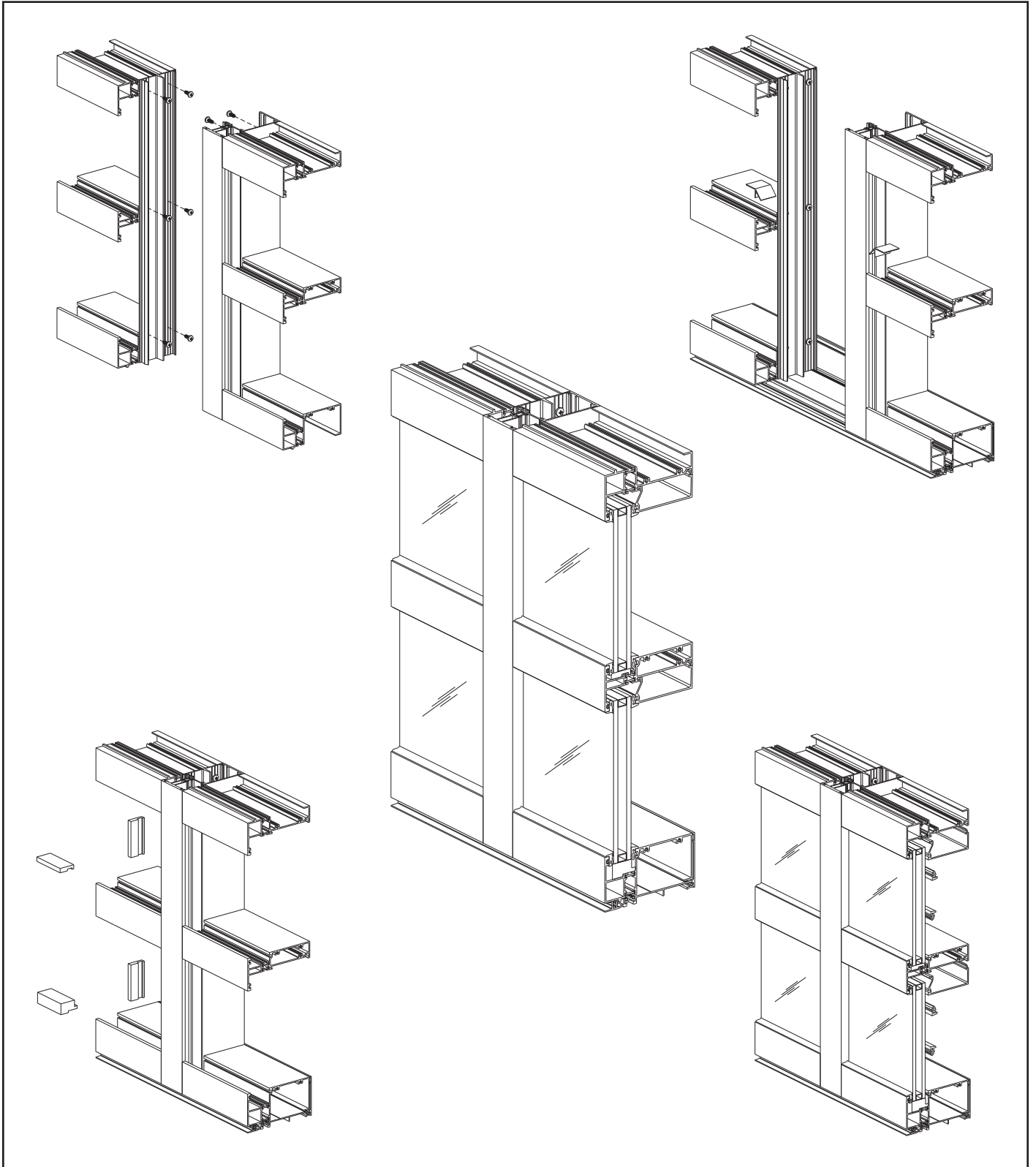


YWW 50 T Thermal Window Wall System



Installation Manual

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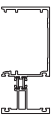

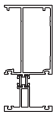
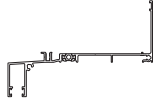


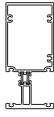

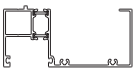
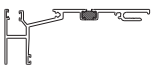
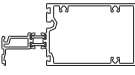

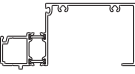
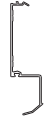






DOOR FRAME INSTALLATION

Install Door Frame Page 50








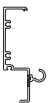
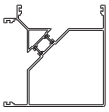

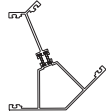
Installation Notes

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 quantity and quality 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 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 that 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. If any questions arise concerning YKK AP products or their installation, contact YKK AP for clarification before proceeding.
12. YKK AP store front and/or curtain wall framing is typically completed before drywall, flooring and other products that may still be in process.
13. Cutting tolerances are plus zero, minus one thirty second unless otherwise noted.
14. Check our website, www.ykkap.com, for the latest installation manual update prior to commencing work.

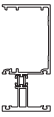

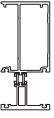
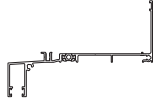

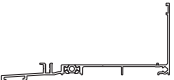
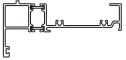

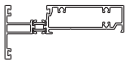
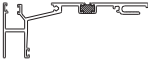




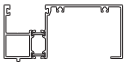





FRAMING MEMBERS FOR OUTSIDE GLAZING

	Vertical	BE9-8707		Sill Flashing	BE9-2818
	Vertical Heavy Duty	BE9-8789		Sill Flashing With Integral Receptor	BE9-2812
	Snap-In Filler Use with BE9-8707 and BE9-8789	E9-8715		Sill Flashing	BE9-2814
	Vertical For Continuous Head & Sill Construction	BE9-2803		Slab Edge Cover Receptor Use with BE9-2814	E9-8222
	Head / Jamb	BE9-2816		Head Receptor	BE9-2819
	Horizontal	BE9-8728		Snap Cover Use with BE9-2819	E9-8720
	Sill	BE9-2823		Pocket Filler	BE9-8734
	Exterior Glass Stop Use with BE9-2823 & BE9-8728	E9-1715		Glazing Adapter For 1/4" glazing Use with BE9-8734	E9-1725
	Deep Pocket Glazing Adaptor For 1/4" Glazing	E9-1707		6-1/8" Slab Edge Cover For use with 5-1/8" Slab	E9-8059
	Shallow Pocket Glazing Adaptor For 1/4" Glazing	E9-1708		6-5/8" Slab Edge Cover For use with 5-5/8" Slab	E9-7723









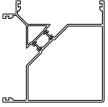

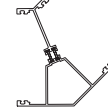
FRAMING MEMBERS FOR OUTSIDE GLAZING

	<p>7-3/8" Slab Edge Cover For use with 6-3/8" Slab</p>	<p>E9-8223</p>	 <p>Expansion Mullion Female Elastomer Weathering E2-0065 not Included</p>	<p>BE9-8708</p>
	<p>7-7/8" Slab Edge Cover For use with 6-7/8" Slab</p>	<p>E9-8231</p>	 <p>Expansion Mullion Male</p>	<p>BE9-2827</p>
	<p>8" Slab Edge Cover For use with 7" Slab</p>	<p>E9-8589</p>	 <p>Slip-On Face Cap Use with BE9-2827</p>	<p>E9-1763</p>
	<p>9" Slab Edge Cover For use with 8" Slab</p>	<p>E9-8428</p>	 <p>Hinged Mullion Female</p>	<p>BE9-7912</p>
	<p>90° Corner Mullion Use with (2) BE9-8734</p>	<p>BE9-8731</p>	 <p>Outside Hinged Mullion Male 3° to 20°</p>	<p>BE9-7911</p>
	<p>135° Outside Corner Mullion Use with (2) BE9-8734</p>	<p>BE9-8725</p>		





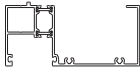

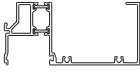
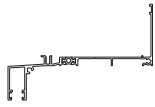
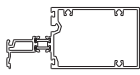

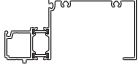


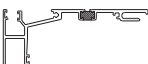






FRAMING MEMBERS FOR INSIDE GLAZING

	Vertical	BE9-8707		Sill Flashing	BE9-2818
	Vertical Heavy Duty	BE9-8789		Sill Flashing With Integral Receptor	BE9-2812
	Snap-In Filler Use with BE9-8707	E9-8715		Sill Flashing	BE9-2814
	Head For vertical through applications	BE9-8703		Slab Edge Cover Receptor Use with BE9-2814	E9-8222
	Horizontal	BE9-8704		Head Receptor	BE9-2819
	Glass Stop For 1" Glazing Use with BE9-8703 & BE9-8704	E9-8711		Snap Cover Use with BE9-2819	E9-8720
	Glass Stop For 1/4" Glazing Use with BE9-8703 & BE9-8704	E9-7703		Pocket Filler	BE9-8734
	Sill / Jamb	BE9-2816		Glazing Adapter For 1/4" glazing Use with BE9-8734	E9-1725
	Deep Pocket Glazing Adaptor For 1/4" Glazing	E9-1707		6-1/8" Slab Edge Cover For use with 5-1/8" Slab	E9-8059
	Shallow Pocket Glazing Adaptor For 1/4" Glazing	E9-1708		6-5/8" Slab Edge Cover For use with 5-5/8" Slab	E9-7723








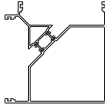
FRAMING MEMBERS FOR INSIDE GLAZING

	<p>7-3/8" Slab Edge Cover For use with 6-3/8" Slab</p>	<p>E9-8223</p>	 <p>Expansion Mullion Female Elastomer Weathering E2-0065 not Included</p>	<p>BE9-8708</p>
	<p>7-7/8" Slab Edge Cover For use with 6-7/8" Slab</p>	<p>E9-8231</p>	 <p>Expansion Mullion Male</p>	<p>BE9-2827</p>
	<p>8" Slab Edge Cover For use with 7" Slab</p>	<p>E9-8589</p>	 <p>Slip-On Face Cap Use with BE9-2827</p>	<p>E9-1763</p>
	<p>9" Slab Edge Cover For use with 8" Slab</p>	<p>E9-8428</p>	 <p>Hinged Mullion Female</p>	<p>BE9-7912</p>
	<p>90° Corner Mullion Use with (2) BE9-8734</p>	<p>BE9-8731</p>	 <p>Outside Hinged Mullion Male 3° to 20°</p>	<p>BE9-7911</p>
	<p>135° Outside Corner Mullion Use with (2) BE9-8734</p>	<p>BE9-8725</p>		





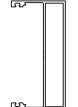






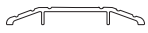
FRAMING MEMBERS FOR STRUCTURAL SILICONE GLAZING

	Vertical For Structural Silicone Glazing	E9-2805		SSG Expansion Mullion Female	E9-2824
	Glazing Adaptor For 1/4" Glazing Use with E9-2805	E9-2716		SSG Expansion Mullion Male	E9-2825
	Head / Jamb / Sill	BE9-2816		Sill Flashing	BE9-2818
	Head For Spliced Runs Longer than 24'-0"	BE9-2801		Sill Flashing With Integral Receptor	BE9-2812
	Horizontal	BE9-8728		Sill Flashing	BE9-2814
	Sill For Spliced Runs Longer than 24'-0"	BE9-2823		Slab Edge Cover Receptor Use with BE9-2814	E9-8222
	Exterior Glass Stop Use with BE9-8728 & BE9-8706	E9-1715		Head Receptor	BE9-2819
	Exterior Glass Stop Use with BE9-2801	E9-1730		Snap Cover Use with BE9-2819	E9-8720
	Deep Pocket Glazing Adaptor For 1/4" Glazing	E9-1707		Pocket Filler	BE9-8734
	Glazing Adaptor For 1/4" Glazing	E9-1708		Glazing Adaptor For 1/4" glazing Use with BE9-8734	E9-1725


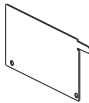

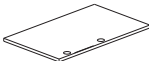
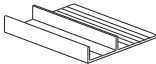
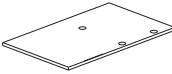
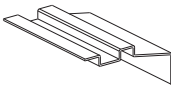

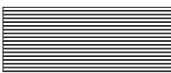

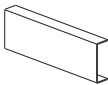
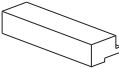
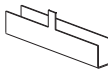

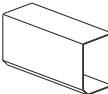



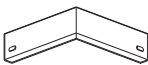

FRAMING MEMBERS FOR STRUCTURAL SILICONE GLAZING

 <p>6-1/8" Slab Edge Cover For use with 5-1/8" Slab</p>	<p>E9-8059</p>	 <p>8" Slab Edge Cover For use with 7" Slab</p>	<p>E9-8589</p>
 <p>6-5/8" Slab Edge Cover For use with 5-5/8" Slab</p>	<p>E9-7723</p>	 <p>9" Slab Edge Cover For use with 8" Slab</p>	<p>E9-8428</p>
 <p>7-3/8" Slab Edge Cover For use with 6-3/8" Slab</p>	<p>E9-8223</p>	 <p>90° Corner Mullion For structural silicone glazing</p>	<p>E9-2821</p>
 <p>7-7/8" Slab Edge Cover For use with 6-7/8" Slab</p>	<p>E9-8231</p>	 <p>90° Corner Mullion Use with (2) BE9-8734</p>	<p>BE9-8731</p>

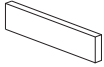
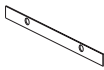

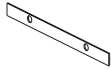
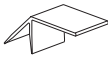
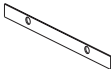

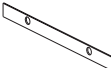


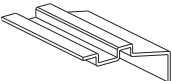

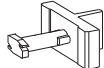







DOOR FRAMING MEMBERS

	<p>Single Acting Door Jamb 2-1/4" x 5" Elastomer Weathering E2-0051 Included</p>	<p>AS-2807</p>	 <p>Glazing Pocket Flush Filler For 1" Glazing</p>	<p>BE9-7856</p>
	<p>Single Acting Transom Bar 2-1/4" x 5" E2-0051 Included</p>	<p>AS-2808</p>	 <p>Glazing Pocket Flush Filler For 1" Glazing</p>	<p>BE9-2721</p>
	<p>Double Acting Door Jamb 2-1/4" x 5"</p>	<p>E9-2809</p>	 <p>Glazing Adaptor For 1/4" Glazing Use with BE9-8734 & E9-1721</p>	<p>E9-1725</p>
	<p>Double Acting Transom Bar 2-1/4" x 5" E2-0062 Included</p>	<p>AS-2810</p>	 <p>Transom Glazing Pocket For 1" Glazing</p>	<p>E9-1721</p>
	<p>Intermediate Door Jamb 2" x 5" Tube Use with AS-0401 Door Stop</p>	<p>E9-8439</p>	 <p>Door Stop Assembly E9-0409 & E9-1113 (Mill) Elastomer Weathering E2-0051 Included</p>	<p>AS-0401</p>
	<p>Jamb Filler</p>	<p>BE9-8734</p>	 <p>Threshold 1/2" x 4"</p>	<p>E9-0407</p>











ACCESSORIES

 <p>Shear Block For BE9-8728 Horizontal Use (2) PC-1228 & (2) FC-1212 not Included</p>	E1-2802	 <p>End Dam For BE9-2818 Sill Flashing</p>	E1-2808
 <p>Shear Clip For BE9-8704 Horizontal Use (4) PC-1210 not Included</p>	E1-2801	 <p>SSG Mullion End Cap</p>	E1-2805
 <p>"F" Anchor For Head & Jamb</p>	E1-2803	 <p>Expansion Mullion End Cap</p>	E1-2806
 <p>Splice Sleeve For Head Receptor</p>	E1-2813	 <p>End Cap For Head Receptor</p>	E1-9957
 <p>Splice Sleeve For Sill Flashing and Head Receptor</p>	E2-0070	 <p>Setting Block / Side Block 1" Glazing</p>	E2-0184
 <p>Joint Sleeve For Head & Sill (Forward Chamber)</p>	E1-1027	 <p>Setting Block For Sill 1" Glazing</p>	E2-0182
 <p>Joint Sleeve For SSG Head & Sill (Forward Chamber)</p>	E1-1028	 <p>Setting Block For Horizontal 1/4" Glazing</p>	E2-0192
 <p>Joint Sleeve For Head & Sill (Rear Chamber)</p>	E1-2804	 <p>Setting Block For Sill 1/4" Glazing</p>	E2-0190
 <p>Water Deflector For Horizontals at Structural Silicone Glazed Verticals</p>	E1-1038	 <p>Setting Block Use with BE9-2819</p>	E2-0054
 <p>Water Deflector For Horizontals at 90° Structural Silicone Glazed Corners</p>	E1-1039	 <p>Weep Baffle</p>	E2-0099

ACCESSORIES

	Side Block	E2-0186		End Cap Use with E9-8223	E1-9953
	Anti-Walk Block For Deep Pocket	E2-0153		End Cap Use with E9-8231	E1-9954
	Water Deflector	E2-0047		End Cap Use with E9-8589	E1-9955
	End Dam For Frame Ends Where Head & Sill Run Through	E2-0193		End Cap Use with E9-8428	E1-9956
	End Dam For Frame Ends Where Head & Sill Run Through	E2-0194		Push-In Glazing Gasket	E2-0801
	Reinforcement Use with BE9-2819	E1-2812		Wedge Glazing Gasket	E2-0808
	Temporary Glass Retainer For 1" Structural Silicone Glazing	E3-0001		Push-In Glazing Gasket For SSG Glazing	E2-0541
	Temporary Glass Retainer For 1/4" Structural Silicone Glazing	E3-0006		Wedge Glazing Gasket For SSG Glazing	E2-0542
	End Cap Use with E9-8059	E1-9984		SSG Glazing Spacer For Inside Glazing	E2-0543
	End Cap Use with E9-7723	E1-9985		SSG Glazing Spacer For Outside Glazing	E2-0544

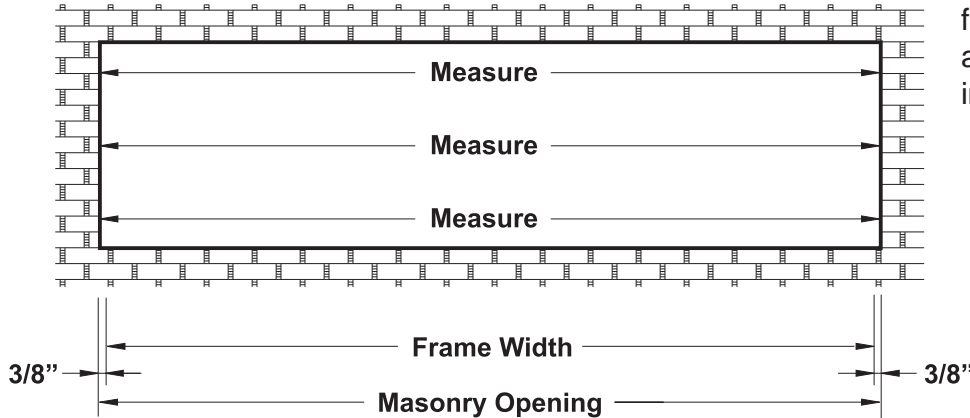
ACCESSORIES

 <p>Weathering Gasket For Expansion Mullion</p>	<p>E2-0065</p>	 <p>#12 x 3/4" FHSMS Type AB For Attachment of Horizontal to Shear Block E1-1037</p>	<p>FC-1212</p>
 <p>Steel Reinforcing 3/16" x 2-3/4" Use with E9-8443, E9-2805</p>	<p>E1-2811</p>	 <p>#12 x 5/8" PHSMS Type AB For Attachment of Shear Clip E1-1040 to Vertical & Horizontal</p>	<p>PC-1210</p>
 <p>#8 x 1/2" FHSMS Type AB For Attachment of Hinged Mullions</p>	<p>FC-0808</p>	 <p>#12 x 1" PHSMS Type AB For Screw Spline Attachment</p>	<p>PC-1216</p>
 <p>#10 x 3/8" FHSMS Type AB For Attachment of Mullion End Caps</p>	<p>FC-1006</p>	 <p>#12 x 1-1/4" PHSMS Type AB For Screw Spline Attachment When Using BE9-1704 as Jamb</p>	<p>PC-1220</p>
 <p>#10 x 5/8" PHSMS Type AB For Attachment of E9-1724 Adaptor</p>	<p>PC-1010</p>	 <p>#12 x 1-3/4" PHSMS Type AB For Attachment of Shear Block E1-2802 to Vertical</p>	<p>PC-1228</p>

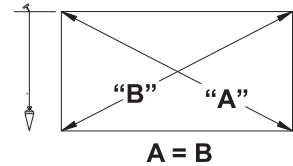
FRAME FABRICATION

STEP 1
DETERMINE FRAME SIZE

Determine Frame Width:



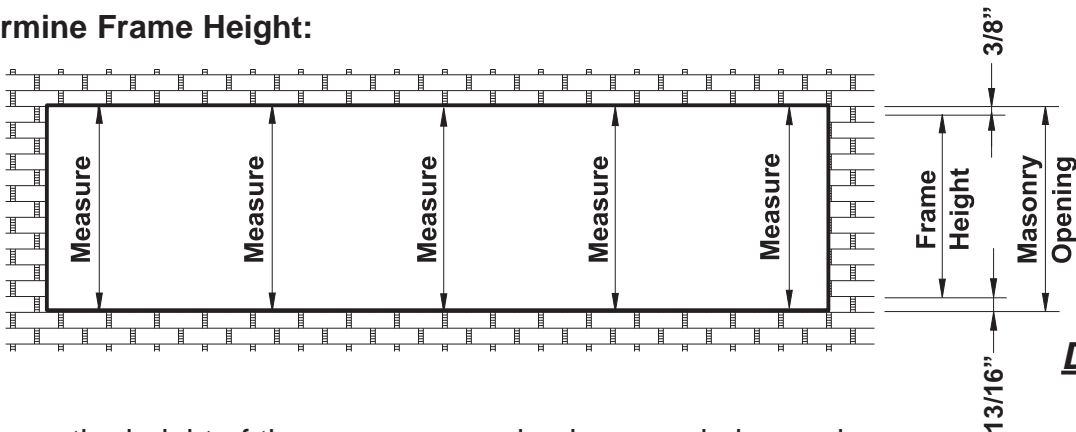
Note: Check the opening for squareness and plumb at both ends. Units must be installed in a true rectangle.



