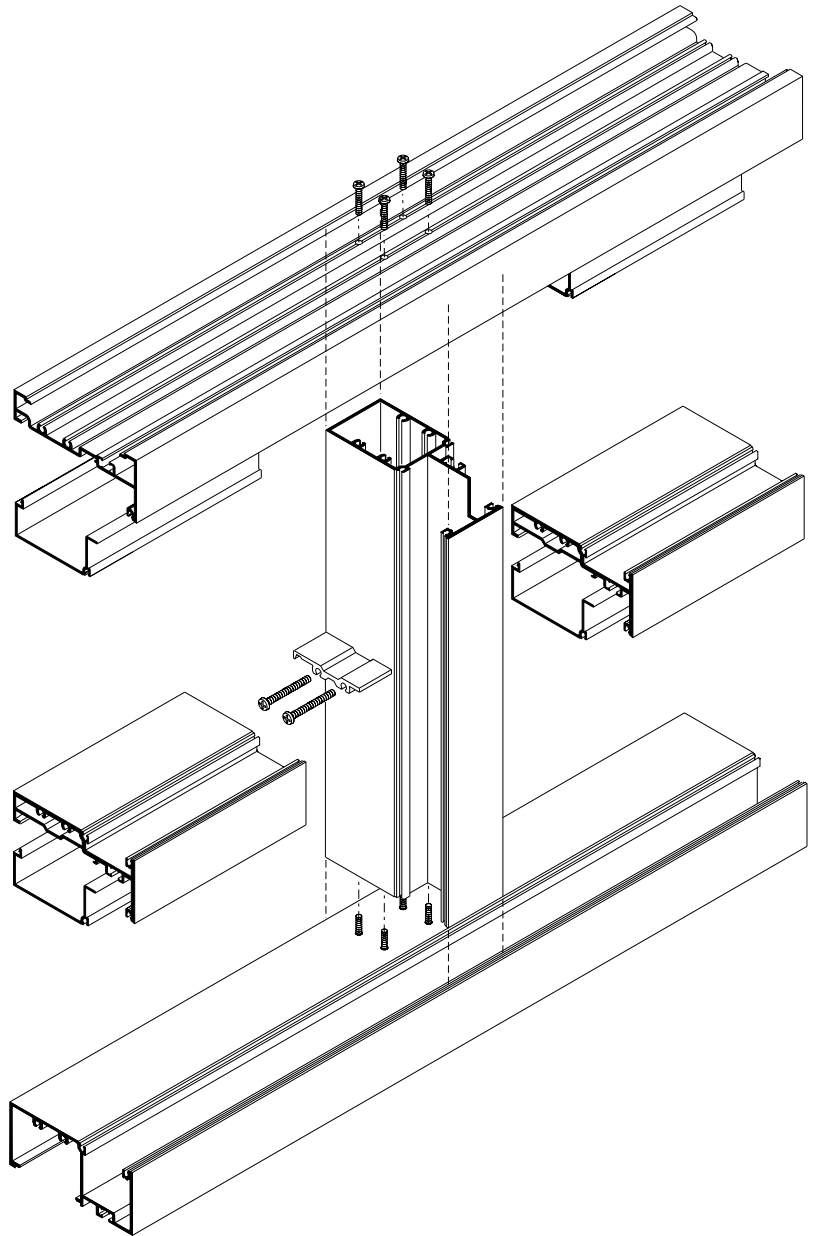


INSTALLATION

TRIFAB[®] VG

TYPE-B ASSEMBLY

- TRIFAB VG 450
 - CAPTURED
 - SSG
 - WEATHERSEAL
- TRIFAB VG 451
 - CAPTURED
 - SSG
 - WEATHERSEAL
- TRIFAB VG 451T
 - CAPTURED
 - SSG
 - WEATHERSEAL



INSTRUCTIONS

INSTALLATION INSTRUCTIONS

CONTENTS

These instructions show the general installation sequence and procedure for typical installations. They supplement the shop details and notations on installation and glazing.

<u>SECTION</u>	<u>PAGE</u>	
I	3-4	GENERAL NOTES * MATERIAL HANDLING, STORING & PROTECTION OF ALUMINUM * GENERAL INSTALLATION NOTES * SILICONE GLAZING NOTES
II	5-9	BASIC FRAMING DETAILS
III	10-15	FABRICATION
IV	16-20	ASSEMBLY
V	21-24	INSTALLATION
VI	25	GLAZING ADAPTERS
VII	26-31	GLAZING
VIII	32-34	OPTIONAL CORNERS

NOTE:

FABRICATION, INSTALLATION & GLAZING ARTWORK DEPICTS TYPICAL 1" FRONT GLAZED MEMBERS. ALL 1/4" INFILL APPLICATIONS ARE SIMILAR UNLESS OTHERWISE NOTED.

SECTION I - GENERAL NOTES

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 ground. Protect against elements and other construction trades.
- 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 INSTRUCTIONS

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 masonry opening to prevent dimensional build-up 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.

SECTION I - GENERAL NOTES

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.

M. GASKET INVENTORY ROTATION - These high quality rubber extrusions are coated with silicone lubricant. Silicone will dry over time leaving a white “chalky” residue. Please rotate your stock “FIRST IN - FIRST OUT”. If the rubber becomes dry, you may use water ONE TIME to reconstitute the silicone, after that, use a soap water solution.

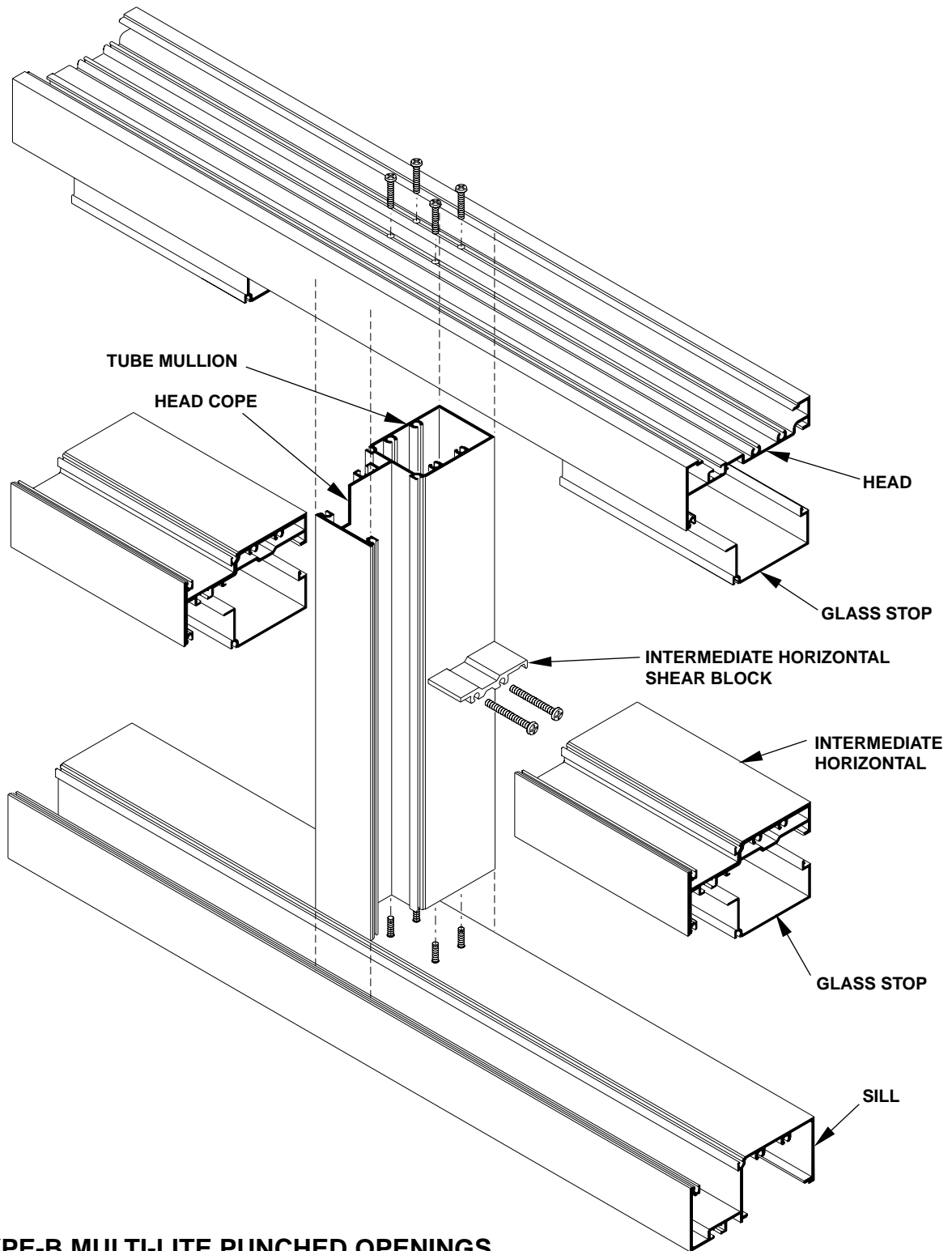
SILICONE GLAZING NOTE

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 the silicone manufacturer’s installation instructions are not in accordance with Kawneer’s installation instructions, it is your responsibility to notify Kawneer of this 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.

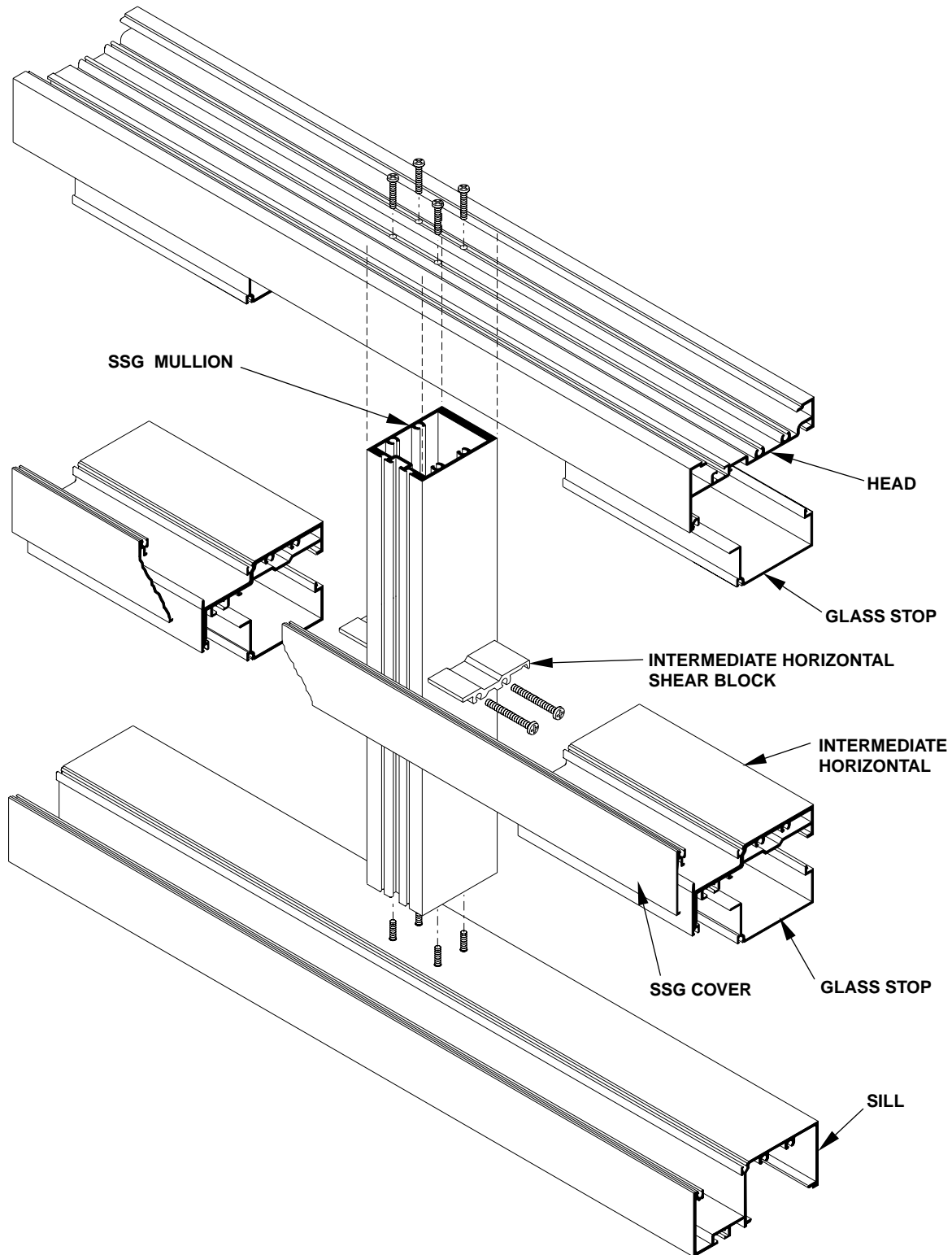
For any structural silicone glazed product application that is not shown in Kawneer’s standard literature, the application must be approved.

SECTION II - BASIC FRAMING DETAILS
TRIFAB® VG (TYPE B)
CAPTURED SYSTEM



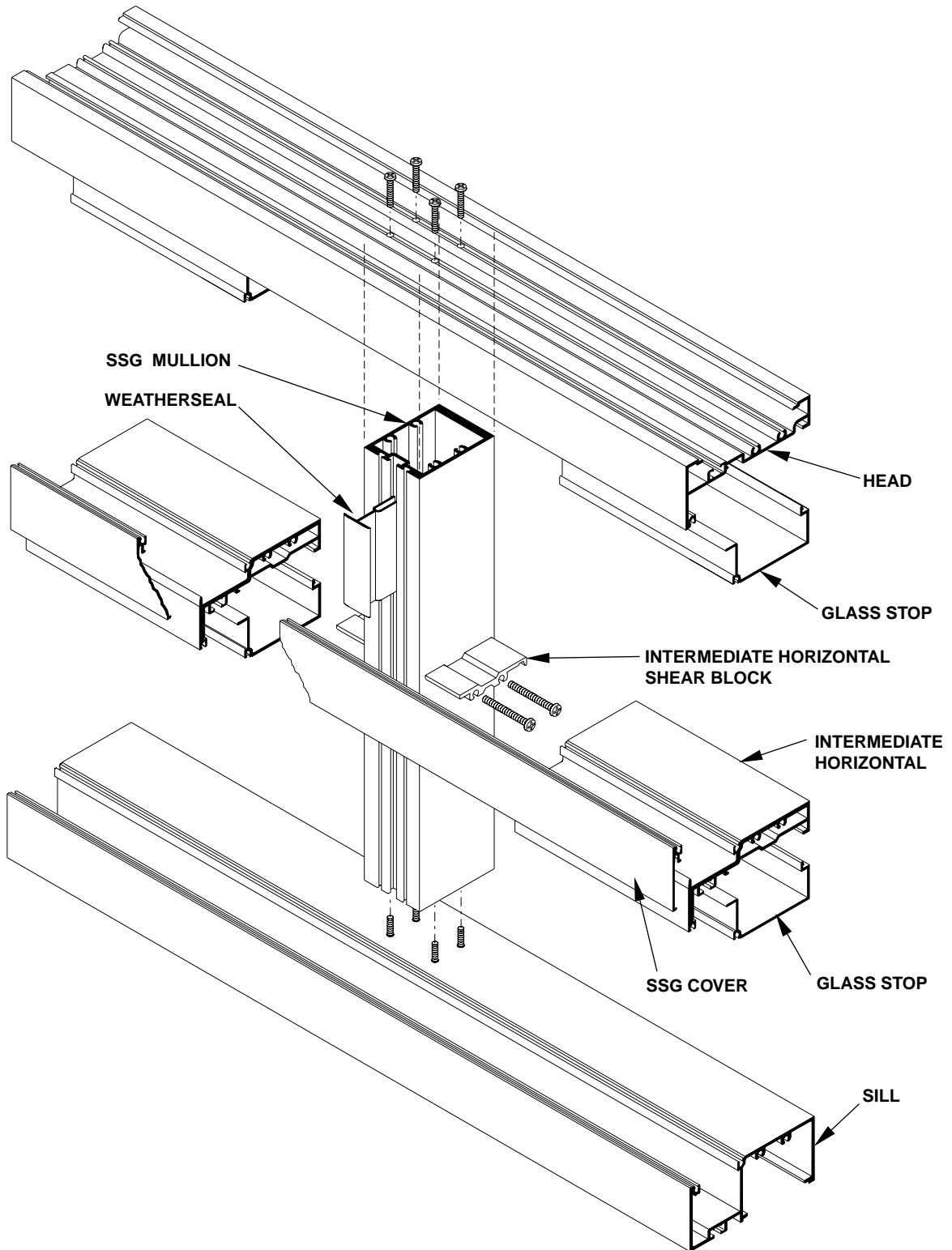
TYPE-B MULTI-LITE PUNCHED OPENINGS
MAXIMUM UNIT WIDTH: 20 FEET

SECTION II - BASIC FRAMING DETAILS
TRIFAB® VG (TYPE B)
SSG SYSTEM



TYPE-B MULTI-LITE PUNCHED OPENINGS
MAXIMUM UNIT WIDTH: 20 FEET

SECTION II - BASIC FRAMING DETAILS
TRIFAB® VG (TYPE B)
WEATHERSEAL

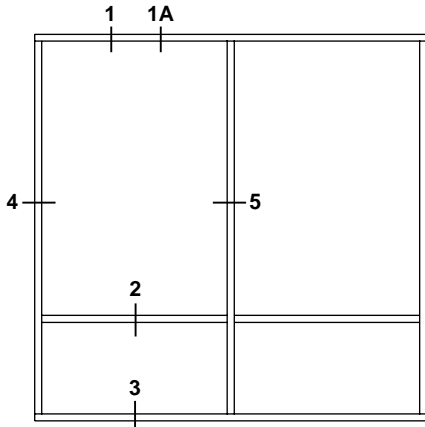


TYPE-B MULTI-LITE PUNCHED OPENINGS
MAXIMUM UNIT WIDTH: 20 FEET

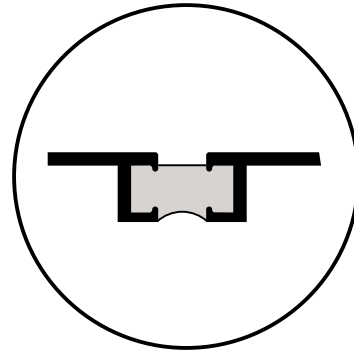
SECTION II - BASIC FRAMING DETAILS

The punched opening fabrication allows a frame to be pre-assembled and installed as a single unit. Screws are run through the back of the head and sill members into splines extruded in the vertical framing members. Intermediate horizontals are attached at the verticals by means of shear blocks.

