORDINATE INSTALLATION OF STEEL WITH ANCHOR LUG BACK-UP INSTALLATION TO BE COMPLETED AFTER GLAZING.

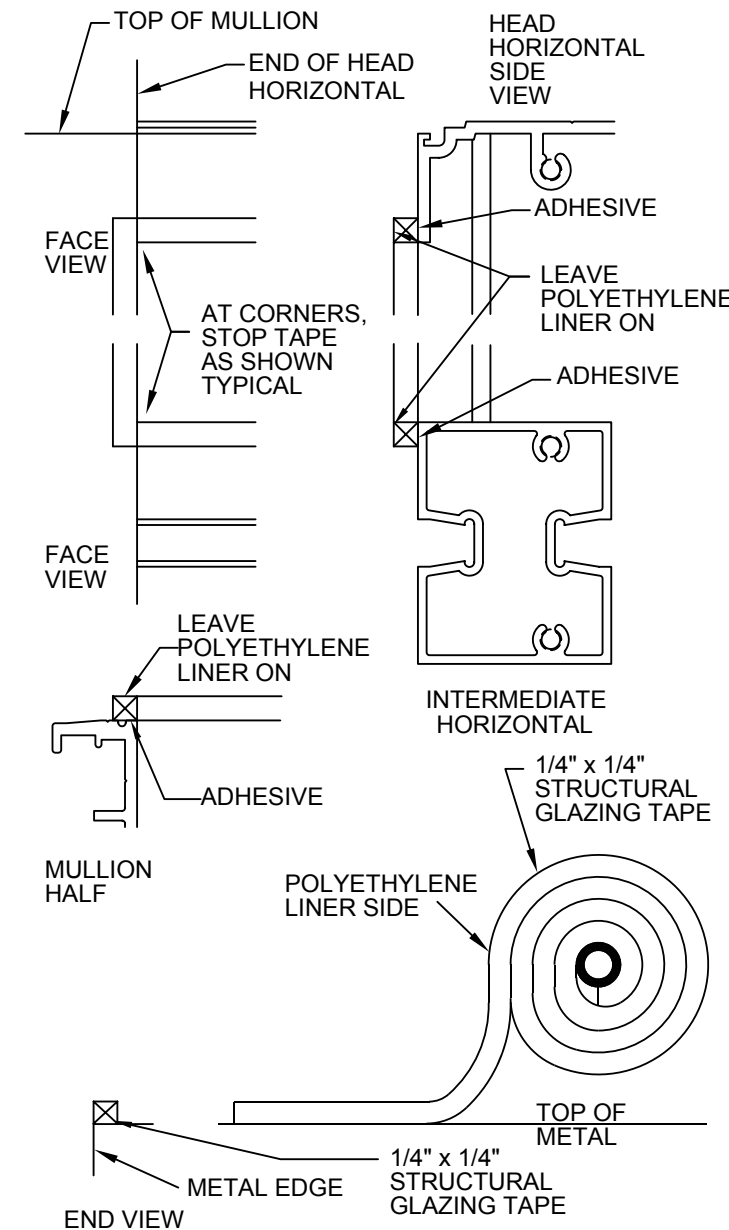
**B GLAZING OF GLASS**

- 1 LAY THE UNIT ON A FLAT SURFACE WITH THE EXTERIOR FACING UP AND PREPARE ALUMINUM SURFACE. TABLE MUST BE FLAT AND MUST SUPPORT FRAME AT ALL LOCATIONS. A UNIT GLAZED IN A DEFLECTED POSITION WILL CAUSE INSTALLATION PROBLEMS.

**CRITICAL:**  
PREPARATION OF ALUMINUM AND GLASS SURFACES AND PROPER CURING TIME ARE TO BE EXACTLY AS OUTLINED BY THE SEALANT MANUFACTURER'S SPECIFICATIONS AND RECOMMENDATIONS.

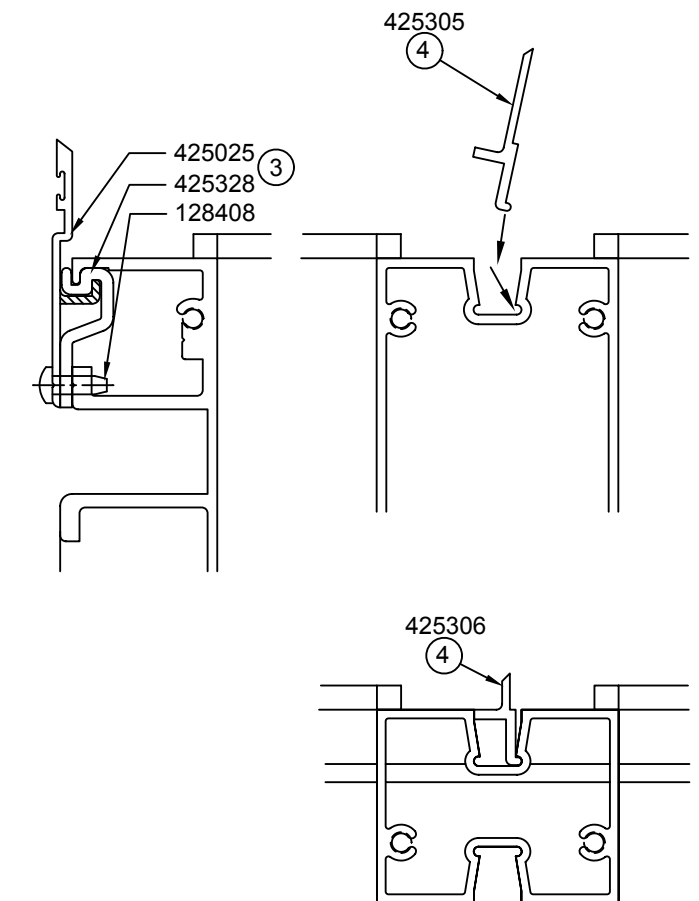
**APPLYING SPACER**

- 2 INSTALL 127095 1/4" x 1/4" (2) SIDED ADHESIVE STRUCTURAL GLAZING SPACER AROUND ALL LITES TYPICAL. SEE APPROVED SHOP DRAWINGS FOR LOCATIONS. AS A FINAL STEP, APPLY PRESSURE TO ENTIRE LENGTH OF SPACER TO ENSURE ADHESION. IF TAPE DOES NOT ADHERE, SILICONE WILL BLOW-OUT TAPE LEAVING EXCESS SILICONE AT THE INTERIOR SURFACE.



- 3 ROTATE CONTINUOUS 425328 ISOLATOR INTO POSITION IN THE SILL HORIZONTAL. ISOLATOR TO RUN DLO - 1/8". APPLY CONTINUOUS 425025 SILL GLASS CHAIR INTO 425328 ISOLATOR. MATCH DRILL .166" DIA. (#19 DRILL) HOLES IN ISOLATOR AND HORIZONTAL AND APPLY 128408 #10 x 9/16" PHTF TO HOLD IN PLACE. ALL SCREWS ARE NOT NEEDED AT THIS TIME.

- 4 AT INTERMEDIATE SSG HORIZONTALS, ROTATE 4 1/2" LONG GLASS CHAIRS INTO PLACE AT 1/4" POINTS. USE 425305 AT 1" INFILL AND 425030 HORIZONTAL. USE 425306 AT 1/4" INFILL.



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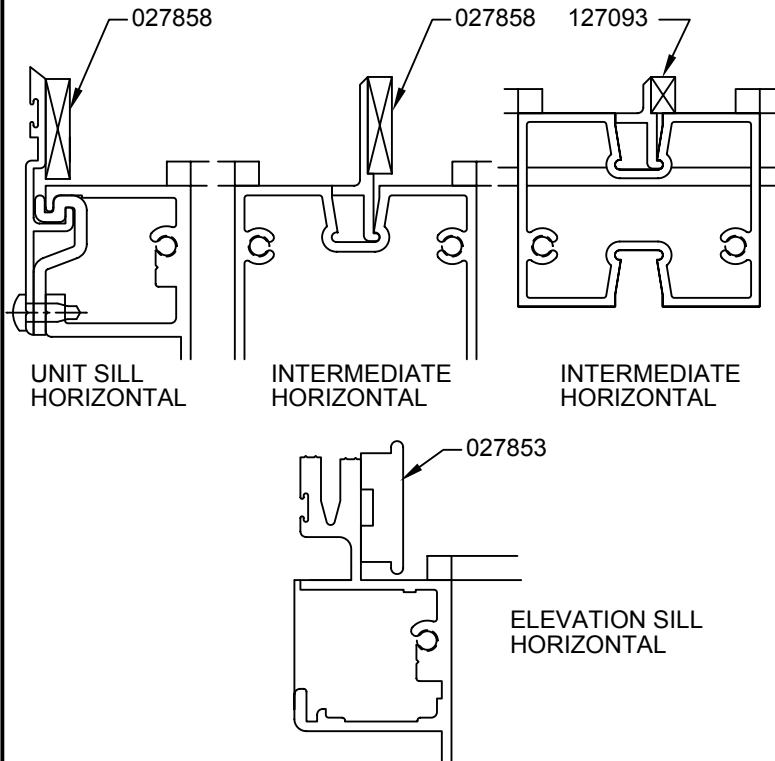
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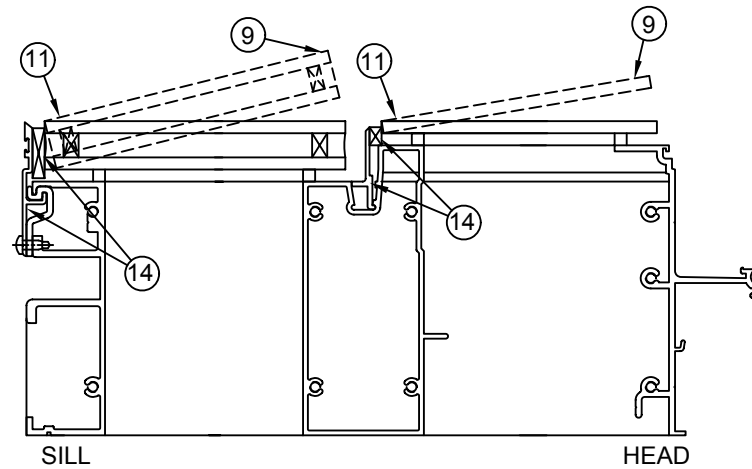
2500 PG WALL  
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- 5 APPLY (2) SETTING BLOCKS AT ALL HORIZONTALS AT 1/4 POINTS AS SHOWN.

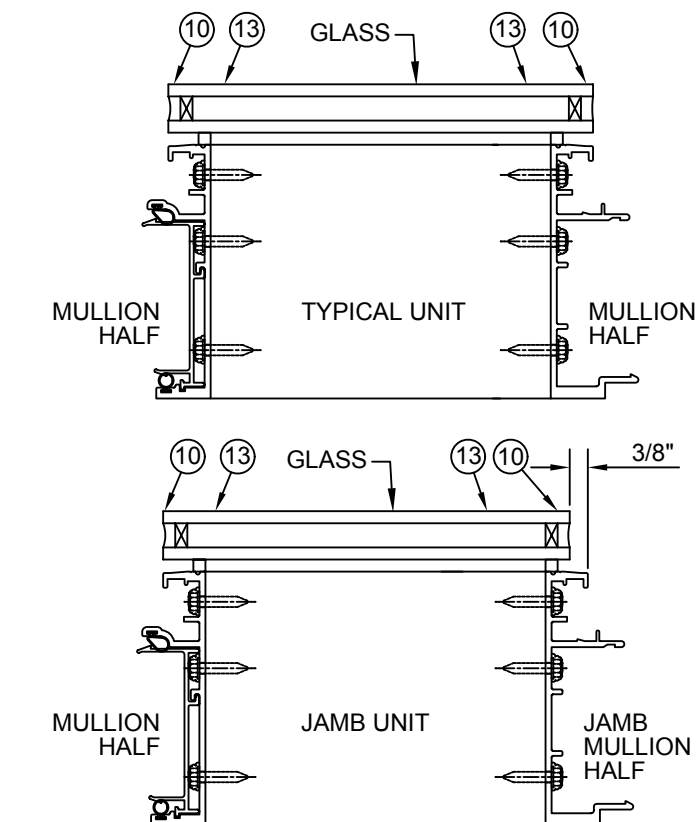
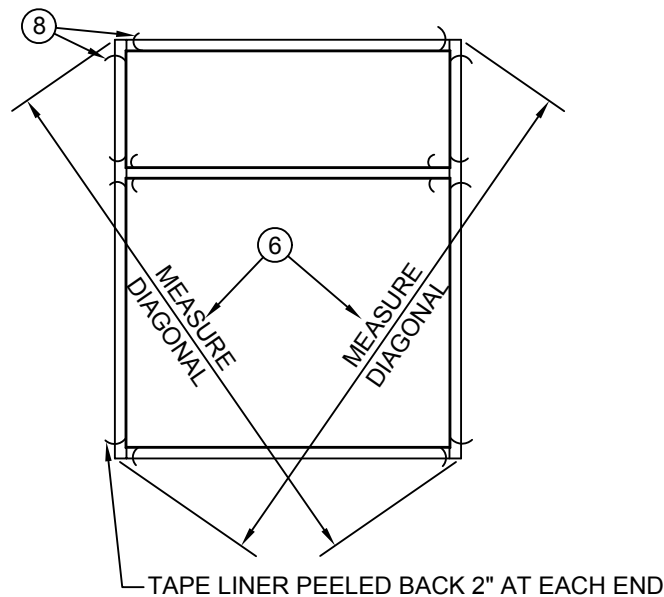


- 9 LINE UP GLASS AS SHOWN (SEE BELOW)  
 10 LOCATE GLASS WIDTHWISE. GLASS EDGES MUST ALIGN WITH PREVIOUS GLASS INSTALLED ON UNIT.  
 11 INSTALL GLASS BY PUSHING BOTTOM EDGE AGAINST BOTH SETTING BLOCKS AND LOWER INTO PLACE.  
 12 WHEN GLASS IS SQUARED AND CENTERED, PRESS DOWN ON CORNERS TO OBTAIN ADHESION, REMOVE REMAINING POLYETHYLENE LINER FROM TAPE.  
 13 APPLY PRESSURE ALONG ALL (4) SIDES OF GLASS BEING SURE GLASS COMES INTO CONTINUOUS CONTACT WITH ADHESIVE SPACER.  
 14 REMOVE ALL GLASS CHAIRS AND SETTING BLOCKS.  
 REFERENCE SHOP DETAILS AND GLAZING DETAILS FOR NON TYPICAL CONDITIONS.