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 determine the frame width.
- See **Detail 1**.

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" for the shim/caulk joint at the head.
 - 7/16" for the sill flashing.
 - 3/8" for the shim/caulk joint below the sill flashing.

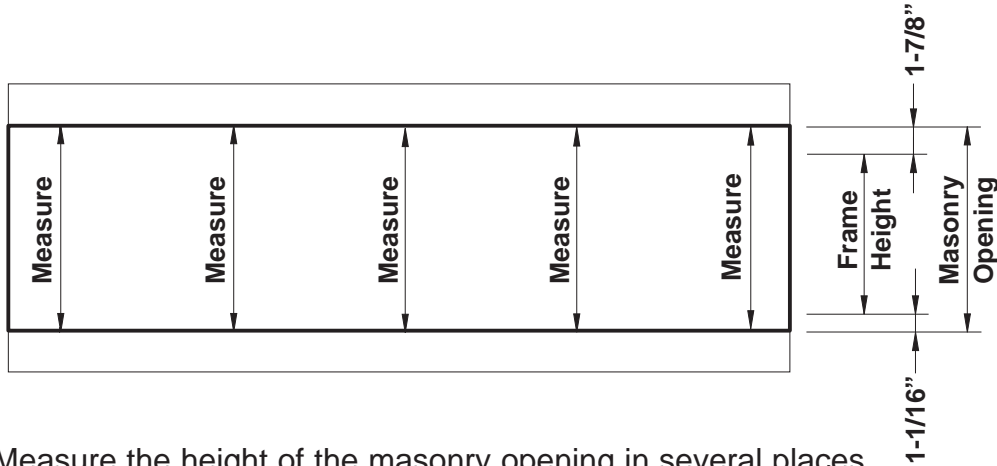
See **Detail 2**.

NOTE: Vertical through frame widths over 24'-0" require expansion mullions every 12 to 15 feet.

FRAME FABRICATION

STEP 1 (Continued) DETERMINE FRAME SIZE

Determine Frame Height for Slab Edge Conditions:

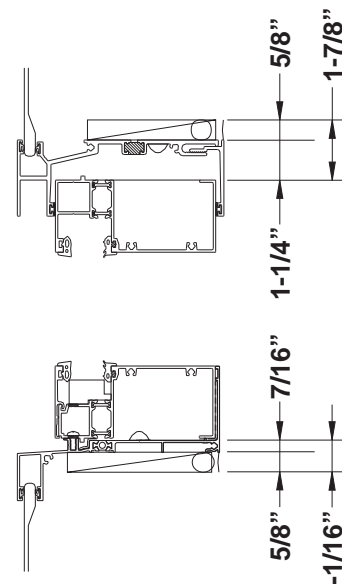


Detail 3

- Measure the height of the masonry opening in several places along the entire length of the opening.
- Select the smallest dimension measured and subtract 2-15/16" to determine the frame height to be used:
 - 5/8" for the shim/caulk joint at the head.
 - 1-1/4" for the head receptor.
 - 7/16" for the sill flashing.
 - 5/8" for the shim/caulk joint below the sill flashing.

See **Detail 3**.

NOTE: Vertical through frame widths over 24'-0" require expansion mullions every 12 to 15 feet.

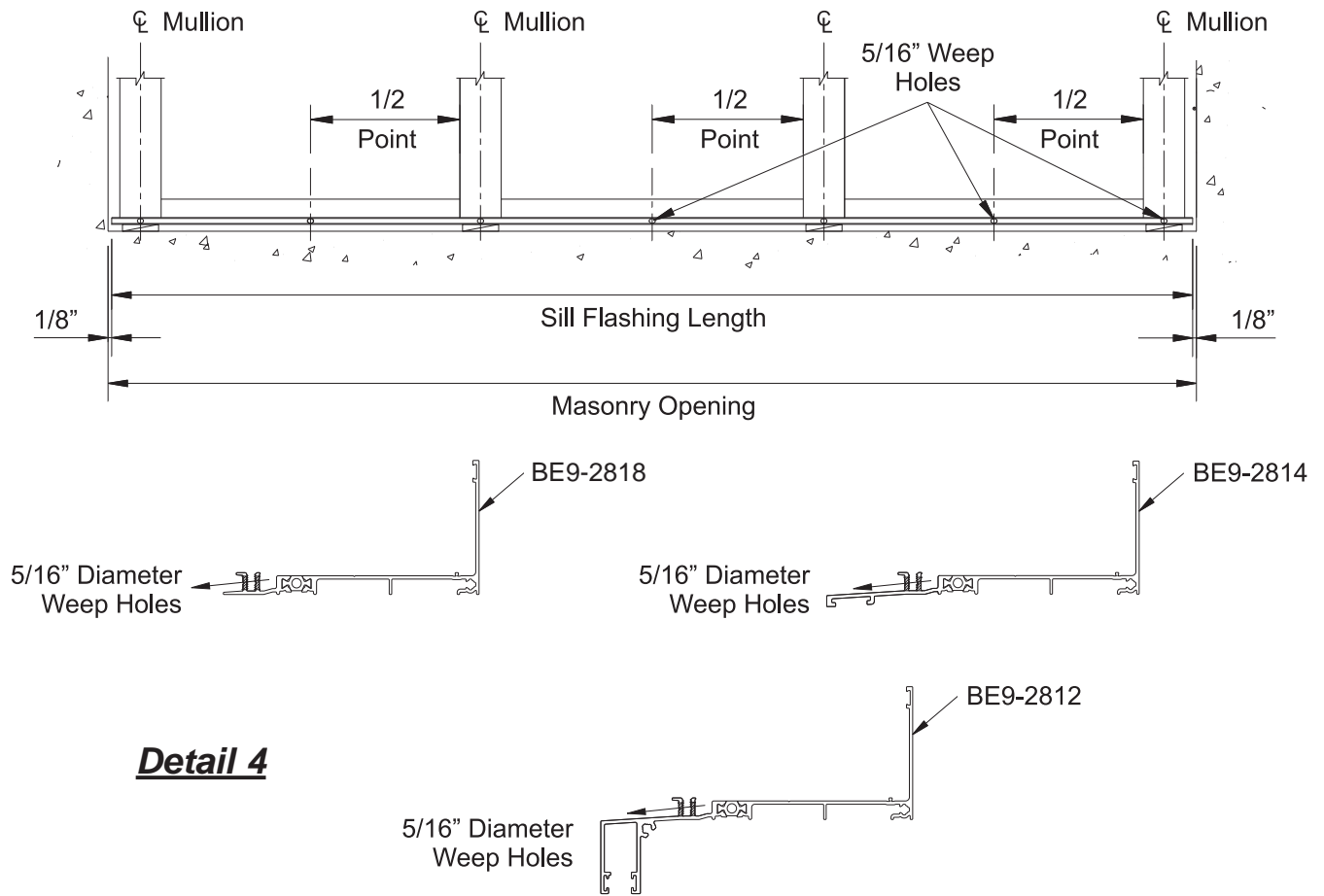


FRAME FABRICATION

**STEP 2
FABRICATE SILL FLASHING**

YWW 50 T requires the use of extruded sill flashing for vertical through frames:

- Cut the sill flashing, BE9-2812, BE9-2818, BE9-2814 as determined in **Step 1**: Masonry Opening width minus(-) 1/4" (1/8" at each jamb).
- For openings longer than 24'-0" the sill flashing needs to be spliced every twelve to fifteen feet.
- Allow for a 3/8" splice joint between sill flashing members.
- Mark the centerline of each vertical mullion on the sill flashing.



-Drill a 5/16" diameter weep hole in the face of the sill flashing at the centerline of each vertical mullion and at the midpoints between vertical mullions.

See **Detail 4**.

NOTE: Sill flashing is not required when head and sill members run continuous.

FRAME FABRICATION

STEP 3 FABRICATE HEAD & SILL MEMBERS

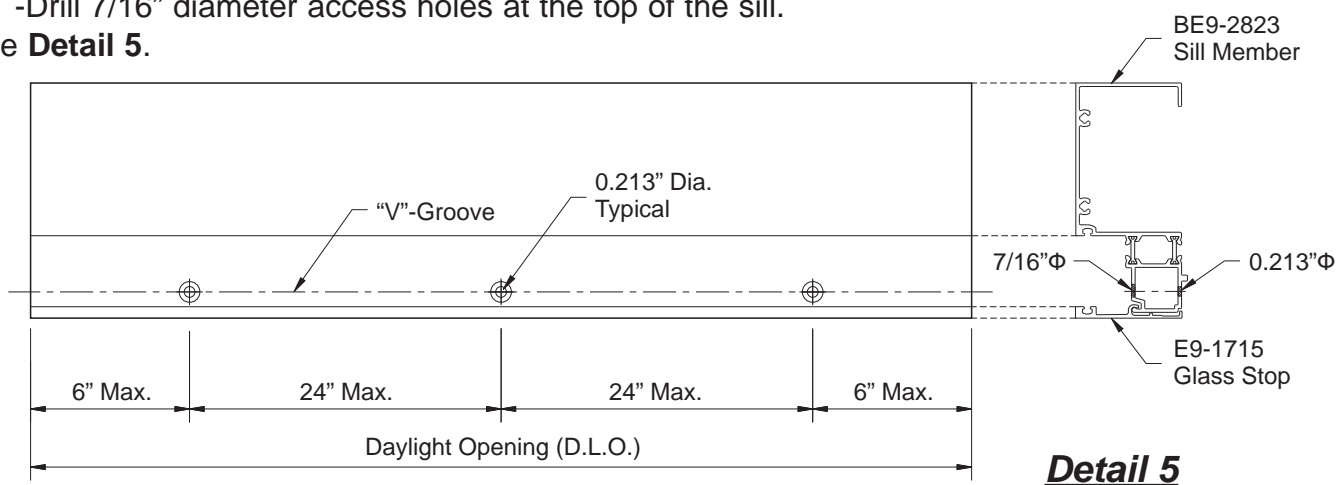
FOR VERTICAL THROUGH FRAMES

-Cut all head and sill members to the daylight opening between verticals.

Sill members require additional fabrication for anchoring to the sill flashing.

- Measure in 6" from each end of the sill member and mark hole locations along the glazing pocket "V"-groove.
- Mark additional hole locations a maximum of 24" on center (O.C.).
- Drill 0.213" diameter (#3 drill bit) holes at the underside of the "V" groove.
- Drill 7/16" diameter access holes at the top of the sill.

See **Detail 5**.



FOR CONTINUOUS HEAD & SILL FRAMES (YWW 50 T SSG Only)

With the YWW 50 T Structural Silicone Glazed (SSG) option, head and sill members may run continuously across the frame.

For Frames 24'-0" or shorter:

- Cut the head and sill members, BE9-2816, to the frame width determined in **Step 1**.

For Frames Longer Than 24'-0":

- Head member BE9-2801 and sill member BE9-2823 must be used instead of BE9-2816.
- Determine the location of the expansion mullions from the shop drawings (typically ten to fifteen feet on center).
- Cut the head and sill members to the dimension between the jamb and expansion mullions at end members and between the expansion mullions for intermediate members.

FRAME FABRICATION

STEP 3 (Continued)

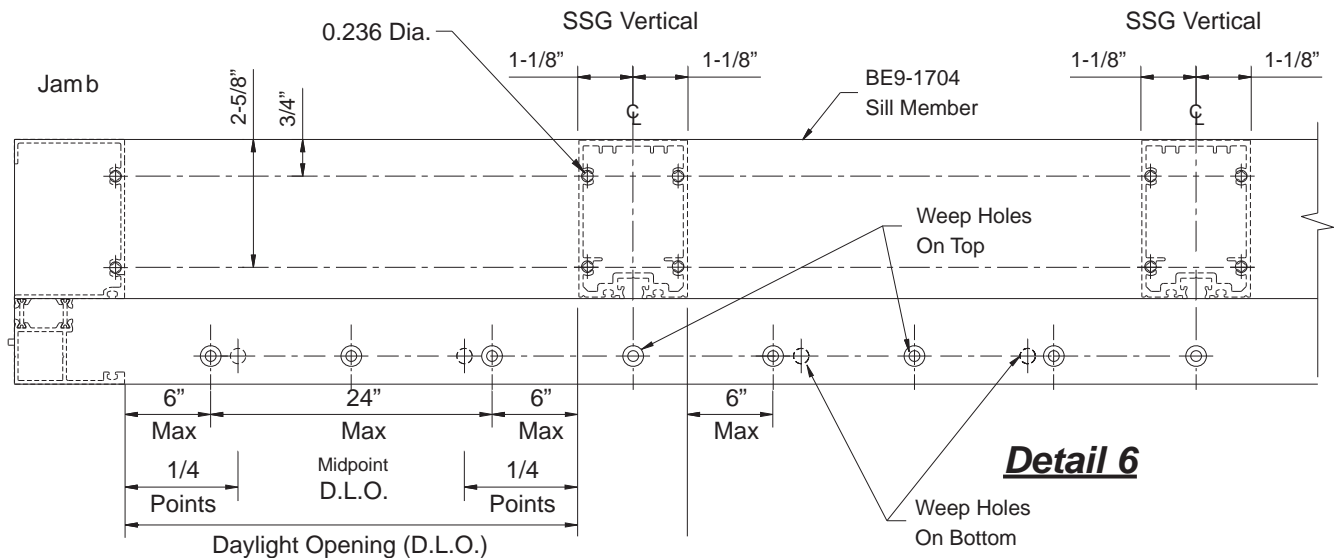
FABRICATE HEAD & SILL MEMBERS

FOR CONTINUOUS HEAD & SILL FRAMES (YWW 50 T SSG Only)

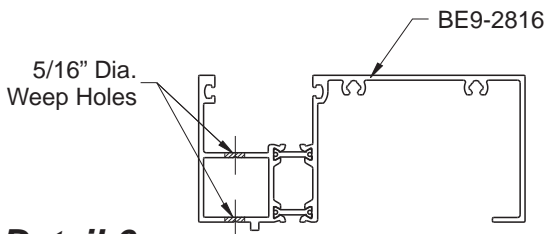
- Mark the centerline of each SSG vertical member along the head and sill members.
- Mark hole locations on the head and sill members for screw spline attachment of vertical members using one of the methods below:
 - Using short pieces of vertical members as a template, align the template with the vertical centerline and the front of the head/sill and mark hole locations through the screw splines.

OR

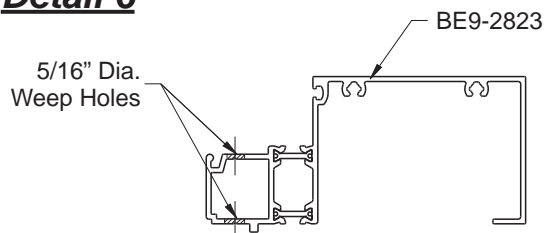
- Layout hole locations on head and sill members as shown in **Detail 6**.
- Drill 0.236" diameter (#B drill bit) clearance holes at each location marked.



Detail 6



Detail 6



Continuous sill members must have weep holes drilled for each lite of glass.

- Mark the centerline of each intermediate vertical and the midpoint of D.L.O. between verticals in the glazing pocket of the sill.
- Turn the sill member over and mark the quarter points of D.L.O. between verticals on the bottom.
- Drill a 5/16" dia. hole at each hole location marked just in front of the thermal break.

See **Detail 6**.

FRAME FABRICATION

STEP 4

FABRICATE TWO PIECE VERTICALS & JAMB MEMBERS

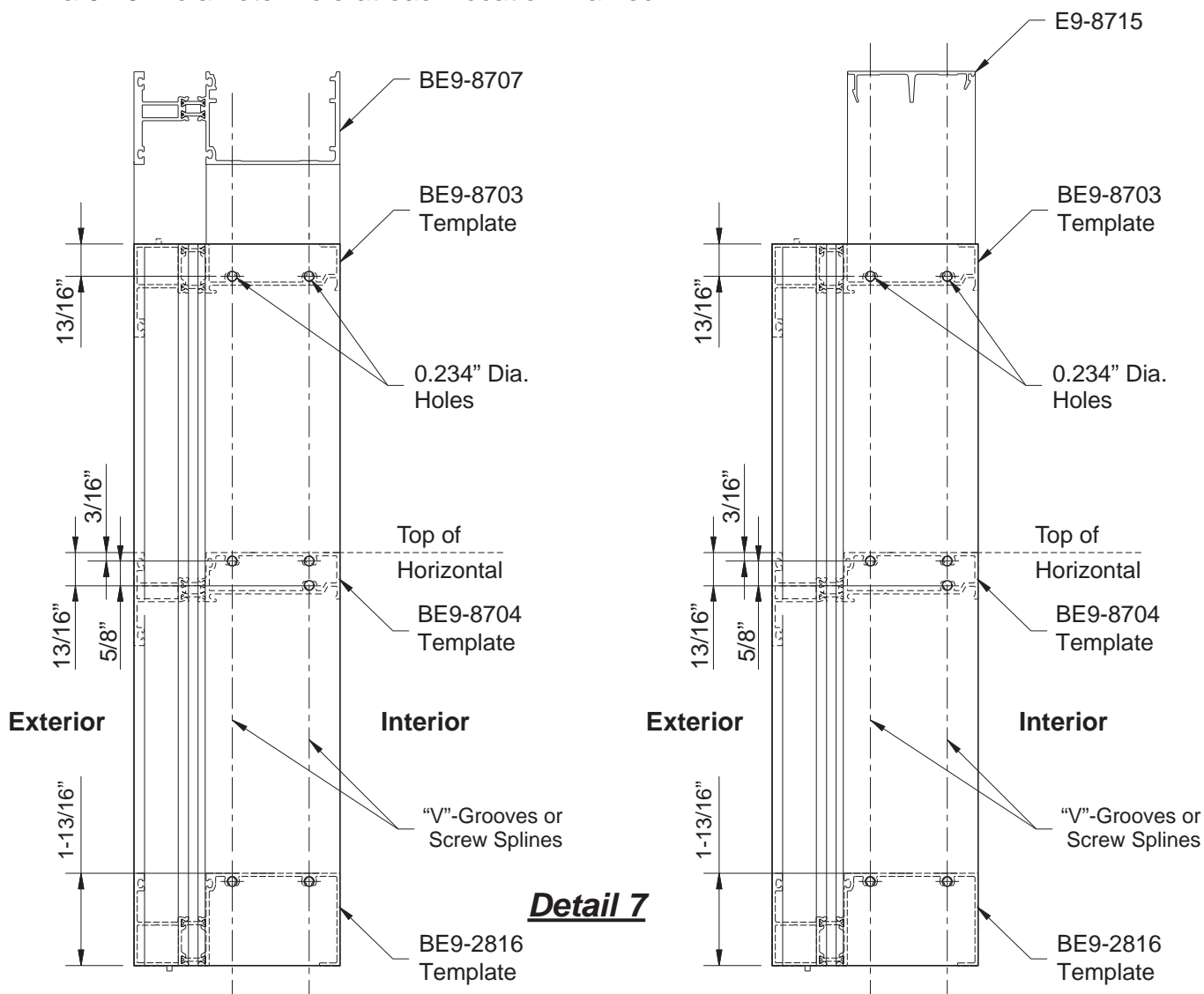
-Cut two piece verticals, fillers, and jamb members to the frame height determined in **Step 1** on **Page 11** or as shown on approved shop drawings.

