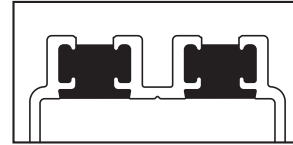


YES 45 XT High Performance Thermal Storefront System

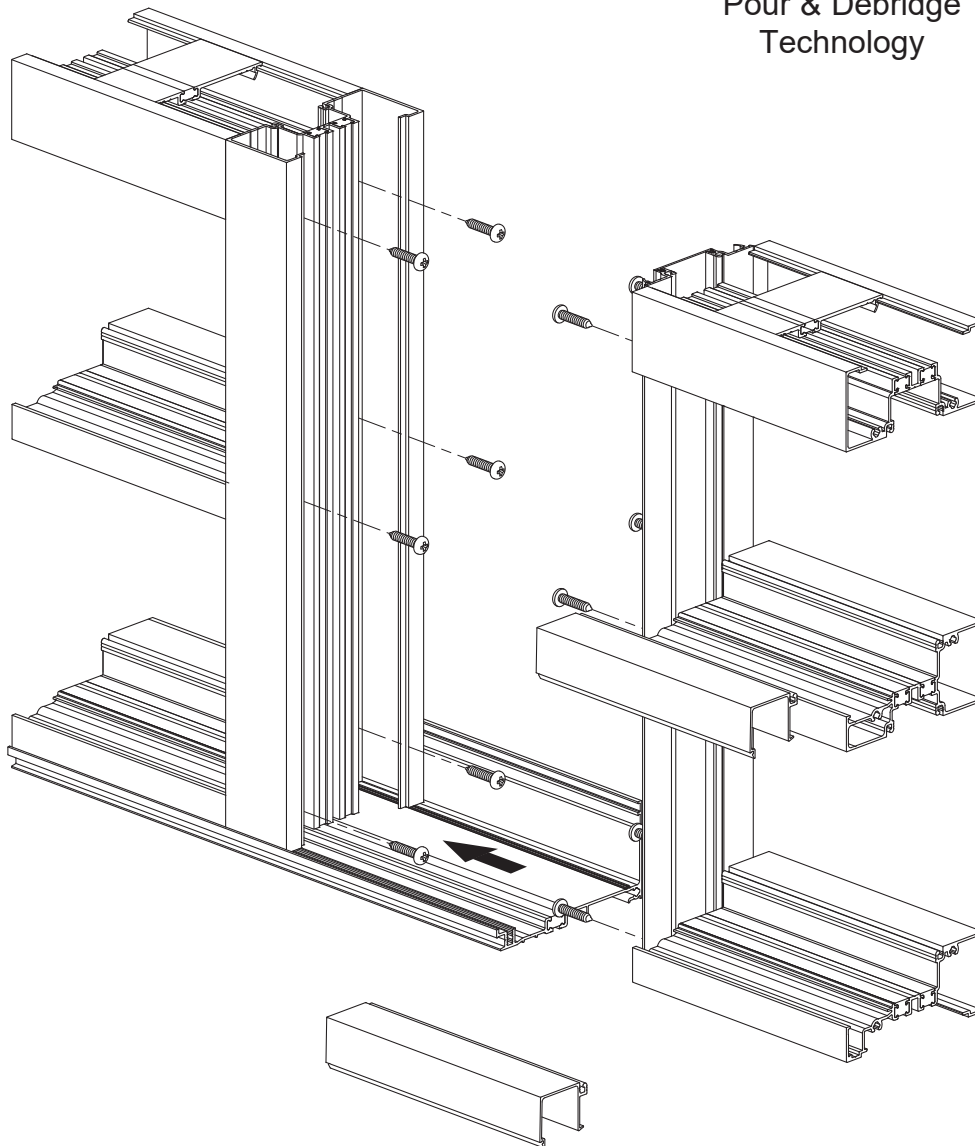


Dual Thermal Barrier



ThermaBond Plus[®]

Pour & Debridge
Technology



Installation Manual

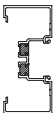



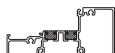

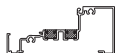
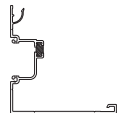

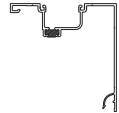

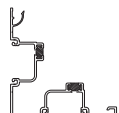
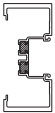
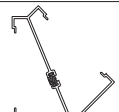

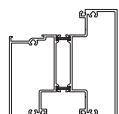






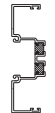

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Installation Notes






1. Do not drop, roll or drag boxes of aluminum framing. Move and stack boxes with proper support to prevent distortion. If fork lifts are used be especially careful about striking the boxes when lifting or moving.
2. Store in a dry, out of the way area. If rain exposure, condensation or any water contact is likely, then all packaging material should be removed. Wet packaging materials will discolor and may stain aluminum finishes and paints.
3. All materials should be checked for quality and quantity upon receipt, YKK AP must be notified immediately of any discrepancies in shipment. Check to make sure that you have the required shims, sealants, supplies and tools necessary for the installation.
4. Carefully check the openings and surrounding conditions that will receive your material. Remember, if the construction is not per the construction documents, it is your responsibility to notify the general contractor in writing. Any discrepancies must be brought to the general contractor's attention before you proceed with the installation.
5. Gather your shop drawings, materials, packing list, and this installation manual. Carefully review parts location, the sequence it goes therein, when you glaze it and how you seal it. Installation instructions are of a general nature and may not cover every condition you will encounter. The shop drawings and/or installation manuals were prepared specifically for the product.
6. Any material substitutions must be of equal or greater quality.
7. Make certain that material samples have been sent for compatibility testing for all manufacturer's sealants involved. Make certain sealants have been installed in strict accordance with the manufacturer's recommendations and specifications.
8. Remember to isolate, in an approved manner, all aluminum from uncured masonry or other incompatible materials.
9. System-to-structure fasteners are not supplied by YKK AP. Fasteners called out on shop drawings are to indicate minimum sizes for design loading.
10. Entrances are to be installed plumb, square, level and true.
11. Please contact the YKK AP DirecTech application engineering department for any project specific condition not covered by these instructions.
12. YKK AP storefront and/or curtain wall framing is typically completed before drywall, flooring and other products which may still be in process. Take the extra time to wrap and protect the installed material.
13. Cutting tolerances are plus zero (0"), minus one thirty second (-1/32") unless otherwise noted.
14. Check our website, www.ykkap.com, for the latest installation manual update prior to commencing work.

YES 45 XT FRAMING MEMBERS (2" x 4-1/2")









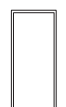




| | | | | | |
|---|--|-----------------|--|--|-----------------|
|  | Vertical / Jamb | BE9-2601 |  | Expansion Mullion (Male) | BE9-2608 |
|  | Head - Outside Glazing | BE9-2602 |  | Hinged Mullion (Male) | BE9-2557 |
|  | Horizontal | BE9-2603 |  | Hinged Mullion (Female) | BE9-2558 |
|  | Sill - Inside & Outside Glazing Head - Inside Glazing | BE9-2604 |  | 90° Corner Mullion | BE9-2566 |
|  | Glass Stop | E9-1015 |  | 90° Corner Mullion | BE9-2567 |
|  | Sill Flashing | BE9-2578 |  | 3-Way Corner Mullion | BE9-2568 |
|  | Heavy Duty Vertical Mullion | BE9-2606 |  | 135° Corner Mullion | BE9-2569 |
|  | Pocket Filler | BE9-2605 |  | 4-1/2" Horizontal/Sill | BE9-1513 |
|  | Head Receptor | BE9-2562 |  | Glazing Adaptor For 1/4" glazing | E9-1040 |
|  | Head Receptor Stop | E9-1033 |  | Adaptor for High Sill | BY7-9478 |
|  | Deep Pocket Filler | BE9-2609 |  | 2-1/2" x 3/4" Face Cover * For Custom Mullions and Horizontals | E9-1206 |
|  | Expansion Mullion (Female) | BE9-2607 |  | 5" x 3/4" Face Cover * For Custom Mullions and Horizontals | E9-3542 |

* Other sizes available. Contact YKK AP for more information.

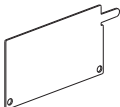

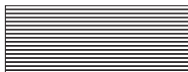

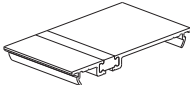

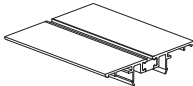

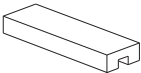

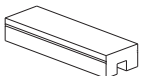

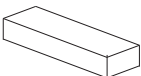

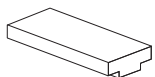







THERMAL DOOR FRAMING MEMBERS

| | | | | | |
|---|--|-----------------|---|---|-----------------|
|  | Single Acting Door Jamb Elastomer weathering E2-0051 included | AS-1530 |  | Transom Glass Stop For 1" glazing | E9-1592 |
|  | Single Acting Door Head/Transom Bar Elastomer weathering E2-0062 included | AS-1532 |  | Transom Glazing Pocket For 1" glazing | BE9-1591 |
|  | Threshold 1/2" x 4" | BE9-1535 | | | |

NON-THERMAL DOOR FRAMING MEMBERS

| | | | | | |
|---|---|----------------|---|--|----------------|
|  | Single Acting Door Jamb Elastomer weathering E2-0051 included | AS-0411 |  | Transom Glass Stop For 1/4" glazing | E9-0403 |
|  | Single Acting Door Head/Transom Bar Elastomer weathering E2-0051 included | AS-0412 |  | Transom Glass Stop For 1" glazing | E9-0413 |
|  | Double Acting Door Jamb | E9-0415 |  | Transom Glazing Pocket For 1/4" glazing | E9-0434 |
|  | Double Acting Door Head/Transom Bar Pile weathering E2-0062 included | AS-0426 |  | Transom Glazing Pocket For 1" glazing | E9-0435 |
|  | Intermediate Door Jamb 2" x 4-1/2" Tube Use with AS-0401 | E9-9312 |  | Sash Base Use with E9-0403 or E9-0413 glass stops | E9-0408 |
|  | Deep Pocket Filler Use with door jambs | E9-1019 |  | Threshold 1/2" x 4" | E9-0407 |
|  | Door Stop Assembly E9-0409 (mill) & E9-1113 Elastomer weathering E2-0051 included | AS-0401 | | | |

YES 45 XT ACCESSORIES

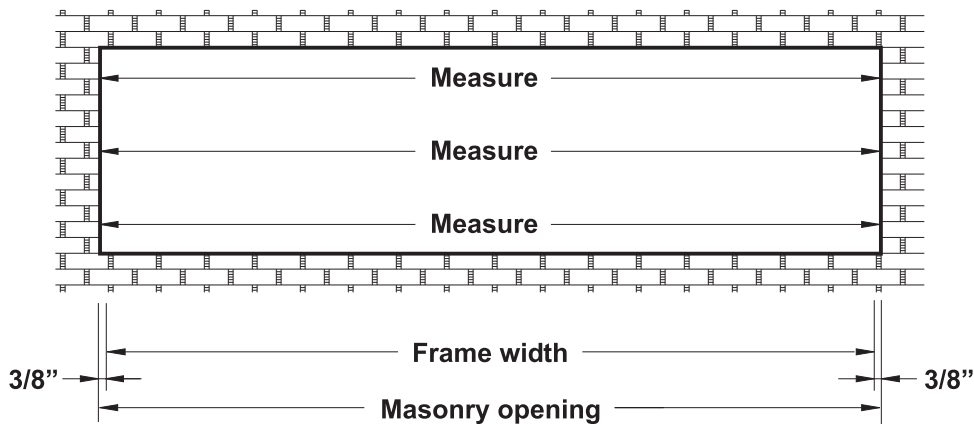
| | | | | | |
|---|--|----------------|---|--|-------------------|
|  | End Dam For Sill Flashing BE9-2578 | E1-0199 |  | Pile Weathering Seal | E2-0062 |
|  | Splice Sleeve For Sill Flashing BE9-2578 | E2-0070 |  | Glazing Gasket | E2-0052 |
|  | Flat Filler Use at all anchor locations | E1-2601 |  | Glazing Gasket | E2-0053 |
|  | Sidelite Base Clip For compound horizon- tals, 4" Long | E1-9836 |  | Glazing Gasket | E2-0064 |
|  | Setting Block For Outside Glazed Horizontal & Sill | E2-0020 |  | Elastomer Weathering For Head Receptor & Door Frame | E2-0051 |
|  | Setting Block For 4-1/2" Horizontal | E2-0068 |  | Weathering Gasket For Expansion Mullion | K2-2441 |
|  | Setting Block For Inside Glazed Intermediate Horizontal | E1-0611 |  | #10-24 x 1/2" PHMS Stainless Steel For Attachment of Sill to Sill Flashing | PM-1008-SS |
|  | Setting Block For 1" Glazing of Transom Head | E2-0056 |  | #10-24 x 7/16" PHMS Stainless Steel For Attachment of 4-1/2" Sill to Sill Flashing | PM-1007-SS |
|  | Water Deflector | E2-0047 |  | #12 x 3/4" UFHSMS Type A Zinc Plated Steel For End Dam Attachment | UA-1212 |
|  | "W" Side Block For Deep Pocket | E2-0153 |  | #12 x 1" PHSMS Type AB Zinc Plated Steel For Screw Spline Attachment | PC-1216 |
|  | PVC Flat Filler | E3-0023 |  | #12 x 1-1/4" PHSMS Type AB Zinc Plated Steel For Screw Spline Attachment when using BE9-2602 as Vertical | PC-1220 |

FRAME FABRICATION

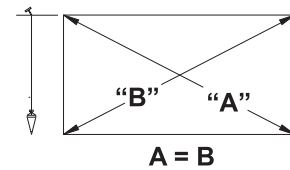
STEP 1

DETERMINE FRAME SIZE

Determine Frame Width:



Note: Check the opening for squareness and plumb at both ends. Units must be installed in a true rectangle.