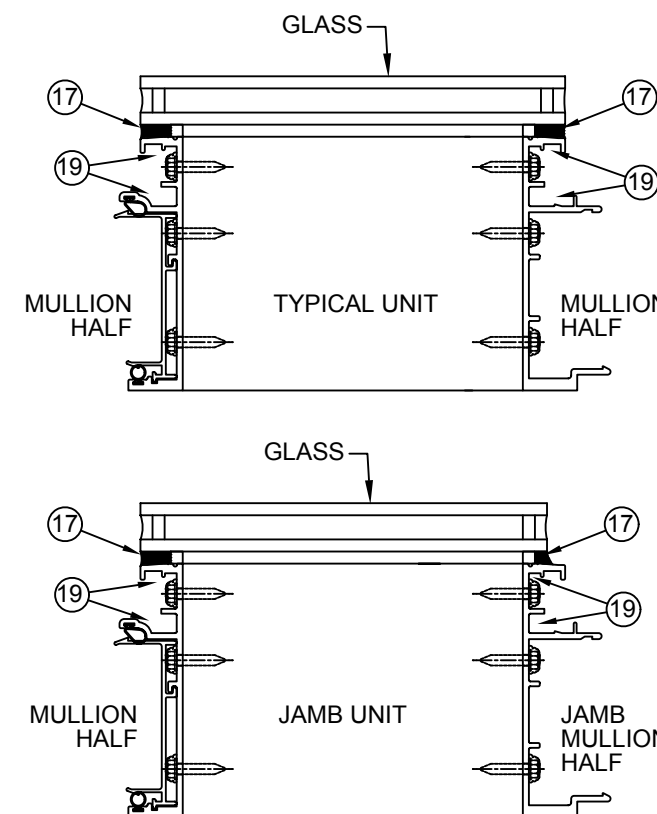
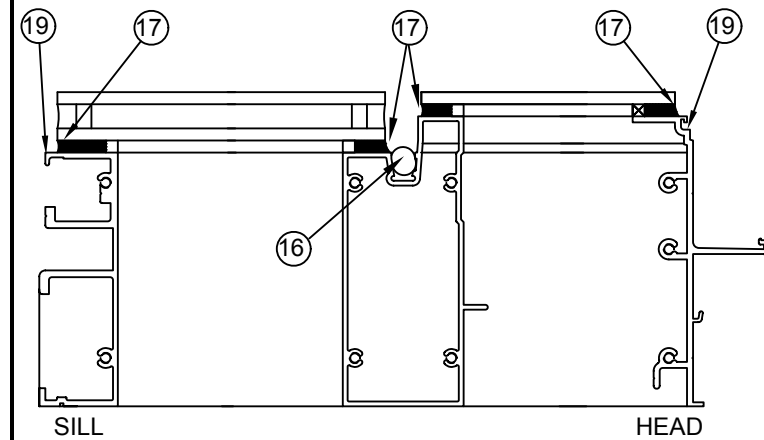


**CRITICAL:**

- 6 SQUARE AND 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.  
 A UNIT GLAZED IN A "OUT OF SQUARE" OR BOWED POSITION WILL CAUSE INSTALLATION PROBLEMS.  
 7 CLEAN GLASS PER SEALANT MANUFACTURER'S RECOMMENDATIONS, BOTH AT TAPE AND SILICONE CONTACT SURFACES.  
 8 PEEL BACK LINER OF STRUCTURAL GLAZING TAPE 2" AT EACH END JUST PRIOR TO SETTING GLASS.

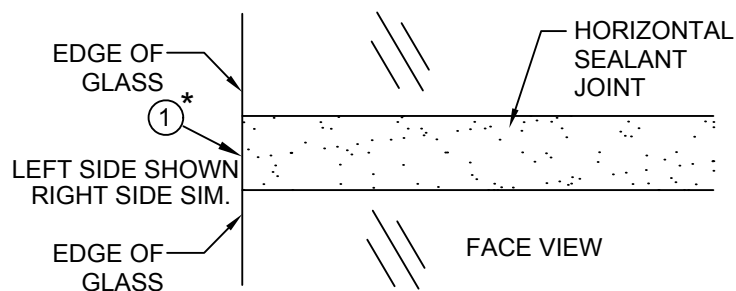
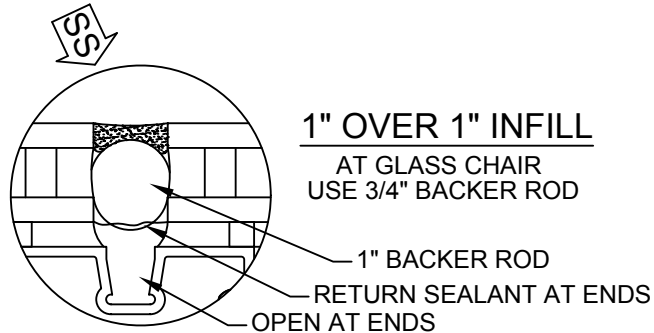
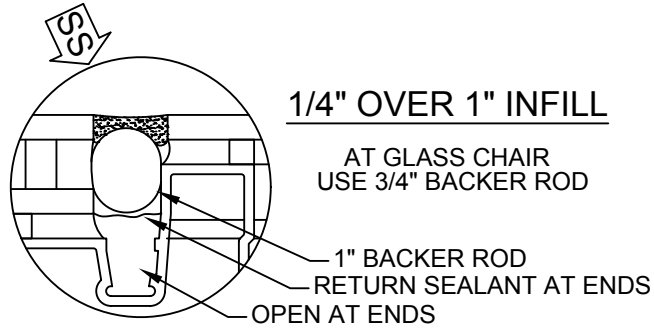
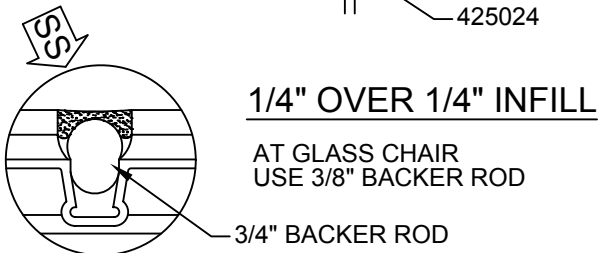
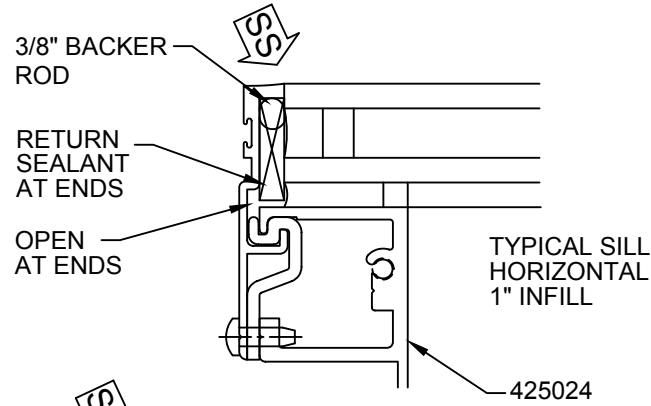


- 15 CHECK TO INSURE THAT GLASS AND METAL SURFACES ARE CLEAN AND PREPARED PER SEALANT MANUFACTURER'S SPECIFICATIONS AND RECOMMENDATIONS.  
 16 APPLY 6" PIECE OF BACKER ROD IN CAVITY AT 1/4 POINTS PRIOR TO SHOOTING SILICONE TO KEEP AREA CLEAN FOR INSTALLATION OF SETTING BLOCK CHAIRS.  
 17 APPLY STRUCTURAL SILICONE SEALANT COMPLETELY FILLING JOINT.  
 18 TOOL SEALANT. TOOL EXCESS SEALANT FLAT OVER HORIZONTAL TO VERTICAL JOINTS.  
 19 CLEAN OUT ANY EXCESS SEALANT IN HORIZONTAL GROOVE AND ENGAGEMENT AREAS. AREAS CAN BE TAPED TO KEEP SEALANT OUT PRIOR TO APPLYING SILICONE IF NECESSARY.  
 20 REAPPLY GLASS CHAIRS AND SETTING BLOCKS.

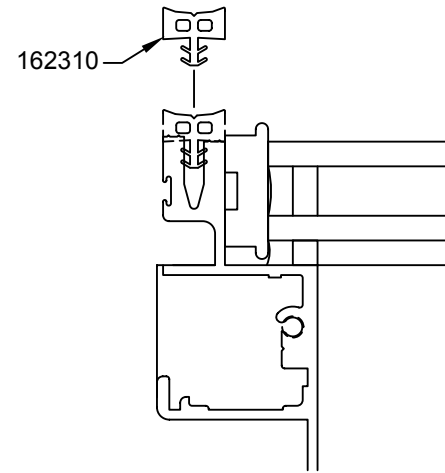


**C APPLYING MISC. PARTS, GASKETS AND WEATHER SEALS**

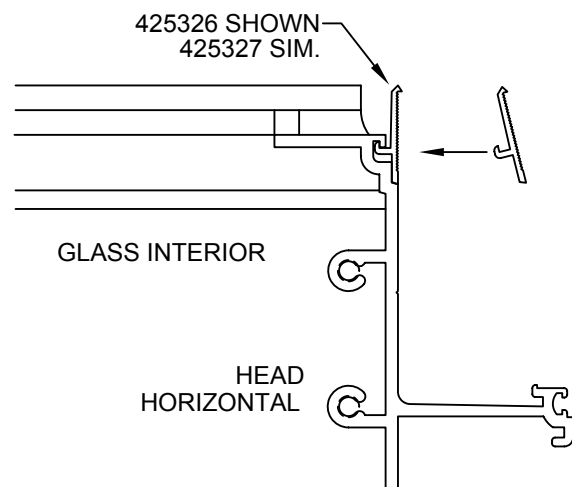
1 APPLY WEATHER SEALS AT HORIZONTALS AS SHOWN. CHECK TO INSURE THAT GLASS AND METAL SURFACES ARE CLEAN AND PREPARED PER SEALANT MANUFACTURER'S SPECIFICATIONS AND RECOMMENDATIONS. AT 1" INFILL, RETURN SEALANT AT ENDS TO BACK OF GLASS. \*NOTE: AT ALL WEATHERSEAL ENDS, SQUARE OFF SEALANT WITH SIDES OF GLASS TO FORM A FLAT VERTICAL LINE WITH EDGE OF GLASS.



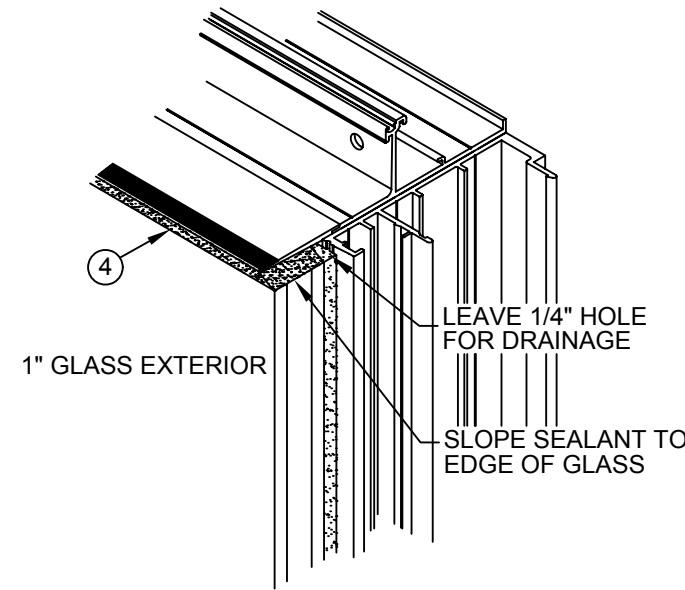
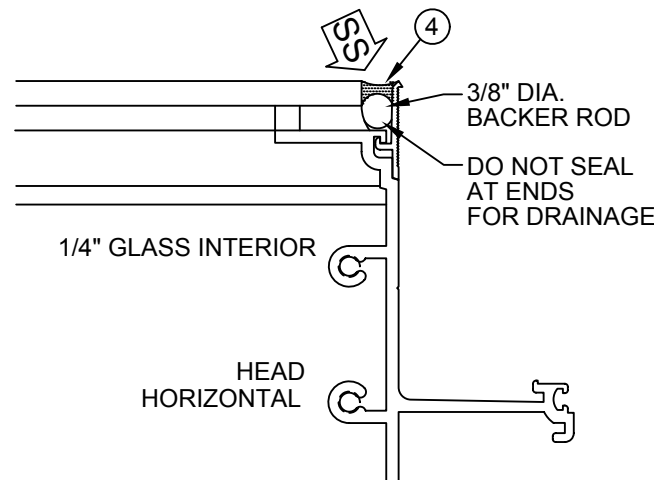
2 AT ELEVATION SILL UNITS ONLY: PUSH-IN 162310 THERMAL BREAK INTO ALL CAPTURED HORIZONTAL TONGUES. APPLY THERMAL BREAK FULL LENGTH OF HORIZONTAL.



3 AT 1/4" INFILL, ROTATE AND HOOK IN 425326 PVC EDGE PROTECTOR. PART RUNS DLO MINUS 1/8". AT 1" INFILL, ROTATE AND HOOK IN 425327 PVC EDGE PROTECTOR. PART RUNS DLO MINUS 1/8".

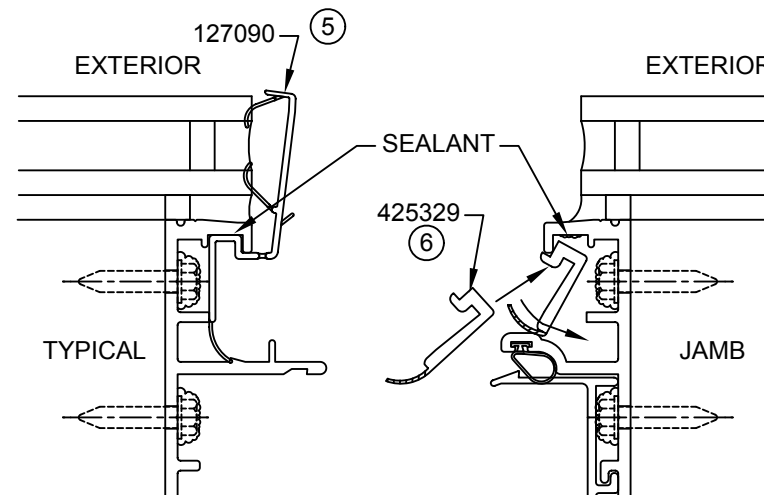


4 PUSH IN 3/8" BACKER ROD AND SEAL. TOOL SEALANT. DO NOT SEAL ENDS AT 1/4" INFILL. AT 1" INFILL, SLOPE SILICONE OUT TO END OF GLASS LEAVING A 1/4" HOLE BETWEEN STRUCTURAL SILICONE AND EDGE PROTECTOR.



5 APPLY 127090 VERTICAL RAINSCREEN GASKET AT SSG MULLIONS. APPLY SMALL AMOUNT OF SEALANT AT 1/4 POINTS OF EACH LITE TO HOLD IN PLACE. RUN GASKET MULLION LENGTH. RUN FINGER ALONG FLAP TO PUSH INTO POSITION. PART CAN BE SLID IN FROM THE END IN LIEU OF ROLLED INTO PLACE.

