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**GENERAL NOTES**

THESE INSTALLATION INSTRUCTIONS ARE A SUPPLEMENT TO THE APPROVED SHOP DRAWINGS. USE IN CONJUNCTION WITH THOSE DRAWINGS.

**HANDLING, STORING AND PROTECTING ALUMINUM MATERIAL**

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.
- B) KEEP MATERIAL AWAY FROM WATER, MUD AND SPRAY - PREVENT CEMENT, PLASTER AND OTHER MATERIALS FROM DAMAGING THE FINISH.
- C) PROTECT THE MATERIALS AFTER ERECTION, BY WRAPPING WITH KRAFT PAPER - OR BY ERECTING VISQUEEN/CANVAS SPLATTER SCREENS. CEMENT, PLASTER, TERRAZZO AND OTHER ALKALINE MATERIALS ARE VERY HARMFUL TO THE FINISH AND SHOULD BE REMOVED WITH WATER AND MILD SOAP BEFORE SETTING OCCURS. UNDER NO CIRCUMSTANCES ALLOW THESE MATERIALS TO DRY OR PERMANENT STAINING WILL OCCUR.

**GENERAL RULES**

THE FOLLOWING PRACTICES ARE RECOMMENDED FOR ALL WALL INSTALLATIONS.

- A) READ COMPLETE INSTRUCTIONS BEFORE ORDERING GLASS OR FABRICATING MATERIAL.
- B) CHECK SHOP DRAWINGS TO BECOME THOROUGHLY FAMILIAR WITH THE JOB.
- C) ALL MATERIALS ARE TO BE INSTALLED PLUMB, LEVEL AND TRUE.
- D) ALL WORK SHOULD START FROM ESTABLISHED BENCH MARKS AND COLUMN CENTER LINES ESTABLISHED BY THE ARCHITECTURAL DRAWINGS AND THE GENERAL CONTRACTOR.
- E) THE SEQUENCE OF ERECTION SHOULD BE COORDINATED WITH THE JOB SUPERINTENDENT SO DELAYS ARE PREVENTED AND RISK OF MATERIAL DAMAGE IS MINIMIZED. IF PRESETTING OF ANCHORAGE IS REQUIRED, COORDINATE WITH GENERAL CONTRACTOR AND SUPERVISE LOCATION.
- F) MAKE CERTAIN CONSTRUCTION WHICH WILL RECEIVE YOUR MATERIALS IS ACCORDING TO THE CONTRACT DOCUMENTS. IF NOT, NOTIFY THE GENERAL CONTRACTOR IN WRITING AND RESOLVE DIFFERENCES BEFORE PROCEEDING WITH YOUR WORK.

- G) INSULATE ALL ALUMINUM TO BE PLACED DIRECTLY IN CONTACT WITH THE MASONRY OR INCOMPATIBLE MATERIALS WITH A HEAVY COAT OF ZINC CHROMATE OR BITUMINOUS PAINT.
- H) FOLLOW KAWNEER INSTALLATION AND GLAZING INSTRUCTIONS.
- J) CHECK ALL MATERIAL ON ARRIVAL FOR QUANTITY.
- K) BE SURE TO HAVE ALL THE MATERIALS AND TOOLS NEEDED TO BEGIN THE INSTALLATION.
  1. APPROVED SHOP DRAWINGS.
  2. LEVEL AND PLUMB (TRANSIT).
  3. FASTENERS AND REQUIRED DRIVERS.
  4. PERIMETERS AND ACCESSORIES SUCH AS ANCHORS, FASTENERS, SLEEVES AND/OR SPLICE CAPS.
  5. SEALING MATERIALS.
  6. GLAZING MATERIALS.
- L) FOLLOW SEALANT MANUFACTURER'S RECOMMENDATIONS FOR PROPER SEALANT AND APPLICATION. ALL SEALANTS AND MASTICS MUST BE COMPATIBLE WITH ALL SURFACES INCLUDING OTHER SEALANT SURFACES. WHERE REQUIRED ALL SEALANTS MUST ADHERE TO ALL SURFACES INCLUDING OTHER SEALANT SURFACES.

**1600 SYSTEM™1 NOTES**

1600 SYSTEM™1 IS AVAILABLE WITH 1" FRAMING MEMBERS WHICH ACCEPT BOTH 1" AND 1/4" INFILLS. ALSO 1/4" FRAMING MEMBERS WHICH ACCEPT 1/4" INFILLS ONLY ARE AVAILABLE.

GLASS BITE IS 1/2" AT VERTICALS AND HORIZONTALS. GLASS SIZES MUST BE CALCULATED FROM APPROVED SHOP DRAWINGS.

UNLESS OTHERWISE SPECIFIED, IT IS RECOMMENDED THAT SILICONE SEALANT BE USED FOR ALL INTERNAL SEALS.

SEALANT MUST BE APPLIED PER THE SEALANT MANUFACTURER'S RECOMMENDATIONS AND PASS ALL ADHESION AND COMPATIBILITY TESTING. AT ALL JOINT SEALS, SEALANT MUST ADHERE TO METAL, GASKETS, THERMAL SEPARATOR AND JOINT PLUG MATERIALS. CLEAN ALL SURFACES PRIOR TO APPLICATION OF SEALANT AND PRIME WHERE NECESSARY TO ACHIEVE PROPER ADHESION.

SHIM ALL SILL HORIZONTALS AT SETTING BLOCK LOCATIONS.

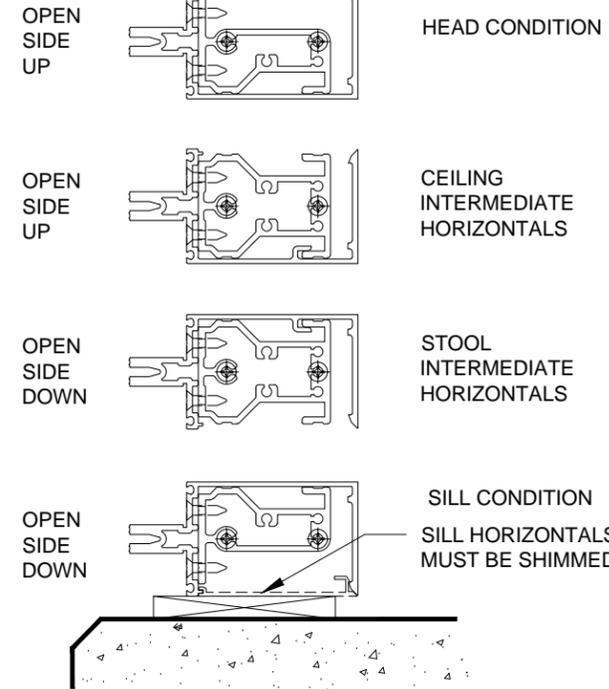
**OPEN BACK HORIZONTAL NOTES**

THE OPEN BACK HORIZONTAL IS TO BE TYPICALLY USED FOR ALL HEAD/SILL AND LAST BAY INTERMEDIATE HORIZONTALS.

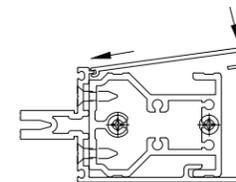
THE OPEN BACK HORIZONTAL CAN BE USED AT OTHER CONDITIONS IF IT IS AN ADVANTAGE TO THE JOB DESIGN.

THE SHEAR BLOCK AT ALL OPEN BACK INTERMEDIATE HORIZONTALS HAS THE OPTION TO BE PRE-INSTALLED INTO THE HORIZONTAL BEFORE HORIZONTALS ARE INSTALLED

REFERENCE INSTRUCTIONS 162983 FOR EXTERIOR FRAME PERIMETERS



WHEN THE OPEN SIDE OF THE OPEN BACK HORIZONTAL IS EXPOSED AND AT EYE LEVEL A SNAP-IN FILLER IS AVAILABLE.



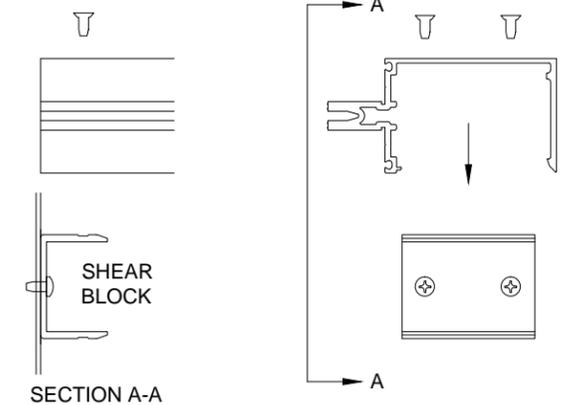
WHEN THE SNAP-IN FILLER IS NOT USED, AND DUE TO STANDARD COMMERCIAL EXTRUDING TOLERANCES, IT MAY BE REQUIRED TO USE A 4" PIECE OF THE FILLER AT EACH END OF A HORIZONTAL.

USE PART 162316 FOR THE 6" DEEP SYSTEM  
USE PART 162317 FOR THE 7 1/2" DEEP SYSTEM

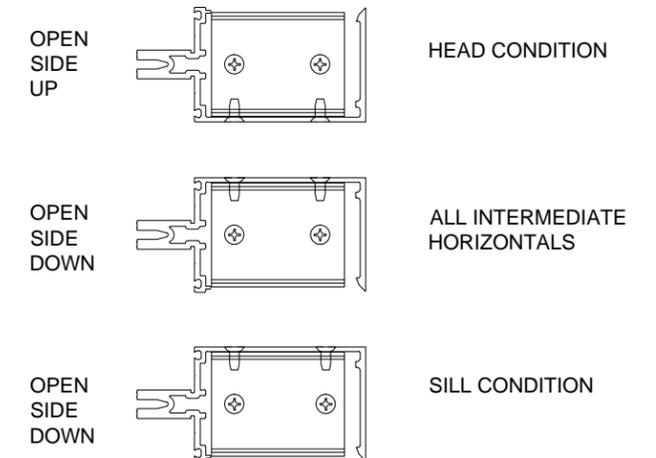
**OPEN BACK HORIZONTALS AT 90° AND 135° CORNERS**

WHENEVER POSSIBLE AVOID USING OPEN BACK HORIZONTALS AT 90° AND 135° CORNERS. IF USING THE OPEN BACK HORIZONTAL BECOMES ABSOLUTELY NECESSARY THE SHEAR BLOCK CONNECTION WILL BE AS SHOWN BELOW.

ALSO REFER TO CORNER INSTRUCTIONS 162972



THE OPEN SIDE OF THE OPEN BACK HORIZONTAL IS TO BE POSITIONED AS SHOWN BELOW. THE INTERMEDIATE HORIZONTAL IS POSITIONED OPEN SIDE DOWN FOR DEAD LOAD SUPPORT.



1600 WALL SYSTEM™1  
CURTAIN WALL  
INSTALLATION  
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### STEP 1 - CHECK OPENINGS

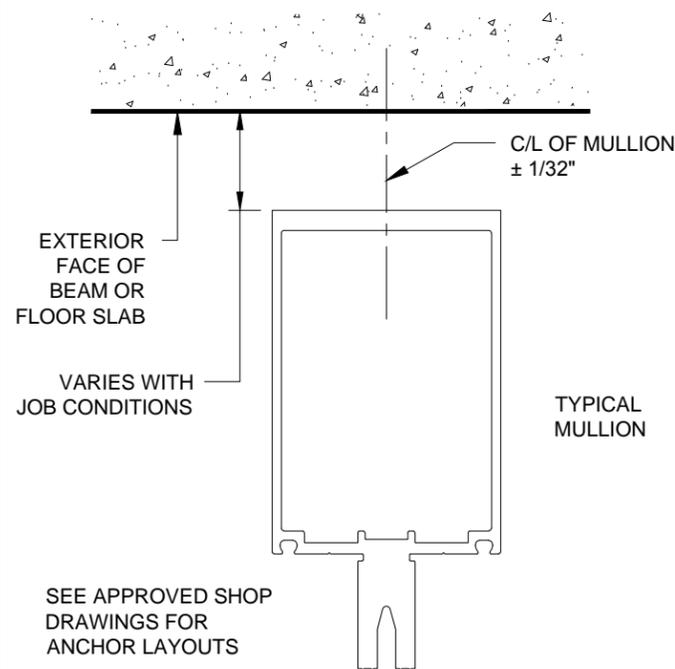
ELEVATIONS AND SLABS MUST BE WITHIN ADJUSTMENT OF ANCHORING SYSTEM. SEE APPROVED SHOP DRAWINGS FOR ALLOWABLE ADJUSTMENT.

