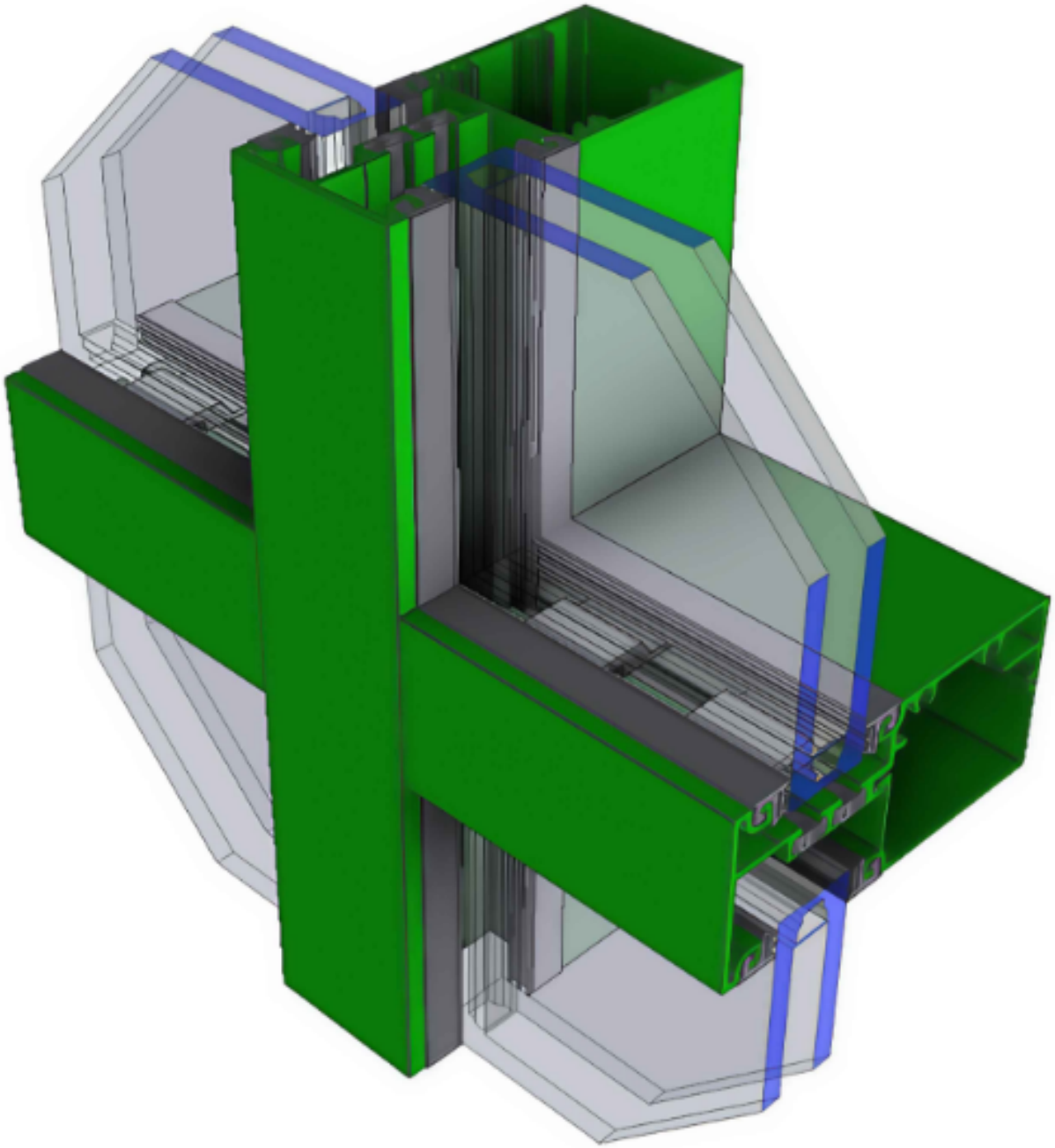
Alumicor™
BUILDING EXCELLENCE

TUBELITE®
DEPENDABLE
LEADERS IN ECO-EFFICIENT STOREFRONT, CURTAINWALL AND ENTRANCE SYSTEMS



14000I/O Storefront

3056 Walker Ridge Dr. NW, Suite G · Walker, MI 49544 · 800-866-2227

TABLE OF CONTENTS

GENERAL CONSTRUCTION NOTES

1. These instructions cover typical product application, fabrication, installation and standard conditions and are general in nature. They provide useful guidelines, but the final shop drawings may include additional details specific to the project. Any conflict or discrepancies must be clarified prior to execution.

2. Materials stored at the job site must be kept in a safe place protected from possible damage by other trades Stack with adequate separation so materials will not rub together and store off the ground. Cardboard or paper wrapped materials must be kept dry. Check arriving materials for quantity and keep a record of where various materials are stored.

3. For cold weather installations, glazing materials (including but not limited to glazing gaskets, isolators and gaskets for air seals and expansion mullions) can become more rigid and thus more difficult to install. These materials should be installed at temperatures above 40°F for proper system performance and ease of installation. A hot box may be required to warm the glazing materials prior to installation. Allow glazing materials to lay flat at 50°F minimum temperature for several hours prior to installing.

4. All field welding must be done in accordance with AISC guidelines. All aluminum and glass should be shielded from field welding to avoid damage from weld splatter. Results will be unsightly and may be structurally unsound. Advise general contractor and other trades accordingly.

5. Coordinate protection of installed work with general contractor and/or other trades.

6. Coordinate sequence of other trades which affect framing installation with the general contractor (e.g. fire proofing, back up walls, partitions, ceilings, mechanical ducts, HVAC, etc.).

7. General contractor should furnish and guarantee bench marks, offset lines and opening dimensions. These items should be checked for accuracy before proceeding with erection. Make certain that all adjacent substrate construction is in accordance with the contract documents and/or approved shop drawings. If not, notify the general contractor in writing before proceeding with installation because this could constitute acceptance of adjacent substrate construction by others.

8. Isolate all aluminum to be placed directly in contact with masonry or other incompatible materials with a heavy coat of zinc chromate or bituminous paint. Fasteners attaching framing to building structure are typically not provided by Tubelite.

9. Sealant selection is the responsibility of the erector, installer and/or glazing contractor and must be approved by the sealant manufacturer with regard to application and compatibility for its intended use. All sealants must be used in strict accordance with the manufacturer's instructions and applied only by trained personnel to surfaces that have been properly prepared.

10. Sealant must be compatible with all materials with which they have contact, including other sealant surfaces. Consult the sealant manufacturer for recommendations relative to shelf life, compatibility, cleaning of substrate, priming, tooling adhesion, environment, temperature, and humidity. Recommend sealant manufacturer perform adhesion "pull test" at "wet" glazing for quality assurance.

11. Drainage gutters and weep holes must be kept clean at all times. Tubelite will not accept responsibility for improper drainage as a result of clogged gutters and weep holes.

12. This product requires clearances at the head, sill and jambs to allow for thermal expansion and contraction as well as construction tolerances. Refer to final distribution drawings for joint sizes. Joints smaller than $\frac{1}{4}$" (6.3mm) may be subject to failure. Consult the sealant manufacturer for proper sizing of joints.

13. All framing members, entrances and other materials are to be installed plumb, level, and true with regard to established bench marks, column center lines, or other working points established by the general contractor and checked by the erector, installer, and/or glazing contractor.

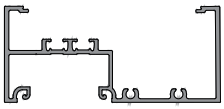
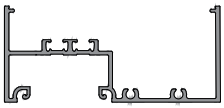
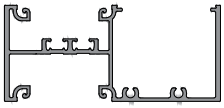
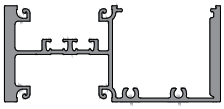
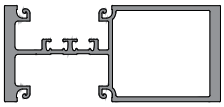
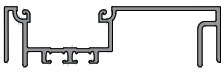
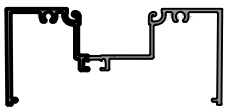
14. After sealant is set and a representative amount of the wall has been glazed (500 square feet or more), run a water hose test to check installation. On large projects, a hose test should be repeated during glazing operation. This testing should be conducted in accordance with AAMA 501.2 specifications.

15. Cleaning of exposed aluminum surfaces should be done per AAMA recommendations.

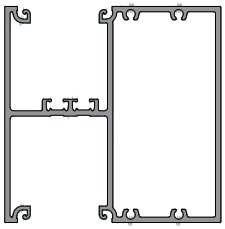
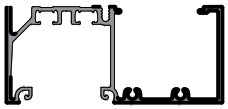
16. Care must be taken when assembling aluminum framing components. Over tightening any fastener may cause stripping or fastener failure. Tubelite recommends the use of clutched drivers to provide satisfactory tightening of the screw while preventing over torque. The use of impact drill motors is not recommended due to the absence of a clutch device.