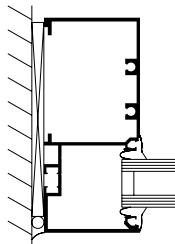
MAXIMUM unit width for Type-B Multi-Lite punched openings: 20 feet.



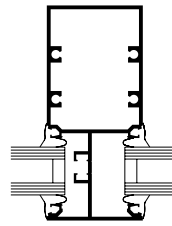
ELEVATION IS NUMBER KEYED TO DETAILS



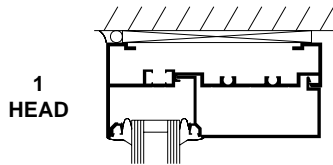
TRIFAB® VG 451T
THERMALLY BROKEN MEMBERS



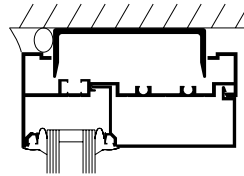
4
JAMB



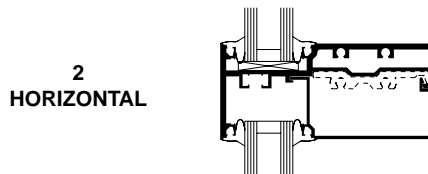
5
VERTICAL



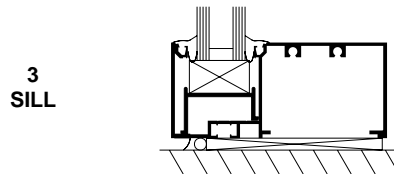
1
HEAD



1A
HEAD



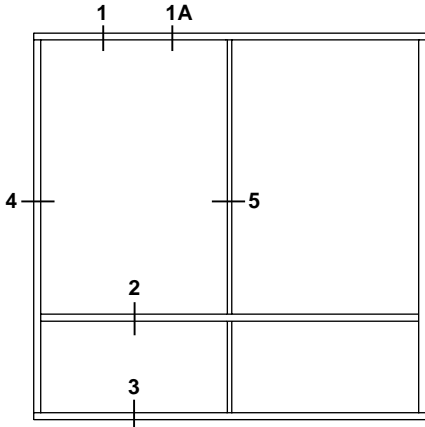
2
HORIZONTAL



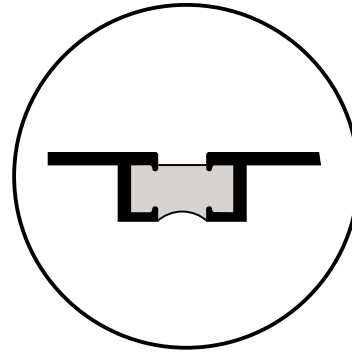
3
SILL

SECTION II - BASIC FRAMING DETAILS

MAXIMUM unit width for Type-B Multi-Lite punched openings: 20 feet.

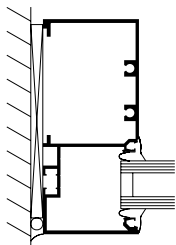


ELEVATION IS NUMBER KEYED TO DETAILS

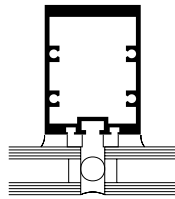


TRIFAB® VG 451T
THERMALLY BROKEN MEMBERS

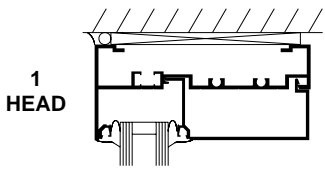
STRUCTURAL SILICONE GLAZING



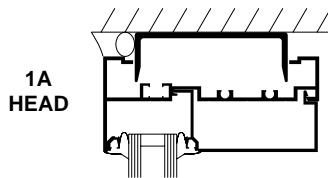
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JAMB



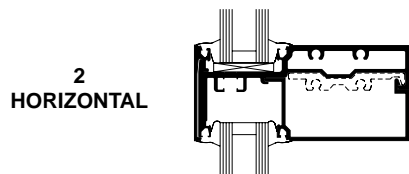
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VERTICAL



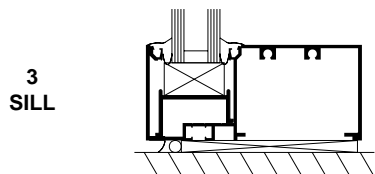
1
HEAD



1A
HEAD

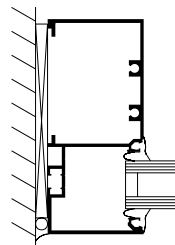


2
HORIZONTAL

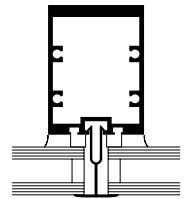


3
SILL

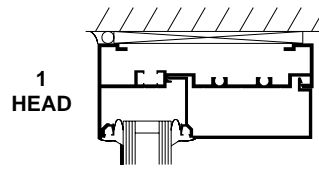
WEATHERSEAL



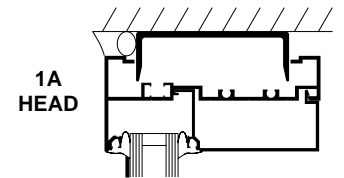
4
JAMB



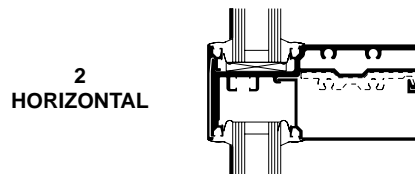
5
VERTICAL



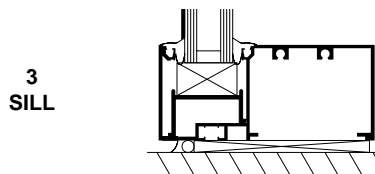
1
HEAD



1A
HEAD



2
HORIZONTAL



3
SILL

SECTION III - FABRICATION

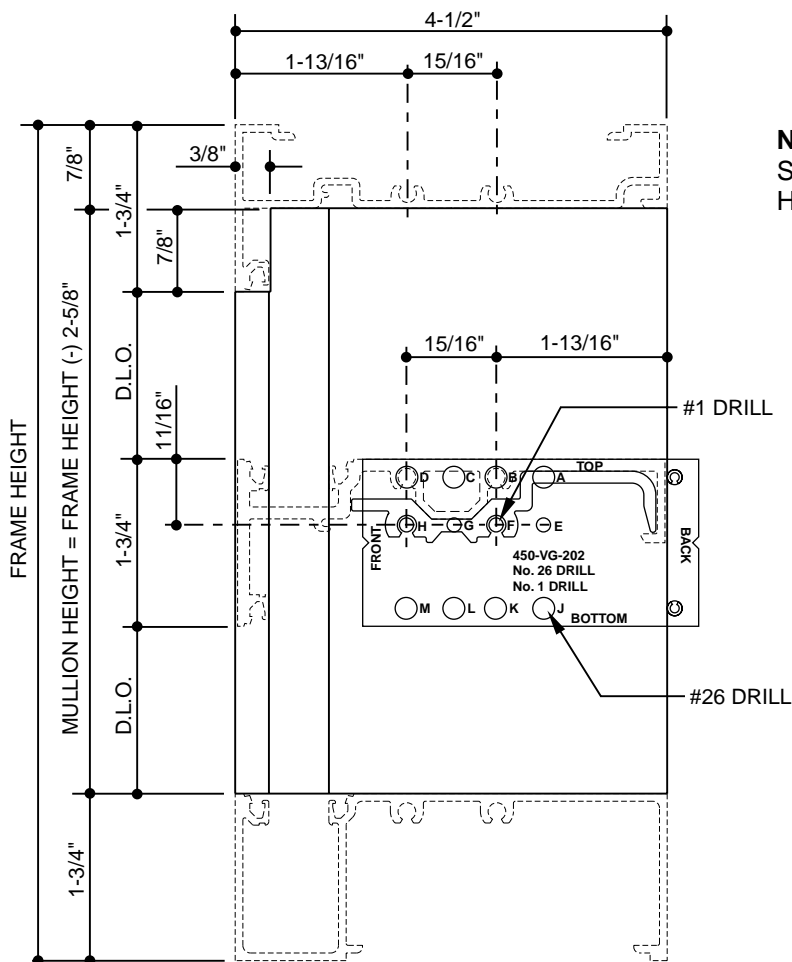
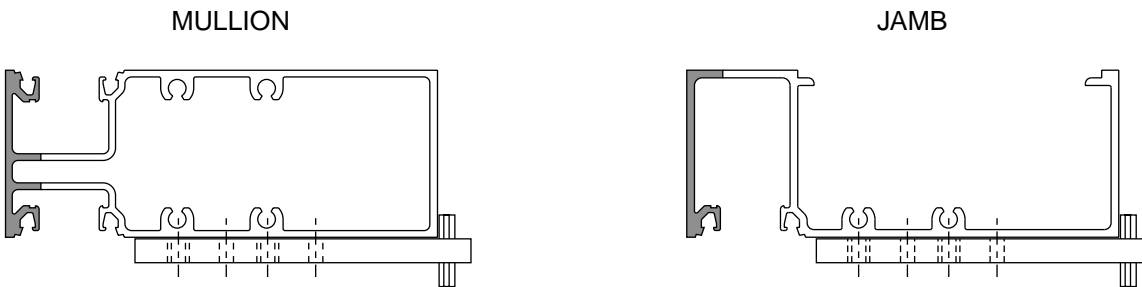
PREPS FOR TRIFAB VG 450

STEP A: VERTICAL PREPS

1. Notch vertical at head as shown.
2. Prep verticals to attach shear blocks using (2) #28-400(#10 x 19/32" P.H.) fasteners.

VERTICAL CUT SIZE = FRAME HEIGHT MINUS (-) 2-5/8"

NOTE: CUT SIZE AT CORNER HALF = FRAME HEIGHT (SEE PAGE 32).



NOTE:
SSG/WEATHERSEAL
HORIZONTAL SIMILAR

SECTION III - FABRICATION

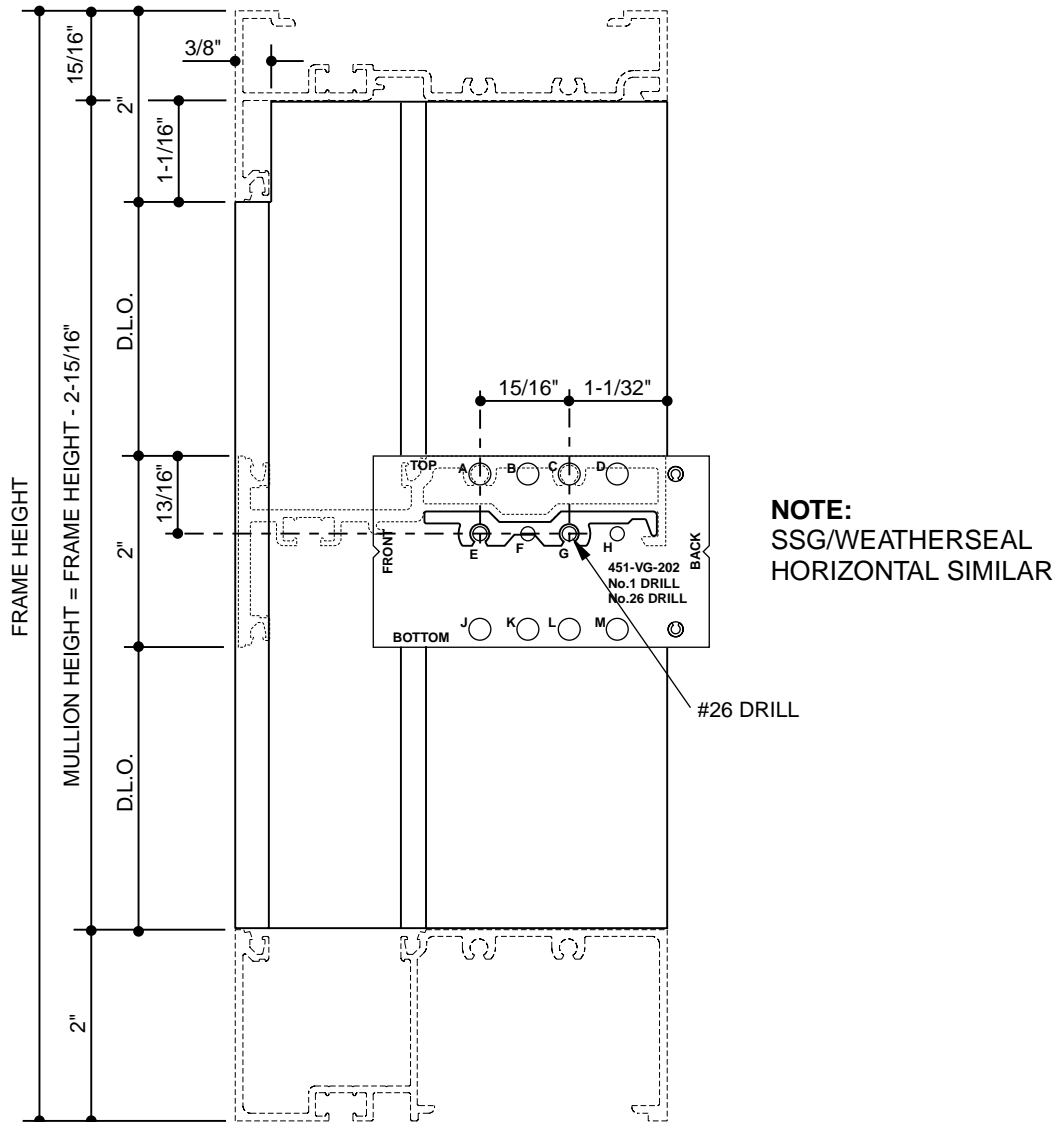
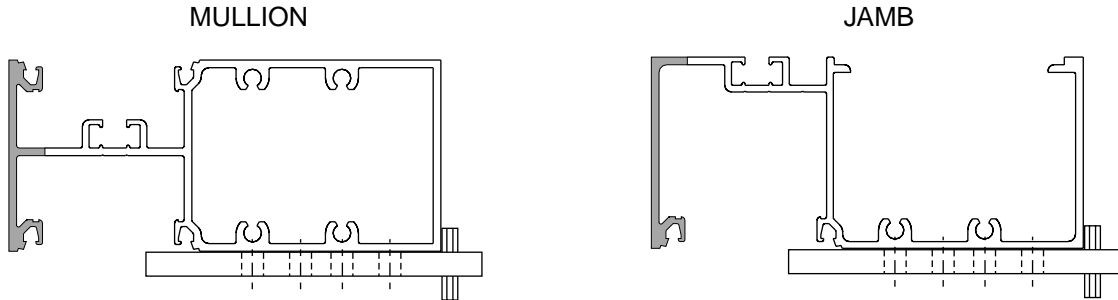
PREPS FOR TRIFAB VG 451/451T

STEP A: VERTICAL PREPS

1. Notch vertical at head as shown.
2. Prep verticals to attach shear blocks using (2) #28-400(#10 x 19/32" P.H.) fasteners.