ANCHORING SURFACES OF PERIMETER CONSTRUCTION MUST BE LEVEL AND PLUMB WITHIN THE ADJUSTMENT LIMITS OF THE HEAD, SILL AND JAMB. SEE APPROVED SHOP DRAWINGS FOR ALLOWABLE ADJUSTMENT.

### STEP 2 - LAY OUT ANCHOR AND MULLION CENTERLINES

USE WALL LINES ESTABLISHED BY THE GENERAL CONTRACTOR. ON EACH FLOOR LAY OUT A REFERENCE LINE TO ESTABLISH IN AND OUT WALL LOCATIONS.

USE COLUMN CENTER LINES ESTABLISHED BY THE GENERAL CONTRACTOR. ON EACH FLOOR LAY OUT MULLION CENTER LINES AND ANCHOR CENTER LINES.



### STEP 3 - INSTALL PRESET ANCHORS IF APPLICABLE

USING LOCATION LINES PREVIOUSLY ESTABLISHED INSTALL PRESET ANCHORS IN PLACE PER APPROVED SHOP DRAWINGS.

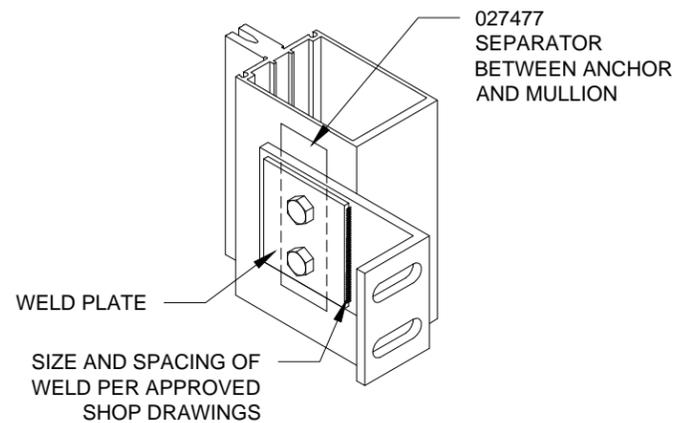
### STEP 4 - FRAME ASSEMBLY

ATTACH ANCHORS TO MULLIONS WHERE APPLICABLE.

ANCHOR PREP MAY BE FABRICATED IN THE FIELD OR FACTORY. CONSULT APPROVED SHOP DRAWINGS FOR CORRECT METHOD.

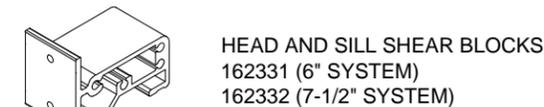
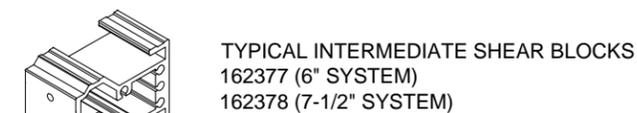
STANDARD ANCHOR PREP IS THRU-BOLTED AT INTERMEDIATE VERTICALS AND TAPPING PLATES ARE USED AT JAMB VERTICALS. REFER TO APPROVED SHOP DRAWINGS FOR CORRECT METHOD.

WHEN WELDING ANCHORS, PROTECT INSTALLED GLASS AND METAL FROM WELD SPLATTER.



DO NOT OVER TIGHTEN ANCHOR CONNECTIONS. TIGHTEN TO A "SNUG TIGHT" POSITION WITH PARTS BROUGHT INTO GOOD CONTACT. BE SURE ANY SPRING TYPE LOCK WASHERS ARE COMPRESSED. THEN TIGHTEN APPROXIMATELY 1/2 MORE TURN.

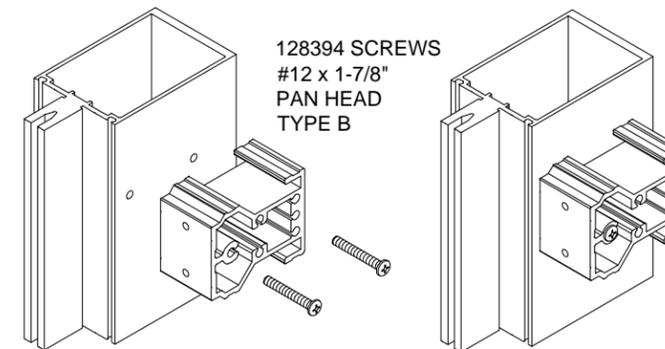
ATTACH SHEAR BLOCKS.



REFERENCE INSTRUCTIONS 162983 FOR EXTERIOR FRAME PERIMETERS HEAD AND SILL SHEAR BLOCKS 162384 (6" SYSTEM) 162385 (7-1/2" SYSTEM)

### STEP 4 - FRAME ASSEMBLY

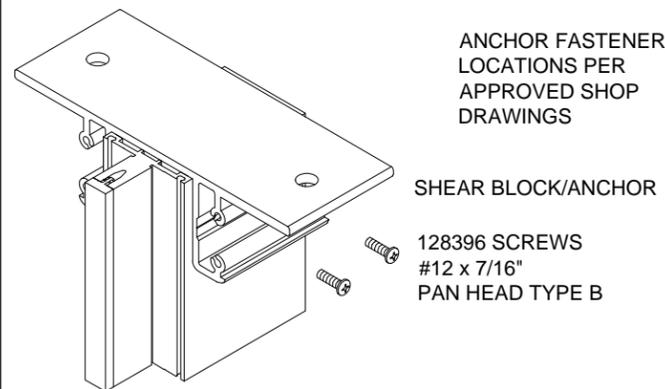
ATTACH SHEAR BLOCKS



HEAD/SILL SHEAR BLOCK/ANCHOR WHERE APPLICABLE AND SHOWN BELOW.

- 162314 (6" SYSTEM AT JAMBS)
- 162315 (7-1/2" SYSTEM AT JAMBS)
- 162342 (6" SYSTEM AT MULLIONS)
- 162343 (7-1/2" SYSTEM AT MULLIONS)

STRUCTURAL INTEGRITY OF ANCHOR AND FASTENERS MUST BE CHECKED BY FACTORY ENGINEERS.

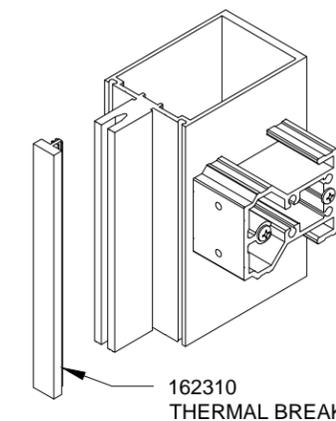


### STEP 5 - INSTALL THERMAL BREAK

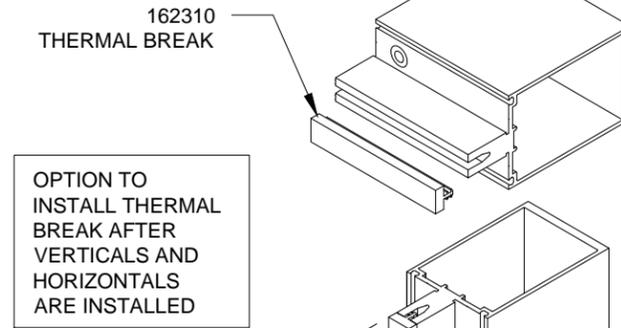


DO NOT STRETCH WHEN REMOVING FROM COIL AND CARTON

DO NOT STRETCH DURING INSTALLATION



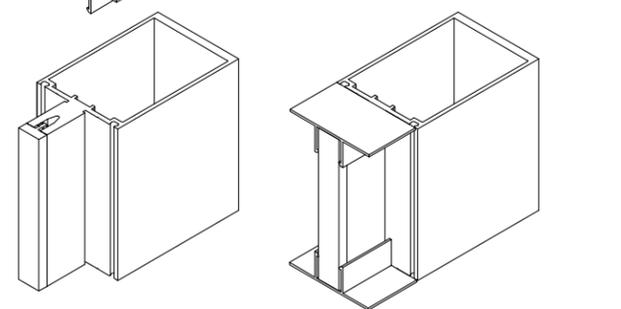
### STEP 5 - INSTALL THERMAL BREAK



THERMAL BREAK TO BE SAME LENGTH AS VERTICAL MULLIONS

THERMAL BREAK TO BE 1/4" SHORT AT EACH END OF HORIZONTALS

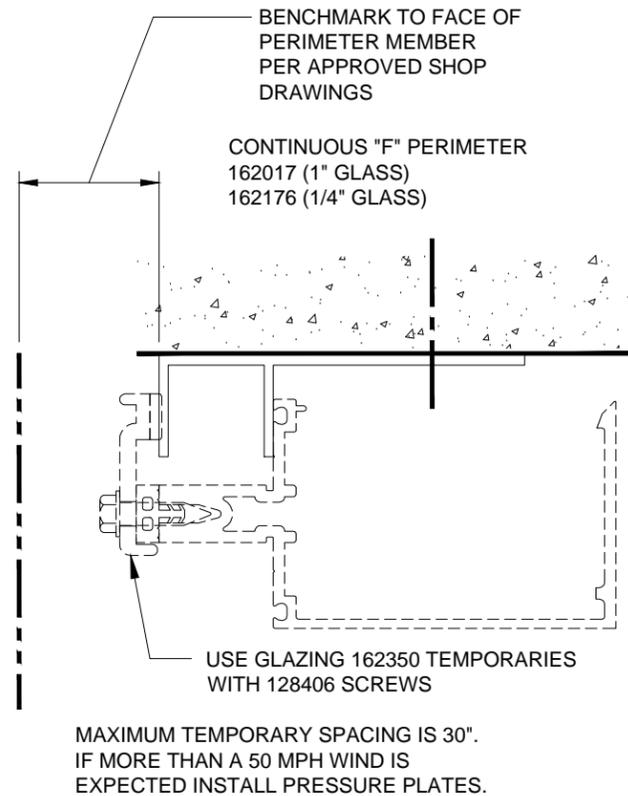
INSTALL HEAD AND SILL END CAPS 162388 (1" FRAMING) 162389 (1/4" FRAMING) SET IN SEALANT



NOT REQUIRED AT EXTERIOR FRAME PERIMETERS SHOWN IN INSTRUCTIONS 162983 AND AT OPTIONAL PERIMETER FILLERS 162022 AND 162023

### STEP 6 - PERIMETERS WHERE APPLICABLE

INSTALL PERIMETER MEMBERS PER APPROVED SHOP DRAWINGS. PERIMETER MEMBERS CAN OCCUR AT HEAD, SILL OR JAMB CONDITIONS.