17. Check www.TubeliteUSA.com for any installation instruction updates.

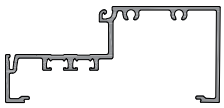
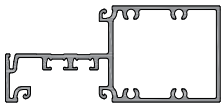
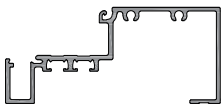
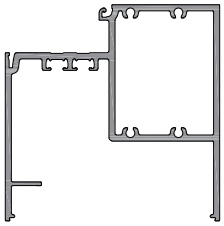
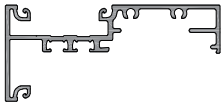
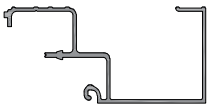
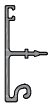
Vertical Extrusions

SHAPE	DESCRIPTION	PART No.
	Head/Jamb/Sill (Use with P1745, P2474, P1130, T6251, P2445 or TU24442)	E15301 T15301 TU15301
	Optional Vertical Mullion & Jamb (Use with E15343, T15343, TU15343 or E15342)	E15311 T15311 TU15311
	Standard Vertical Mullion (Use with E15302)	E15306 T15306 TU15306
	Heavy Vertical Mullion (Use with E15302)	E15356 T15356 TU15356
	Vertical Filler	E15302
	Heavy Tubular Vertical Mullion	E15366 T15366 TU15366
	Male Expansion Vertical (Use with E15346, T15346 or TU15346 with P1221 gasket)	E15336 T15336 TU15336
	Female Expansion Vertical (Use with E15336, T15336 or TU15336)	E15346 T15346 TU15346
	Center Plane to I/O Plane Vertical, use with E15342 (or E/T/TU15312, NOTE: E/T15321 prep is handed, refer to details)	E15321 T15321

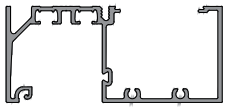
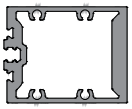
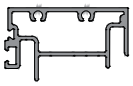
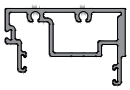
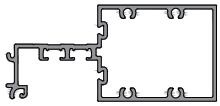
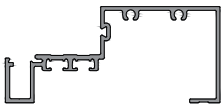
Vertical Extrusions

SHAPE	DESCRIPTION	PART No.
	4-1/2" x 4-1/2" (114.3mm x 114.3mm) Tubular Vertical	E15396 T15396 TU15396
	Deep Pocket Head/Jamb (use with E15339 flat filler (optional))	E15340 T15340 TU15340

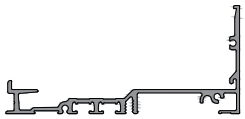
Horizontal Extrusions

SHAPE	DESCRIPTION	PART No.
	Sill- Outside Glazed (Use with E15314 Stop)	E15310 T15310 TU15310
	Intermediate Horizontal- Outside Glazed (Use with E15314 Stop)	E15313 T15313 TU15313
	Pinnable Sill- Outside Glazed (Use with E15364 Stop)	E15363 T15363 TU15363
	4-1/2" x 4-1/2" (114.3mm x 114.3mm) Horizontal- Outside Glazed (Use with E15314 Stop, E15312, T15312 or TU15312)	E15347 T15347 TU15347
	Head & Intermediate Horizontal- Inside Glazed (Use with E15304 Stop)	E15303 T15303 TU15303
	Glass Stop - Inside Glazed (Use with E15303, T15303 or TU15303)	E15304
	Glass Stop - Outside Glazed (Use with E15310, T15310, TU15310, E15313, T15313, TU15313, E15347, T15347 or TU15347)	E15314
	Glass Stop- Outside Glazed (Use With E15363, T15363, TU15363, E15353, T15353 or TU15353)	E15364
	Curvable Head (Use with E14389)	E14388
	Curvable Head Snap (Use with E14388)	E14389

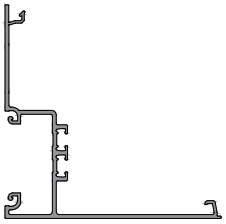
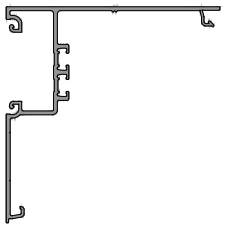
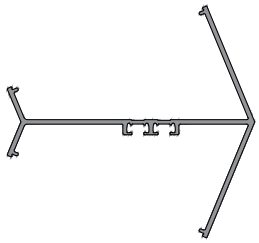
Structural Silicone Glaze Extrusions

SHAPE	DESCRIPTION	PART No.
	SSG Deep Pocket Head & Jamb (Use with E15339)	E15350 T15350 TU15350
	SSG Intermediate Vertical & Horizontal	E15326
	Female SSG Expansion Vertical (Use with E15376)	E15386
	Male SSG Expansion Vertical (Use with E15386)	E15376
	Captured SSG Horizontal (Use with E15324)	E15323 T15323 TU15323
	Glass Stop - Outside Glazed (Use with E15323, T15323 or TU15323)	E15324
	Pinnable Sill- Wet Glazed, Use with SSG vertical (Use with E15364 Stop)	E15353 T15353 TU15353

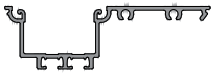
Head Receptor and Sill Flashing Extrusions

SHAPE	DESCRIPTION	PART No.
	Standard Head Receptor (Use with E9410 with P6296 Gasket & P15455 End Dam)	E15129 T15129 TU15129
	Standard Head Receptor Snap (Use with E15129, T15129 or TU15129 with P6296 Gasket)	E9410
	Lightweight Head Receptor (Use with E14091 with P6296 Gasket)	E14090 T14090
	Lightweight Head Receptor Snap (Use with E14090 or T14090 with P6296 Gasket)	E14091
	Standard Subsill (Use with P15455 End Dam)	E15259 T15259 TU15259
	Subsill Starter (Optional) (Use with E15259, T15259 or TU15259)	E15260
	Non-Thermal Subsill (Use with P2455 End Dam)	E14059
	Optional Subsill (Use with P2455 End Dam)	T14055
	Optional Subsill (Use with P2455 End Dam)	T14259

Corner Extrusions

SHAPE	DESCRIPTION	PART No.
	OS 90° Corner Half (Use with E15361, T15361 or TU15361)	E15362 T15362 TU15362
	OS 90° Corner Half (Use with E15362, T15362 or TU15362)	E15361 T15361 TU15361
	135° Corner Vertical (Use with E15312, T15312, TU15312, E15332*, T15332*, TU15332* or E15342) * Outside Outboard or Inside Inboard Corner Only	E15319 T15319 TU15319
	Female SSG OS 90° Corner (Use with E15348)	E15349
	Male SSG OS 90° Corner (Use with E15349)	E15348

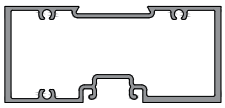
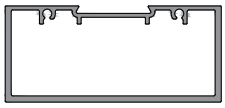
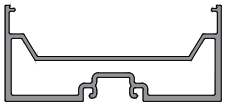
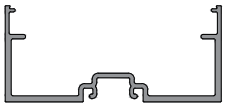
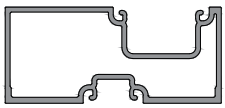
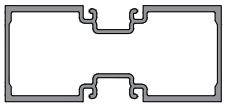
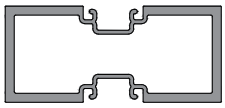
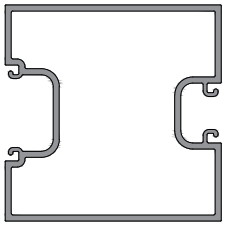
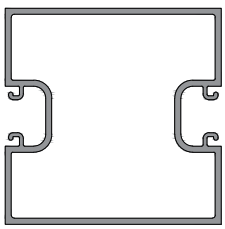
Pocket Fillers and Glazing Adaptors

SHAPE	DESCRIPTION	PART No.
	Shallow Pocket Filler	E15312 T15312 TU15312
	Deep Pocket Filler	E15332 T15332 TU15332
	Non-Thermal Shallow Pocket Filler	E15342
	Flat Aluminum Snap Filler	E4543
	6" Aluminum Flat Snap in Filler Anchor Plate Use at Head and Jamb Anchor Points as Required	P1745
	Flat PVC Snap in Filler Use Between Anchor Points as Required	P2474
	Flat Aluminum Snap in Filler	T6251
	6" Flat Aluminum Snap in Filler Use at Head and Jamb Anchor Points as Required	P1130
	Snap in Sidelite Base Adaptor	E15248 T15248 TU15248
	Flat Snap in FIller	E15343 T15343 TU15343

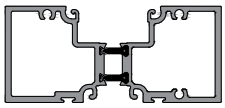
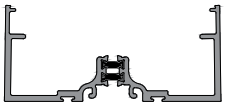
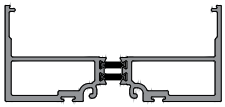
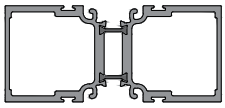
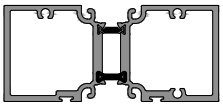
Pocket Fillers and Glazing Adaptors

SHAPE	DESCRIPTION	PART No.
	Thermal Closure Plate	TU24442
	6" Flat Thermal Snap in Filler Use at Head and Jamb Anchor Points as Required	P2445
	Deep Pocket Jamb, Flat Snap in Filler	E15339
	Aluminum 1" (25.4mm) Pocket Filler	E1411
	PVC 1" (25.4mm) Pocket Filler	P4563
	Thermal 1" (25.4mm) Pocket Filler	E15011 T15011
	Snap in 1/4" (6.3mm) Glazing Adaptor	E15036
	Snap in 1/2" (12.7mm) Glazing Adaptor	E15061
	Slide in Brake Metal Receiver	E15139