VERTICAL CUT SIZE = FRAME HEIGHT MINUS (-) 2-15/16"

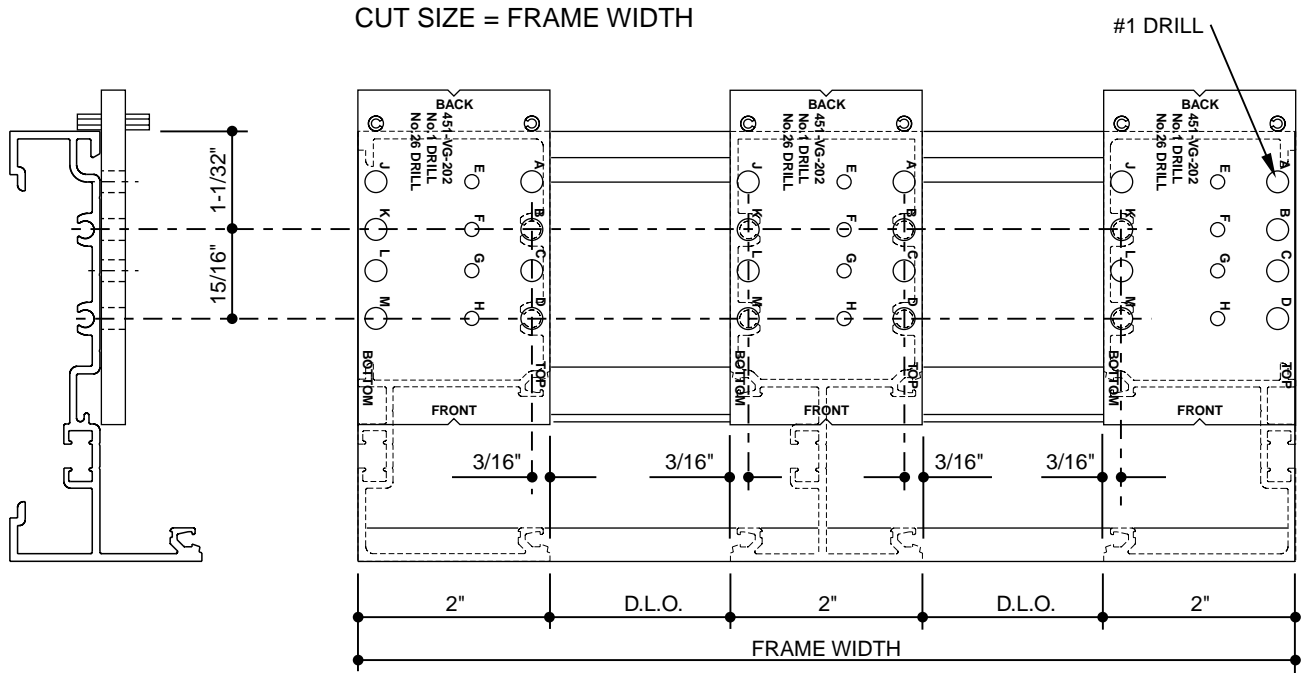
NOTE: CUT SIZE AT CORNER HALF = FRAME HEIGHT (SEE PAGE 33).



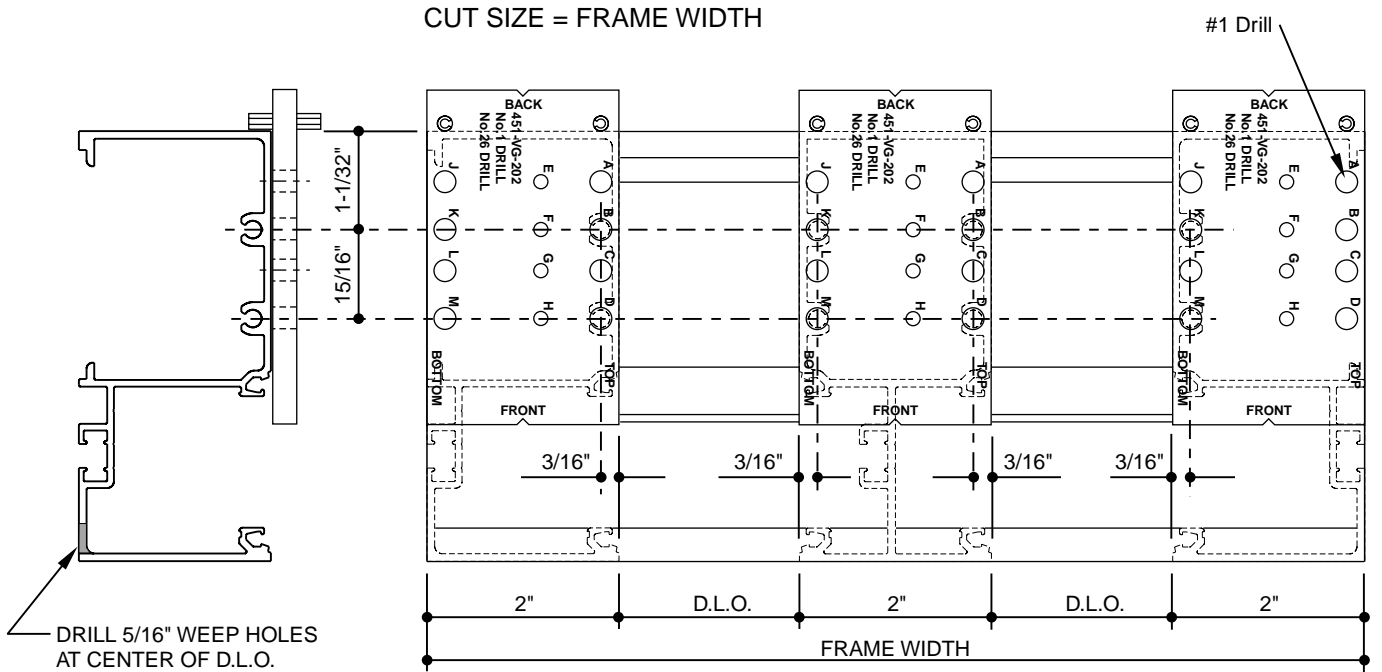
SECTION III - FABRICATION

PREPS FOR TRIFAB VG 451/451T

STEP B: HEAD PREPS



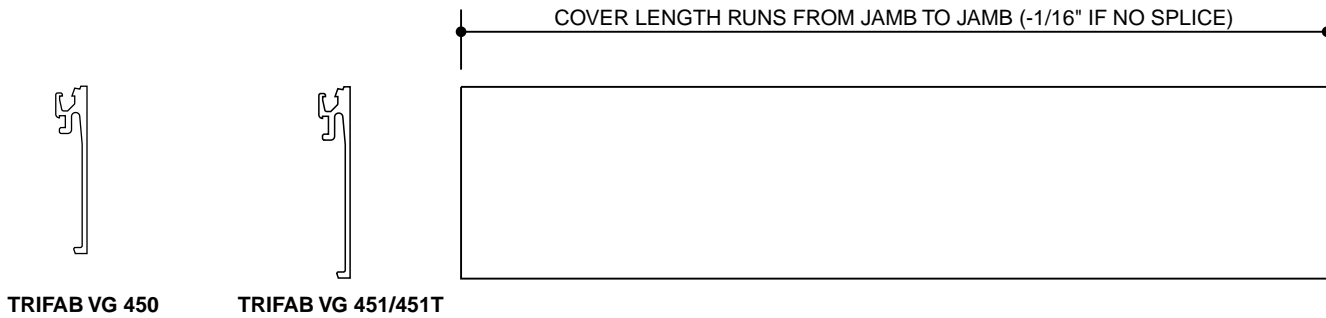
STEP C: SILL PREPS



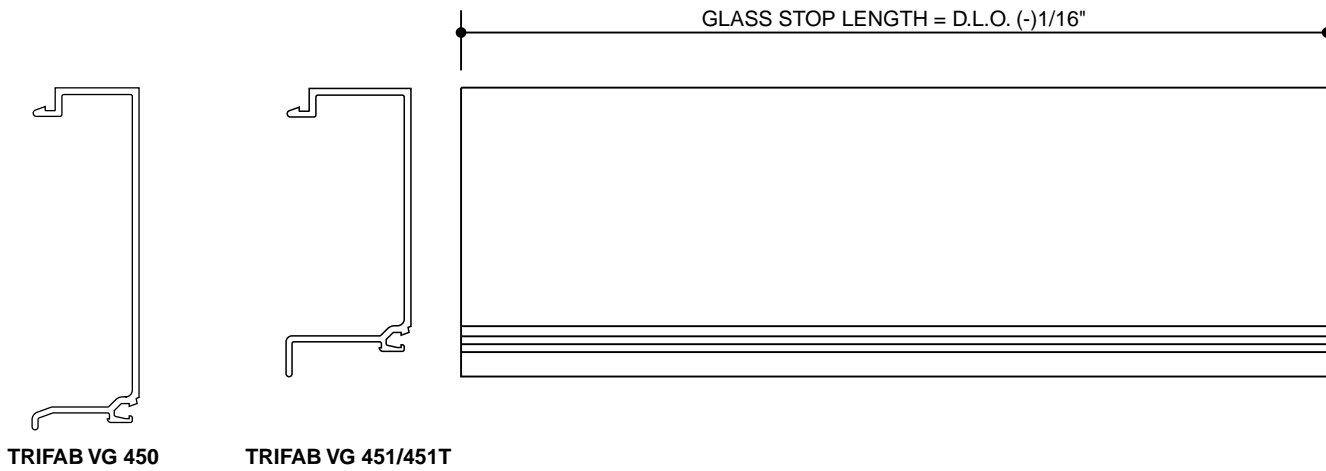
SECTION III - FABRICATION

CUT FORMULA FOR SSG COVER

Cut horizontal cover to length. Horizontal cover runs from jamb to jamb. Horizontal cover length should not exceed 10 feet. If opening exceeds 10 feet, splice horizontal cover at centerline of vertical mullion leaving a 1/4" gap. Reference Page 30 for splice information.

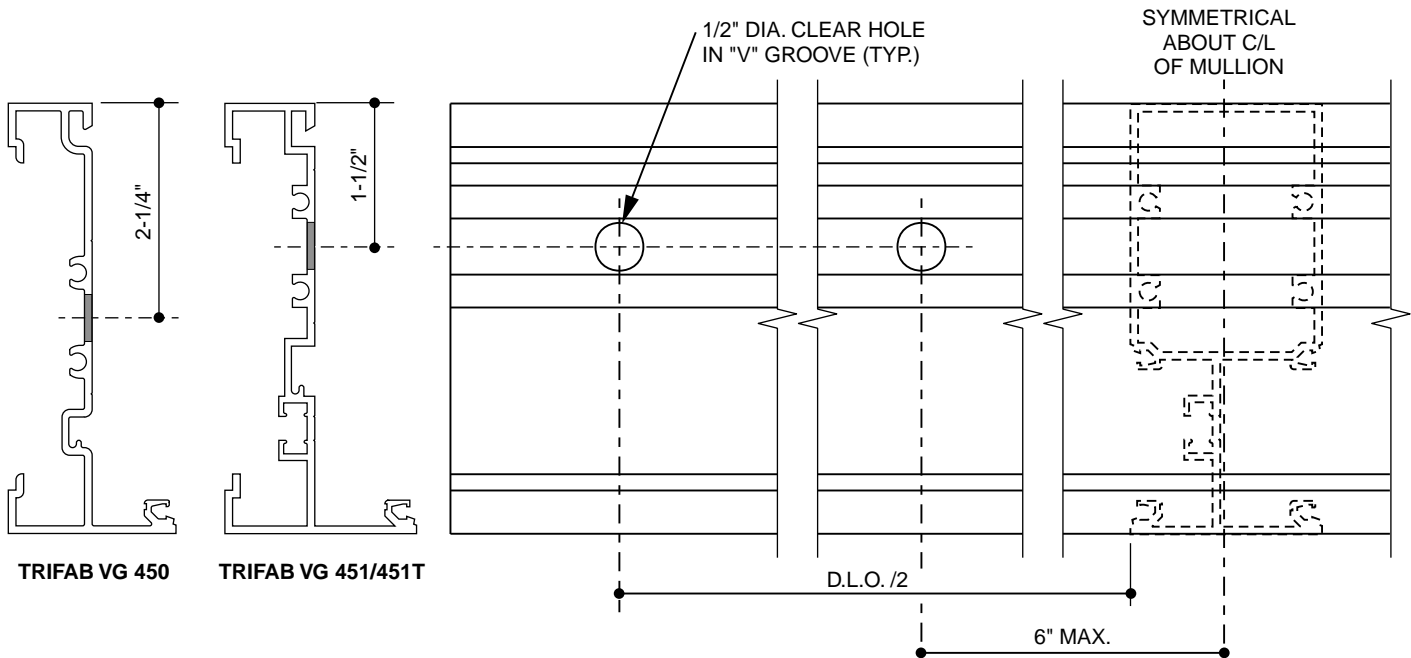


CUT FORMULA FOR GLASS STOPS



OPTIONAL HEAD ANCHOR PREP

If head anchors are used, drill 1/2" dia. clear holes in the head member, as shown below.

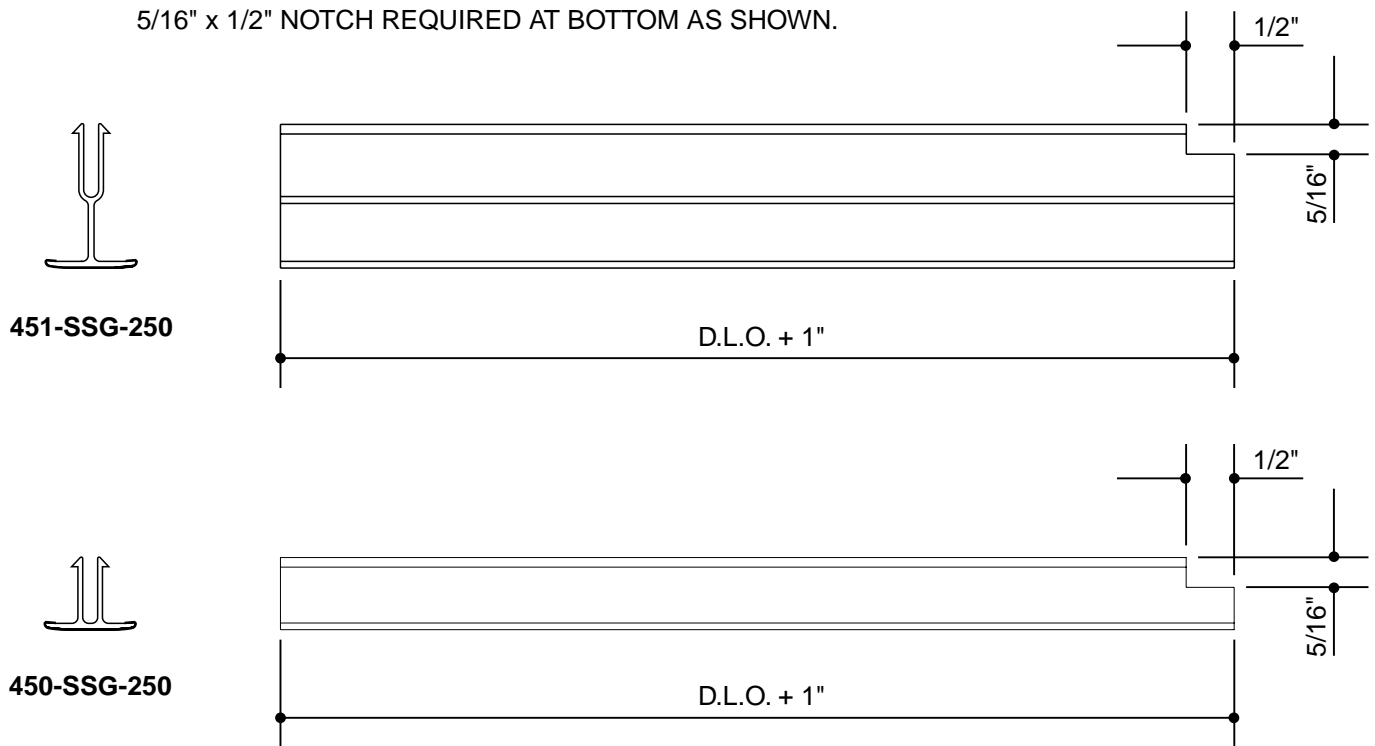


SECTION III - FABRICATION

WEATHERSEAL PREP

CUT LENGTH = D.L.O. + 1"

5/16" x 1/2" NOTCH REQUIRED AT BOTTOM AS SHOWN.



GLAZING ADAPTERS FOR SSG/WEATHERSEAL SYSTEM

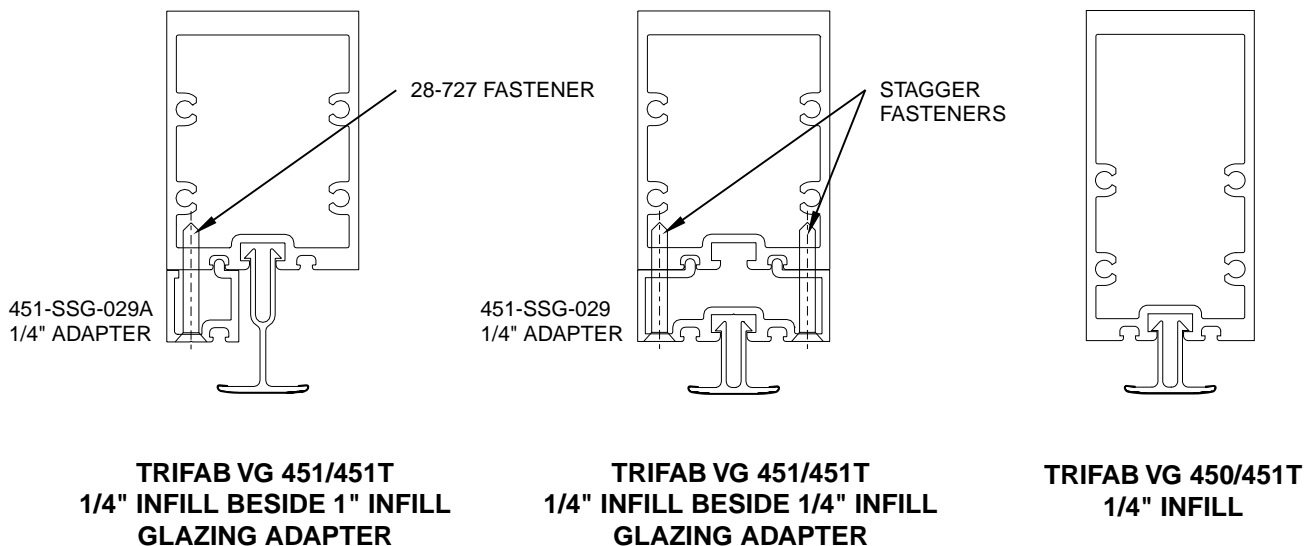
STEP 1: Cut adapters to D.L.O. + 1/2".