### STEP 7 - INSTALL VERTICAL MULLIONS

"F" OR "T" ANCHORS WHERE APPLICABLE

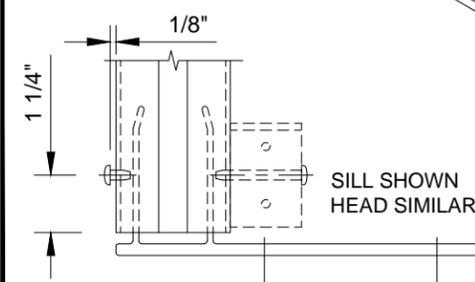
"F" AND "T" ANCHOR FASTENER LOCATIONS PER APPROVED SHOP DRAWINGS

REFERENCE INSTRUCTIONS 162983 FOR EXTERIOR FRAME PERIMETERS

THESE SHEAR BLOCKS MAY NEED TO BE REMOVED TO INSTALL AN ANCHOR FASTENER THAT MIGHT BE LOCATED CLOSE TO THE MULLION

"F" AND "T" ANCHOR FASTENER LOCATIONS PER APPROVED SHOP DRAWINGS

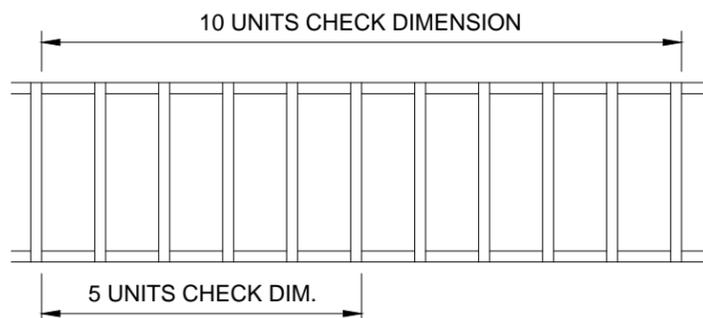
AT MULLION JAMB SIDE, APPLY (2) 128396 SCREWS AS SHOWN TO CENTER F-CLIPS AS REQUIRED.



### STEP 7 - INSTALL VERTICAL MULLIONS

DIMENSION BUILD-UP CHECK CHECK

OVERALL FRAME DIMENSIONS ABOUT EVERY FIVE MULLIONS ON LONG RUNS. THIS IS TO AVOID DIMENSION BUILD-UP

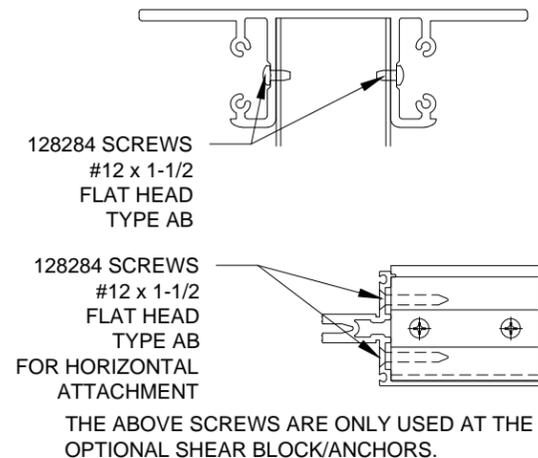


### STEP 7 - INSTALL VERTICAL MULLIONS

HEAD/SILL SHEAR BLOCK/ANCHOR WHERE APPLICABLE.

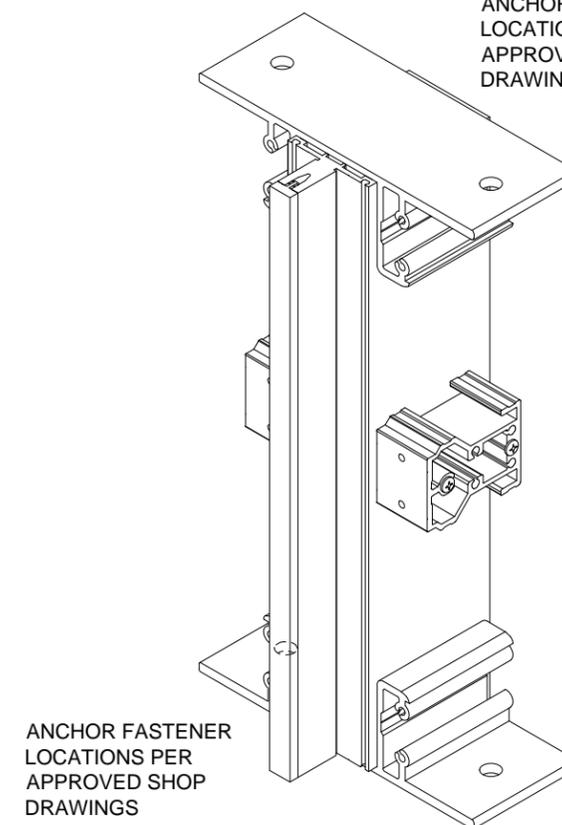
CAN NOT BE USED WITH EXTERIOR FRAME PERIMETERS SHOWN ON INSTRUCTIONS 162983

- 162314 (6" SYSTEM AT JAMBS)
- 162315 (7-1/2" SYSTEM AT JAMBS)
- 162342 (6" SYSTEM AT MULLIONS)
- 162343 (7-1/2" SYSTEM AT MULLIONS)



STRUCTURAL SHIMMING IS REQUIRED AT SILL TO ACCOMPLISH DESIGNED PERIMETER SEAL WIDTH

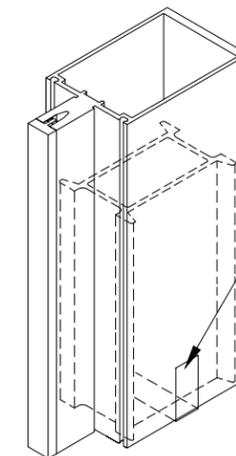
ANCHOR FASTENER LOCATIONS PER APPROVED SHOP DRAWINGS



ANCHOR FASTENER LOCATIONS PER APPROVED SHOP DRAWINGS

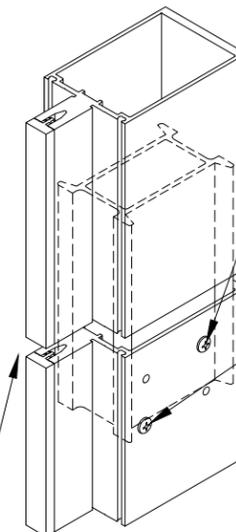
### STEP 7 - INSTALL VERTICAL MULLIONS

VERTICAL SPLICE JOINTS WHERE APPLICABLE.



SLEEVE IS FACTORY TAPED INTO THE BOTTOM OF THE TOP VERTICAL

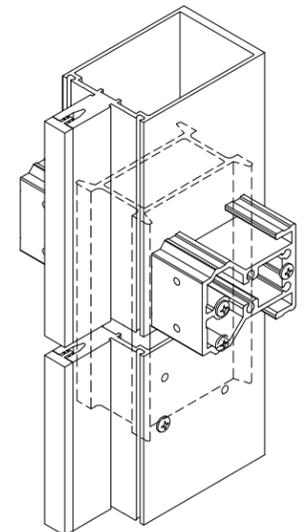
REMOVE THE TAPE AND LET THE SLEEVE SLIDE DOWN TO THE FACTORY APPLIED STOP SCREW



FIELD APPLIED FIXING SCREW 128348 #10 x 1-1/4" FLAT HEAD SELF DRILLING

SHOP APPLIED STOP SCREW 128267 #12 x 1" PAN HEAD TYPE AB

USE TEMPORARY SPACERS FOR JOINT DIMENSION



SPLICE JOINT WHEN IT OCCURS AT A HORIZONTAL



1600 WALL SYSTEM™ 1 CURTAIN WALL INSTALLATION INSTRUCTIONS

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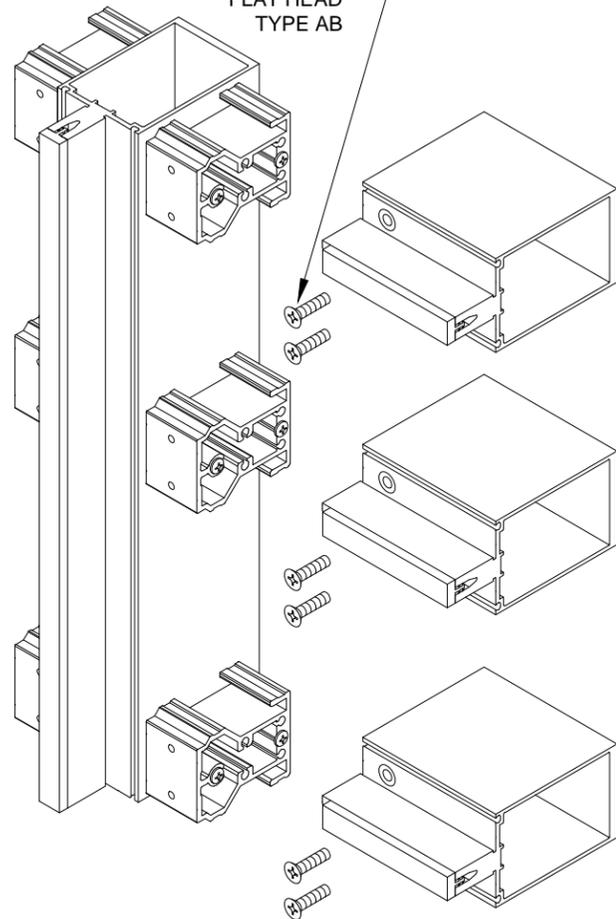
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### STEP 8 - INSTALL HEAD/SILL AND INTERMEDIATE HORIZONTALS

TUBULAR HORIZONTALS

128405 SCREWS  
#12 X 7/8"  
FLAT HEAD  
TYPE AB



THERMAL BREAK  
TO BE 1/4"  
SHORT AT EACH  
END OF  
HORIZONTALS

1/4"

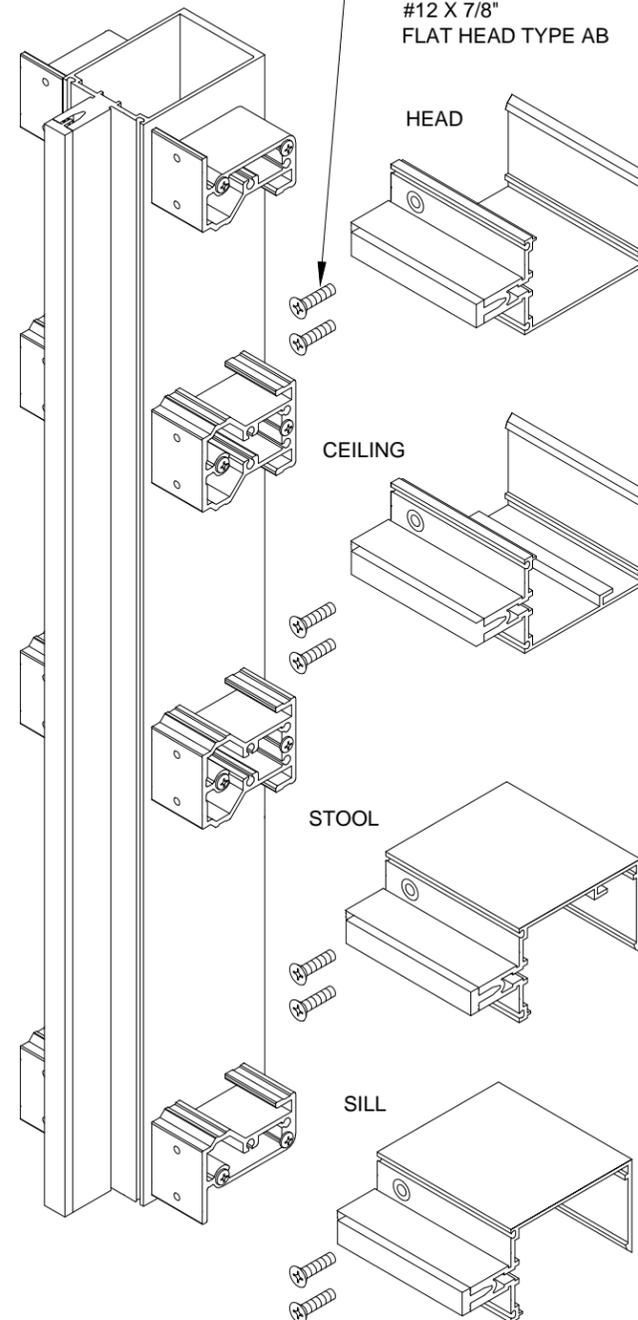
### STEP 8 - INSTALL HEAD/SILL AND INTERMEDIATE HORIZONTALS

REFERENCE INSTRUCTIONS 162983 FOR  
EXTERIOR FRAME PERIMETERS

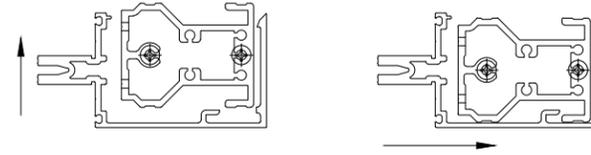
OPEN BACK HORIZONTALS AND LAST BAY HORIZONTALS.