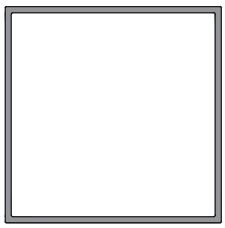
Door Frame Extrusions

SHAPE	DESCRIPTION	PART No.
	Standard Tubular Door Header	E15124
	Tubular Door Header	E15125
	Open Back Tubular Door Jamb (Use with E15343, T15343, TU15343, E15312, T15312, TU15312 or E15342)	E15325
	Open Back Door Jamb (Use with E15343, T15343, TU15343, E15312, T15312, TU15312 or E15342)	E14305
	Tubular Door Jamb	E14341
	Tubular Intermediate Door Jamb	E14145
	Heavy Tubular Intermediate Door Jamb	E14245
	4-1/2" x 4-1/2" (114.3mm x 114.3mm) Tubular Door Jamb	E14250
	4-1/2" x 4-1/2" (114.3mm x 114.3mm) Tubular Intermediate Door Jamb	E45009

Door Frame Extrusions

SHAPE	DESCRIPTION	PART No.
	Strutted Tubular Door Jamb	A649192
	Strutted Open Back Door Jamb (Use with TU15343 or TU15312)	A648585
	Strutted Open Back Tubular Door Jamb (Use with TU15343 or TU15312)	A648080
	Strutted Tubular Intermediate Door Jamb	A646565
	Strutted Tubular Door Head	A645859

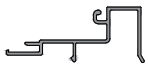
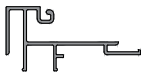
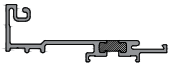
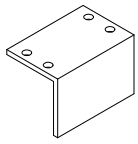
OPTIONAL TUBE MEMBERS

SHAPE	DESCRIPTION	PART No.
	2" x 4 1/2" x 1/8" (50.8 mm x 114.3mm x 3.2mm) Tube	E1451
	4 1/2" x 4 1/2" x 1/8" (114.3mm x 114.3mm x 3.2mm) Tube	E0133

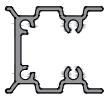
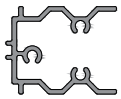
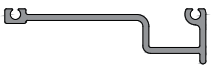
Door Frame Accessories

SHAPE	DESCRIPTION	PART No.
	Non-Thermal Snap-in Door Stop	E4531
	Offset Arm Door Stop	E2298
	1/2" Thermal Door Stop For 3/16" Inset 1-3/4" Door	E5926
	PVC Lower Door Stop	P5923
	3/4" Thermal Door Stop For 3/16" Inset 1-3/4" Door	E5928
	1/2" Thermal Door Stop For 1/16"-1/8" Inset 1-3/4" Door	E5946
	3/4" Thermal Door Stop For 1/16"-1/8" Inset 1-3/4" Door	E5948
	1/2" Thermal Door Stop For Flush 1-3/4" Door	E5966
	3/4" Thermal Door Stop For Flush 1-3/4" Door	E5968
	Threshold	E2550 TA2550

Door Frame Accessories

SHAPE	DESCRIPTION	PART No.
	Snap in Transom Glazing Gutter	E14315
	Transom Gutter Glass Stop	E4015
	Screw Applied Transom Glazing Gutter	E1414
	Snap in Transom Glazing Gutter	E14325
	Thermal Transom Glazing Gutter, use with E15375 glass stop	T15374
	Thermal Transom Glass Stop	E15375
	Sidelite Base Anchor Clip (use with E14027, (2) S149 & (2) S191 screws per clip)	P1137
	Steel Reinforcing - Primer Painted 12'-0" lengths	P1437

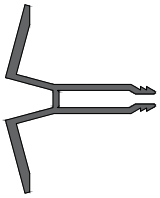
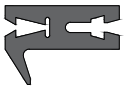
Shear Clips

SHAPE	DESCRIPTION	PART No.
	Horizontal Alignment Key	P15315
	Shear Clip for Inside Glazed Horizontal & Head	P15373
	Shear Clip For Outside Glazed Horizontal & Head	P15316
	Shear Clip for SSG Horizontal	P15327
	Shear Clip for SSG Captured Horizontal & Sill	P15357
	Shear Clip For Outside Glazed 4-1/2" x 4-1/2" Horizontal & Sill	P15397
	Shear Clip for 4-1/2" (114.3mm) Door Header	P532A
	Shear Clip for 4-1/2" (114.3mm) Door Header	P917A
	Shear Clip for 2" (50.8mm) Door Header	P1141A
	Shear Clip for 4-1/2" (114.3mm) Door Header	P531A

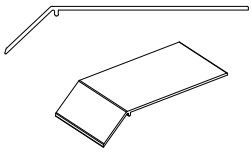
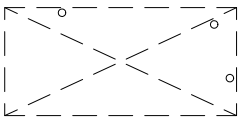
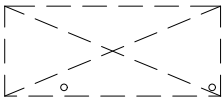
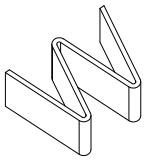
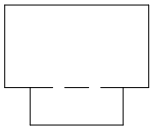
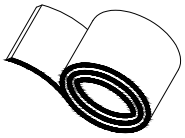
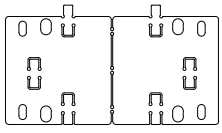
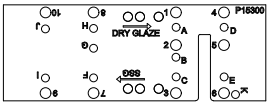
Gaskets and P-Parts

SHAPE	DESCRIPTION	PART No.
	Roll-in Glazing Gasket for 1" (25.4mm) Glass	P2728
	Roll-in Glazing Gasket for 1-1/8" (28.6mm) Glass	P487
	Roll-in Glazing Gasket for Undersized Glass	P2428
	SSG Spacer Gasket	P6587
	Wiper Gasket for One Piece Head Receptor, Expansion Mullion, and Rotational Mullion	P1221
	Bulb Gasket for Thermal Door Frames	P6296
	Wedge Gasket for Standard Subsill	P2901
	Pile Weathering for Thermal Door Frames	P1098A
	Typical Setting Block	P2470 (EPDM) P2470S (Silicone)
	Setting Block (use with E/T/TU15363 sill)	P1167 (EPDM) P1167S (Silicone)
	Inside Glazed Horizontal Setting Block	P2413 (EPDM) P2413S (Silicone)
	Setting Block at Transom	P4720 (EPDM) P4732 (Silicone)

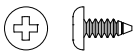
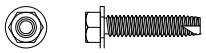
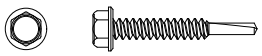
Gaskets and P-Parts

SHAPE	DESCRIPTION	PART No.
	Setting Block, use for E/T/TU15323 horizontal	P946 (EPDM) P947 (Silicone)
	Setting Block, use for E/T/TU15353 sill	P2075 (EPDM) P2505 (Silicone)
	Setting Block, use for horizontal SSG	P5103 (EPDM) P5103S (Silicone)
	Setting Shelf, use for horizontal SSG	P15328
	Setting Block (alternative to P2470 or P1167)	P1180 (EPDM) P1180S (Silicone)
	Temporary Glazing Clip, use for SSG applications	P1108
	Frame Clip for Curving Head Members	P1707
	Water Diverter 12'0", use for Curved Head	P1709
	Optional, Open Cell Weep Baffle 1/2" x 1" x 3" long	PTB42
	Clip for Perimeter Curving - Back	P289

Gaskets and P-Parts

SHAPE	DESCRIPTION	PART No.
	Water Diverter Use at Intermediate Horizontals	P1135
	End Dam for Standard Subsill	P15455
	End Dam for Non-Thermal Subsill	P2455
	EPDM AntiWalk "W" Block (Optional) (Use at Deep Pockets on Verticals and Jambs)	P1917
	SSG Water Diverter	P2407
	Silicone Splice Sleeve (Standard) (Use at T14055, E14059, and T14259 Sill Flashing)	P3444
	Head Receptor Strap Anchor (Optional use in15129 head receptor)	P2918
	14000 I/O Mullion Cap	P15337
	14000 I/O Drill Fixture (screw spline & shear clip)	P15300

Fasteners

SHAPE	DESCRIPTION	PART No.
	#10 1 3/4" type B Philips Pan Head (Fastens shear block to verticals)	S009
	#10 x 1/2" Philips Truss Head (Fastens horizontal and sill to shear block & P1137 anchor to vertical)	S191
	#8 x 3/8" type A Philips Pan Head (Fastens end dam to sill flashing)	S196
	#12-24 x 1" Type 23 hex head washer (Screw spline frame assembly screws)	S204
	#12-24 x 5/8" Phillips Flat Head (Shear Clip Attachment Screws)	S286
	#12-14 x 1-1/2" Hex Washer Head Self-Drilling (SSG shear clip attachment)	S419

