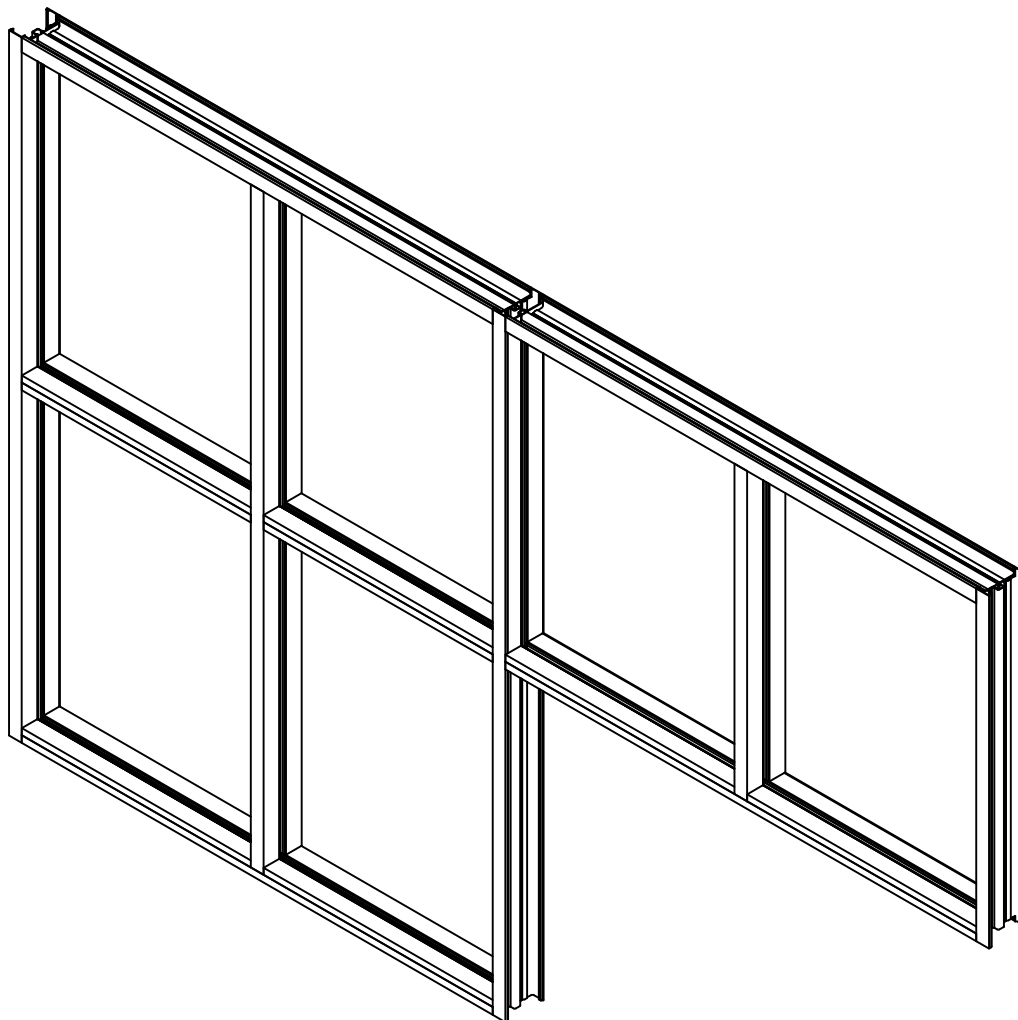


INSTALLATION



INSTRUCTIONS

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

| SECTION | PAGE | |
|----------------|---------------|---------------------------------------------|
| I | 3 | GENERAL NOTES |
| II | 4, 5 | PARTS IDENTIFICATION |
| III | 6-8 | BASIC FRAMING DETAILS |
| IV | 9-38 | FRAME FABRICATION |
| V | 39-46 | FRAME ASSEMBLY |
| VI | 47-50 | FRAME INSTALLATION |
| VII | 51, 52 | GLAZING |
| VIII | 53 | DOOR STOP INSTALLATION |
| IX | 54 | TRANSOM AREA GLASS STOP INSTALLATION |

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HANDLING, STORING, AND PROTECTION OF ALUMINUM



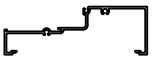





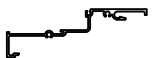






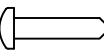
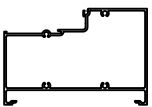
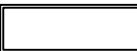










The material must be protected against damage. The following precautions are recommended to assure early acceptance of your products and workmanship.

- A. HANDLE CAREFULLY** - Do not 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. Work safely - always wear proper personal protective equipment. 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, and 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:




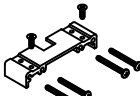
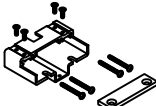
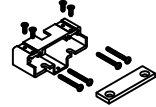

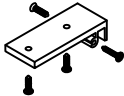
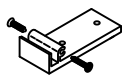
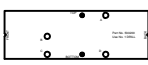
- A. CHECK SHOP DRAWINGS, INSTALLATION INSTRUCTIONS and GLAZING INSTRUCTIONS** to become thoroughly familiar with the project. The SHOP DRAWINGS take precedence and include specific details for the project. The INSTALLATION INSTRUCTIONS are of a general nature and cover the most common conditions.
- 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 ends of masonry opening to prevent dimensional build-up of day light opening.
- D. Make certain that the construction and openings which will receive your materials are in accordance with the contract documents.** If not, notify the GENERAL CONTRACTOR IN WRITING and resolve the 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, perimeter anchor fasteners are not specified in these instructions. For perimeter anchor fastening, refer to the Shop Drawings or Engineering Calculations.
- 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 CODE** - Building 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. 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.

| ILLUSTRATION | NO. | DESCRIPTION | ILLUSTRATION | NO. | DESCRIPTION |
|-------------------------------------------------------------------------------------|------------------------|-----------------------------------------------------|-------------------------------------------------------------------------------------|--------|---------------------------------|
|  | 027366 (EPDM) | SETTING BLOCK |  | 530010 | VERTICAL MULLION |
| | 027366SI (Silicone) | |  | 530011 | HORIZONTAL / SILL OPEN BACK |
|  | 027074 | STANDARD PUSH-ON GASKET |  | 530012 | SHALLOW POCKET FILLER |
|  | 027076 | LIGHT PUSH-ON GASKET |  | 530013 | FLAT POCKET FILLER |
|  | 027077 | HEAVY PUSH-ON GASKET |  | 530015 | PARTITION SILL |
|  | 027084 | "W" BLOCK |  | 530016 | HEAD / JAMB / STACK VERTICAL |
|  | 027633 | 1/2" DIA. HOLE PLUG |  | 530017 | SNAP-IN STOP |
|  | 027860 | BULB GASKET (Used with 530021) |  | 530018 | GLASS STOP |
|  | 028856 | #12 X 1-1/8" PHTF TYPE "AB" (Spline Screw) |  | 530019 | 4" HORIZONTAL / SILL |
|  | 061222 | 2" X 6" TUBE |  | 530020 | HEAD / DOOR JAMB |
|  | 069177 | CONCEALED SCREW APPLIED DOOR STOP |  | 530021 | SNAP-IN STOP |
|  | 028260 | #8 X 3/8" PHST TYPE "AB" (For Applied Door Stop) |  | 530022 | SHALLOW POCKET |
|  | 279001 | APPLIED SASH GUTTER |  | 530023 | DEEP POCKET FILLER |
|  | 450022 | APPLIED SASH STOP |  | 530024 | DEEP POCKET FILLER |
|  | 128345 | #10 X 9/16" FHTF TYPE B (For Applied Sash) | | | |

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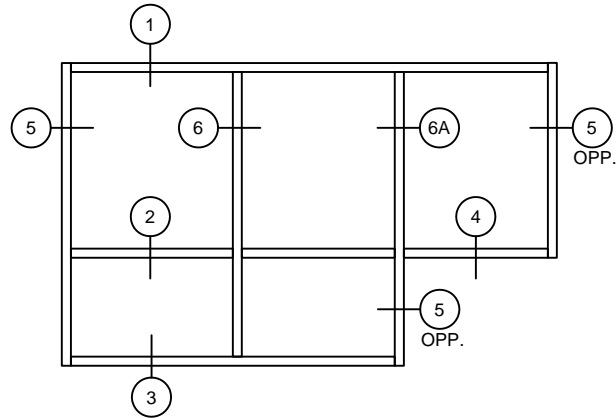
| ILLUSTRATION | NO. | DESCRIPTION | ILLUSTRATION | NO. | DESCRIPTION |
|-------------------------------------------------------------------------------------|--------|-----------------------------------------------|--------------|-----|-------------|
|  | 530301 | SHIM SUPPORT 3" LONG | | | |
|  | 530504 | SNAP-IN STOP (530021) WITH GASKET (027860) | | | |
|  | 050761 | C.O.C. MOUNTING BRACKET | | | |
|  | 450506 | SINGLE ACTING T-BAR CLIP PKG. | | | |
|  | 451548 | SHEAR BLOCK PKG. FOR S/A O/P C.O.C. | | | |
|  | 451549 | SHEAR BLOCK PKG. FOR S/A B/H C.O.C. | | | |
|  | 530501 | ANGLE CLIP PKG. FOR COMMON STRIKE JAMB | | | |
|  | 530502 | HEAD CLIP PKG. FOR COMMON STRIKE JAMB | | | |
|  | 530503 | SILL CLIP PKG. FOR COMMON STRIKE JAMB | | | |
|  | 530200 | DRILL FIXTURE | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

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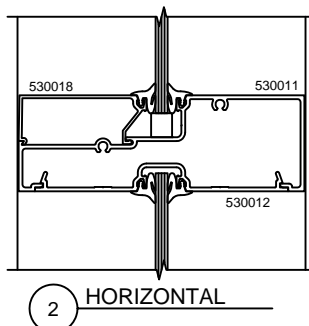
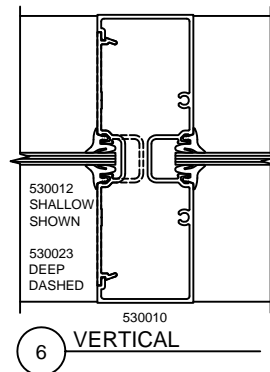
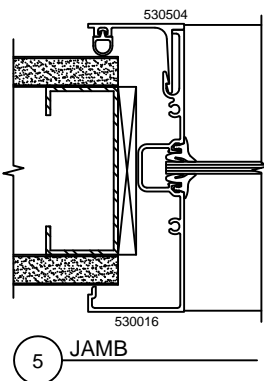
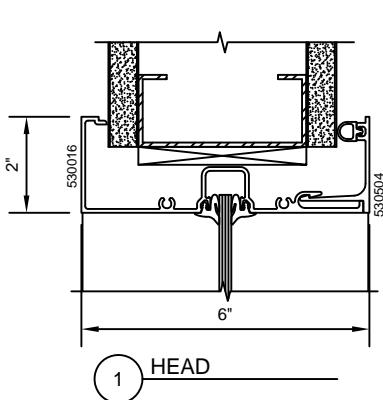
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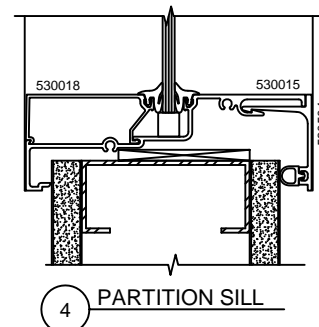
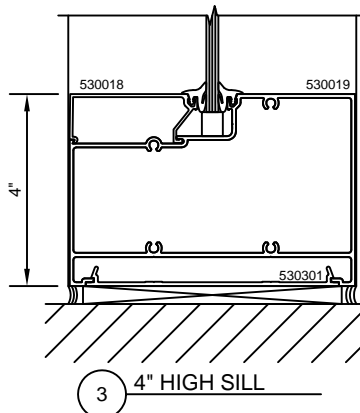
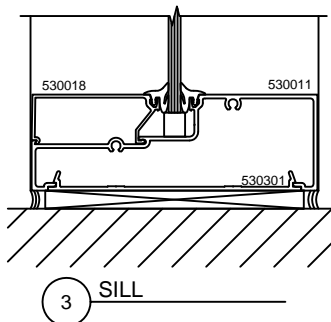
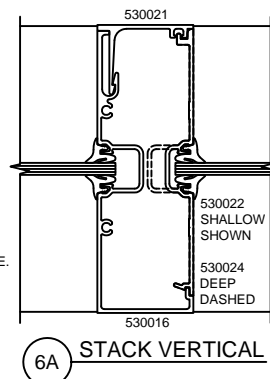
This framing system is designed to be fabricated and assembled on the floor in bays, then each bay is raised into the opening position and joined with the next bay. Once elevation is anchored into the opening, the head, jambs and partition sill members are captured with a snap-in face member to secure the entire opening.

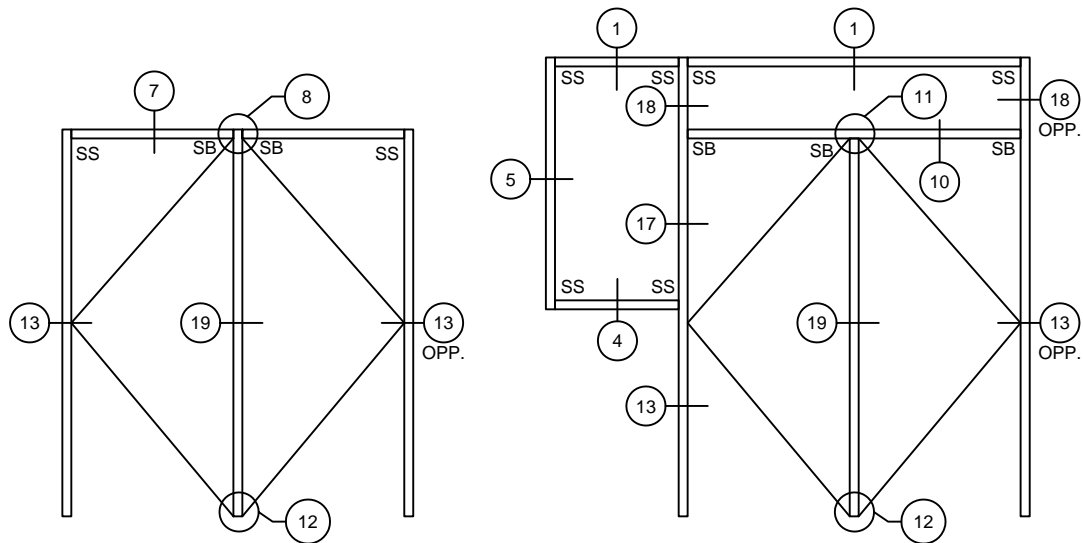


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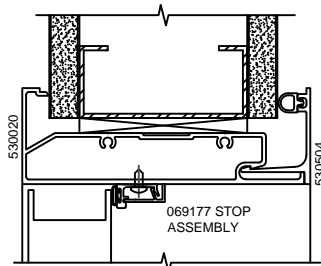
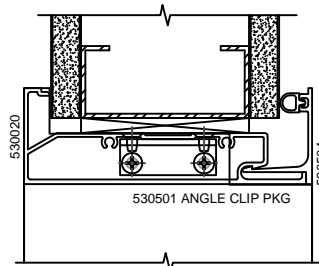
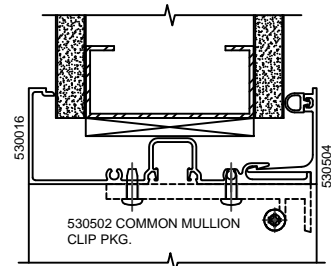
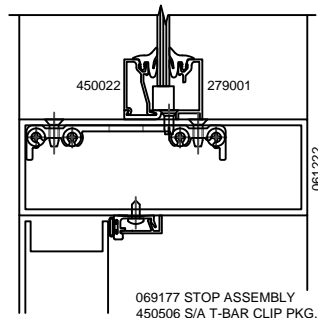
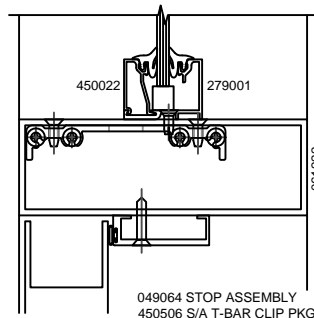
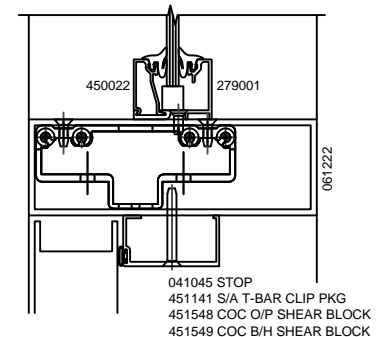
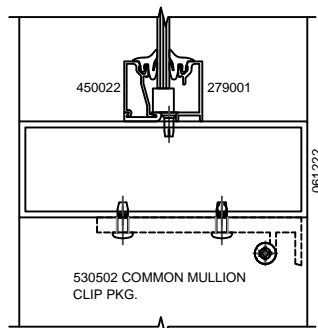
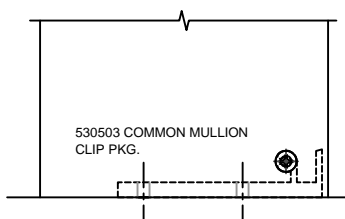


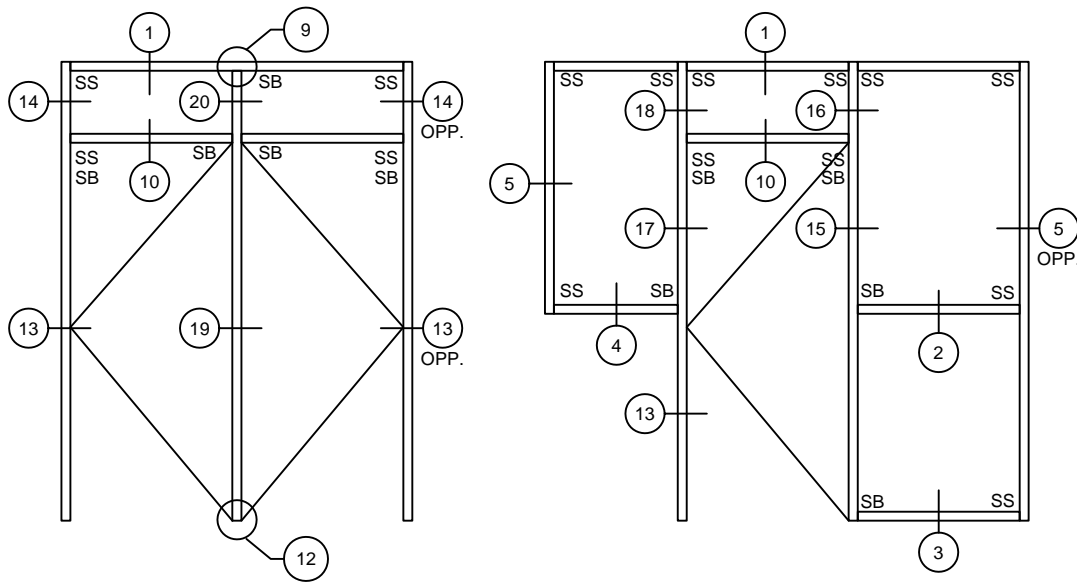
NOTE:
EVERY UNIT MUST HAVE AT LEAST
ONE DEEP VERTICAL POCKET TO
INSTALL GLAZING.



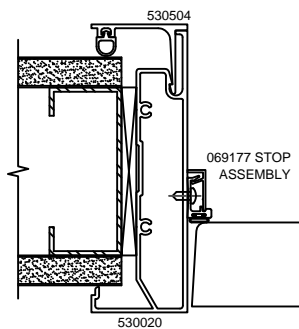


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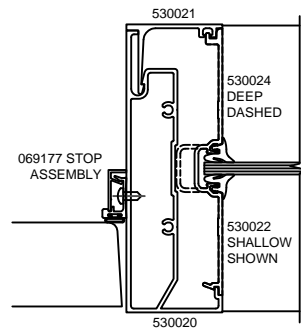
SS = SCREW SPLINE
SB = SHEAR BLOCK7 HEAD
AT DOOR8 HEAD
AT COMMON DOOR JAMB9 TRANSOM HEAD
AT COMMON DOOR JAMB10 TRANSOM BAR W/ COC
OR SURFACE CLOSER10 TRANSOM BAR W/ COC
FOR LCN CLOSER10 TRANSOM BAR W/ COC
FOR STD. KAWNEER CLOSER11 HEAD CLIP
AT COMMON DOOR JAMB12 SILL CLIP
AT COMMON DOOR JAMB



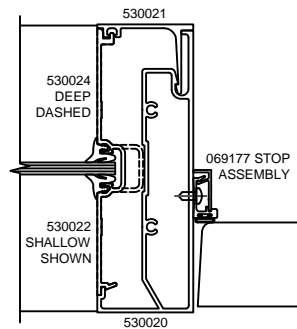
ELEVATIONS ARE NUMBER KEYED TO DETAILS



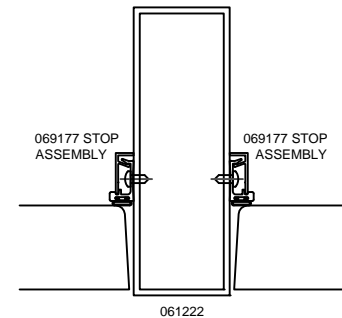
13 DOOR JAMB



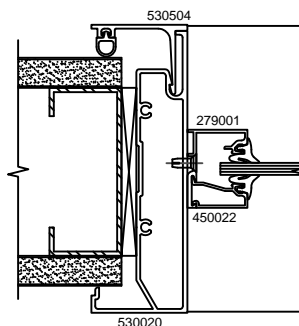
15 DOOR JAMB



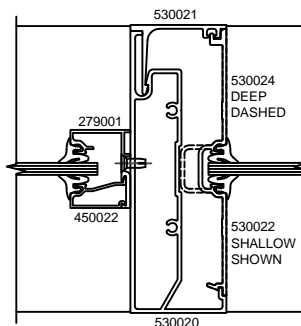
17 DOOR JAMB



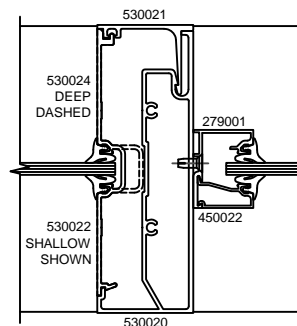
19 COMMON DOOR JAMB



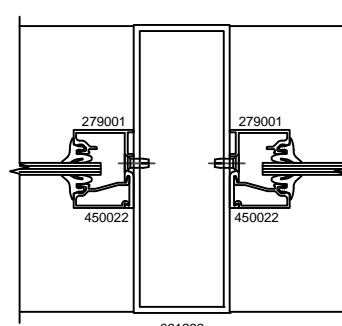
14 TRANSOM JAMB



16 TRANSOM JAMB



18 TRANSOM JAMB



20 COMMON TRANSOM JAMB

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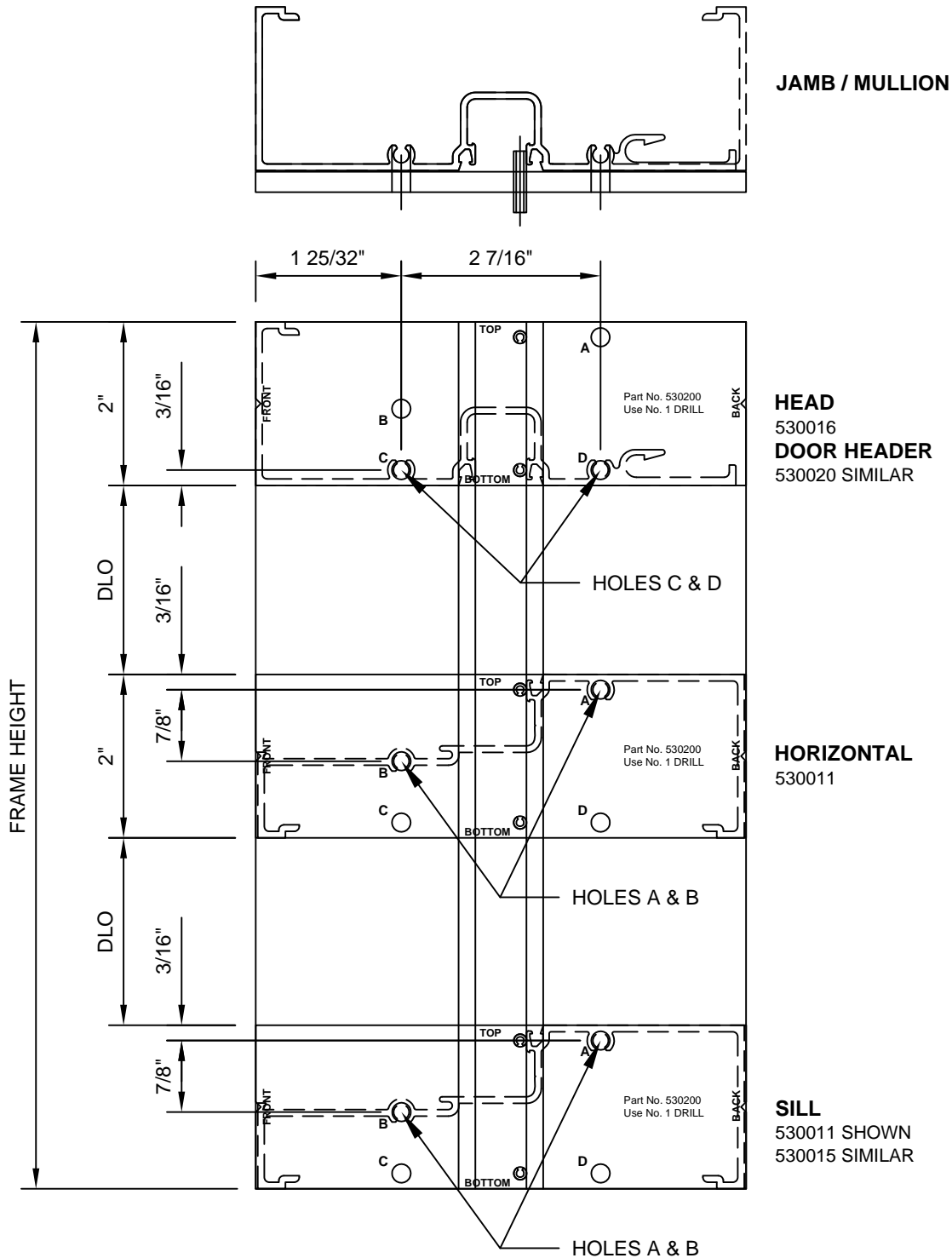
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| FRAMING MEMBERS | CUT FORMULA |
|-------------------------------------------------|---------------------------------------------|
| JAMB | FRAME HEIGHT |
| INTERMEDIATE MULLION | FRAME HEIGHT - 3.049" |
| INTERMEDIATE MULLION POCKET FILLER | FRAME HEIGHT - 4.000" |
| STACK MULLION | FRAME HEIGHT |
| STACK MULLION POCKET FILLER (W/ Standard Sill) | FRAME HEIGHT - 1.000" |
| STACK MULLION POCKET FILLER (W/ Partition Sill) | FRAME HEIGHT - 1.750" |
| HEAD | TOTAL DLO + (No. of VERT. MULLIONS x 2") |
| HORIZONTAL | DLO |
| SILL / PARTITION SILL | TOTAL DLO + (No. of VERT. MULLIONS x 2") |
| GLASS STOP (Sill / Horizontal) | DLO - 1/16" |
| SNAP-IN STOP (Head / Partition Sill) | TOTAL DLO + (No. of VERT. MULLIONS x 2") |
| SNAP-IN STOP (At Door Header) | DOOR OPENING WIDTH |
| SNAP-IN STOP (Jamb / Stack Mullion / Door Jamb) | FRAME HEIGHT |
| DOOR JAMB | FRAME HEIGHT |
| DOOR JAMB POCKET FILLER (With Standard Sill) | FRAME HEIGHT - 1.000" |
| DOOR JAMB POCKET FILLER (With Partition Sill) | FRAME HEIGHT - 1.750" |
| COMMON DOOR JAMB WITH DOOR HEADER | FRAME HEIGHT |
| CRIPPLE COMMON DOOR JAMB AT T-BAR | DOOR OPENING HEIGHT |
| CRIPPLE COMMON DOOR JAMB AT TRANSOM HEAD | FRAME HEIGHT - 2" |
| DOOR HEADER | DOOR OPENING WIDTH |
| TRANSOM BAR | DOOR OPENING WIDTH |
| TRANSOM BAR WITH CRIPPLE DOOR JAMB | (DR OPENING WIDTH x 2) + 2" |

STEP A: SCREW SPLINE HOLE PREPS

Cut vertical members to required length (Frame Height). At horizontal locations drill the required holes in the vertical member to attach spline screws using (530200) Drill Jig as shown below.