STEP 2: Drill attachment screw clearance holes in the vertical adapter 6" from each end and every 12" on center with a #16 (.177) bit and countersink.

STEP 3: Locate adapter on mullion and match drill with #26 (.147) bit.

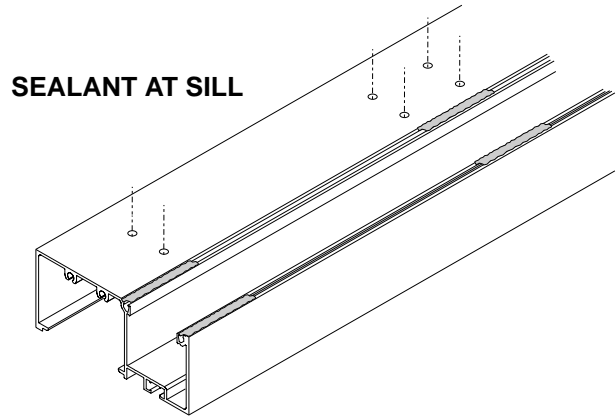
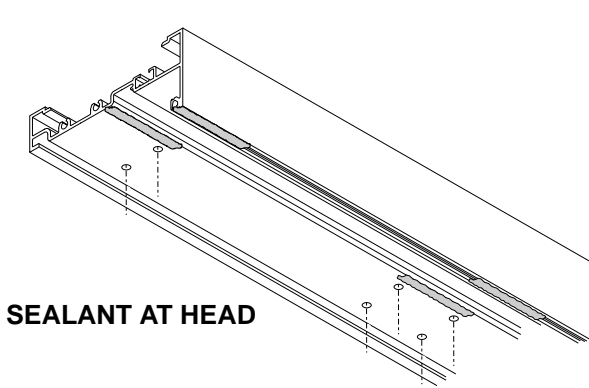
STEP 4: Screw apply adapter to mullion using 28-727 (#8 x 1-1/4" F.H.T.F.S.).

STEP 5: Follow steps shown for horizontal adapter, weathering installation and sealing.



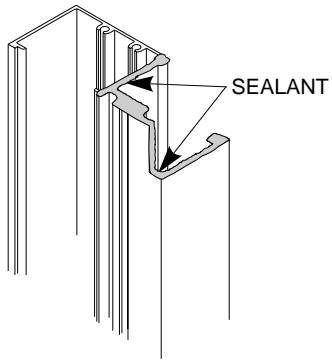
SECTION IV - ASSEMBLY

STEP A: Apply sealant into glazing reglet at the head and sill where vertical mullions will be located.

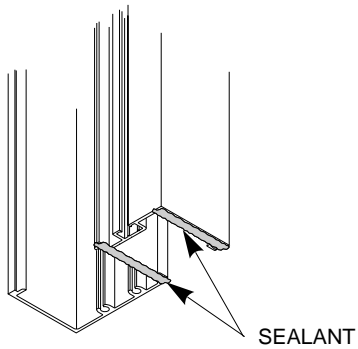
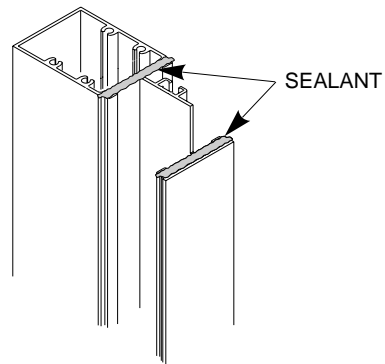


STEP B: Apply sealant to both ends of the vertical mullions and jambs as shown.

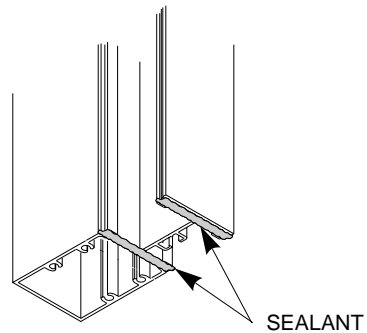
TOP OF JAMB



TOP OF VERTICAL



BOTTOM OF JAMB

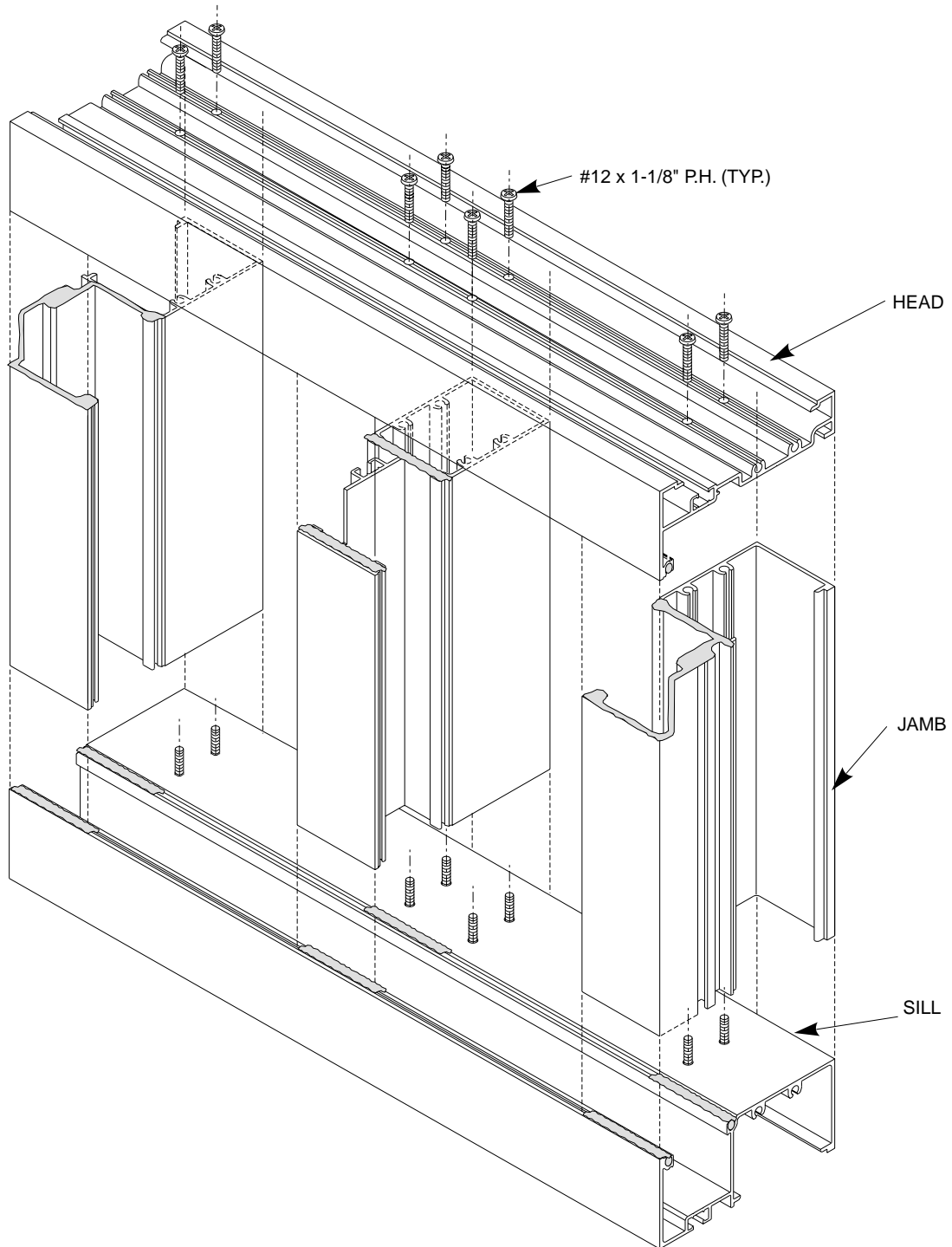


BOTTOM OF VERTICAL

SECTION IV - ASSEMBLY

STEP C: Fasten verticals to the head member using #12 x 1-1/8" P.H. fasteners. Repeat this process at the sill.

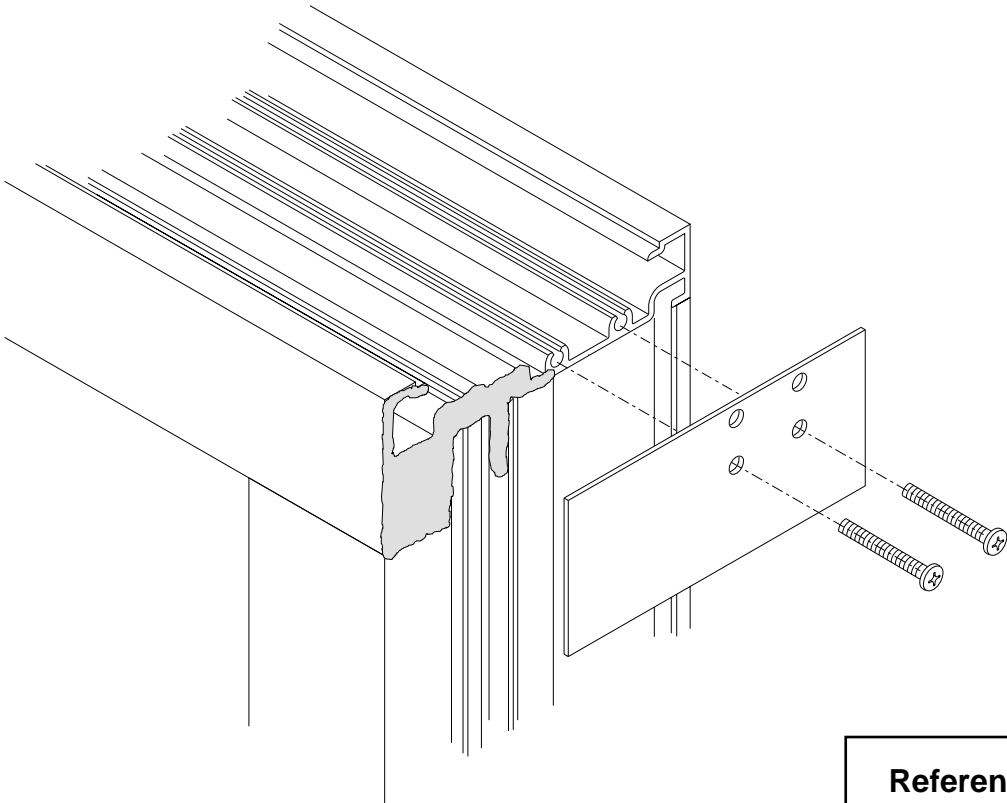
STEP D: After frame is assembled, check for proper sealing between verticals and head/sill members, tool sealant if necessary.



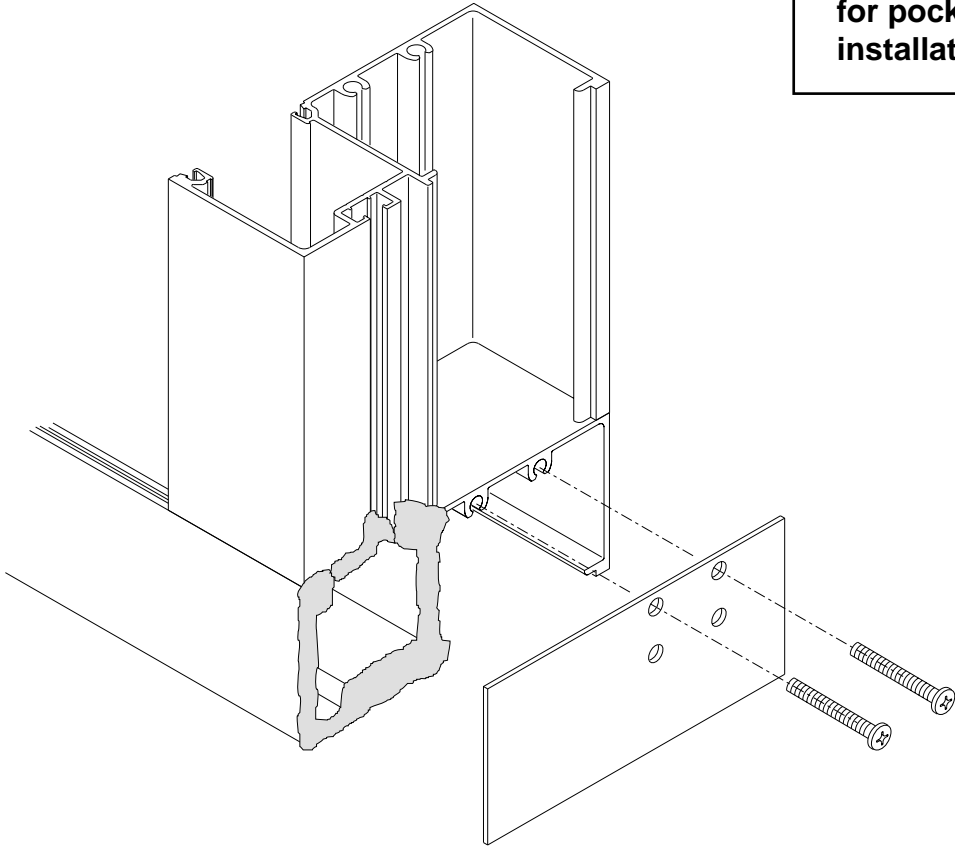
TYPE-B MULTI-LITE PUNCHED OPENINGS
MAXIMUM UNIT WIDTH: 20 FEET

SECTION IV - ASSEMBLY

STEP E: Apply sealant to both ends of head and sill members. Attach end dams using #12 x 1-1/8" P.H. fasteners.



**Reference Page 34
for pocket zone dam
installations at corner.**



SECTION IV - ASSEMBLY

STEP F: ASSEMBLE HORIZONTAL

1. Apply sealant to the ends of horizontal members, shear blocks, and into glazing reglets as shown below.
2. Roll horizontal member over shear block. Hold fabricated horizontal member in place over shear block and tight against vertical member. Match drill tap hole in horizontal with #26 drill (.147") slightly offset to **D.L.O. Side** of hole in the shear block so as to pull the joint tight when assembled as shown below (See Figure 1).
3. Secure horizontal to shear block with supplied fasteners. After horizontal has been installed, check for proper sealing between vertical and horizontal, tool sealant if necessary.