Quick Refrence Checklist

1. Make sure the opening is square and the caulk joints are $\frac{1}{4}$"(6.3mm) minimum around the frame. Note: Frames that utilize the T14259, or E15259 sill flashing must have a minimum of $\frac{3}{8}$" (9.5mm) caulk joint at head.
2. Ensure surfaces that will be sealed are free of contaminants that can lead to adhesion issues.
3. Sill flashing must be properly shimmed and level from left to right and front to back for proper drainage.
4. A continuous line of sealant must be applied between the sill and the top interior leg of the sill flashing.
5. Check that all weeps and baffles (if required) conform to the locations and sizes called out in these instructions.
6. Ensure that sill flashing weep holes are not plugged by the perimeter seal.
7. A sill flashing splice is needed in openings larger than 24 feet (7315.2mm). Follow instructions for installing and sealing.
8. End dams must be installed and sealed onto the sill flashing. Fasteners used must also be sealed.
9. Where the sill flashing abuts a door jamb, the jamb pocket cavity must be completely sealed to dam this area.
10. Cap seal any exposed anchor or screw.
11. Seal ends of horizontal frame members that are joined to vertical members.
12. Water diverter installation and sealing is critical. Check installation against instructions to ensure conformity.
13. Apply sealant between all corner gasket joints.
14. Glass bites must be equal on all sides.
15. Double check anchor size and location against installation instructions or approved shop drawings.
16. Ensure that interior seal is married to sill flashing interior leg.
17. Field modify P4543a snap-in PVC filler at the sill to clear the anchors in the sill flashing.
See page 50

GLASS SIZE CALCULATION
Width tolerance = + 0", - $\frac{1}{16}$"(-1.6mm)

Typical Framing:

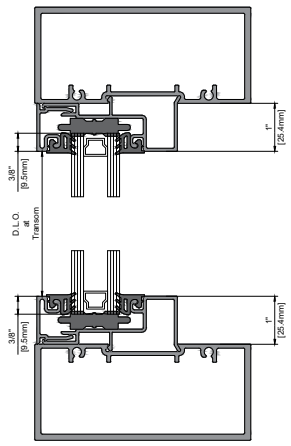
Glass Width = D.L.O plus $\frac{3}{4}$"(19mm)

Glass Height = D.L.O plus $\frac{3}{4}$"(19mm)

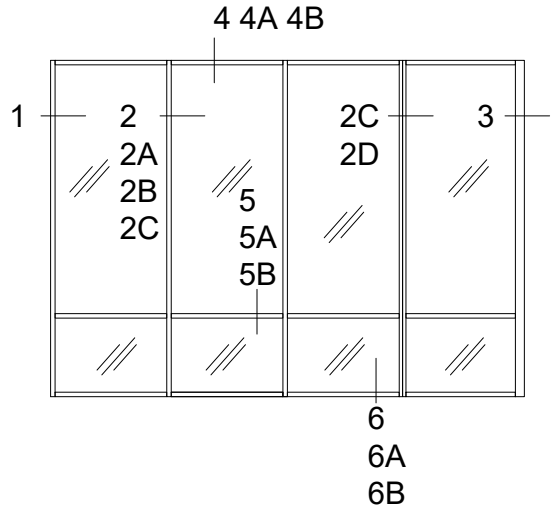
Transoms with Sash:

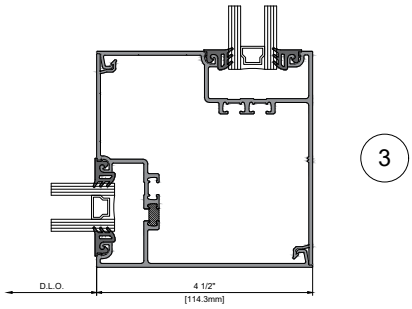
Glass Width = Pocket filler D.L.O plus $\frac{3}{4}$"(19mm)

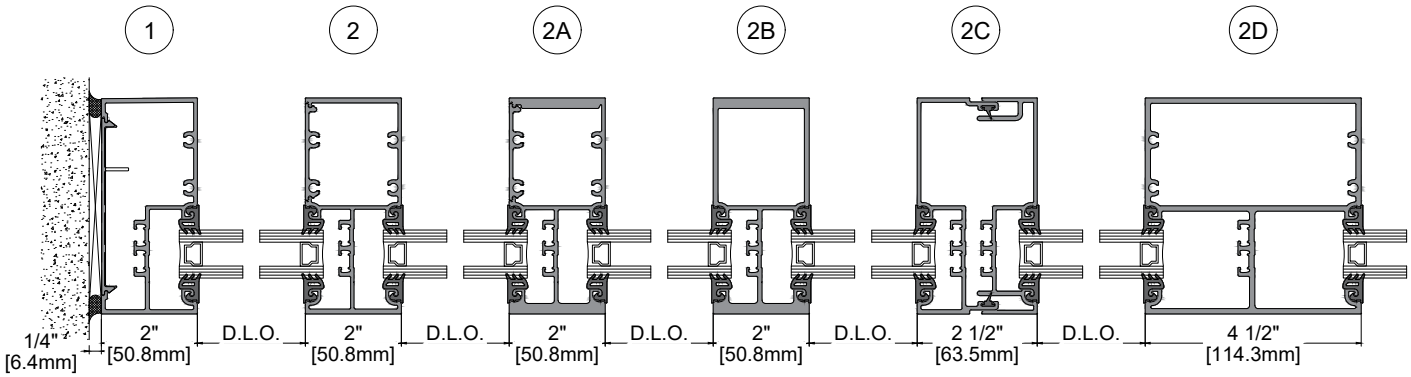
Glass Height = Pocket filler D.L.O plus $\frac{3}{4}$"(19mm)

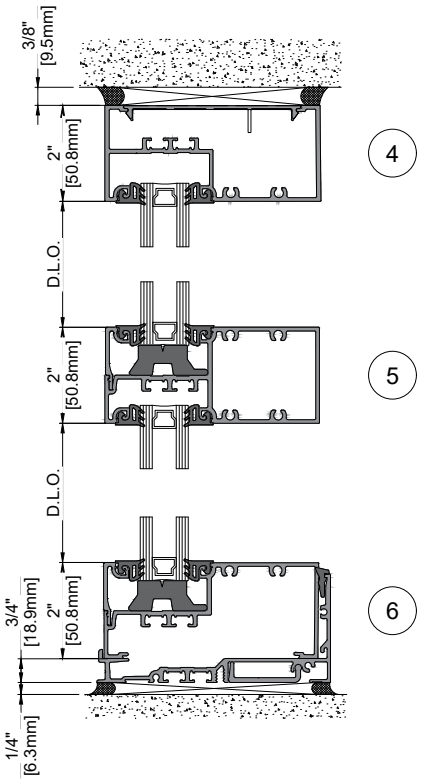


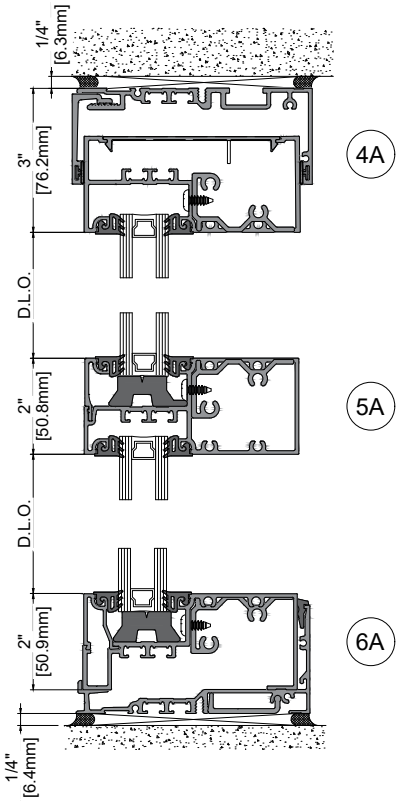
Typical Elevation With Details
Outboard Plane- Outside Glazed