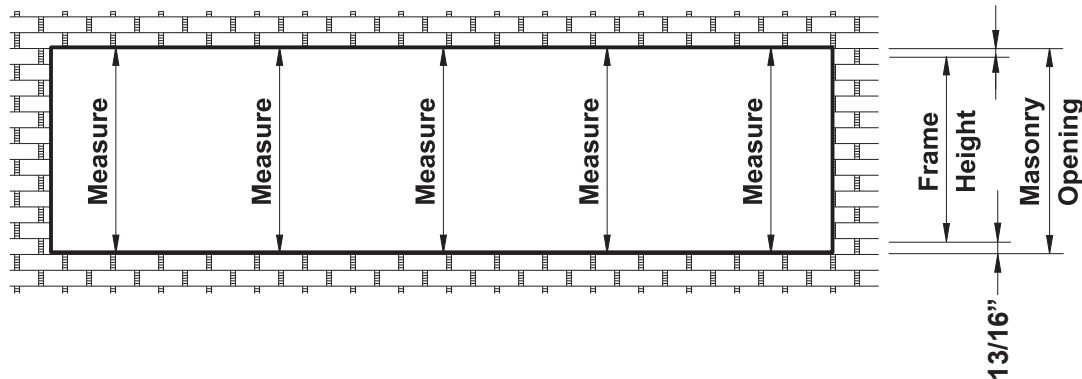
Detail 1

- Measure the width of the masonry opening at the top, middle and bottom.
- Select the smallest dimension measured and subtract 3/4" to the determine the frame width to be used.

See **Detail 1**.

NOTE: Frame widths over 24'-0" require expansion mullions every 12 to 15 feet (best location at vertical next to the door jamb.)

Determine Frame Height:



Detail 2

- Measure the height of the masonry opening in several places along the entire length of the opening.
- Select the smallest dimension measured and subtract 1-3/16" to determine the frame height to be used:

3/8" shim/caulk joint at the head.

7/16" for sill flashing.

3/8" shim/caulk joint below the sill flashing.

See **Detail 2**.

FRAME FABRICATION

STEP 2

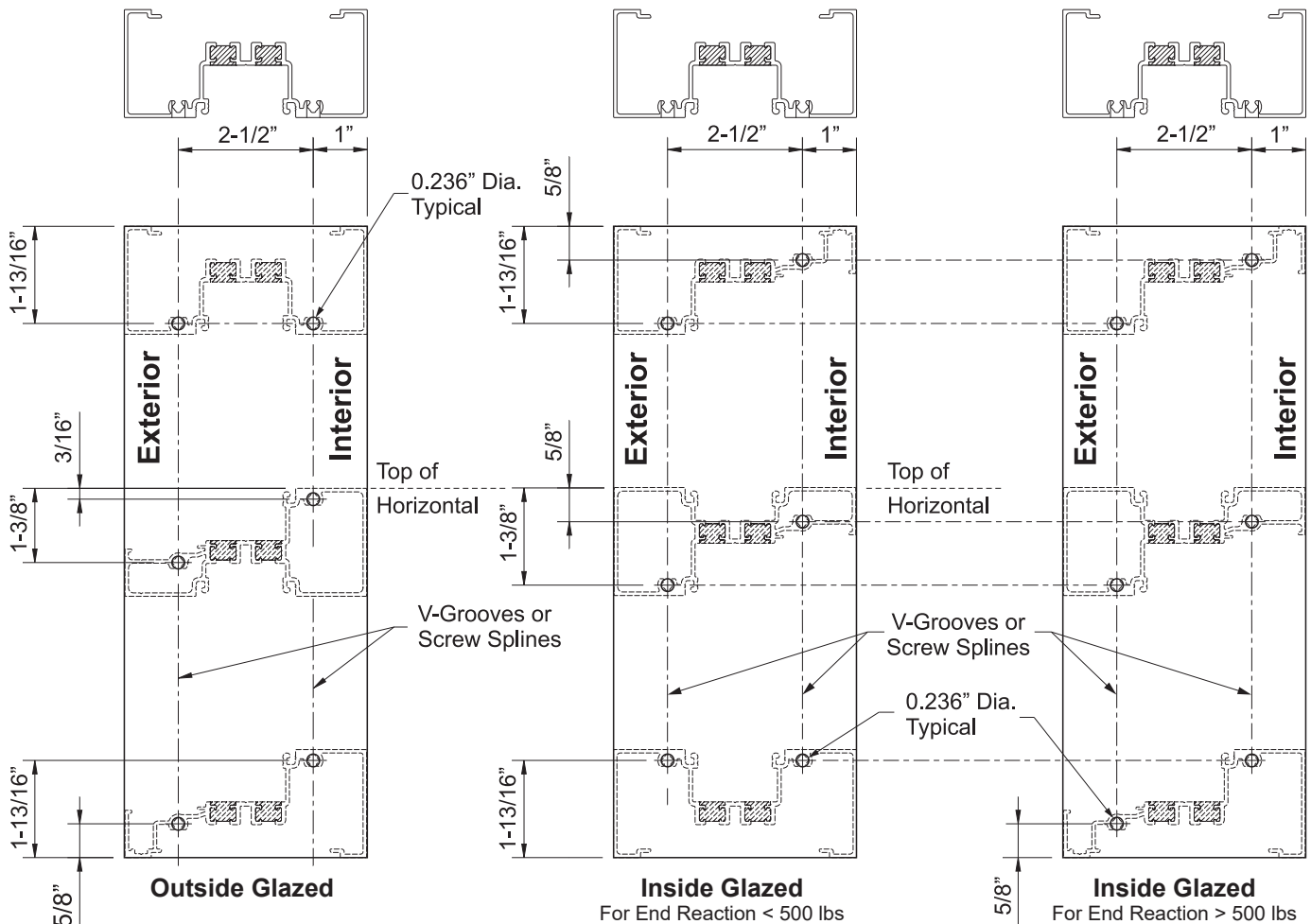
FABRICATE TWO PIECE VERTICALS

- Cut the two piece vertical and jamb members to the frame height determined in Step 1.
- Fabricate holes in vertical members for screw spline attachment using one of the methods below:

1. Using a short piece of each horizontal member as a template, center the template on the face of the vertical and mark the location of each screw spline. Drill a 0.236" diameter (#B drill bit) hole at each location marked.
2. Layout the hole locations as shown in **Detail 3** and drill a 0.236" dia. (#B drill bit) clearance hole at each location marked.
3. Use the YKK AP drill fixture, H-7201, to drill the holes.
4. Use punch press with appropriate die set.

Note: End reaction = $\frac{\text{Frame Height (ft)} \times \text{Mullion Spacing (ft)} \times \text{Wind Load (PSF)}}{2}$

or consult YKK AP DirecTech.



Detail 3

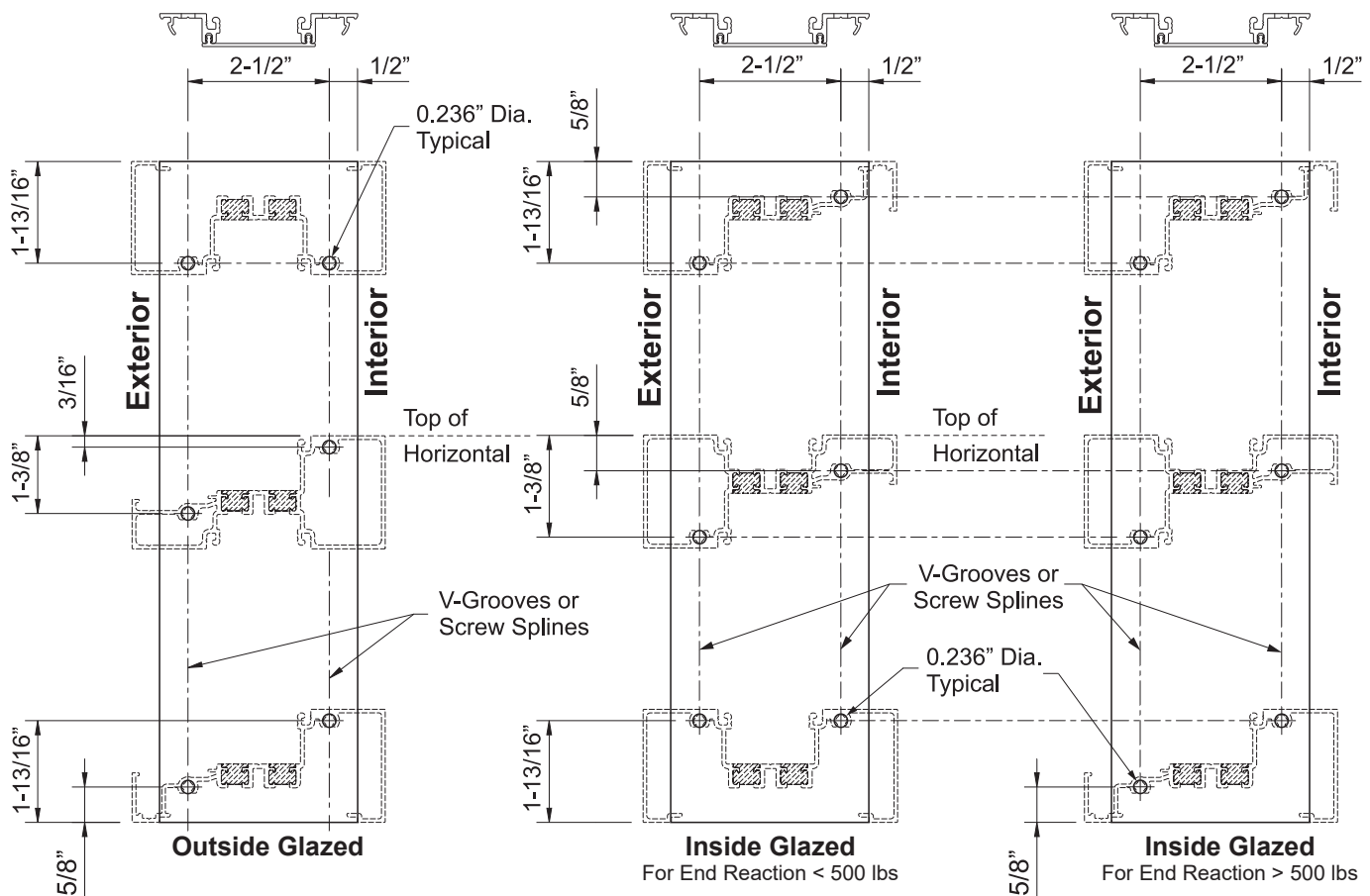
FRAME FABRICATION

STEP 2 (Continued)

FABRICATE TWO PIECE VERTICALS

-Fabrication of shallow pocket filler is similar to that of the mullions.

See **Detail 4**.



Detail 4

FRAME FABRICATION

STEP 3

FABRICATE HEAD, HORIZONTAL & SILL MEMBERS

-Cut head, horizontal, and sill members to the daylight opening (D.L.O.) as indicated on the shop drawings.