Fabrication of Verticals for Inside Glazed Frames:

- Use a short piece of each horizontal member as a template.
- Center the template on the face of the vertical member.
- Line up the glazing pockets and mark the location of each screw spline.

-OR-

- Layout the hole locations along the "V"-grooves of each member as shown in **Detail 7**.
- Drill a 0.234" diameter hole at each location marked.



FRAME FABRICATION

STEP 4 (Continued)

FABRICATE TWO PIECE VERTICALS & JAMB MEMBERS

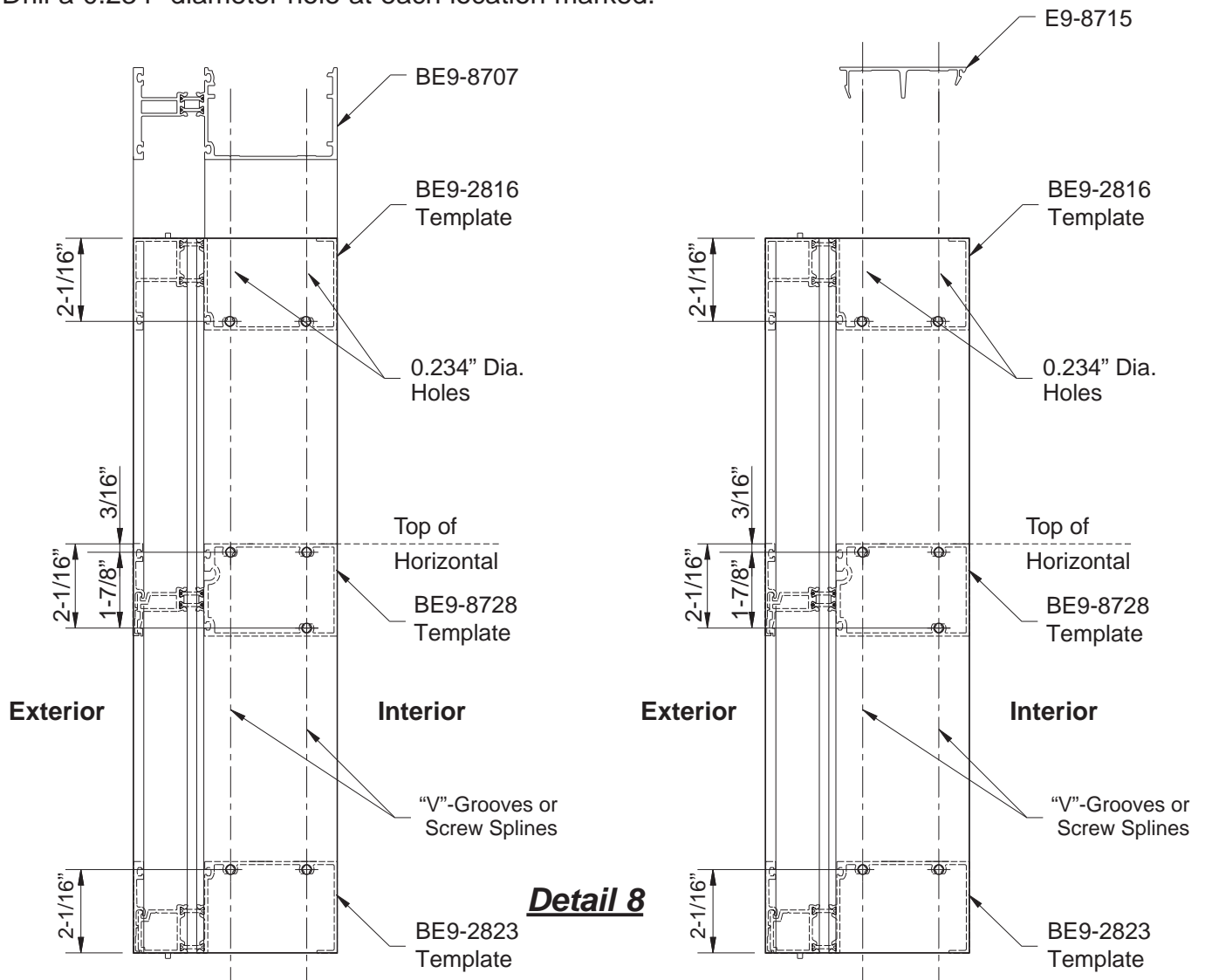
-Cut two piece verticals, fillers, and jamb members to the frame height determined in **Step 1** on **Page 11** or as shown on approved shop drawings.

Fabrication of Verticals for Outside Glazed Frames:

- Use a short piece of each horizontal member as a template.
- Center the template on the face of the vertical member.
- Line up the glazing pockets and mark the location of each screw spline.

-OR-

- Layout the hole locations along the "V"-grooves of each member as shown in **Detail 8**.
- Drill a 0.234" diameter hole at each location marked.

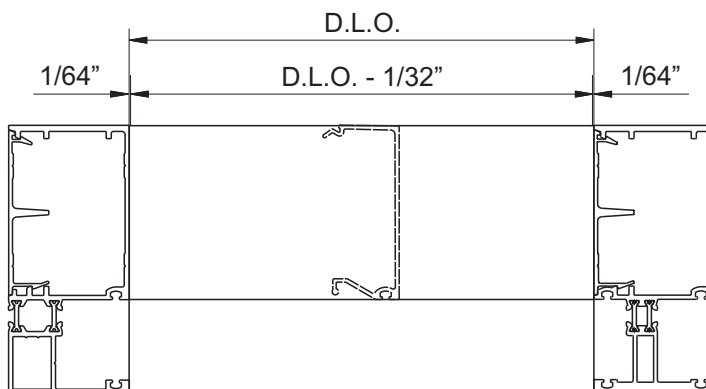


FRAME FABRICATION

STEP 5

FABRICATE INTERIOR GLASS STOP FOR INSIDE GLAZED HORIZONTALS

- Interior glazed horizontals require interior glass stops:
BE9-8704 requires interior glass stop E9-8711.
- Cut all interior glass stops to the same dimension as the horizontals (D.L.O.) minus (-) 1/32".
See **Detail 9**.



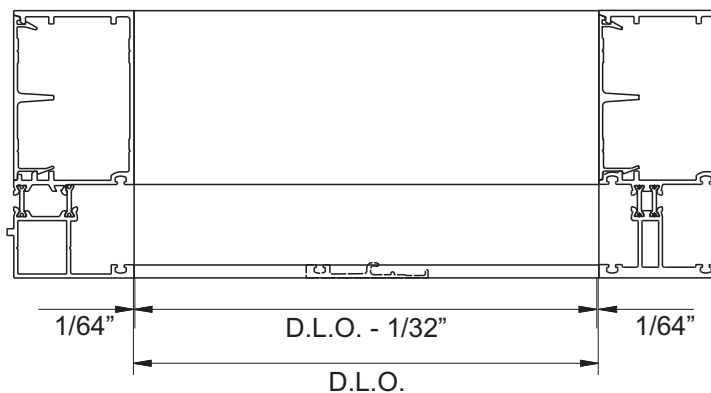
Detail 9

STEP 6

FABRICATE EXTERIOR GLASS STOP FOR OUTSIDE GLAZED HORIZONTALS

- Exterior glazed horizontals require exterior glass stops:
BE9-8706 and BE9-8728 requires interior glass stop E9-1715.
- Cut the glass stop to the same dimension as the horizontals (D.L.O.) minus (-) 1/32".
See **Detail 10**.

Detail 10



FRAME FABRICATION

**STEP 6
FABRICATE GLAZING ADAPTORS**

YWW 50 T offers glazing adaptors for 1/4" glazing:

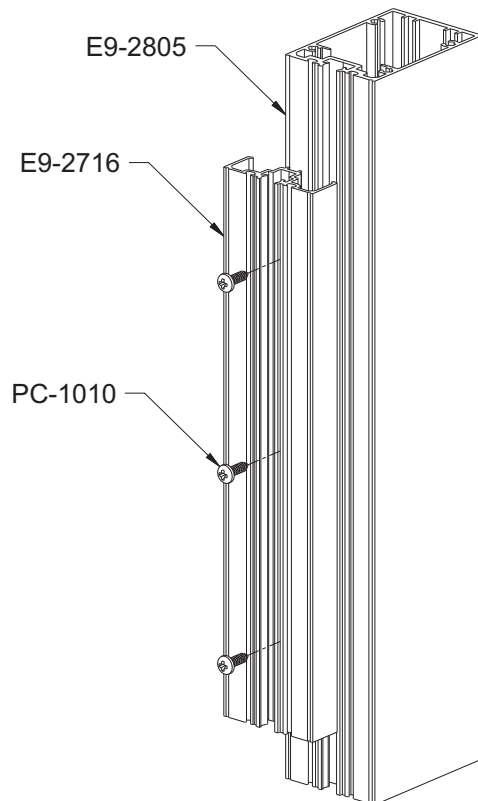
- E9-1707 for captured mullion deep pockets.
- E9-1708 for captured mullion shallow pockets.
- E9-2716 for structural silicone glazed (SSG) vertical mullions.
- E9-1725 for BE9-8734 pocket fillers for 90° corner posts and door jams.

- Cut vertical glazing adaptors to the daylight opening dimension between horizontals plus(+) 7/8".
- Cut horizontal glazing adaptors to the daylight opening dimension between verticals minus(-) 1/32".

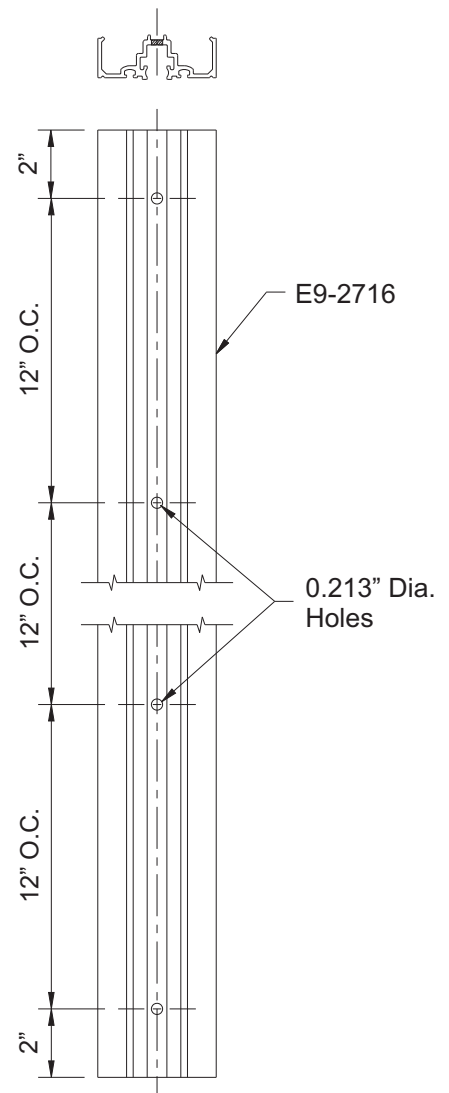
Glazing adaptor, E9-2716, requires additional fabrication:

- Mark hole locations along the recessed area in the middle of the adaptor 2" from each end and 12" on center.
- Drill 0.213" (#3 bit) dia. holes at each location marked.

See **Detail 11**.



Detail 11



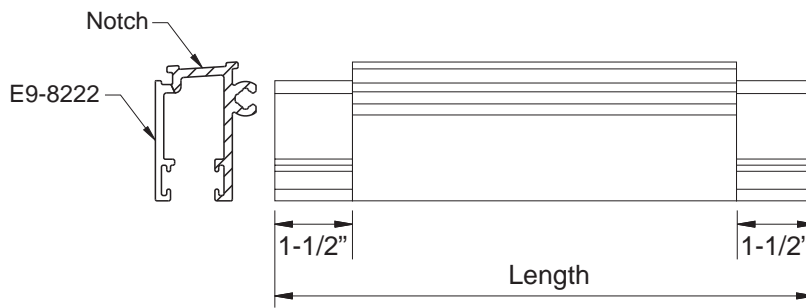
FRAME FABRICATION

STEP 7

FABRICATE PLATE ADAPTOR

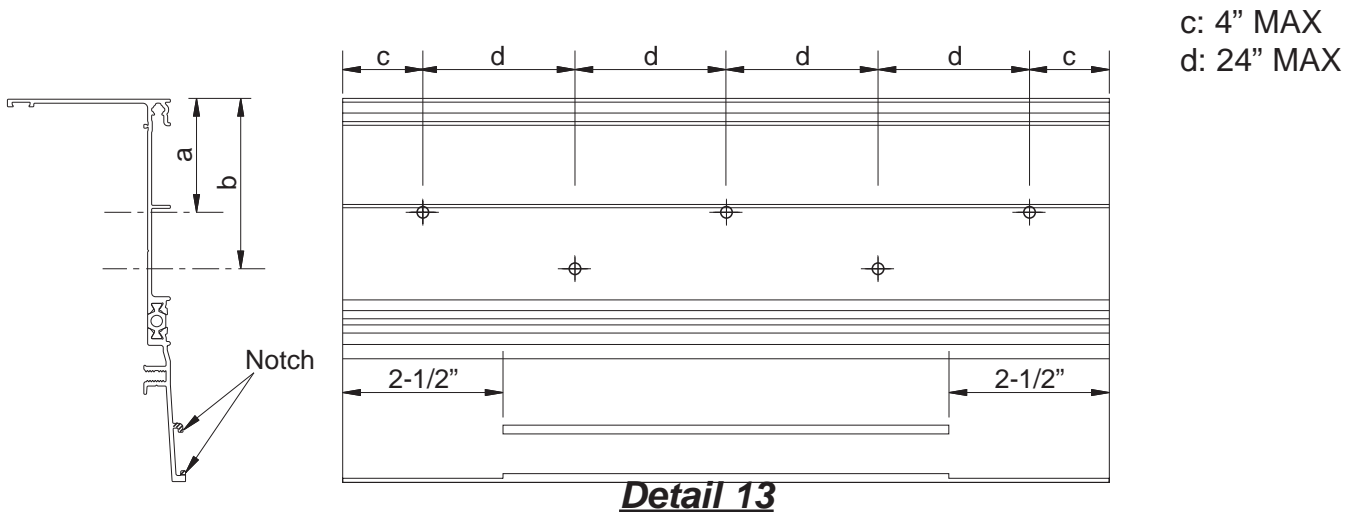
- Cut the aluminum plate adaptor, E9-8222, to the same length as the sill flashing.
- Notch the aluminum plate adaptor 1-1/2" from each end where adjacent to a splice location as shown in **Detail 12**.

Detail 12



- Drill a hole at each location marked for anchoring to the sill flashing. Anchor size and location as determined by structural calculations.
- Alternate perimeter fasteners as shown with dimensions a and b.

Note: It is necessary to also notch the sill flashing 2-1/2" from each end where adjacent to a splice location as shown in **Detail 13**.



FRAME FABRICATION

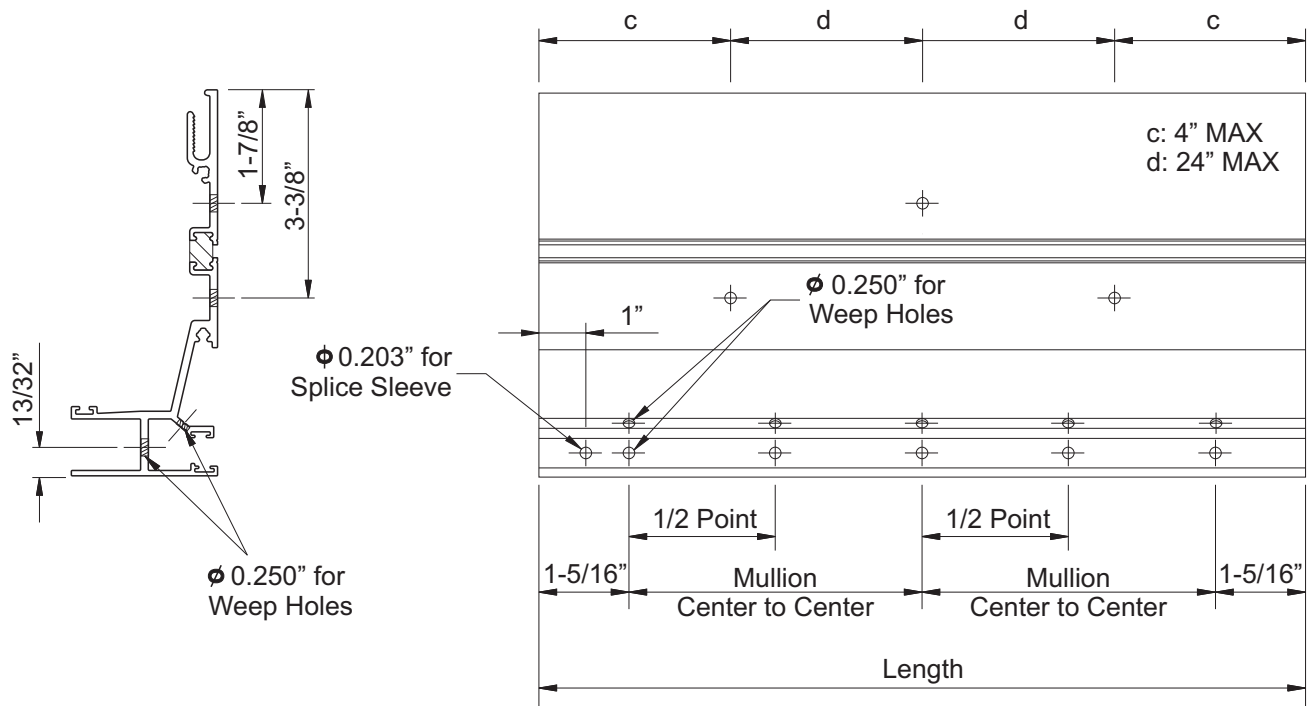
STEP 8

FABRICATE HEAD RECEPTOR AND SLAB EDGE COVER

-Cut the head receptor and snap cover to the same dimension of the sill flashing as

determined in **Step 2**.

-Alternate perimeter fasteners and drill weep holes as shown in **Detail 14**.



Detail 14

FRAME ASSEMBLY

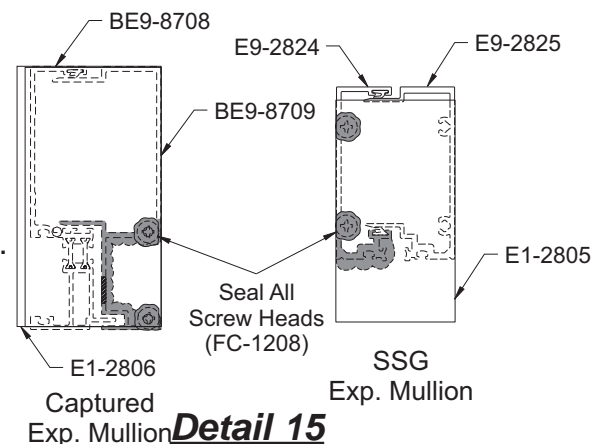
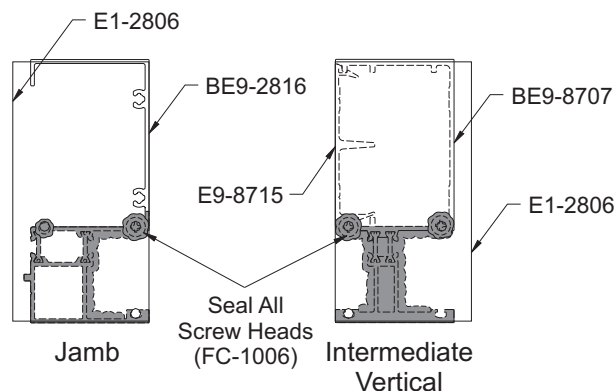
STEP 9 ATTACH MULLION END CAPS

Mullion end caps are required at the top end only of jamb and vertical mullions of vertical through frames and at each end of the expansion mullion of continuous head and sill frames.