FILLER AVAILABLE WHEN OPEN BACK IS EXPOSED AND AT  
EYE LEVEL.

128405 SCREWS  
#12 X 7/8"  
FLAT HEAD TYPE AB



INSTALLING CEILING INTERMEDIATE  
OPEN BACK HORIZONTAL



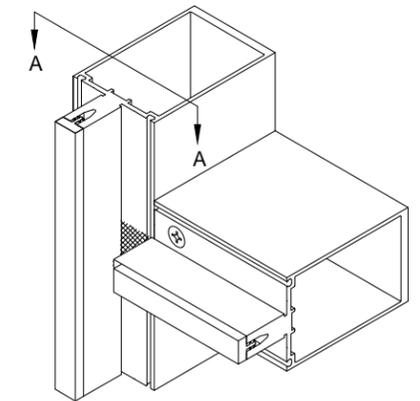
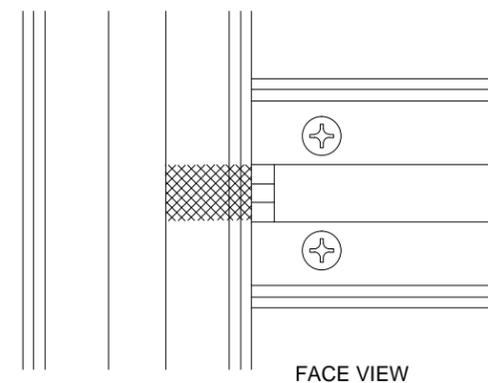
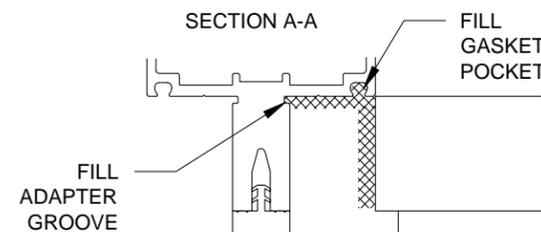
INSTALLING STOOL INTERMEDIATE  
OPEN BACK HORIZONTAL



### STEP 9 - INSTALL JOINT PLUGS

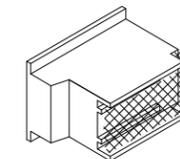
ALL SURFACES AND GROOVES MUST BE  
CLEANED PER THE SEALANT MANUFACTURER'S  
RECOMMENDATIONS.

JUST BEFORE INSTALLING JOINT PLUGS  
APPLY SEALANT AS SHOWN FILLING  
GASKET POCKET AND ADAPTER GROOVE.

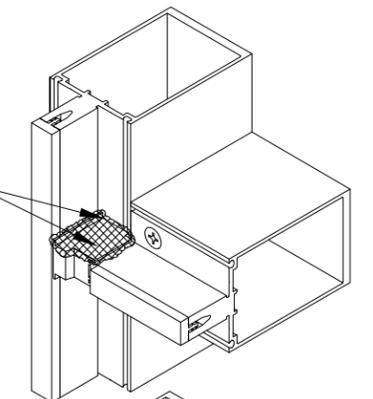


JOINT PLUG  
162321 (1" FRAMING)  
162322 (1/4" FRAME MEMBERS)

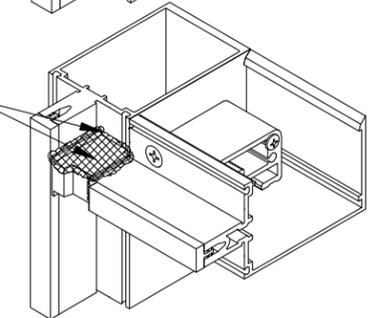
APPLY SEALANT TO THIS  
FACE OF JOINT PLUG



SEAL AROUND JOINT PLUG  
EDGES AND COMPLETELY  
OVER JOINT PLUG WITH  
SEALANT AND TOOL  
AS SHOWN



SEAL AROUND JOINT PLUG  
EDGES AND COMPLETELY  
OVER JOINT PLUG WITH  
SEALANT AND TOOL  
AS SHOWN



REFERENCE INSTRUCTIONS 162983 FOR  
EXTERIOR FRAME PERIMETERS

**KAWNEER**  
AN ARCONIC COMPANY

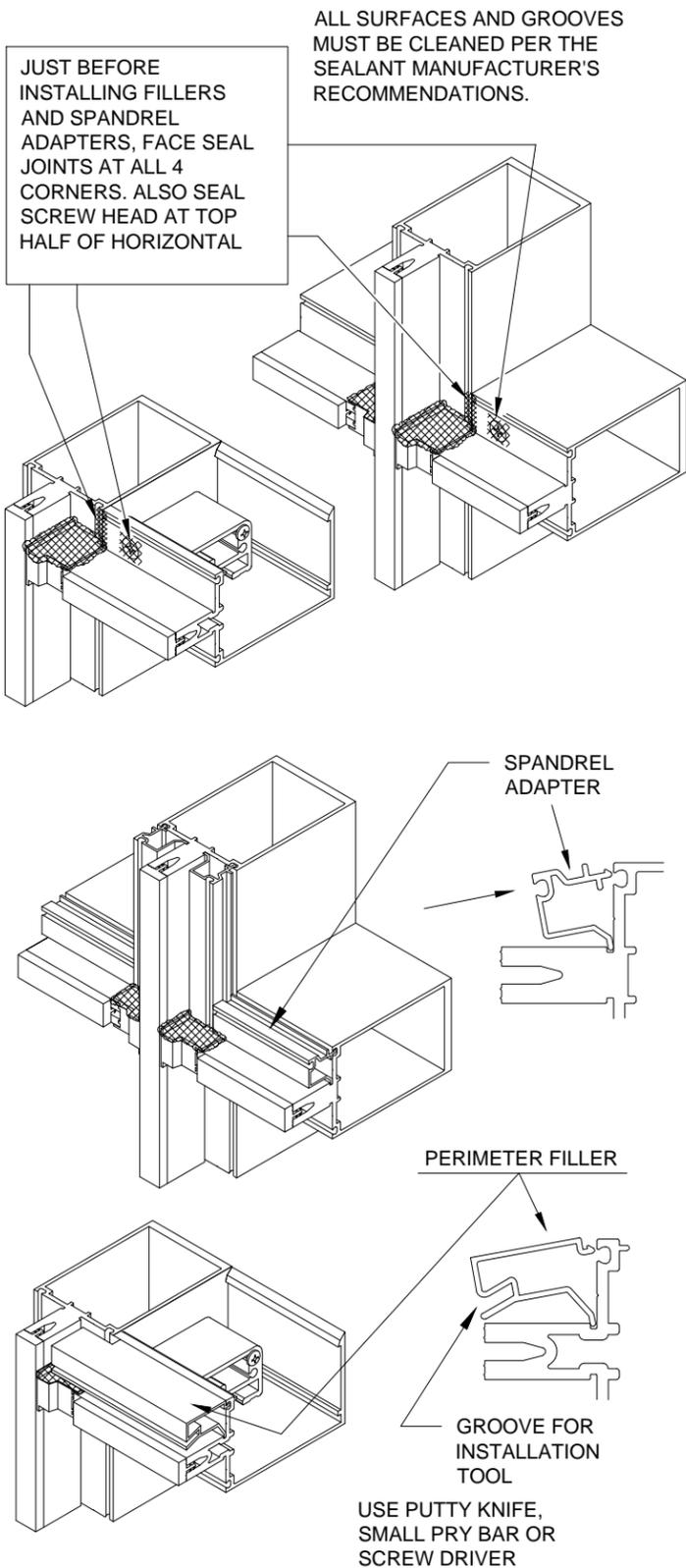
1600 WALL SYSTEM™ 1  
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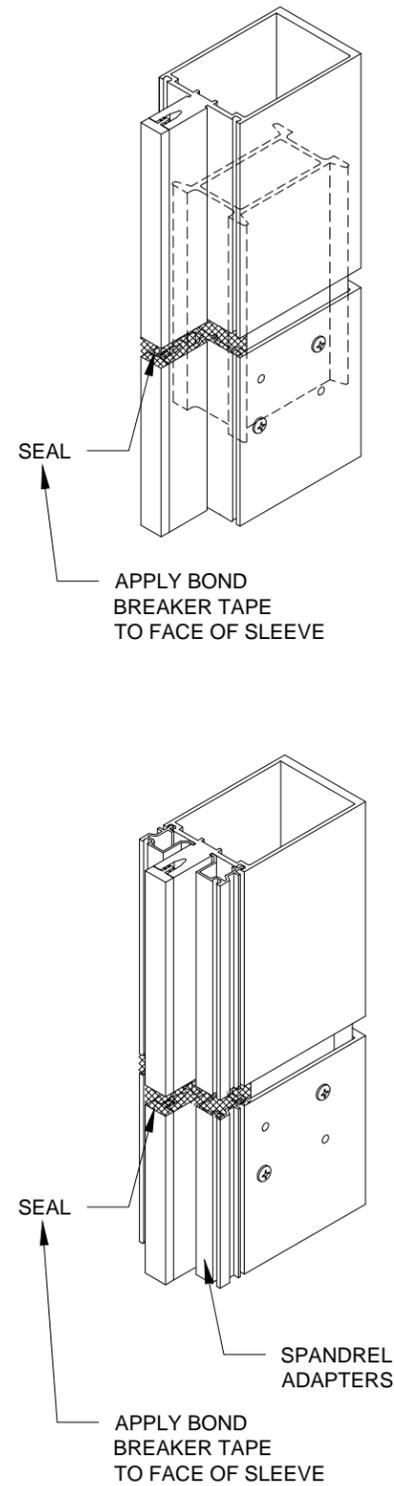
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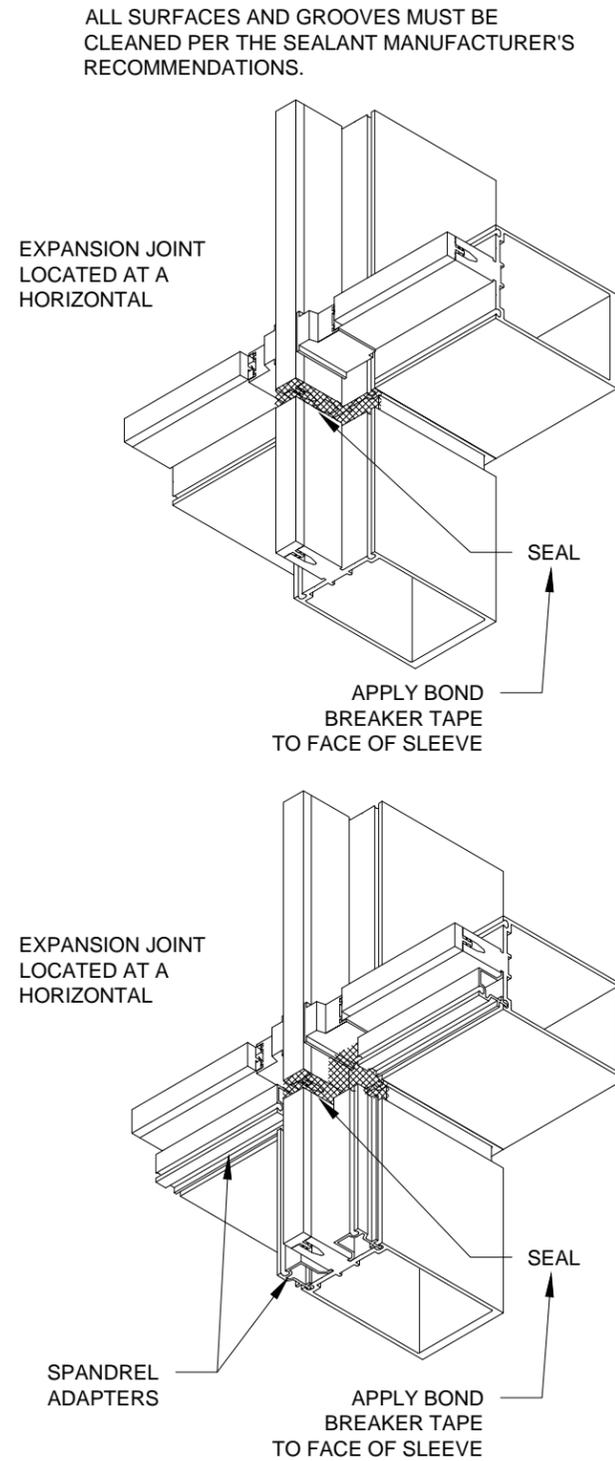
**STEP 10 - INSTALL PERIMETER  
FILLERS AND SPANDREL  
ADAPTERS WHERE  
APPLICABLE**