STEP 4

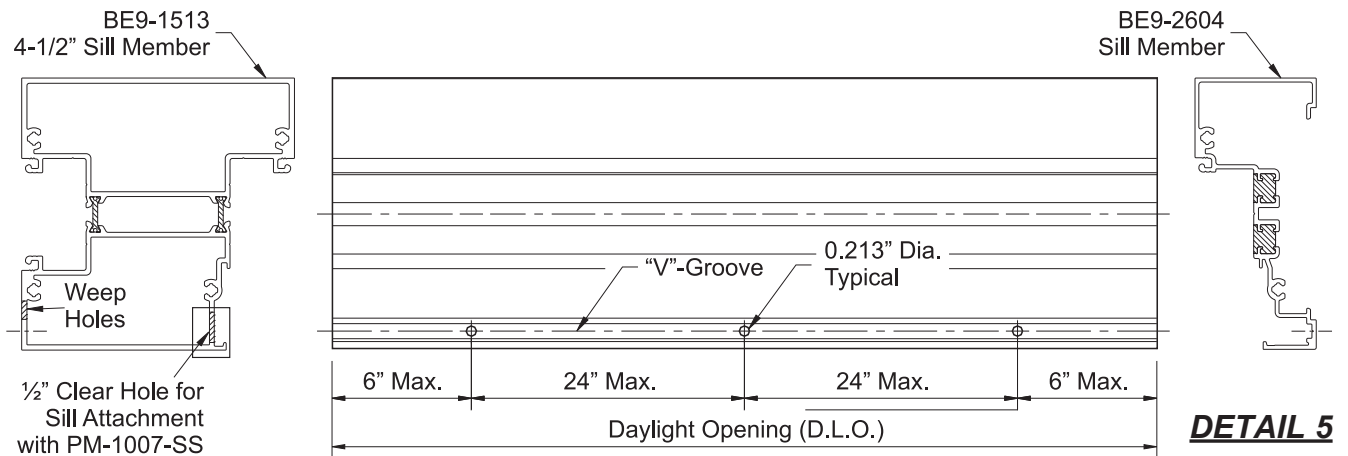
FABRICATE GLASS STOPS & GLAZING ADAPTORS

-Cut glass stops to the same dimensions as their respective horizontals minus(-) 1/32".
-Cut glazing adaptors to the daylight opening minus(-) 1/32".

STEP 5

FABRICATE SILL MEMBERS

-Cut sill members to the daylight opening dimension between verticals.
-For end reactions over 500 lbs., fabricate sill members for anchoring to sill flashing:
-Measure in 6" from each end of the sill member and mark hole locations along the "V"-groove as shown in **Detail 5**.
-Mark additional hole locations a maximum of 24" on center (O.C.).
-Drill a 0.213" diameter (#3 drill bit) hole at each location marked.
-For BE9-1513 4-1/2" sill, a 0.5" clear hole is required at sill anchor locations.
-For BE9-1513 4-1/2" sill, weep holes are required at 1/3 points of each horizontal member.
-If end reaction is under 500 lbs., one (1) .213" dia. weep hole is required at the center of each daylight opening. See **Detail 5**.



STEP 6

FABRICATE SILL FLASHING

For elevations without door framing:

-Cut sill flashing, BE9-2578 to the end of the frame plus (+) 1/4". See **Detail 6 & 7**.

For elevations with door framing:

-Cut the sill flashing from the end of the frame to the door jamb + 1/8".

(See approved shop drawings for this dimension)

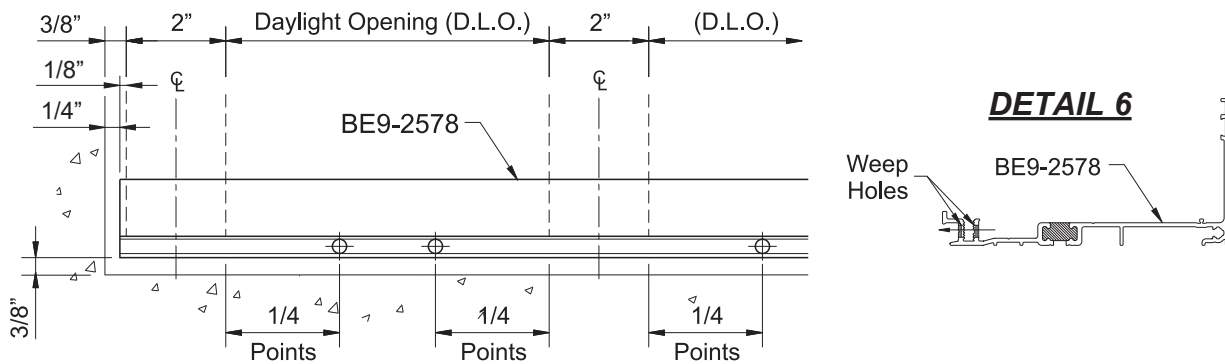
See **Detail 8**.

FRAME FABRICATION

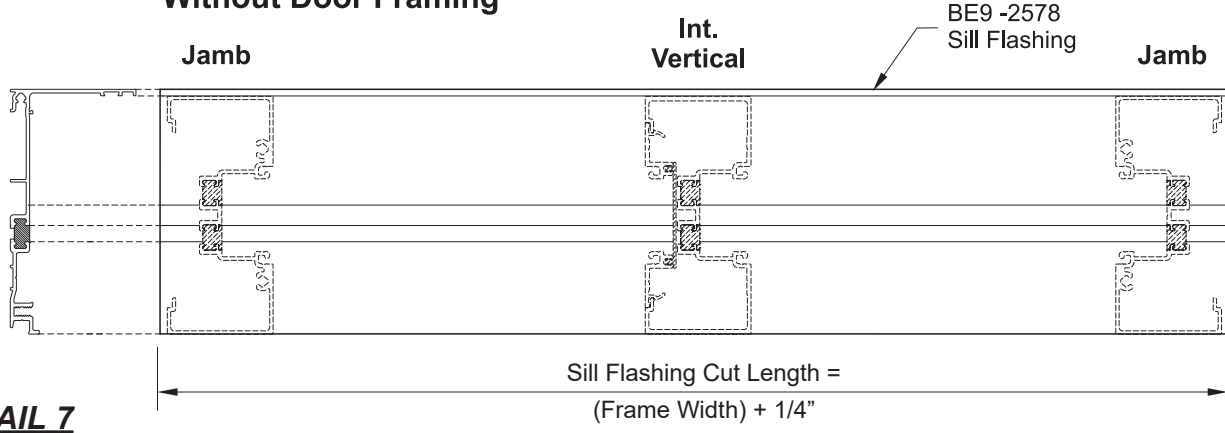
**STEP 6 (Cont'd)
FABRICATE SILL FLASHING**

-Drill 5/16" diameter weep holes in the front of the sill flashing at the quarter points of each D.L.O.

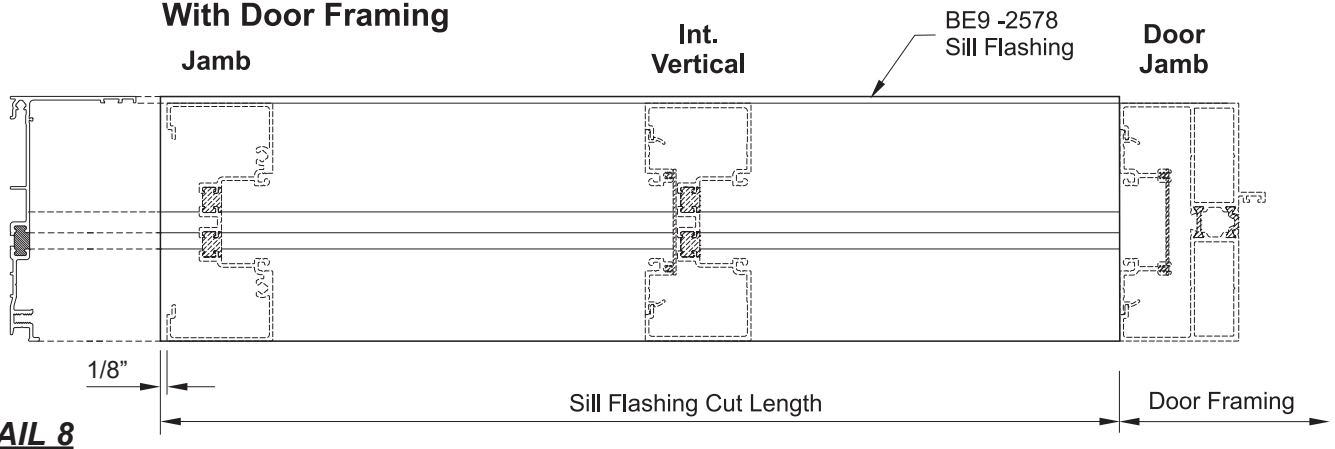
See **Detail 6**.



Without Door Framing



With Door Framing

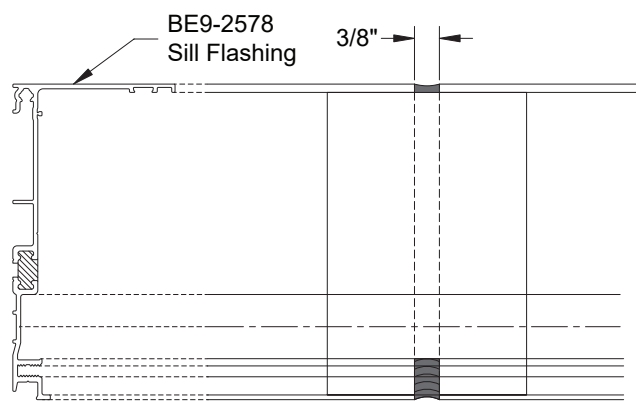


FRAME FABRICATION

STEP 6 (Continued) FABRICATE SILL FLASHING

- For openings longer than 24'-0" the sill flashing needs to be spliced every twelve to fifteen feet at the center of a D.L.O.
- Allow for a 3/8" joint for expansion between sill flashing members.

See **Detail 9**.



DETAIL 9

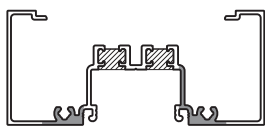
FRAME ASSEMBLY

STEP 7 ASSEMBLE FRAMES

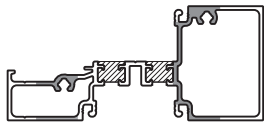
Screw Spline Assembly:

- Clean all joint surfaces using cleaner approved by sealant manufacturer.
- Apply (butter) sealant to both ends of head, horizontal and sill members just prior to assembly.
- Apply sealant to the vertical up 6" from the sill.
- Attach head, horizontal and sill members to vertical members with two (2) PC-1216 fasteners at each end.
- Tool the sealant into the joints and wipe away any excess sealant.

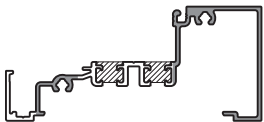
See **Detail 10**.



HEAD
BE9-2602

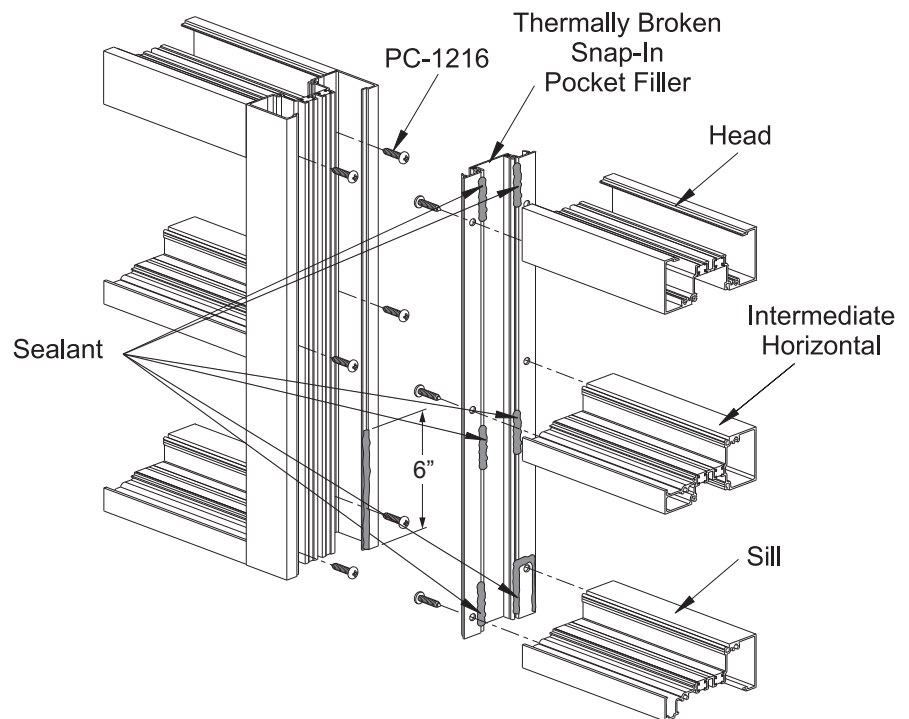


HORIZONTAL
BE9-2603



SILL
BE9-2604

Apply sealant to
the shaded areas
at each end.