- Clean the vertical mullion ends and mullion end caps with a cleaner and method approved by the sealant manufacturer.
- Apply sealant to the gasket reglet and along the front of the vertical members on both ends prior to installing mullion end caps .
For expansion mullions, apply sealant to the fastener side mullion only.
- Attach the mullion end caps to each end of the mullion with fasteners as shown **Detail 15**.
- Install E1-2806 mullion cap as shown on expansion mullion half. On the standard mullion, install end cap as shown with offset facing the pre-assembled unit.
- Tool the excess sealant along the inside of the glazing pocket between the mullion end cap and the mullion.

Field note: At the top of each mullion, the perimeter sealant must cover the extrusions entire front edge, thus completely covering the mullion cap.

- Seal all screw heads.
- See **Detail 15**.



Detail 15

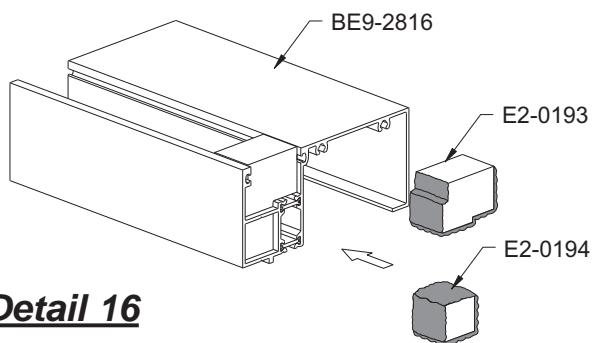
STEP 10 INSTALL END DAMS (For Continuous Head & Sill Frames Only)

The ends of head and sill members of continuous head & sill frames must be plugged using end dams, E2-0193 and E2-0194.

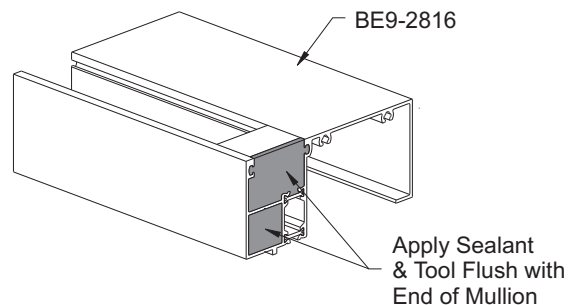
Use the following technique to install end dams at the head and sill:

- Clean the ends of the head and sill members with a cleaner and method approved by sealant manufacturer.
- Apply sealant to all contact sides of the end dam.
- Insert the end dam into each end, leaving it 1/8" recessed from the edge of the mullion.
- Apply sealant to the end dams and tool the sealant flush with the ends of the mullion.

See **Detail 16** (sill shown, head similar).



Detail 16



Apply Sealant & Tool Flush with End of Mullion

FRAME ASSEMBLY

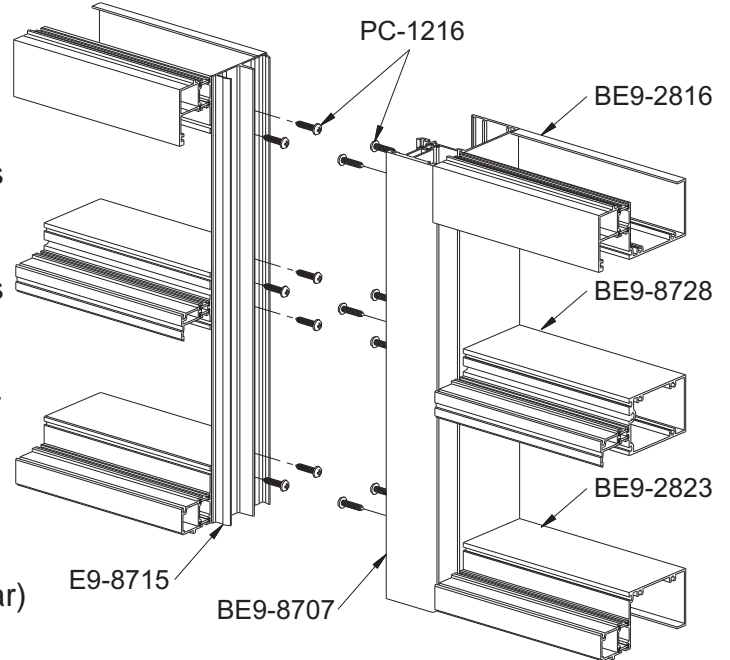
**STEP 11
ASSEMBLE FRAMES**

Vertical Through Frames:

- Attach head and sill members to two piece verticals and jambs using (2) PC-1216 fasteners at each end.
- Attach intermediate horizontals to two piece verticals and jambs using (3) PC-1216 fasteners at each end.

Note: PC-1220 fasteners must be substituted for the PC-1216 fasteners when attaching to vertical members that have screw splines.

See **Detail 17**.
(YWW 50 T Outside Glazed shown; others similar)

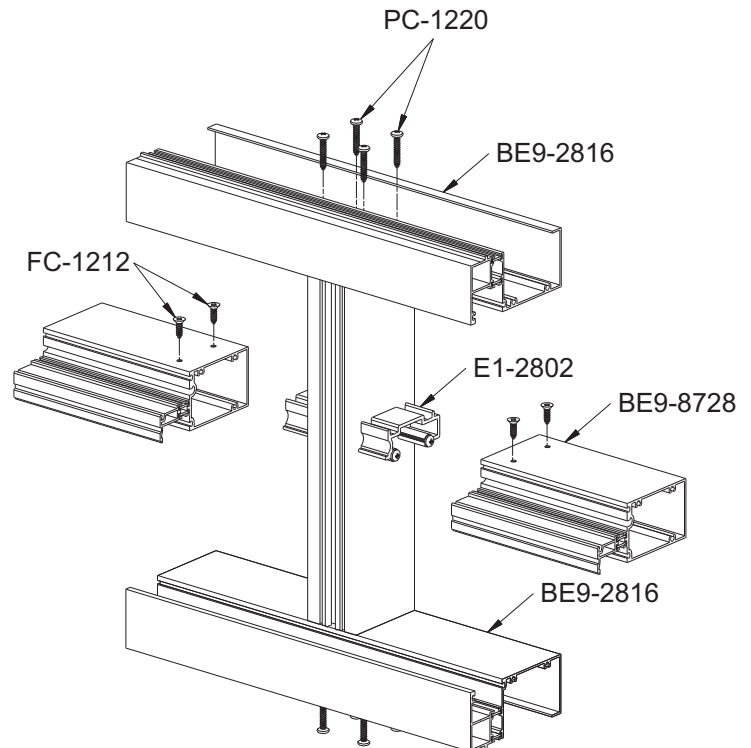


Detail 17

**Continuous Head & Sill Frames
With One Piece SSG Verticals:**

- Attach jamb members to continuous head and sill members using (2) PC-1220 fasteners at each end.
- Attach one piece verticals to continuous head and sill members using (4) PC-1220 fasteners at each end.
- Attach intermediate horizontals to shear block, E1-2802, using (2) FC-1212 fasteners at each end.

See **Detail 18**.



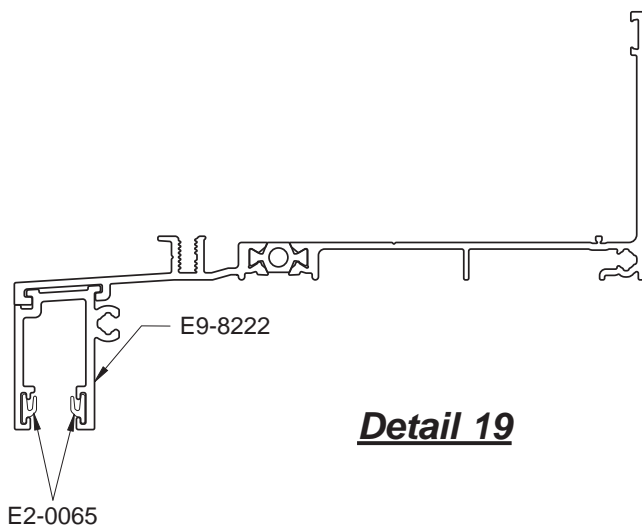
Detail 18

FRAME ASSEMBLY

**STEP 12
ASSEMBLE SILL FLASHING**

- Install 2 rows of gasket, E2-0065 at the slab edge cover pocket side of the plate adaptor.
- Install the aluminum plate adaptor, E9-8222 by sliding into place.

See **Detail 19**.

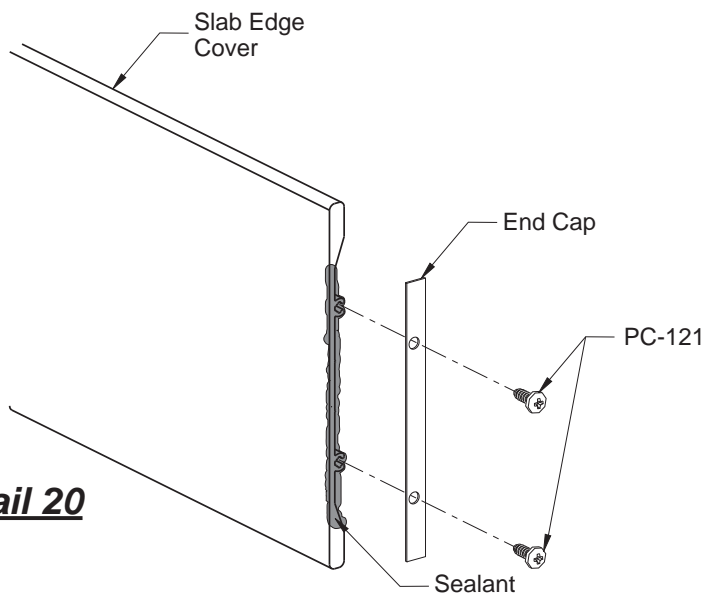


Detail 19

**STEP 13
ASSEMBLE SLAB EDGE COVER**

- Clean the ends of the slab edge cover and attachment areas of end caps using a cleaner approved by sealant manufacturer.
- Apply and tool sealant to each end of the slab edge cover prior to attaching the end caps.
- Attach end caps to each end of the slab edge cover using (2) PC-1210 fasteners.
- Tool and wipe away any excess sealant at the joints.

See **Detail 20**.



Detail 20

FRAME INSTALLATION

STEP 14 INSTALL SILL FLASHING END DAMS

-Bend the tab as shown in **Detail 21** and **Detail 22** with a pair of pliers.

See **Detail 21**.

Note: The tab must be bent in the correct position for the sill flashing.

-Clean all joint surfaces using cleaner approved by sealant manufacturer.

-Apply silicone sealant to the end dam as shown in **Detail 22**.

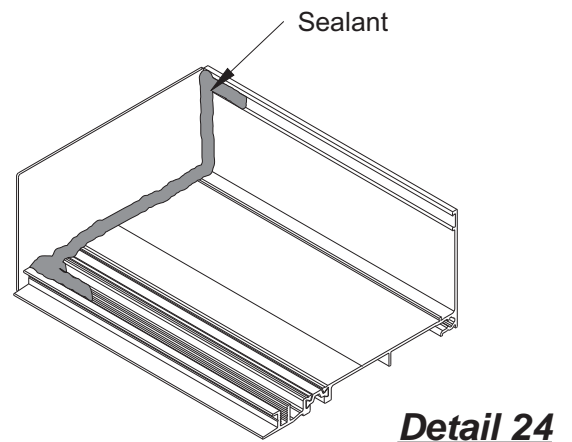
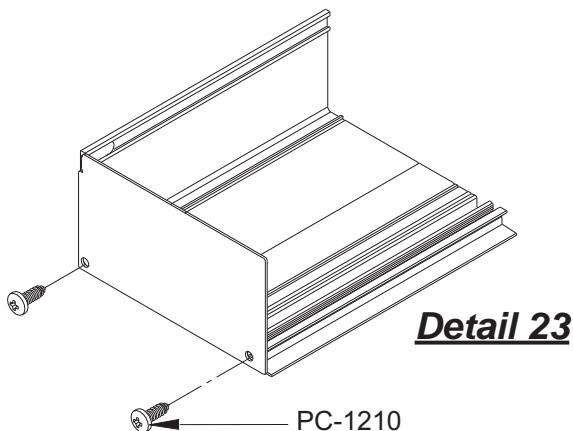
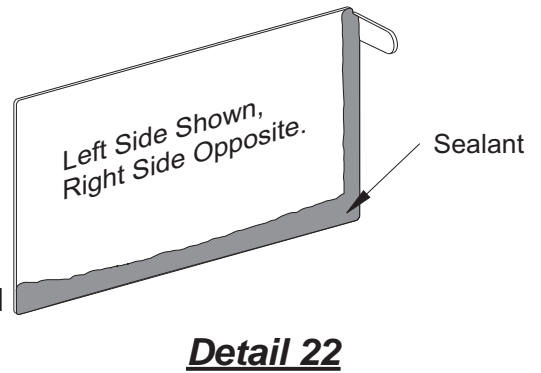
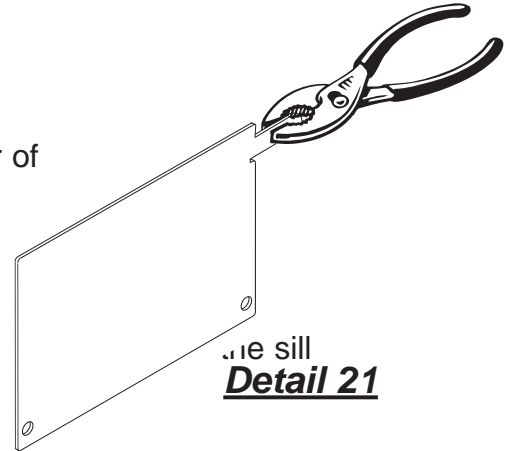
-Slide the tab into the top portion of the sill flashing.

-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 PC-1210 screws, starting at the back, followed by the front as shown in **Detail 23**.

-Tool sealant along the joint between the end dam and the sill shown in **Detail 24**.

-Seal over any exposed screw threads.



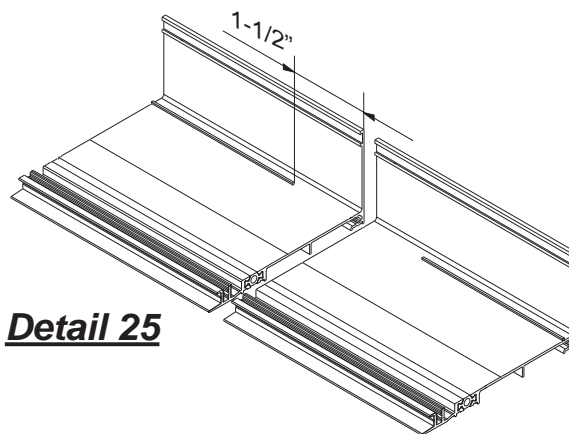
FRAME INSTALLATION

STEP 15 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.

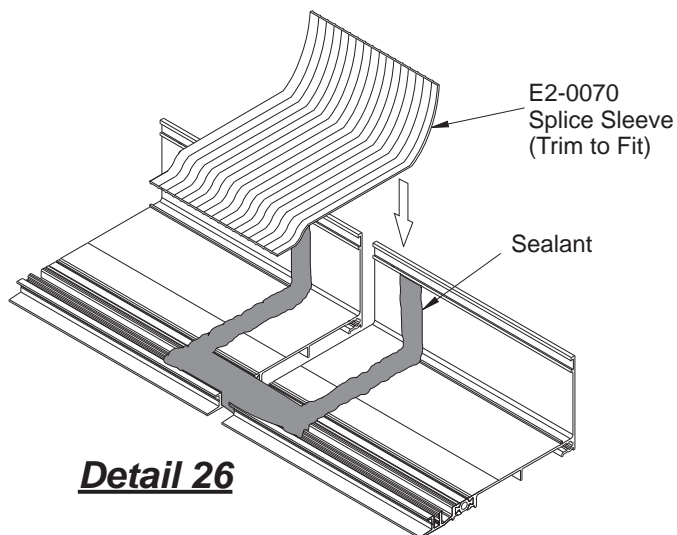
STEP 16 INSTALL SILL FLASHING SPLICE SLEEVE

- Remove the nub with a chisel or needle nose pliers a minimum length of 1 1/2" as shown in **Detail 25**.
- 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 27**.
- 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 26**, before positioning the flashing. Set the Silicone Splice Sleeve into the sealant and flashing.
- Tool sealant tight as shown in **Detail 27**, squeezing the sheet flat.
- Thoroughly seal the small joint directly in front of the Silicone Splice Sleeve as shown in **Detail 27**.

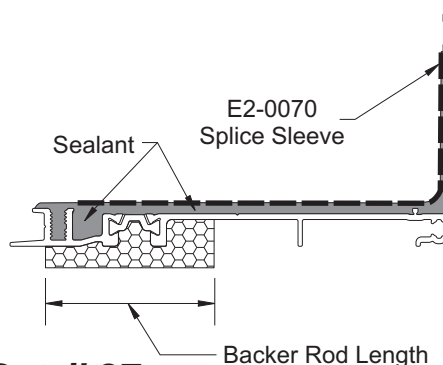


Detail 25

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

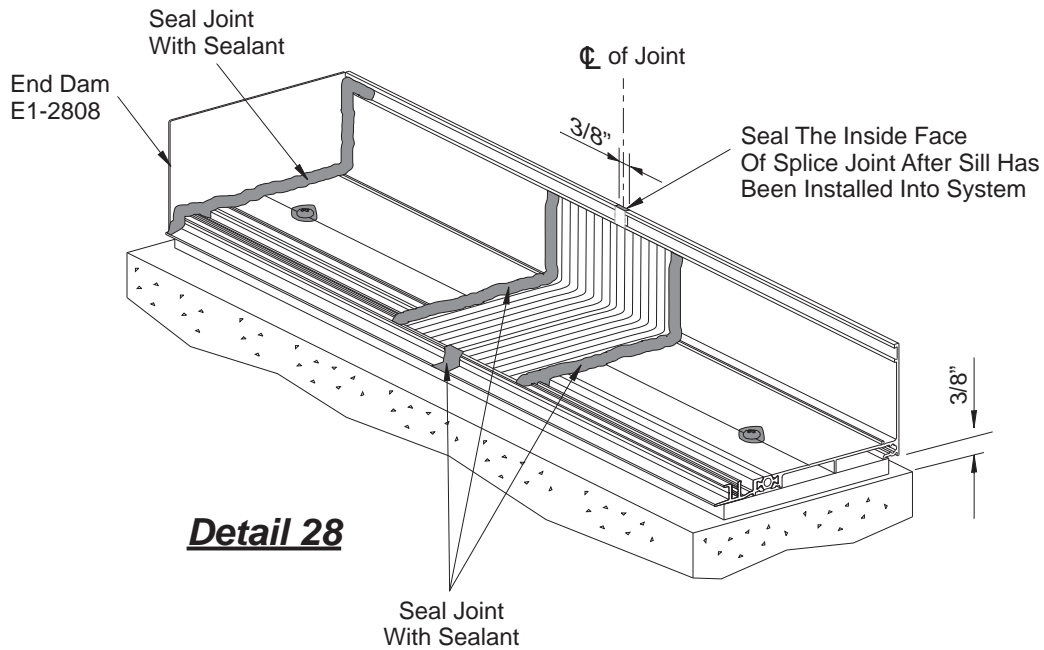


Detail 26



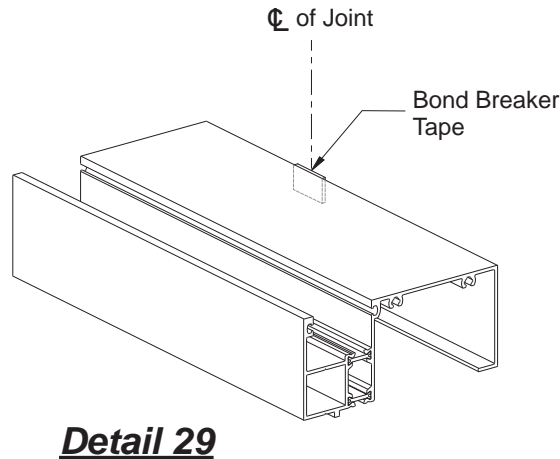
Detail 27

FRAME INSTALLATION



STEP 17
SILL FABRICATION

At every splice condition, apply bond breaker tape to the back of the sill member before it is placed into the sill flashing.
See **Detail 29**.