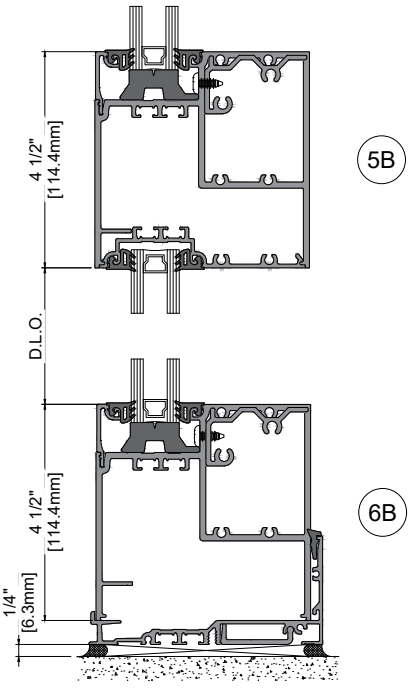




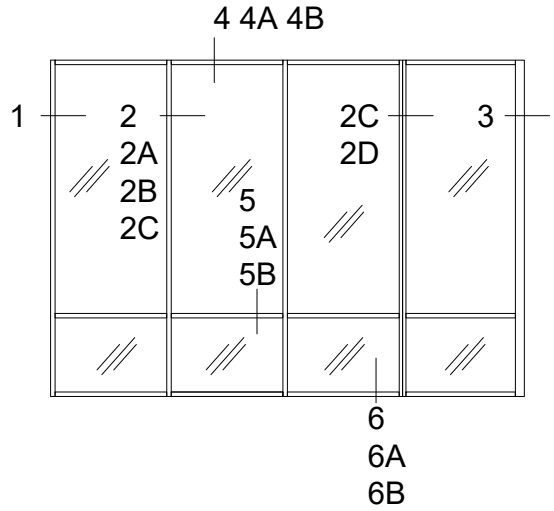


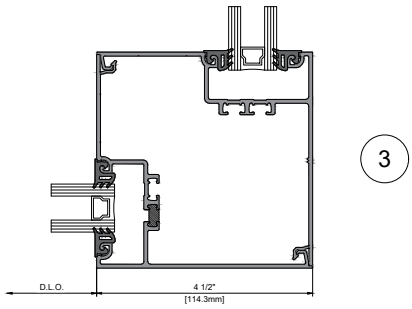


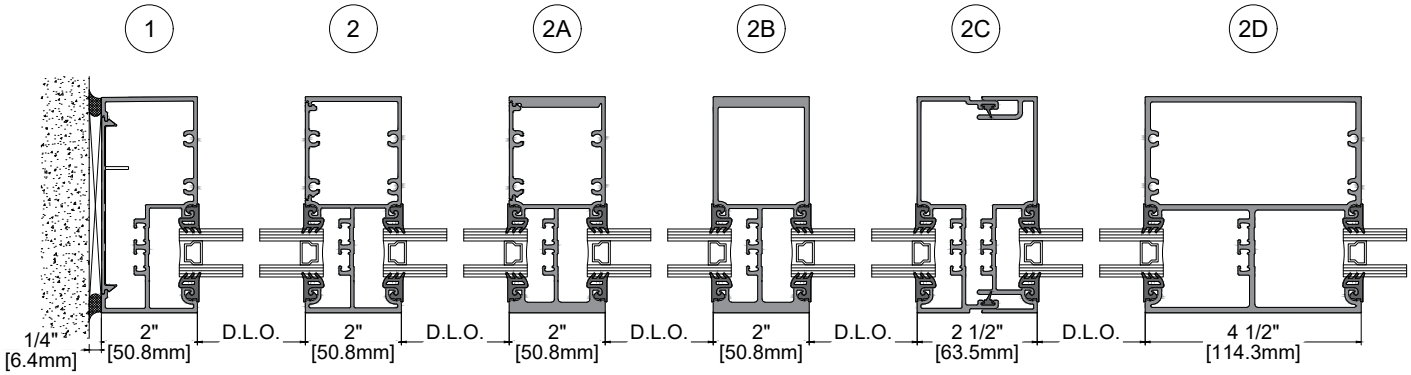


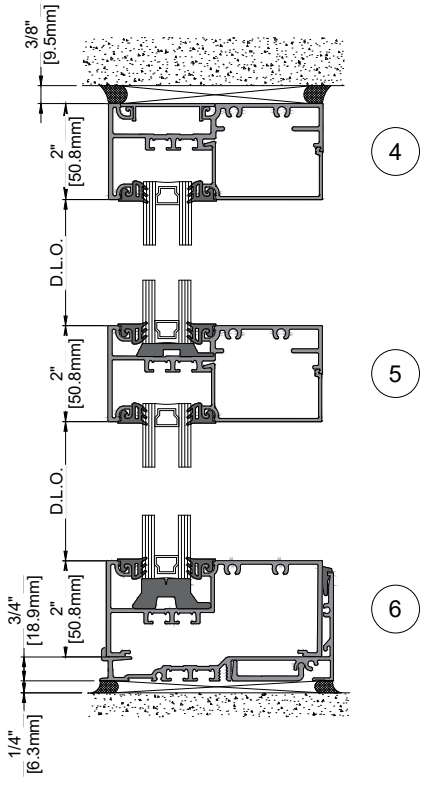


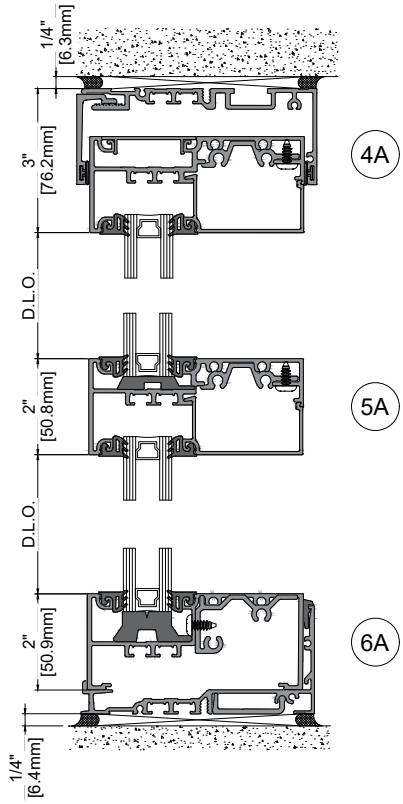
Typical Elevation With Details
Outboard Plane- Inside Glazed



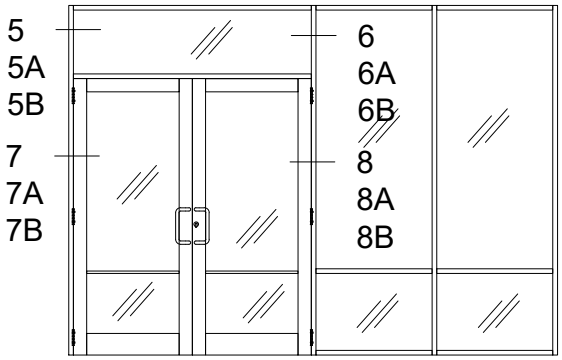




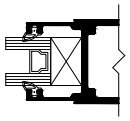


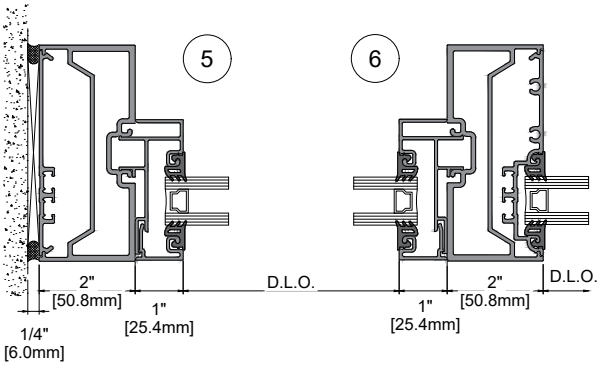


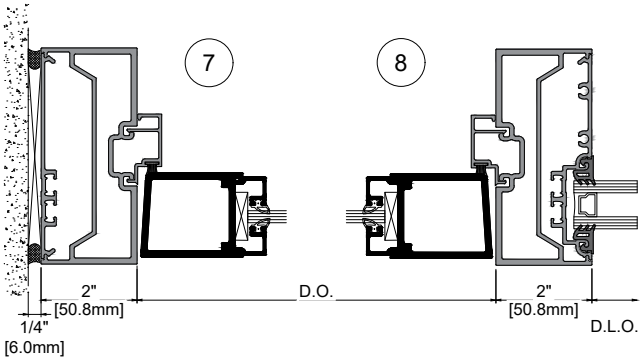
Door Frame Elevation With Details
Outboard Plane

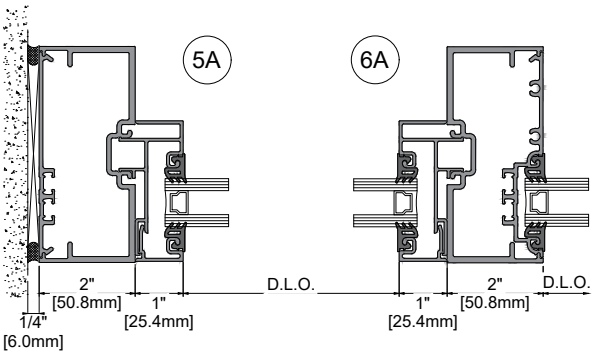


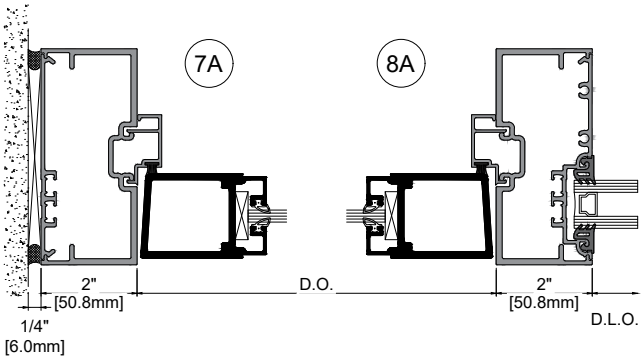
NOTE:
1. Narrow Stile doors are shown. Refer to entrance section for other door types and stiles.
2. Doors are available with a 1"(25.4mm) glazing