**STEP 11 - SEAL INTERIOR OF  
VERTICAL SPLICE JOINTS**



**STEP 11 - SEAL INTERIOR OF  
VERTICAL SPLICE JOINTS**



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CURTAIN WALL  
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### STEP 12 - INSTALL INTERIOR GLAZING GASKETS

GASKETS SHOULD BE INSTALLED JUST PRIOR TO GLASS TO AVOID CONTAMINATION BY JOB SITE DEBRIS. GASKET GROOVES AND POCKETS SHOULD BE CLEAN.

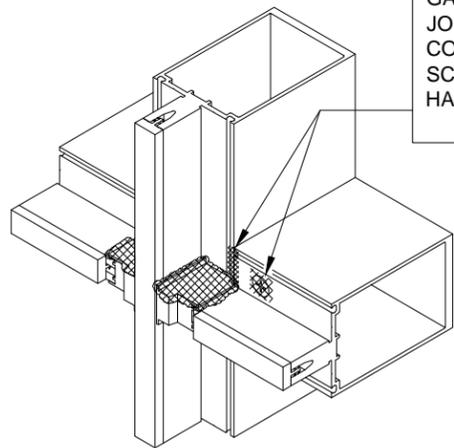
IN TEMPERATURES COLDER THAN 50° F ARRANGEMENTS SHOULD BE MADE TO WARM GASKETS BEFORE INSTALLATION. THIS WILL PREVENT EXCESSIVE GLAZING PRESSURE ON THE GLASS DUE TO COLD, STIFF RUBBER GASKETS.

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

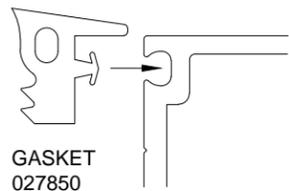
GASKET INSTALLED LENGTH TO BE DAYLITE OPENING. GASKETS TO BE CUT LONG FOR SOME "CROWD-IN". GASKETS SHOULD NEVER BE "STRETCHED TO FIT".

"CROWD-IN" TO BE 1/8" PER FOOT UP TO 5'-0", 3/16" PER FOOT UP TO 8'-0", 1/4" PER FOOT OVER 8'-0".

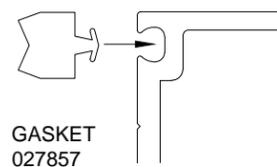
JUST BEFORE INSTALLING VERTICAL AND HORIZONTAL GASKETS FACE SEAL JOINTS AT ALL (4) CORNERS. ALSO SEAL SCREW HEAD AT TOP HALF OF HORIZONTAL



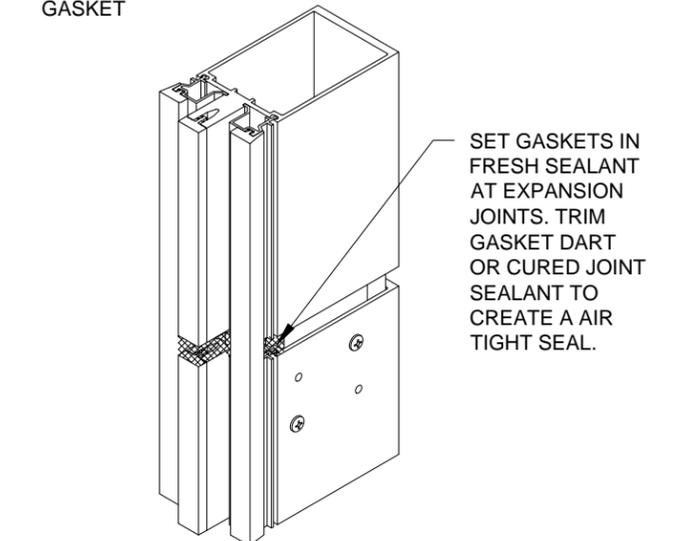
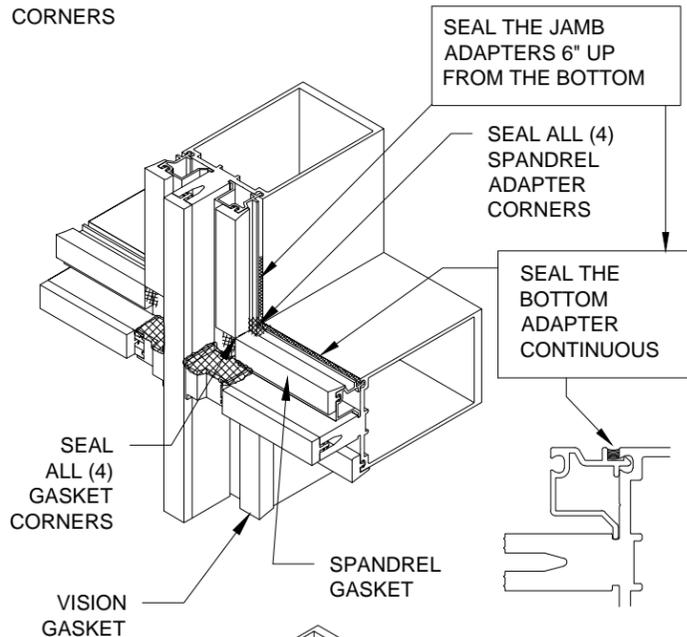
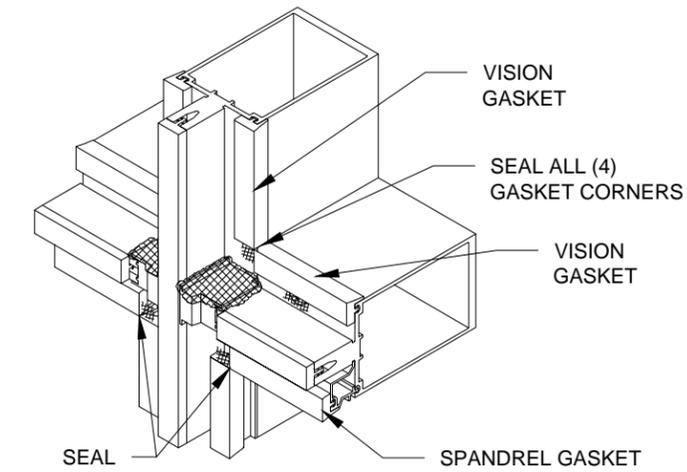
TYPICAL



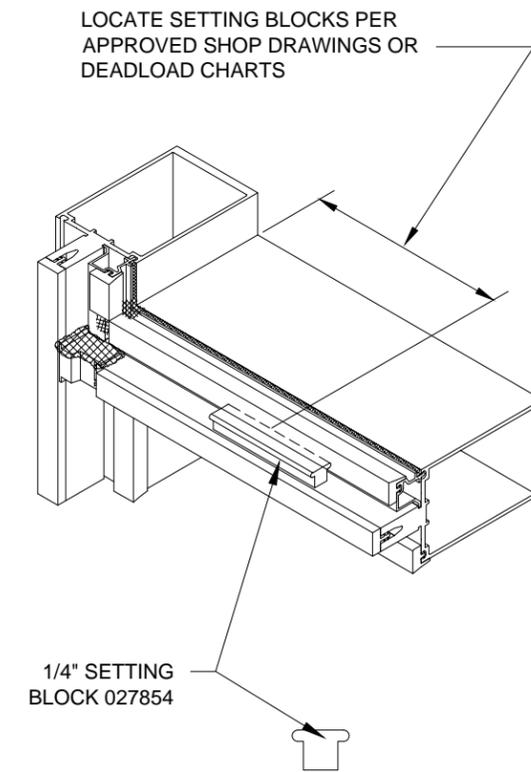
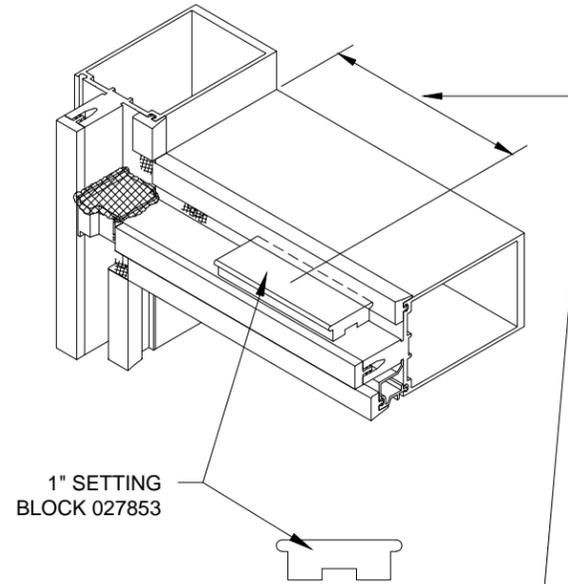
PERIMETER WHERE APPLICABLE



### STEP 12 - INSTALL INTERIOR GLAZING GASKETS



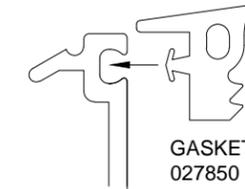
### STEP 13 - INSTALL SETTING BLOCKS



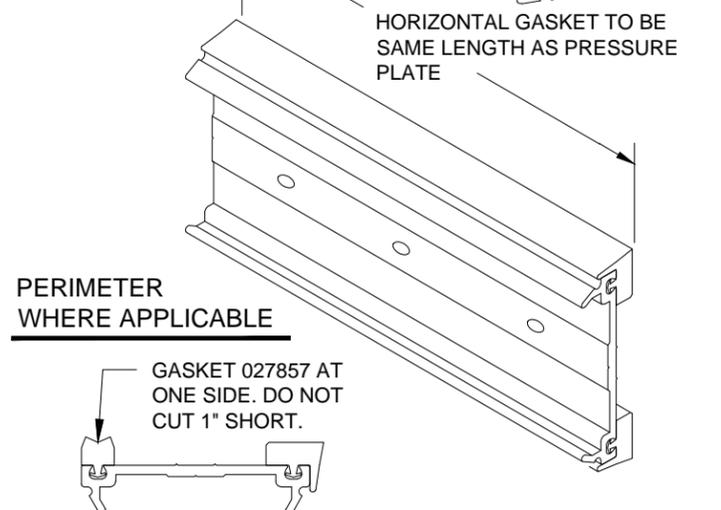
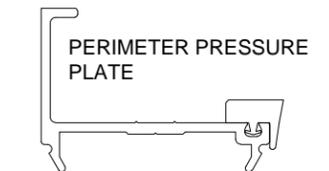
### STEP 14 - INSTALL EXTERIOR GASKETS INTO PRESSURE PLATES

REFERENCE GASKET NOTES IN STEP 12 SAME NOTES APPLY.