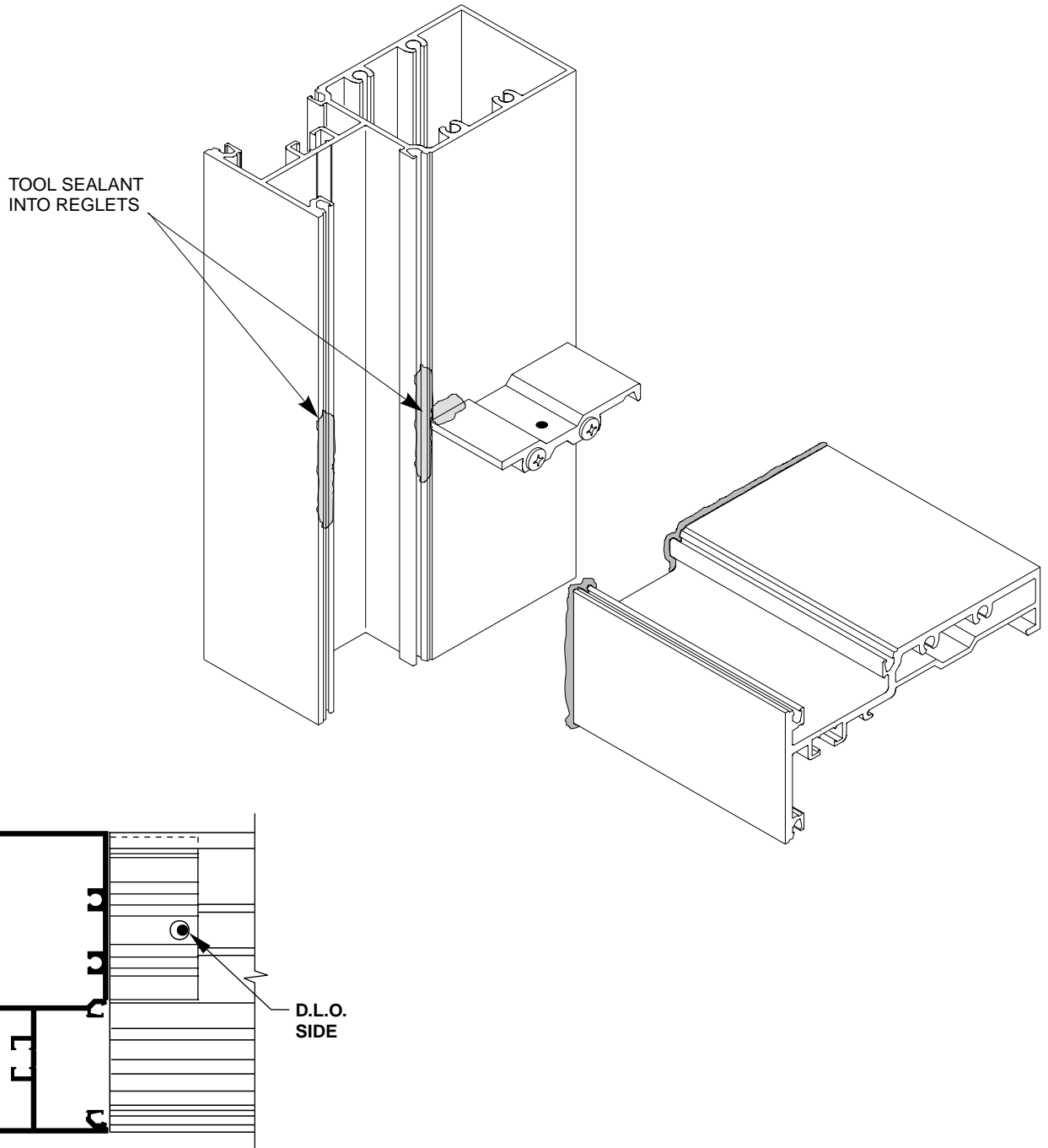
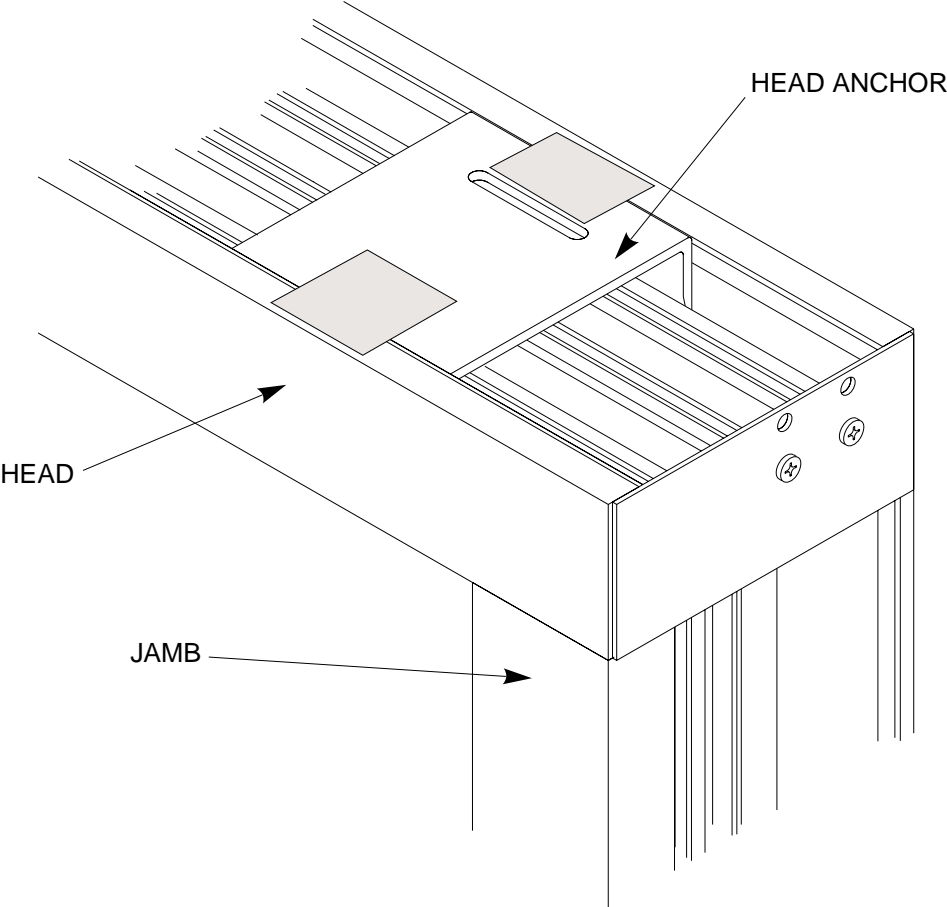


FIGURE 1

SECTION IV - ASSEMBLY

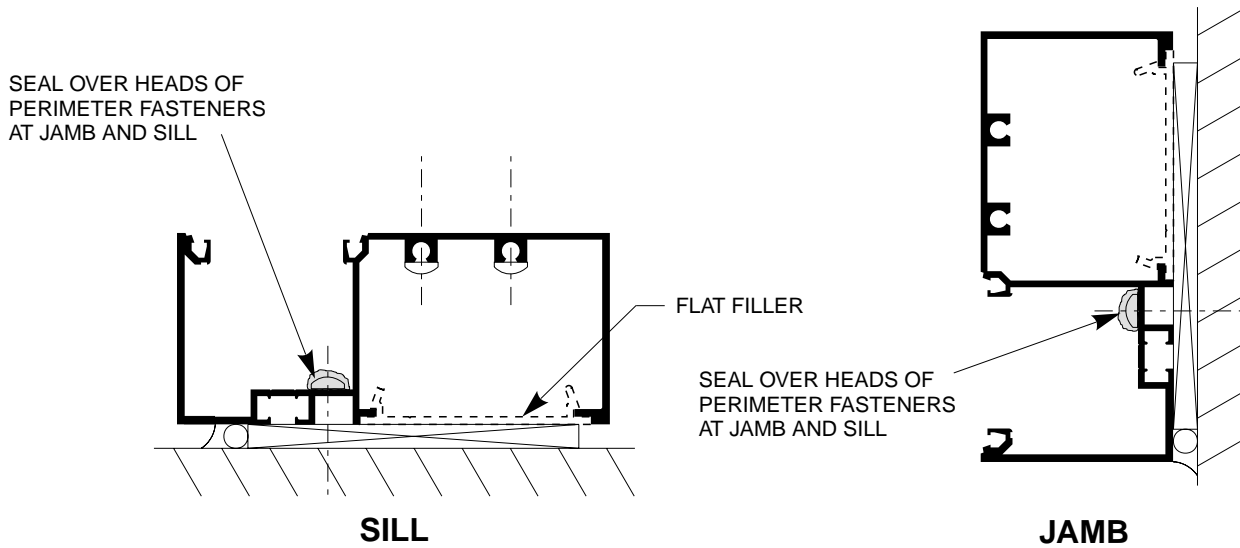
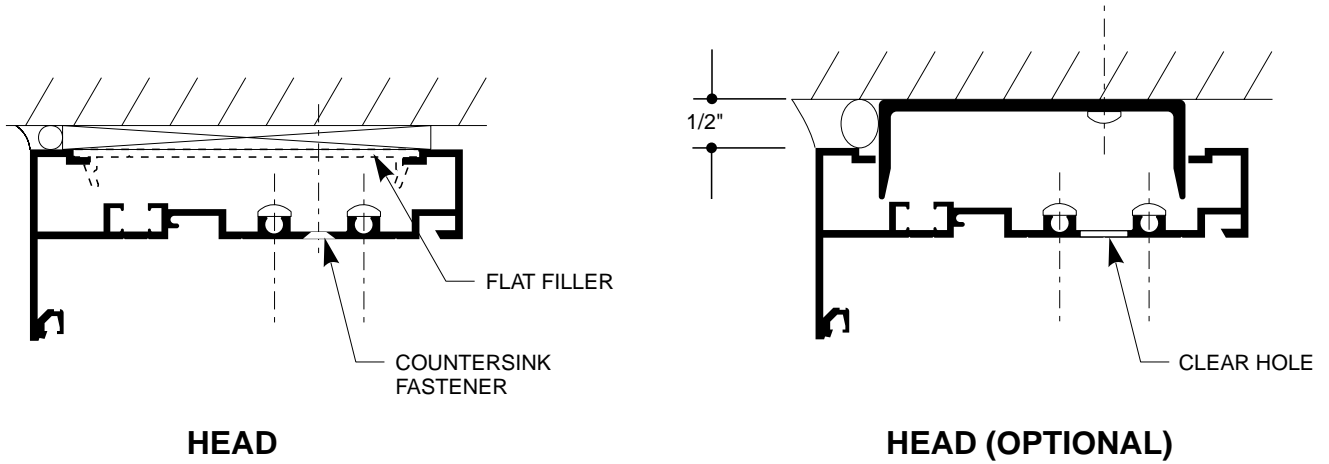
STEP G: Tape optional head anchor into head member at the clearance hole locations.



SECTION V - INSTALLATION

STEP 1: Locate short pieces of flat filler and snap into the back of the jamb and head members as a backup plate to support shims at perimeter fastener locations. Fasteners should be located at 6" from each end of head, sill and jamb and 24" O.C. between.

NOTE: PERIMETER FASTENERS NOT BY KAWNEER.



STEP 2: Install unit into opening. Shim as required checking that unit is level and plumb.

SECTION V - INSTALLATION

WATER DEFLECTOR AT CAPTURED VERTICALS

Install water deflector on Intermediate Horizontals by removing the paper backing from the water deflector. Install them on a clean, dry surface centered in the glazing pocket and seal. (See Figure 1)

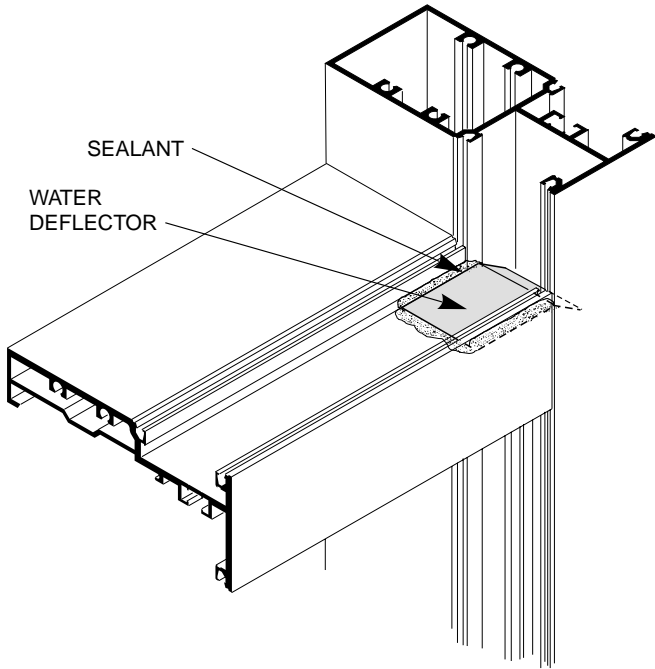


FIGURE 1

COLD WEATHER NOTE:
 For temperatures below 40° the following precautions should be taken. Just prior to installing the water deflector, wipe glazing pocket with a solvent or cleaning solution recommended by the manufacturer.

***CAUTION:** Carefully follow the recommendations contained in the material safety data sheet provided by the solvent/cleaning solution manufacturer regarding health and fire/explosion risks.

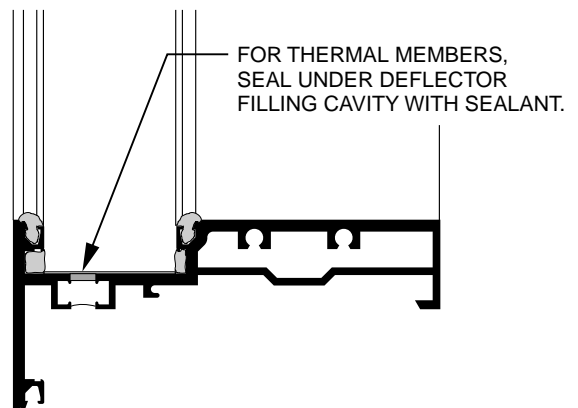
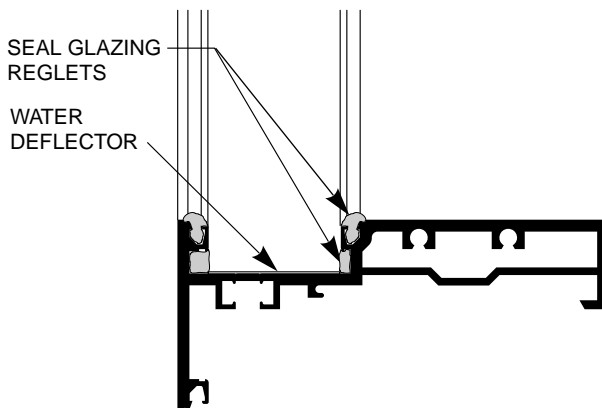
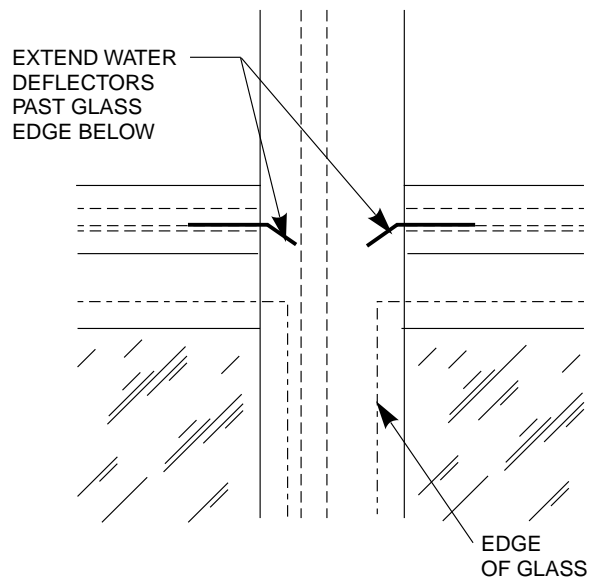


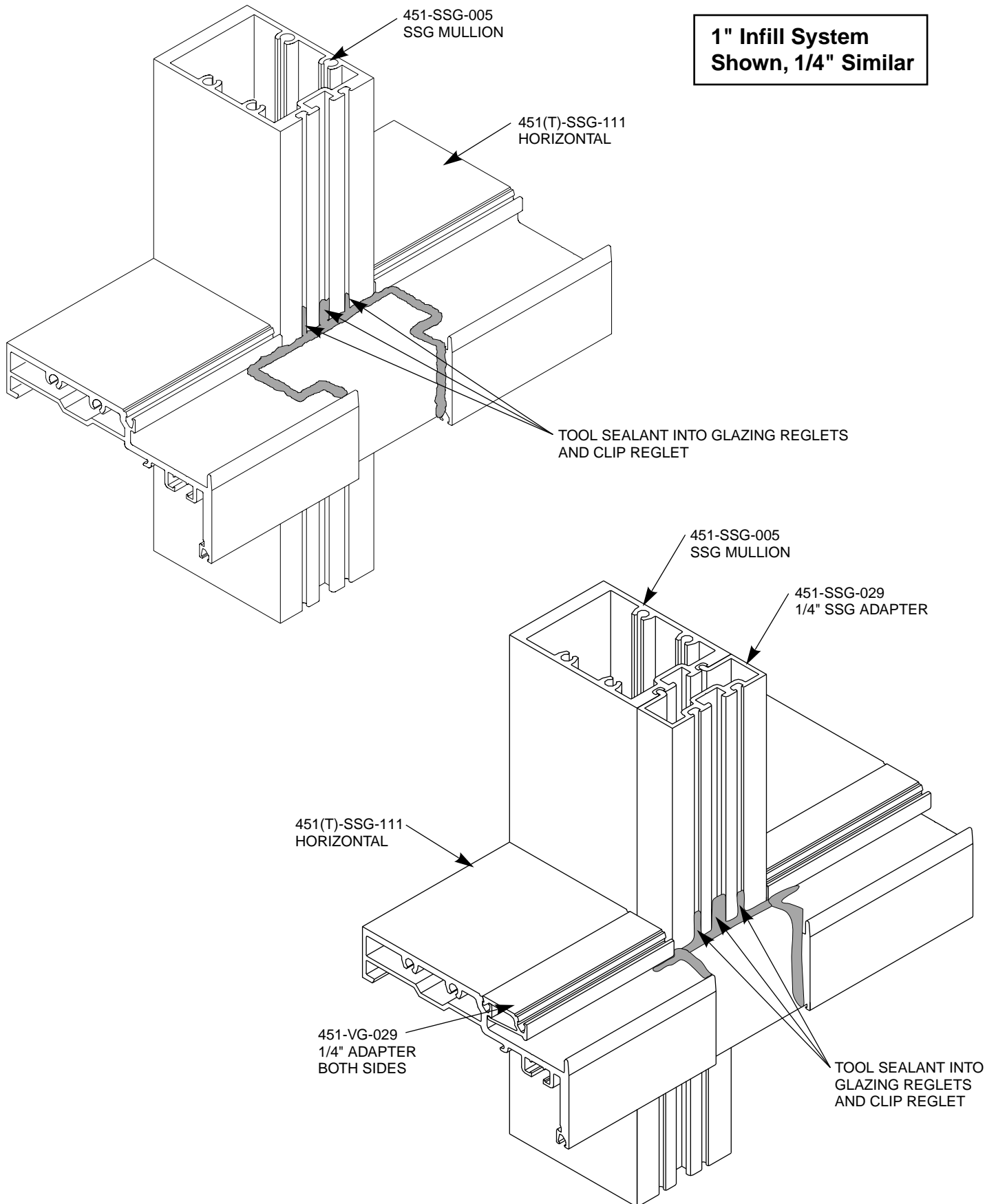
FIGURE 2

After the water deflector is installed, seal the joint between the back leg of the Horizontal and the Vertical. Make sure to fill the glazing Gasket reglets in the area to prevent water from running down to the lite below. (See Figure 2).