DETAIL 10

CAUTION: Always assemble frames such that each lite of glass will have a minimum of one deep vertical glazing pocket.

FRAME INSTALLATION

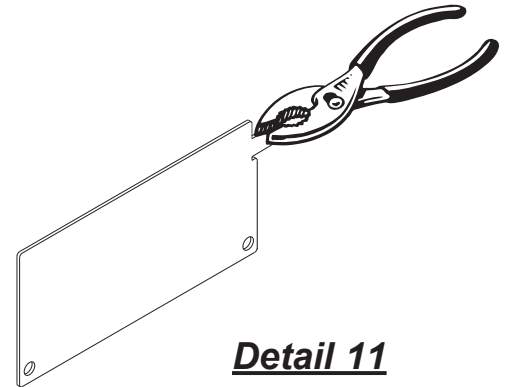
STEP 8 INSTALL SILL FLASHING END DAMS

- Hold the end dam with one hand and grab the tab with a pair of pliers.
- Bend the end dam left or right 90 degrees in the proper direction.

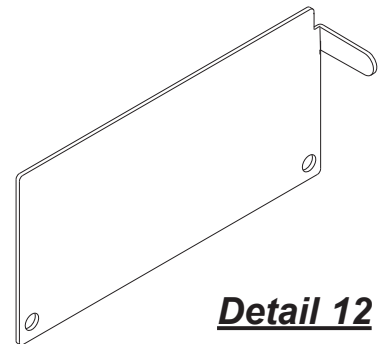
See **Detail 11**.

Note: The dam must be bent in the correct position for the left or right end of the sill flashing.

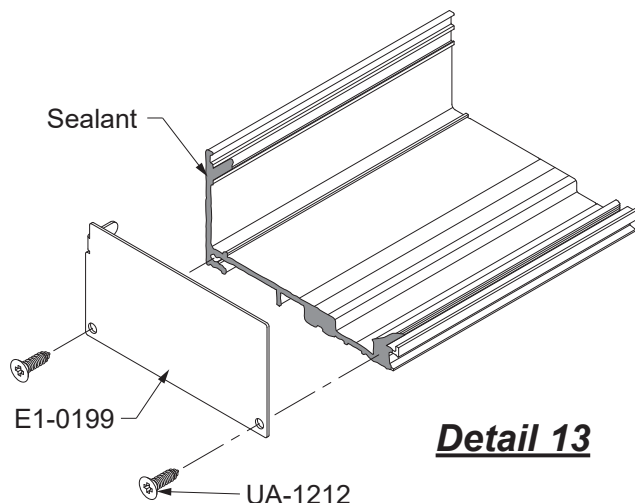
- Clean all joint surfaces using cleaner approved by sealant manufacturer.
- Apply silicone sealant to the end of the sill flashing as shown in **Detail 12**.
- Slide the tab into the top portion of the sill flashing.
- Tap the tab into place with a small tool until the end dam is snug against the end cut of the flashing.
- Fasten the end dam to the sill flashing with two UA-1212 screws, starting at the back, followed by the front as shown in **Detail 13**.
- Tool sealant along the joint between the end dam and the sill flashing as shown in **Detail 14**.
- Seal over any exposed screw threads.



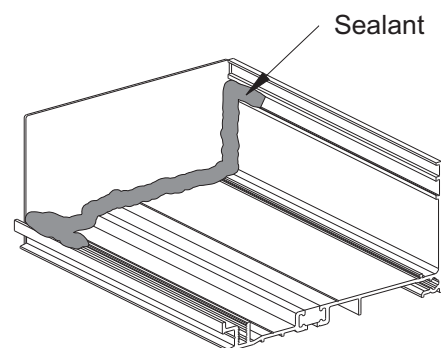
Detail 11



Detail 12



Detail 13



Detail 14

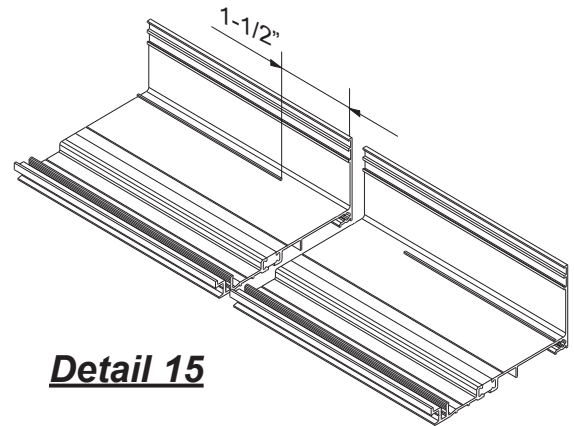
FRAME INSTALLATION

STEP 9 INSTALL SILL FLASHING

- Starting at the smallest opening height, install the sill flashing with a minimum of 3/8" shim underneath. Sill flashing must be installed level.
- Anchor the sill flashing to the structure a maximum of 4" from each end and then 18" to 24" on center.
- Apply and tool sealant to cover the heads of all fasteners.

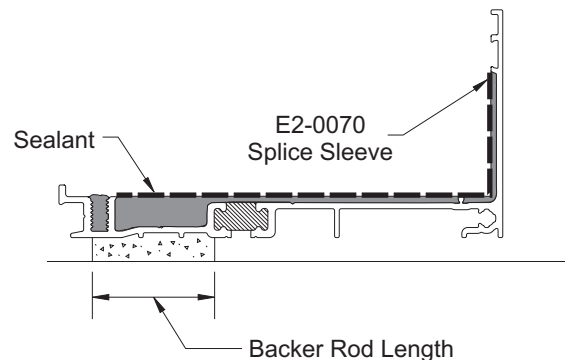
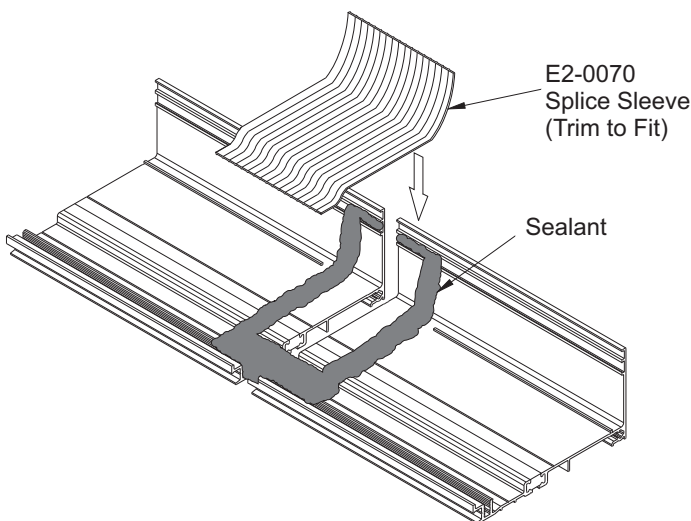
STEP 10 INSTALL SILL FLASHING SPLICE SLEEVE

- Remove the nub with a chisel or needle nose pliers a minimum length of 1-1/2" as shown in **Detail 15**.
- After the sill flashing has been shimmed and installed to the building structure, apply a small backer rod under the sill flashing as shown in **Detail 16**.
- Position the Silicone Splice Sleeve against the back wall below the groove.
- Bend the Silicone Splice Sleeve into the front on the channel as shown. Mark, and cut the sleeve at this position.
- Clean Sill Flashing and Silicone Splice Sleeve with isopropyl alcohol at the splice location
- Seal the flashing at the splice location as shown in **Detail 17**, before positioning the flashing. Set the Silicone Splice Sleeve into the sealant.
- Tool sealant tight as shown in **Detail 17**, squeezing the sheet flat.



Detail 15

When using E2-0070 splice sleeve, a compatible Silicone Sealant must be used at the splice. Compatible Silicone Sealants include Tremco® Spectrum 2 and Dow Corning® 795.



Detail 16

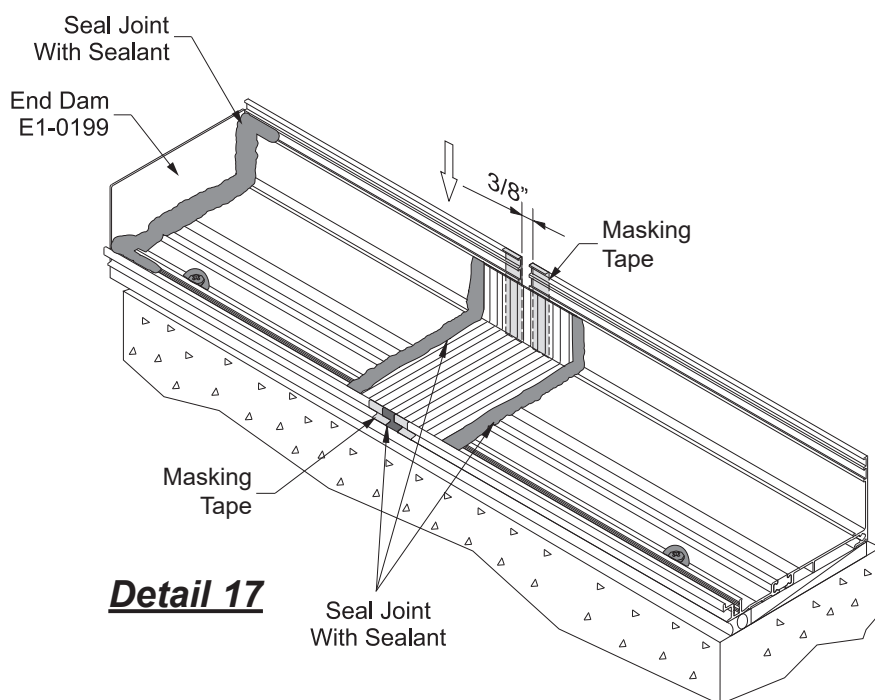
FRAME INSTALLATION

STEP 10

INSTALL SILL FLASHING SPLICE SLEEVE (Continued)

-Apply masking tape to the back of the sill flashing at the splice and at the front as shown in **Detail 17**.

-Thoroughly seal the small joint directly in front of the Silicone Splice Sleeve. Carefully remove masking tape from the front gap before the sealant skins over.



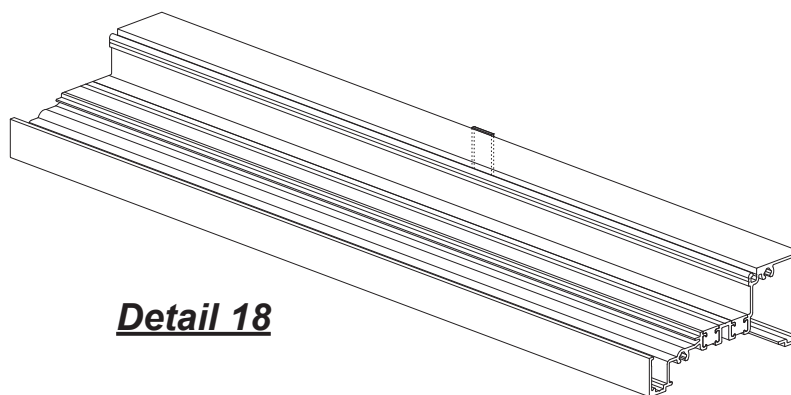
Detail 17

STEP 11

SILL PREPARATION

At every splice condition, apply bond breaker tape to the back of the sill member before the joint is sealed between the sill and sill flashing.

See **Detail 18**.