REFERENCE INSTRUCTIONS 162983 FOR EXTERIOR FRAME PERIMETERS



VERTICAL GASKETS ARE TO RUN CONTINUOUS EXCEPT AT HEAD AND SILL CONDITIONS THE GASKET IS TO BE CUT 1" SHORT THIS IS FOR THE SEAL AT SECTION D-D STEP 17 - SHEET # 8

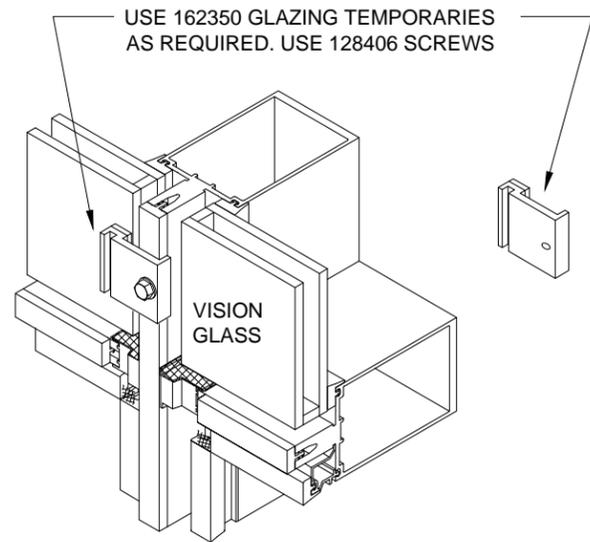


1600 WALL SYSTEM™ 1 CURTAIN WALL INSTALLATION INSTRUCTIONS

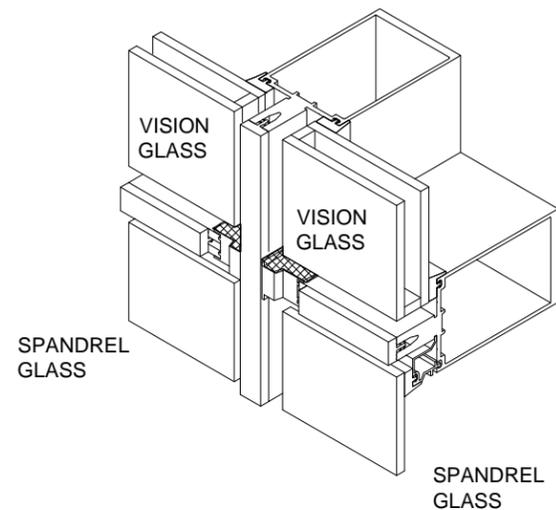
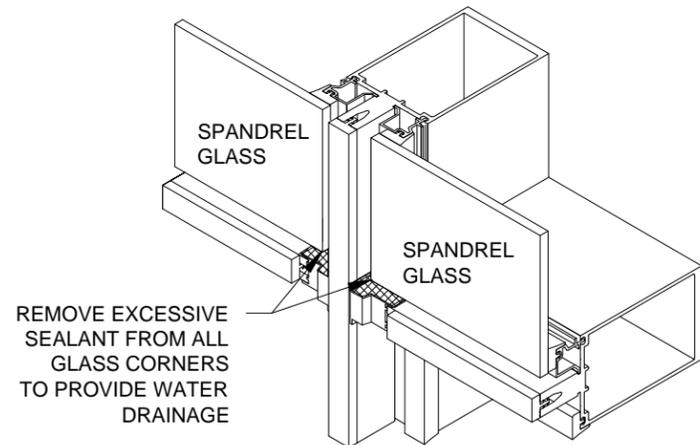
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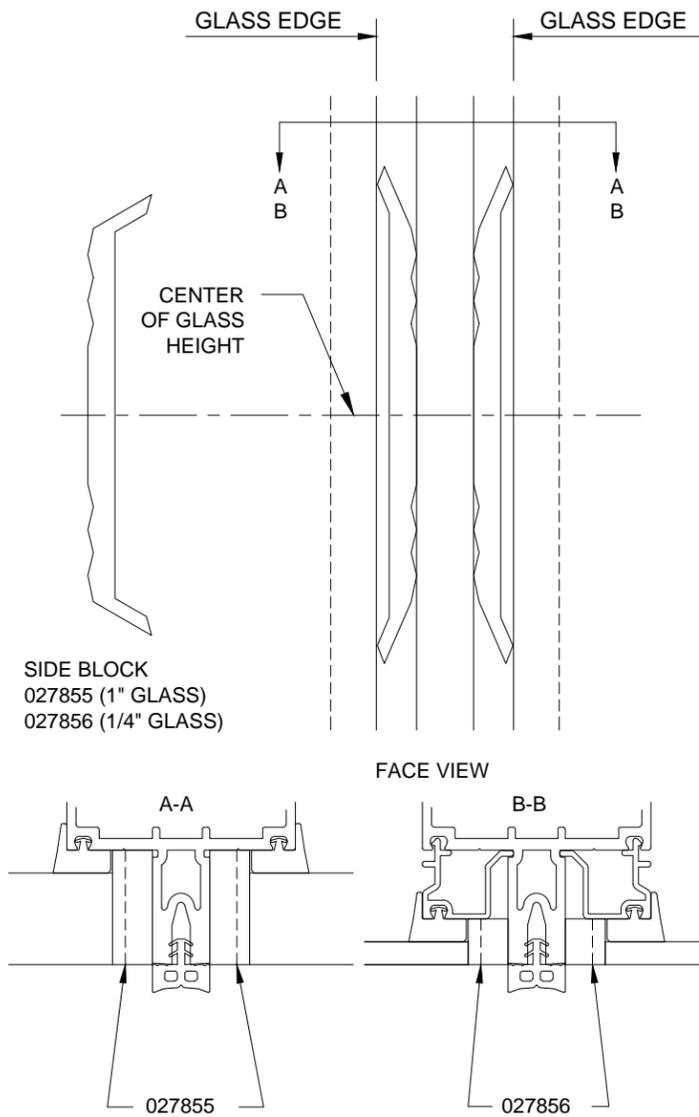
**STEP 15 - INSTALL GLASS**



MAXIMUM TEMPORARY SPACING IS 30". IF WINDS GREATER THAN 50 MPH (80KPH) ARE EXPECTED, ADDITIONAL TEMPORARIES MAY BE REQUIRED. CONSULT YOUR SEALANT AND/OR INFILL SUPPLIER FOR SPACING RECOMMENDATIONS. INSTALL PRESSURE PLATES WHERE POSSIBLE.



**STEP 16 - INSTALL GLASS SIDE BLOCKS**



INSTALL SIDE BLOCKS, COMPRESSING AS SHOWN

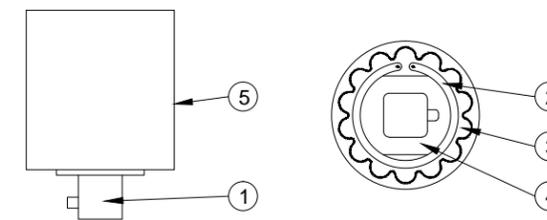
**STEP 17 - INSTALL EXTERIOR PRESSURE PLATES**



RECOMMEND USING TORQUE LIMIT TOOL 162399 SEE NOTE.

**HOW TO SET TORQUE LIMIT**

- 1) ATTACH ANY CALIBRATED TORQUE INDICATOR TO OUTPUT STUB (1) AND DETERMINE PRESENT TORQUE SETTING WHILE HOLDING THE BODY (5), OR VICE-VERSA.
- 2) REMOVE SNAP RING (2) AND LOCKING PLATE (3).
- 3) ADJUST NUT (4) WITH OPEN-END WRENCH : CLOCKWISE TO INCREASE TORQUE, COUNTER- CLOCKWISE TO DECREASE TORQUE.
- 4) OBTAIN NEW TORQUE READING WITH THE CALIBRATED TORQUE INDICATOR. REPEAT PRECEDING STEP IF MORE ADJUSTMENT IS NECESSARY TO REACH DESIRED LIMIT.
- 5) REPLACE LOCKING PLATE INTO NOTCHES AND INSTALL SNAP RING. IF LOCKING PLATE DOES NOT "SEAT", MOVE THE ADJUSTING NUT SLIGHTLY UNTIL IT DROPS IN PLACE. THE DIRECTION IS BEST DETERMINED BY WHETHER A MINIMUM TORQUE APPLICATION OR A MAXIMUM ONE IS DESIRED.



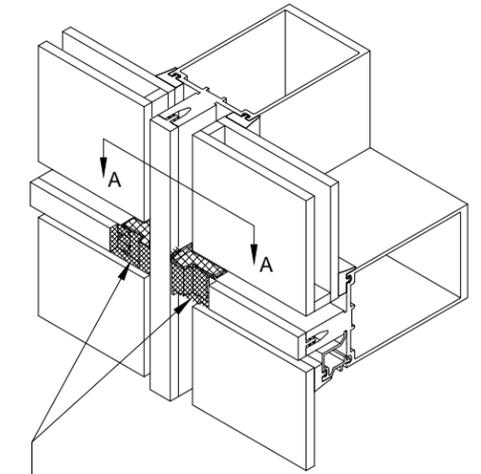
INSTALL PRESSURE PLATES USING SCREWS 128406 1/4-14 X 1" HEX WASHER HEAD TYPE AB.

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

INSTALL HORIZONTAL PRESSURE PLATES WITH WEEP HOLES TOWARDS TOP OF HORIZONTAL.

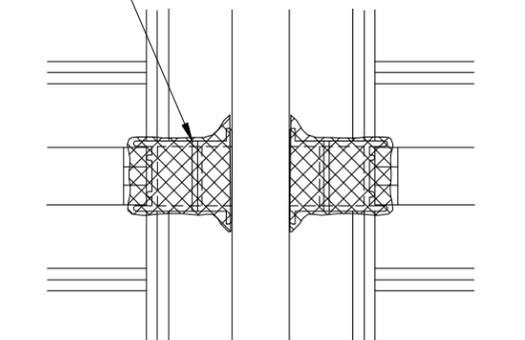
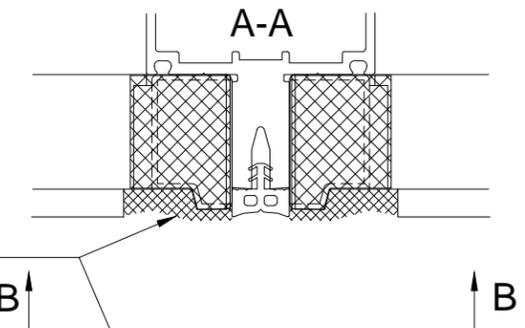
AT EACH HORIZONTAL AND VERTICAL PRESSURE PLATE INSTALL TWO SCREWS PART WAY, THEN INSTALL THE THIRD SCREW ALL THE WAY, AND THEN TIGHTEN THE FIRST TWO SCREWS. THIS ELIMINATES LATERAL WALKING OF THE PRESSURE PLATE POSITION.