SECTION V - INSTALLATION

WATER DEFLECTOR AT SSG/WEATHERSEAL MULLIONS

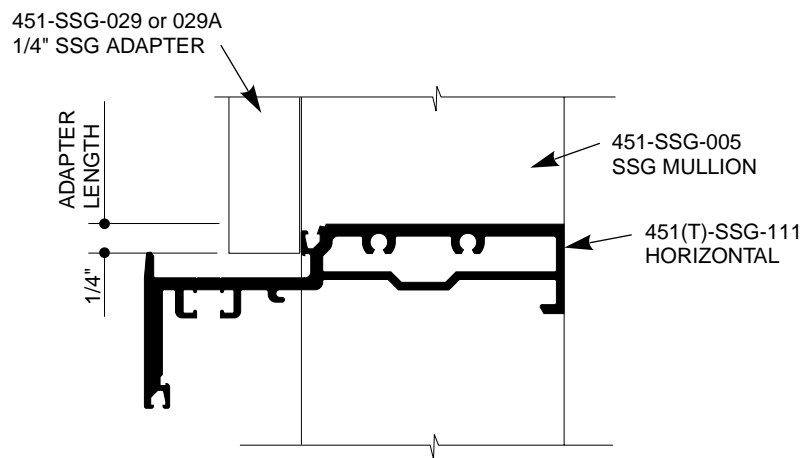
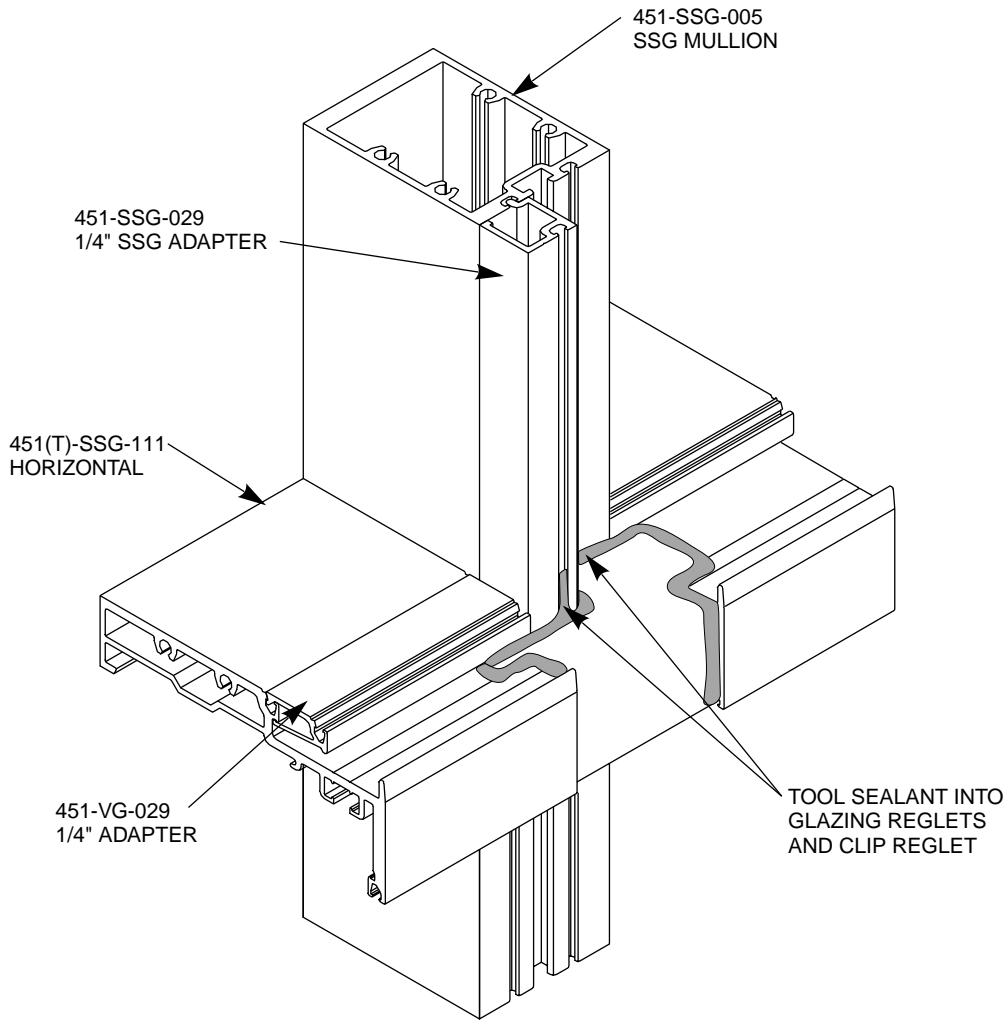
NOTE: FOR WATER DEFLECTOR AT JAMBS, REFER TO PAGE 22.



SECTION V - INSTALLATION

WATER DEFLECTOR AT SSG/WEATHERSEAL MULLIONS

NOTE: FOR WATER DEFLECTOR AT JAMBS, REFER TO PAGE 22.



SECTION VI - GLAZING ADAPTERS

GLAZING ADAPTERS FOR TRIFAB VG 451/451T

TYPICAL INSTALLATION OF PARTIAL OR FULL LENGTH VERTICAL GLAZING ADAPTERS - PRIOR TO FRAME ASSEMBLY

Vertical glazing adapters may be installed for partial, (**Figure 1**) or full-length, (**Figure 2**) applications at the time the frames are assembled.

STEP 1: Cut VERTICAL glazing adapters to D.L.O. Plus 1/2" for partial length applications or to Vertical member length for full-length applications.

STEP 2: Cut HORIZONTAL glazing adapters to D.L.O.

STEP 3: Snap vertical adapters into glazing reglets of frame and assemble frame as instructed. In partial length applications, vertical adapter should be positioned to allow sealing of the horizontal adapter to the vertical adapter (approximately 1/4" projection into horizontal pocket, **Figure 3**). It may be necessary to lightly crimp vertical adapter in place to prevent sliding.

SPECIAL NOTE: When using pre-installed vertical glazing adapters, care should be taken at the time of the frame assembly, to seal the vertical glazing reglets where they meet the intermediate horizontals. The 1/4" water deflector should be used on all full-length applications (**Figure 4**), and installed as shown in **Section V**. 1" water deflectors are used for partial adapter applications as long as the adapter does not impede water evacuation of the intermediate horizontal. The water deflector must allow water to drain into the vertical pocket *beyond* the edge of the glass below.

STEP 4: Apply sealant to vertical adapter at the final position of the snapped-in horizontal adapter.

STEP 5: Snap the HORIZONTAL glazing adapters into the glazing reglet allowing the adapter to rotate into the pocket and contact the sealant at the vertical adapter.

INSTALLATION OF GLAZING ADAPTERS - AFTER FRAME ASSEMBLY AND FOR FIELD RETROFIT APPLICATIONS

STEP 1: Cut VERTICAL glazing adapters to D.L.O. + 1/2".

STEP 2: Make a 1/4" by 1/4" notch at each end of the vertical glazing adapter. Notch should be made on the face side of the adapter nearest the gasket reglet as shown. (**Figure 5**)

STEP 3: Cut HORIZONTAL glazing adapters to D.L.O.

STEP 4: Snap vertical adapters into glazing reglets of frame. Adapter should be positioned to allow sealing of horizontal adapter to the vertical adapter (approximately 1/4" projection into horizontal pocket, **Figure 3**)

SPECIAL CARE NOTE: Care should be taken to insure that the glazing adapter does not impede water evacuation at the intermediate horizontal. The previously installed 1" water deflector must allow water to drain into the vertical pocket *beyond* the edge of the glass below.

STEP 5: Apply sealant to vertical adapter at the final position of the snapped-in horizontal adapter.

STEP 6: Snap the HORIZONTAL glazing adapters in the glazing reglet allowing the adapter to rotate into the pocket and contact the sealant at the vertical adapter.

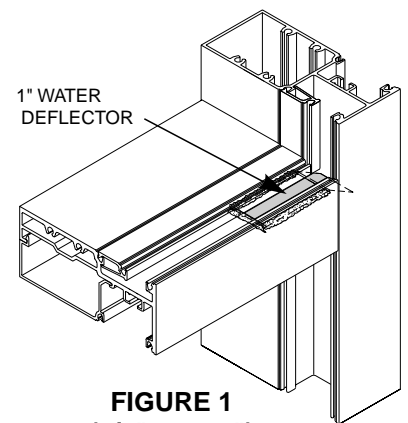


FIGURE 1
(1/4" over 1")

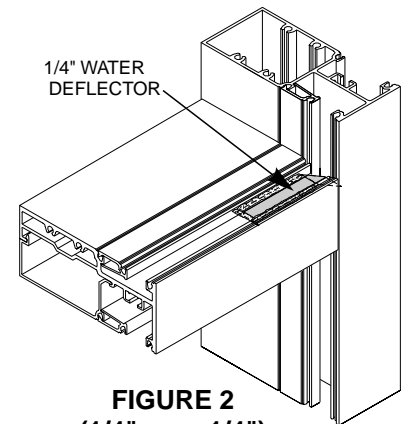


FIGURE 2
(1/4" over 1/4")

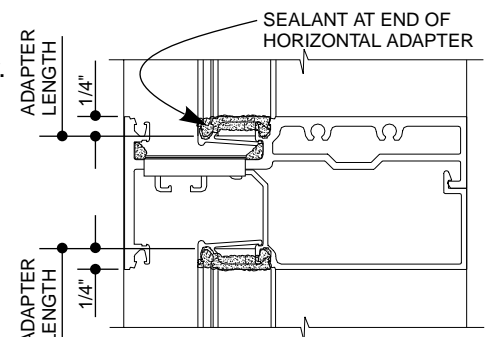


FIGURE 3

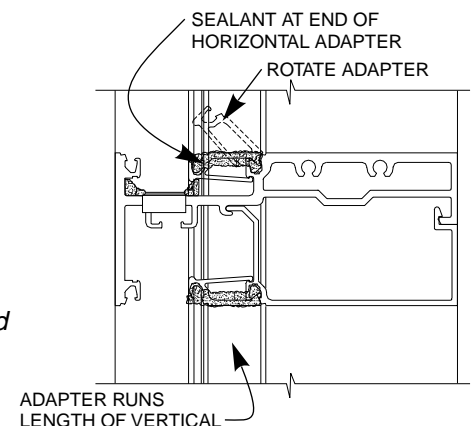


FIGURE 4

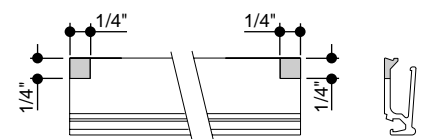


FIGURE 5

SECTION VII - GLAZING

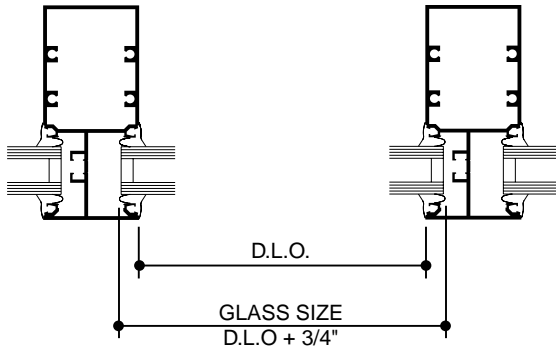
CAPTURED SYSTEM

STEP A: All pockets for 1" infill are 1-3/8" in width and will accept up to 1-1/8" glass dry glazed.
 All pockets for 1/4" infill are 5/8" in width, and will accept up to 3/8" glass dry glazed.

STEP B: Glass size is (Daylight Opening) D.L.O. + 3/4".

NOTE 1: This formula does not allow for undersize or out of square daylight openings.

NOTE 2: The glass manufacturer must indicate the specific glazing requirements for the material being used.



**CAPTURED SYSTEM
 GLAZING CHART for 1/4" SYSTEM**

Infill Thickness	Weathering (Both Sides)
1/8"	27-077 (Heavy)
1/4"	27-074 (Standard)
3/8"	27-076 (Light)

GLAZING CHART for 1" SYSTEM

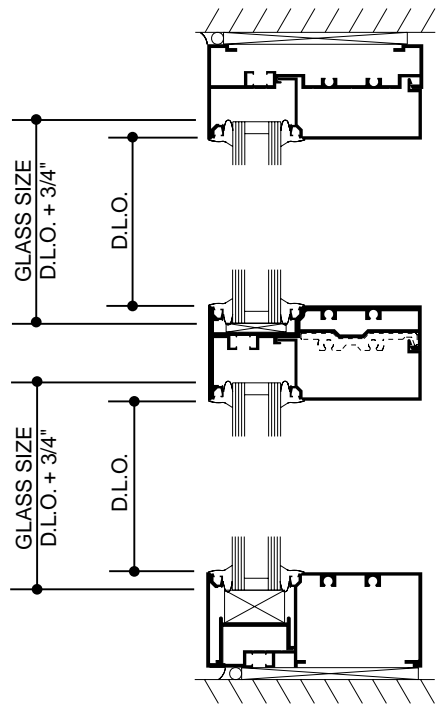
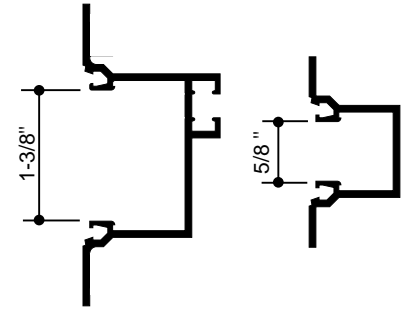
Infill Thickness	*Adapter	Weathering (Both Sides)
1/8"	451-VG-029	27-077 (Heavy)
1/4"	451-VG-029	27-074 (Standard)
3/8"	451-VG-029	27-076 (Light)
1/2"	451-VG-030	27-077 (Heavy)
5/8"	451-VG-030	27-074 (Standard)
3/4"	451-VG-030	27-076 (Light)
7/8"	—	27-077 (Heavy)
1"	—	27-074 (Standard)
1-1/8"	—	27-076 (Light)

NOTE: For infill thickness in 1/16" increments or oversize and undersize glass, use a combination of the standard (27-074) with either the light (27-076) or heavy (27-077) gaskets.



27-077 (HEAVY) 27-074 (STANDARD) 27-076 (LIGHT)

NOTE: I.D. Marks = 3 for Heavy, 2 for Light, and none for Standard



CAPTURED SYSTEM

*** NOTE:**
 Snap-in glazing adapters 451-VG-029 and 451-VG-030 are provided for applications requiring infills less than 1" in thickness at adaptation. Reference Page 25, Glazing Adapters, for adapter cut lengths and seal information.

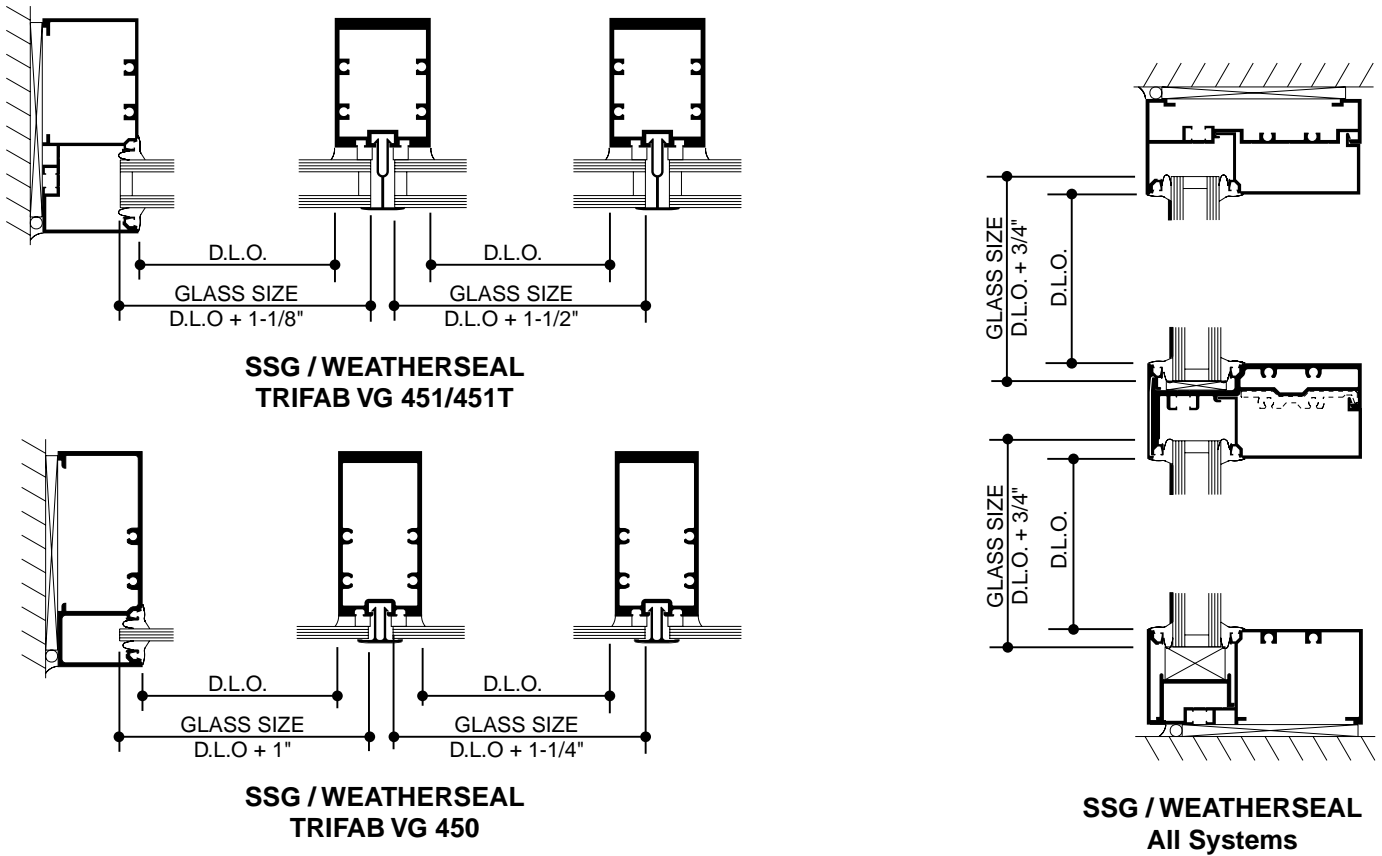
SECTION VII - GLAZING

SSG / WEATHERSEAL SYSTEM

STEP A: SSG/WEATHERSEAL system will accept 1/4" or 1" vision and 1/4" or 1" spandrel infills.