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JAMB PREPARATION

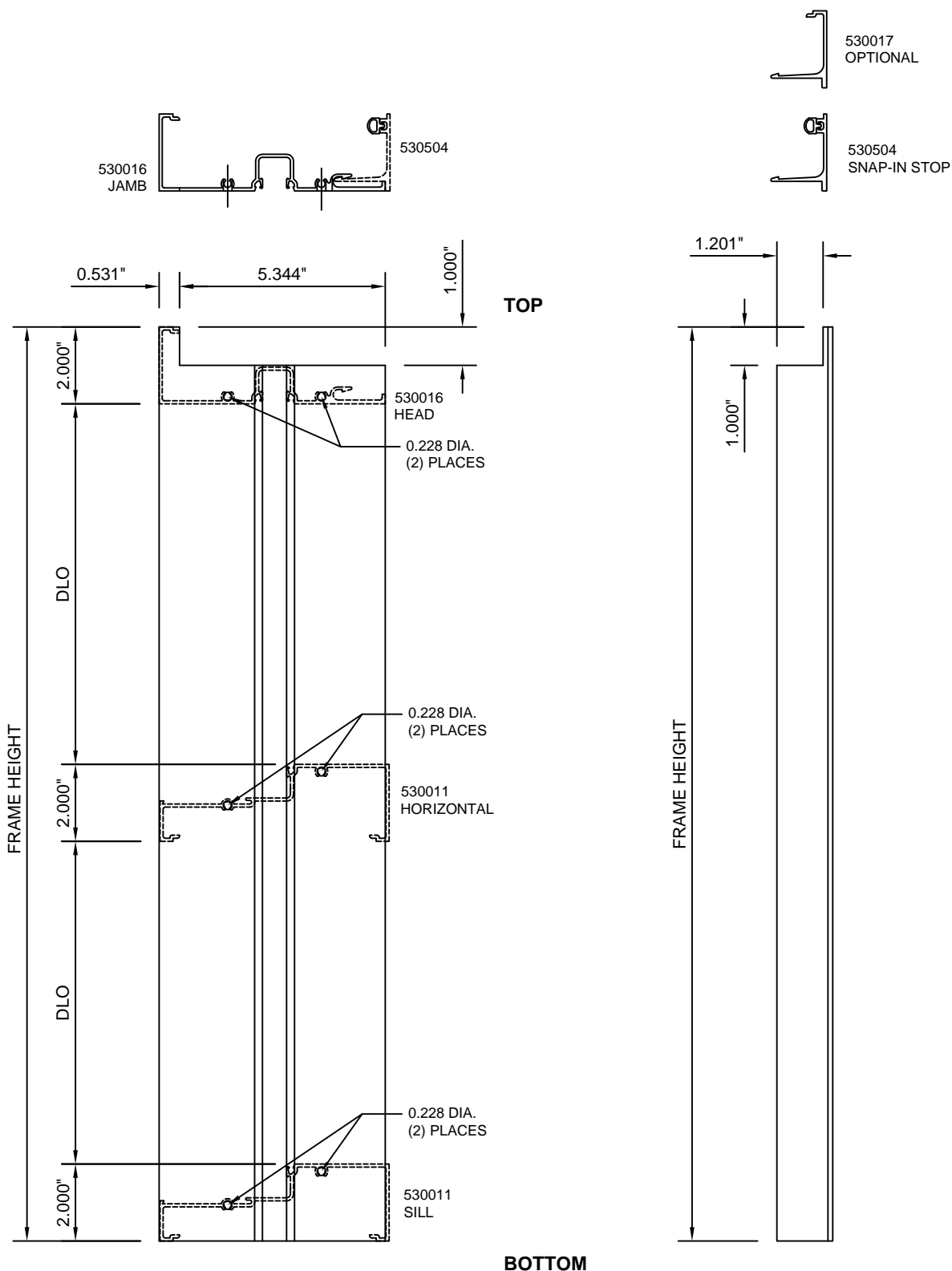
Cope top of jamb as shown below.

Bottom of jamb is square cut.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in jamb at required locations.

Cope top of the snap-in stop as shown below.

Bottom of snap-in stop is square cut.

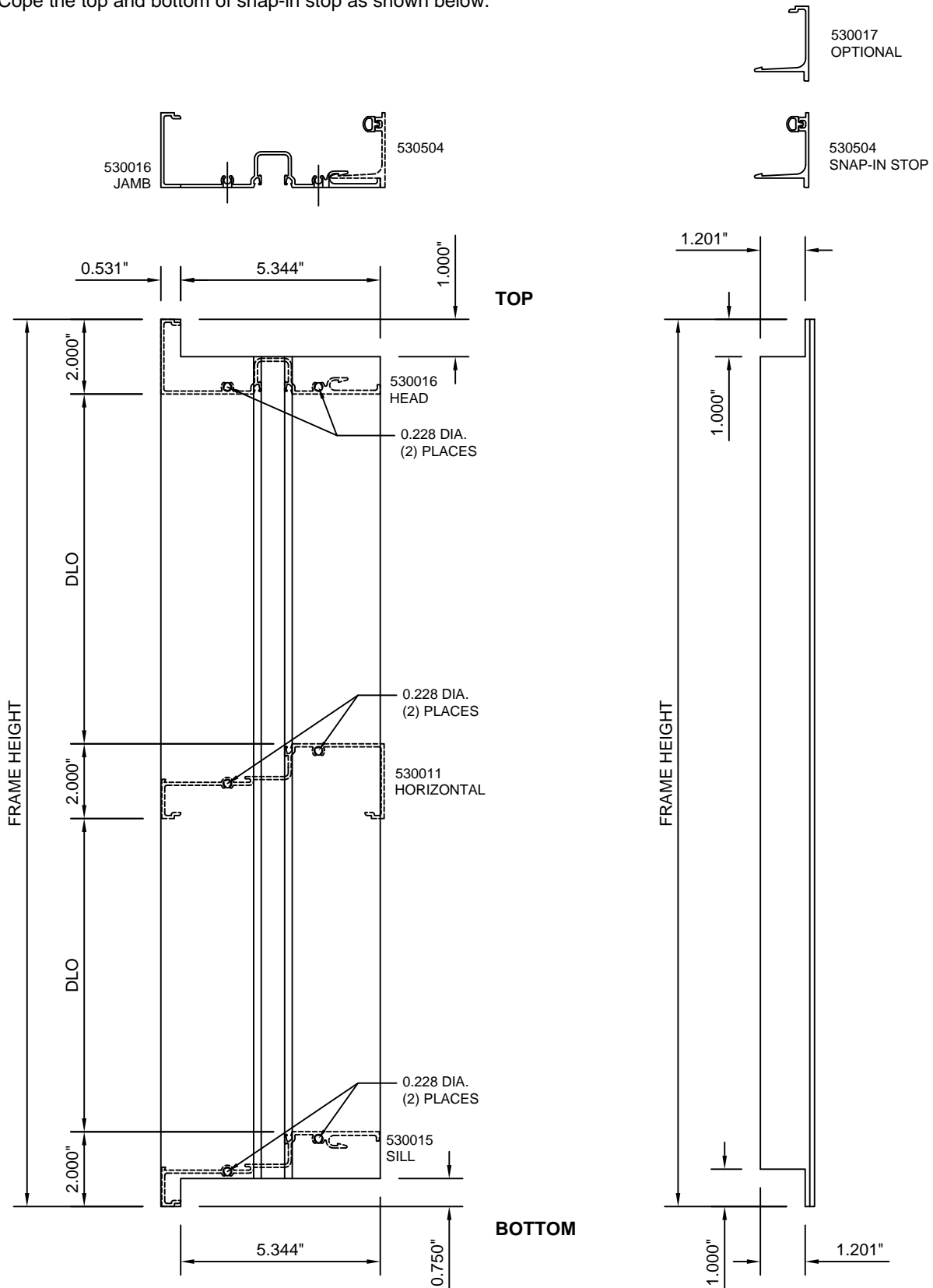


JAMB PREPARATION AT PARTITION WALL

Cope the top and bottom of jamb as shown below.

Using the 530200 drill jig, drill 0.228 dia. holes for spline screws in jamb at required locations.

Cope the top and bottom of snap-in stop as shown below.



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INTERMEDIATE VERTICAL PREPARATION

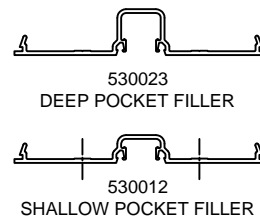
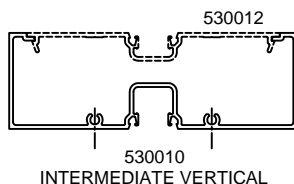
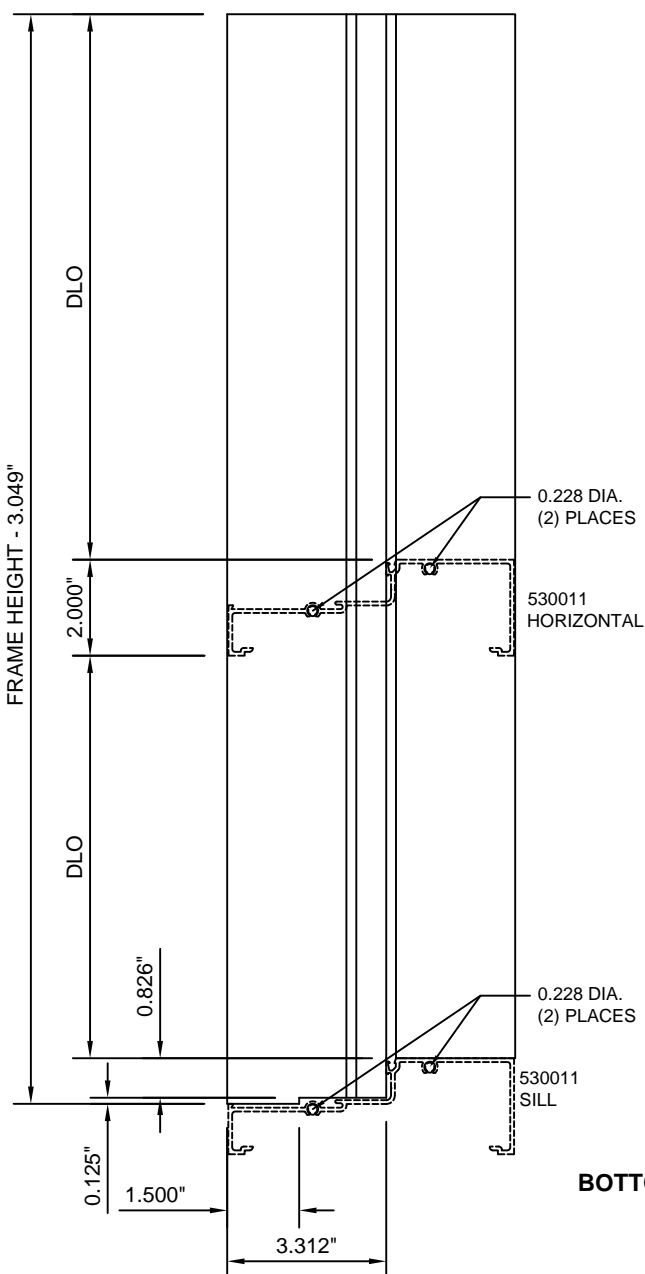
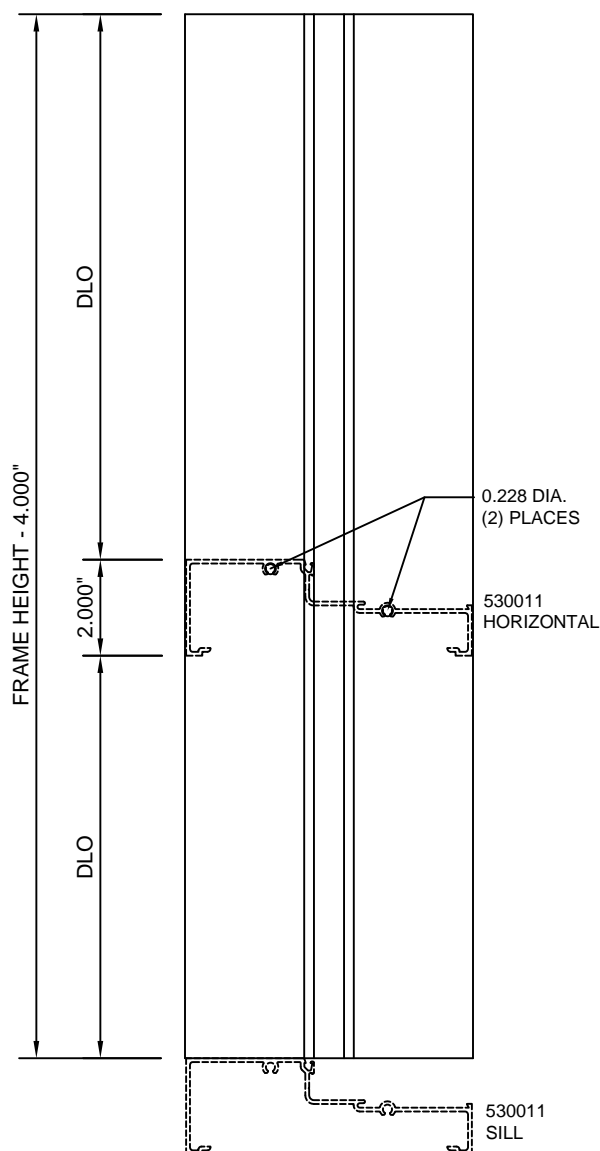
Top of vertical is square cut.

Cope bottom of vertical as shown below.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in vertical at required locations.

Top and bottom of pocket filler is square cut.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in pocket filler at required locations.

**TOP****BOTTOM**

INTERMEDIATE VERTICAL PREPARATION AT PARTITION WALL

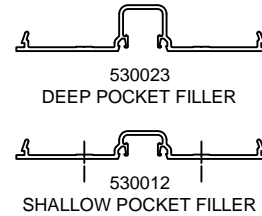
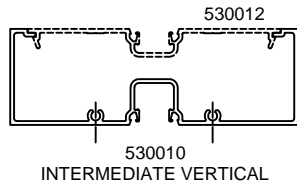
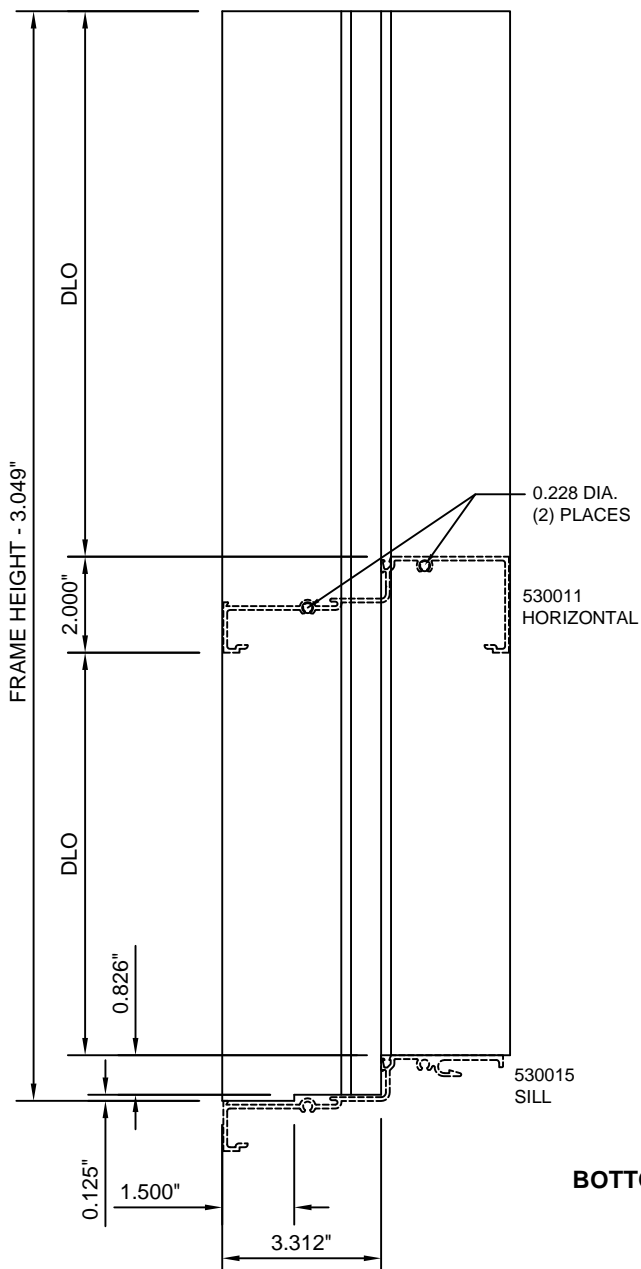
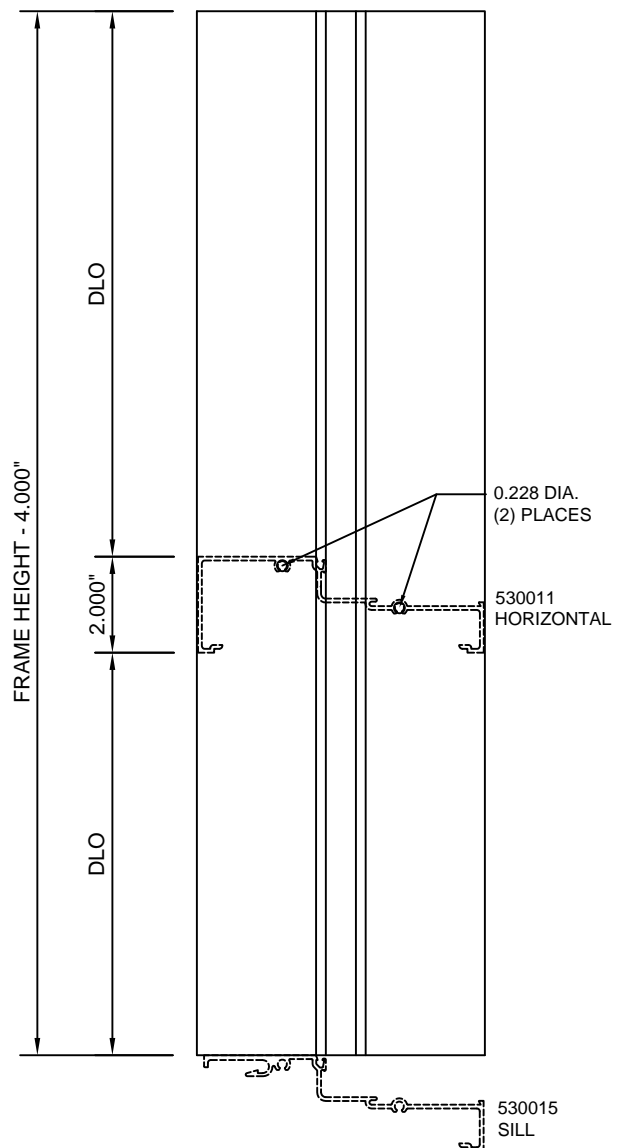
Top of vertical is square cut.

Cope bottom of vertical as shown below.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in vertical at required locations.

Top and bottom of pocket filler is square cut.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in pocket filler at required locations.

**TOP****BOTTOM**

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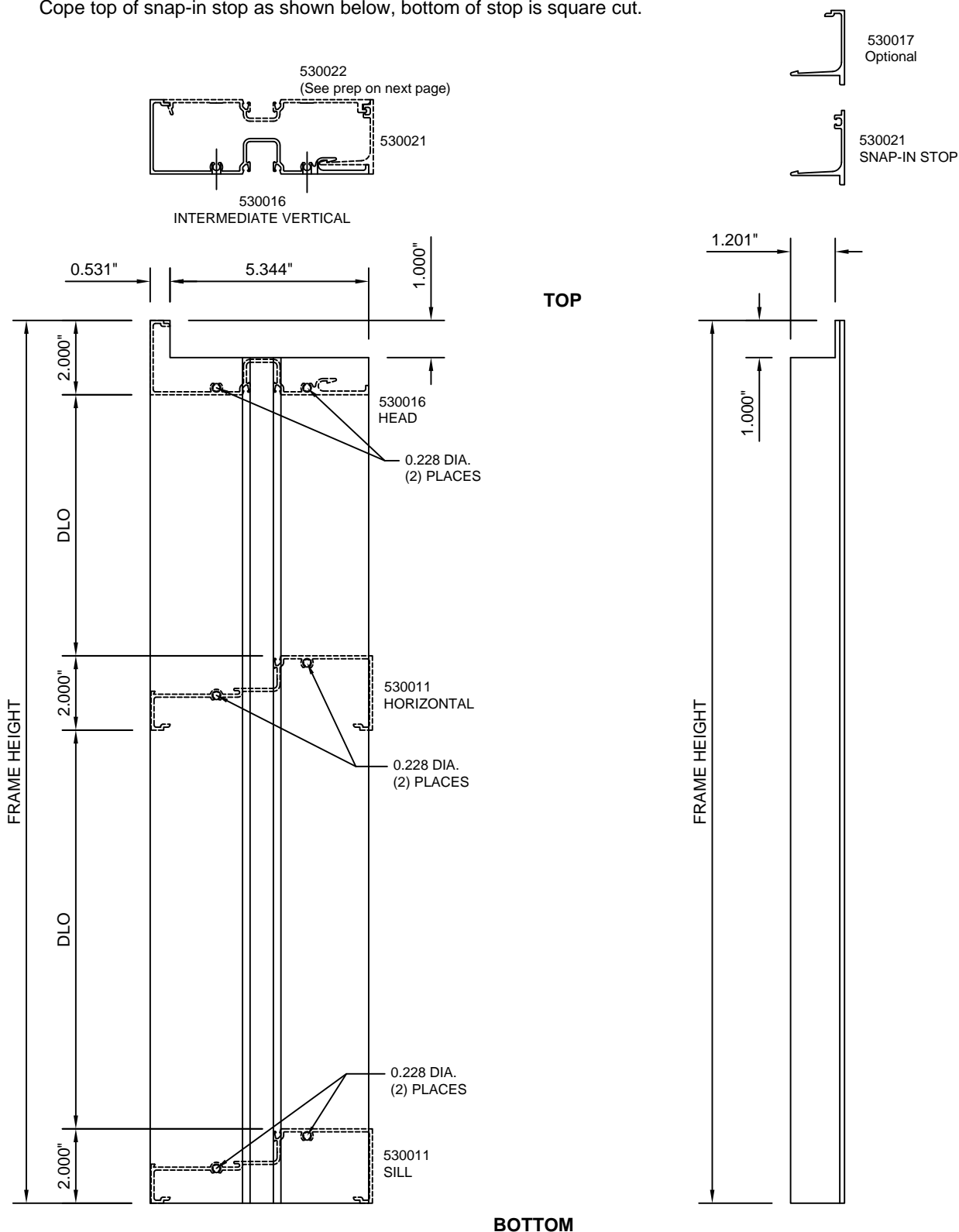
STACK INTERMEDIATE VERTICAL PREPARATION

Cope top of intermediate vertical as shown below.