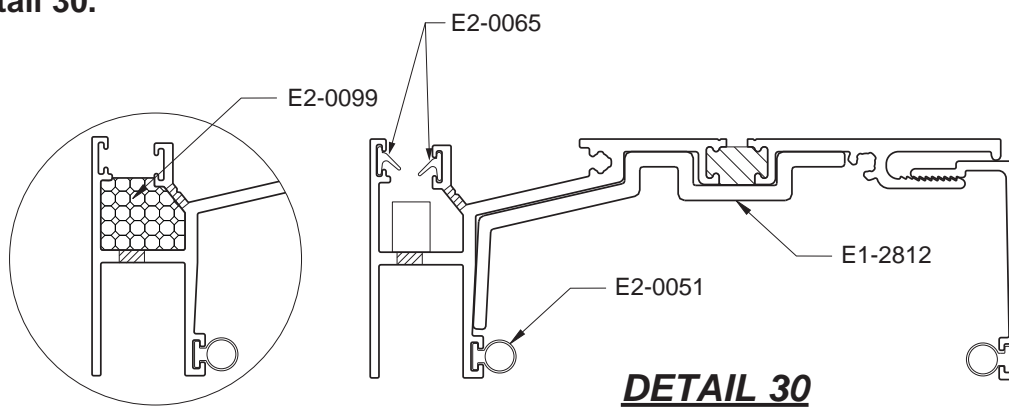


FRAME INSTALLATION

STEP 18 ASSEMBLE HEAD RECEPTOR

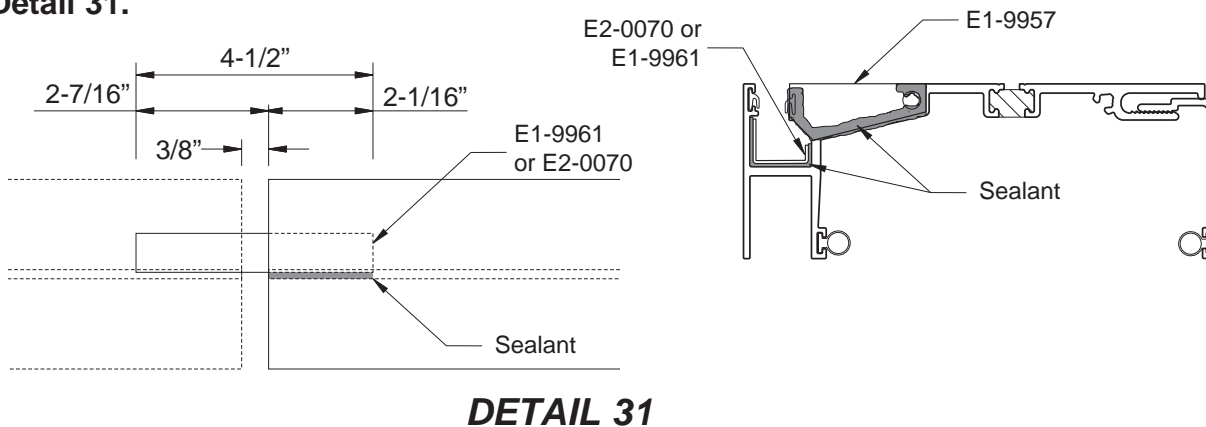
- Install setting blocks at 1/4 points of head receptor.
- Install weep baffle, E2-0099, over every weep hole location.
- Install gasket, E2-0051, on YWW 50 T frame side of receptor.
- Install two rows of gasket, E2-0065, on the slab edge cover pocket side of head receptor.
- Install reinforcement, E1-2812, as determined by engineering calculations.

See **Detail 30**.



- Clean splice sleeve surfaces using cleaner approved by sealant manufacturer.
- Install splice sleeve, E2-0070, or E1-9961 in a bed of sealant at every splice joint.
- Apply and tool the sealant to the shaded area just prior to installing the end cap.
- Install end cap, E1-9957, at both receptor ends using PC-1208.

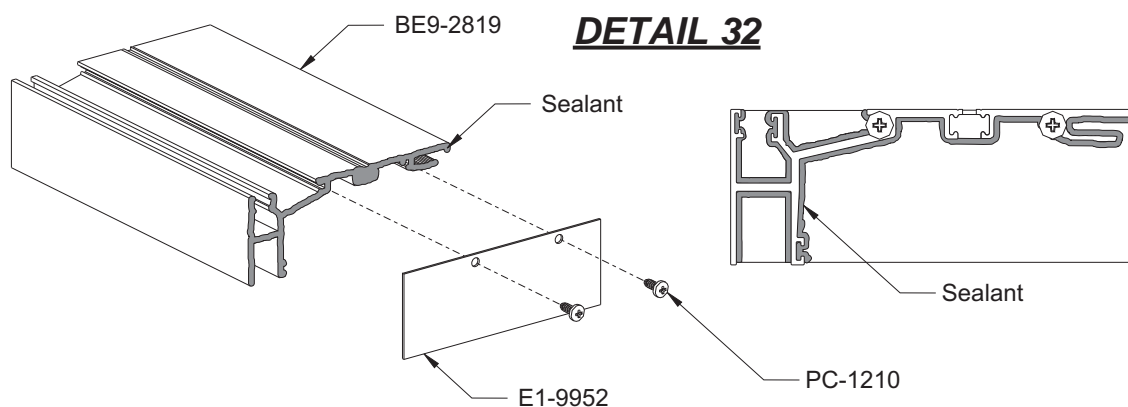
See **Detail 31**.



FRAME INSTALLATION

STEP 19 INSTALL HEAD RECEPTOR

- Clean all joint surfaces using cleaner approved by sealant manufacturer.
 - Install brake metal end cap, E1-9952, at each jamb end of the head receptor with two (2) PC-1210 fasteners.
 - Apply and tool sealant along the joint between the end cap and the head receptor.
 - Tape down the back corners to hold the end cap in place until the sealant cures.
- See **Detail 32**.

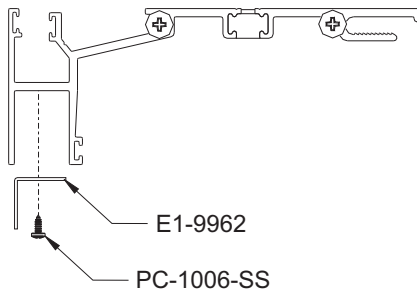
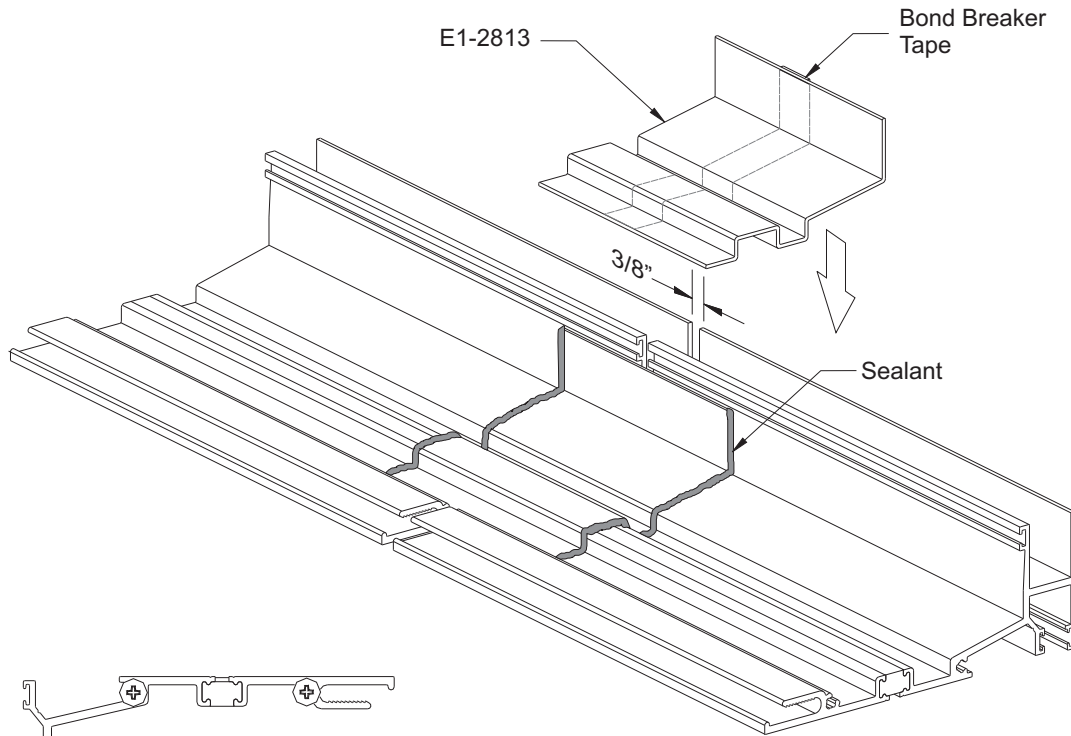


- Starting at the smallest opening height, install the head receptor with a minimum of 3/8" shim underneath. Head receptor must be installed level.
- Anchor the head receptor to the structure a maximum of 4" from each end and then 18" to 24" on center.
- Apply and tool sealant to the heads of all fasteners.
- The head receptor must be spliced every twelve to fifteen feet using splice sleeve, E1-2813:
- Apply bond breaker tape to center of the splice sleeve on the underside.
- Apply a generous amount of sealant to both sides of the head receptor splice.
- Center the splice sleeve over the 3/8" splice joint.
- Tool the sealant up and over the edges of the splice sleeve to completely seal the joint.
- Apply and tool the sealant at the front and back faces of the splice joint.
- Install splice sleeve, E1-9962, using screw, PC-1006-SS .

See **Detail 33**.

**STEP 19 (Continued)
INSTALL HEAD RECEPTOR**

Shown upside down for
viewing purposes only.



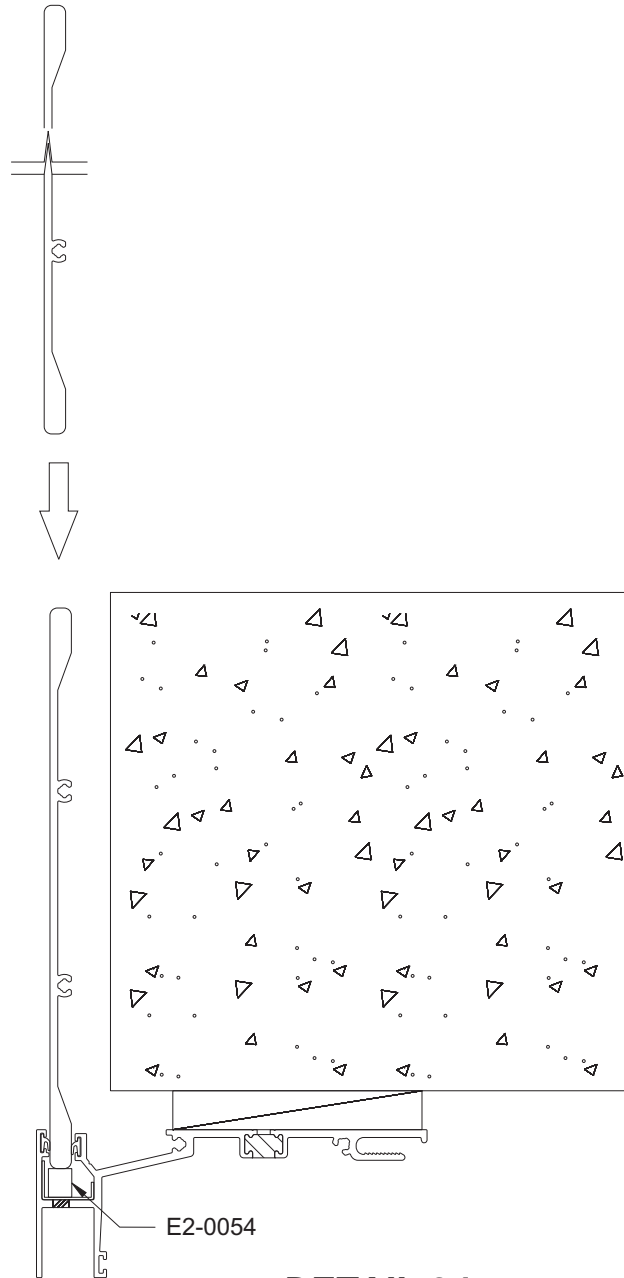
DETAIL 33

FRAME INSTALLATION

STEP 34
INSTALL SLAB EDGE COVER

-Push slab edge cover into the head receptor to make contact with setting blocks, E2-0054.

See **Detail 34**.



DETAIL 34

FRAME INSTALLATION

**STEP 35
INSTALL SILL FLASHING END DAMS**

-Bend the tab as shown in **Detail 35** and **Detail 36** with a pair of pliers.

See **Detail 35**.

Note: The tab 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 dam as shown in **Detail 36**.

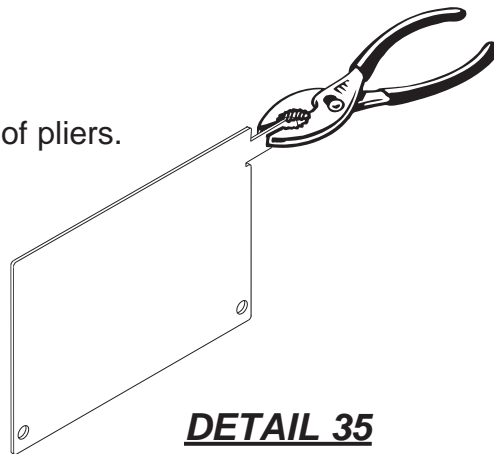
-Slide the tab into the top portion of the sill flashing.

-Tap the tab into place with a small tool until the end dam is snug against the end cut of the flashing.

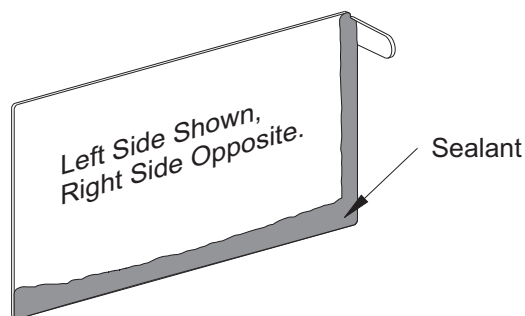
-Fasten the end dam to the sill flashing with two PC-1210 screws, starting at the back, followed by the front as shown in **Detail 37**.

-Tool sealant along the joint between the end dam and the sill flashing as shown in **Detail 38**.

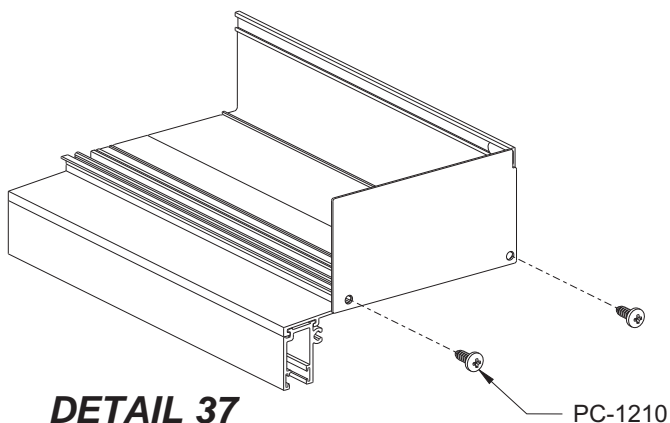
-Seal over any exposed screw threads.



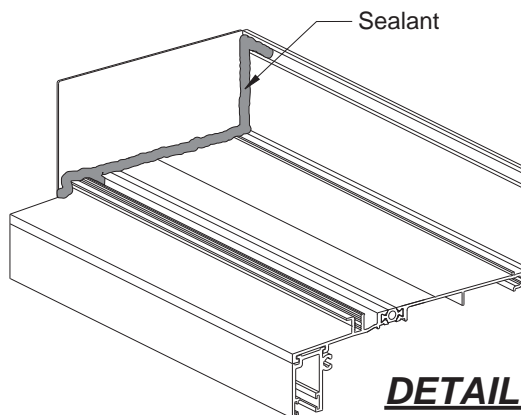
DETAIL 35



DETAIL 36



DETAIL 37



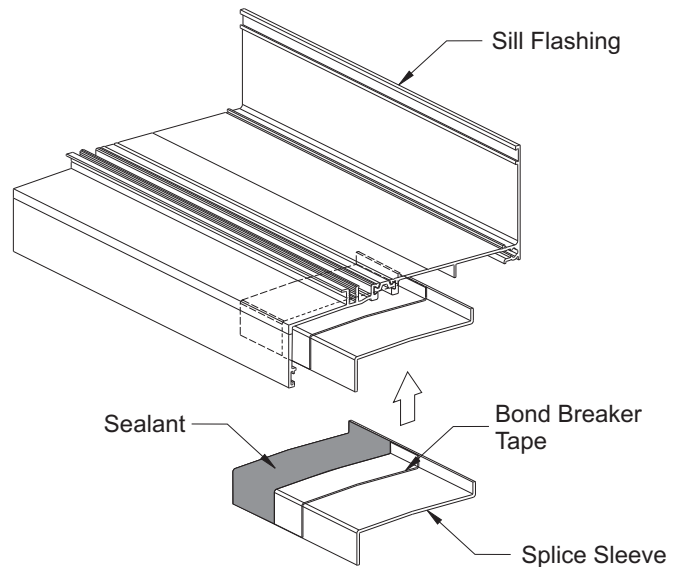
DETAIL 38

FRAME INSTALLATION

**STEP 36
INSTALL SILL FLASHING SPLICE SLEEVE**

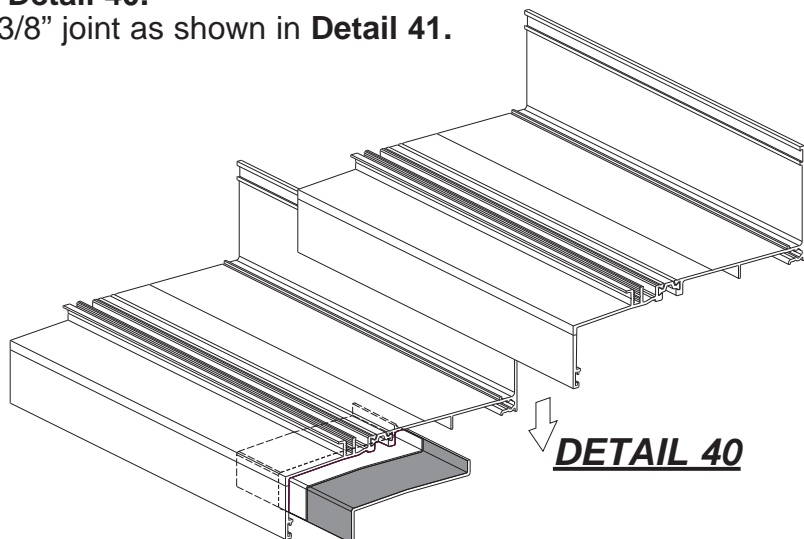
- Apply backer tape to topside of splice sleeve.
- Apply sealant to one-half of splice sleeve topside.
- Press sealed half up into sill flashing.

See **Detail 39**.



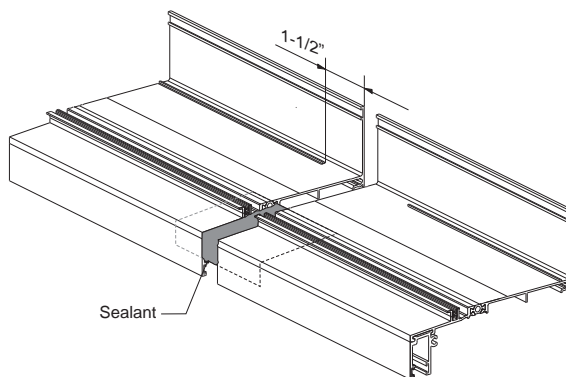
DETAIL 39

- Apply sealant to remaining exposed sill flashing.
- Lower the second half of sill flashing onto splice sleeve as shown in **Detail 40**.
- Be sure to leave a 3/8" joint as shown in **Detail 41**.