6 APPLY 425329 VERTICAL ISOLATOR AT JAMB CAPTURED MULLIONS. APPLY SMALL AMOUNT OF SEALANT IN A FEW AREAS TO HOLD IN PLACE. ISOLATOR TO RUN MULLION LENGTH. RUN FINGER ALONG FLAP TO PUSH INTO POSITION. PART CAN BE SLID IN FROM THE END IN LIEU OF ROLLED INTO PLACE.



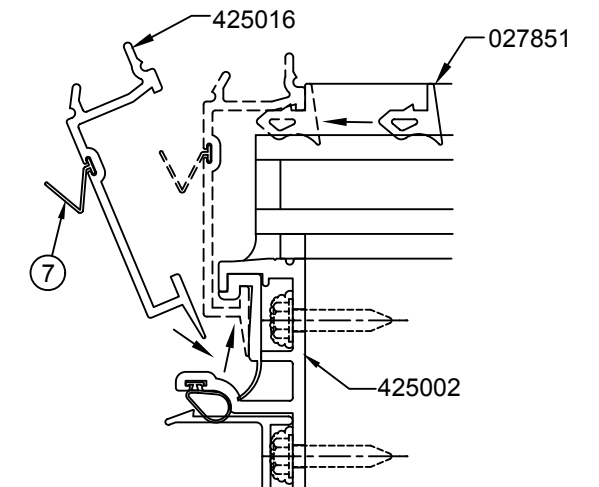
7 FOR JAMBS ONLY, SLIDE IN 127086 HINGED RAINSCREEN GASKET IN 425016 GLASS RETAINERS. RUN GASKET FULL LENGTH OF GLASS RETAINER AND TRIM EXCESS. APPLY SEALANT IN REGLET TO HOLD IN PLACE.

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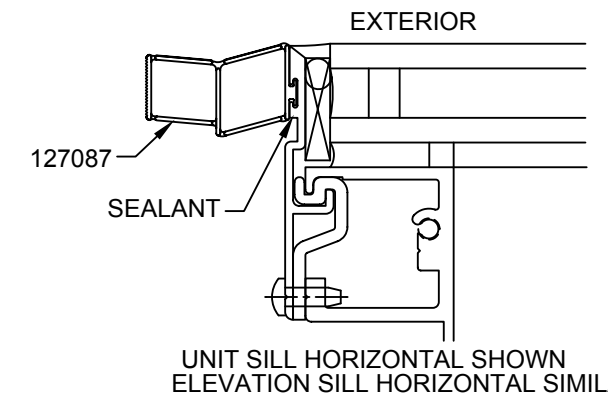
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8 AT TYPICAL JAMBS ONLY, ROTATE 425016 GLASS RETAINER INTO MULLION HALF. WEDGE 027851 GASKET CONTINUOUS BETWEEN RETAINER AND GLASS. GASKET TO RUN FULL LENGTH OF GLASS RETAINER. ALIGN WITH TOP OF MULLION. AT JAMBS AT ELEVATION SILL HORIZONTAL ONLY, STOP 027851 WEDGE GASKET 1 3/8" SHORT OF BOTTOM OF GLASS RETAINER.

IF THE INSTALLATION OF THE WEDGE REQUIRES EXCESSIVE FORCE OR THE WEDGE DOES NOT PROVIDE ENOUGH COMPRESSION ON THE EXTERIOR FIXED GASKET, CONTACT YOUR KAWNEER PROJECT MANAGER IMMEDIATELY.



9 THE 127087 STACK RAINSCREEN GASKET RUNS UNIT REFERENCE DIMENSION MINUS 1/4". SLIDE-IN GASKET AT UNIT SILL HORIZONTAL. APPLY A FEW SPOTS OF SEALANT IN REGLET TO HOLD GASKET IN PLACE. LOCATE CENTER OF GASKET WITH CENTER OF UNIT. AT JAMBS, GASKET RUNS UNIT REFERENCE DIMENSION PLUS 1 1/8". LOCATE END OF GASKET 2 1/4" BEYOND DLO ON JAMB SIDE.



Product Engineering & Development

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2500 PG WALL  
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**D AT ELEVATION SILL  
INSTALL EXTERIOR GLAZING GASKETS**

GASKET MATERIAL, GASKET GROOVES AND POCKETS SHOULD BE CLEAN.

IN TEMPERATURES COLDER THAN 50° F ARRANGEMENTS SHOULD BE MADE TO WARM GASKETS BEFORE INSTALLATION. THIS WILL PREVENT EXCESSIVE GLAZING PRESSURE ON THE GLASS DUE TO COLD STIFF RUBBER GASKETS.

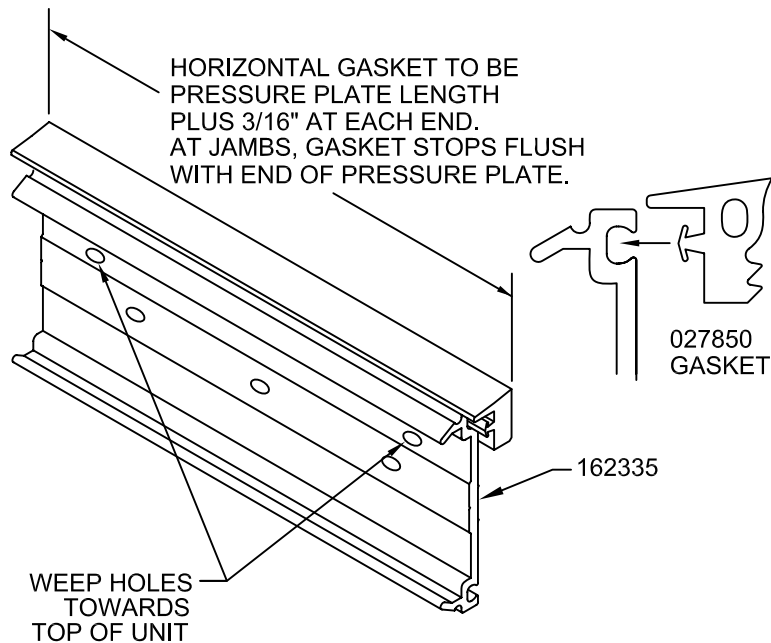
GASKETS CAN BECOME SOMEWHAT DEFORMED DURING STORAGE IN CARTONS. THEY SHOULD BE REMOVED FROM CARTONS SEVERAL HOURS PRIOR TO GLAZING AND LAID FLAT OR HUNG TO ALLOW RECOVERY OF CORRECT SHAPE. TEMPERATURES SHOULD BE AT LEAST 50° F TO ALLOW THIS.

GASKET INSTALLED LENGTH TO BE DAYLITE 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".

ELEVATION SILL HORIZONTAL PRESSURE PLATE LENGTH = TYPICAL UNITS = DLO+2" JAMB UNITS = DLO-3/16"+1"

- ① PUSH-IN 027850 GASKET INTO PRESSURE PLATE GLAZING POCKETS.



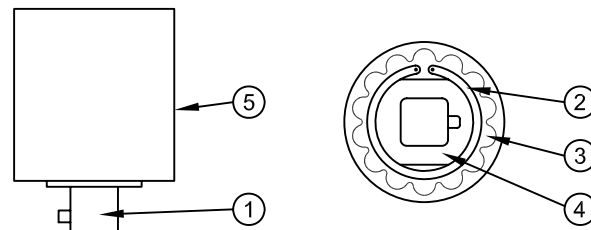
**E AT ELEVATION SILL  
INSTALL HORIZONTAL PRESSURE PLATES**



RECOMMEND USING TORQUE LIMIT TOOL 162399. SEE NOTE BELOW.

**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 128406 1/4-14 x 1" HEX WASHER HEAD TYPE AB

SCREWS ARE TO BE LOCATED 9" ON CENTER. ALWAYS LOCATE A SCREW AT THE ENDS AT THE HORIZONTAL JOINT. THIS WILL PROVIDE MAXIMUM PRESSURE FOR THE CRITICAL JOINT SEALS.

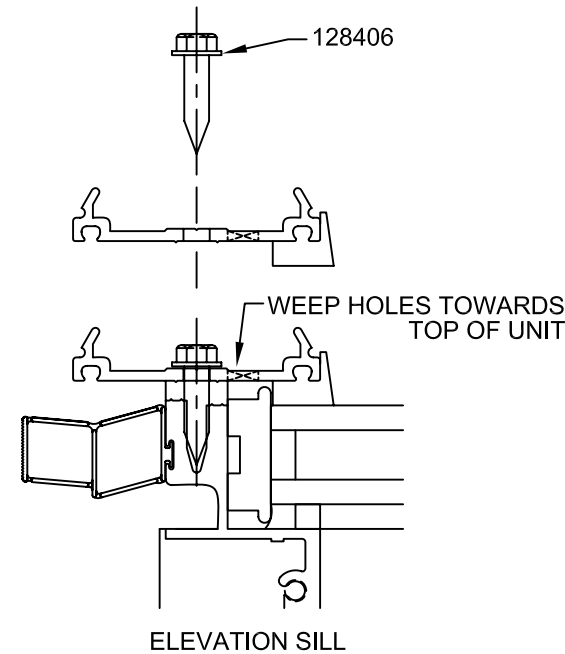
AT EACH HORIZONTAL PRESSURE PLATE, INSTALL TWO SCREWS PART WAY, THEN INSTALL THE THIRD SCREW ALL THE WAY, AND THEN TIGHTEN THE FIRST TWO SCREWS. THIS ELIMINATES LATERAL WALKING OF THE PRESSURE PLATE POSITION.

TORQUE ALL SCREWS TO 95 TO 100 INCH POUNDS.

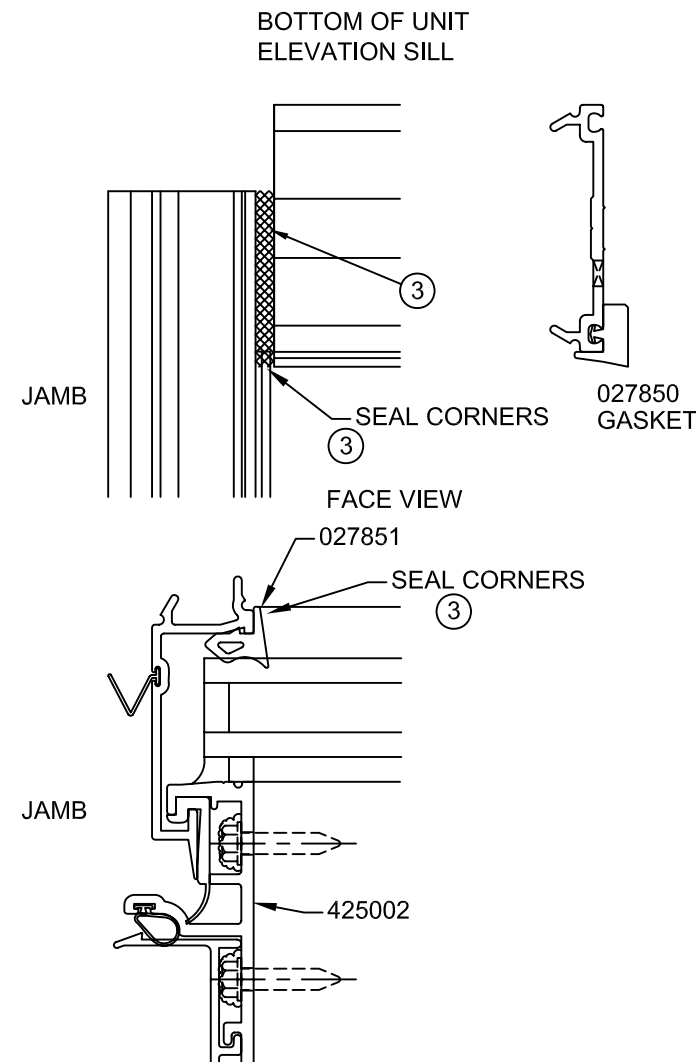
NOTE - THE TORQUE LIMIT TOOL WAS DESIGNED TO BE USED WITH A HAND DRIVEN DEVICE. THE TOOL CAN BE ADAPTED TO A DRILL MOTOR IF USED AT A MAXIMUM SPEED OF APPROX. 300 RPM. HIGHER SPEEDS CAN CAUSE OVERHEATING AND AFFECT THE ACCURACY. AFTER APPROX. 1 HOUR OF TOOL USAGE CHECK TORQUE SETTINGS WITH A TORQUE WRENCH.

- ① TYPICALLY, CENTER HORIZONTAL PRESSURE PLATE ON UNIT AT EXTERIOR FACE OF HORIZONTAL SO END SPACES ARE EQUAL. AT JAMB UNIT, LOCATE HORIZONTAL PRESSURE PLATE 3/16" OFF GLASS RETAINER AT EXTERIOR FACE OF HORIZONTAL.

- ② INSTALL PRESSURE PLATES USING 128406 1/4-14 x 1" HWHTF FASTENERS.



- ③ CLEAN JOINT BETWEEN END OF PRESSURE PLATE AND GLASS RETAINER PER SEALANT MANUFACTURER'S RECOMMENDATIONS. APPLY AND TOOL SEALANT. DO NOT LET THE SEAL INTERFERE WITH THE COVER SNAPS. SEAL CORNERS OF VERTICAL 027851 WEDGE GASKET TO HORIZONTAL 027850 GASKET.



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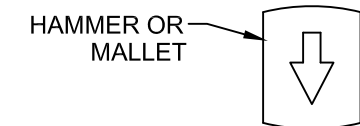
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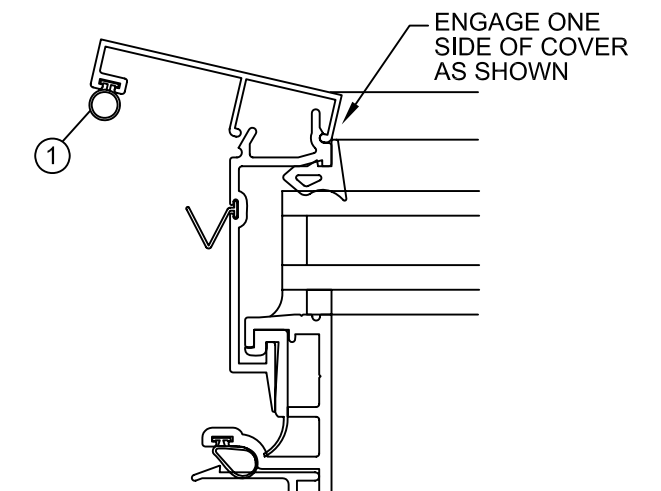
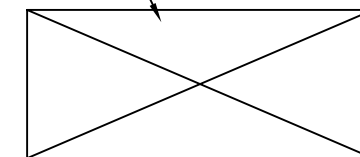
**F INSTALL EXTERIOR COVERS  
AT JAMBS AND ELEVATION SILL UNITS**

INSTALL 425017 VERTICAL JAMB COVERS FIRST

- ① APPLY A FEW SPOTS OF SEALANT IN THE REGLET OF THE VERTICAL COVER. SLIDE IN 127091 T-BULB GASKET INTO REGLET OF VERTICAL COVER. GASKET LENGTH TO BE FLUSH WITH TOP AND BOTTOM OF COVER.
- ② 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 COVER. ALIGN WITH TOP OF EDGE PROTECTOR.