Bottom of vertical is square cut.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in vertical at required locations.

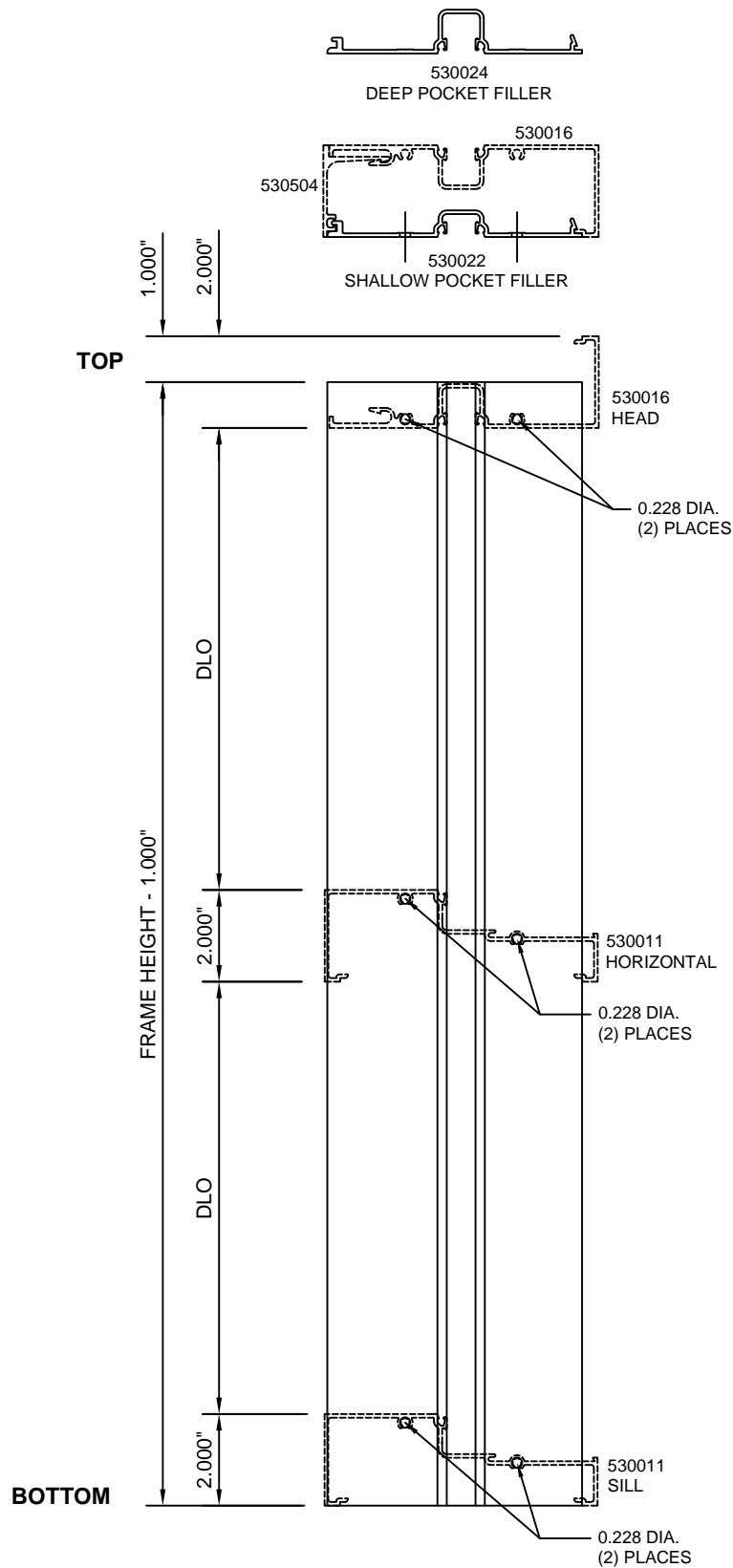
Cope top of snap-in stop as shown below, bottom of stop is square cut.



STACK INTERMEDIATE VERTICAL PREPARATION (Cont.)

Top and bottom of snap-in stop is square cut.

Using the 530200 drill jig, drill 0.228 dia. holes for spline screws in vertical at required locations.



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STACK INTERMEDIATE VERTICAL PREPARATION AT PARTITION WALL

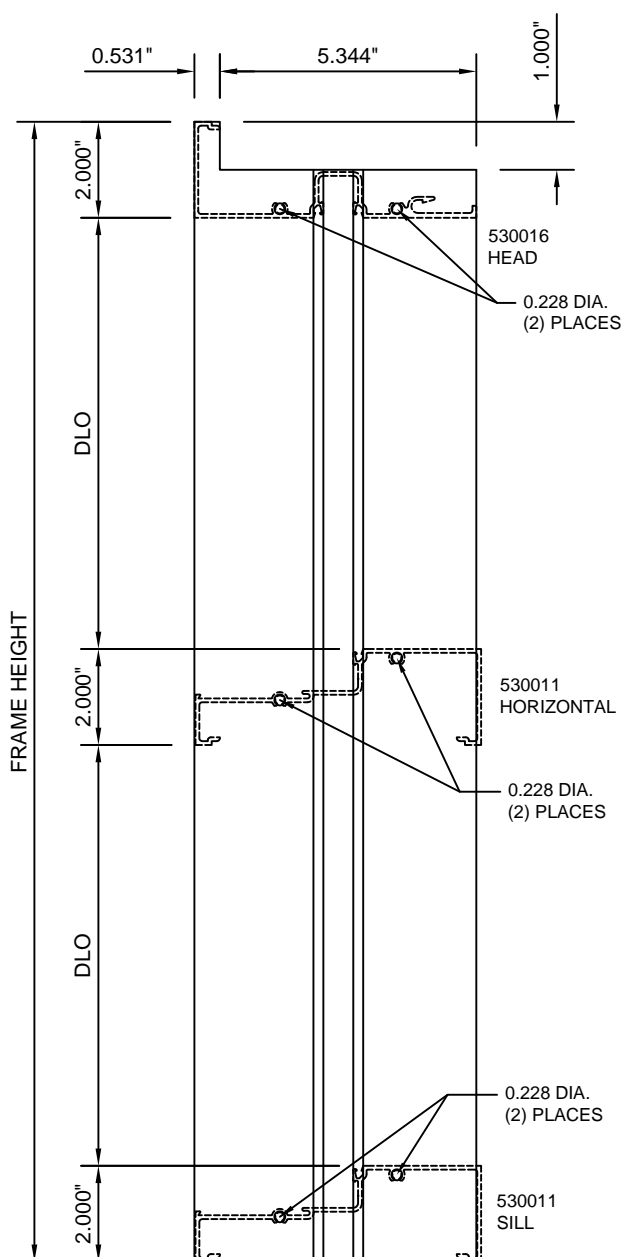
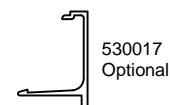
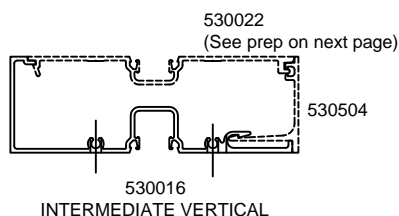
Cope top of intermediate vertical as shown below.

Bottom of vertical is square cut.

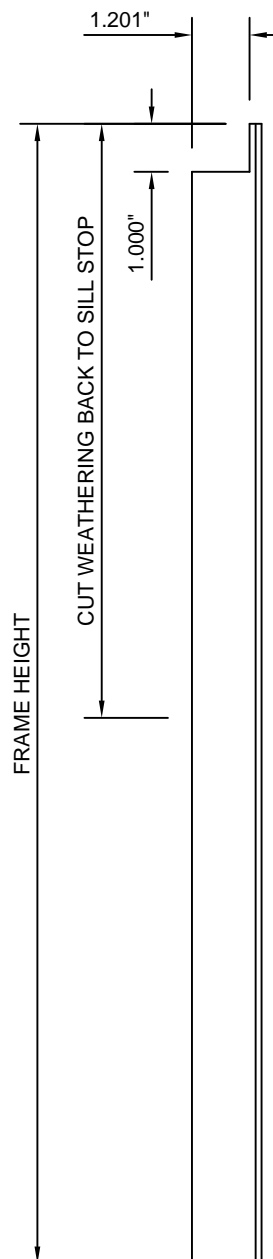
Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in vertical at required locations.

Cope top of snap-in stop as shown below, bottom of stop is square cut.

Weathering must be cut back to bottom of sill snap-in stop at partition wall.



TOP



BOTTOM

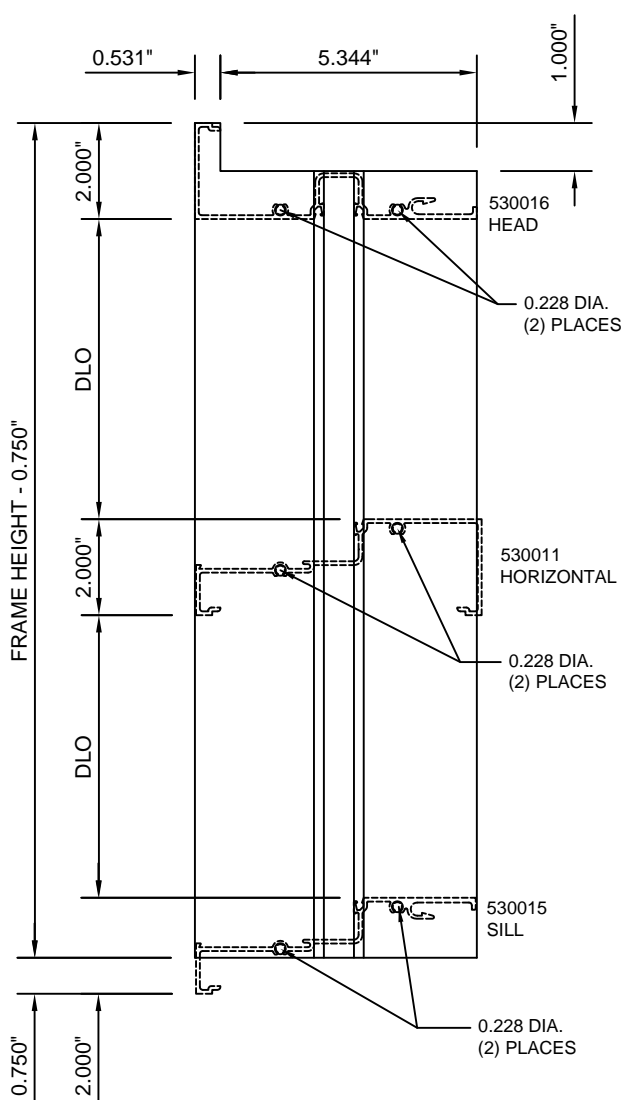
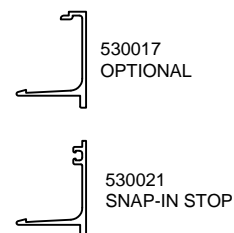
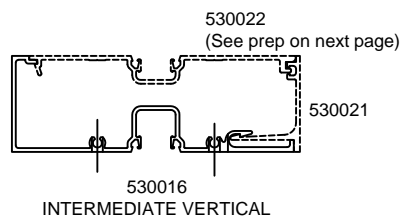
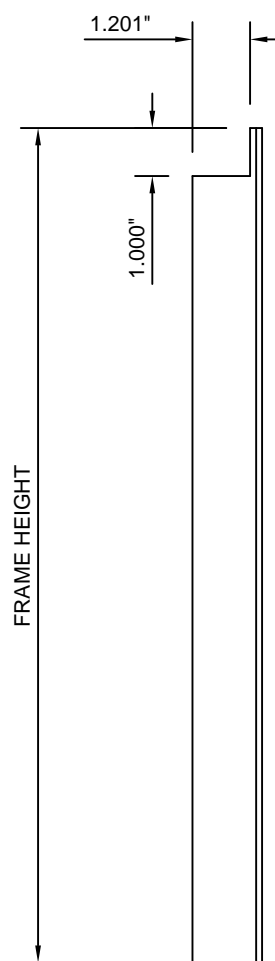
STACK INTERMEDIATE VERTICAL PREPARATION WITH PARTITION WALL BOTH SIDES

Cope top of intermediate vertical as shown below.

Bottom of vertical is square cut.

Using the 530200 drill jig, drill 0.228 dia. holes for spline screws in vertical at required locations.

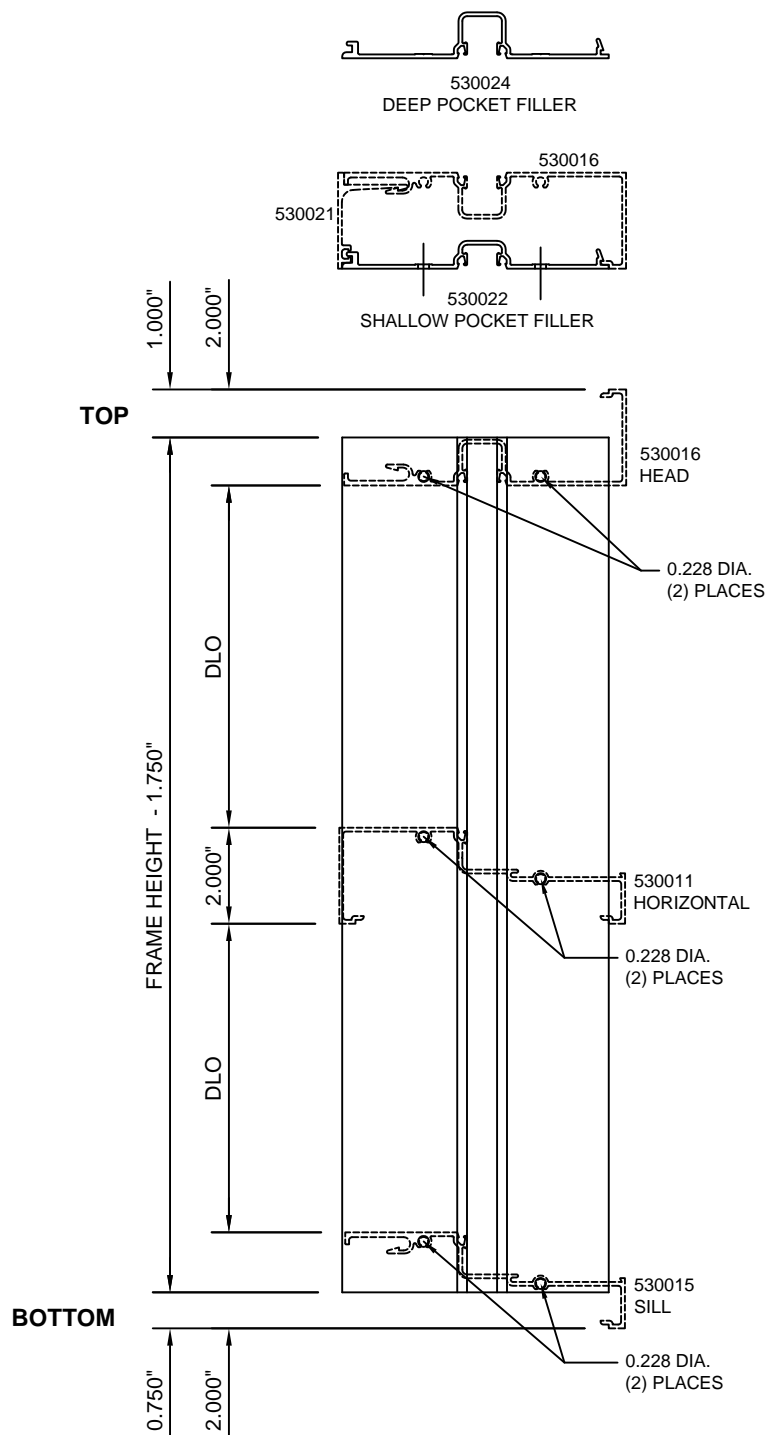
Cope top of snap-in stop as shown below, bottom of stop is square cut.

**TOP****BOTTOM**

STACK INTERMEDIATE VERTICAL PREPARATION WITH PARTITION WALL BOTH SIDES (Cont.)

Top and bottom of pocket filler is square cut.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in vertical at required locations.



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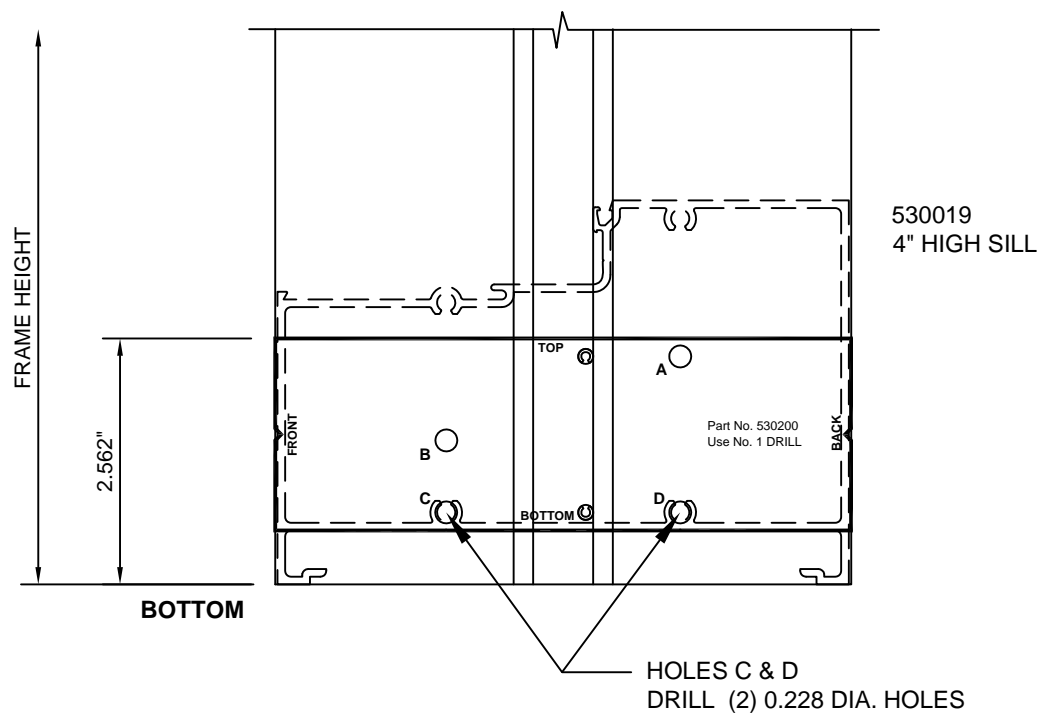
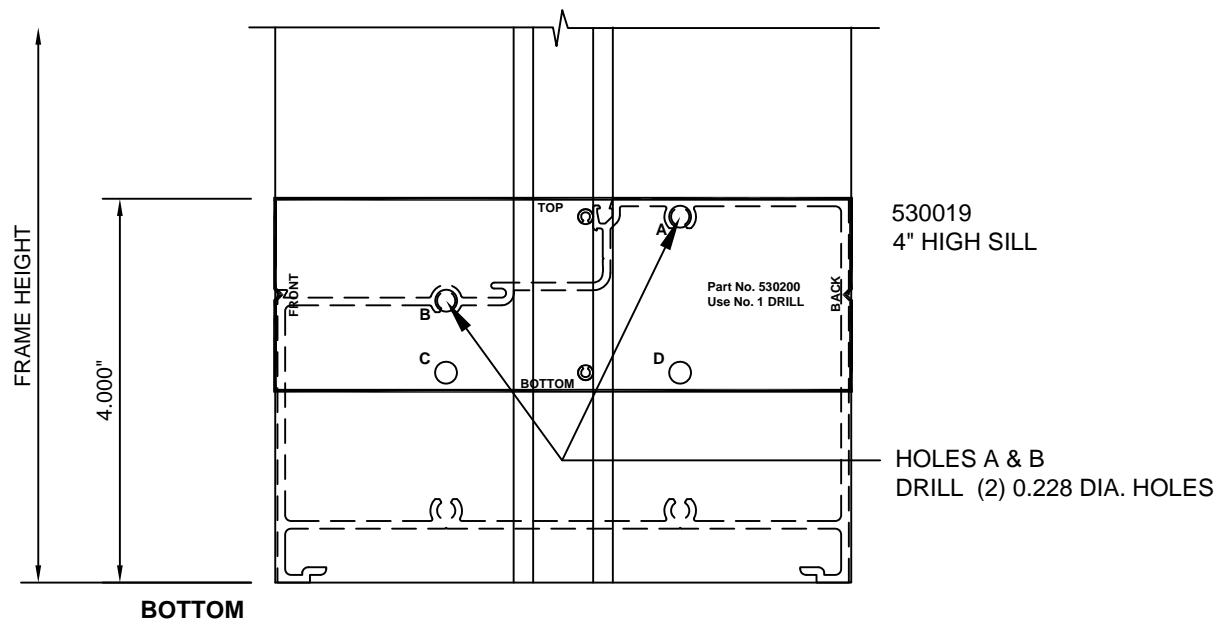
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INTERMEDIATE VERTICAL PREP WITH 4" HIGH SILL

Insert Drill Jig 530200 into vertical mullion glazing pocket and position as shown to prep for (530019) 4" high sill.

Position top of drill jig 4" from bottom of mullion to locate and drill (2) 0.228 dia. holes at A and B.

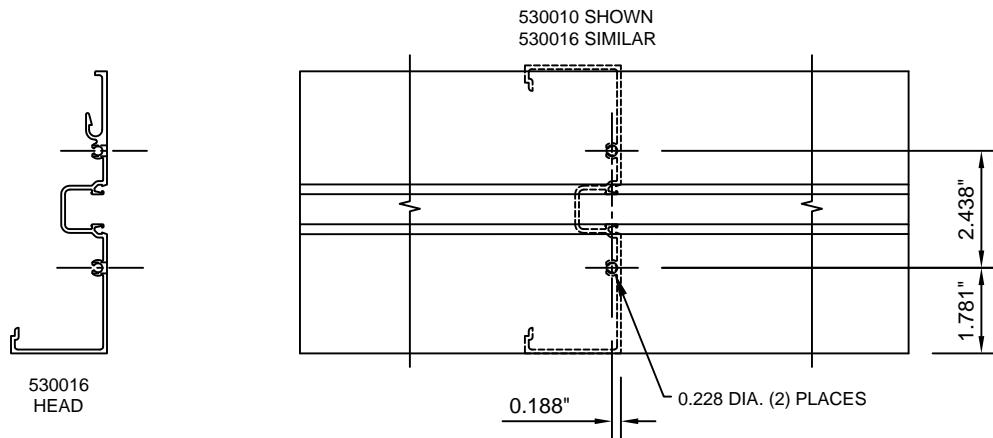
Position top of drill jig 2.562" from bottom of mullion to locate and drill (2) 0.228 dia. holes at C and D.



HEAD PREPARATION FOR VERTICAL ATTACHMENT

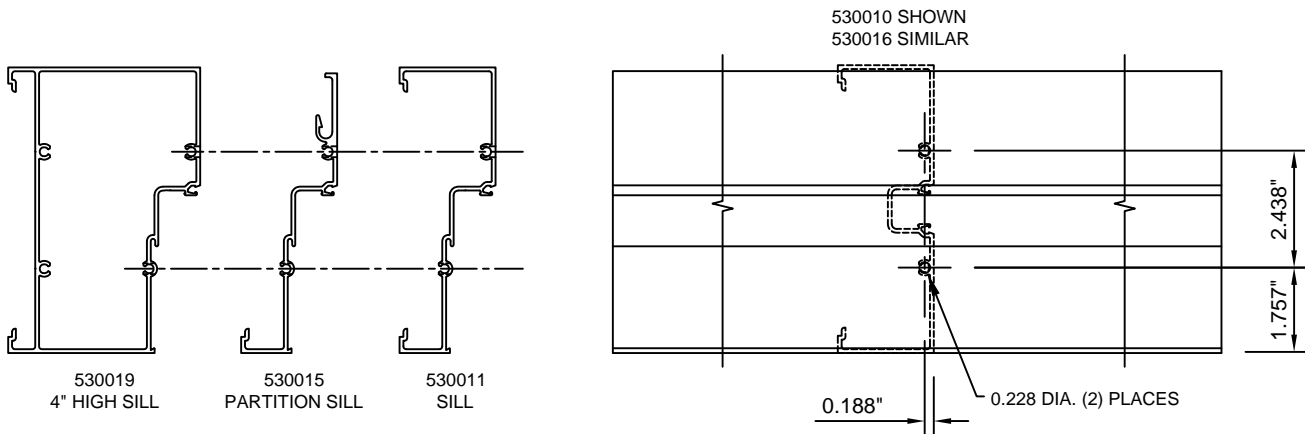
Drill (2) 0.288 dia. holes for screw spline attachment at locations shown.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in head at required locations.