Detail 18

FRAME INSTALLATION

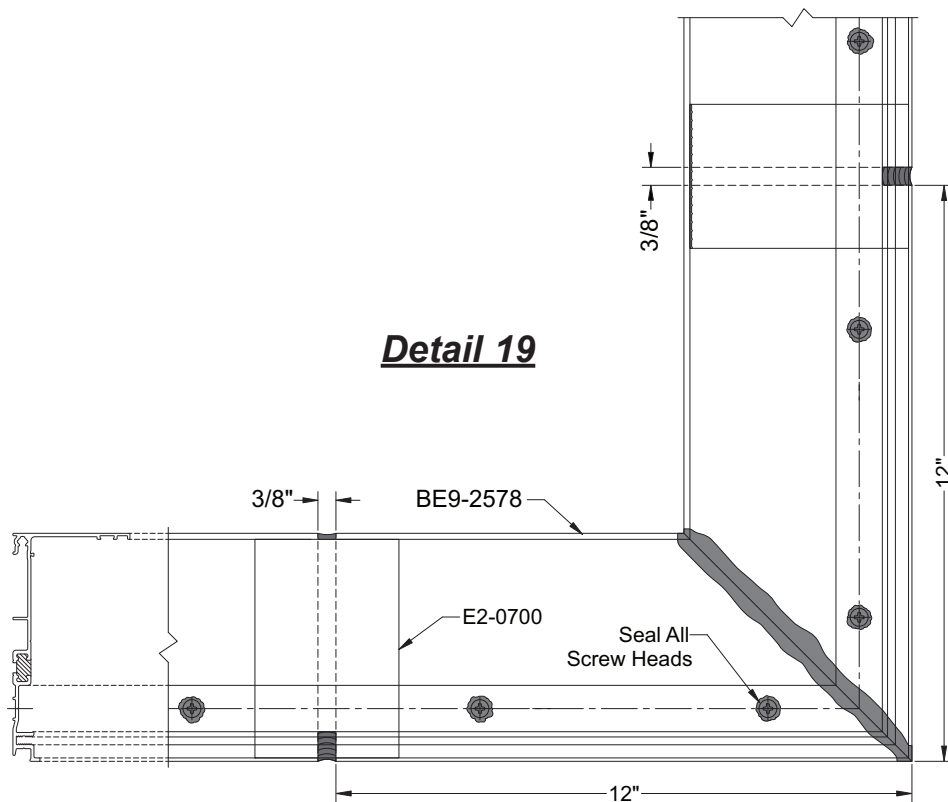
STEP 12

FABRICATE/INSTALL SILL FLASHING FOR CORNERS

- Cut two 12" long pieces of sill flashing BE9-2578 and miter (45° for 90° corners and 67.5° for 135° corners).
- Align the two pieces at the corner condition with the mitered ends pushed together tight and anchor the sill flashing as called out on shop drawings.
- Apply and tool sealant to the mitered joint and anchor heads.

See **Detail 19**.

- Continue installing the rest of the sill flashing providing a 3/8" expansion joint at splices as shown in **Step 10** on **Page 12**.



FRAME INSTALLATION

STEP 13

PREPARE DOOR JAMBS

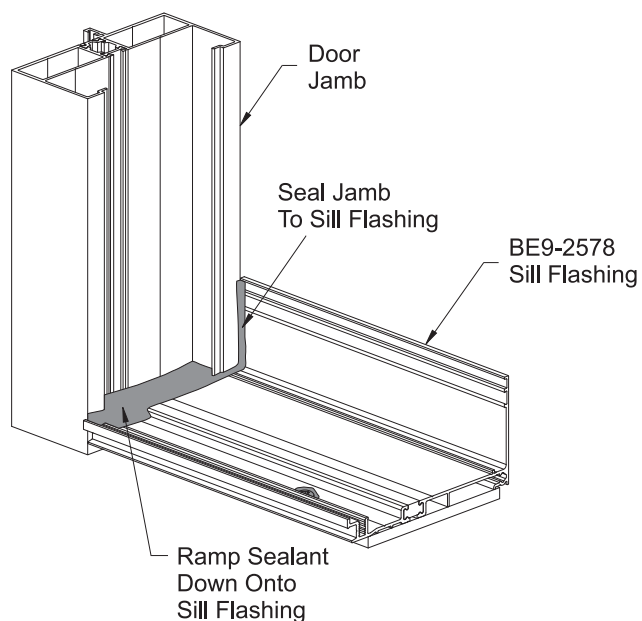
Prior to snapping the assembled frames into the door jamb, the end of the sill flashing needs to be sealed to the door jamb.

-Apply and tool sealant to all sill flashing to door jamb joints.

-Apply sealant to completely fill the door jamb cavity and ramp the sealant down onto the sill flashing.

See **Detail 20**.

Refer to the **Entrances Installation Manual** for door installation instructions.



Detail 20

FRAME INSTALLATION

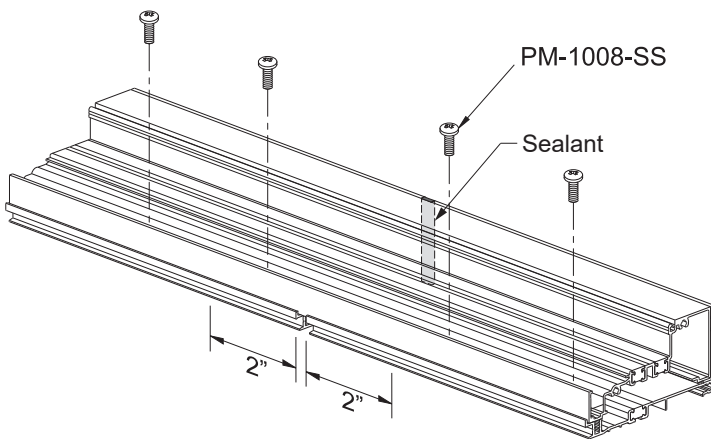
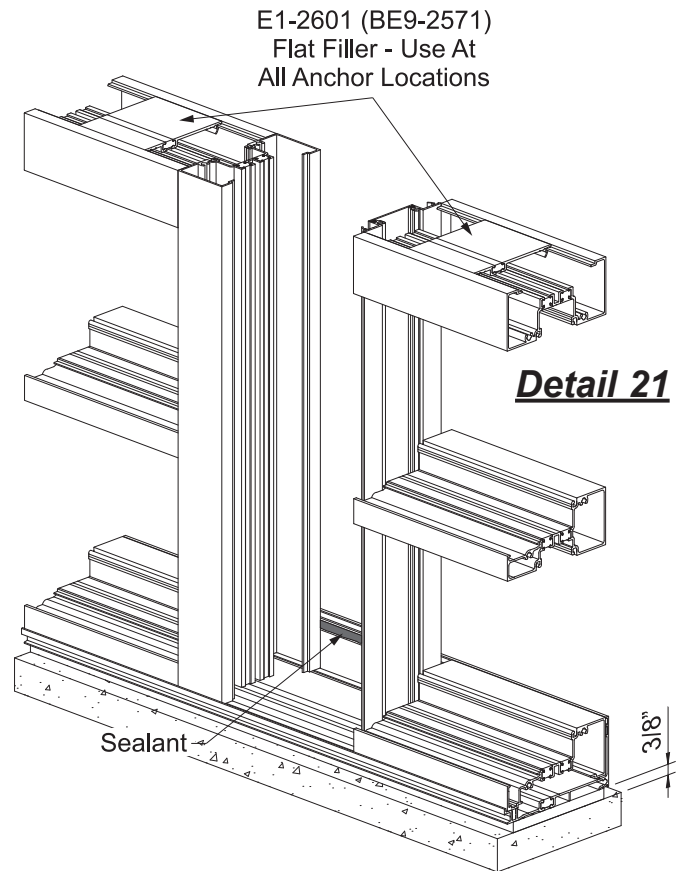
**STEP 14
INSTALL FRAMES**

- Snap in flat fillers, E1-2601, or PVC flat filler E3-0023 at head, jamb, and sill anchor locations.
- Snap assembled frames together if using screw spline assembly.
- Apply sealant continuously to the front of the back leg of the sill flashing and immediately set the frame into the opening.

See **Detail 21**.

- Shim jamb and head members with a minimum of 3/8" shim.
- Anchor the frame to the structure at the sill*, head, and jamb: 3" from the ends and then 18" to 24" on center.
- Seal all perimeter anchors at head and jamb. Do not seal the anchor that attaches the sill to the sill flashing.

Note: Use only flat head fasteners at head and jamb conditions.



Detail 22

- For end load reactions over 500 lbs., attach the sill to the sill flashing using PM-1008-SS screws.

- Additionally, add one (1) PM-1008-SS fastener 2" in both directions from the centerline of the splice.

- Apply and tool sealant to the gap in the back of the sill flashing splice. Carefully remove the masking tape before the sealant skins over.

See **Detail 22**.

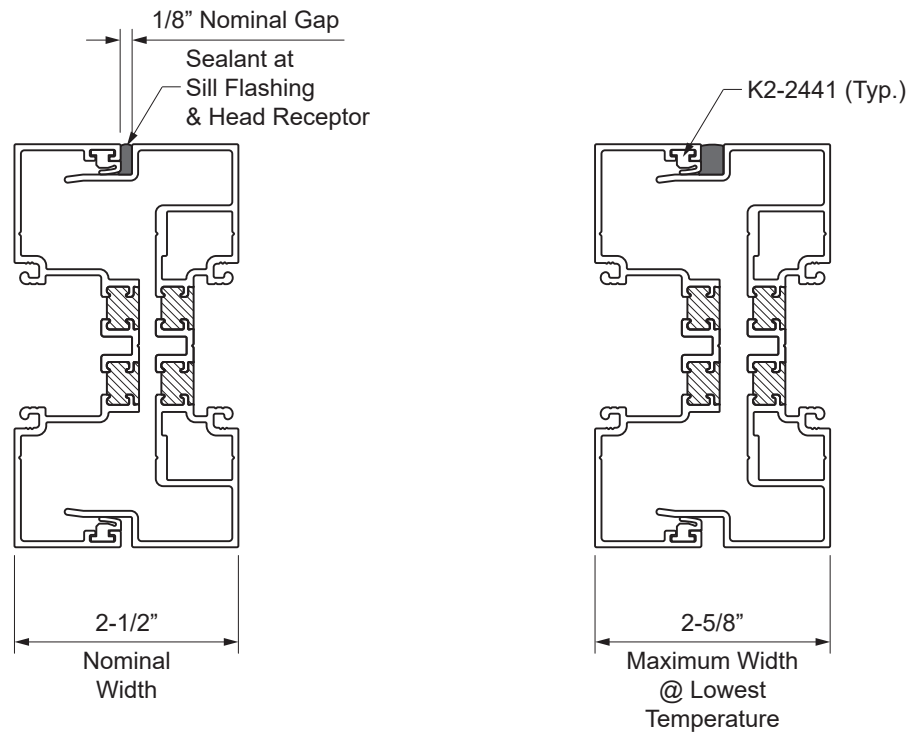
FRAME INSTALLATION

STEP 14 (Continued)

INSTALL EXPANSION MULLIONS WHERE REQUIRED

- Expansion mullions require the K2-2441 weathering gasket in both front and rear reglets.
- During installation, the current air temperature should be taken into account to determine the proper spacing between the mullion halves such that the expansion mullion stays within its allowable width limits during its service in hot and cold weather conditions.
- Fill the interior gap between the mullion halves with sealant at the sill flashing and head receptor.

See **Detail 23**.



Detail 23

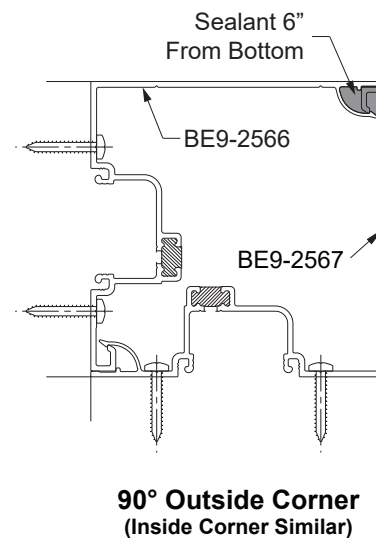
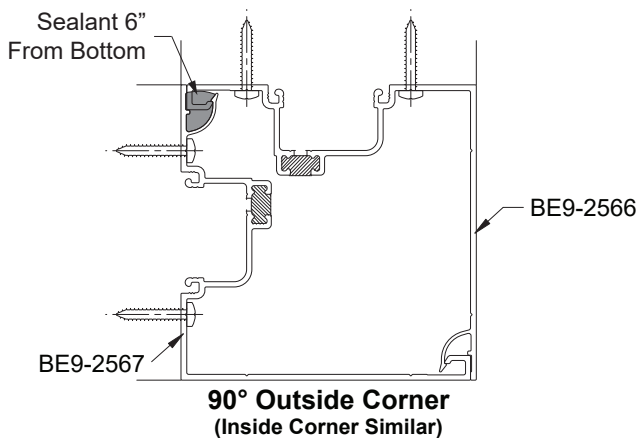
FRAME INSTALLATION

STEP 14 (Continued)

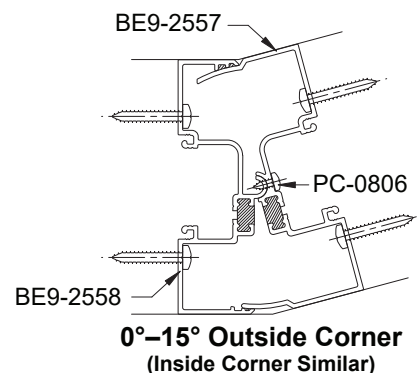
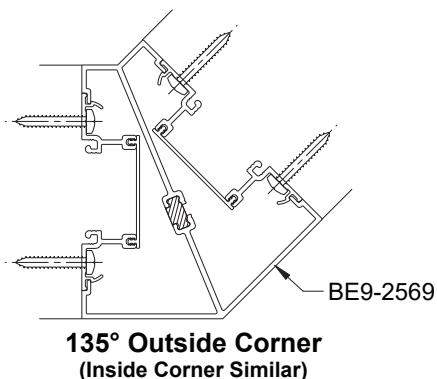
INSTALL CORNER ASSEMBLIES

- Attach horizontal members to standard mullions as shown before in **Step 7**.
- Attach the other end of the horizontals to the corner mullions, hinged mullions, or flat fillers, or using the same technique.
- Apply sealant to the interior snap receptor of the corner mullion, 6" up from the bottom.
- Snap the corner framing members together to form the corner assemblies.
- Hinged mullions must be fastened through the ball joint 6" from each end and no more than 18" on center with PC-0806 fasteners.
- Carefully move the corner assembly into place and snap it into the rest of the frame one side at a time.