2 x 4 WOOD 18" LONG



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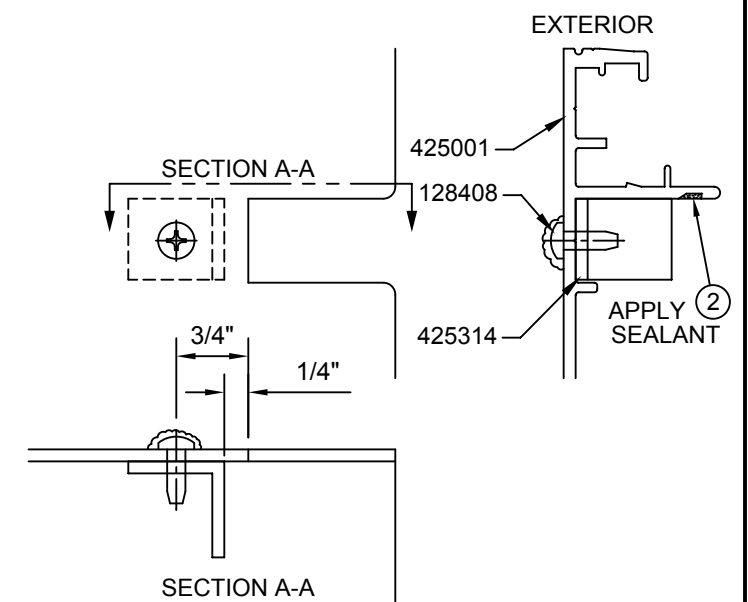
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**I APPLICATION OF JAMB MULLION**

- 1 APPLY 425314 ANGLE AT BOTTOM OF JAMB MULLION WITH A 128408 #10 x 9/16" B PHTF FASTENER. SEAL OVER SCREW HEAD.

**CRITICAL:**

- 2 APPLY SEALANT IN GROOVE FROM BOTTOM OF 425001 MULLION HALF UP 4" AND TOOL FLUSH.

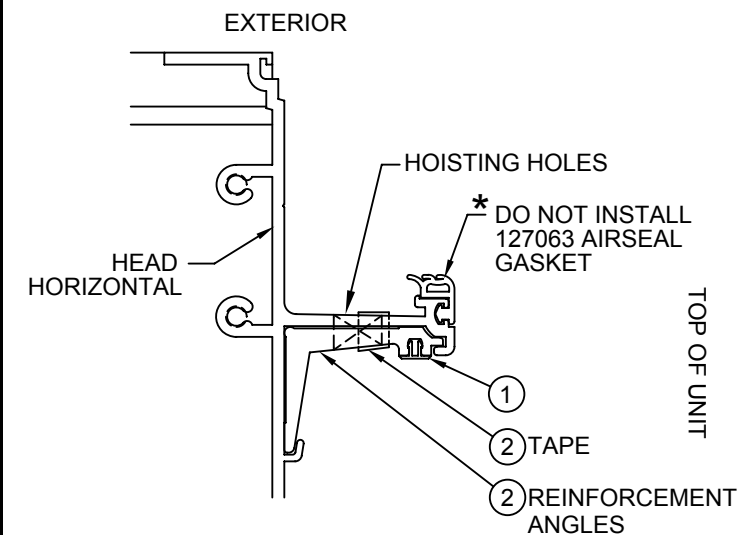


**H INSTALL REINFORCING ANGLES**

- 1 SNAP IN (1) 425330 ISOLATION CLIP IN THE CENTER OF THE LEG OF THE TYPICAL 14" REINFORCEMENT ANGLES. 4" REINFORCEMENT ANGLES ARE FOR HOISTING ONLY AND DO NOT REQUIRE ISOLATION CLIPS. FOR JAMB UNITS, AT 8 1/4" REINFORCEMENT ANGLES, SNAP IN (1) 425330 ISOLATION CLIP AT THE OPPOSITE END OF THE HOISTING HOLE.
- 2 INSTALL THE 425316 REINFORCEMENT ANGLE IN THE LEFT SIDE OF THE TOP HORIZONTAL. ALIGN HOISTING HOLES AND TAPE IN PLACE. AT RIGHT SIDE, APPLY 425319 HOISTING ANGLE. AT JAMBS APPLY 425317 OR 425318. SEE BELOW.

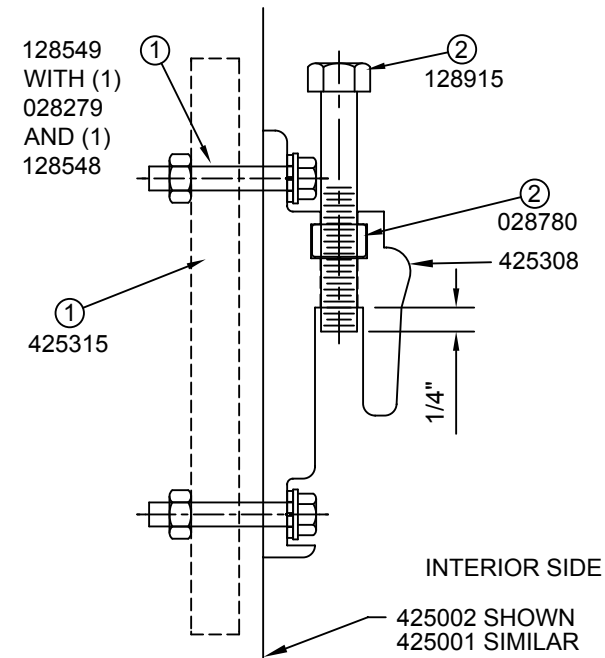
REINFORCEMENT ANGLES  
425316 - TYPICAL - 14" LONG  
425317 - LEFT JAMB - 8 1/4" LONG  
425318 - RIGHT JAMB - 8 1/4" LONG  
425319 - HOISTING - 4" LONG

\* DO NOT INSTALL 127063 AIR SEAL GASKET AT THE HEAD HORIZONTAL AT THIS TIME. GASKET WILL BE INSTALLED IN LONG LENGTHS AFTER UNIT INSTALLATION.

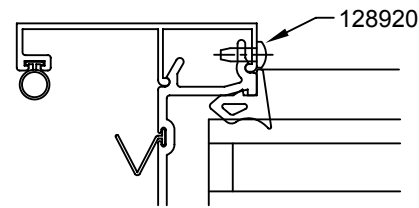


**G INSTALL ANCHOR LUGS**

- 1 APPLY THE 425315 TAPPING BAR INTO THE MULLION HALF. APPLY THE 425308 ANCHOR LUG WITH (2) 128549 1/4-20 x 1 1/2" HWHMS, 028279 LOCK WASHERS AND 128548 1/4-20 HEX NUTS. SEE APPROVED SHOP DRAWINGS FOR LOCATIONS.
- 2 APPLY (1) 028780 3/8-16 HEX NUT TO 425308 ANCHOR LUG. NEXT, APPLY (1) 128915 3/8-16 x 2 1/2" HHMS JACKING BOLT TO 028780 HEX NUT. LOCATE BOTTOM OF BOLT 1/4" EXTENDED BEYOND THE BOTTOM OF THE LUG.

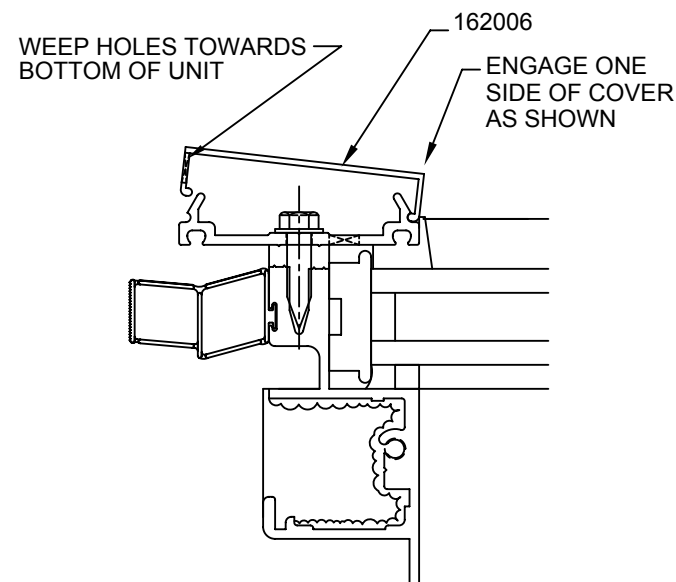


- 3 PIN VERTICAL COVER WITH (1) 128920 #6 x 3/8" B PHTF FASTENER. DRILL A .106" DIA. (#36 DRILL) HOLE AT CENTERLINE OF HORIZONTAL CLOSEST TO THE COVER HEIGHT CENTER.



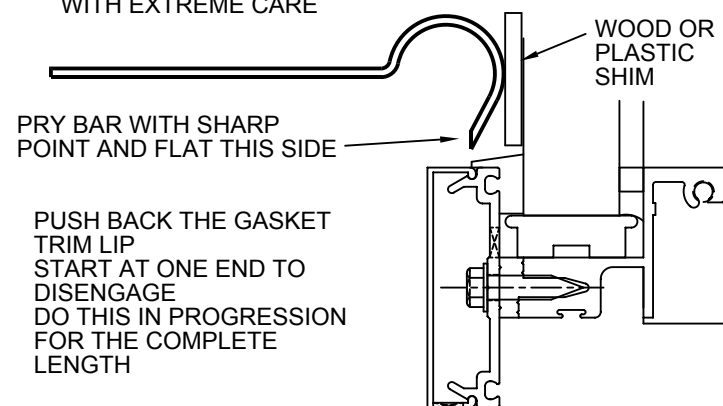
INSTALL ELEVATION SILL HORIZONTAL COVERS  
TYPICAL UNIT  
COVER LENGTH = DLO + 2 3/8"  
JAMB UNIT  
COVER LENGTH = DLO - 1/16" + 1 3/16"

- 4 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 COVER.



**REMOVING COVERS**

COVERS CAN BE SAVED IF TOLERANCES ARE NOT TOO TIGHT AND THE COVER IS REMOVED WITH EXTREME CARE



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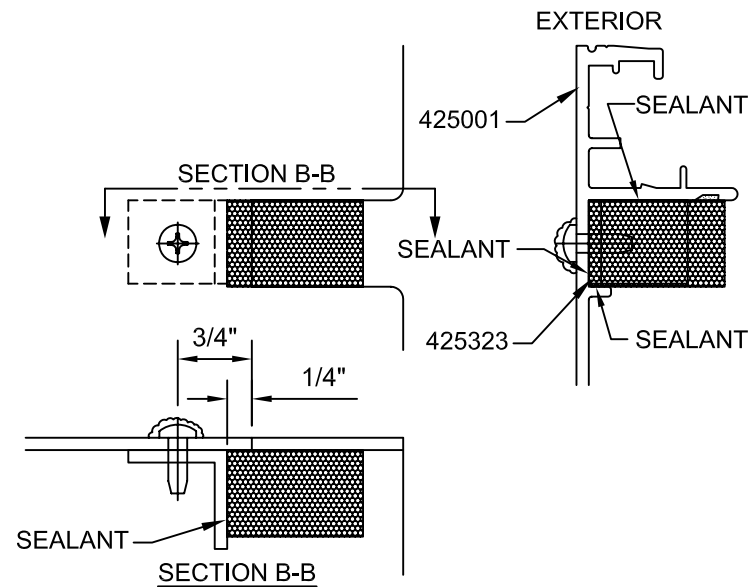
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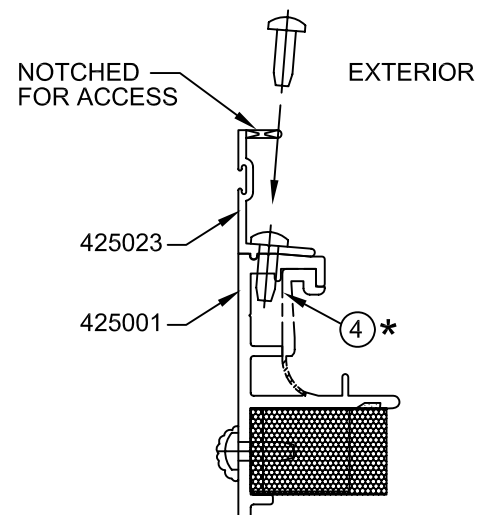
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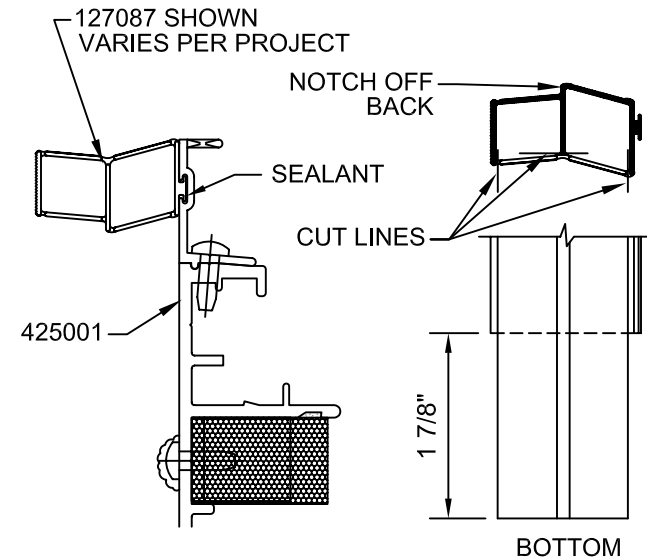
3 APPLY 425323 END PLUG WITH SILICONE AS SHOWN. APPLY SEALANT ON ALL SURFACES WHERE END PLUG TOUCHES ALUMINUM.



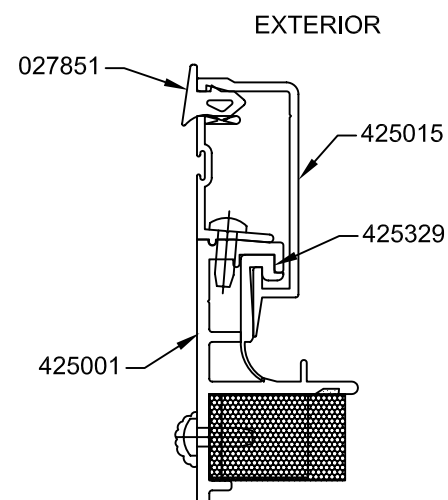
4 MATCH DRILL .166" DIA. (#19 DRILL) HOLES IN MULLION AND APPLY 425023 JAMB ADAPTER WITH 128408 #10 x 9/16" B PHTF FASTENERS AT 24" ON CENTER. \*NOTE: 128408 SCREWS MUST NOT INTERFERE WITH THE APPLICATION OF ISOLATORS. ALIGN ADAPTER WITH TOP OF MULLION.