**SILL PREPARATION FOR VERTICAL ATTACHMENT**

Drill (2) 0.288 dia. holes for screw spline attachment at locations shown.

Using the 530200 drill jig, drill 0.288 dia. holes for spline screws in sill at required locations.



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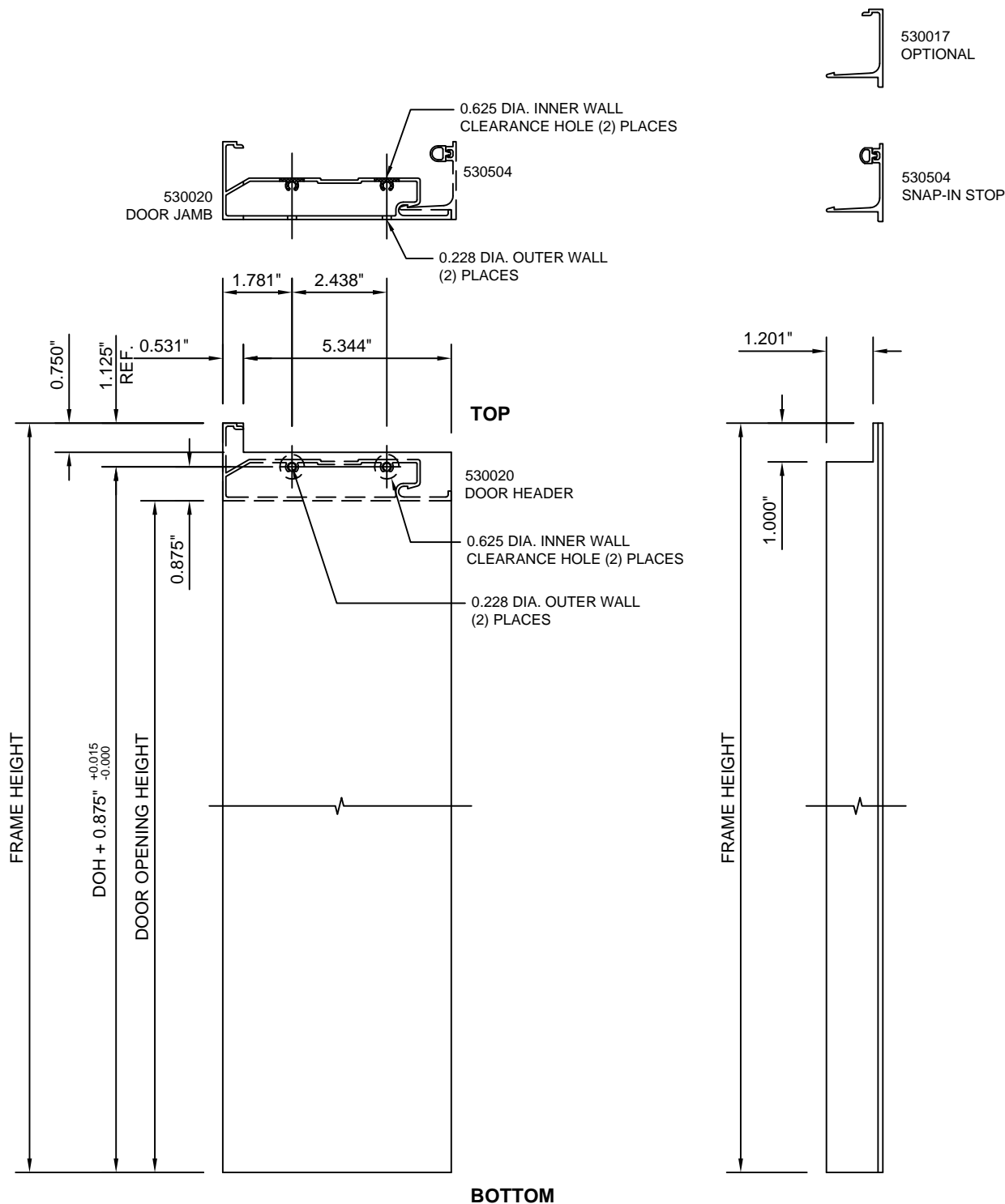
DOOR JAMB PREPARATION AT DOOR HEADER

Cope top of door jamb as shown below, bottom of door jamb is square cut.

At transom head drill (2) 0.625 dia. clearance holes in inner wall of door jamb.

Then drill (2) 0.228 dia. holes for spline screws in outer wall of door jamb at locations shown.

Cope top of snap-in stop as shown below, bottom of stop is square cut.



DOOR JAMB PREPARATION FOR TRANSOM

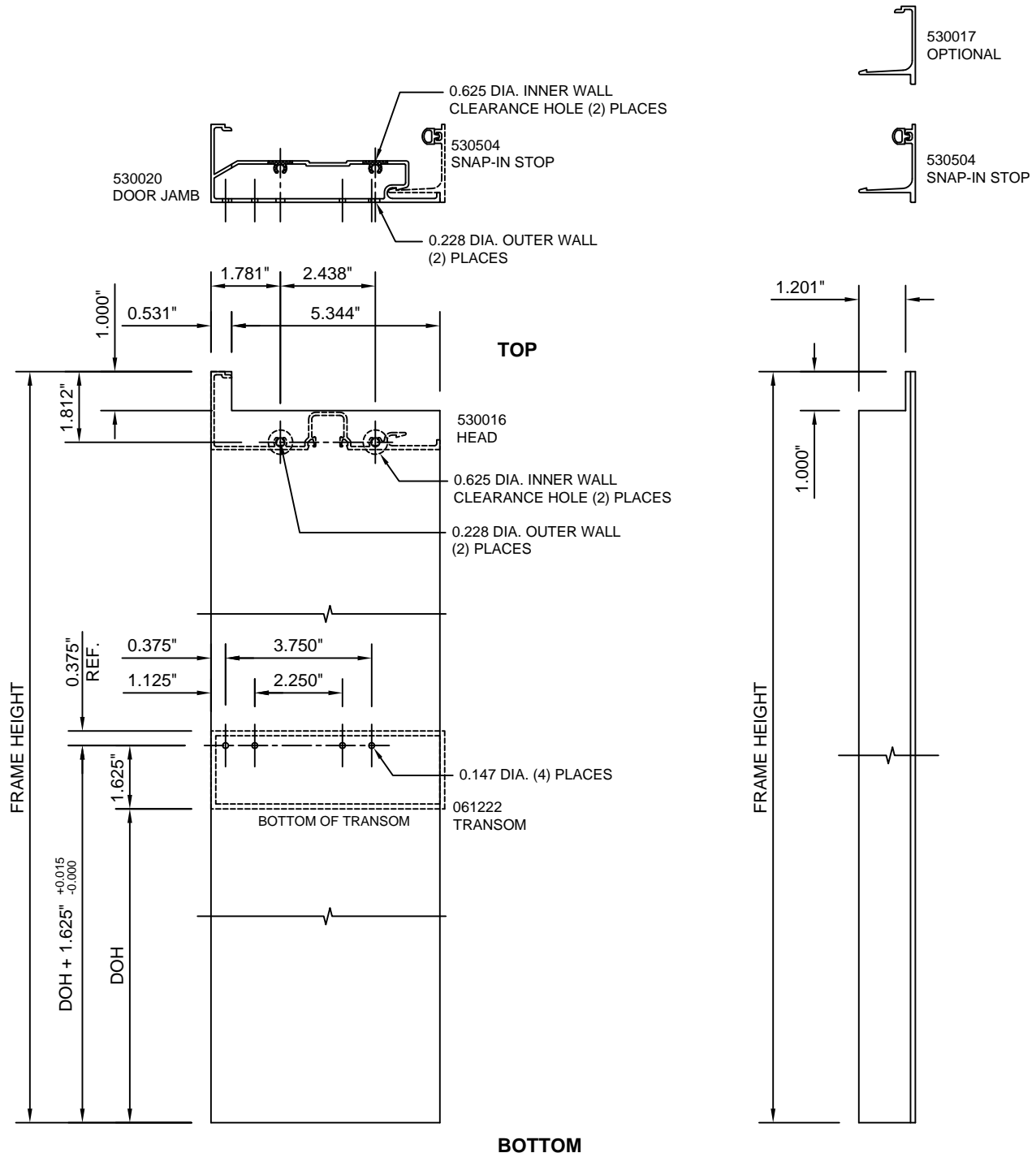
Cope top of door jamb as shown below, bottom of door jamb is square cut.

At head drill (2) 0.625 dia. clearance holes in inner wall of door jamb.

Then drill (2) 0.228 dia. holes for spline screws in outer wall of door jamb at locations shown.

At transom drill (4) 0.147 dia. holes in door jamb at locations shown for shear block attachment.

Cope top of snap-in stop as shown below, bottom of stop is square cut.



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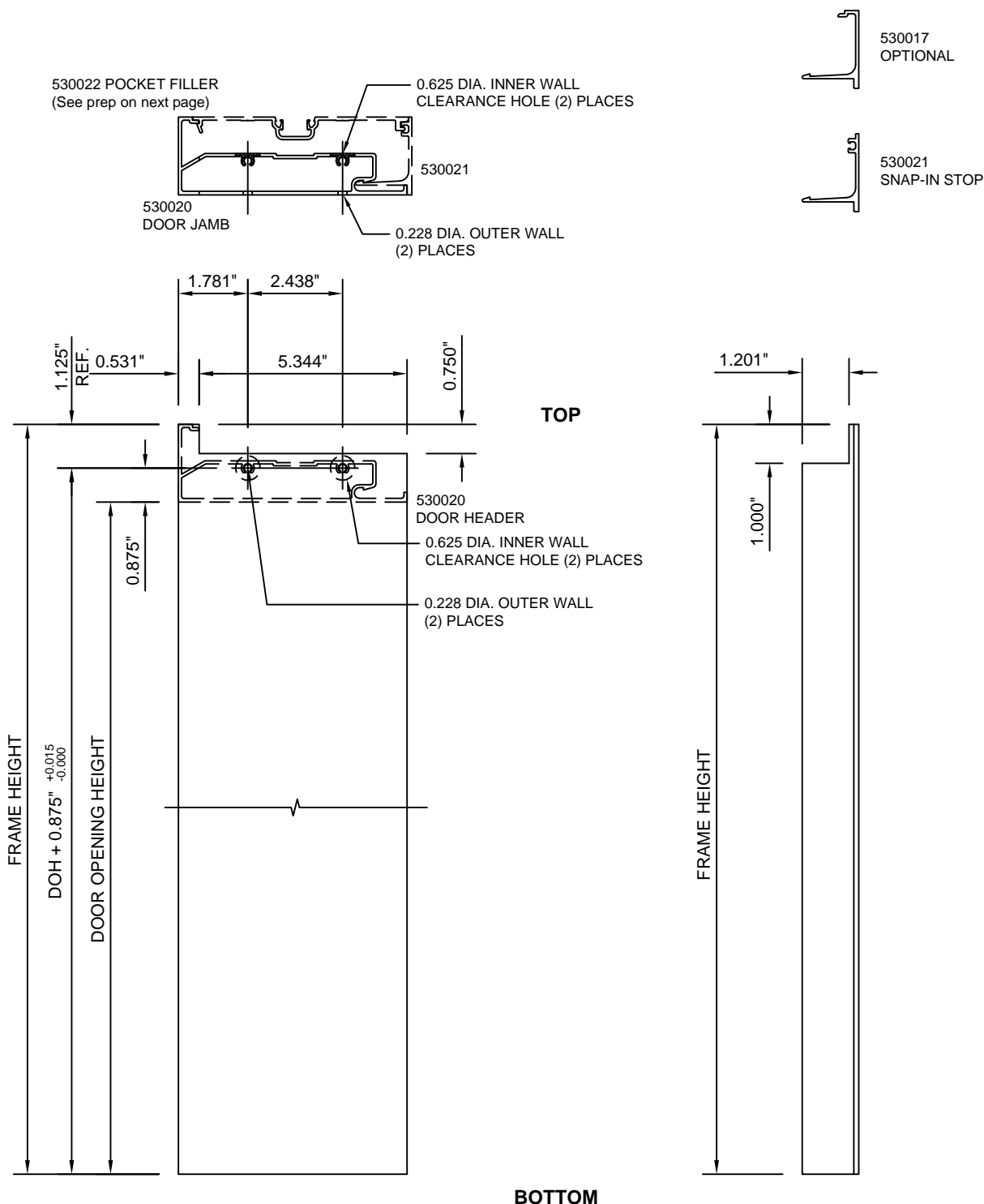
DOOR JAMB PREP AT DOOR HEADER WITH SIDELITE

Cope top of door jamb as shown below, bottom of door jamb is square cut.

At door header drill (2) 0.625 dia. clearance holes in inner wall of door jamb.

Then drill (2) 0.228 dia. holes for spline screws in outer wall of door jamb at locations shown.

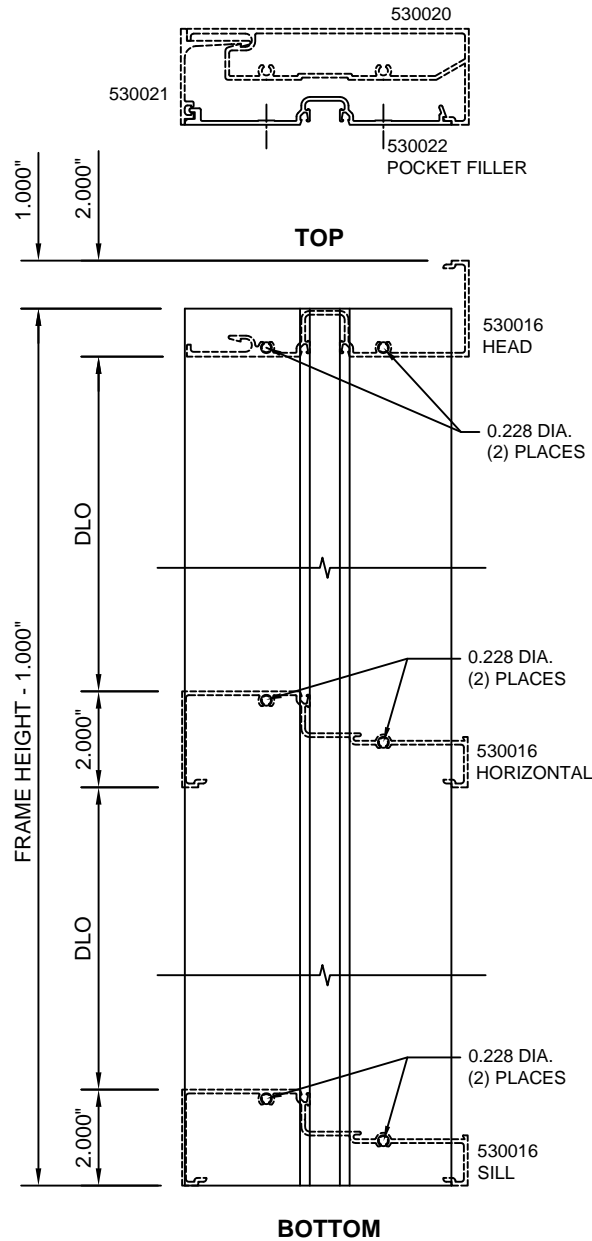
Cope top of snap-in door stop as show, bottom of snap-in stop is square cut.



DOOR JAMB PREP AT DOOR HEADER WITH SIDELITE (Cont.)

Pocket filler is square cut at head and sill.

Using the 530200 drill jig, drill (2) 0.228 dia. holes in pocket filler for spline screws at required locations.



NOTE:
FOR 4" HIGH SILL PREP SEE NEXT PAGE.

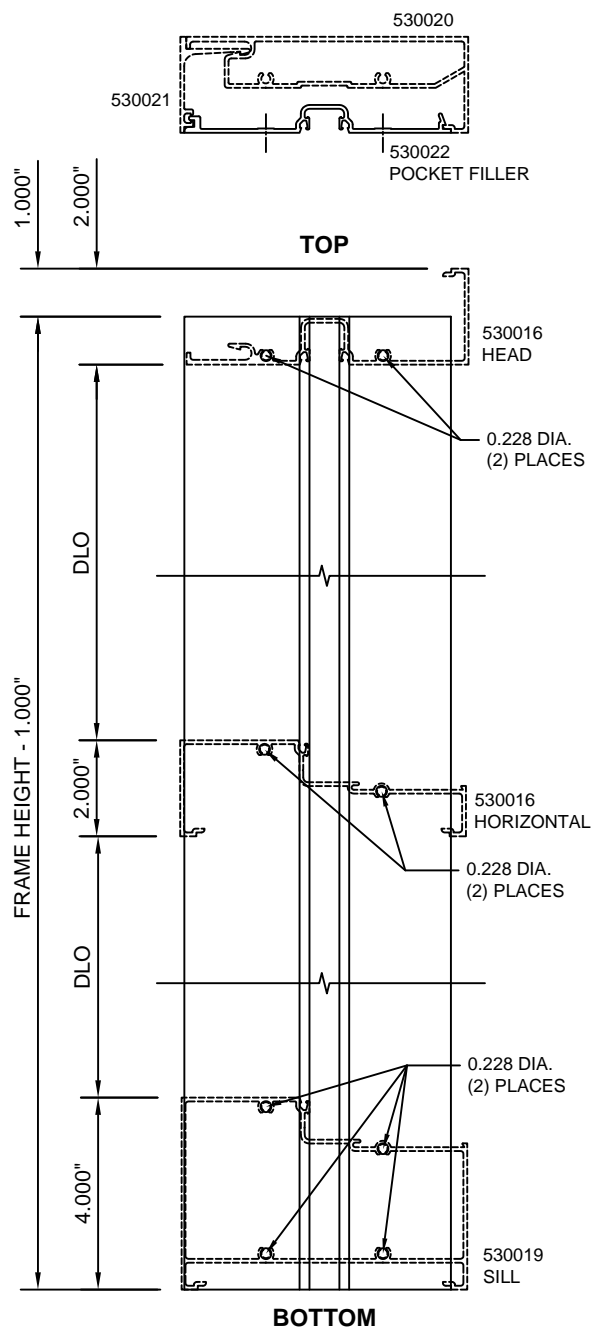
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DOOR JAMB PREP AT DOOR HEADER WITH 4" HIGH SILL , WITH SIDELITE (Cont.)

Pocket filler is square cut at head and sill.

Using the 530200 drill jig, drill (2) 0.228 dia. holes in pocket filler for spline screws at required locations.

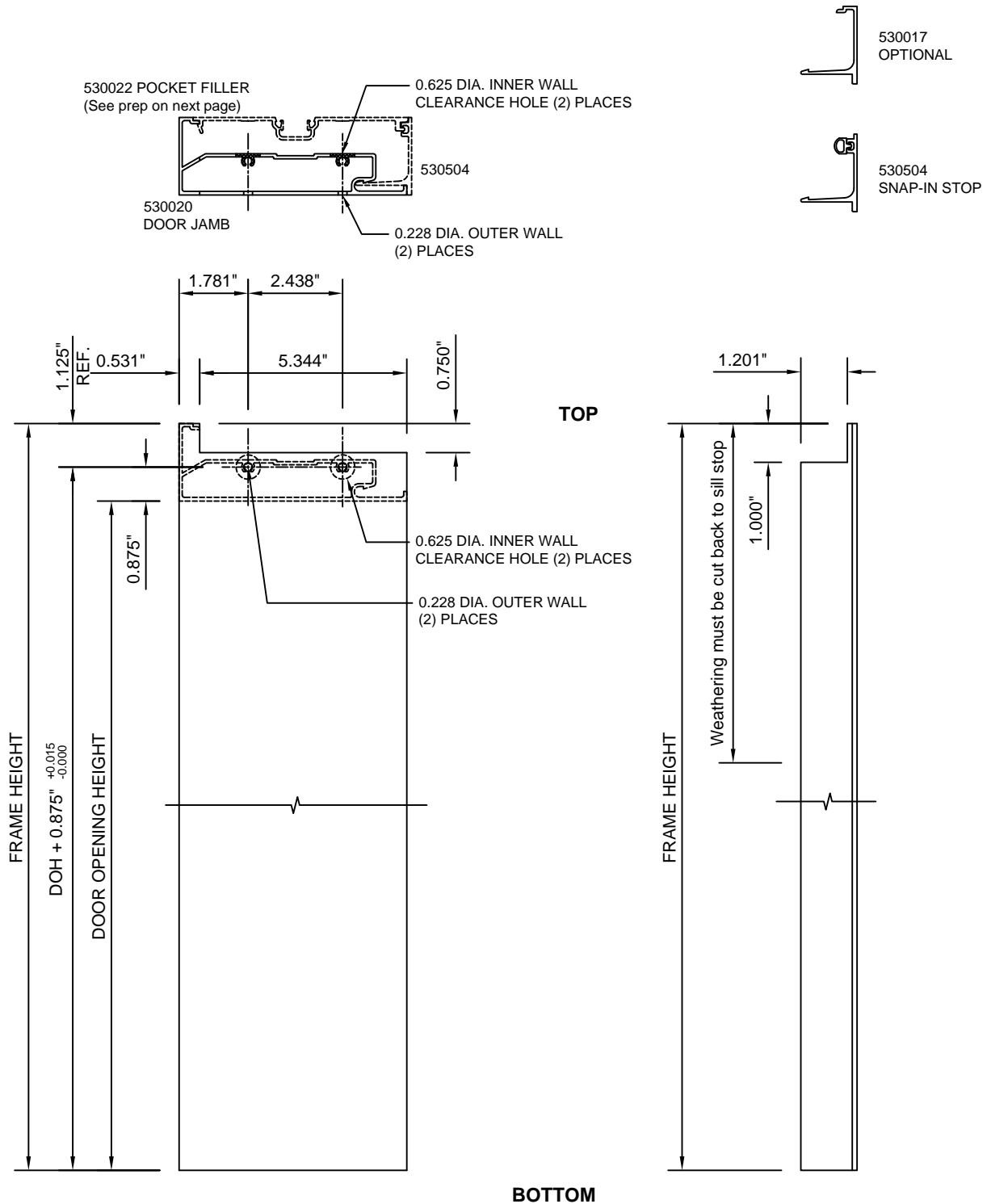


DOOR JAMB PREP WITH DOOR HEADER AT SIDELITE WITH PARTITION WALL

Cope top of door jamb as shown below, bottom of jamb is square cut.

Prep top of door jamb for spline screws by drilling (2) 0.625 dia. clearance holes into inner wall. Then drill (2) 0.228 dia. holes into outer wall at locations shown.

Cope top of snap-in stop as shown, bottom of snap-in stop is square cut. Weathering must be cut back to bottom of sill snap-in stop at partition wall.



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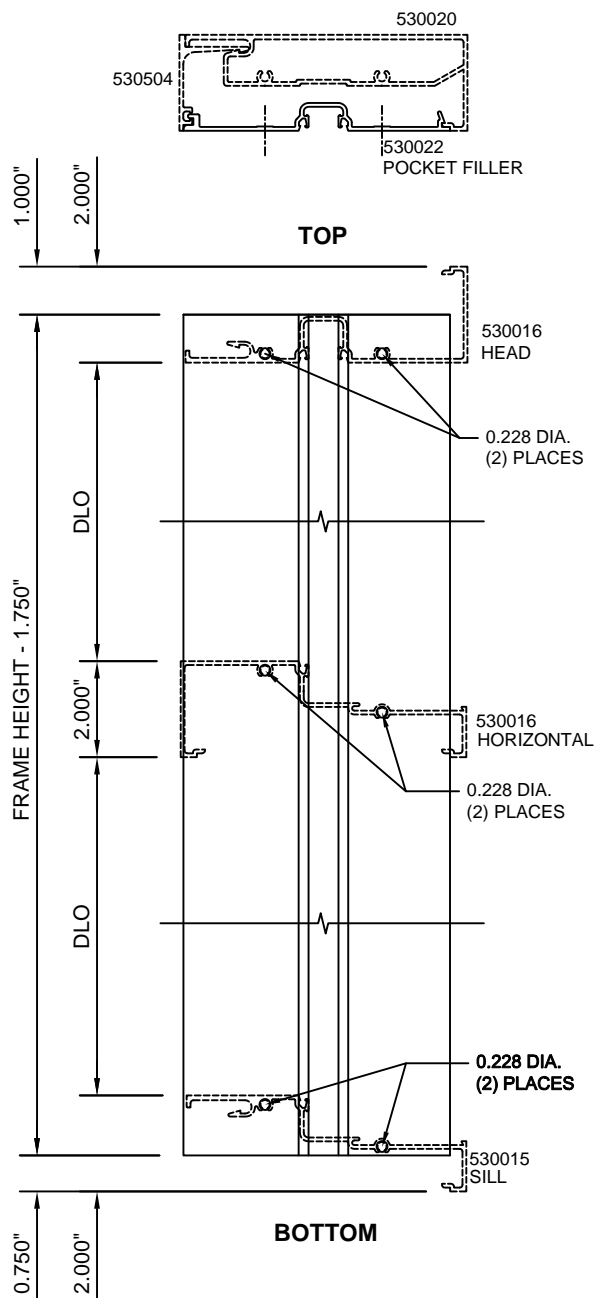
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DOOR JAMB PREP WITH DOOR HEADER AT SIDELITE WITH PARTITION WALL (Cont.)