See **Detail 24**.



Detail 24



FRAME INSTALLATION

STEP 14 (Continued)

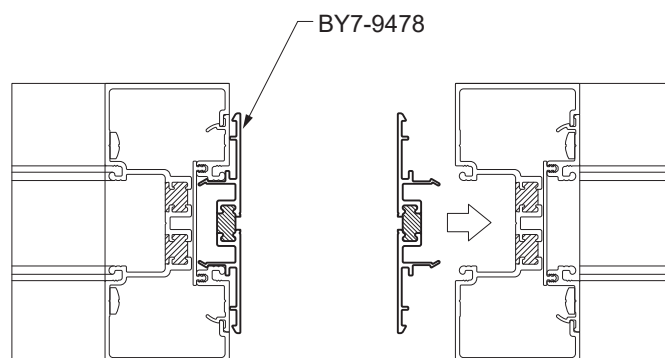
INSTALL OPTIONAL COMPOUND MULLIONS

-Snap in the BY7-9478 adaptors (cut full length of the mullion) into the mullions for each frame as shown in **Detail 25**.

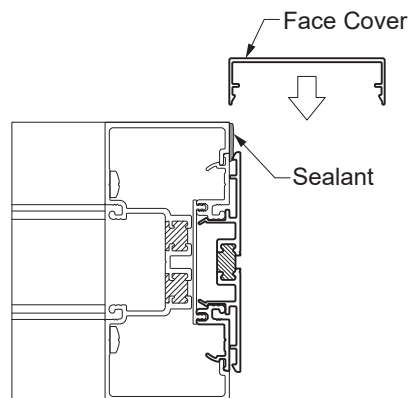
-Apply Sealant to the full length of the first mullion for which the rear face cover will snap into.

-Snap the face cover into place.

See **Detail 26**.



Detail 25



Detail 26

FRAME INSTALLATION

STEP 14 (Continued)

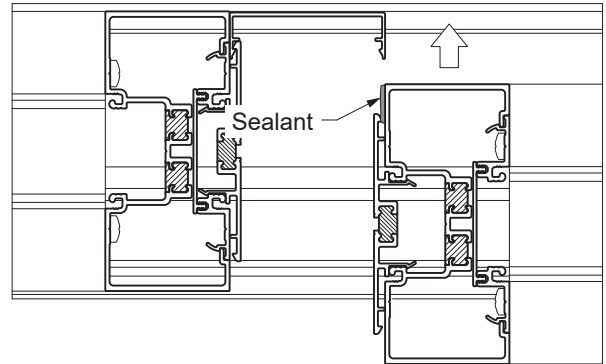
INSTALL OPTIONAL COMPOUND MULLIONS

-Apply sealant to the full length of the mullion for the second frame.

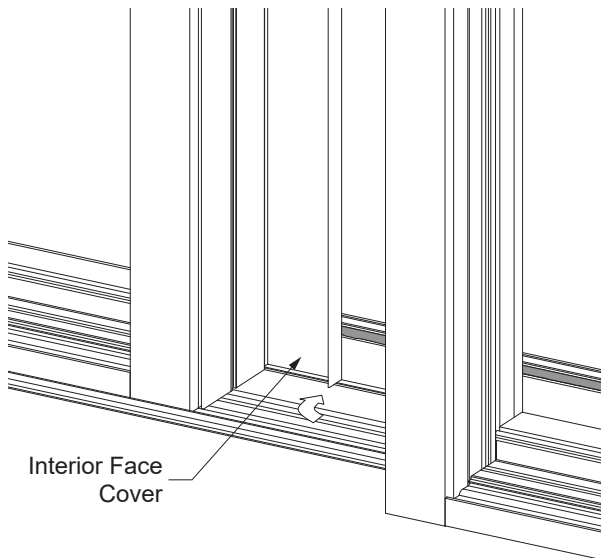
-Snap the second frame into place from the front, engaging the face cover as shown in **Details 27 & 27A**.

-Snap the front face cover into both frames. Start at the sill to clear the front lip of the sill flashing.

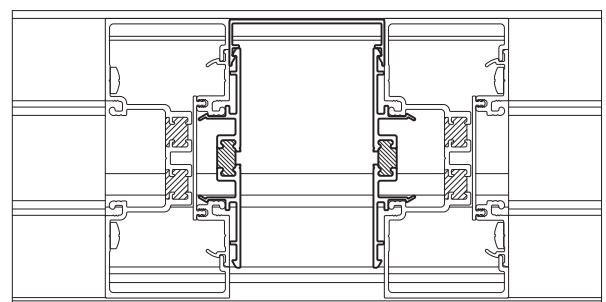
See **Detail 28**.



Detail 27A



Detail 27



Detail 28

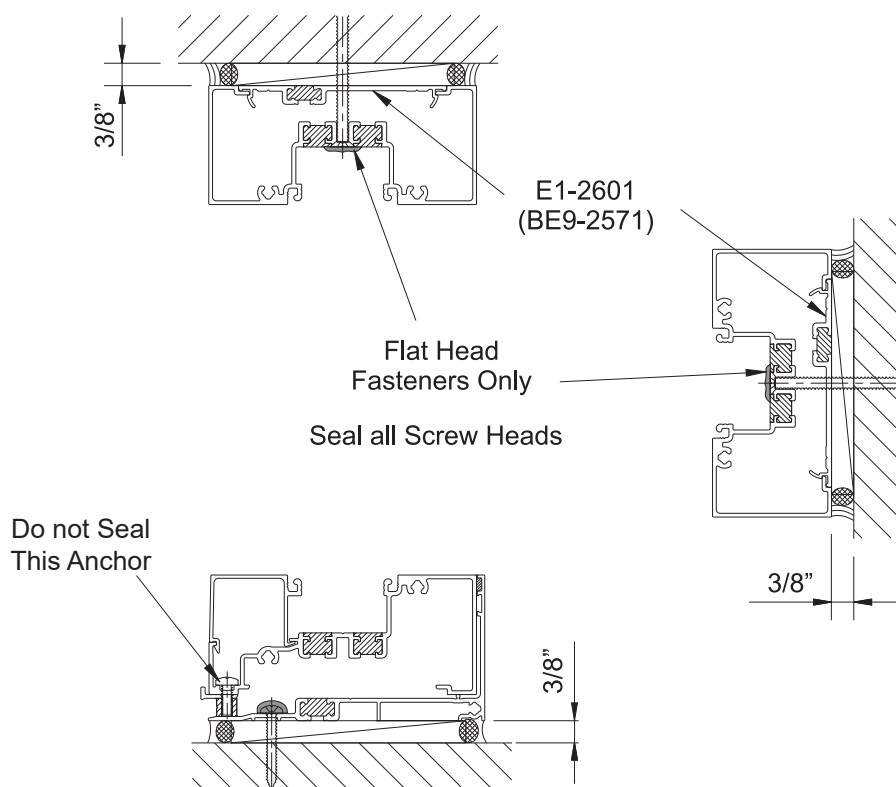
FRAME INSTALLATION

STEP 15

APPLY PERIMETER SEALANT

- Perimeter seal required on interior and exterior.
- Install backer rod around the perimeter of the frame.
- Apply perimeter sealant to the joint between the frame and the structure.
- Do not** seal the anchor that attaches the sill to the sill flashing.
- Make sure all screw heads are sealed.

See **Detail 29**.



Detail 29

FRAME INSTALLATION

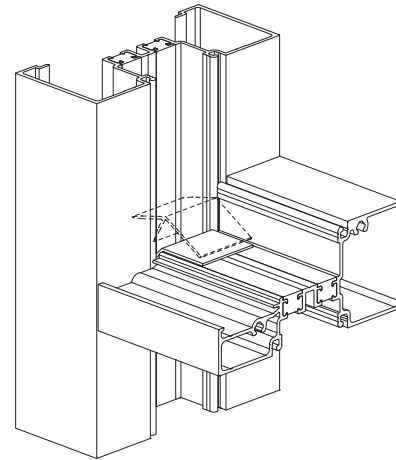
STEP 16 INSTALL WATER DEFLECTORS

YES 45 XT requires the installation of a water deflector, E2-0047, at the ends of every intermediate horizontal to keep water off of the insulated units.

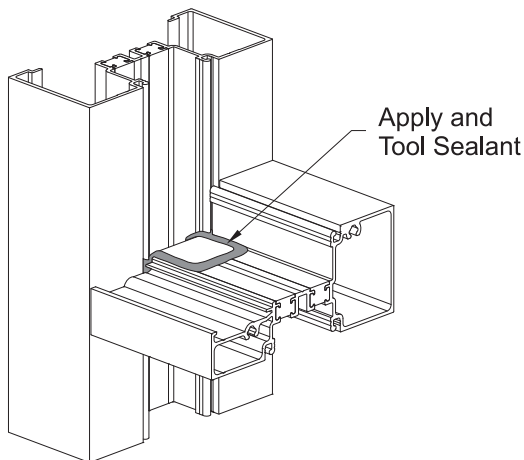
- Peel away the protective paper from the bottom of the water deflector, E2-0047, and install the water deflector by rotating it over each end of the horizontal.
- Position the vertical leg of the water deflector against the end of the horizontal.

Note: For best adhesion, make sure that the horizontal is clean and dry.

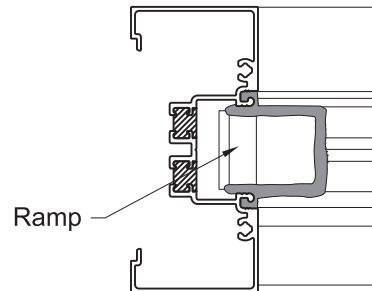
See **Detail 30**.



Detail 30



Detail 31



Detail 32

- Apply and tool sealant along the edges of the water deflector and down onto the horizontal.

See **Detail 31**.

- Seal the ramp of the water deflector to the sides of the vertical gasket reglets.
- See **Detail 32**.

FRAME INSTALLATION

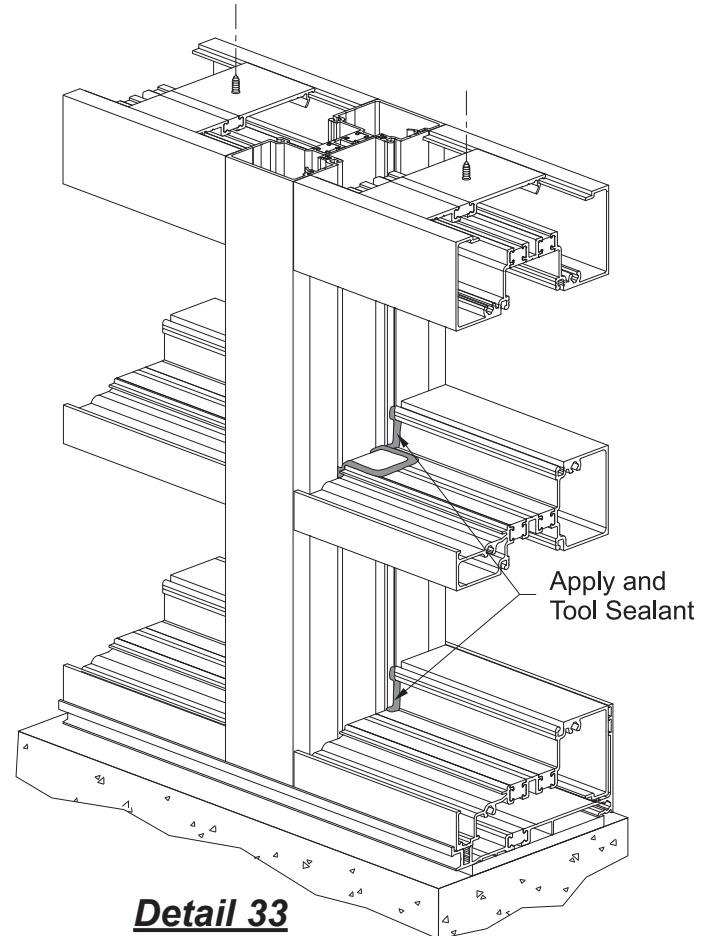
STEP 17

APPLY INTERNAL SEALANT

- Apply a generous amount of sealant to the vertical intersection of the horizontal and vertical members.
 - Tool all of the sealant to ensure a water tight joint.
 - Make sure all exposed screw heads are sealed.
- See **Detail 33**.