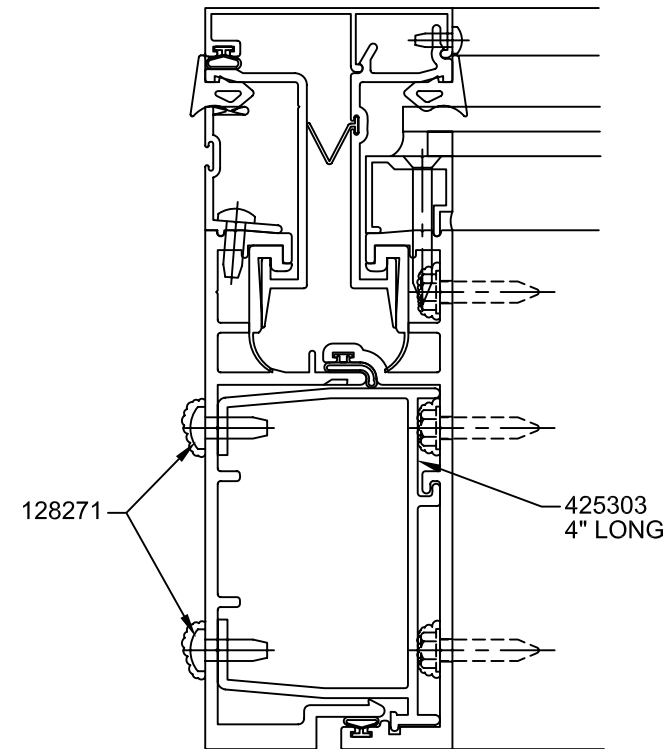
5 SLIDE-IN JAMB RAINSCREEN GASKET IN 425023 JAMB ADAPTER. GASKET TO RUN U.R.D. + 1". NOTCH OUT BACK OF GASKET AT BOTTOM WITH SNIPS UP 1 7/8" SO ONLY FRONT FACE REMAINS. APPLY A FEW SPOTS OF SEALANT IN REGLET TO HOLD GASKET IN PLACE IF NECESSARY. ALIGN WITH TOP OF JAMB ADAPTER.



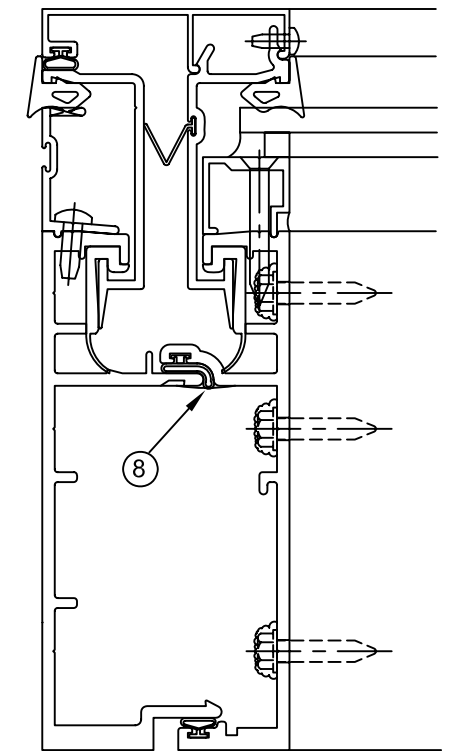
6 APPLY 425329 ISOLATOR, 425015 GLASS RETAINER AND 027851 WEDGE GASKET SAME AS IN PREVIOUS STEPS.



7 SLIDE ASSEMBLED JAMB MULLION TO UNIT JAMB. MATCH DRILL .173" DIA. (#17 DRILL) HOLES IN 425303 CLIPS AND APPLY WITH 128271 #10 x 5/8" B PHTF FASTENERS AND SEAL OVER HEADS.



8 AT BOTTOM OF UNIT, APPLY SEALANT ACROSS 127092 GASKET AND TOOL FLAT AND SMOOTH, 4" IN HEIGHT.



STORE UNITS HORIZONTALLY UNTIL SEALANT HAS CURED PER THE SEALANT MANUFACTURER'S RECOMMENDATIONS. UNITS ARE NOT TO BE ERECTED UNTIL AFTER SEALANT MANUFACTURER'S RECOMMENDED CURING TIME.



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**J CHECK OPENINGS**

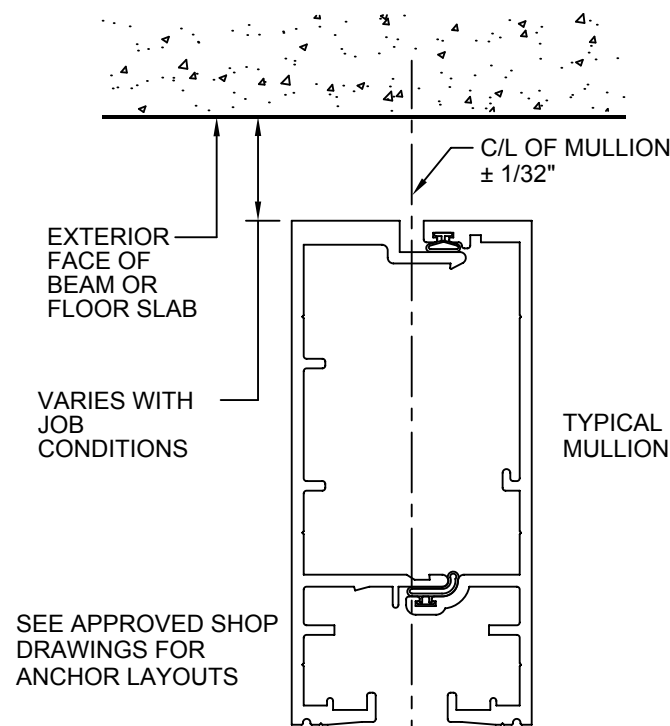
ELEVATIONS AND SLABS MUST BE WITHIN ADJUSTMENT OF ANCHORING SYSTEM. SEE APPROVED SHOP DRAWINGS FOR ALLOWABLE ADJUSTMENT.

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.

**K LAY OUT ANCHOR AND MULLION 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 COLUMNS CENTER LINES ESTABLISHED BY THE GENERAL CONTRACTOR. ON EACH FLOOR, LAY OUT MULLION CENTER LINES AND ANCHOR CENTER LINES.



**L APPLICATION OF SILL TRACK**

1 LOCATE THE BACK OF THE CURTAINWALL SYSTEM (BACK OF THE VERTICAL MULLIONS) AND MARK LOCATIONS. NOTE: THE BACK OF THE 425032 SILL TRACK IS FLUSH WITH THE BACK OF THE MULLIONS.

2 LOCATE THE CENTERLINE OF THE VERTICAL MULLIONS FROM ESTABLISHED COLUMN LINES AND MARK THE LOCATIONS.

3 SLIDE IN THE REINFORCING ANGLES INTO THE SILL TRACK. LOCATE AT MULLION CENTERLINES AND JAMBS. SEE BELOW.

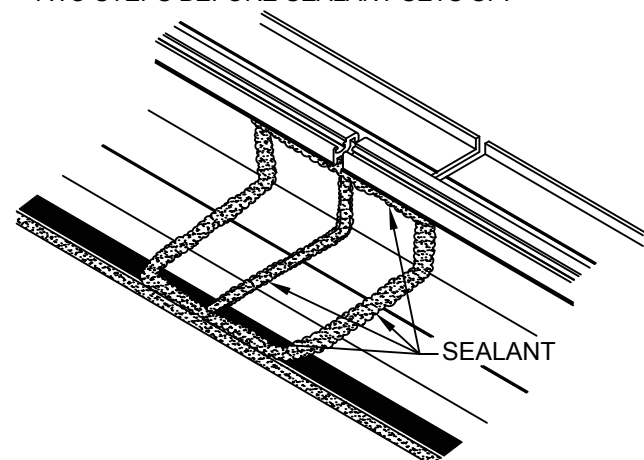
REINFORCEMENT ANGLES  
425316 - TYPICAL - 14" LONG  
425317 - LEFT JAMB - 8 1/4" LONG  
425318 - RIGHT JAMB - 8 1/4" LONG

4 POSITION SILL TRACK AND SHIM AS NECESSARY TO PLACE IT AT THE PROPER HEIGHT. (MEASURED FROM ESTABLISHED BENCHMARK) THE SHIM STACK AND PERIMETER ANCHORS TO BE LOCATED PER APPROVED SHOP DRAWINGS. THE SILL TRACK MUST BE LEVEL AND STRAIGHT.

5 FIELD MATCH DRILL BUILDING CONDITION FOR PERIMETER FASTENERS. LOCATE FASTENERS FRONT TO BACK WHERE FASTENER HEAD WILL NOT INTERFERE WITH UNIT SILL HORIZONTAL, WHEN UNIT IS INSTALLED. APPLY FASTENERS AND SEAL OVER ALL FASTENER HEADS. TOOL SEALANT.

6 APPLY BACKER ROD AND PERIMETER SEALS. TOOL SEALANT. APPLY BACKER ROD AND SEALANT AT END OF TRACK. MARRY TO FRONT SEAL AND TO BACK OF TRAY. TOOL SEALANT.

7 APPLY SEALANT AT SPLICES AND INSTALL 127096 (4" WIDE x 4 1/2" LONG) SILICONE SPLICE SHEET IN A BED OF SEALANT. SEAL AND TOOL AROUND SPLICE SHEET. ALL SPLICE JOINTS ARE TO BE SEALED FROM THE FRONT OF THE SILL TRACK TO THE TOP OF THE UPTURNED LEG. COMPLETE NEXT TWO STEPS BEFORE SEALANT SETS UP.

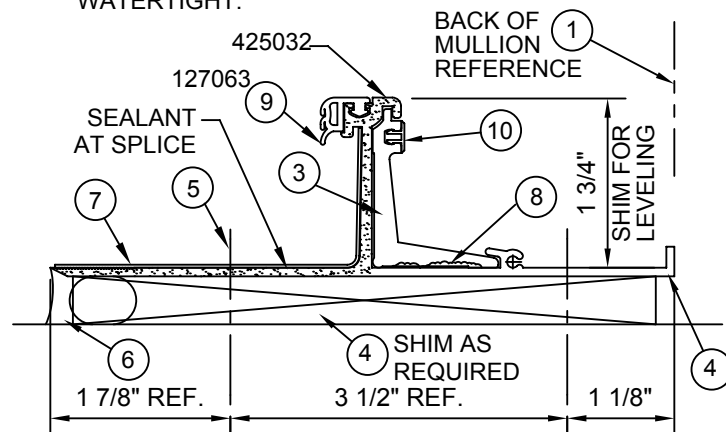


8 REPOSITION REINFORCING ANGLES AT MULLION CENTERLINES AND APPLY SEALANT AT ENDS TO FIX IN PLACE. SEE STEP 3 ABOVE.

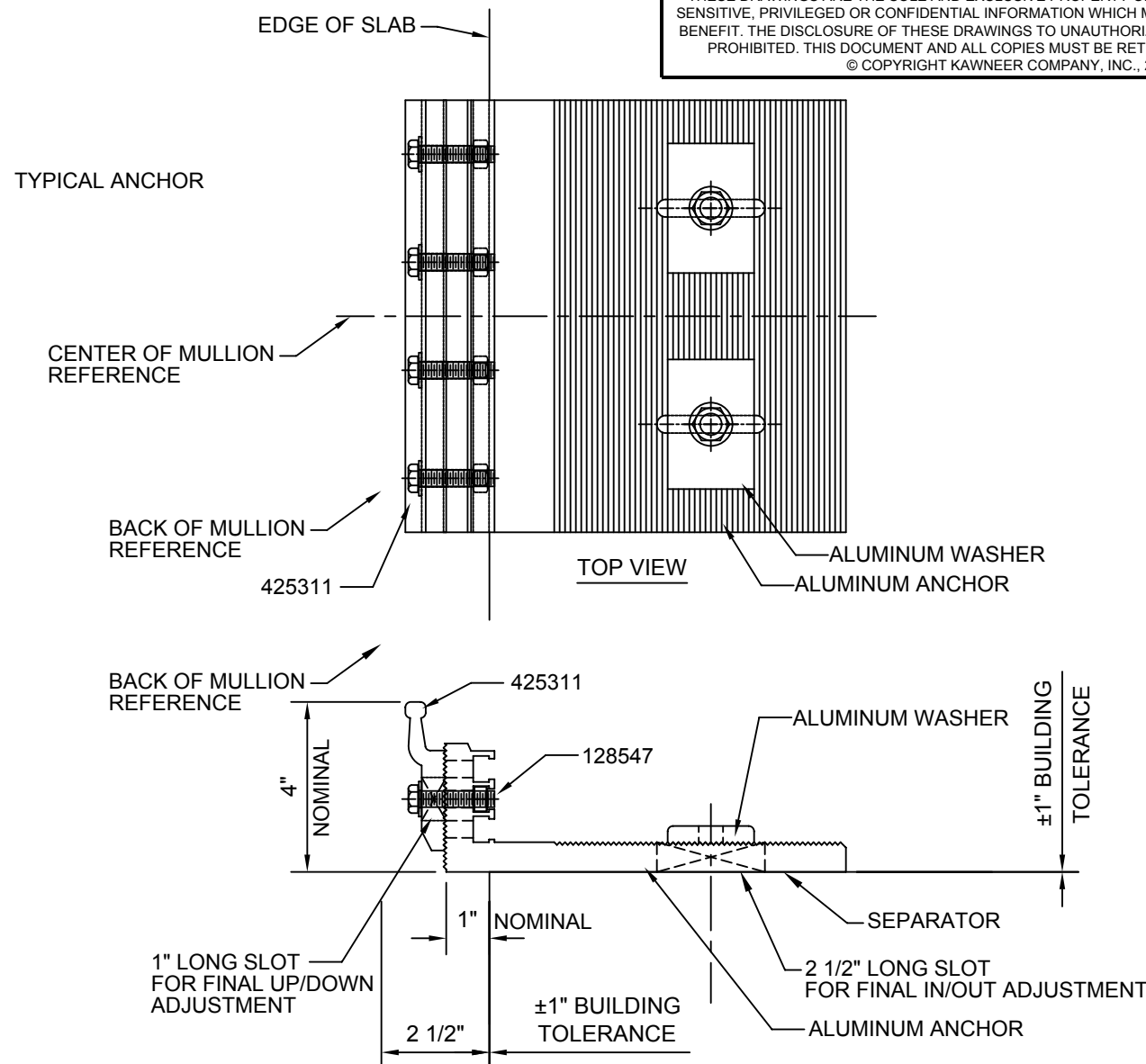
9 PUSH-IN 127063 AIR SEAL GASKET CONTINUOUS. GASKET TO BE CUT LONG, 1/4" PER FOOT, FOR SOME "CROWD-IN". GASKET SHOULD NEVER BE "STRETCHED TO FIT". APPLY SEALANT AT THE ENDS AND BUTT TOGETHER WHERE SPLICED.