Pocket filler is square cut at head and sill.

Using the 530200 drill jig, drill (2) 0.228 dia. holes in pocket filler for spline screws at required locations.



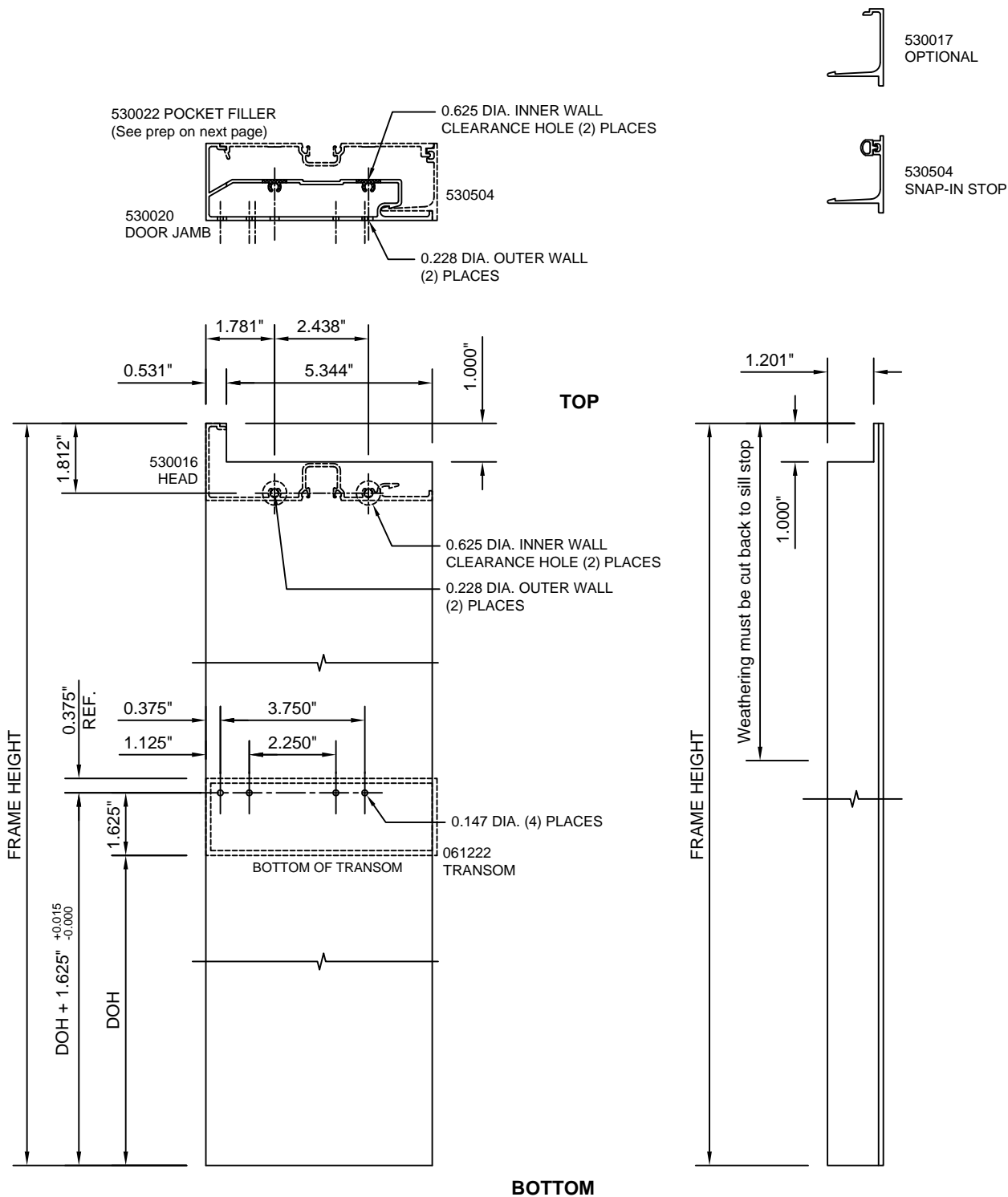
DOOR JAMB PREP WITH TRANSOM AT SIDELITE WITH PARTITION WALL

Cope top of door jamb as shown below, bottom of jamb is square cut.

At head drill (2) 0.625 dia. clearance holes in inner wall of door jamb at locations shown.
Then drill (2) 0.228 dia. holes for spline screws in outer wall of door jamb at locations shown.

At transom drill (4) 0.147 dia. holes in door jamb at locations shown for shear block attachment.

Cope top of snap-in stop as shown, bottom of snap-in stop is square cut.
Weathering must be cut back to bottom of sill snap-in stop at partition wall.



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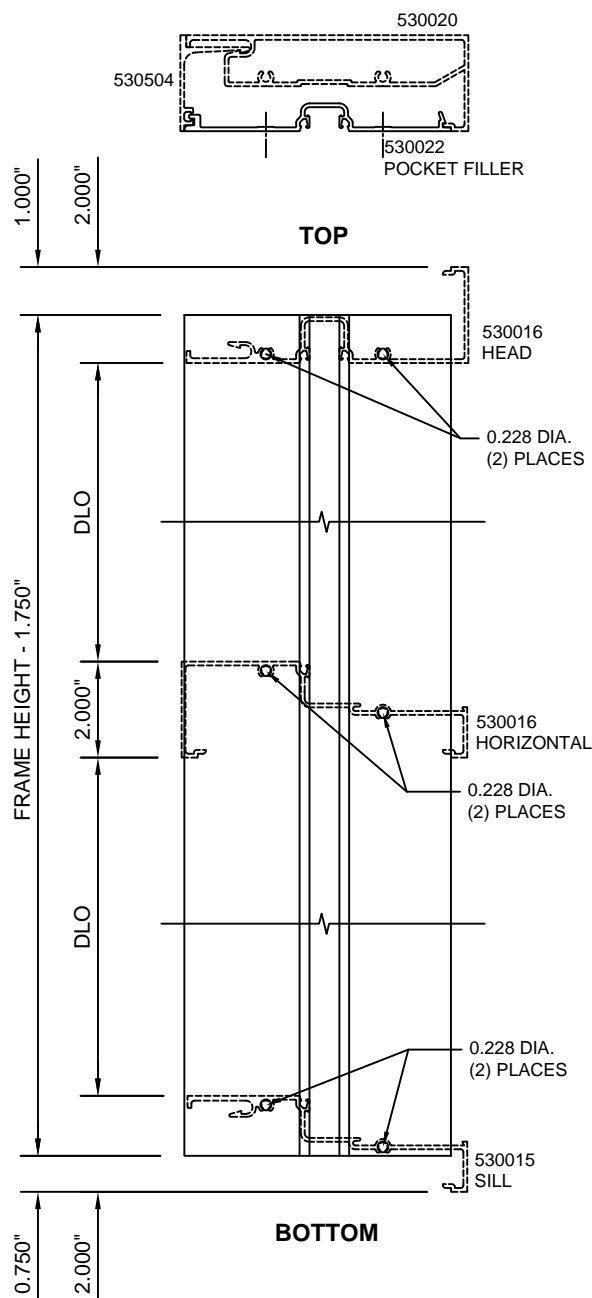
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DOOR JAMB PREP WITH TRANSOM AT SIDELITE WITH PARTITION WALL (Cont.)

Pocket filler at is square cut at head and sill.

Using the 530200 drill jig, drill (2) 0.228 dia. holes in pocket filler for spline screws at required locations.



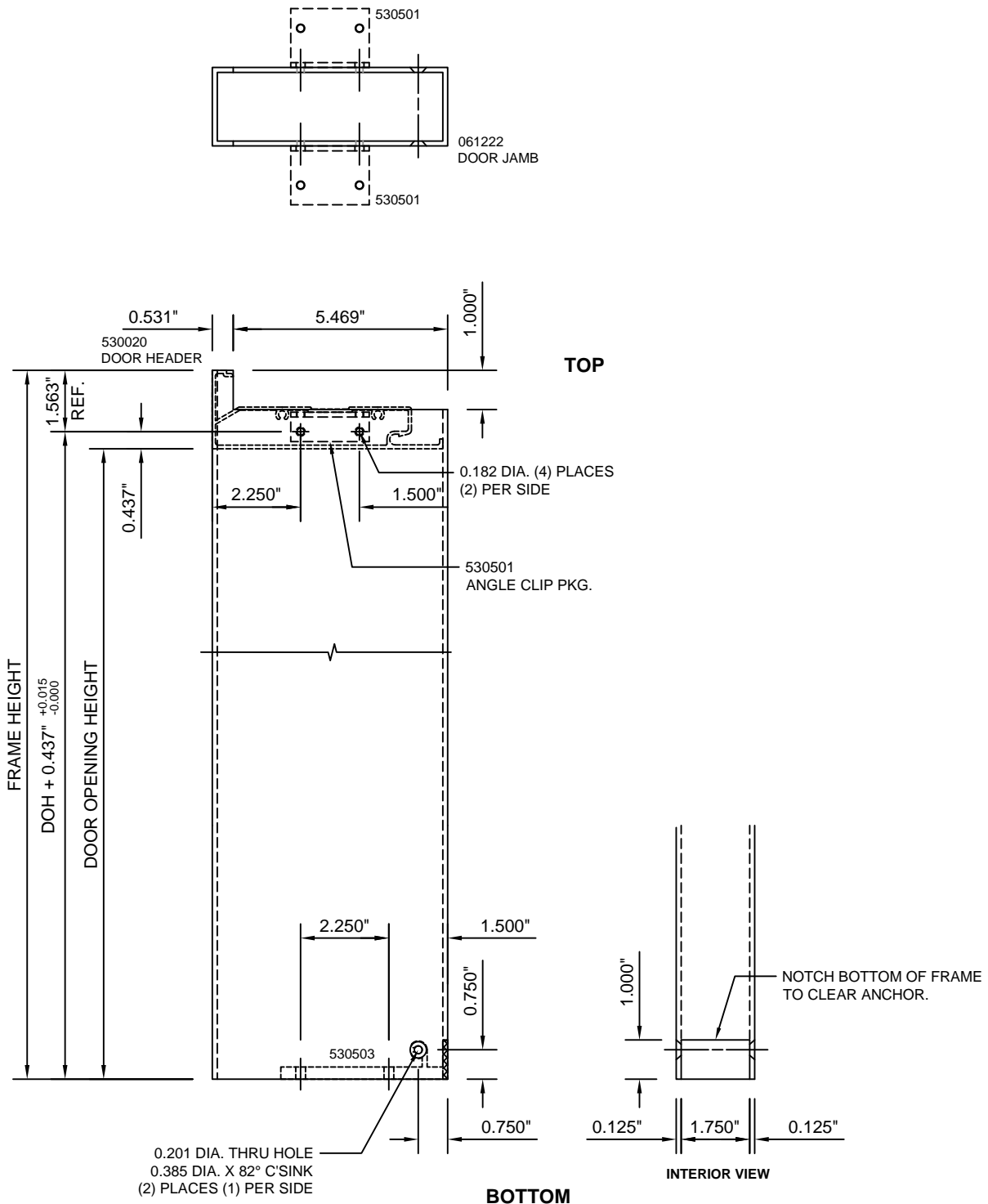
COMMON DOOR JAMB PREP WITH DOOR HEADER

Cope top of common door jamb as shown, bottom of door jamb is square cut.

Drill (2) 0.182 dia. holes on both sides of door jamb at locations shown for clip attachment.

At bottom of door jamb notch out interior side of jamb per dimensions shown to allow anchor installation.

At bottom of door jamb drill (1) 0.201 dia. thru hole with 0.385 dia. X 82° countersink on each side.



Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

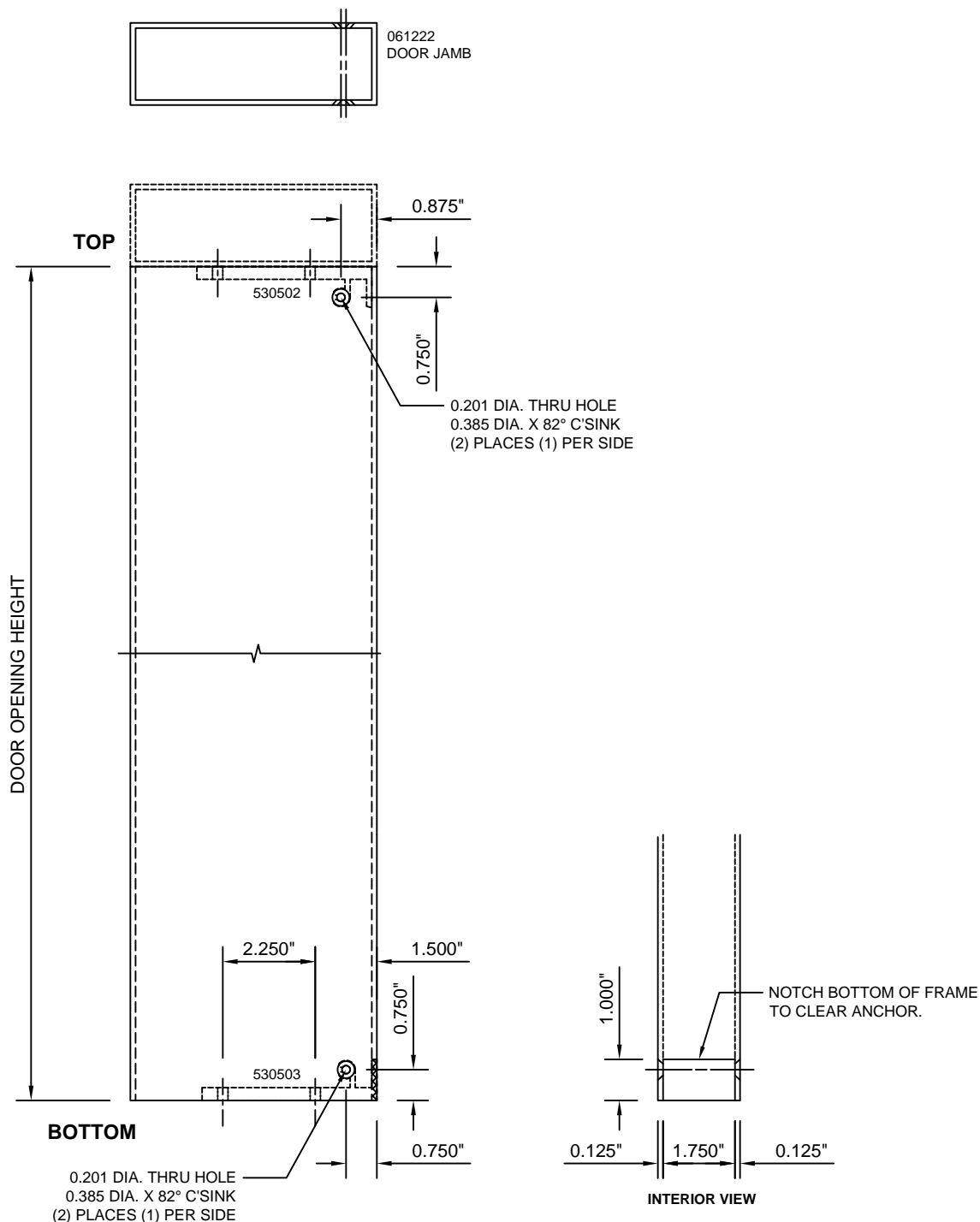
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COMMON DOOR JAMB PREP WITH TRANSOM

At top of door jamb drill (1) 0.201 dia. thru hole with 0.385 dia. X 82° countersink on each side.

At bottom of door jamb notch out interior side of jamb per dimensions shown to allow anchor installation.

At bottom of door jamb drill (1) 0.201 dia. thru hole with 0.385 dia. X 82° countersink on each side.



COMMON DOOR JAMB PREP WITH TRANSOM

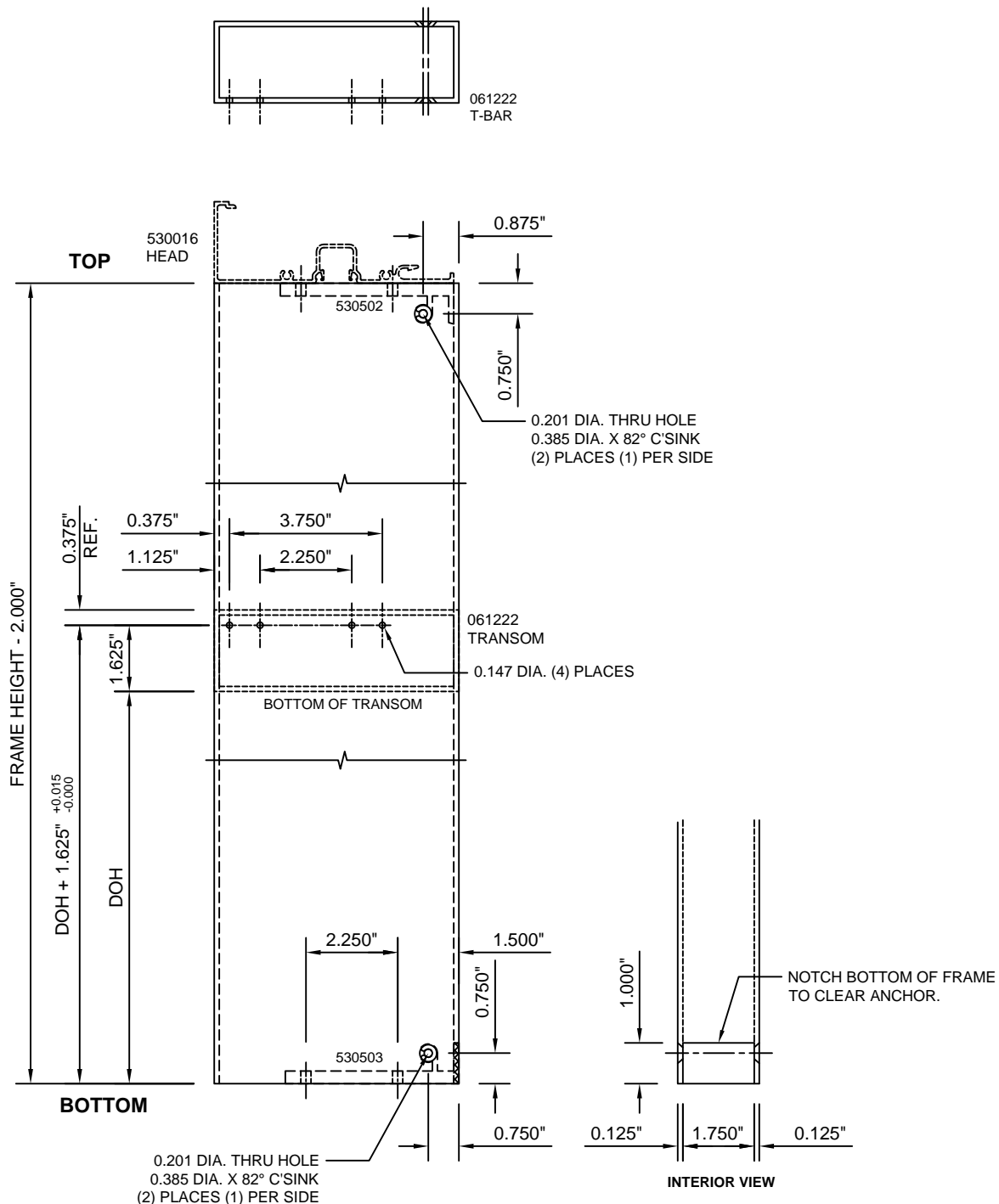
Top of common door jamb is square cut.

At top of door jamb drill (1) 0.201 dia. thru hole with 0.385 dia. X 82° countersink on each side.

At transom drill (4) 0.147 dia. holes in door jamb at locations shown for shear block attachment.

At bottom of door jamb notch out interior side of jamb per dimensions shown to allow anchor installation.

At bottom of door jamb drill (1) 0.201dia. thru hole with 0.385 dia. X 82° countersink on each side.



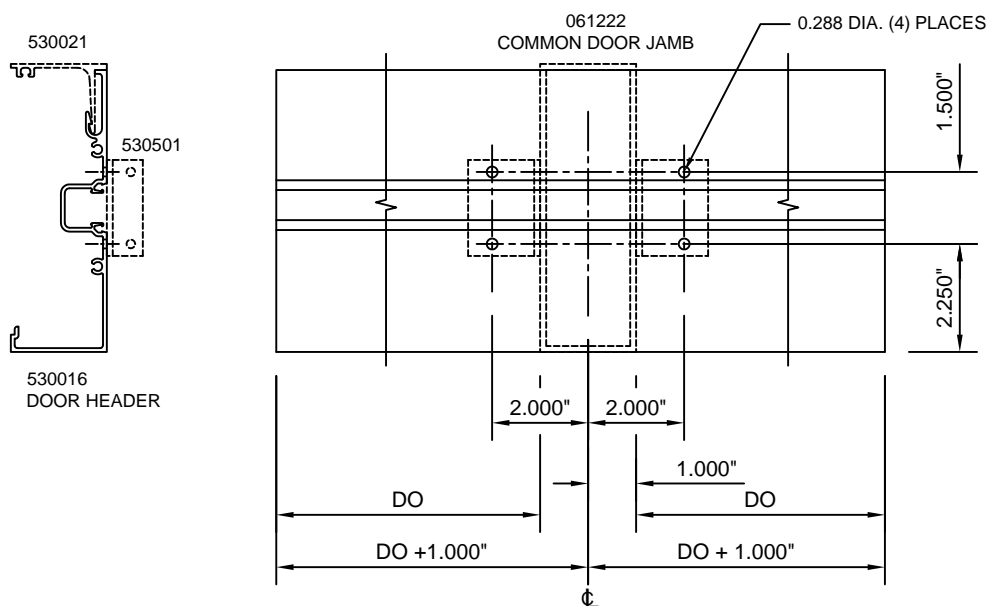
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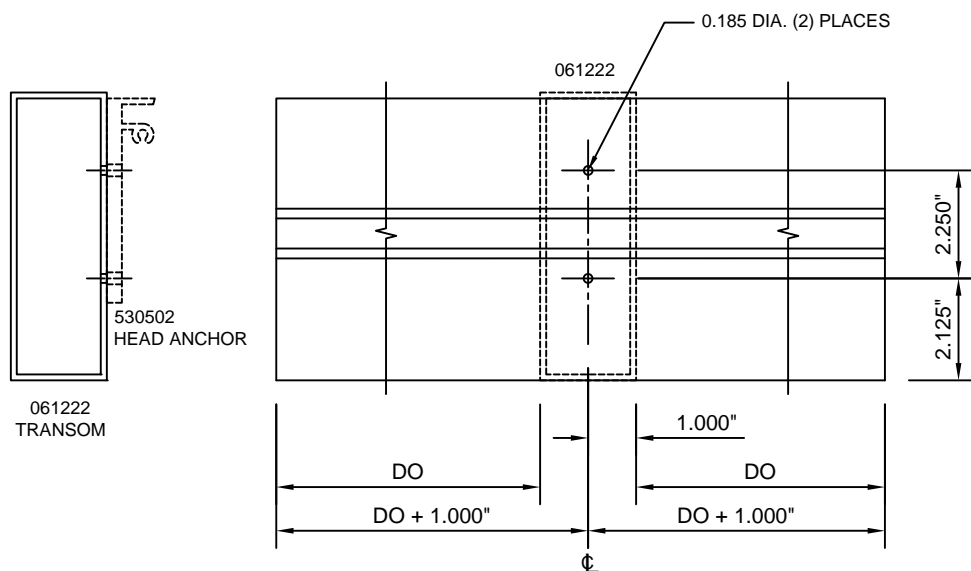
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DOOR HEADER PREP FOR COMMON DOOR JAMB

Prep door header from centerline of common door jamb location, drill (4) 0.288 dia. holes at locations shown.