Glazing Table - YES 45 XT

| Glass Thickness | Adaptor | Exterior | Interior |
|-----------------|---------|----------|----------|
| 3/16" | E9-1040 | E2-0052 | E2-0064 |
| 1/4" | E9-1040 | E2-0052 | E2-0052 |

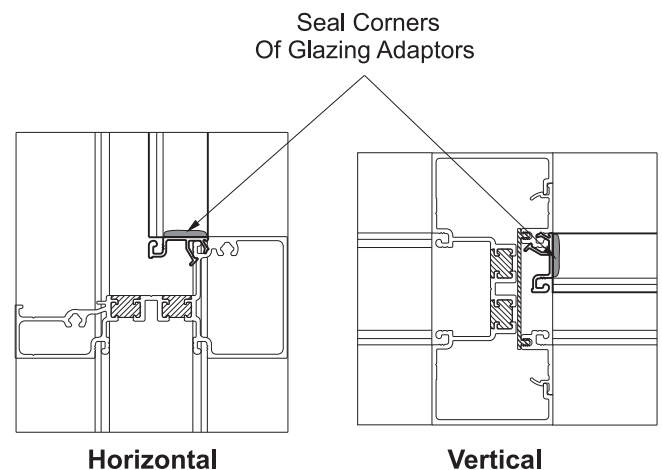


STEP 18 (Optional)

INSTALL GLAZING ADAPTORS

Glazing adaptors E9-1040, allows for glazing infills of 1/4" or 1". Please refer to the glazing tables above for adaptor/gasket combinations.

- Snap glazing adaptors into the interior gasket reglets of the verticals.
 - Snap glazing adaptors into the interior gasket reglets of the horizontals.
 - Apply and tool sealant to the joint between vertical and horizontal glazing adaptors.
- See **Detail 34**.



Detail 34

FRAME INSTALLATION

STEP 19 (Optional)

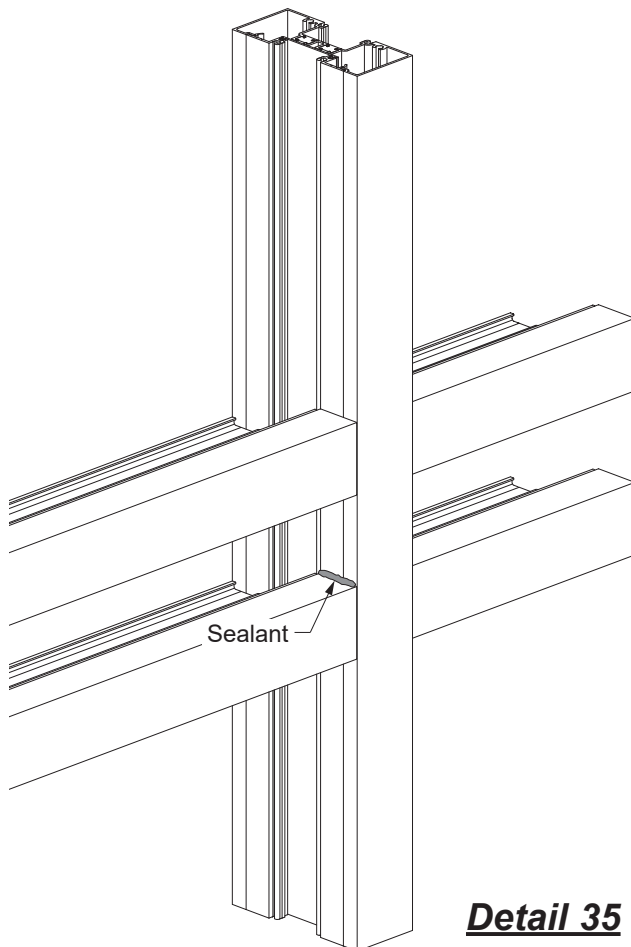
INSTALL OPTIONAL COMPOUND HORIZONTALS

-Apply sealant to the top of of the lower horizontals where they intersect with the vertical. Tool the sealant. Do not seal the upper horizontal.

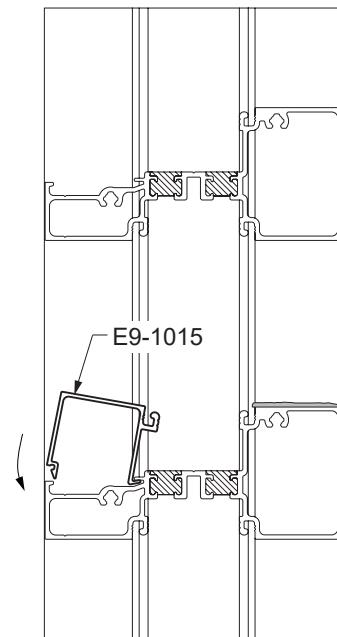
See **Detail 35**.

-Snap the E9-1015 glass stop into the lower horizontal as shown in **Detail 36**. Do not snap glass stops into the upper horizontals yet.

Note: Outside glazing shown, inside glazing similar.



Detail 35



Detail 36

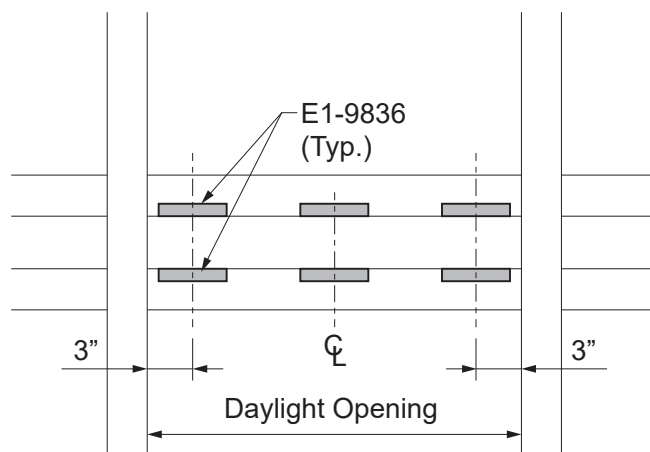
Note: Prior to snapping the glass stops onto an inside glazed storefront, apply sealant to the ends of the glass stops as illustrated in **Step 23A** on **Page 30**.

FRAME INSTALLATION

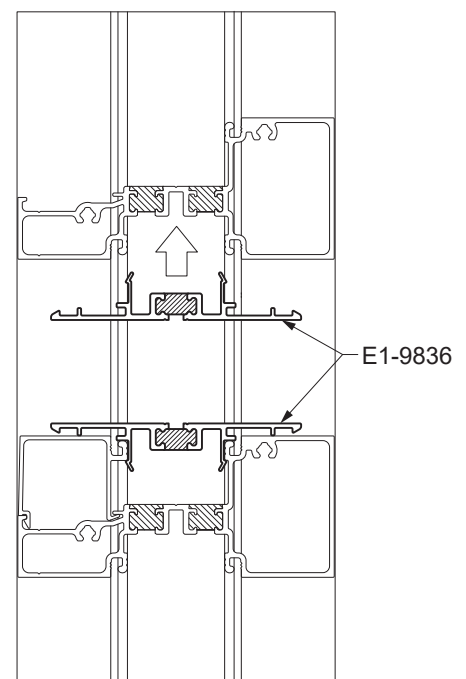
STEP 19 (Optional, Continued)

INSTALL OPTIONAL COMPOUND HORIZONTALS

-Snap in the E1-9836 adaptors into the horizontals, one at 3" from each end of each horizontal and one at the middle of each horizontal as shown in **Details 37 & 38**.



Detail 37



Detail 38

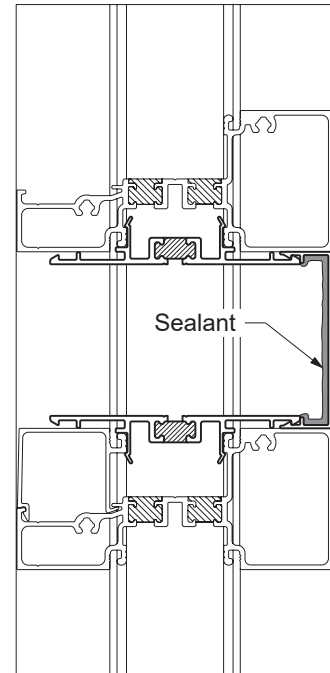
FRAME INSTALLATION
STEP 19 (Optional, Continued)
INSTALL OPTIONAL COMPOUND HORIZONTALS

-Cut the front and rear horizontal face covers to Daylight Opening minus(-) 1/16". Apply continuous sealant to the full length of the back of both horizontals where the rear face cover will snap into as shown in **Detail 39**. Snap the rear face cover into place.

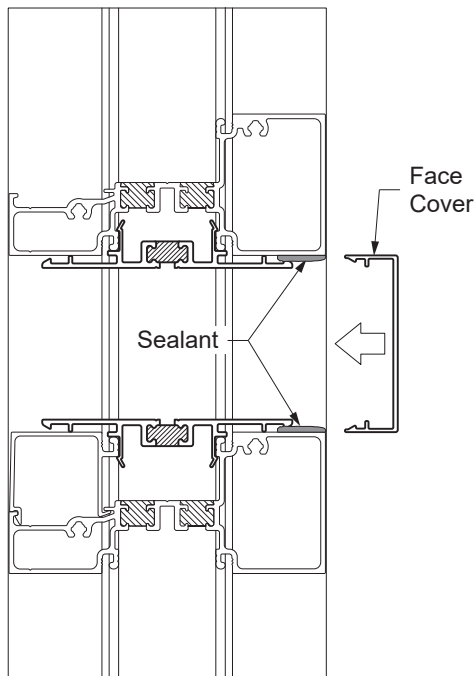
-Seal the joint between the edge of the face cover and the verticals as shown in **Detail 40**.

-Snap the front face cover into place.

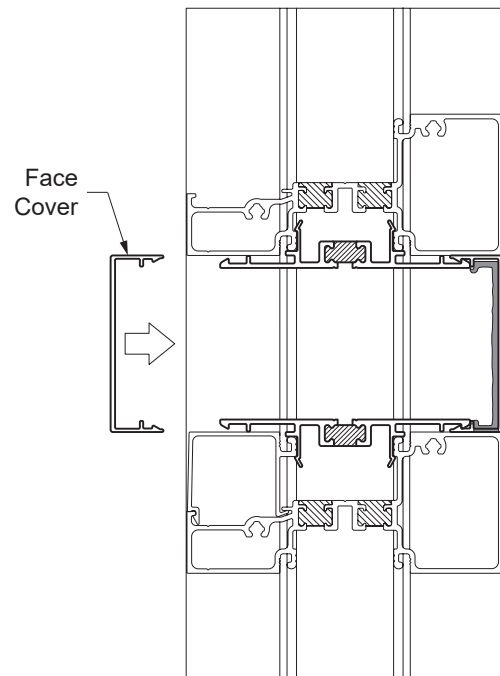
See **Detail 41**.