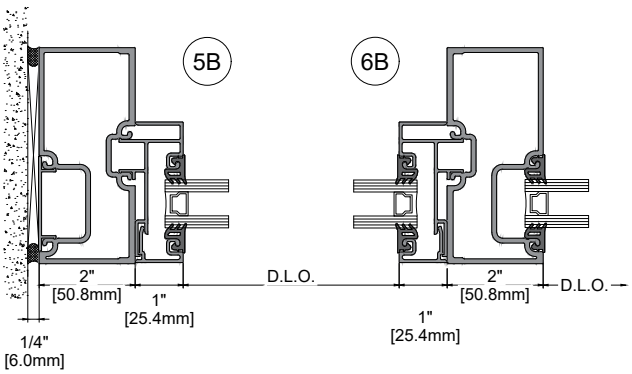


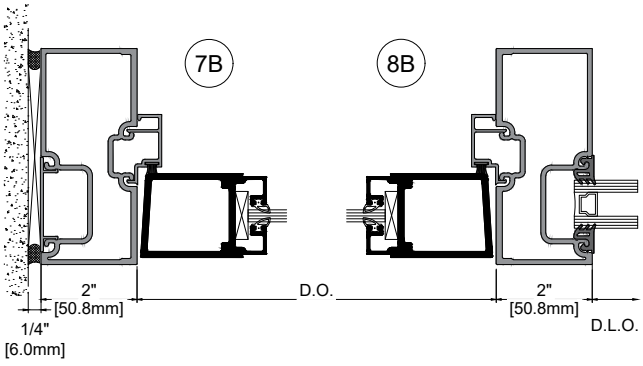




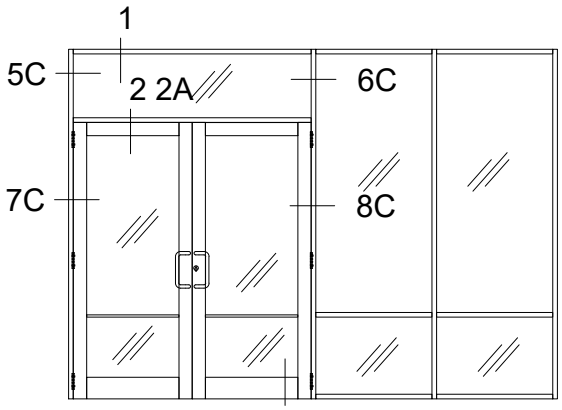


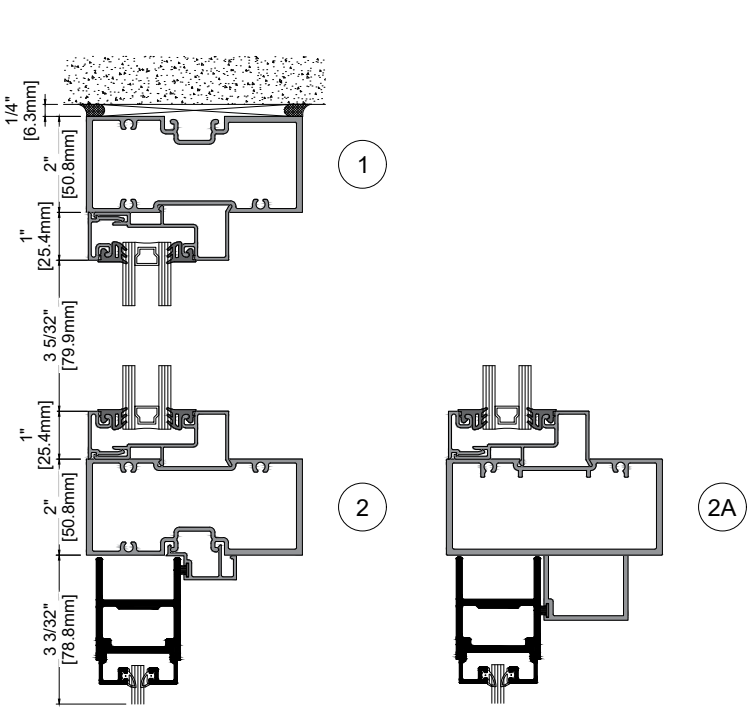


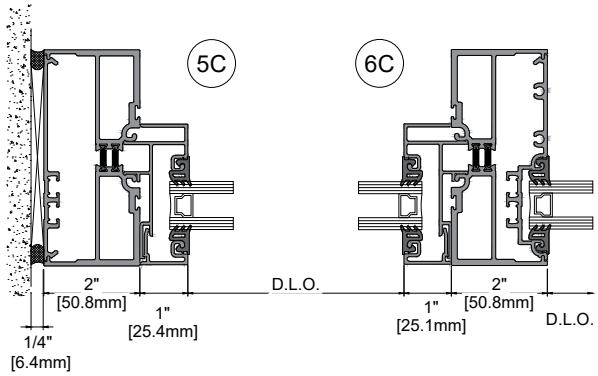


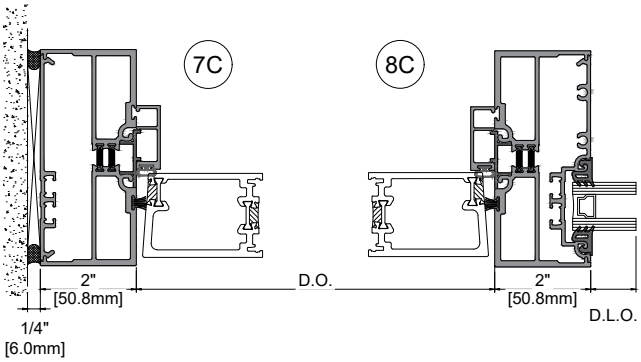


Door Frame Elevation With Details
Outboard Plane

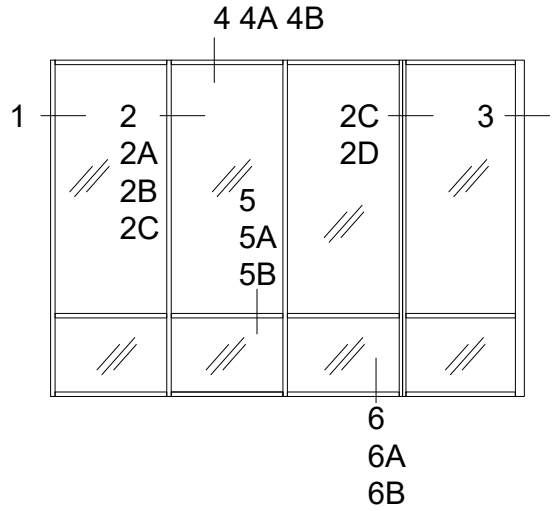


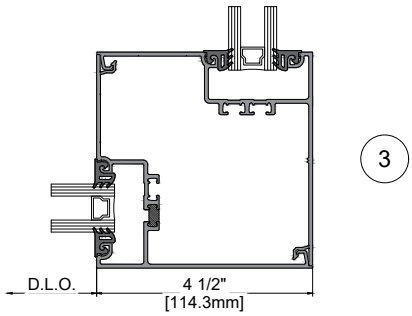


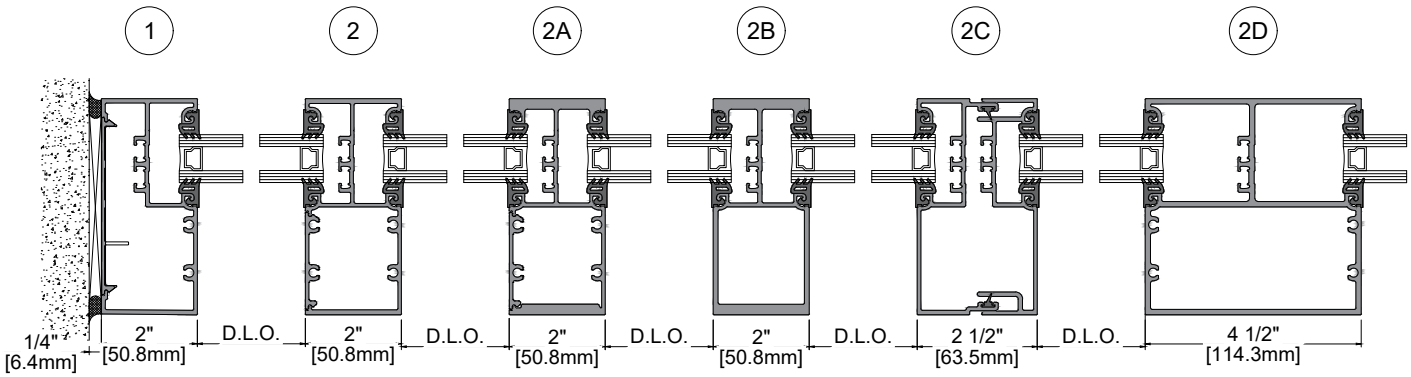


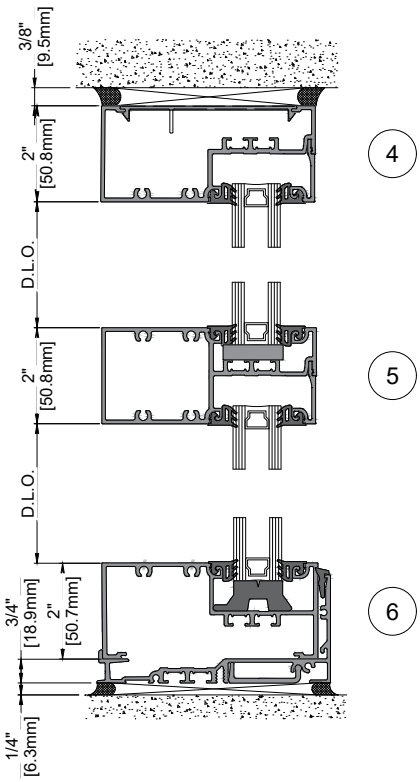


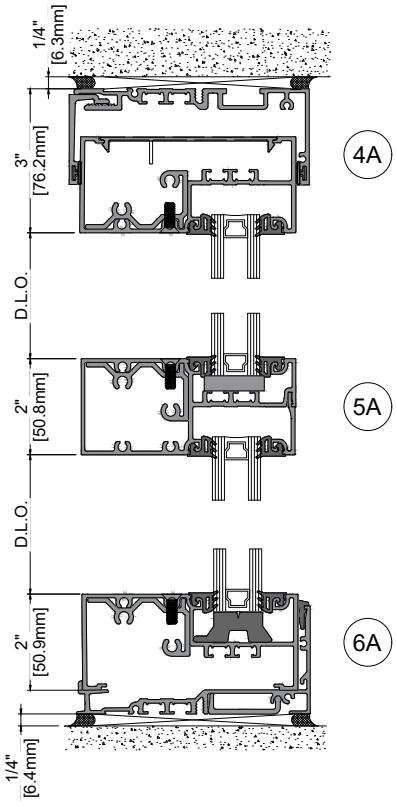
Typical Elevation With Details
Inboard Plane- Inside Glazed

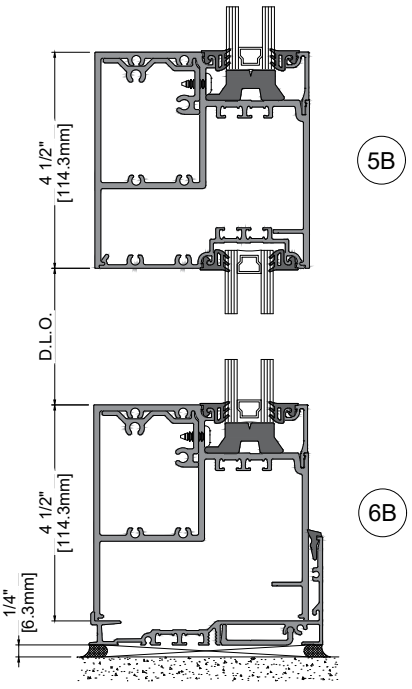




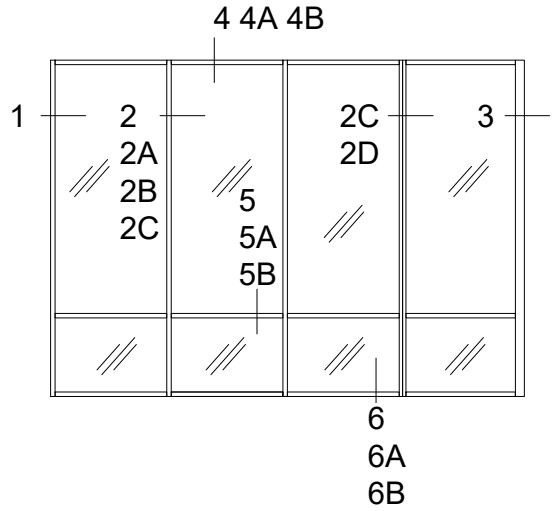


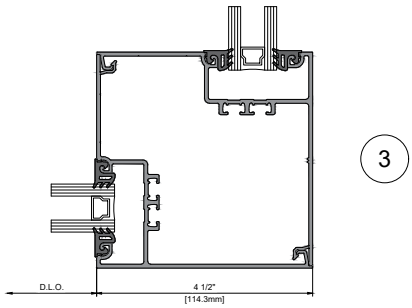


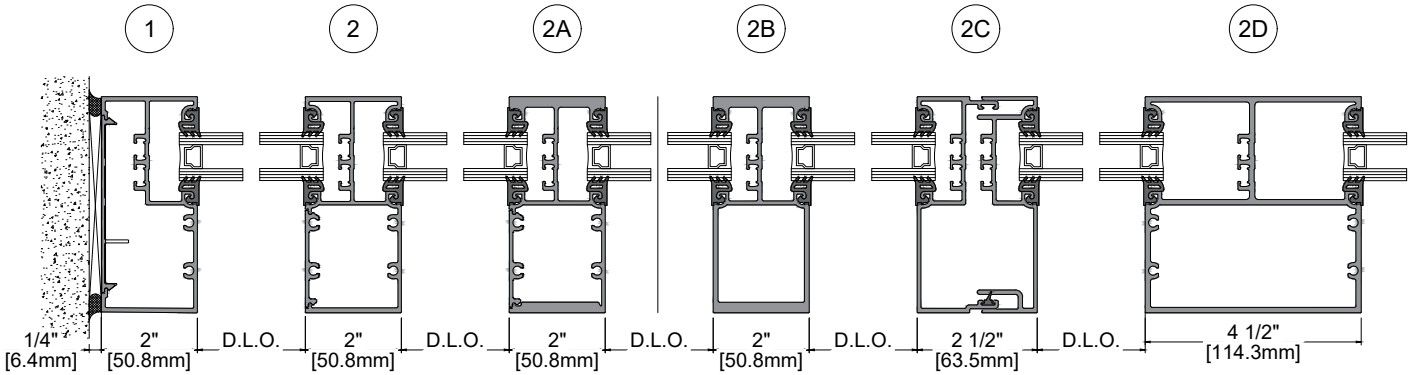