10 SNAP IN (1) 425330 ISOLATION CLIP IN THE LEG OF THE REINFORCING ANGLE AT MULLION CENTERLINES.

11 INSPECT THE SPLICE JOINTS FOR ANY GAP WHERE AIR OR WATER MAY PENETRATE. SEAL COMPLETELY WATERTIGHT.



**M ERECTION OF TOP OF SLAB ANCHORS WHERE REQUIRED**



1 SEE APPROVED SHOP DRAWINGS FOR ANCHOR TYPES AND LOCATIONS.

2 LOCATE THE CENTERLINE OF THE VERTICAL MULLIONS FROM ESTABLISHED COLUMN LINES AND MARK THE LOCATIONS.

NOTE: ALUMINUM ANCHORS MUST BE SEPARATED FROM CONCRETE AND STEEL BUILDING SUBSTRATES.

3 LOCATE CENTERLINE OF ALUMINUM ANCHOR AND MARK FOR CENTERLINE OF MULLION. ALSO LOCATE ANCHOR AT IN/OUT POSITION. APPLY ALUMINUM WASHER AND ATTACH TO BUILDING SUBSTRATE. FINAL IN/OUT ADJUSTMENT CAN BE MADE PRIOR TO TIGHTENING IN PLACE.

4 TIGHTEN BOLTS DOWN AFTER FINAL ADJUSTMENT.

5 APPLY 425311 ANCHOR RAIL WITH 128547 3/8-16 x 1 3/4" HHMS BOLTS, 028596 WASHERS AND 128546 LOCK NUTS. APPLY BOLTS THROUGH HOLES IN ANCHOR THAT BEST ACCOMMODATES UP/DOWN BUILDING TOLERANCE. FINAL UP/DOWN ADJUSTMENT CAN BE MADE PRIOR TO TIGHTENING IN PLACE.



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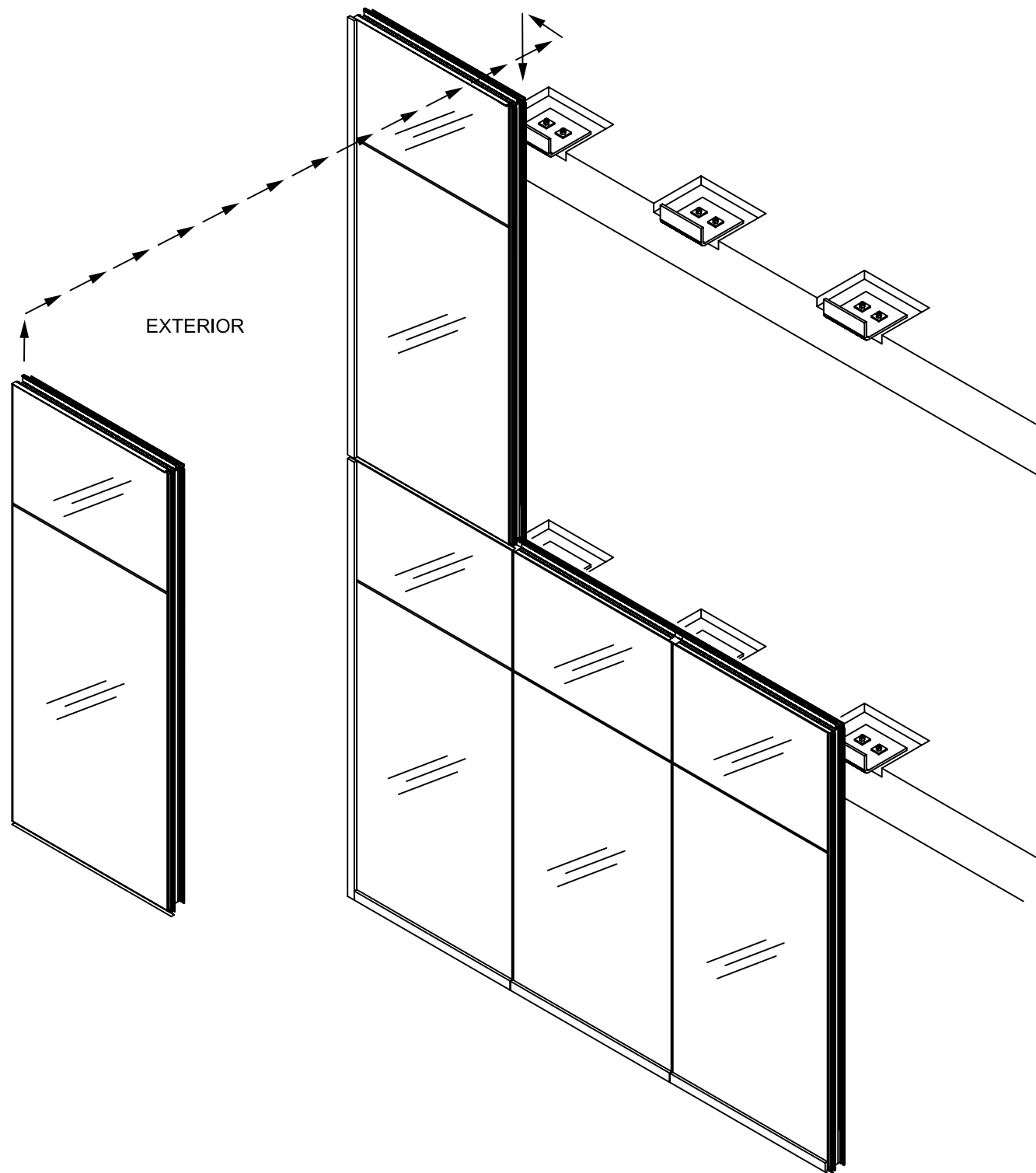
**N CURTAINWALL UNIT INSTALLATION**

NOTE: ALL CURTAINWALL INSTALLATION WILL START ON THE LEFT AND PROCEED TO THE RIGHT AND FROM BOTTOM TO TOP, VIEWED FROM THE EXTERIOR OF THE BUILDING. REFERENCE THE KEY PLANS SHOWN IN APPROVED SHOP DRAWINGS FOR STARTING LOCATIONS. UNITS CAN BE INSTALLED FROM RIGHT TO LEFT WHERE REQUIRED.

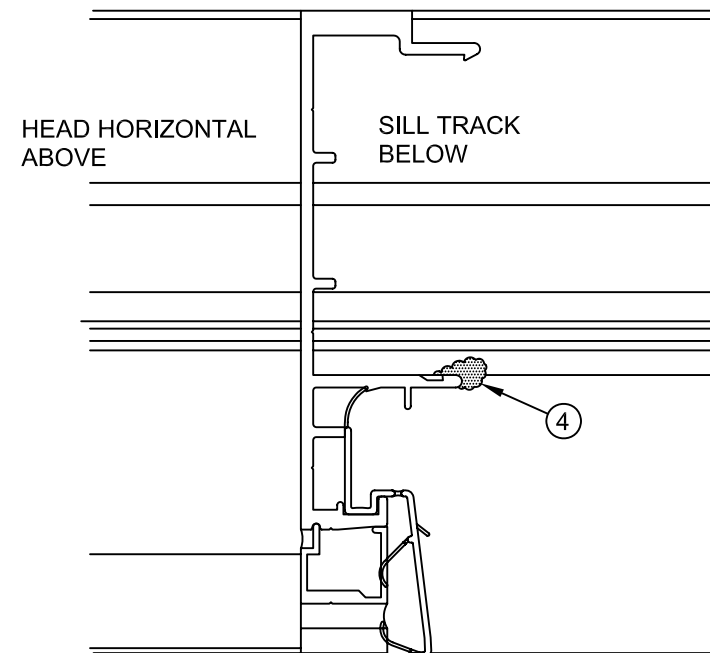
CLEAN AND PREPARE ALL SURFACES FOR SEALANT APPLICATION PER SEALANT MANUFACTURER'S RECOMMENDATIONS.

PRESET BOLT IN ANCHOR LUG TO A 1/4" NOMINAL PROJECTION. REFERENCE ANCHOR LUG SECTION G, STEP 2 ON SHEET 7 OF 13.

ALL UNITS REQUIRE A REINFORCING ANGLE AT HOISTING POINTS IN THE UNIT HEAD HORIZONTAL TO PREVENT BENDING. USE 425319 4" LONG TEMPORARY PART. INSPECT FRAMES PRIOR TO HOISTING. THE HOIST SPREADER BEAM CHAINS SHOULD BE SPACED APART THE SAME LENGTH AS THE DISTANCE BETWEEN HOISTING HOLES IN HEAD HORIZONTAL. THE MOVEMENT OF THE FRAME MUST BE CONTROLLED AS IT IS BEING HOISTED. IT MUST NOT BE ALLOWED TO SWING OR SPIN. MAXIMUM UNIT WEIGHT TO BE LESS THAN 600 LBS. FOR HOISTING.



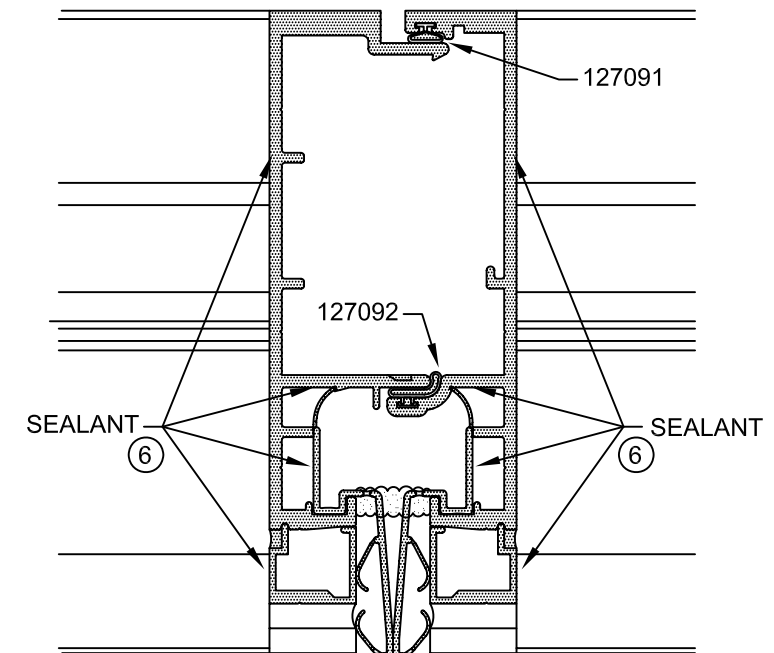
- ① INSTALL THE FIRST UNIT (FROM LEFT TO RIGHT) BY LIFTING IT OVER THE SILL TRACK, LOWER IT DOWN TO ENGAGE THE HORIZONTAL AT THE BOTTOM AND REST ANCHOR LUGS ON PREINSTALLED ANCHORS.
  - ② ADJUST UNIT HEIGHT USING ADJUSTMENT BOLTS AT ANCHOR LUGS TO MAKE SURE THAT IT IS LEVEL, PLUMB AND AT THE CORRECT HEIGHT. ( $\pm 1/4"$  MAX.) AT NOMINAL POSITION, TYPICAL SPACE AT BACK OF EXPANSION HORIZONTAL BETWEEN UNITS IS 1/2".
  - ③ REMOVE 4" LONG REINFORCING ANGLE FROM THE RIGHT SIDE OF THE HEAD HORIZONTAL USED FOR HOISTING.
- BLOCK BETWEEN JAMB CONDITION AND FIRST UNIT TO PREVENT MOVEMENT DURING INSTALLATION OF SECOND UNIT.
- ④ JUST PRIOR TO INSTALLING NEXT UNIT, APPLY SEALANT TO THE INTERSECTION OF 127063 HORIZONTAL AIR/WATER SEAL GASKET AND LOCATION FOR 127092 VERTICAL AIR/WATER SEAL GASKET.



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- ⑤ INSTALL THE NEXT UNIT BY LIFTING UNIT UP TO CLEAR THE LEG AT THE SILL AND MOVE TO THE LEFT TO ENGAGE THE UNITS. SLIDE UNIT DOWN TO ENGAGE UNIT AT THE SILL TRACK. CHECK TO MAKE SURE THAT 127091 AND 127092 GASKETS ARE IN PLACE AND HAVE NOT SLID UP IN MULLION REGLETS. WHEN STACKING UNITS, ALIGN MULLIONS WITH UNIT BELOW.
- ⑥ ADJUST UNIT HEIGHT USING ADJUSTMENT BOLTS AT ANCHOR LUGS TO MAKE SURE THAT IT IS LEVEL, PLUMB AND AT THE CORRECT HEIGHT. CHECK TO MAKE SURE ALL VERTICAL PARTS AT TOP OF MULLION ARE FLUSH SO 425307 CAP WILL ALIGN WITH HEAD HORIZONTALS. CLEAN TOP OF EXPOSED MULLION PER MANUFACTURERS RECOMMENDATIONS. APPLY SEALANT AROUND TOP OF MULLION, GASKETS AND VERTICAL ISOLATOR AS SHOWN.



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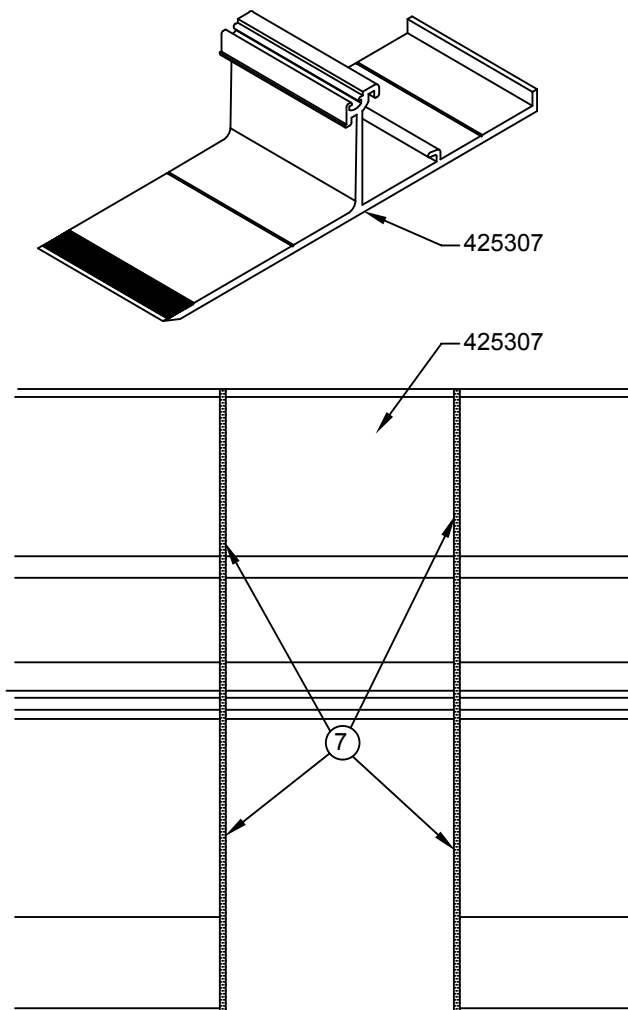
2500 PG WALL  
4 SIDE SSG  
INSTALLATION  
INSTRUCTIONS

95500-03  
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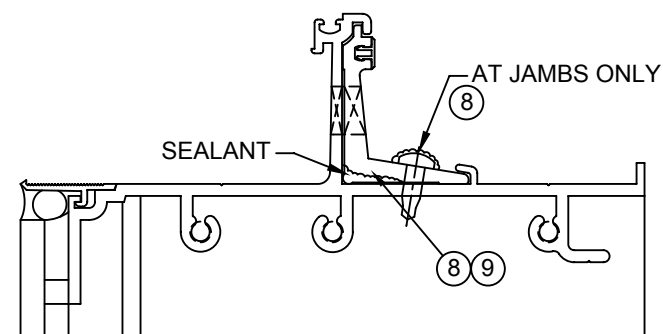
7 APPLY 425307 2 3/8" LONG CAP IN LINE WITH HEAD HORIZONTAL. TOOL EXCESS SEALANT THAT SQUEEZES THROUGH SPACE BETWEEN CAP AND HEAD HORIZONTAL. APPLICATION AT JAMB MULLION SIMILAR.