Detail 40



Detail 39



Detail 41

GLAZING

STEP 20

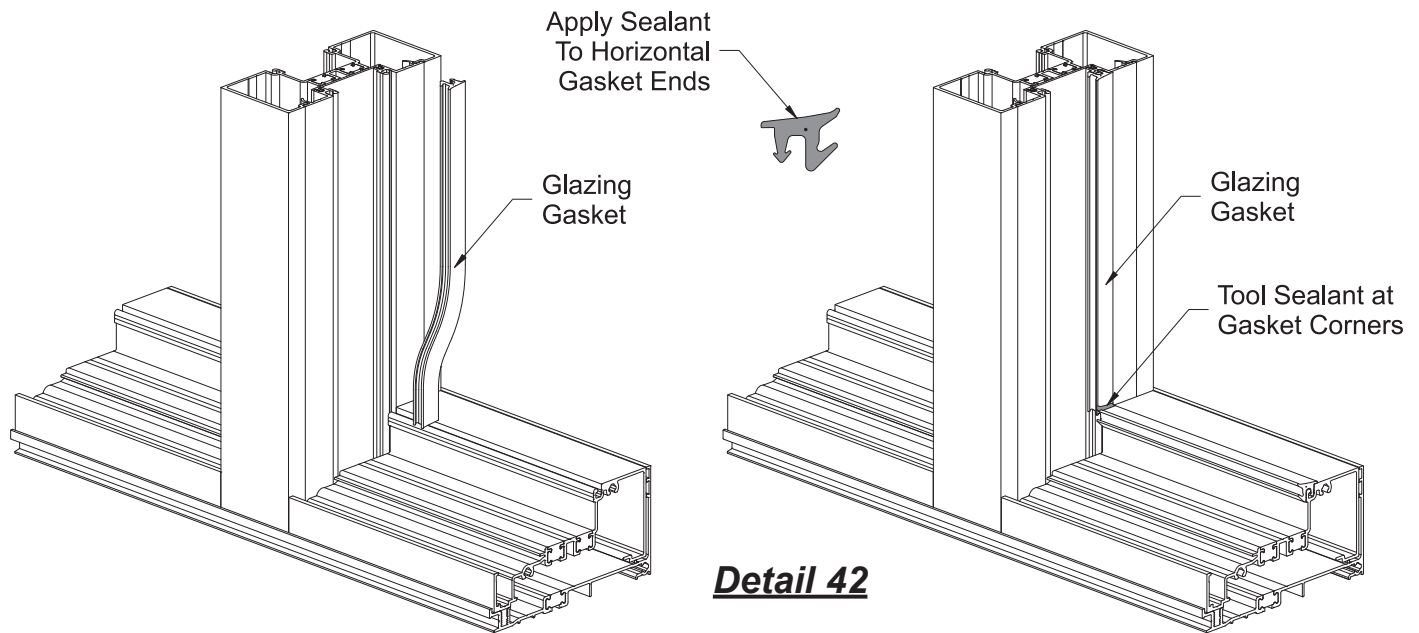
INSTALL INTERIOR GLAZING GASKETS

The interior glazing gaskets must be installed prior to the glazing process.

-Using a small brush clean out any dirt that may have accumulated in the gasket reglets.

Vertical glazing gaskets must be installed first:

- Cut vertical glazing gaskets to Daylight Opening plus(+) 1/4" for each foot of length.
- Insert the gasket into the reglet at each end first, and then insert the gasket at the midpoint of the opening.
- Push the gasket into the reglet starting at the midpoint and work towards each end.



Install horizontal glazing gaskets next:

- Cut horizontal glazing gaskets to Daylight Opening plus(+) 1/4" for each foot of length.
- Apply sealant to each end of the horizontal glazing gasket prior to inserting into the reglet.
- Insert the gasket into the reglet at each end first and push each end tight against the vertical gasket.
- Then insert the gasket at the midpoint of the opening and push the gasket into the reglet starting at the midpoint and work towards each end.
- Tool the excess sealant at the gasket corners to ensure a watertight seal.

See **Detail 42**.

GLAZING

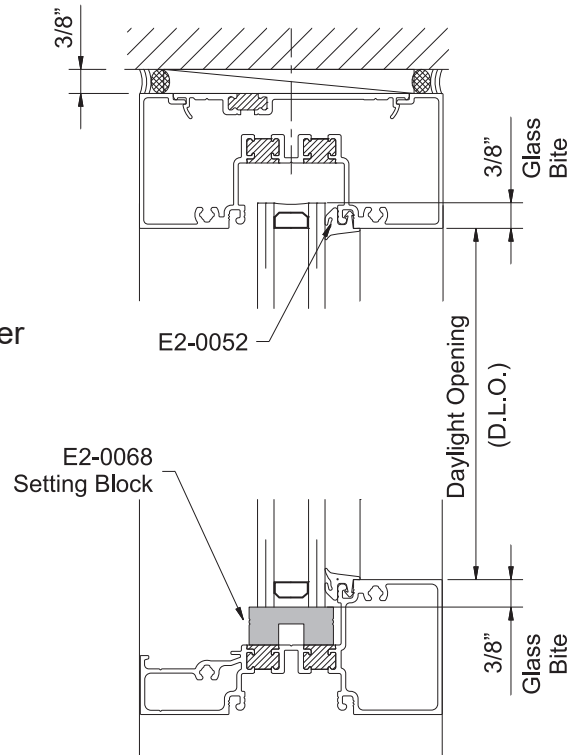
**STEP 21
INSTALL GLASS**

Determine the glass size:

Horizontal Glass Size = D.L.O. plus(+) 3/4"
Vertical Glass Size = D.L.O. plus(+) 3/4"

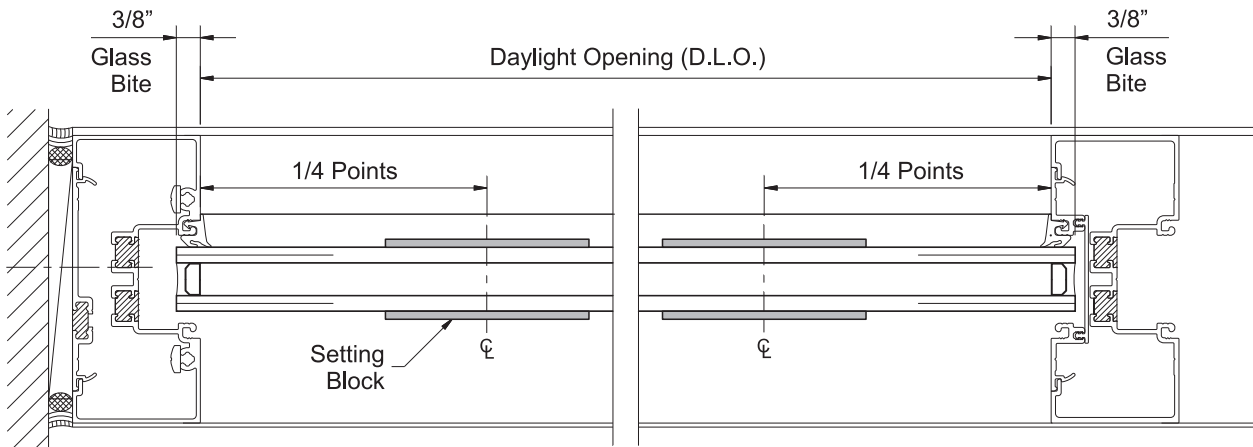
- Carefully install the glass into the opening: bring the lite up and into the deep pocket first and then rotate the other end in place.
- Carefully lift lite of glass, install setting blocks at quarter points of horizontal D.L.O. or according to engineering calculations.
- Make sure the glass is engaged with all setting blocks.

See **Detail 43**.



Detail 43

Outside Glazed Shown
Inside Glazed Similar



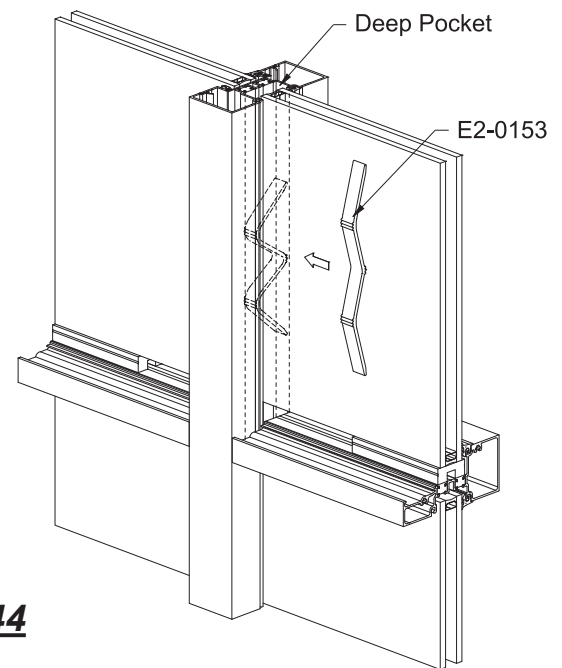
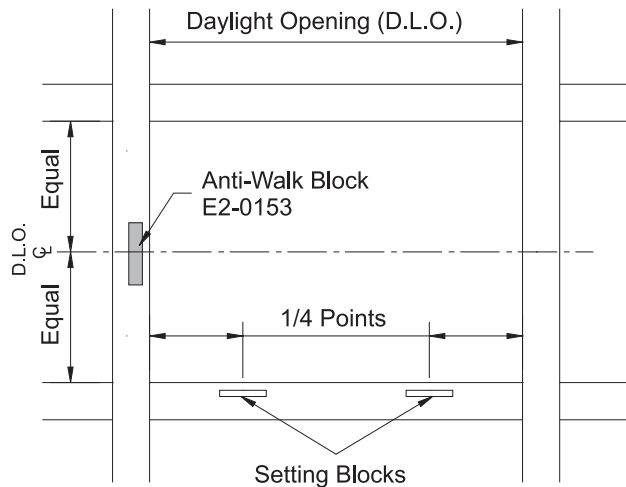
GLAZING

STEP 22 INSTALL ANTI-WALK BLOCKS

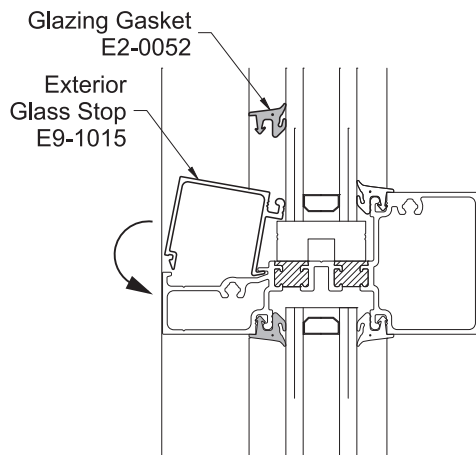
YES 45 XT frames require the installation of an anti-walk block, E2-0153, in the vertical deep glazing pocket of each lite centered along the daylight opening.

-Flatten the anti-walk block against the exterior surface of the glass and push it into the opening between the glass and the mullion until it is released into the glazing pocket.

See **Detail 44**.



Detail 44



Detail 45

STEP 23 INSTALL EXTERIOR GLASS STOPS & GLAZING GASKETS

-Snap the exterior glass stops into place as shown in **Detail 45**.

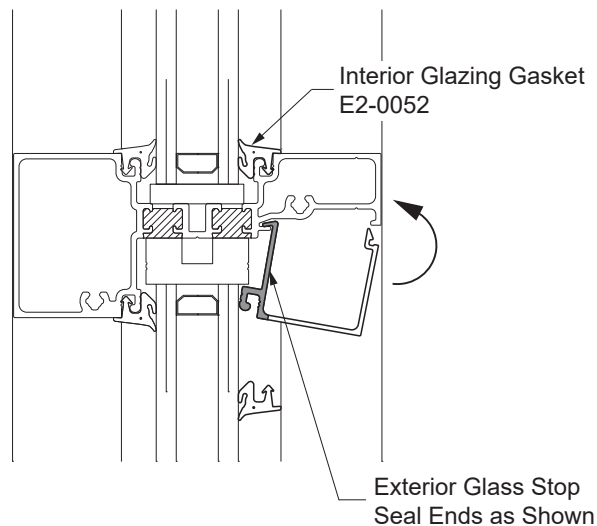
-Install the exterior glazing gaskets using the same technique described in **Step 18** on **Page-19**. Always install the vertical glazing gasket first.

Repeat **Steps 19 through 22** until all lites are installed.

GLAZING**STEP 23A
INSTALL INTERIOR GLASS STOPS
& GLAZING GASKETS**

- Apply sealant to the ends of the interior glass stops as shown in **Detail 46**.
- Snap the exterior glass stops into place. Wipe off excess sealant.
- Install the interior glazing gaskets using the same technique described in **Step 20 on Page 27**. Always install the vertical glazing gasket first.

Repeat **Steps 21 through 23A** until all lites are installed.



Detail 46



270 Riverside Parkway
Suite 100
Austell, Georgia 30168
www.ykkap.com