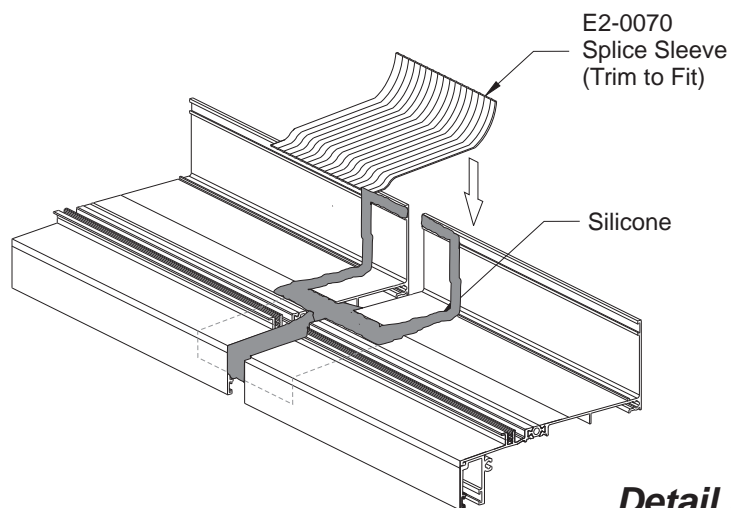
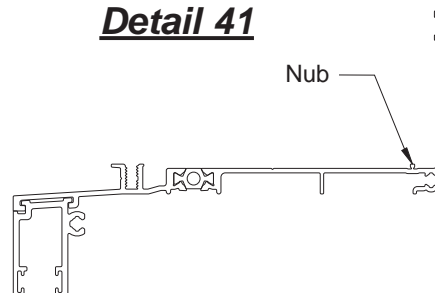


**STEP 37
INSTALL SILL FLASHING SPLICE SLEEVE**

- Remove the nub with a chisel or needle nose pliers a minimum length of 1 1/2" as shown in **Detail 41**.
- Apply sealant to topside of Splice Sleeve as shown in **Detail 41**.
- 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 42**, before positioning the flashing. Set the Silicone Splice Sleeve into the Sill Flashing.
- Tool sealant tight as shown in **Detail 43**, squeezing the sheet flat.
- Thoroughly seal the small joint directly in front of the Silicone Splice Sleeve as shown in **Detail 43**.



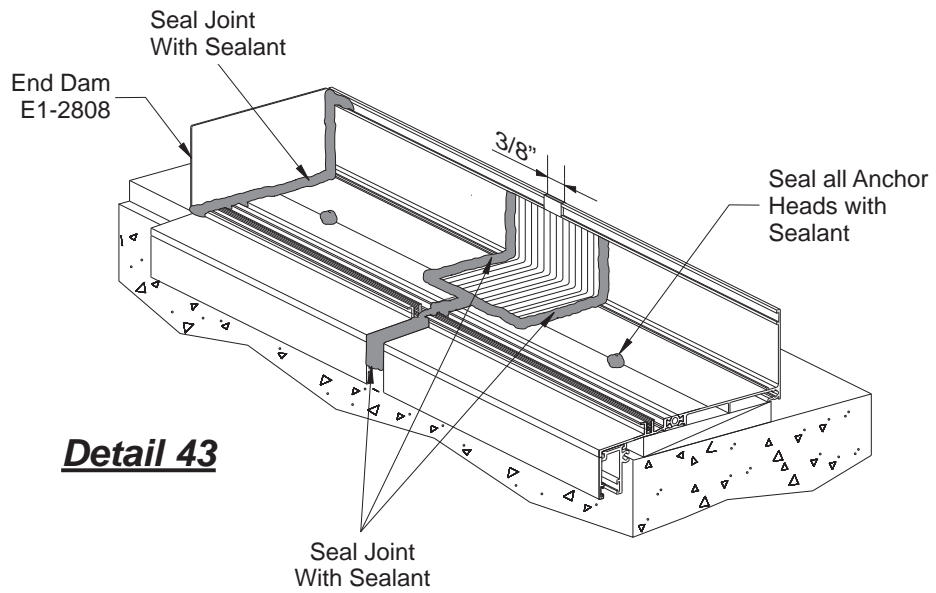
Detail 41



Detail 42

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

STEP 37 (Continued) INSTALL SILL FLASHING SPLICE SLEEVE



FRAME INSTALLATION

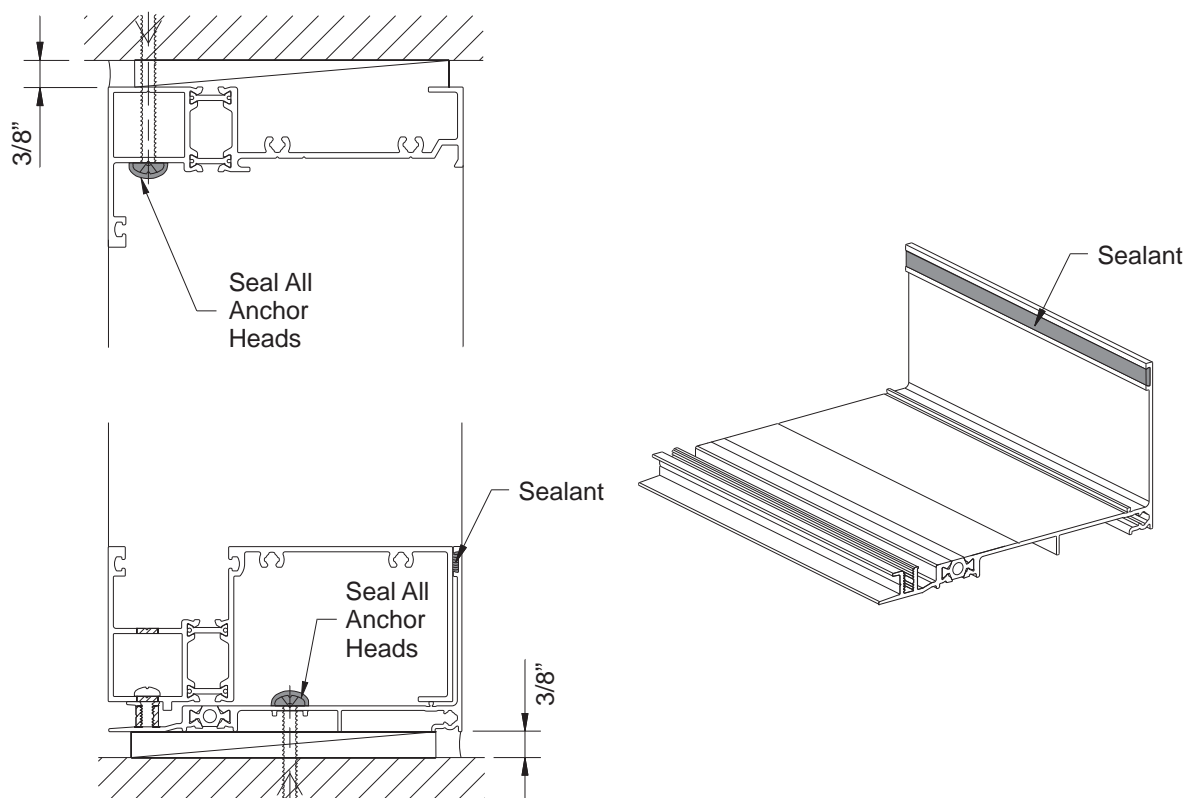
STEP 38 INSTALL ASSEMBLED FRAMES

- Immediately before installing the frames, apply a continuous bead of sealant to the top of the upturned leg of the sill flashing, and a generous amount of sealant to the pilot holes in the sill flashing. Be sure not to obstruct weep holes on exterior of sill. Make sure all surfaces are clean before applying sealant.
- Snap frame assemblies together and set onto the sill flashing.
- Shim the head and jamb members to ensure that the frame is installed plumb, square, and true.
- Anchor the head members at 6" on each side of every vertical centerline and then no more than 24" on center.
- Anchor jamb members 6" from each end and then no more than 24" on center.
- Follow by inserting and tightening fasteners into flashing through sealant.
- Seal all anchor heads.

Note: Shims must be installed at all anchor locations.

See **Detail 44**.

(Inside glazed shown, outside glazed similar)

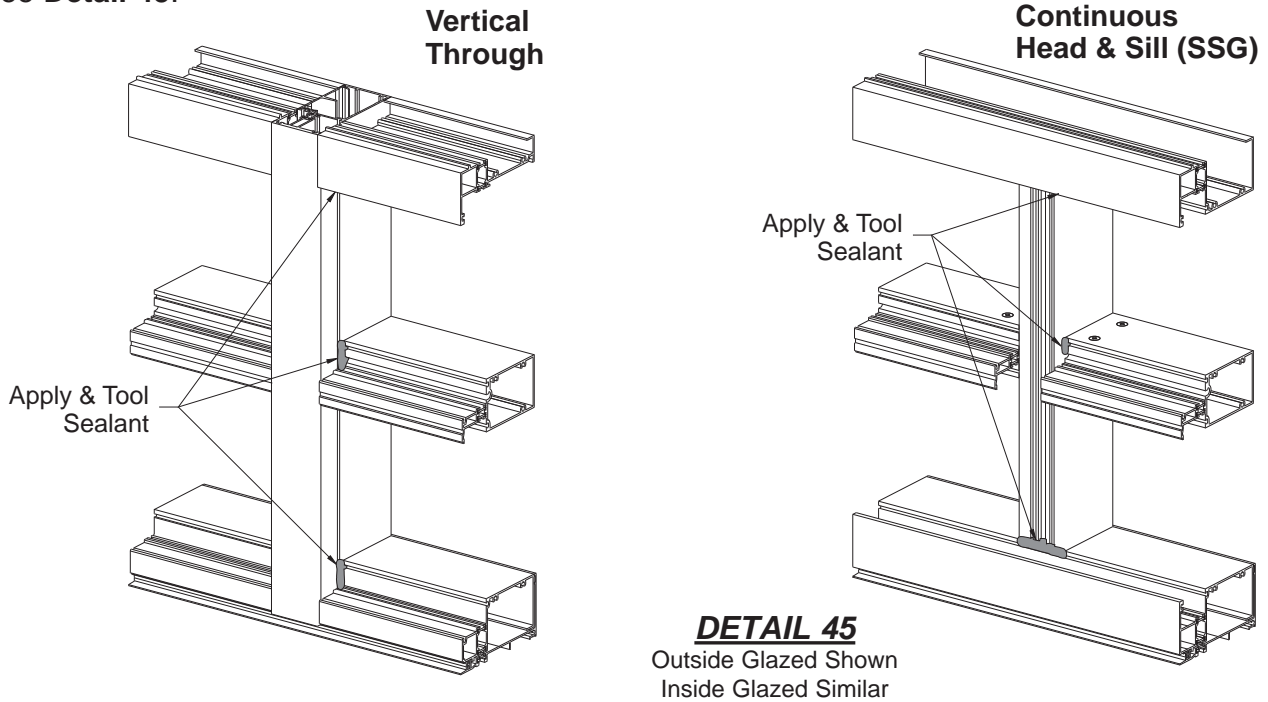


DETAIL 44

FRAME INSTALLATION

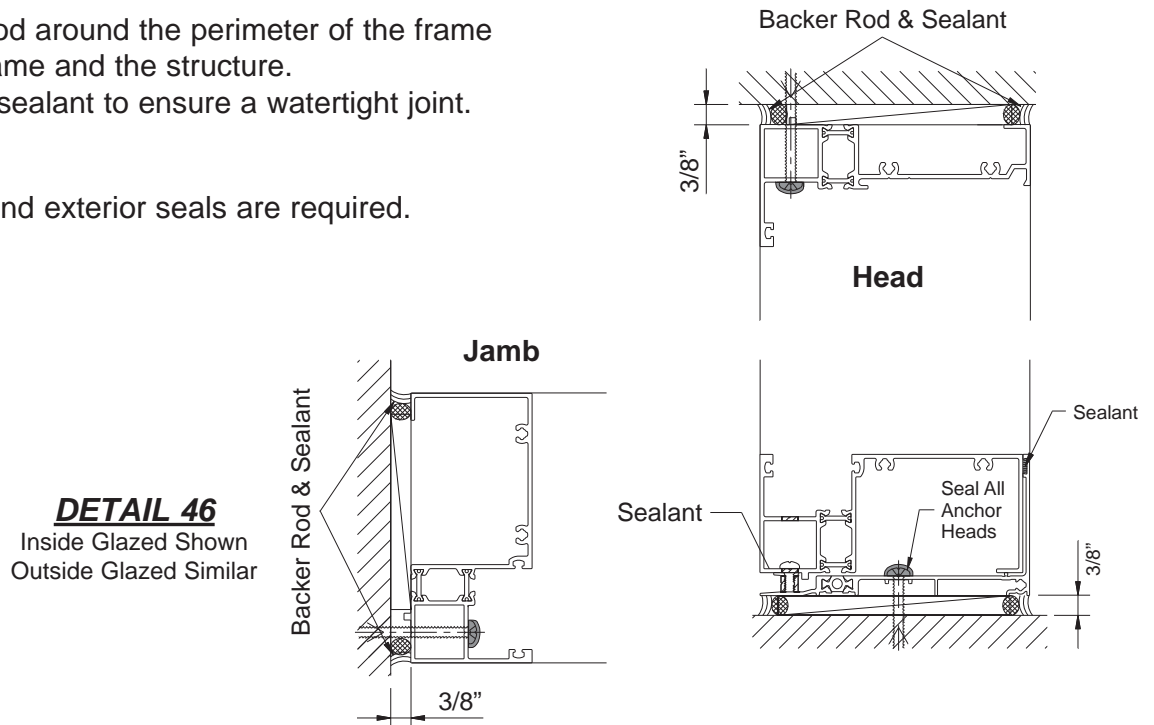
STEP 39
APPLY INTERNAL & PERIMETER SEALANT

- Apply sealant to all vertical/horizontal joints at the glazing pockets.
 - Tool the sealant to ensure a watertight joint.
- See **Detail 45**.



- Install backer rod around the perimeter of the frame between the frame and the structure.
 - Apply and tool sealant to ensure a watertight joint.
- See **Detail 46**.

Note: Interior and exterior seals are required.

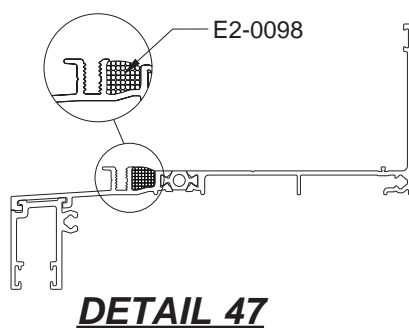


FRAME INSTALLATION

**STEP 40
INSTALL ASSEMBLED FRAMES WITH SLAB EDGE COVER**

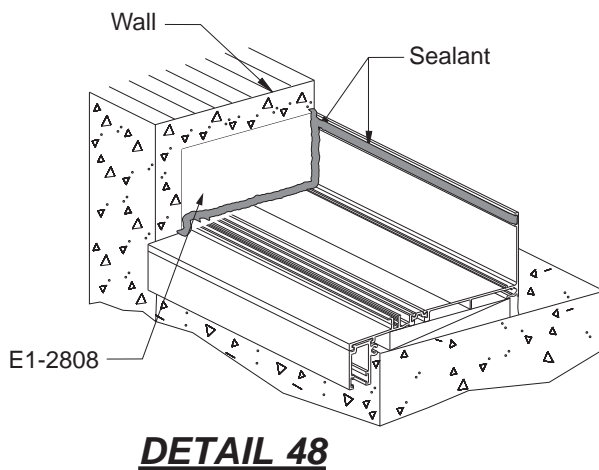
- Install E2-0098 sill weep baffle at each weep hole location.
- Clean the surfaces using cleaner approved by sealant manufacturer.

See **Detail 47**.



- Apply and tool sealant between wall and end dam.
- Apply and tool sealant to the sealant track on the back of the sill flashing.

See **Detail 48**.

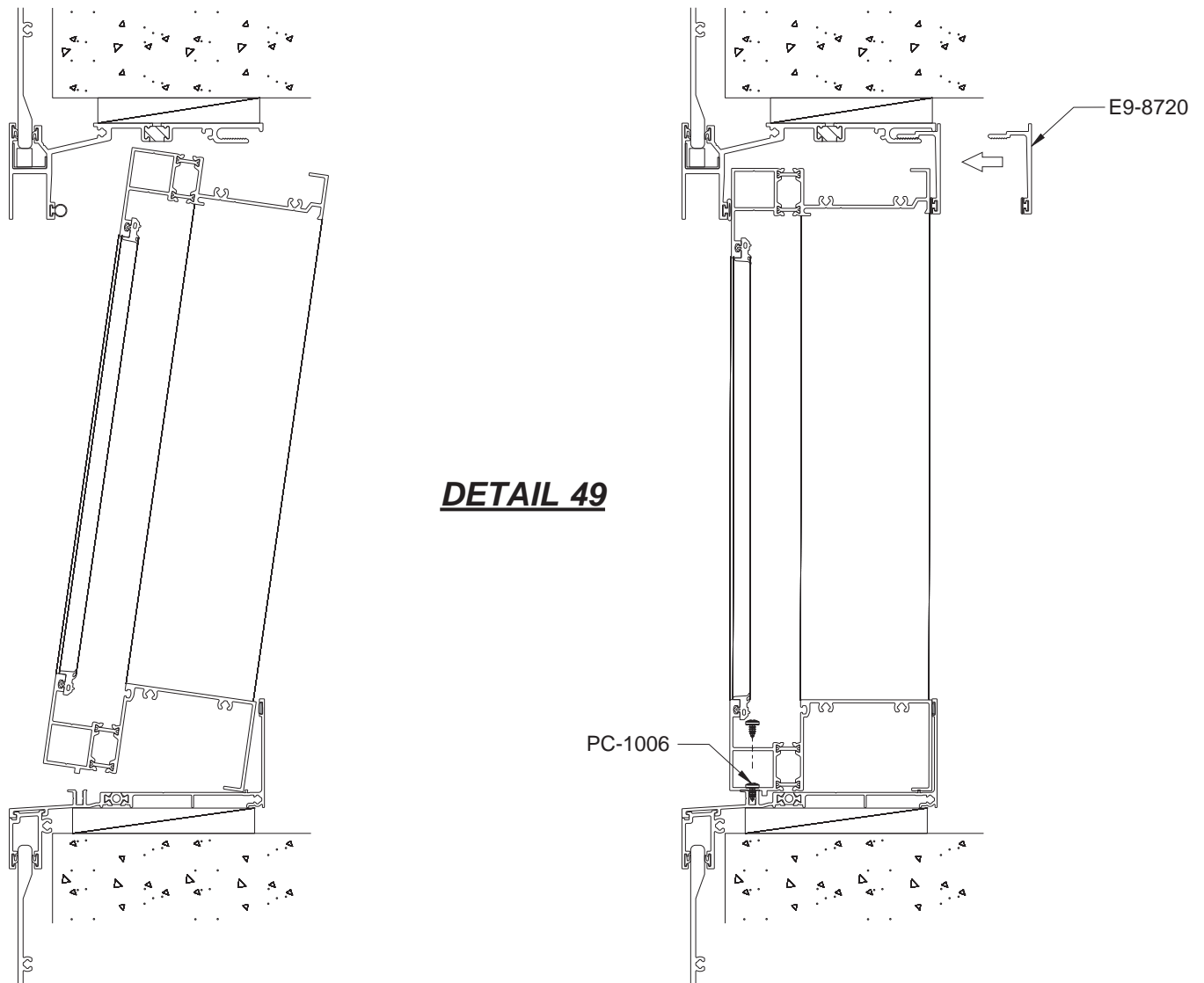


FRAME INSTALLATION

STEP 40 (Continued) INSTALL ASSEMBLED FRAMES WITH SLAB EDGE COVER

- Set unglazed YWW50T frame into the opening pressing the excess sealant out of the sealant track on the sill flashing.
- Clean up excess sealant.
- Apply receptor snap cover into head receptor.
- Match drill hole in sill flashing for PC-1006-SS and install screws.