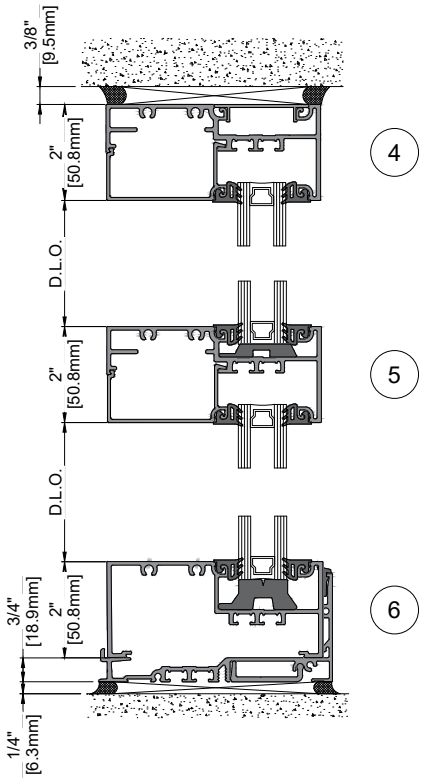


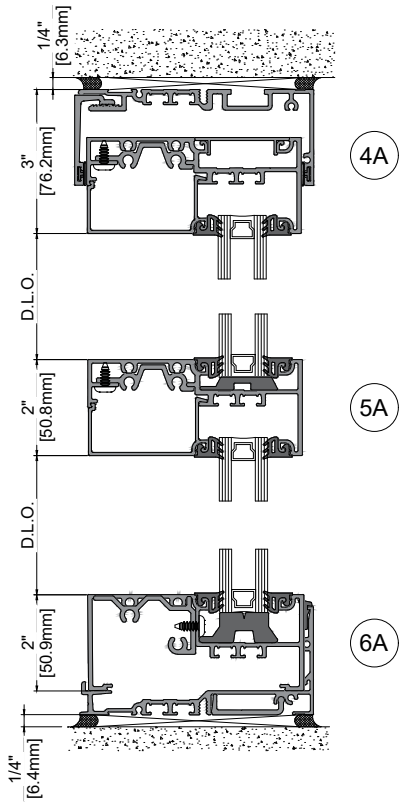
Typical Elevation With Details
Inboard Plane- Outside Glazed











Frame Fabrication

STEP 1

NOTE: Non-thermal extrusions are shown in these instructions for clarity. Fabrication and installation of thermal members are the same.

Step 1: Determine Frame Size

A. Make sure the opening is square and plumb. Measure each diagonal of the opening. **SEE Fig. 1.**

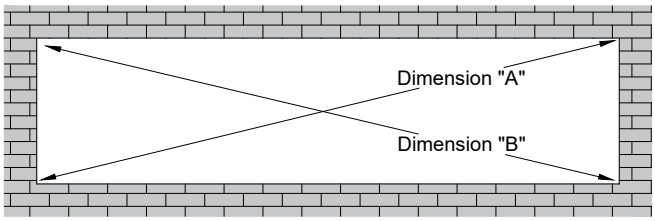


FIG. 1. Dimension "A" = "B"

Frame Width

B. Measure the width of the opening at the top, middle, and bottom. Select the smallest of these dimensions and subtract the left and right caulk joint width per approved shop drawings ($\frac{1}{4}$"(6.3mm) min caulk joint at each jamb). **SEE Fig. 2**.