8 SLIDE THE 425316 REINFORCING ANGLE AT THE LEFT SIDE TO ENGAGE THE ADJOINING UNIT AND CENTER IT ON THE MULLION CENTERLINE. AT JAMB MULLION, ALIGN END OF ANGLE WITH SIDE OF JAMB MULLION HALF. MATCH DRILL .159" DIA. (#21 DRILL) HOLES IN CAP AND HEAD HORIZONTAL AND FIX WITH (2) 128408 #10 x 9/16" B PHTF FASTENERS. SEAL HOLES PRIOR TO APPLYING FASTENER. SEAL OVER HEADS. APPLY A BEAD OF SEALANT AT ENDS OF INTERMEDIATE REINFORCEMENT ANGLES TO HOLD IN PLACE.

REINFORCEMENT ANGLES  
425316 - TYPICAL - 14" LONG  
425317 - LEFT JAMB - 8 1/4" LONG  
425318 - RIGHT JAMB - 8 1/4" LONG  
425319 - HOISTING - 4" LONG

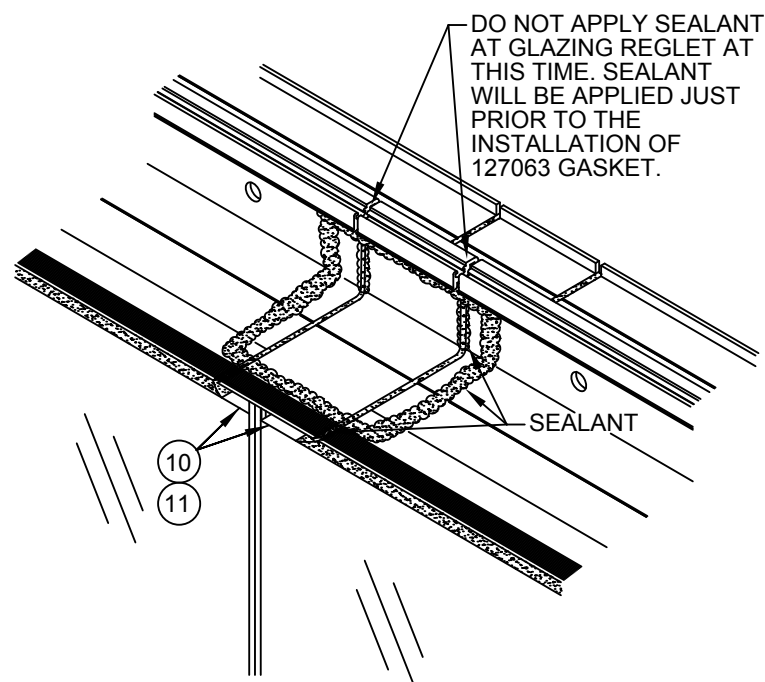
9 REMOVE 4" REINFORCING ANGLE FROM THE RIGHT SIDE OF THE HEAD HORIZONTAL USED FOR HOISTING.



10 APPLY 3/8" BACKER ROD AT TOP OF GLASS, UNDER 425307 CAP.

11 CLEAN AND APPLY SILICONE AS SHOWN. TOOL SEALANT.

12 CLEAN AND PREPARE THE TOP SURFACE OF THE HEAD HORIZONTAL AND CAP LOCATIONS PER SEALANT MANUFACTURER'S RECOMMENDATIONS. APPLY SEALANT COMPLETELY AROUND THE ENTIRE FRONT FACE OF HEAD HORIZONTAL AS SHOWN FOR APPLICATION OF 4" WIDE SILICONE SHEET. ALSO APPLY SEALANT BETWEEN CAP AND HEAD HORIZONTAL AT UPTURNED LEG.

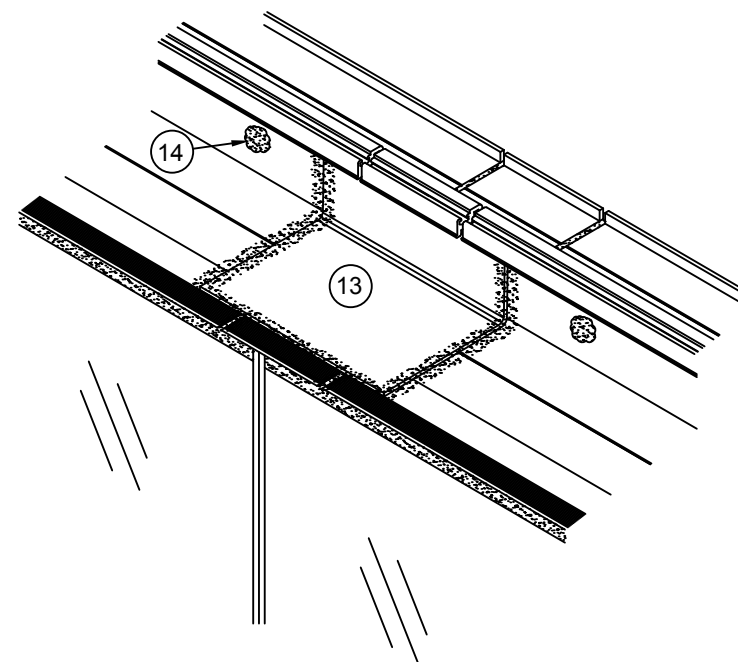


13 CLEAN AND SET 127096 (4" WIDE x 3 3/4" LONG) PIECE OF SILICONE SPLICE SHEET IN A CONTINUOUS BED OF SEALANT. THE CENTER OF THE SHEET OCCURS AT THE CENTER OF THE VERTICAL, OVERLAPPING THE SPLICE JOINTS. APPLY SILICONE AROUND EDGES AS REQUIRED AND TOOL SEALANT. SILICONE SPLICE SHEET IS ALSO REQUIRED AT JAMBS.

(NOTE: HOLD LOW PROFILE AND MINIMIZE SEALANT BUILD UP OR DAMMING OF SEALANT)

14 SEAL HOLES USED FOR HOISTING UNITS AND TOOL SEALANT.

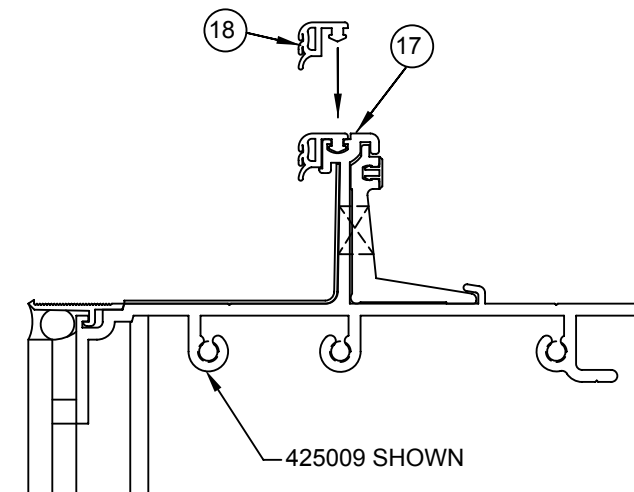
15 INSPECT THE SPLICE JOINT FOR ANY GAP WHERE AIR OR WATER MAY PENETRATE. SEAL COMPLETELY WATERTIGHT.



16 CONTINUE ACROSS ELEVATION IN A SIMILAR MANNER. CHECK UNIT SPACING EVERY 4 OR 5 UNITS TO ELIMINATE DIMENSIONAL BUILD-UP OF THE WIDTH OF THE ELEVATION. IF NECESSARY, BLOCK AND CLAMP MULLION HALVES TOGETHER TO KEEP UNITS IN ALIGNMENT DURING INSTALLATION OF NEXT UNIT.

17 JUST PRIOR TO THE INSTALLATION OF THE 127063 AIR / WATER GASKET, APPLY SEALANT INTO GAPS BETWEEN THE CAP AND HEAD HORIZONTAL AT THE TOP OF THE UPTURNED LEG.

18 PUSH-IN 127063 STACK AIR SEAL GASKET INTO UNIT HEAD HORIZONTAL CONTINUOUS ACROSS ELEVATION. GASKET TO BE CUT LONG, 1/4" PER FOOT, FOR SOME "CROWD-IN". GASKET SHOULD NEVER BE "STRETCHED TO FIT". APPLY SEALANT AT THE ENDS AND BUTT WHERE SPLICED.



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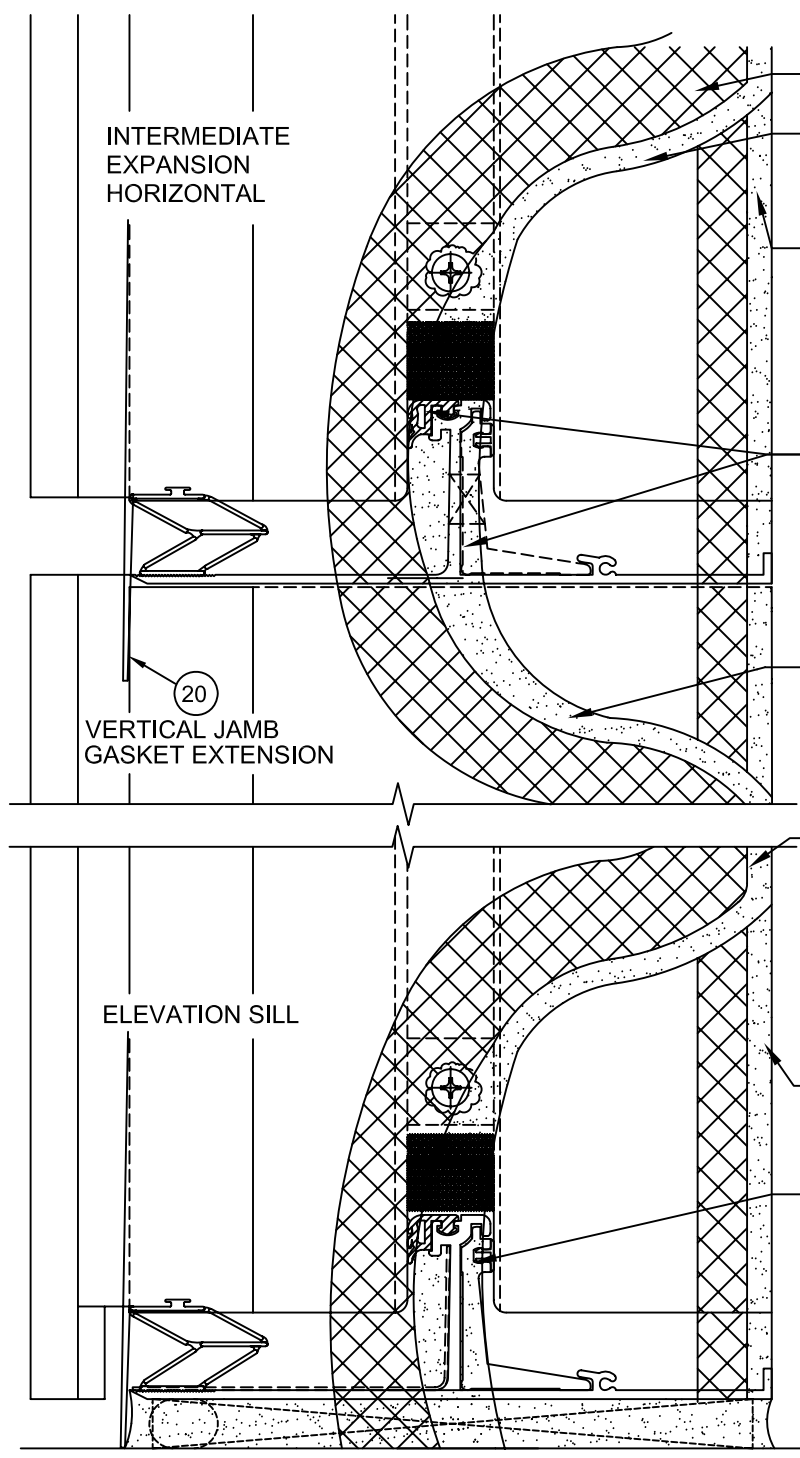
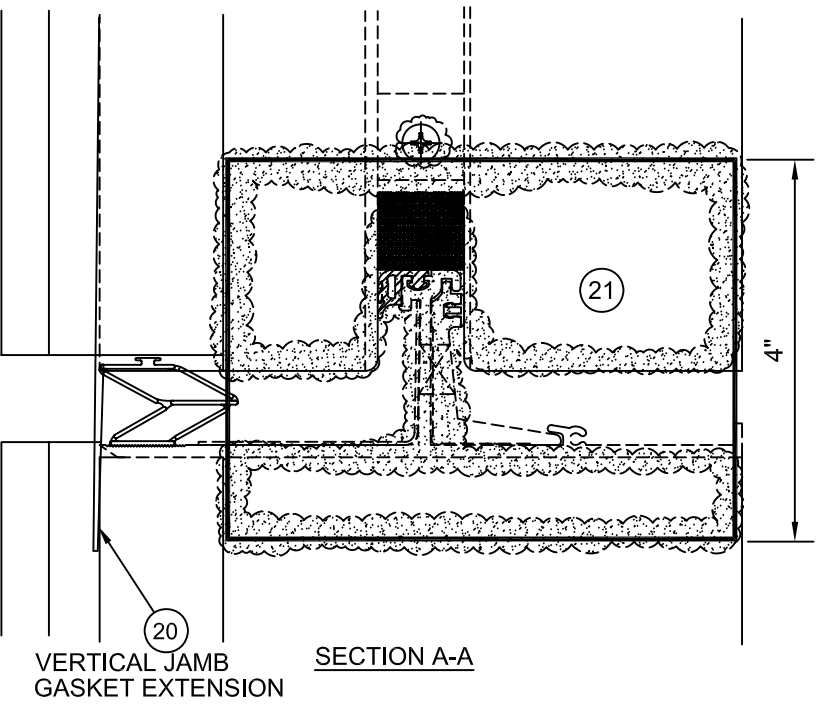
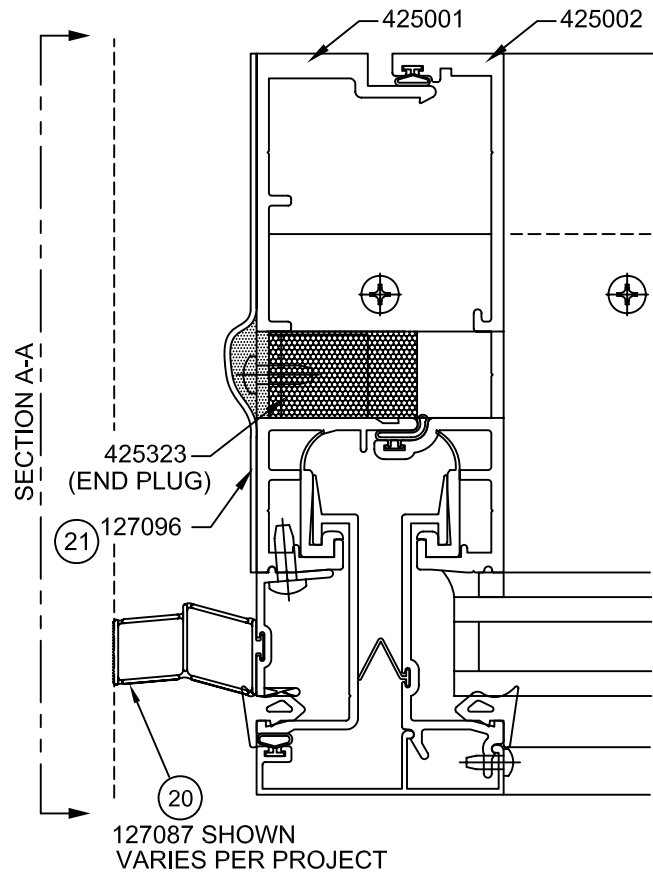
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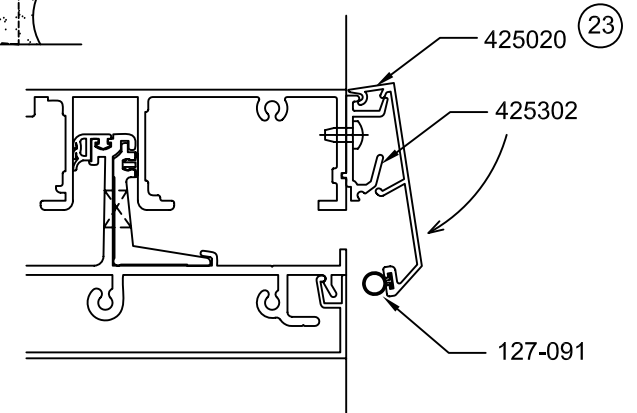
425971 (SHEET 11 OF 13)