TORQUE ALL SCREWS TO 95 TO 100 INCH POUNDS. DURING COLD WEATHER, TORQUE SCREWS TO 50 INCH POUNDS UNTIL ALL 4 SIDES HAVE BEEN CLAMPED. THEN TORQUE SCREWS TO 95 TO 100 INCH POUNDS.



JUST BEFORE INSTALLING VERTICAL PRESSURE PLATES APPLY A GENEROUS AMOUNT OF SEALANT TO THE JOINT PLUG FACE FILLING JOINTS AS SHOWN.

CLEAN JOINT PER SEALANT MANUFACTURER'S RECOMMENDATIONS



B-B



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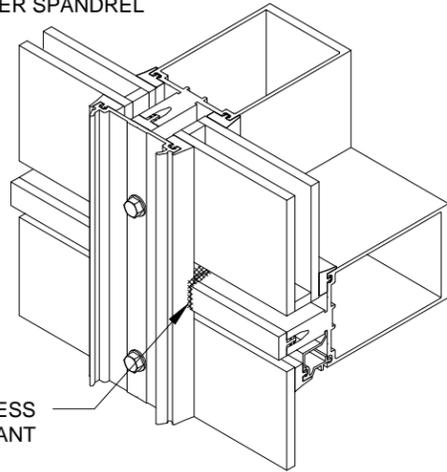
162970 SHEET 07 OF 09

# STEP 17 - INSTALL EXTERIOR PRESSURE PLATES

## INSTALL VERTICAL PRESSURE PLATES

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

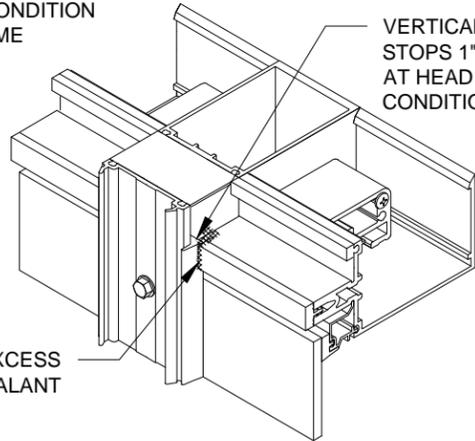
INTERMEDIATE HORIZONTAL VISION OVER SPANDREL



TOOL EXCESS SEALANT

HEAD CONDITION SILL SAME

VERTICAL GASKET STOPS 1" SHORT AT HEAD AND SILL CONDITIONS

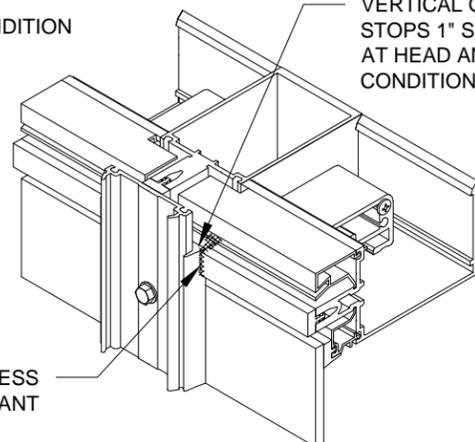


TOOL EXCESS SEALANT

### PERIMETER FILLER

HEAD CONDITION SILL SAME

VERTICAL GASKET STOPS 1" SHORT AT HEAD AND SILL CONDITIONS

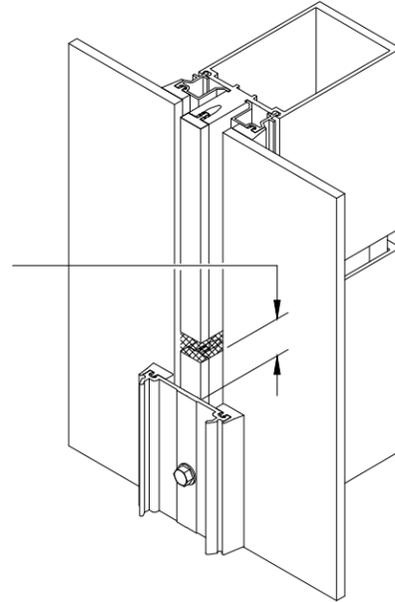


TOOL EXCESS SEALANT

## INSTALL VERTICAL PRESSURE PLATES

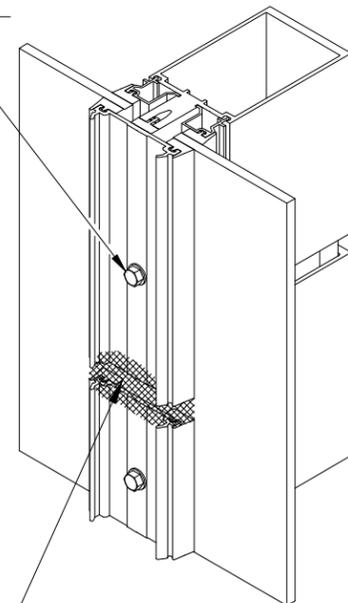
### VERTICAL EXPANSION JOINTS

TOP OF VERTICAL MULLION TO TOP OF PRESSURE PLATE IS 1-1/2"



AT TOP PRESSURE PLATE LOCATE SCREW CLOSE TO THE MULLION JOINT BUT NOT BELOW THE JOINT

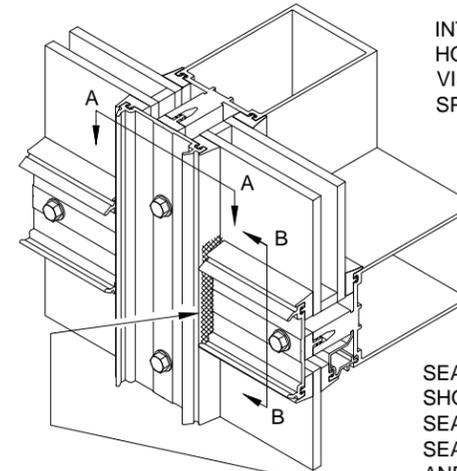
CLEAN JOINT PER SEALANT MANUFACTURER'S RECOMMENDATIONS



COMPLETELY SEAL JOINT. DO NOT LET SEALANT INTERFERE WITH COVER SNAP. OVERLAP PRESSURE PLATE FACE CREATING A BAND-AID SEAL.

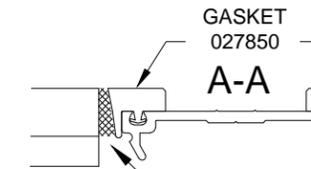
## INSTALL HORIZONTAL PRESSURE PLATES

CENTER HORIZONTAL PRESSURE PLATES SO END GAPS ARE EQUAL.



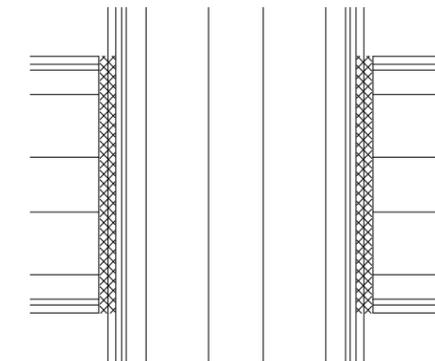
INTERMEDIATE HORIZONTAL VISION OVER SPANDREL

SEAL JOINTS AS SHOWN. TOOL SEALANT. THIS SEAL IS TO JOIN AND ADHERE TO THE JOINT PLUG SEALS



CLEAN JOINT PER SEALANT MANUFACTURER'S RECOMMENDATIONS

DO NOT LET THE SEAL INTERFERE WITH THE COVER SNAP



FACE VIEW

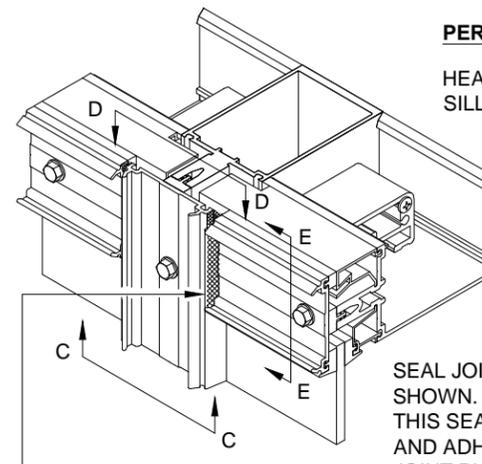
GASKET 027850

B-B

GASKET 027850

### PERIMETER FILLER

HEAD HORIZONTAL SILL SAME

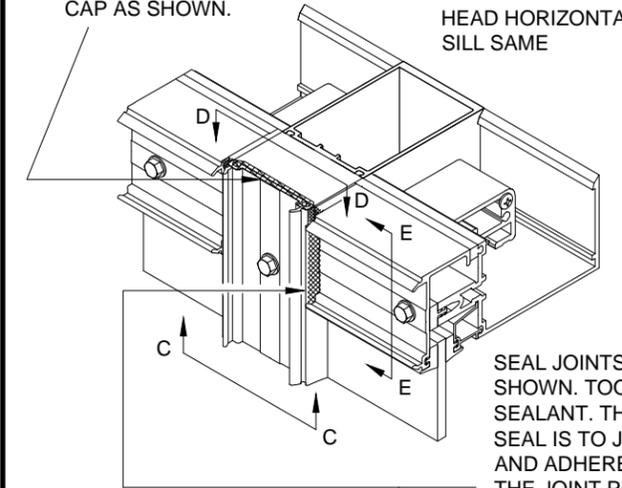


SEAL JOINTS AS SHOWN. TOOL SEALANT. THIS SEAL IS TO JOIN AND ADHERE TO THE JOINT PLUG SEALS.

REFERENCE INSTRUCTIONS 162983 FOR EXTERIOR FRAME PERIMETERS

SEAL BETWEEN PRESSURE PLATE AND HEAD/SILL END CAP AS SHOWN.

HEAD HORIZONTAL SILL SAME



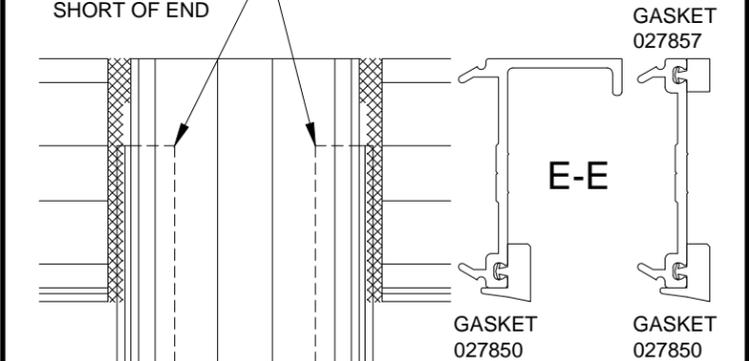
SEAL JOINTS AS SHOWN. TOOL SEALANT. THIS SEAL IS TO JOIN AND ADHERE TO THE JOINT PLUG SEALS.