See **Detail 49**.

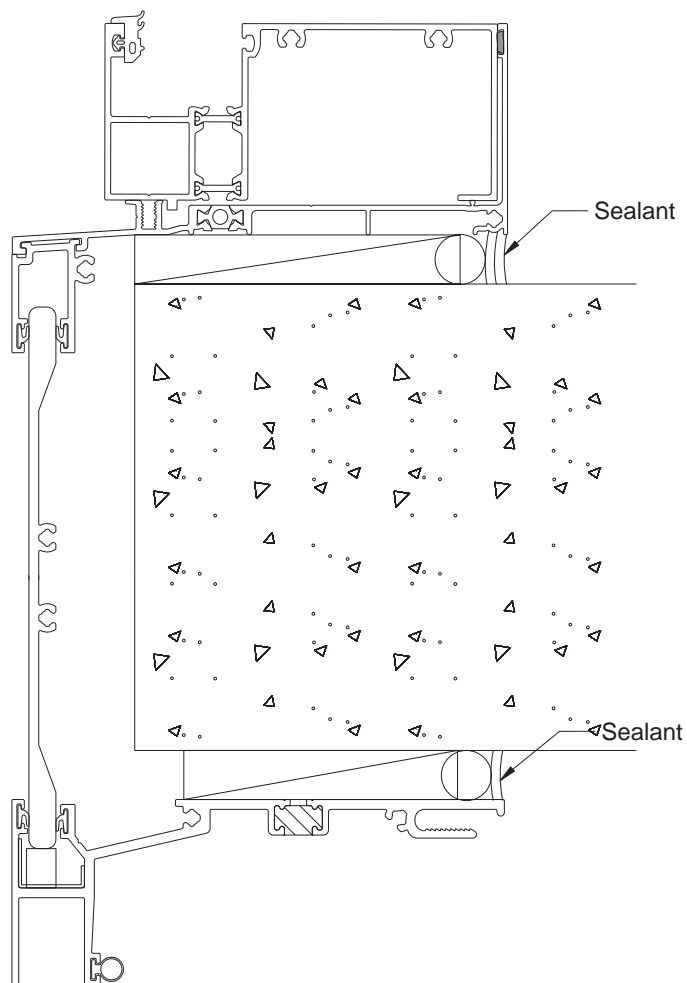


DETAIL 49

FRAME INSTALLATION**STEP 41****APPLY PERIMETER SEALANT**

- Install backer rod and apply sealant to the back of the sill flashing and head receptor.
- Tool sealant prior to skinning over.

See **Detail 50**.



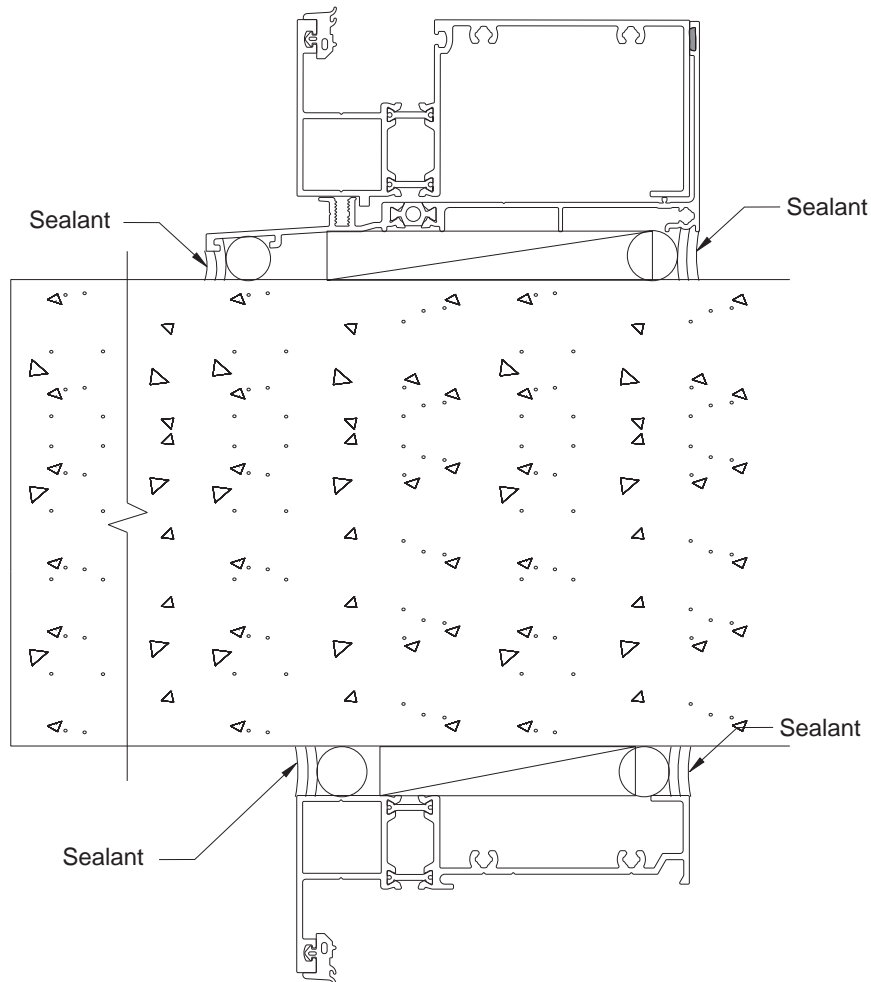
DETAIL 50
(WITH SLAB EDGE COVER)

FRAME INSTALLATION

STEP 41 Continued) APPLY PERIMETER SEALANT

- Install backer rod and apply sealant to the back of the sill flashing and head receptor.
- Tool sealant prior to skinning over.

See **Detail 51**.



DETAIL 51
(WITHOUT SLAB EDGE COVER)

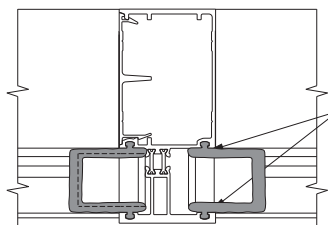
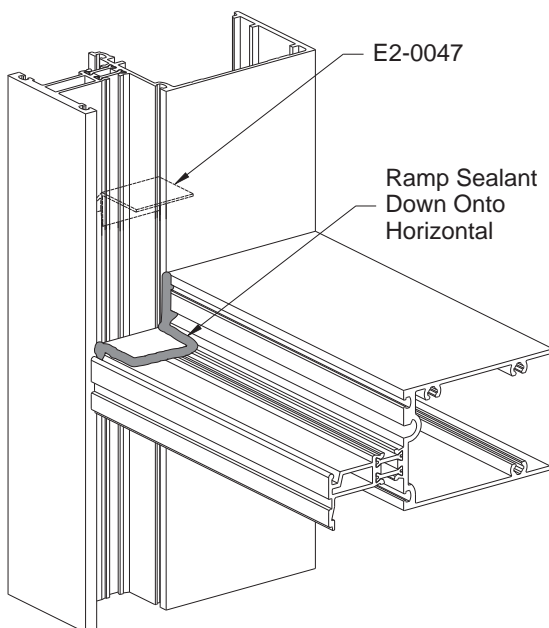
FRAME INSTALLATION

STEP 42 INSTALL WATER DEFLECTORS (Standard Mullions and Jamb)

The installation of a water deflector, E2-0047, at the ends of every intermediate horizontal is required to divert water away from the insulated units.

- Clean and dry off the glazing pocket of each horizontal at the ends.
- Peel off the protective paper and install the water deflector at the end of the horizontal.
- Position the vertical leg of the deflector against the end of the horizontal.
- Apply and tool sealant along the edges of the water deflector down onto the horizontal.
- Seal the ramp of the water deflector to the sides of the glazing pocket wall.

See **Detail 52**.



Seal Ramp of
Deflector to the
Pocket Wall

DETAIL 52

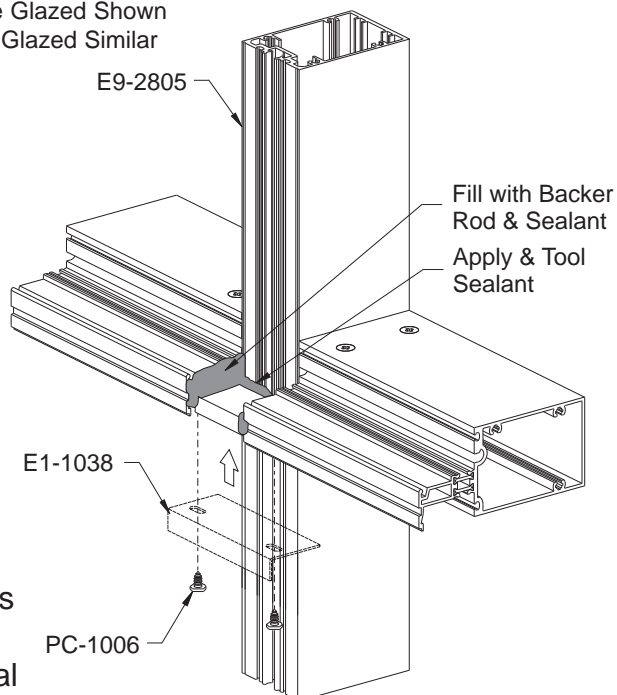
Outside Glazed Shown
Inside Glazed Similar

STEP 43 INSTALL HORIZONTAL BRIDGES (For SSG Verticals Only)

The installation of horizontal bridge, E1-1038, is required to bridge the gap between intermediate horizontals at the SSG vertical.

- Clean and dry off the glazing pocket of each horizontal at the ends.
- Install E1-1038 from the underside of the horizontals with a PC-1006 fastener on each side.
- Fill the cavity of the horizontal with backer rod and completely cover the end of the horizontals with sealant.
- Apply and tool sealant at all bridge to horizontal and vertical joints to ensure a watertight seal.

See **Detail 53**.



DETAIL 53

FRAME INSTALLATION

**STEP 44
INSTALL 1/4" GLAZING ADAPTORS
(When Required)**

Attach the vertical glazing adaptors first.

For Standard Verticals:

- Apply sealant in the vertical gasket reglets.
- Center the vertical adaptor in the opening.
- Position the foot of the adaptor into the MegaTherm recess and rotate the other end into the gasket reglet of the mullion.

For SSG Verticals:

- Center the vertical adaptor in the opening.
- Attach the SSG glazing adaptor, E9-2716, to the mullion with PC-1010 fasteners, 2" from each end and no more than 18" on center.
- Seal all screw heads.

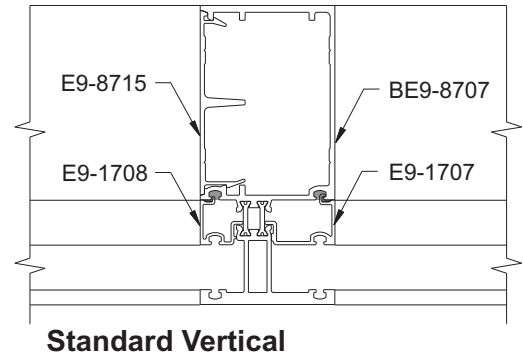
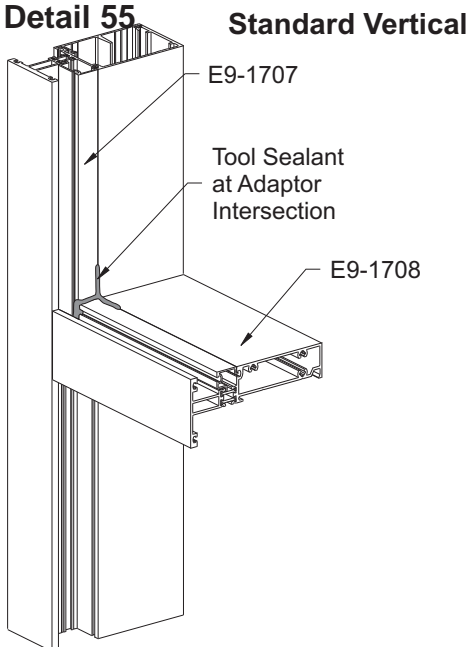
See **Detail 54**.

Attach the horizontal glazing adaptors last.

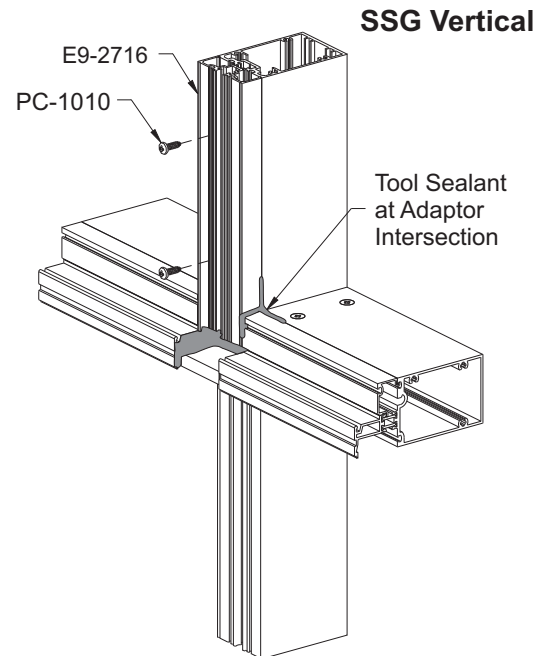
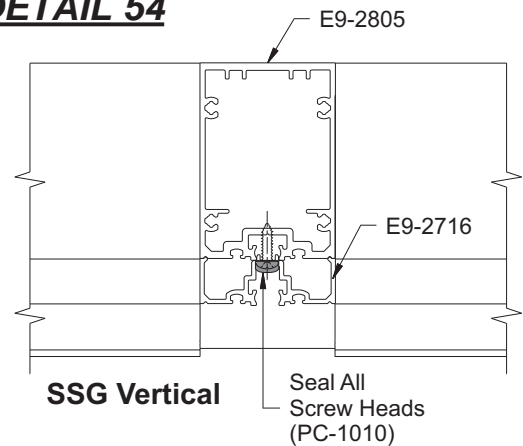
- Apply sealant to the ends of the horizontal glazing adaptors.
- Install the horizontal adaptors.

-Tool the sealant at the intersections of the adaptors to completely seal the joint.

See **Detail 55**.



DETAIL 54



DETAIL 55

GLAZING

STEP 45 INSTALL PUSH IN GLAZING GASKETS

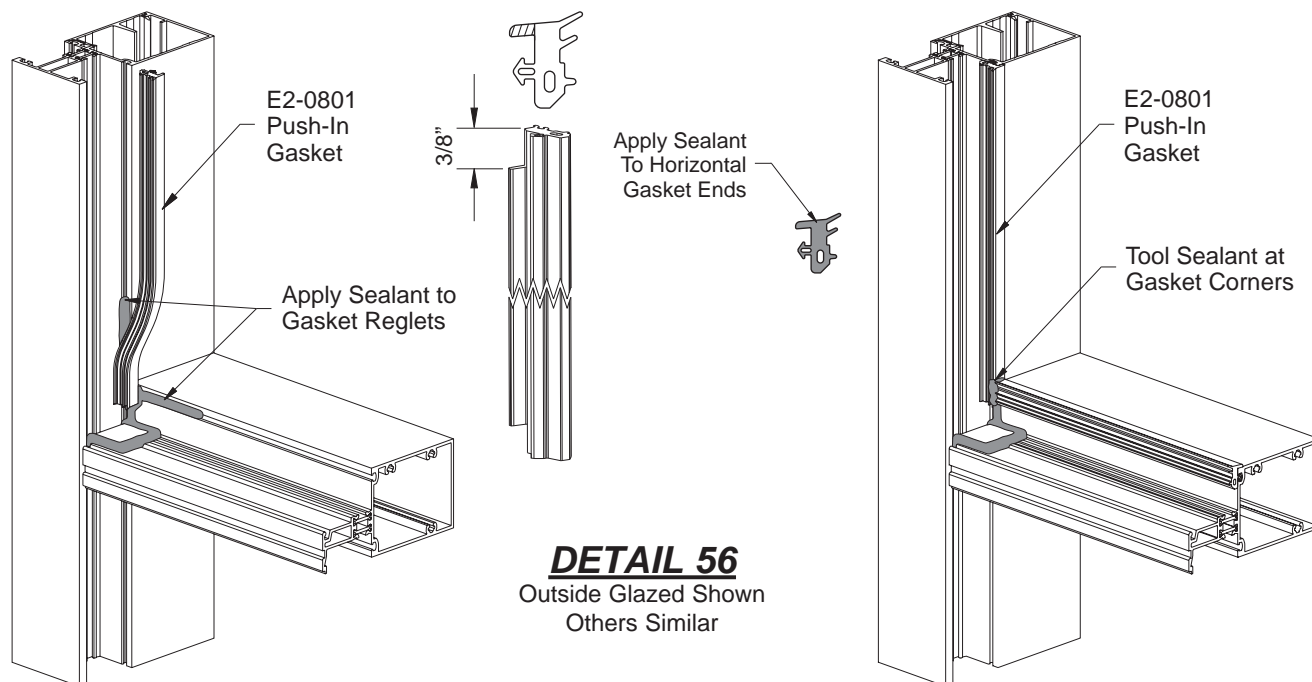
For inside glazing: Push-in gasket, E2-0801, must be installed on the exterior prior to glazing.
For outside glazing: Push-in gasket, E2-0801, must be installed on the interior prior to glazing.

-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 the Daylight Opening plus(+) 3/4" plus(+) an additional 1/4" for each foot of length. Notch ends of the vertical gasket as shown.
- Insert the gasket into the reglets at each end first; 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.

See **Detail 56**.



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; 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.
- Tool the excess sealant at the gasket corners to ensure a watertight seal.

See **Detail 56**.

-See **Step 46** on **Page 47** for SSG gasket instructions.

GLAZING

STEP 46
INSTALL GLASS FOR STANDARD GLAZING

Determine the glass size:

	Width	Height
Standard Glazing	D.L.O. + 7/8"	D.L.O. + 7/8"

- Install setting blocks at 1/4 points or according to engineering calculations.
At intermediate horizontals: E2-0184 for 1" glazing and E2-0192 for 1/4" glazing.
At sill conditions: E2-0182 for 1" glazing and E2-0190 for 1/4" glazing.

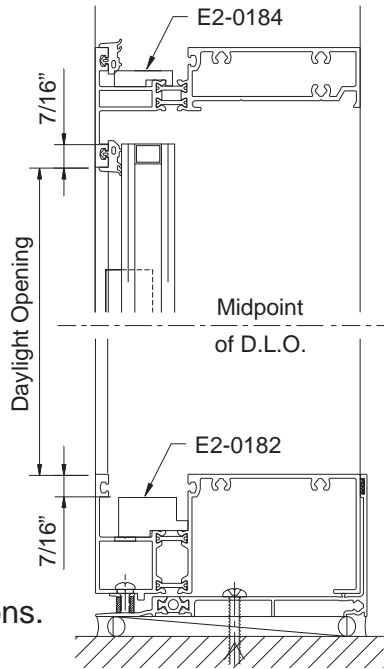
See **Detail 57**.

- Install side blocks, E2-0186, in the shallow glazing pocket of each vertical at the midpoint of daylight opening.
- Carefully install glass into the frame making sure that setting and side blocks are properly aligned with the glass.

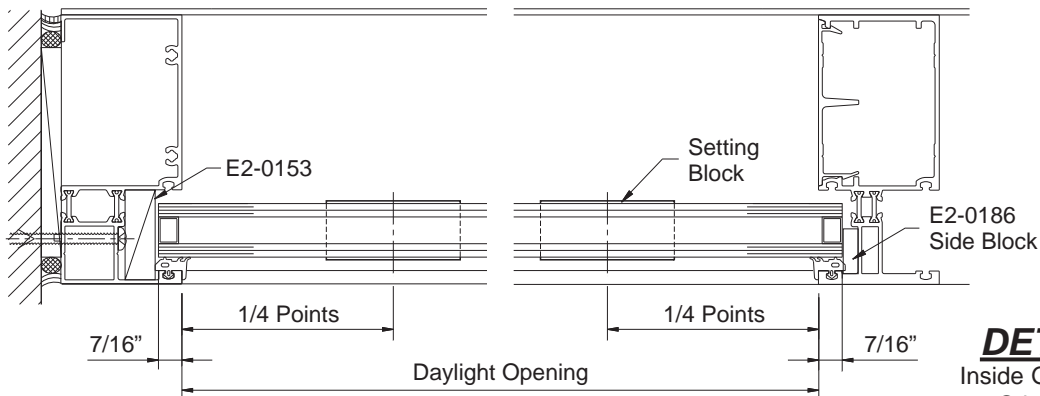
Note: Be careful not to disengage any gaskets that have already been installed when installing glass.