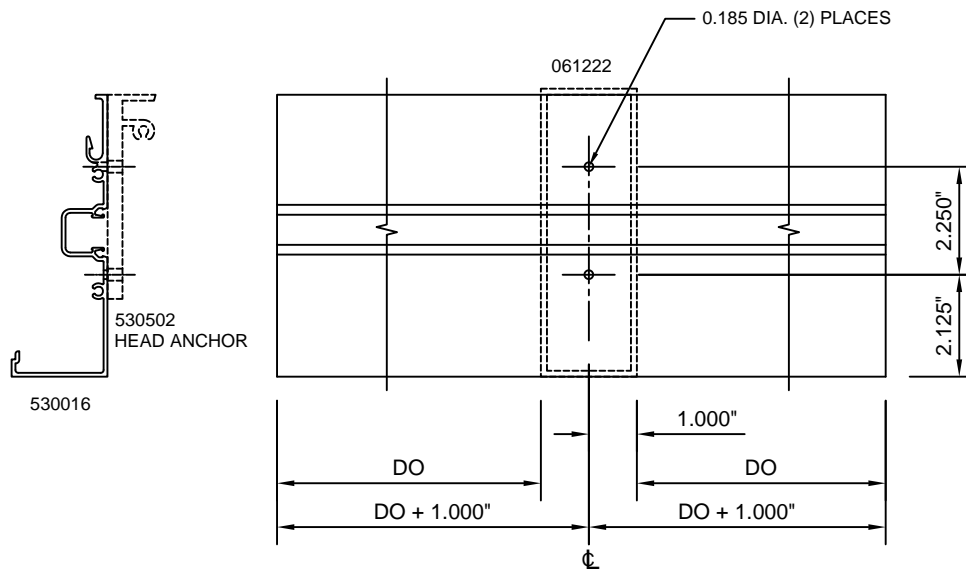
**TRANSOM PREP FOR COMMON DOOR JAMB**

Prep transom at centerline of common door, drill (2) 0.185 dia. holes at locations shown.



TRANSOM HEAD PREP FOR COMMON DOOR JAMB

Prep transom head at centerline of common door, drill (2) 0.185 dia. holes at locations shown.



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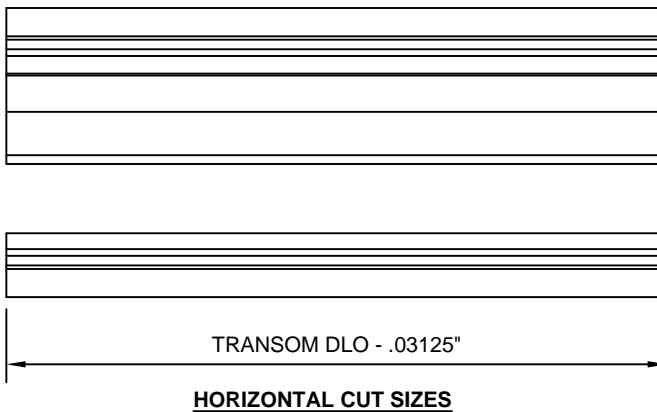
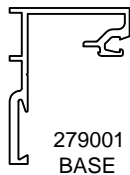
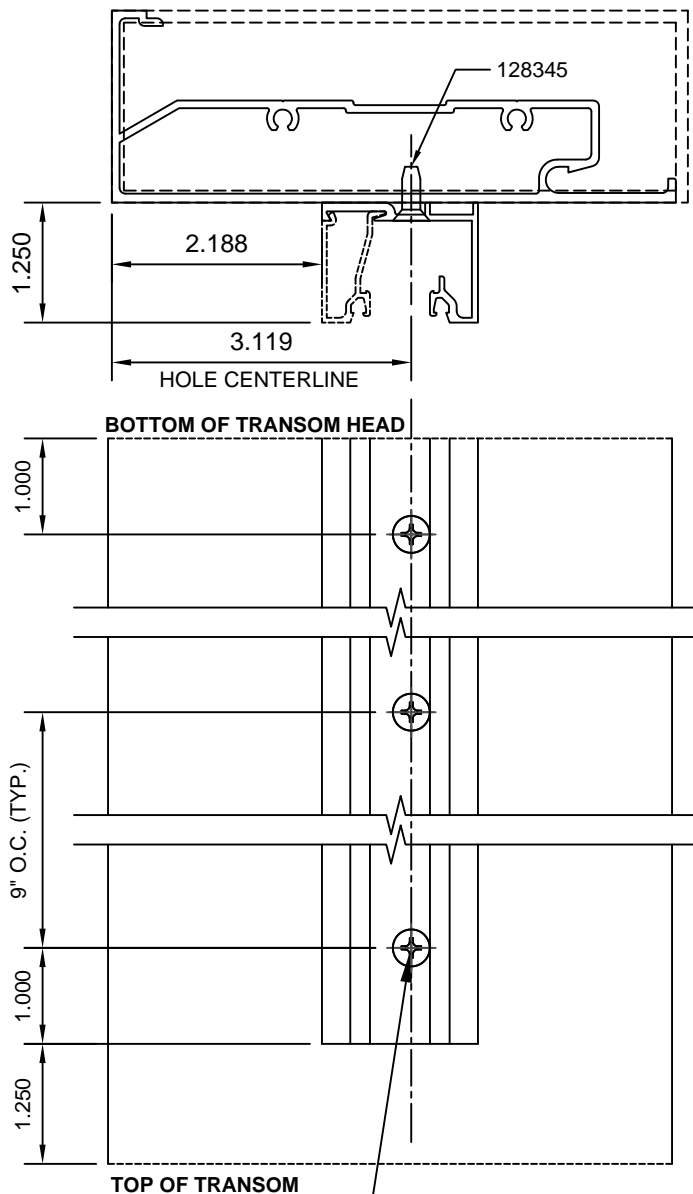
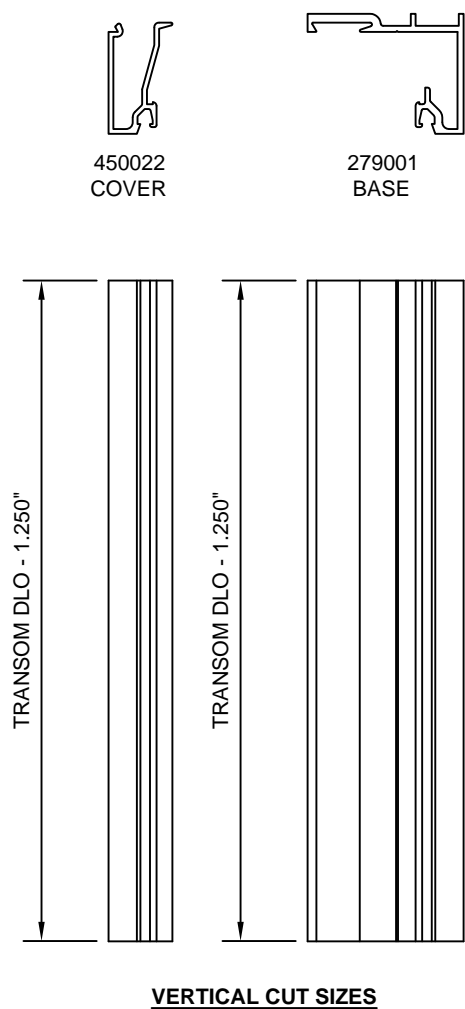
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DETAIL OF TRANSOM STOP ASSEMBLY

DOOR JAMB (TRANSOM SIMILAR)

530020 SHOWN

061222 DASHED



DETAIL OF (069177) DOOR STOP ASSEMBLY

DOOR JAMB (TRANSOM SIMILAR)

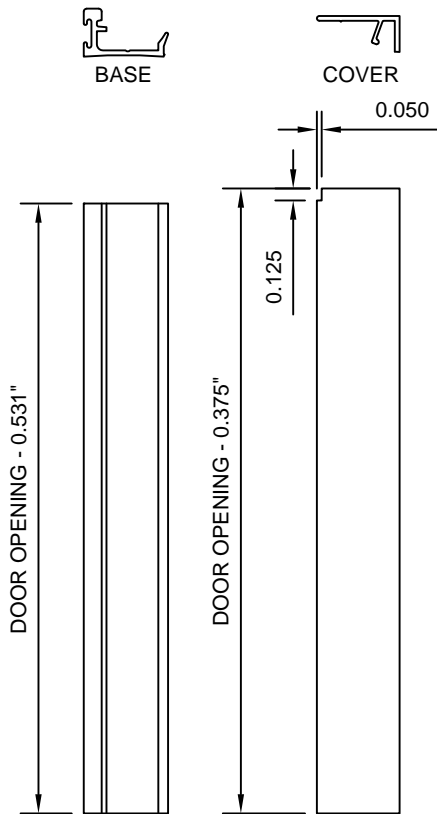
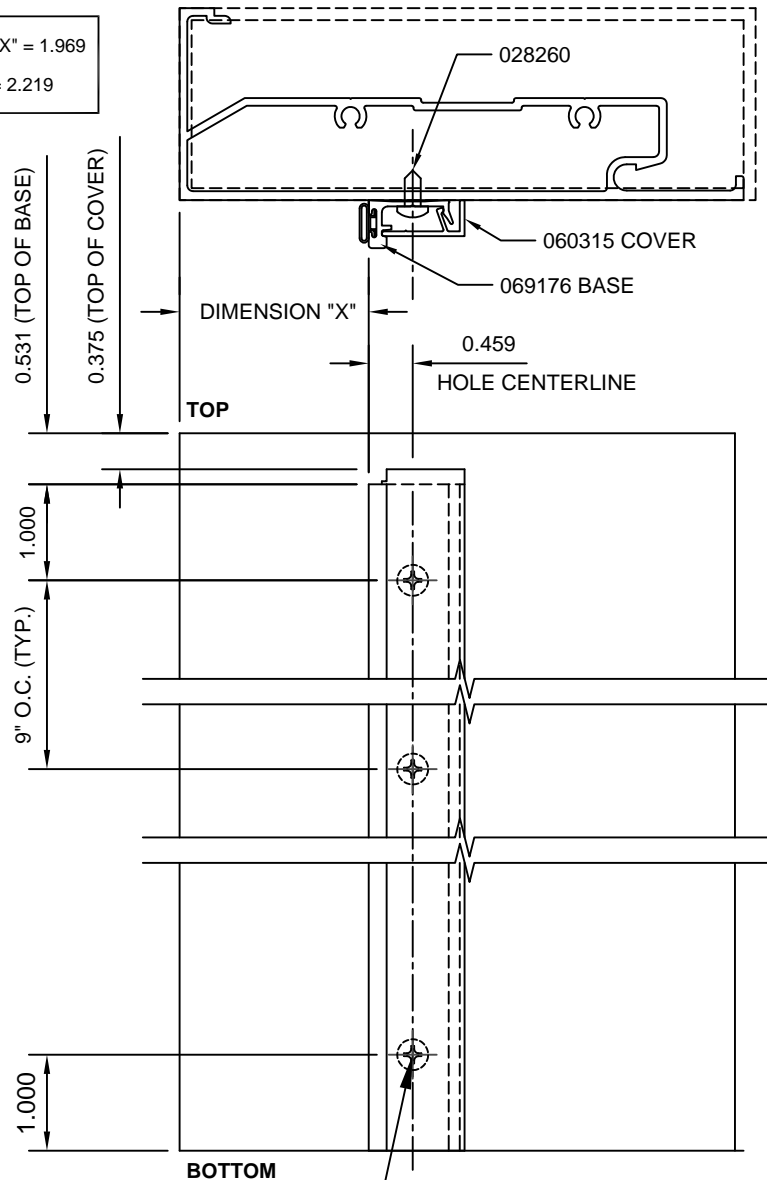
530020 SHOWN

061222 DASHED

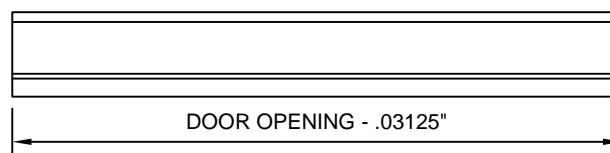
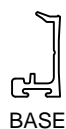
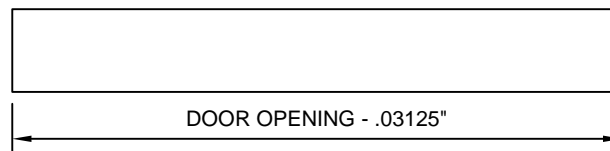
DIMENSION "X"

FOR 1-3/4" DOORS: DIMENSION "X" = 1.969

FOR 2" DOORS: DIMENSION "X" = 2.219

**VERTICAL CUT SIZES**

DRILL HOLES FOR #8 PHST FASTENER
AT 1" FROM EACH END AND 9" O.C.
(USE HOLES IN BASE AS TEMPLATE)

**HORIZONTAL CUT SIZES**

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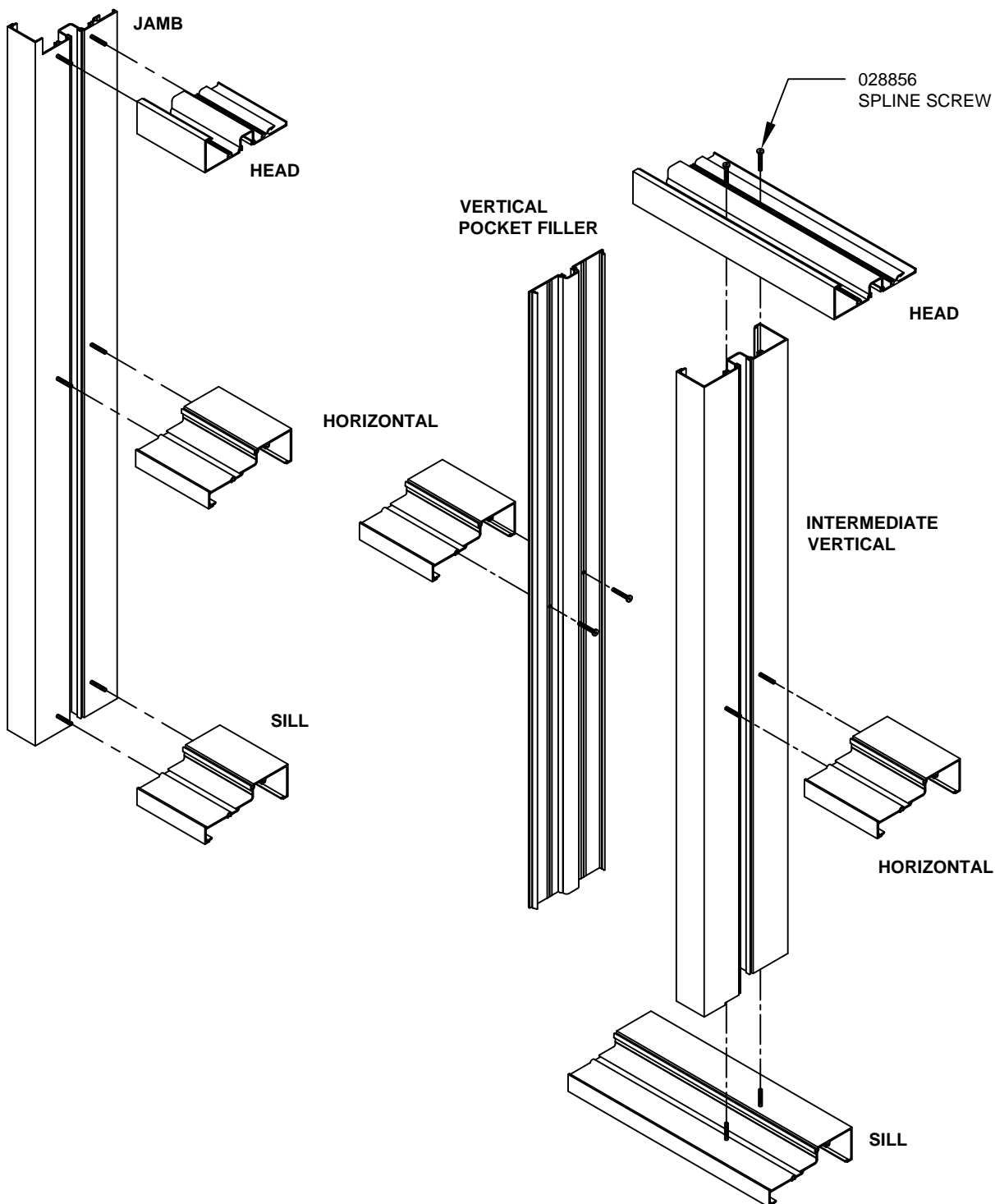
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FRAME ASSEMBLY

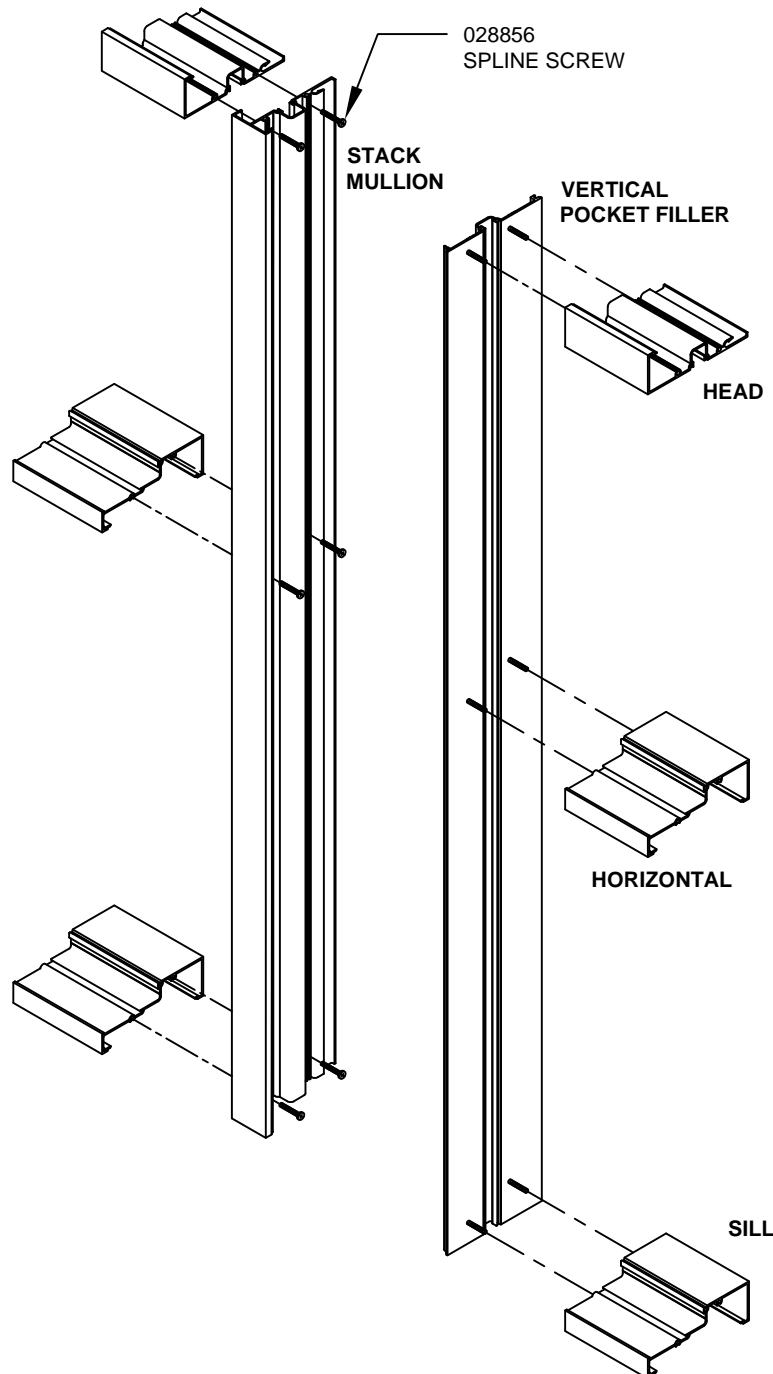
1. Using 028856 (#12 x 1-1/8" PHTF) spline screws, attach head and sill to intermediate vertical.
Drive first fastener mid-way into screw spline, insert and drive second fastener into remaining screw spline.
Then secure / tighten both fasteners into framing member. Applying fasteners in this method will prevent crazing the finish on exposed surfaces.
2. Attach horizontal to intermediate vertical.
3. Attach horizontal to vertical pocket filler.
4. Snap pocket filler into vertical member.
5. Attach jamb to head, horizontal and sill members.

NOTE: Build one bay at a time, fastening first bay then installing next.



FRAME ASSEMBLY AT STACK MULLION

1. Using 028856 (#12 x 1-1/8" PHTF) spline screws, attach head, horizontal and sill to intermediate vertical. Drive first fastener mid-way into screw spline, insert and drive second fastener into remaining screw spline. Then secure / tighten both fasteners into framing member. Applying fasteners in this method will prevent crazing the finish on exposed surfaces
2. Attach head, horizontal and sill to vertical pocket filler.
3. Pocket filler will snap into vertical member when frame is installed.



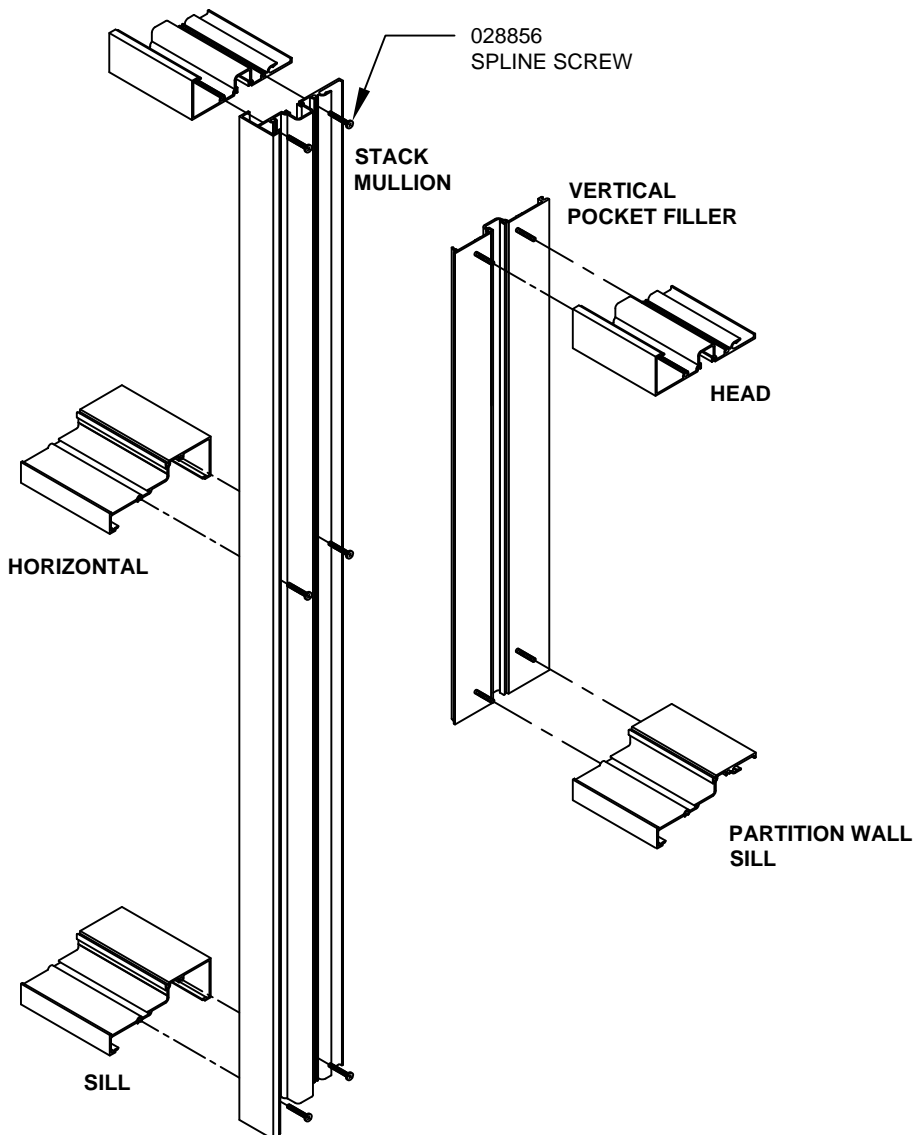
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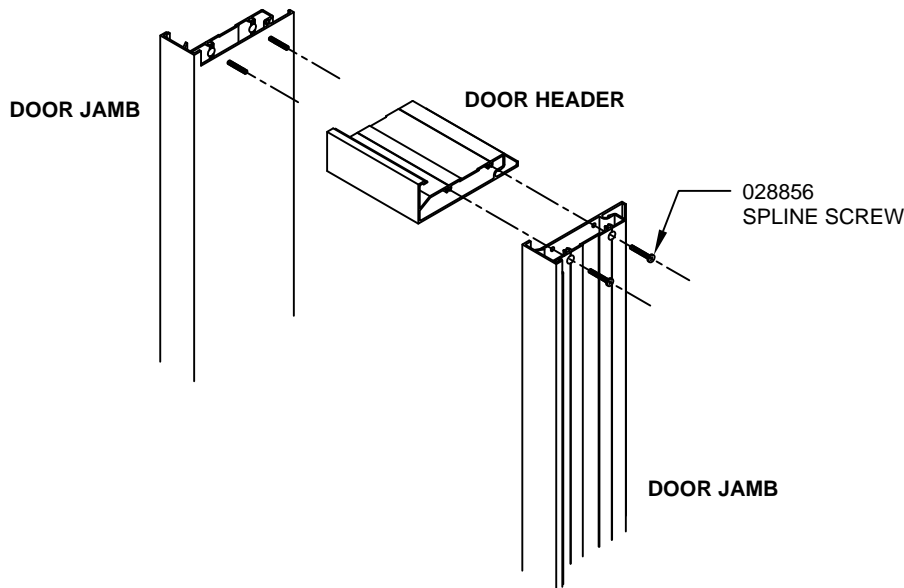
FRAME ASSEMBLY AT STACK MULLION WITH PARTITION WALL

1. Using 028856 (#12 x 1-1/8" PHTF) spline screws, attach head, horizontal and sill to intermediate vertical. Drive first fastener mid-way into screw spline, insert and drive second fastener into remaining screw spline. Then secure / tighten both fasteners into framing member. Applying fasteners in this method will prevent crazing the finish on exposed surfaces
2. Attach head, horizontal and sill to vertical pocket filler.
3. Pocket filler will snap into vertical member when frame is installed.