NOTE 1: This formula does not allow for undersize or out of square daylight openings.

NOTE 2: The glass manufacturer must indicate the specific glazing requirements for the material being used.



SSG / WEATHERSEAL GLAZING CHART

Infill Thickness	* Vertical Adapter	* Head, Jamb & Sill Adapter	Vertical Spacer	Head, Jamb & Sill Gasket	Weatherseal
1/4"	—	—	127-008	27-074	450-SSG-250
1/4" ADAPTED	451-SSG-029 or 451-SSG-029A	451-VG-029	127-008	27-074	450-SSG-250
1"	—	—	127-008	27-074	451-SSG-250

NOTE: For infill thickness in 1/16" increments or oversize and undersize glass, use a combination of the standard (27-074) with either the light (27-076) or heavy (27-077) gaskets.



27-077 (HEAVY) 27-074 (STANDARD) 27-076 (LIGHT)

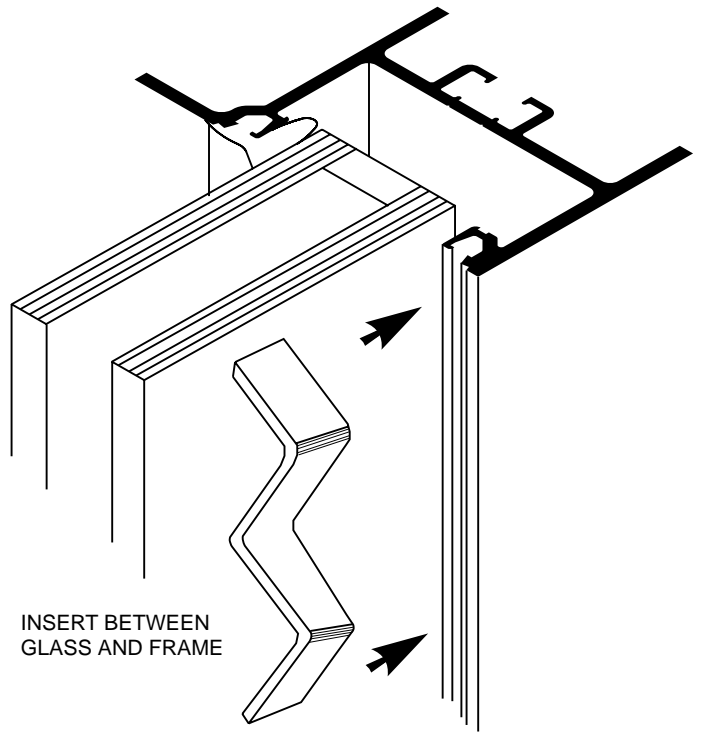
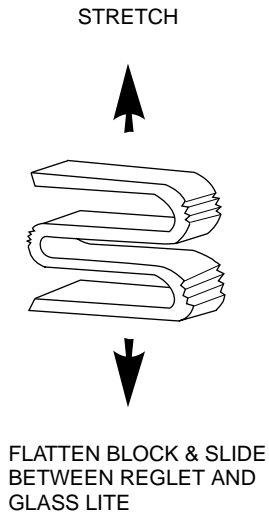
NOTE: I.D. Marks = 3 for Heavy, 2 for Light, and none for Standard

* See page 15 for adapted details.

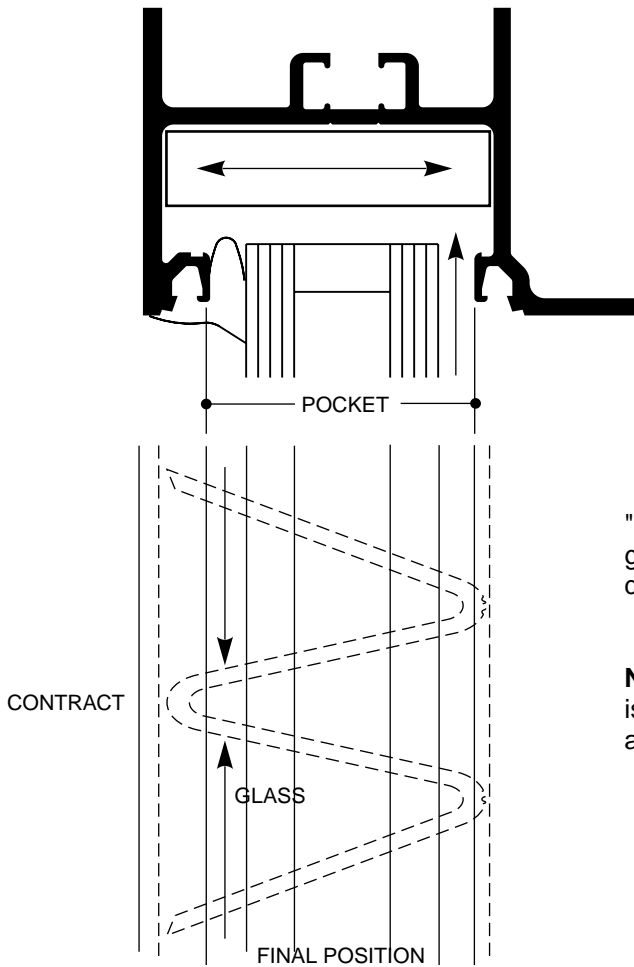
SECTION VII - GLAZING

"W" SIDE BLOCKS

One "W" Side Block should be installed into the deep pocket of the mullion of each lite of glass in the opening.



SIDE BLOCK INSTALLATION



"W" Block will expand and wedge between walls of glazing pocket and prevent glass from shifting into deep pocket.

NOTE: If deglazing of lite is required after "W" Block is installed, remove both interior and exterior weathering and use hook to pull "W" Block out of the pocket.

SECTION VII - GLAZING

GASKET AND GLASS STOP INSTALLATION FOR CAPTURED SYSTEM

STEP 1: Cut horizontal and vertical gaskets to an approximate length of D.L.O. + 1/4" per foot of D.L.O..

STEP 2: Install gaskets on the side of frame opposite glass stops first. ①

Insert gaskets into the horizontal members first starting at the ends and work toward the center as shown.
(See Figure 1)
Install vertical gaskets into the same side of frame after horizontal gaskets are in place in the same manner.

STEP 3: Position setting blocks at points under glass as required.

STEP 4: Install glass into frame using standard flush glazing technique. ②

STEP 5: Run bead of sealant along vertical reglets where glass stop meets, then install glass stop. ③

STEP 6: Install horizontal and vertical gaskets into glass stop side of frame in the same manner as described in Step 2.

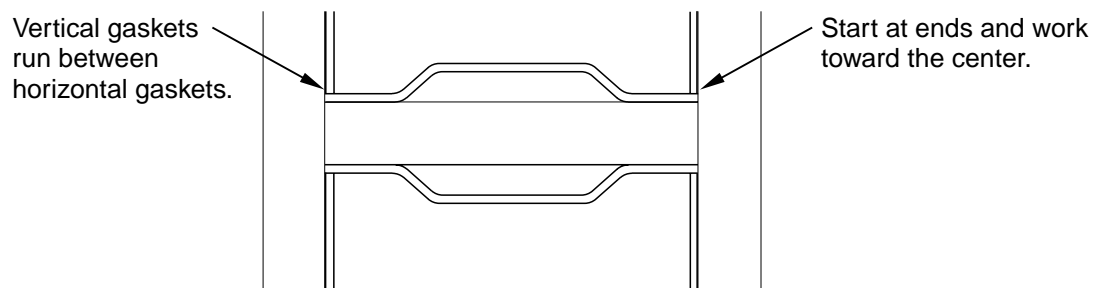
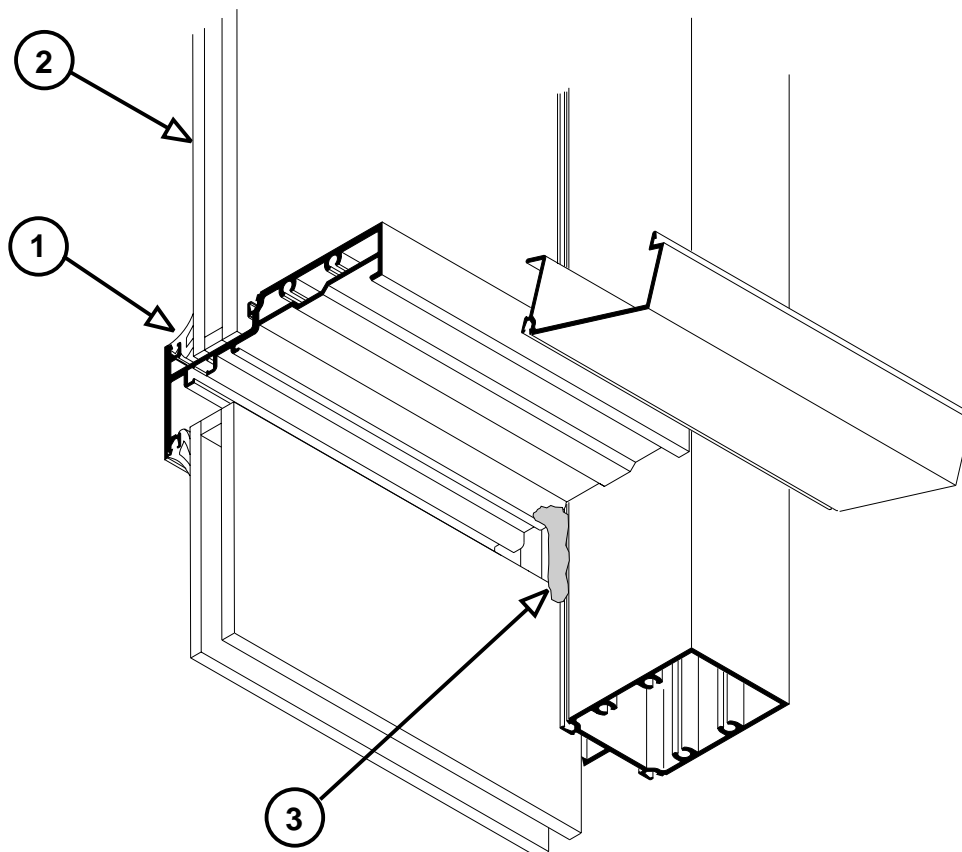


FIGURE 1



SECTION VII - GLAZING

GASKET AND GLASS STOP INSTALLATION FOR SSG SYSTEM

STEP 1: Cut horizontal and vertical gaskets, and SSG spacer to approximate length of D.L.O. + 1/4" per foot of D.L.O.

NOTE: Exterior horizontal gaskets run continuous across opening. Cut this gasket to approximate length of opening width + 1/4" per foot of opening.

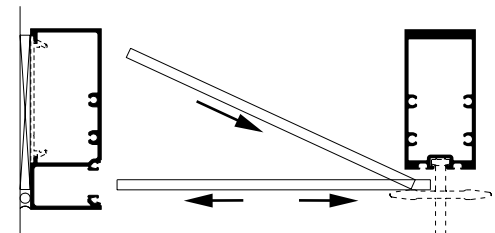
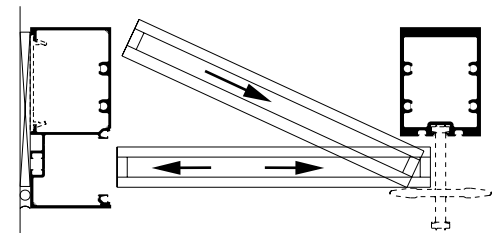
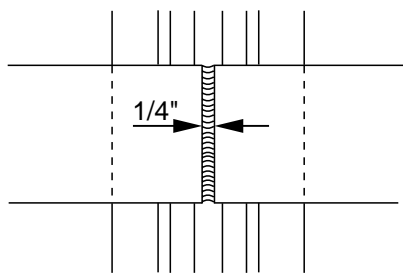
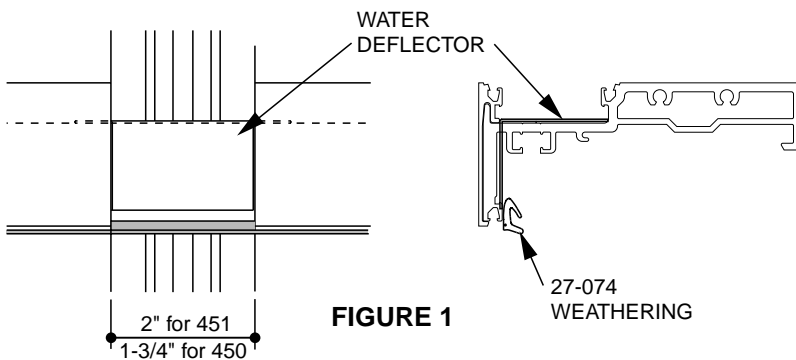
STEP 2: Install setting blocks and/or setting block chairs into the horizontal members.

STEP 3: At all intermediate horizontal water deflectors, cut the dart and back leg off of weathering, 27-074 (**Figure 1**). This will create a weep slot after the horizontal cover is installed.

STEP 4: Install exterior horizontal covers. Covers should not exceed a maximum of 10 feet. If an elevation is longer than 10 feet, splice the horizontal covers at mullions as shown (**Figure 2**).

STEP 5: Install gasket on the side opposite the glass stops first. Insert gaskets into horizontal members first starting at the ends and working towards the center. Install vertical gaskets in the same manner.

STEP 6: Install glass in the frame opening (**Figure 3**). Install temporary glass retainers to hold glass in place. Retainers should be spaced a maximum of 30" on center. If high windload conditions are anticipated, additional retainers may be needed. Consult your sealant and glass supplier for spacing recommendations.



STEP 7: Install adjacent glass light and then install SSG glazing spacer along mullion at each light.

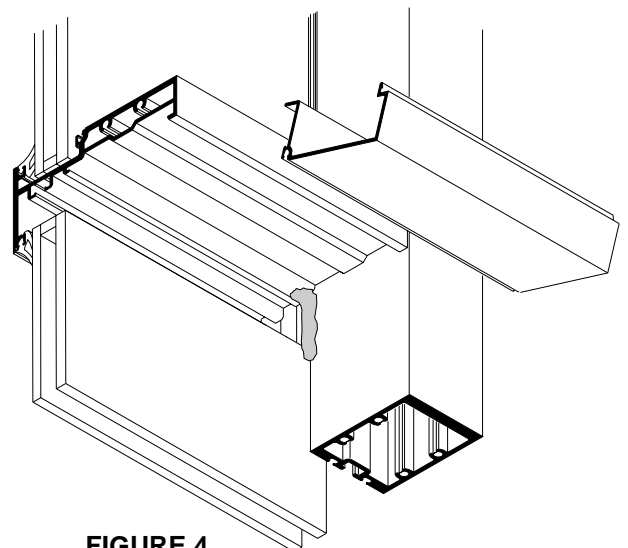
STEP 8: Apply sealant along verticals where glass stop meets, then install glass stops (**Figure 4**).

STEP 9: Install interior push-on gasket.

STEP 10: Mask SSG mullion and glass as required. Install the interior, vertical structural seal.

NOTE: Kawneer does not supply the structural silicone sealant. This sealant is to be recommended by the sealant manufacturer. Reference the SSG GLAZING NOTE found in the GENERAL NOTES section of this manual.

STEP 11: Apply exterior seal at the butt glass joint.



SECTION VII - GLAZING

GASKET AND GLASS STOP INSTALLATION FOR WEATHERSEAL OPTION

STEP 1: Cut horizontal and vertical gaskets, and SSG spacer to approximate length of D.L.O. + 1/4" per foot of D.L.O.

NOTE: Exterior horizontal gaskets run continuous across opening. Cut this gasket to approximate length of opening width + 1/4" per foot of opening.