See **Details 57 & 58**.

After glass is set, install one (1) E2-0153 anti-walk block at the deep pocket mullion locations.



DETAIL 57



DETAIL 58
Inside Glazed Shown
Others Similar

GLAZING

**STEP 46 (Continued)
INSTALL GLASS FOR STANDARD GLAZING**

For Interior Glazing:

Interior glass stops are required at all head and intermediate horizontals:

E9-8711 for 1" glazing and

E9-7703 for 1/4" glazing.

-Apply a quality non-hardening sealant to each end

of the glass stops and snap them into position.

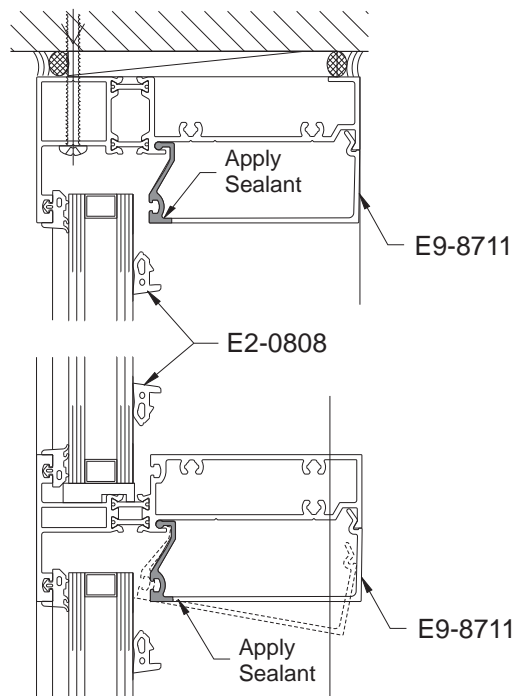
-Tool the sealant into the joint between the glass

stop and the vertical to ensure a watertight seal and wipe away any excess sealant.

See **Detail 59**.

-Install the interior wedge gaskets, E2-0808, to the Daylight Opening plus(+) 1/4" for each foot of length.

Note: Always install vertical glazing gaskets first.



DETAIL 59

For Outside Glazing:

Exterior face covers are required at all sill and intermediate horizontals:

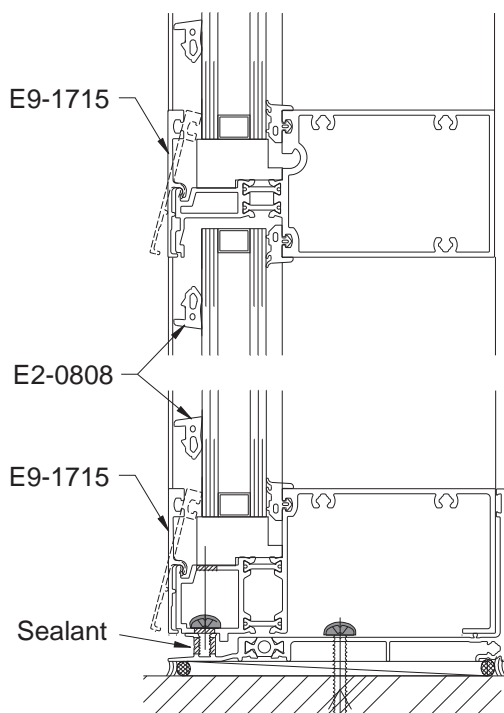
E9-1715 for BE9-2823 horizontal members.

-Engage the hook of the face covers with the ball of the horizontal members and rotate them into position.

See **Detail 60**.

-Install the interior wedge gaskets, E2-0808, to the Daylight Opening plus(+) 1/4" for each foot of length.

Note: Always install vertical glazing gaskets first.



DETAIL 60

GLAZING

STEP 46 (Continued)
INSTALL GLASS FOR STRUCTURAL SILICONE GLAZING

Determine the glass size:

	Width	Height
Jamb to SSG	D.L.O. + 1-5/16"	D.L.O. + 7/8"
SSG to SSG	D.L.O. + 1-3/4"	D.L.O. + 7/8"

Determine the gasket size:

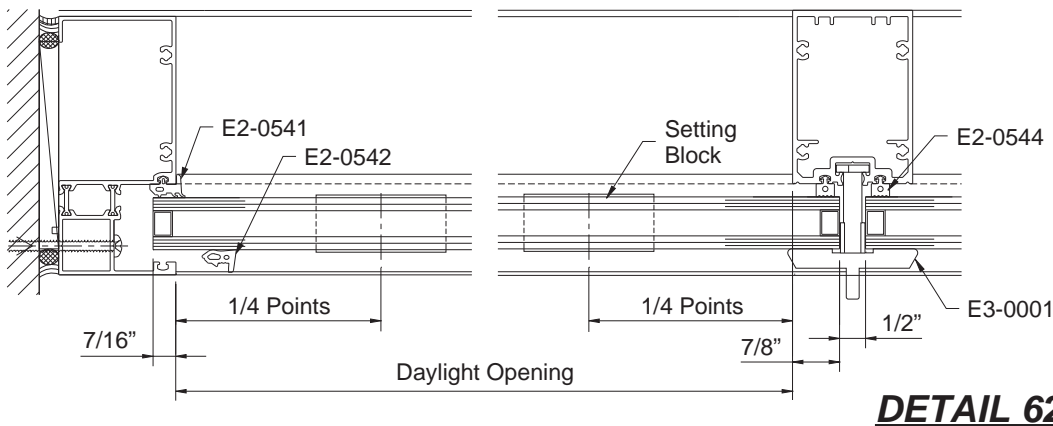
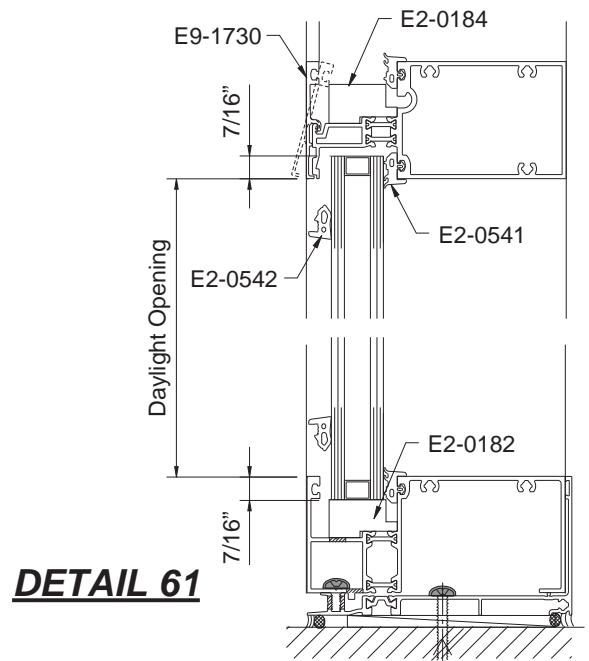
Jamb	D.L.O. + 1/4" per Foot of D.L.O.
Spacer	D.L.O.
Head/Sill	D.L.O. + 1/4" per Foot of D.L.O.

Notch head/sill gaskets as shown on Page 44.

- Install setting blocks at 1/4 points or according to engineering calculations.
At intermediate horizontals: E2-0184 for 1" glazing and E2-0192 for 1/4" glazing.
At sill conditions: E2-0182 for 1" glazing and E2-0190 for 1/4" glazing.
- See **Detail 61**.

- Cut glazing spacer, E2-0544, to the Daylight Opening.
- Install the glazing spacer as shown in **Detail 62**.
- Install the interior glazing gaskets at the jambs and horizontals as shown in **Step 45 on Page 44**.
- Carefully install each lite of glass leaving a 1/2" joint between lites of glass. Be careful not to disturb the interior gaskets and spacers.
- Insert the temporary glass retainers, E3-0001 for 1" glazing or E3-0006 for 1/4" glazing, between the lites and twist them 90° clockwise to engage.
- Locate temporary glass retainers 18" to 24" on center.
- Snap on exterior face covers and install exterior wedge gaskets, E2-0542, starting at one end and work towards the opposite end.

See **Detail 62**.



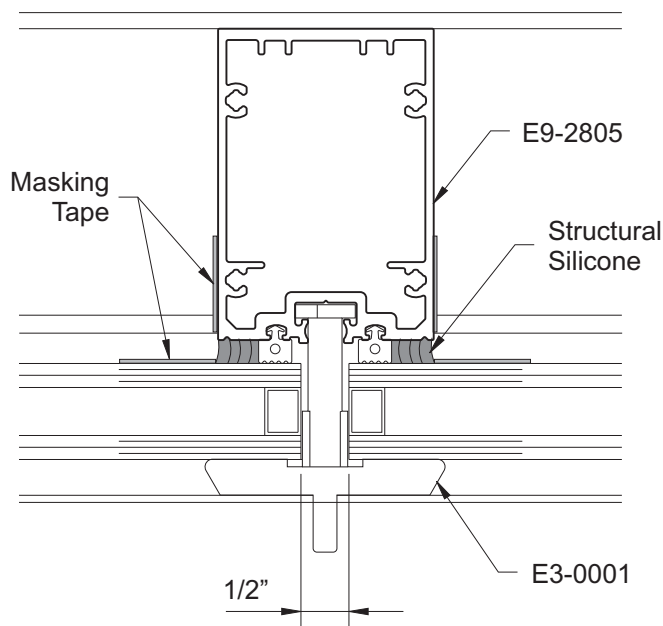
GLAZING

STEP 46 (Continued)

INSTALL GLASS FOR STRUCTURAL SILICONE GLAZING

Apply Interior Structural Silicone:

- Prior to applying structural silicone, clean all contact surfaces using an approved cleaner.
- Run masking tape vertically on the glass with one edge in line with the side of the mullion.
- Run another piece of masking tape vertically along the edge of the vertical next to the glass.



DETAIL 63

- Apply an approved structural silicone from the bottom to the top of the joint. Use positive pressure to completely fill the cavity between the glass and vertical mullion.
 - Using a nylon spatula or other non-scratching implement, tool the silicone immediately after running the vertical joint. Exert positive pressure while tooling to ensure that the silicone completely fills the cavity.
 - Be careful not to remove too much silicone. The silicone should make complete contact with the glass and aluminum surfaces. The finished joint should be flush with the edge of the vertical.
- See **Detail 63**.

Caution: Do not permit the silicone to skin over before it is tooled. Immediately remove masking tape after tooling the silicone.

GLAZING

STEP 46 (Continued) INSTALL GLASS FOR STRUCTURAL SILICONE GLAZING

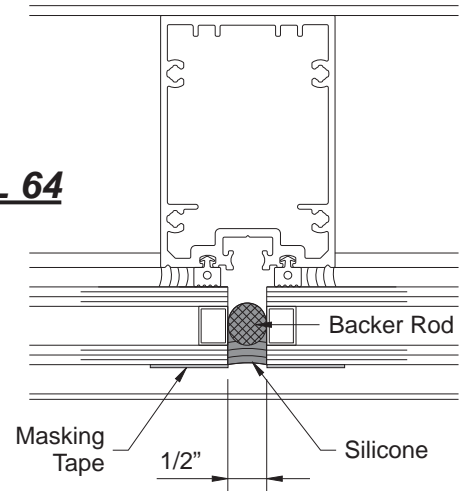
Apply Exterior Weatherseal:

Interior structural silicone must be fully cured before removing temporary retainers. Please consult sealant manufacturer for recommended cure time.

- Remove the temporary glass retainers and insert a backer rod between the lites of glass.
- Clean all contact surfaces with an approved cleaner and apply masking tape to both vertical edges of the glass.
- Starting at the bottom of the lite, pump silicone into the joint between the lites of glass. Apply moderate pressure so that the void is completely filled, and tool.

Caution: Be careful not to puncture the backer rod or push it out of the way.

DETAIL 64



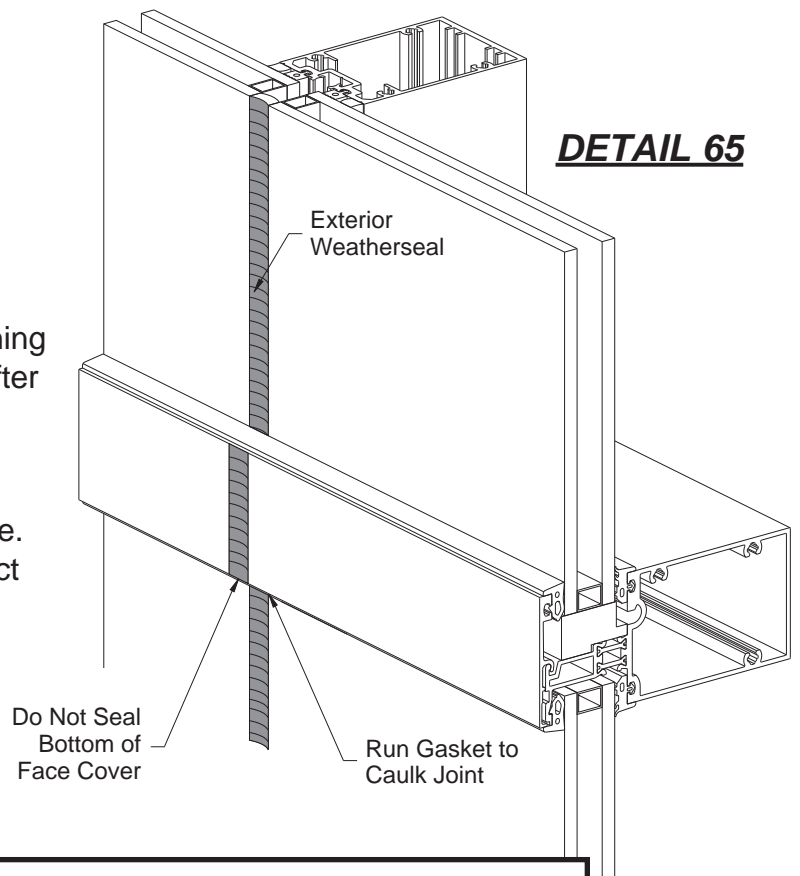
See **Detail 64**.

- At face cover splices, carry the sealant down over the face cover without sealing off the bottom to allow the system to weep properly.

See **Detail 65**.

- Using a nylon spatula or other non-scratching implement, tool the silicone immediately after running the vertical joint. Exert positive pressure while tooling to ensure that the silicone completely fills the cavity.
- Be careful not to remove too much silicone. The silicone should make complete contact with the glass and aluminum surfaces. The finished joint should be flush with the edge of the vertical.

DETAIL 65



Caution: Do not permit the silicone to skin over before it is tooled. Immediately remove masking tape after tooling the silicone.

DOOR FRAME INSTALLATION

STEP 47 INSTALL DOOR FRAME

Doors are shipped assembled, and door frames will be fabricated and shipped knocked down. Please refer to the 20D, 35D, & 50D Entrances Installation Manual for door installation.

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

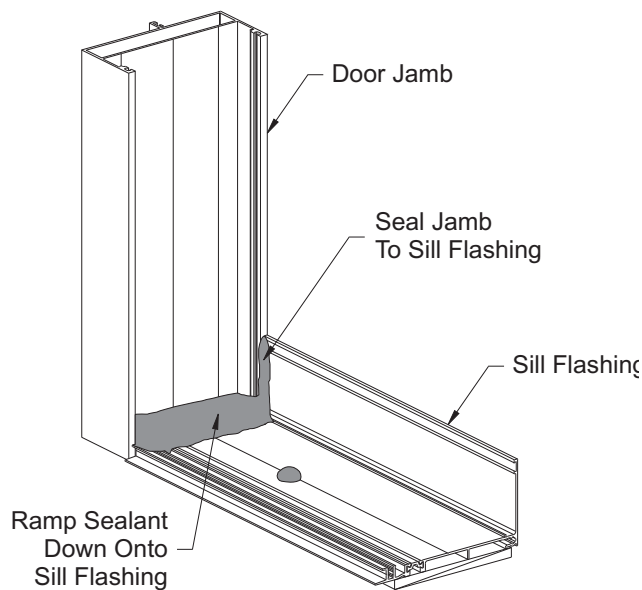
- Apply and tool sealant to all sill flashing to door jamb joints.
- Apply a liberal amount of sealant to completely fill the door jamb cavity and ramp the sealant down onto the sill flashing.

See **Detail 66**.

Glass sizes for transom areas are not the same as for standard YWW 45 T frames. See the table below and **Detail 67** for transom glass sizes.

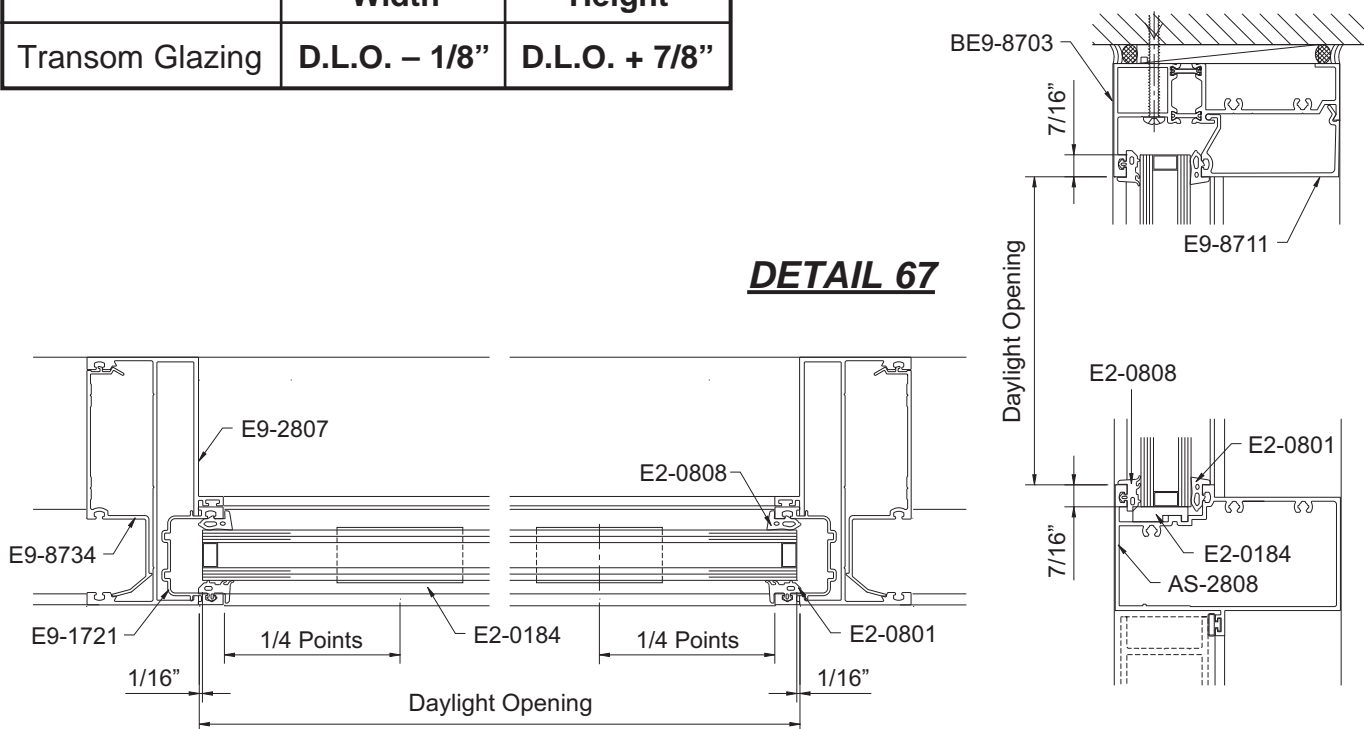
Transom Glass Sizes:

	Width	Height
Transom Glazing	D.L.O. - 1/8"	D.L.O. + 7/8"



DETAIL 66

DETAIL 67





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