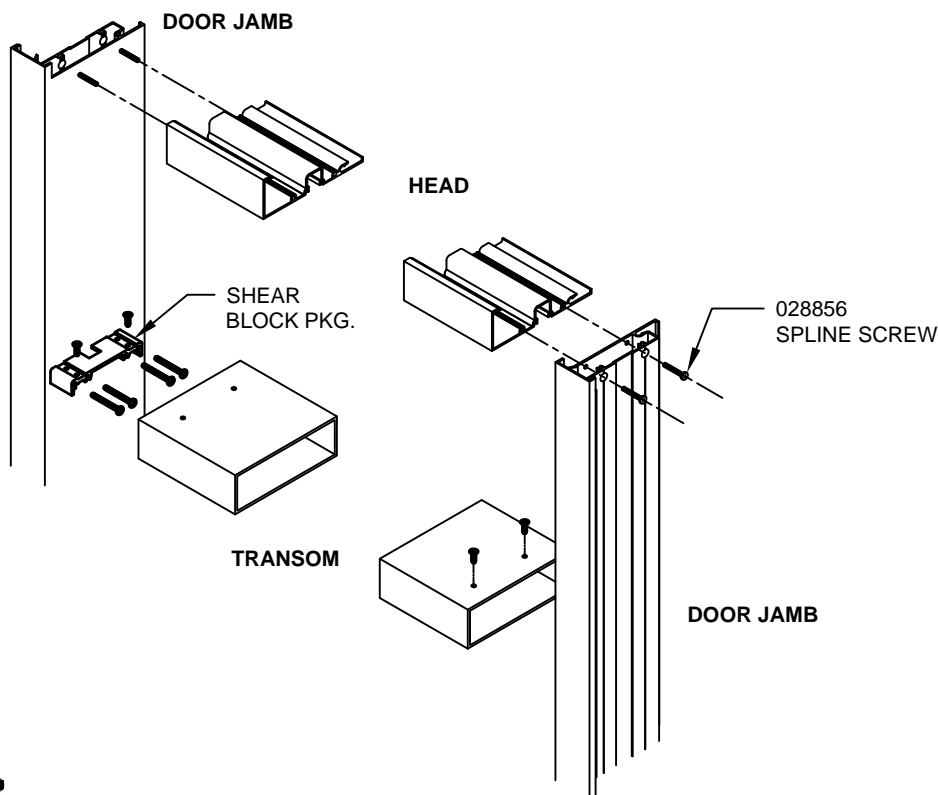


DOOR FRAME ASSEMBLY WITH DOOR HEADER

1. Using 028856 (#12 x 1-1/8" PHTF) spline screws, attach door header to door jambs.
Drive first fastener mid-way into screw spline, insert and drive second fastener into remaining screw spline.
Then secure / tighten both fasteners into framing member. Applying fasteners in this method will prevent crazing the finish on exposed surfaces

**DOOR FRAME ASSEMBLY WITH TRANSOM**

1. Using 028856 (#12 x 1-1/8" PHTF) spline screws, attach head to door jambs.
Drive first fastener mid-way into screw spline, insert and drive second fastener into remaining screw spline.
Then secure / tighten both fasteners into framing member. Applying fasteners in this method will prevent crazing the finish on exposed surfaces
2. Attach transom to door jambs with shear blocks.

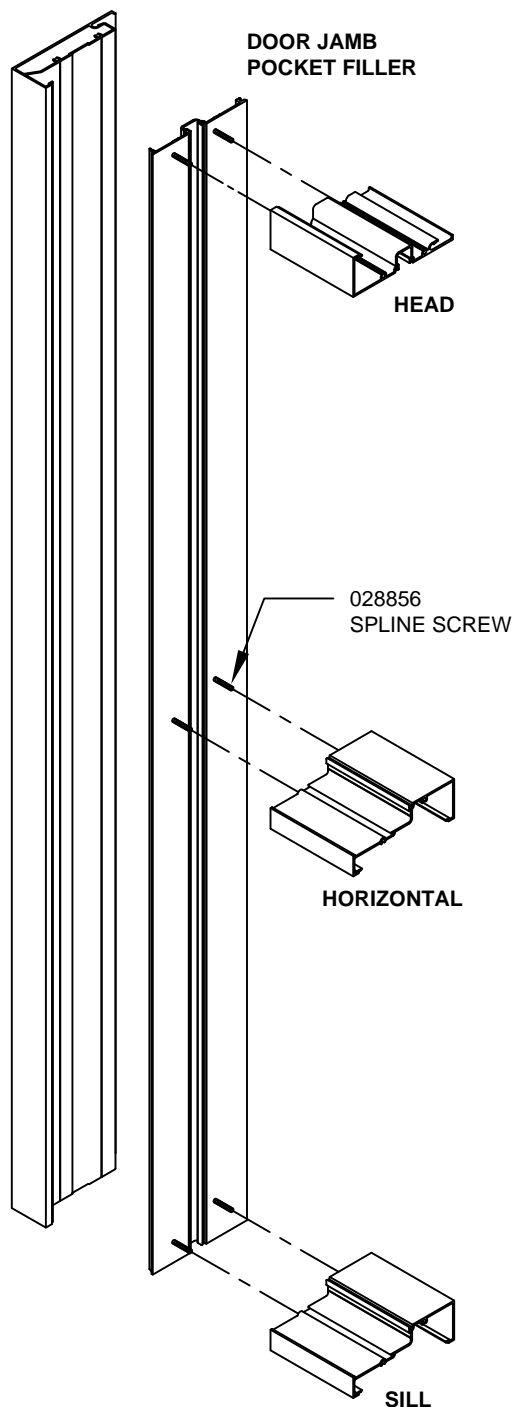
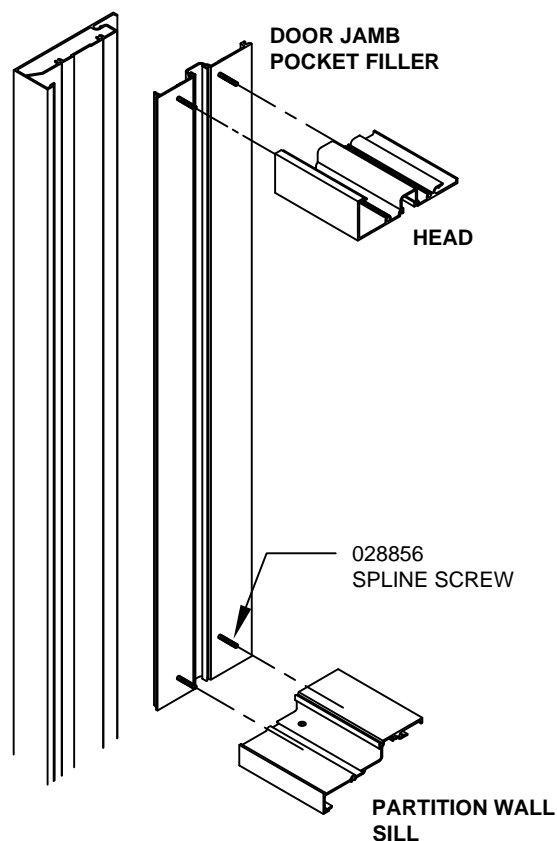


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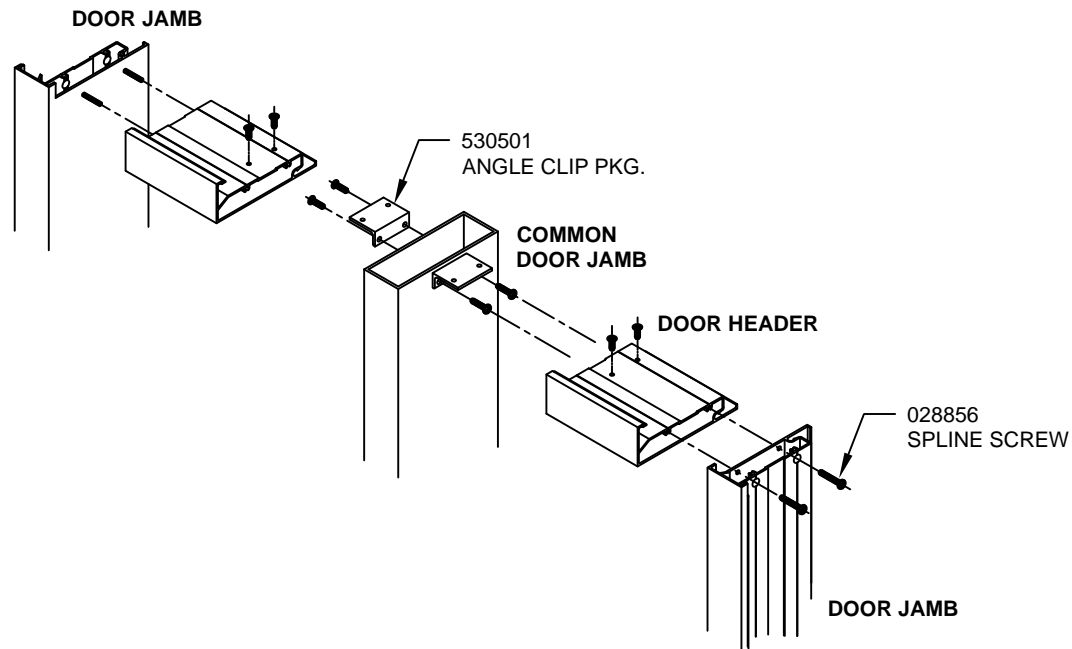
DOOR FRAME ASSEMBLY WITH SIDELITE

1. Using 028856 (#12 x 1-1/8" PHTF) spline screws, attach door jamb pocket filler to head, horizontal and sill. Drive first fastener mid-way into screw spline, insert and drive second fastener into remaining screw spline. Then secure / tighten both fasteners into framing member. Applying fasteners in this method will prevent crazing the finish on exposed surfaces

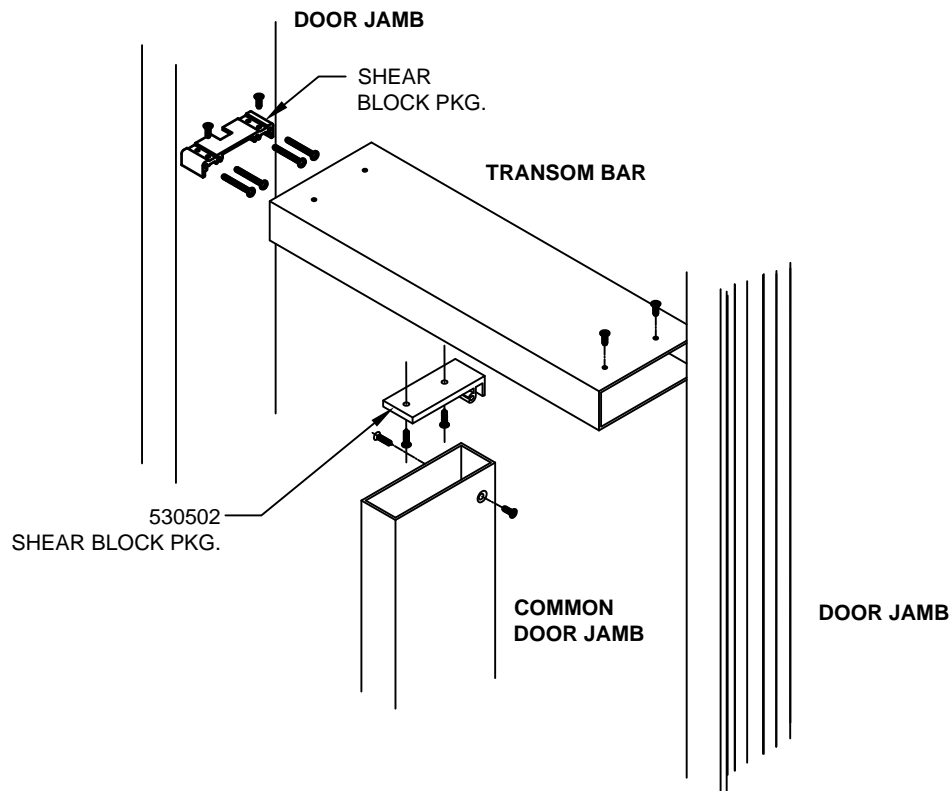
DOOR JAMB**AT PARTITION WALL****DOOR JAMB**

COMMON DOOR JAMB FRAME ASSEMBLY WITH DOOR HEADER

1. Attach door header to door jambs with 028856 (#12 x 1-1/8" PHTF) spline screws.
2. Attach common door jamb to door header with (530501) angle clip package.

**COMMON DOOR FRAME ASSEMBLY WITH TRANSOM**

1. Attach transom to door jambs with shear block.
2. Attach (530502) shear block pkg. to transom with pan head screws provided.
3. Insert common door jamb over shear block and fasten with flat head screws provided.

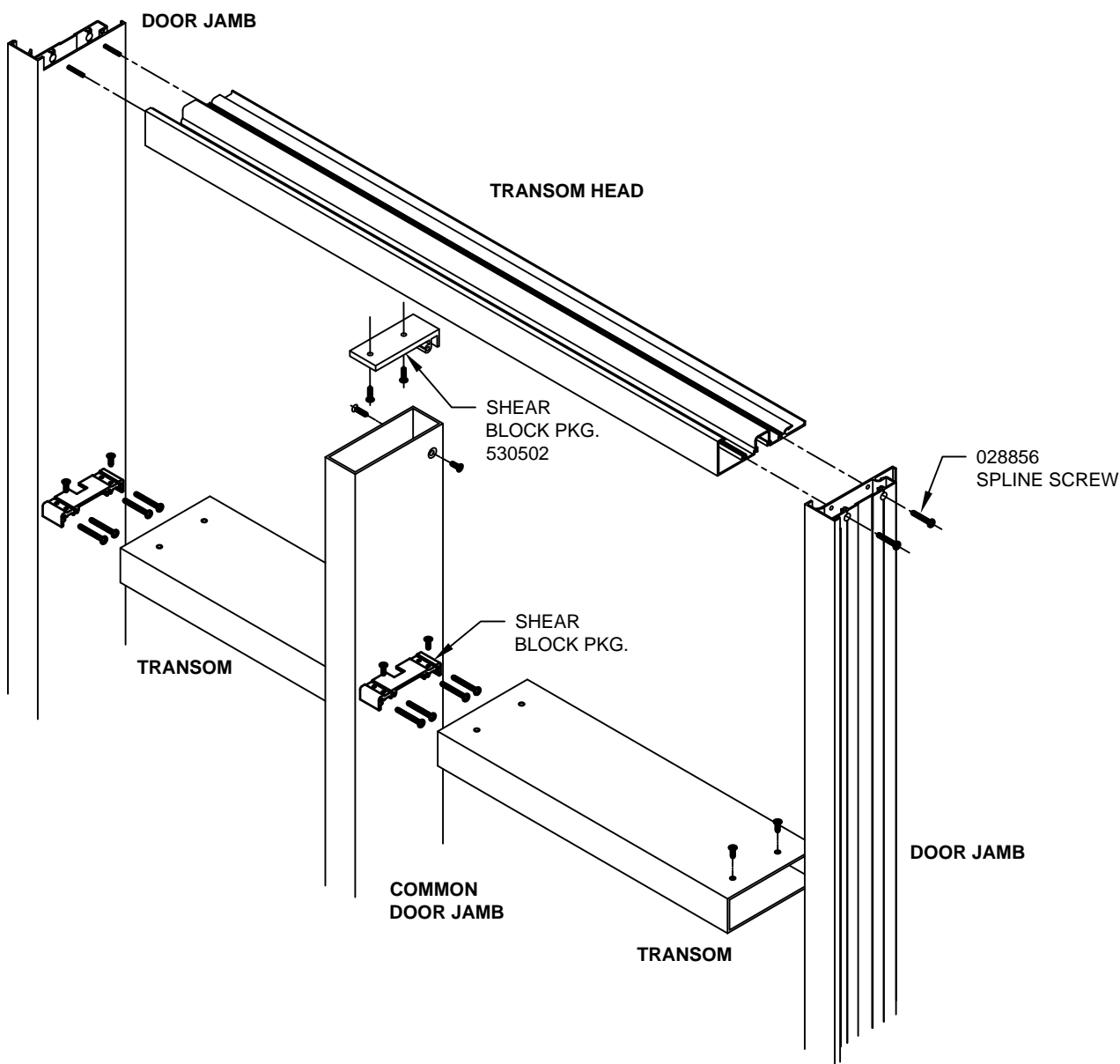


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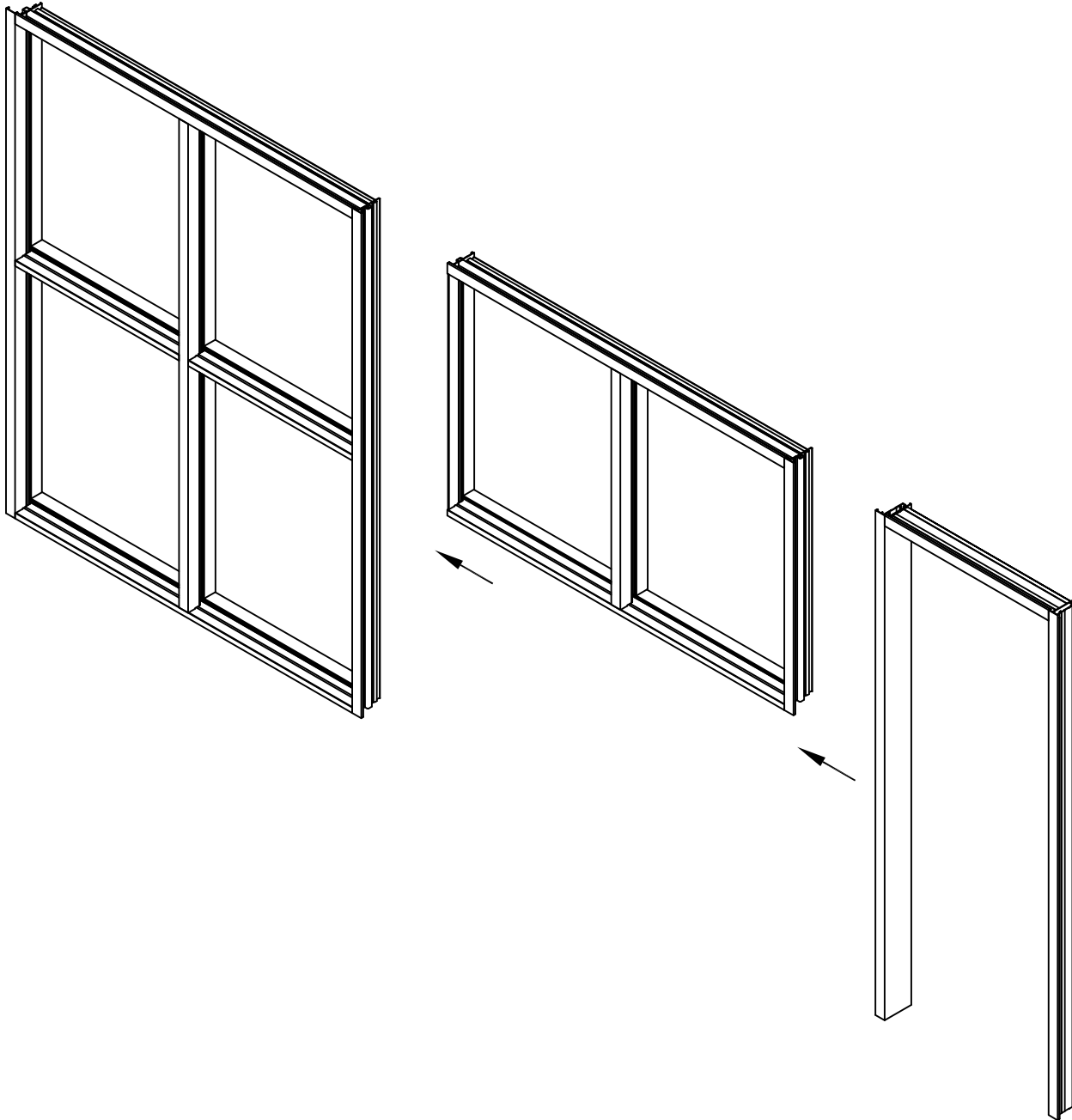
COMMON DOOR JAMB FRAME ASSEMBLY WITH TRANSOM

1. Attach transom head to door jambs with 028856 (#12 x 1-1/8" PHTF) spline screws.
2. Attach (530502) shear block pkg. to transom head with pan head screws provided.
3. Insert common door jamb over (530502) shear block pkg. and fasten with flat head screws provided.
4. Attach transom bar to common door jam with shear block on both sides.



FRAME ASSEMBLY

This framing system is designed to be fabricated and assembled on the floor in bays, then each bay is raised into the opening position and joined with the next bay. Once elevation is anchored into the opening, the head, jambs and partition sill members are captured with a snap-in face member to secure the entire opening.

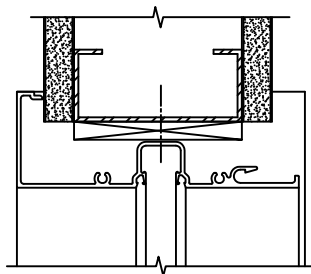
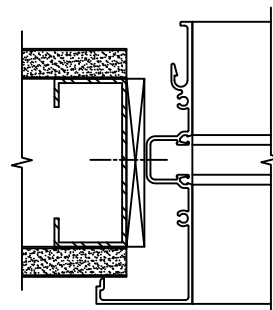
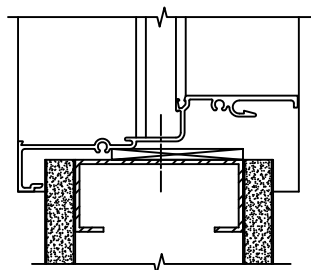
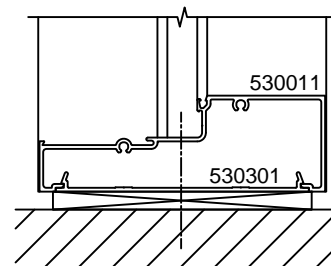


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Shim and anchor the frame in a plum and level condition after the frame is set into place.

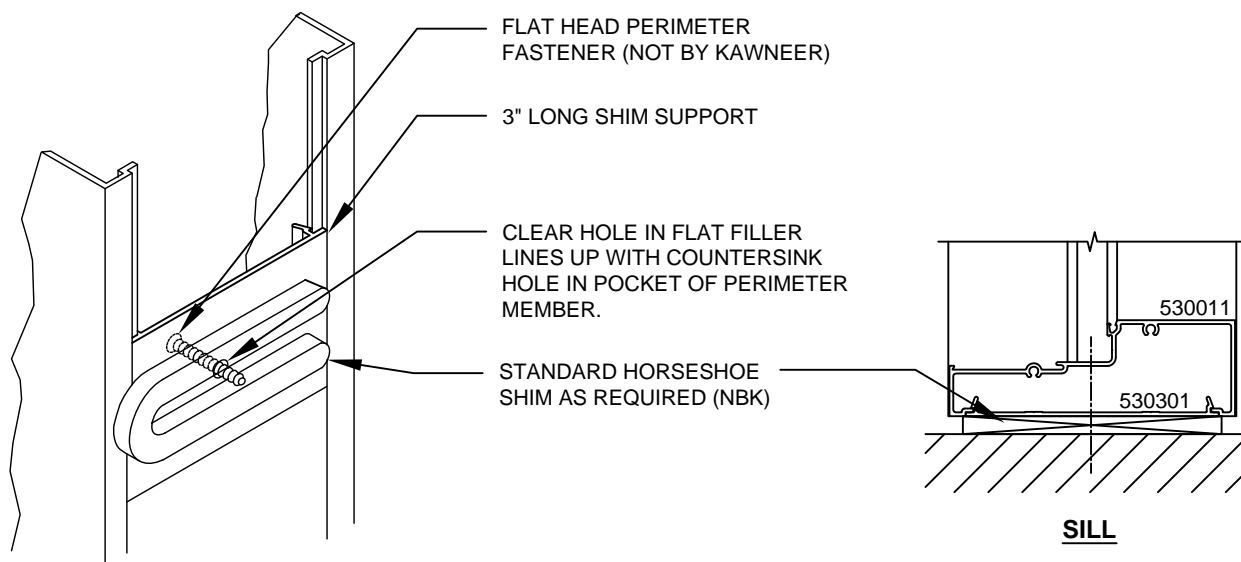
**HEAD****JAMB****SILL AT PARTITION WALL****SILL**

SHIM INSTALLATION

Drill and countersink perimeter fastener holes in frame members, place shims at perimeter anchor locations.

For (530011) sill, match drill hole through (530301) shim support.