- 19 BEFORE PROCEEDING TO THE NEXT FLOOR, INSPECT ALL HORIZONTAL JOINTS TO ENSURE THEY ARE WATERTIGHT.
- 20 AT THE NEXT FLOOR, INSTALL UNITS USING STEPS PREVIOUSLY STATED. AT JAMB UNIT, CHECK THAT VERTICAL JAMB GASKET EXTENSION AT BOTTOM OVERLAPS TOP OF VERTICAL JAMB GASKET BELOW.
- 21 IF REQUIRED, AT JAMBS AT STACK JOINTS AND SILLS, APPLY A PIECE OF 127096 (4" WIDE x 5" LONG) SILICONE SHEET ACROSS END OF STACK JOINT AS SHOWN. INTERMEDIATE SHOWN, SILL SIMILAR

- 22 APPLY BACKER ROD AND SEALS AROUND END CAPS PER APPROVED SHOP DRAWINGS. TOOL SEALANT. APPLY BACKER ROD AND PERIMETER SEALS TYPICALLY. TOOL SEALANT. WHERE JAMB PATCH IN STEP 21 IS NOT USED, PERIMETER SEAL MUST STEP IN TO AIR / WATER SEAL AS SHOWN BELOW.

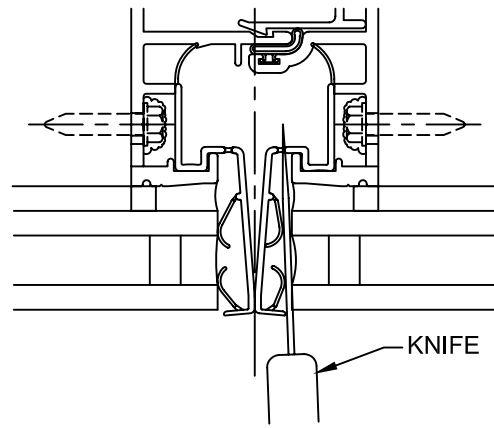


- 23 APPLY 425020 INTERIOR SNAP COVERS AT 1" VISION OVER 1" VISION STACK HORIZONTALS WHERE REQUIRED. MATCH DRILL .159" DIA. (#21 DRILL) HOLES IN BACK OF HORIZONTAL AND APPLY 425302 ADAPTER CLIPS WITH 028514 #10 x 3/8" B PHTF FASTENERS. SLIDE 127091 T-BULB GASKET INTO COVER REGLET. RUN GASKET COVER LENGTH. SNAP ON COVER. SEE APPROVED SHOP DRAWINGS FOR ADDITIONAL INFORMATION.
- 24 APPLY INTERIOR SNAP TRIM STOOLS AT INTERMEDIATE AND STACK HORIZONTALS WHERE REQUIRED. SEE APPROVED SHOP DRAWINGS.

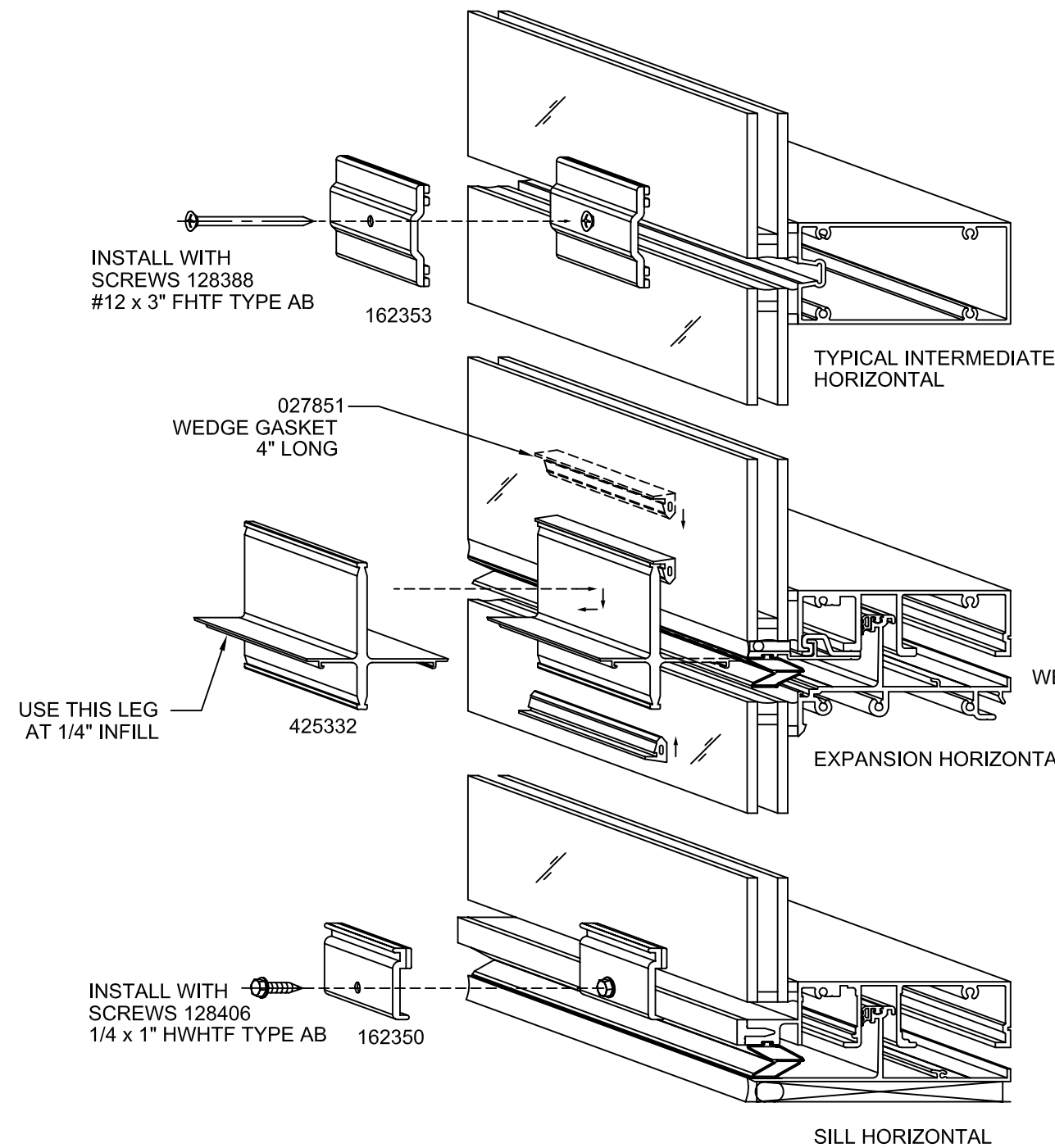
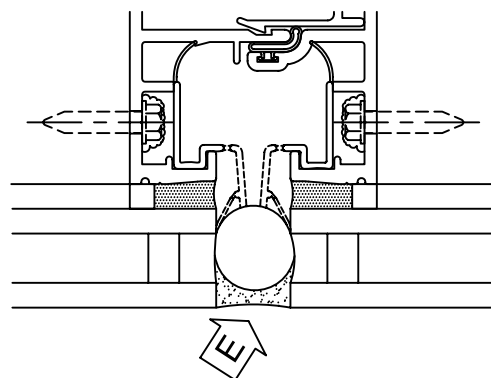


**REGLAZING INSTRUCTIONS**

- 1 CUT AWAY WEATHER SEALS ABOVE AND BELOW LITE TO BE REPLACED.
- 2 CUT AWAY BOTH VERTICAL RAINSCREEN GASKETS AT BOTH SIDES OF THE LITE. SLIDE A KNIFE BETWEEN GASKET AND GLASS AND CUT DOWN HINGE. STOP CUT JUST ABOVE AND BELOW LITE TO BE REPLACED.



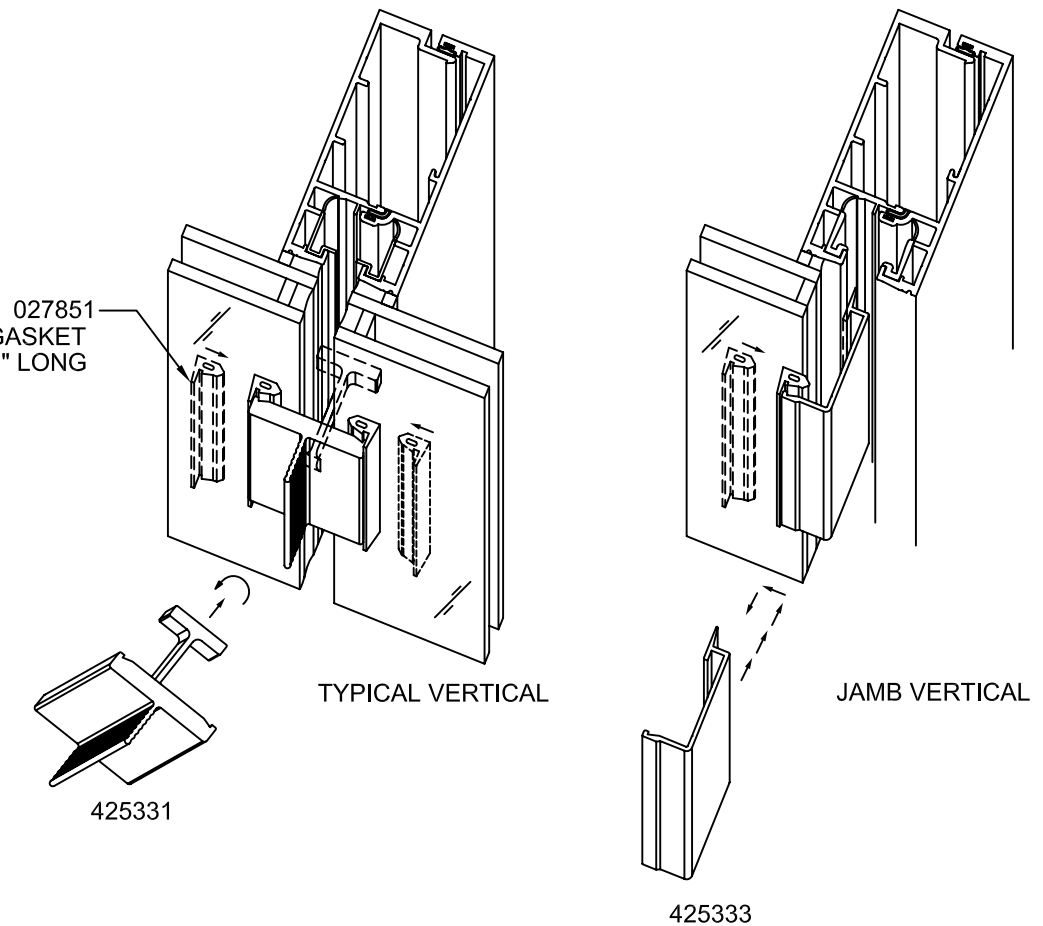
- 3 CUT ACROSS GASKET JUST ABOVE AND BELOW LITE TO BE REPLACED. REMOVE SECTIONS OF VERTICAL RAINSCREEN.
- 4 CUT AWAY SEALANT AND TAPE AROUND LITE TO BE REMOVED. APPLY GLAZING TEMPS TO HOLD GLASS IN PLACE UNTIL READY TO BE REMOVED.
- 5 REMOVE GLASS.
- 6 CLEAN REMAINING SEALANT AND TAPE FROM HORIZONTALS AND MULLION HALVES.
- 7 FOLLOW ASSEMBLY INSTRUCTIONS TO REPLACE LITE. SEE GLAZING TEMPORARY INFORMATION. PRIOR TO APPLYING HORIZONTAL WEATHER SEAL AT TYPICAL INTERMEDIATE HORIZONTALS, SEAL HOLES IN HORIZONTAL WHERE GLAZING CLIP WAS REMOVED.
- 8 APPLY 1" BACKER ROD AND SEAL IN LIEU OF REPLACEMENT OF VERTICAL RAINSCREEN GASKET.



**GLAZING TEMPORARY INFORMATION**

MAXIMUM TEMPORARY SPACING IS 30". IF WINDS GREATER THAN 50 MPH ARE EXPECTED, ADDITIONAL TEMPORARIES MAY BE REQUIRED. CONSULT YOUR SEALANT AND/OR INFILL SUPPLIER FOR SPACING RECOMMENDATIONS.

AT CORNERS AND SPLAYED CONDITIONS, TEMPORARIES SHOULD BE MADE FROM A GOOD QUALITY HARDWOOD. THESE TEMPORARIES ARE NOT SUPPLIED BY KAWNEER.



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