STEP 2: Install setting blocks and/or setting block chairs into the horizontal members.

STEP 3: At all intermediate horizontal water deflectors, cut the dart and back leg off of weathering 27-074 (**Figure 1**). This will create a weep slot after the horizontal cover is installed.

STEP 4: Install exterior horizontal covers. Covers should not exceed a maximum of 10 feet. If an elevation is longer than 10 feet, splice the horizontal covers at mullions as shown (**Figure 2**).

STEP 5: Install gasket on the side opposite the glass stops first. Insert gaskets into horizontal members first starting at the ends and working towards the center. Install vertical gaskets in the same manner.

STEP 6: Install glass in the frame opening (**Figure 3**). Install snap-in Weatherseal to hold glass in place.

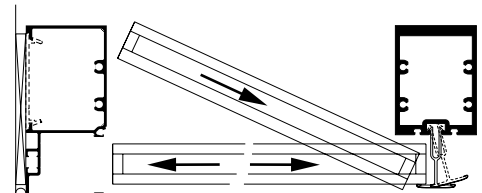
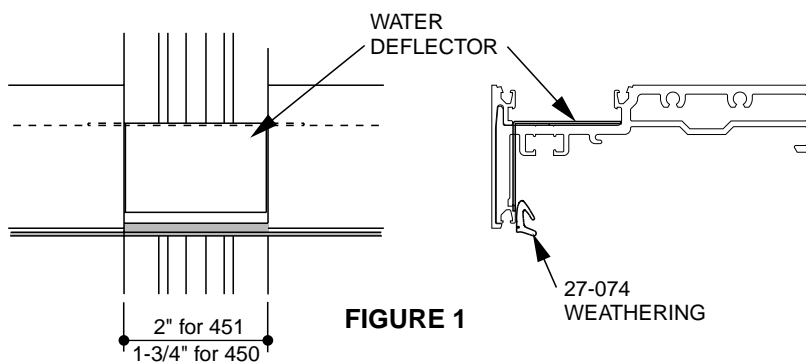


FIGURE 3
Trifab VG 451/451T

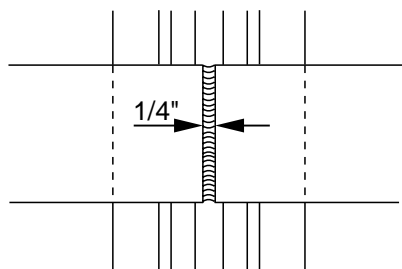


FIGURE 2

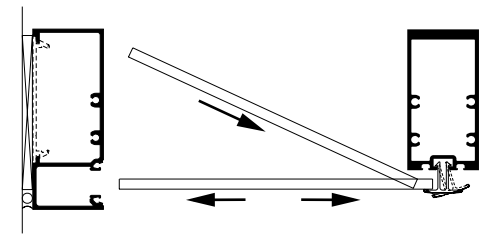


FIGURE 3
Trifab VG 450

STEP 7: Install adjacent glass light and then install SSG glazing spacer along mullion at each light.

STEP 8: Apply sealant along verticals where glass stop meets, then install glass stops (**Figure 4**).

STEP 9: Install interior push-on gasket.

STEP 10: Mask SSG mullion and glass as required. Install the interior, vertical structural seal.

NOTE: Kawneer does not supply the structural silicone sealant. This sealant is to be recommended by the sealant manufacturer. Reference the SSG GLAZING NOTE found in the GENERAL NOTES section of this manual.

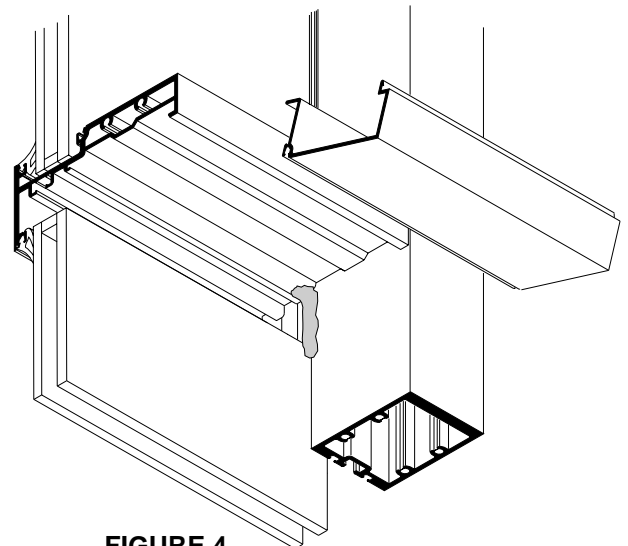


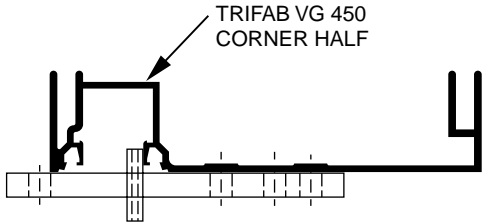
FIGURE 4

SECTION VIII - OPTIONAL CORNERS

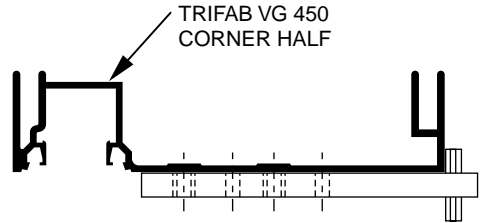
ADJUSTABLE CORNER MULLION FABRICATION

TRIFAB VG 450

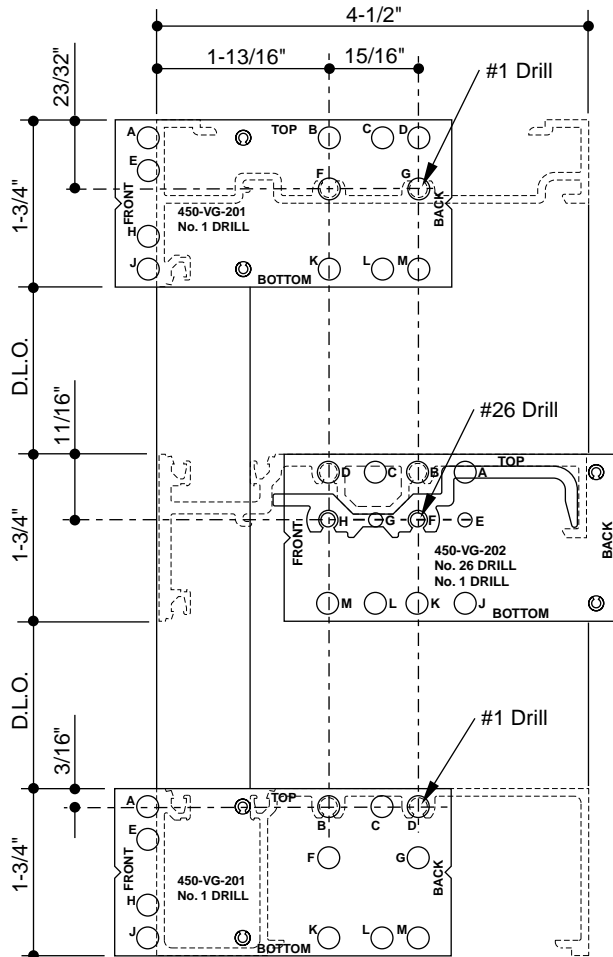
CUT SIZE AT CORNER HALF = FRAME HEIGHT



**450-VG-201 SCREW SPLINE
JIG LOCATION
AT HEAD AND SILL**



**450-VG-202 TYPE-B
JIG LOCATION
AT HORIZONTAL**



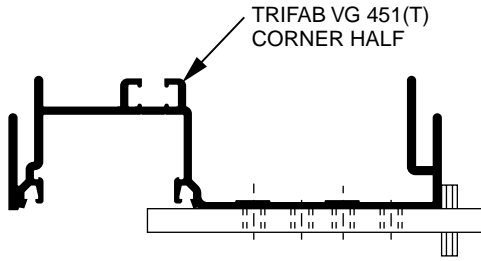
NOTE:
SSG WEATHERSEAL
HORIZONTAL SIMILAR

SECTION VIII - OPTIONAL CORNERS

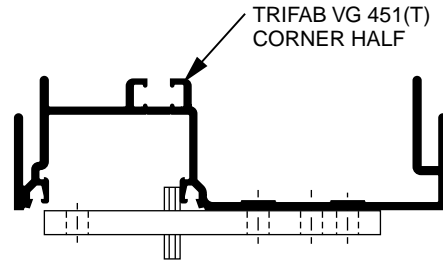
ADJUSTABLE CORNER MULLION FABRICATION

TRIFAB VG 451/451T

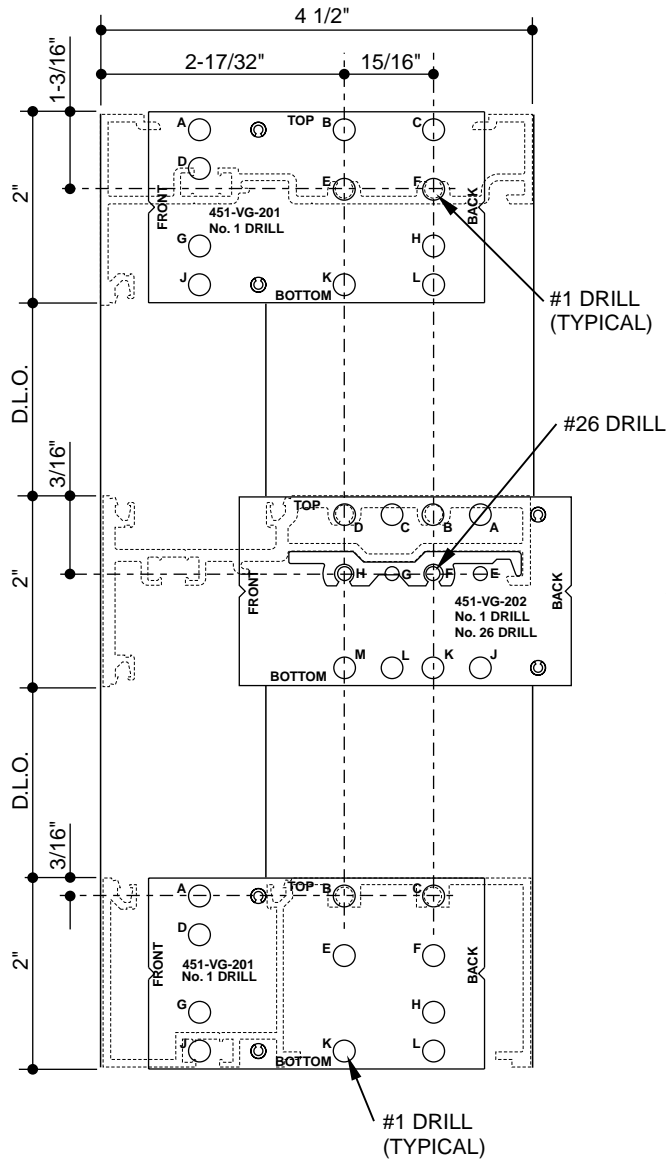
CUT SIZE AT CORNER HALF = FRAME HEIGHT



**451-VG-201 SCREW SPLINE
JIG LOCATION
AT HEAD AND SILL**



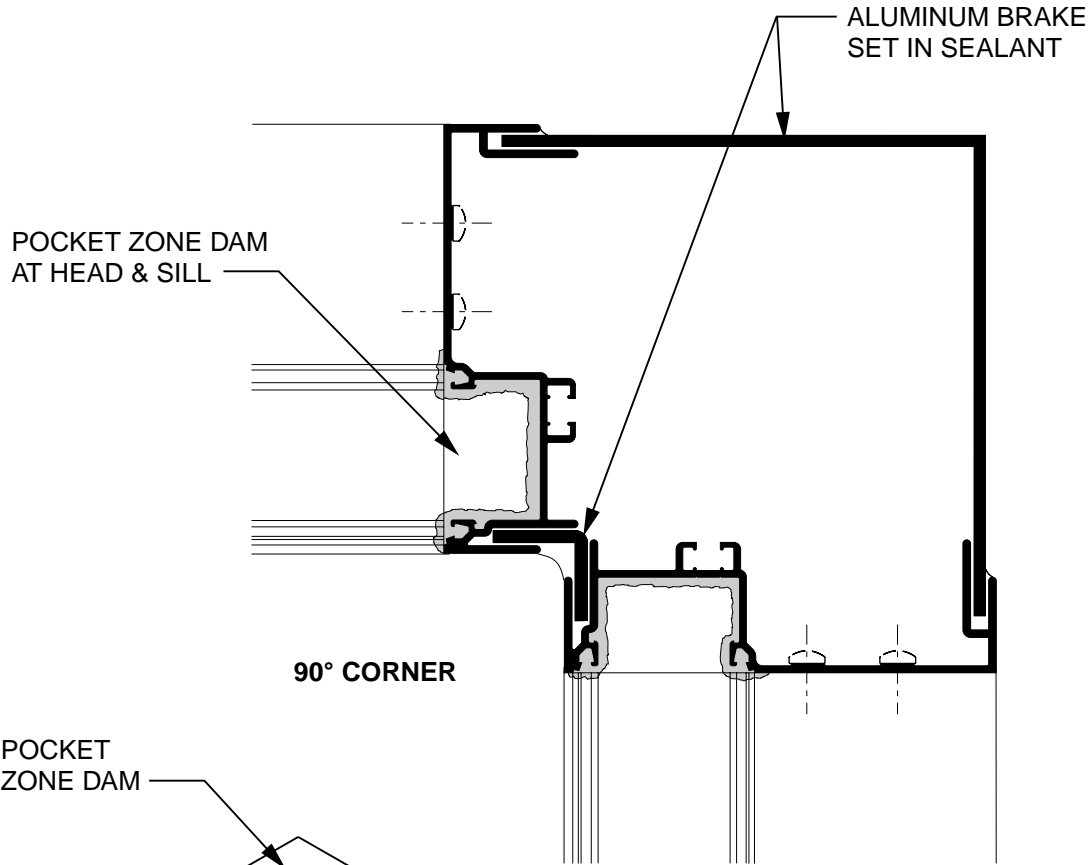
**451-VG-202 TYPE-B
JIG LOCATION
AT HORIZONTAL**



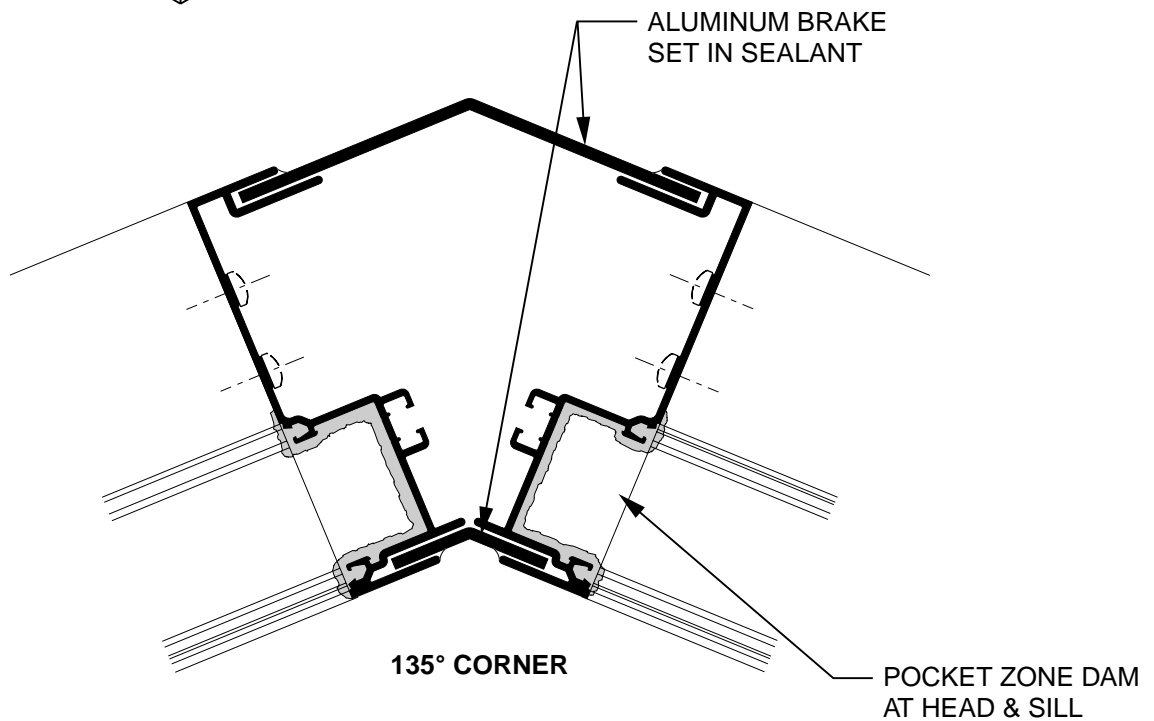
NOTE:
SSG WEATHERSEAL
HORIZONTAL SIMILAR

SECTION VIII - OPTIONAL CORNERS

ADJUSTABLE CORNERS



1" Infill System
Shown, 1/4" Similar



NOTES



KAWNEER COMPANY, INC.
TECHNOLOGY PARK/ATLANTA
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NORCROSS, GEORGIA 30092