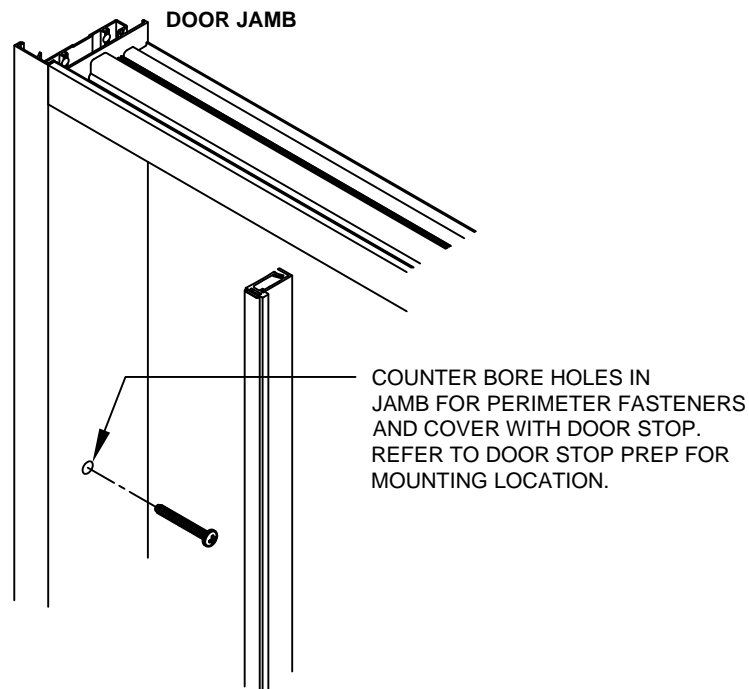
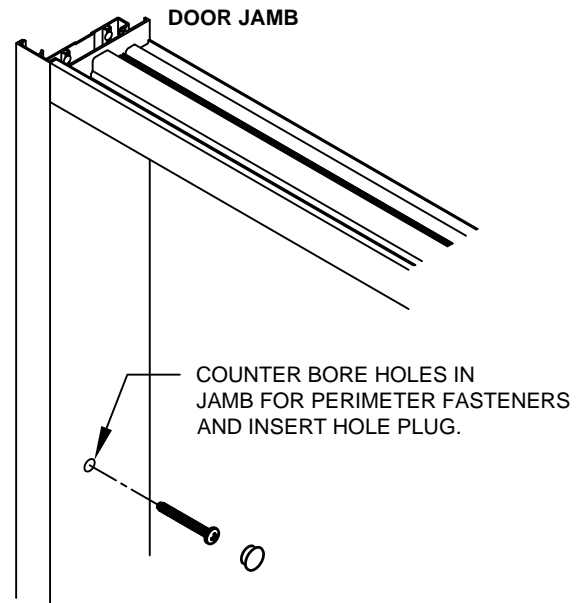
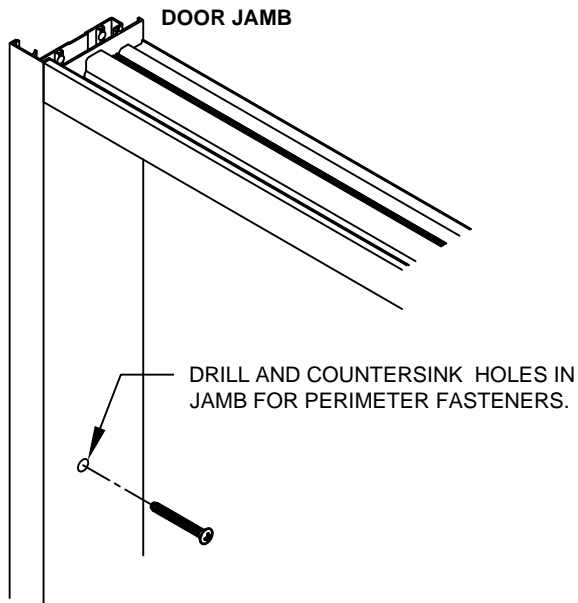
Place shim between (530301) pocket filler and perimeter condition at perimeter anchor locations.



PERIMETER FASTENERS AT DOOR JAMB

There are three options for anchoring the door jamb to the perimeter condition:

1. Drill and countersink holes in door jamb for perimeter fasteners.
2. Drill 1/2" counter bore holes in door jamb and insert hole plug (027633) after installation.
3. Counter bore holes in door jamb for perimeter fasteners, then install door stop, which will cover these holes.



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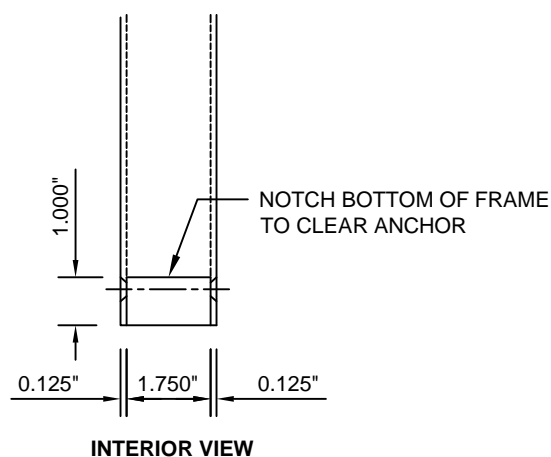
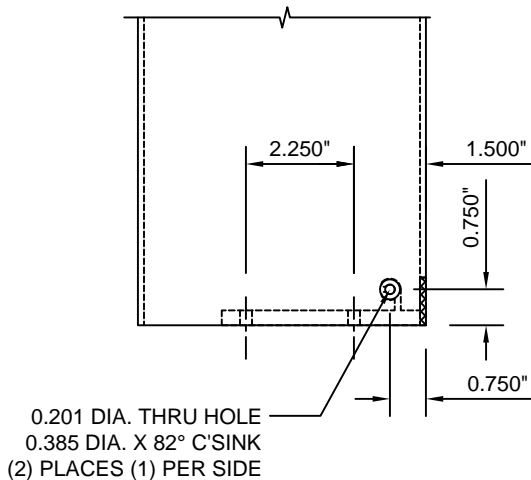
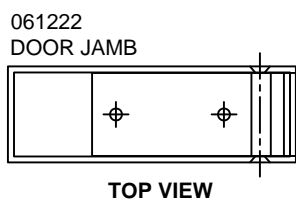
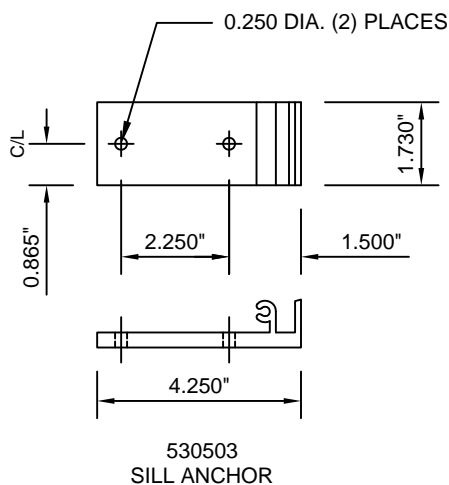
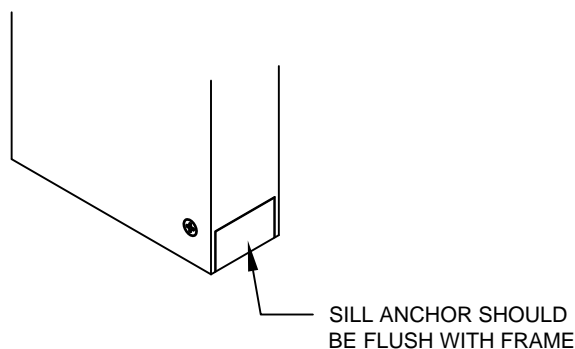
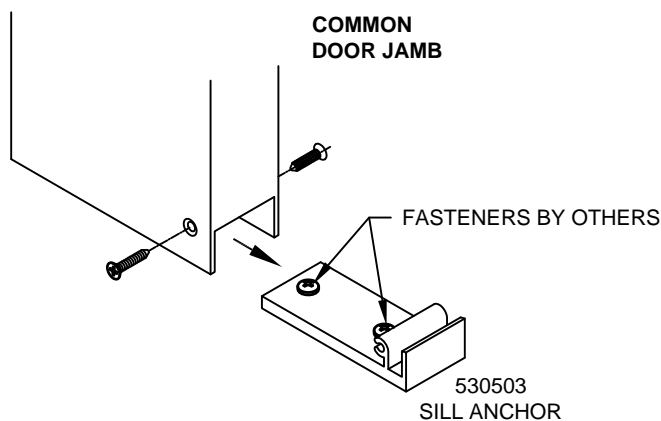
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COMMON DOOR JAMB INSTALLATION AT SILL ANCHOR

Locate sill anchor at centerline of common door jamb and install on floor.

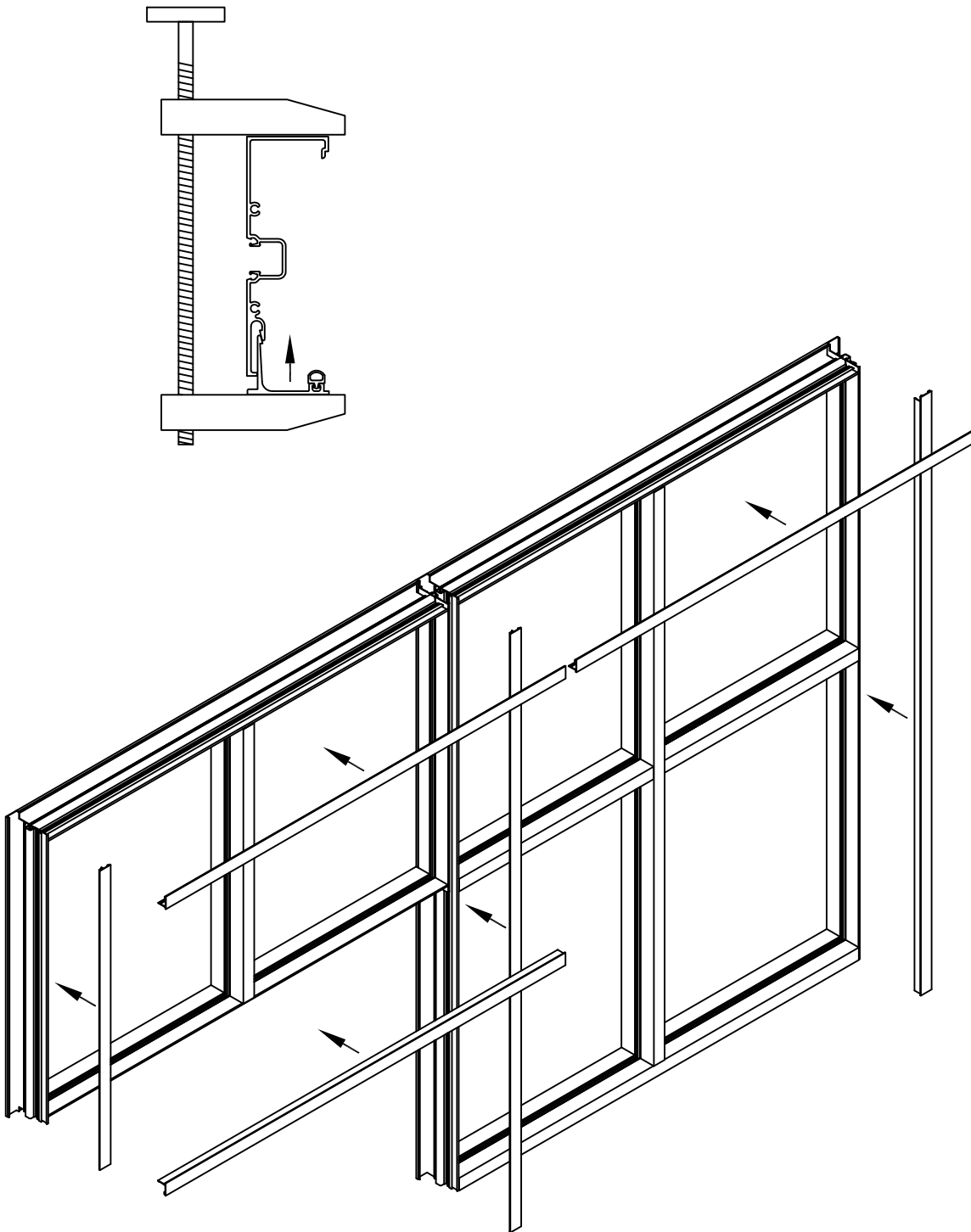
Slide bottom of door jamb over sill anchor, anchor should be flush with face of frame.

Fasten door jamb to anchor with flat head fasteners provided.



INSTALLATION OF INTERIOR SNAP-IN COVERS

1. Install vertical snap-in stops first then horizontal stops.
2. Insert leg of snap-in stop into frame, use a clamp to start and hold stop, using a wood or plastic clamp will prevent scratching the finish. Tap snap-in stop into place with a mallet and wood block.



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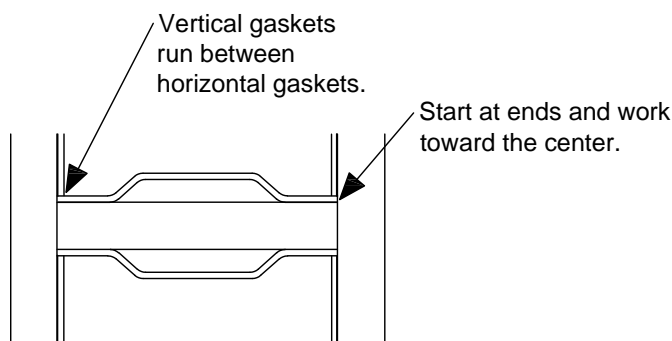
GASKET INSTALLATION

- 1: Cut horizontal and vertical gaskets to an approximate length of D.L.O. + 1/4" per foot of D.L.O..
- 2: Install gaskets on the side of frame **opposite** glass stop first.

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.

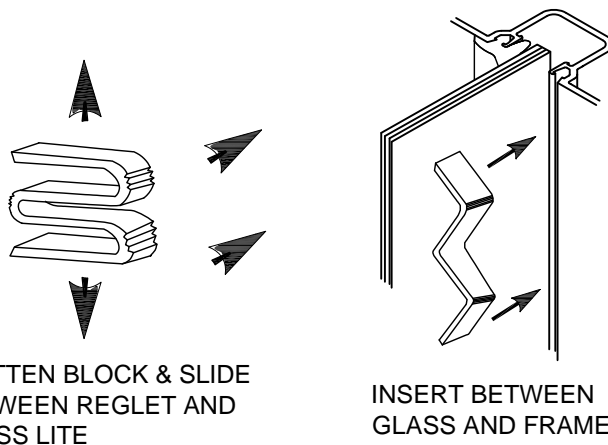
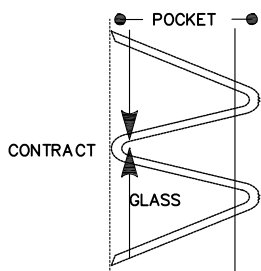
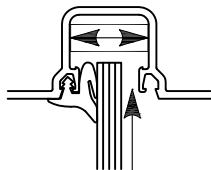
- 3: Position setting blocks at points under glass as required.
- 4: Install glass into frame using standard flush glazing technique.
- 5: Install horizontal and vertical gasket into **glass stop side** of frame in the same manner as described in Step #2.



(Figure 1)

"W" SIDE BLOCKS

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

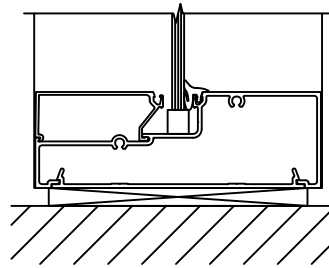
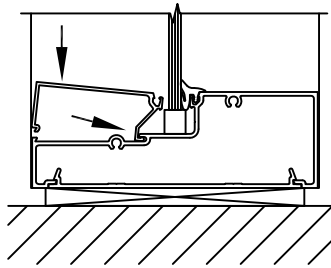
SIDE BLOCK INSTALLATION

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

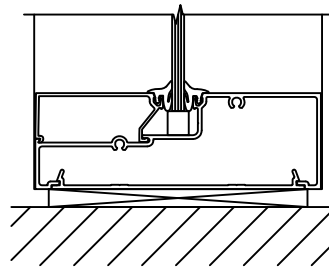
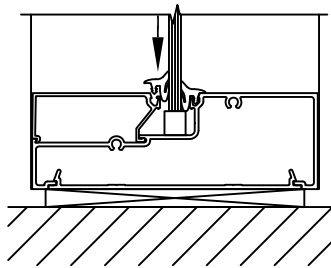
NOTE: If deglazing of lite is required after "W" Block is installed, remove both interior and exterior weathering and use hook to pull "W" Block out of pocket.

INSTALLATION OF SILL / HORIZONTAL GLASS STOP

1. Insert leg of glass stop into frame and push down to snap in place.

**INSTALLATION OF EXTERIOR GASKET**

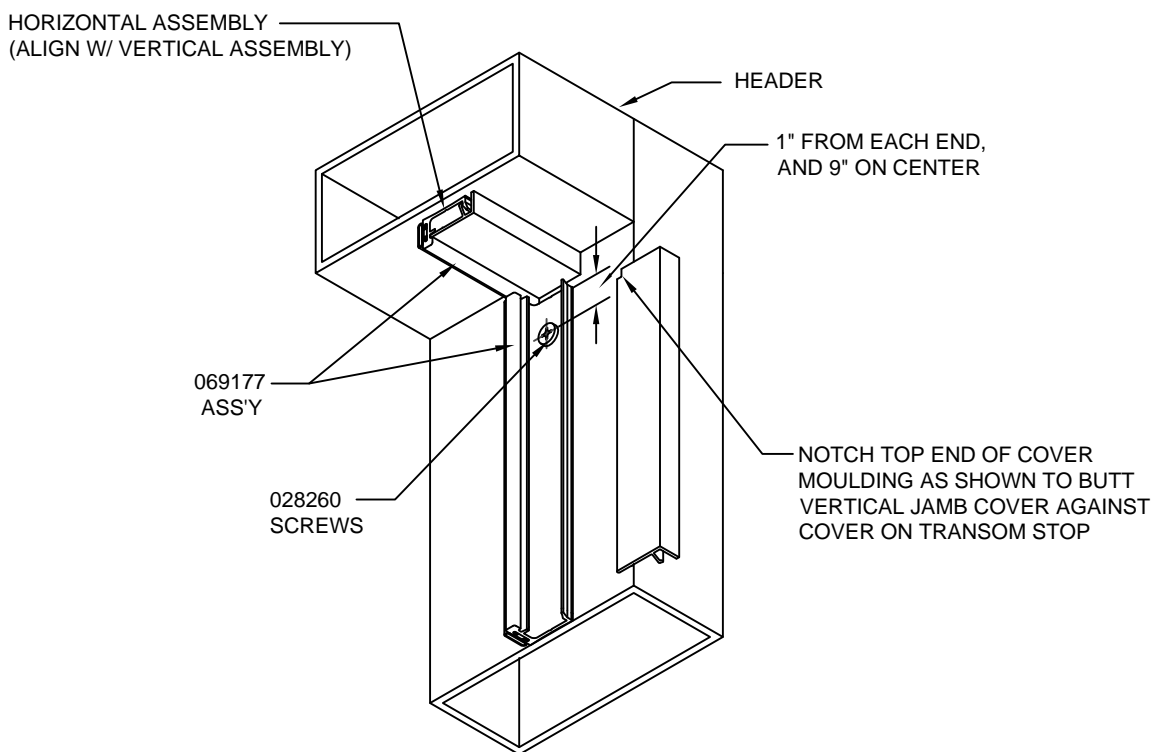
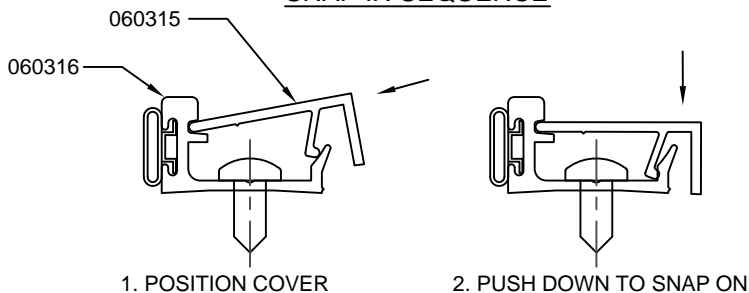
1. Install exterior gasket in same manner as the interior gasket.



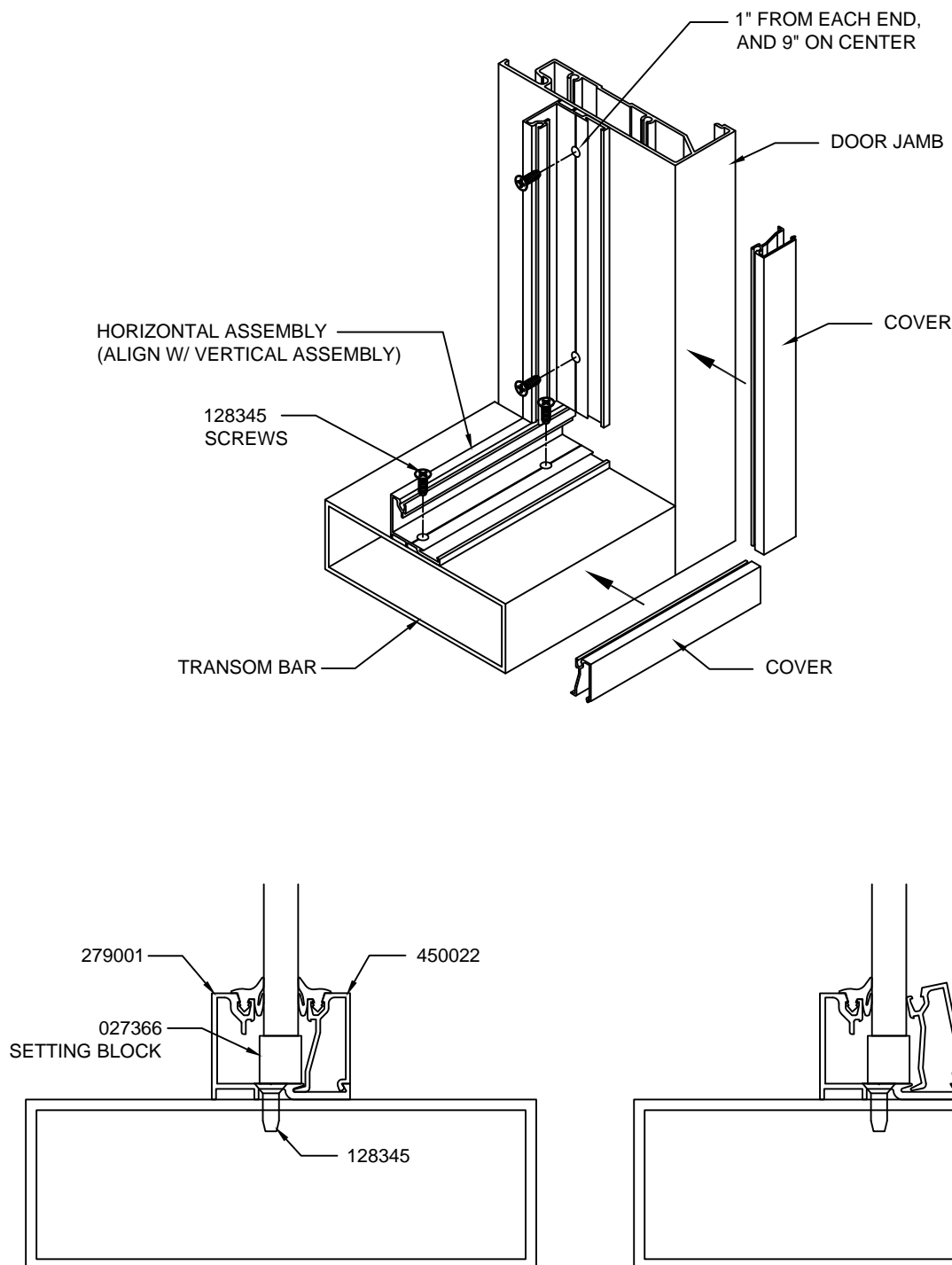
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DOOR STOP INSTALLATION**SNAP IN SEQUENCE**

THE COVER MOULDING, 060315, SHOULD BE SNAPPED INTO PLACE WITH HAND PRESSURE ONLY, USING CARE NOT TO DENT THE PART. IF DONE CAREFULLY, THE COVER CAN BE REMOVED AND REPLACED WITHOUT DAMAGE. LUBRICANT APPLIED TO THE LOCKING LEG OF THE BASE MOULDING WILL REDUCE ASSEMBLY FORCE.

TRANSOM STOP INSTALLATION**SNAP IN SEQUENCE**

THE COVER MOULDING, 450022, SHOULD BE SNAPPED INTO PLACE WITH HAND PRESSURE ONLY, USING CARE NOT TO DENT THE PART. IF DONE CAREFULLY, THE COVER CAN BE REMOVED AND REPLACED WITHOUT DAMAGE. LUBRICANT APPLIED TO THE LOCKING LEG OF THE BASE MOULDING WILL REDUCE ASSEMBLY FORCE.

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

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