D-D

CLEAN JOINT PER SEALANT MANUFACTURER'S RECOMMENDATIONS

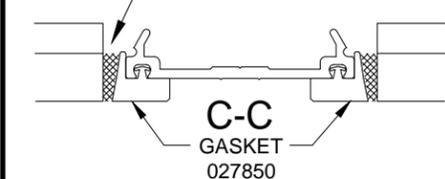
DO NOT LET THE SEAL INTERFERE WITH THE COVER SNAP

VERTICAL GASKET STOPS 1" SHORT OF END



FACE VIEW

DO NOT LET THE SEAL INTERFERE WITH THE COVER SNAP



C-C GASKET 027850



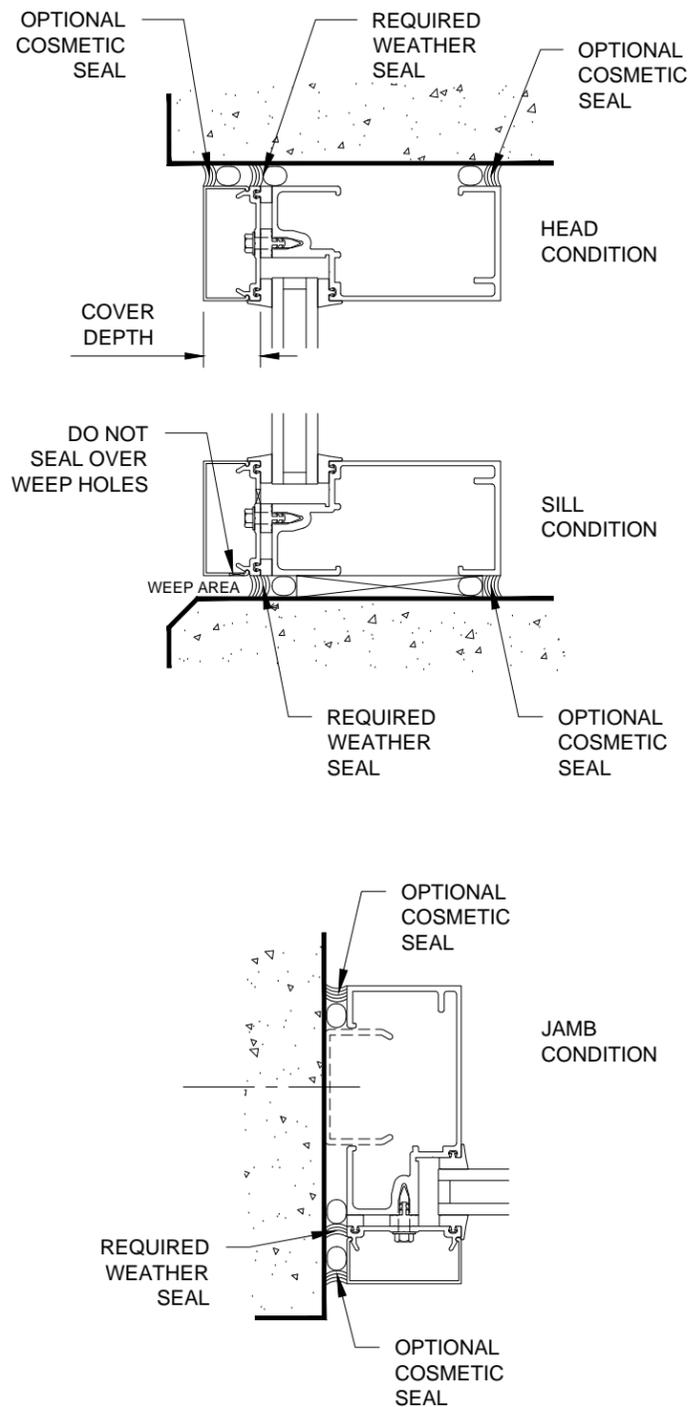
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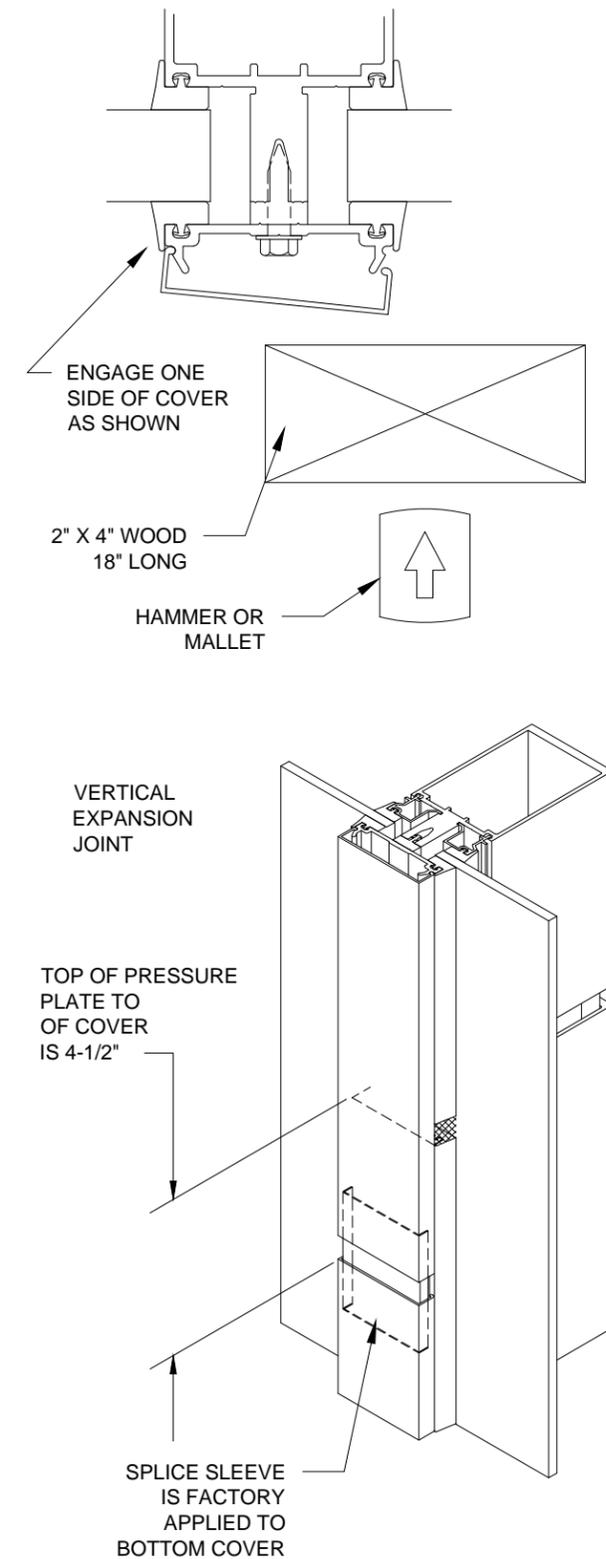
### STEP 18 - INSTALL PERIMETER WEATHER SEALS

PERIMETER WEATHER SEALS ARE INSTALLED AT THE PRESSURE PLATE LOCATION AS DETAILED BELOW. (THIS SEAL SHOULD BE INSTALLED BEFORE COVERS ARE APPLIED WHEN COVERS DEEPER THAN 3/4" ARE USED) EXTERIOR COSMETIC SEALS AT THE COVER MAY BE APPLIED AT THE HEAD, JAMB AND SILL. COSMETIC SEAL AT SILL COVERS MUST ALL WATER DRAINAGE TO THE EXTERIOR.



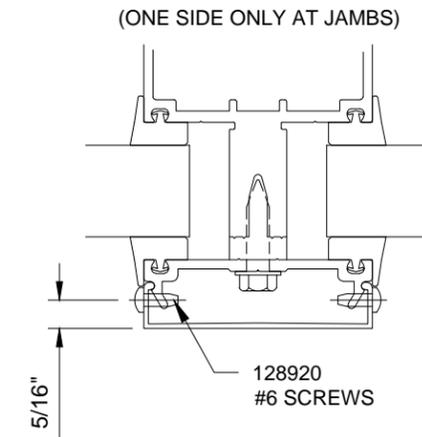
### STEP 19 - INSTALL EXTERIOR COVERS

CARE MUST BE TAKEN TO AVOID DAMAGE TO COVERS DURING INSTALLATION. USE A 18" LONG PIECE OF 2" X 4" WOOD ALONG WITH A HAMMER OR Mallet TO SEAT THE COVER.



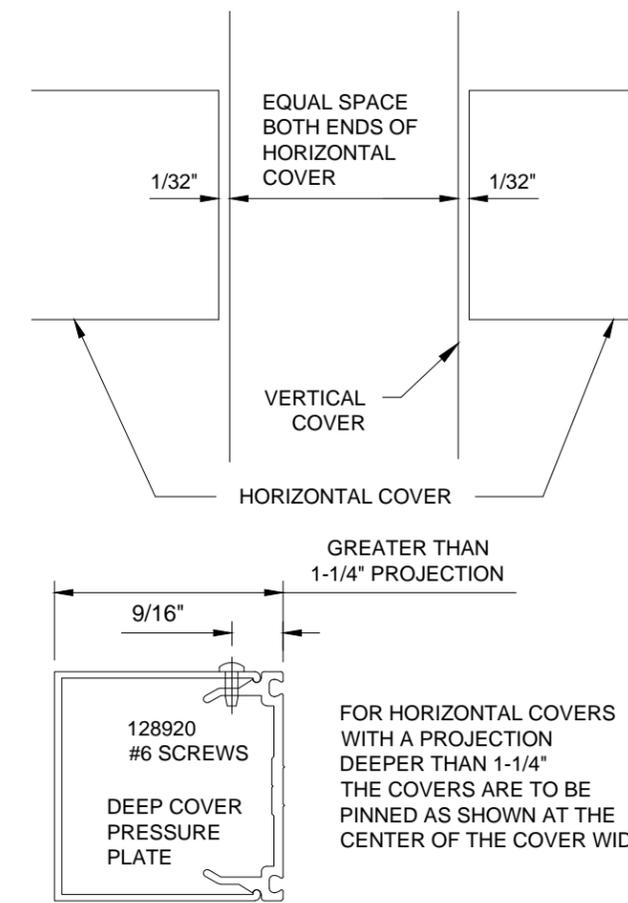
### STEP 19 - INSTALL EXTERIOR COVERS

PINNING OF ALL VERTICAL COVERS IS REQUIRED FOR BOTH SIDES. DRILL A 0.106 DIA. HOLE (#36 DRILL) AND INSTALL 128920 SCREWS #6 X 3/8" PAN HEAD TYPE B. LOCATE PINNING AT A HORIZONTAL CLOSEST TO THE COVER HEIGHT CENTER.



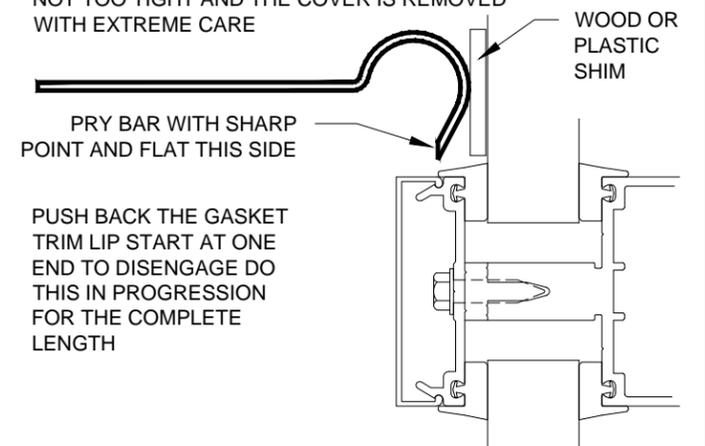
NOTE FOR 5" SIGHTLINE COVERS  
DUE TO LARGE EXTRUSION TOLERANCES, 5" SIGHTLINE COVERS MAY REQUIRE SEALANT OR PINNING TO HOLD IN PLACE.

INSTALL HORIZONTAL COVERS WITH THE WEEP HOLES DOWN



### REMOVING COVERS

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



PUSH BACK THE GASKET TRIM LIP START AT ONE END TO DISENGAGE DO THIS IN PROGRESSION FOR THE COMPLETE LENGTH