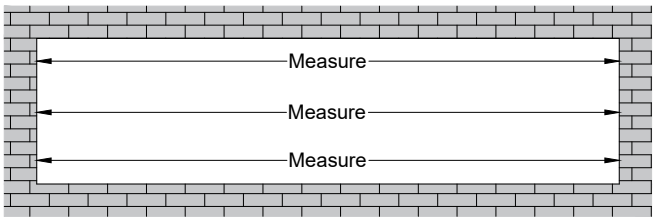


FIG. 2.

Frame Height

C. Measure the height of the opening at several points along the entire width of the opening. Select the smallest of these dimensions and subtract the top and bottom caulk joint height per approved shop drawings ($\frac{1}{4}$"(6.3mm) minimum caulk joint at sill. At head, caulk joint can be $\frac{1}{4}$"(6.3mm) using T14055 or similar flashing. When using T14259, E14059 or E/T/TU15259 sill flashing, head caulk joint must be $\frac{3}{8}$"(9.5mm)). **SEE Fig. 3**.

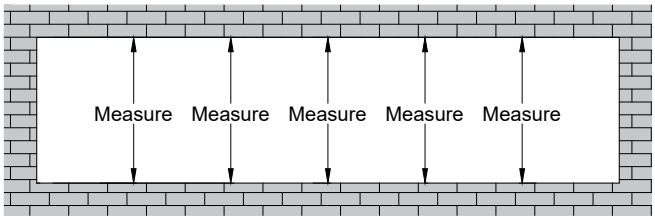


FIG. 3.

FRAME FABRICATION

STEP 2

Step 2: Cut Material to Size

Note: Door framing material comes cut to size from the factory. In cases of door frames with transoms, the door jambs must be cut down in the field to size and head member attached per standard instructions shown within this manual.

Door Jamb with Transom height will equal the Rough Opening height - head caulk gap (minimum $\frac{1}{4}$" (6.3mm) or match head caulk gap of adjacent storefront based on sill flashing. **See Fig. 1**.)

Framing Members

Sill Flashing with Entrance..... Door Jamb to End of Frame + $\frac{1}{8}$" (+3.2mm) (**SEE Fig. 1.**)
Sill Flashing without Entrance..... Frame Width + $\frac{1}{4}$" (+6.3mm)
Verticals..... **See Fig. 1.**
Head Receptor ..... Frame Width + $\frac{1}{4}$" (+6.3mm)
Head Receptor Snap Stop..... Frame Width + $\frac{1}{4}$" (+6.3mm)
Head, Horizontal & Sill..... D.L.O.
Horizontal & Sill Glass Stops..... D.L.O. - $\frac{1}{32}$" (-0.8mm)
Closure Pockets at Verticals..... **See Fig. 4**
Glazing Adaptors..... D.L.O. - $\frac{1}{32}$" (-0.8mm)
Snap-In Fillers..... Refer to Approved Shop Drawings

Accessories

Exterior Gasket..... D.L.O. + Allowance*
Interior Gasket..... D.L.O. + Allowance*

*Allowance = $\frac{1}{8}$"(3.2mm)extra length per foot of D.L.O.

Sill Flashing Note:
For openings wider than 24'(7315.2mm), the sill flashing must be spliced at the center line of a D.L.O. every twelve to fifteen feet. Splice joint should be $\frac{3}{8}$"(9.5mm) wide. **SEE Step 14, Page 51** for sill flashing splice details.

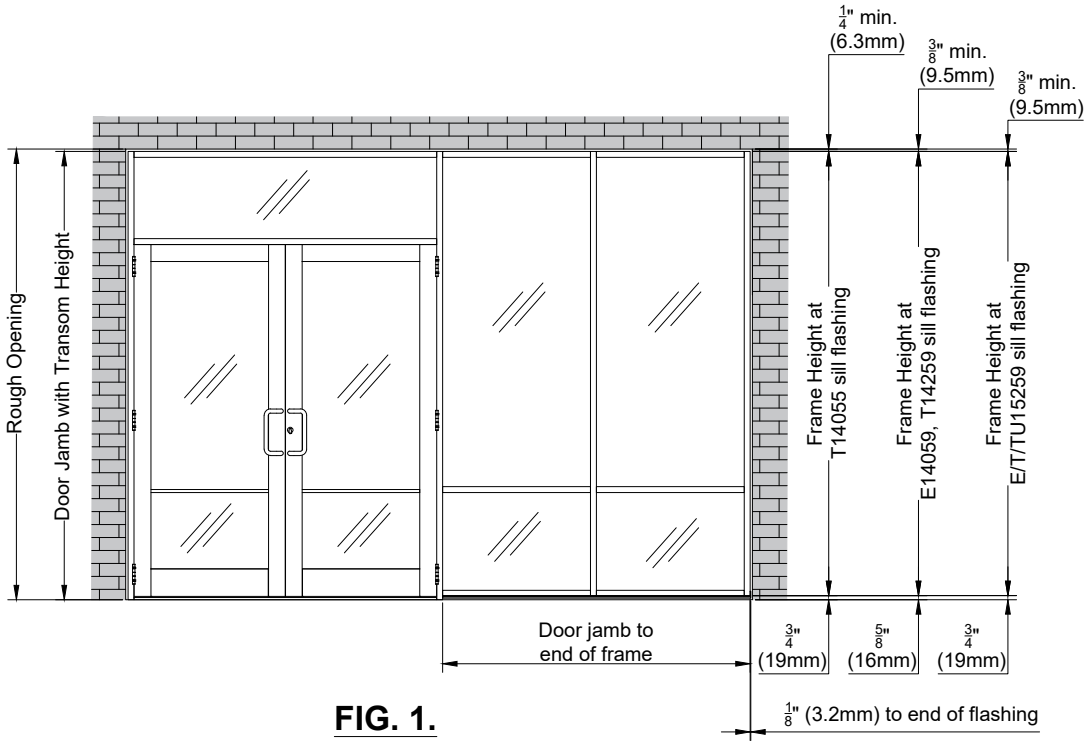


FIG. 1.

Frame Fabrication

STEP 3

Step 3: Fabricate Sill Flashing

A. When using E/T/TU15259, drill two 5/16"(8mm) dia. weep holes at $\frac{1}{4}$ points of the DLO.

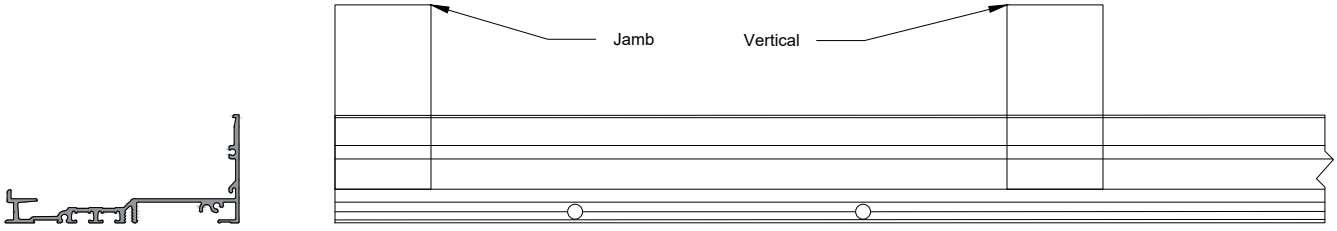
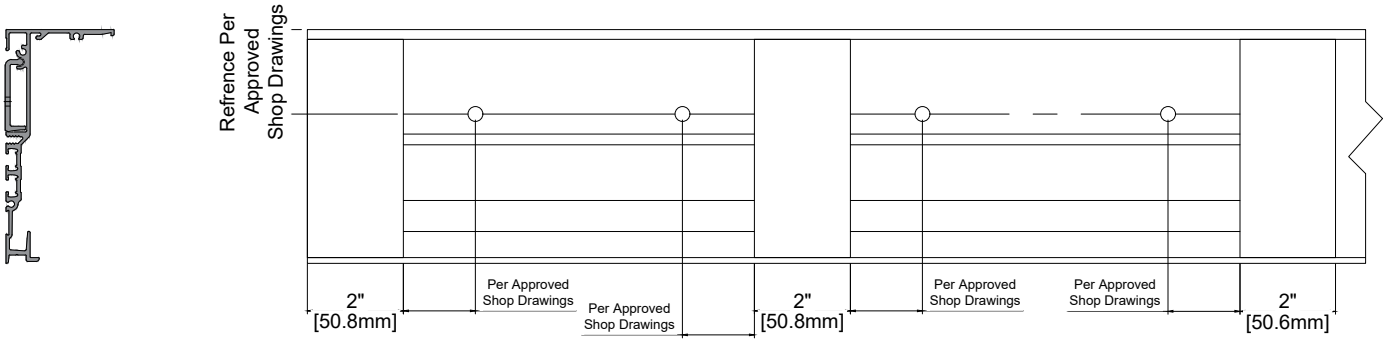


FIG. 1.

B. Drill clearance holes for perimeter anchors. Size and quantity vary per job. Refer to to approved shop drawings.
Note: if head receptors are used, follow the same procedure as on the sill flashing



NOTE: *DLO's Larger than 42" (1066.8mm) require an additional anchor hole at the mid-point of the bay*

* Reference approved shop drawings for anchor hole sizes, locations, and quantity

NOTE: ***If E15260 is used for anchoring, prep is similar. Use V-groove to locate fastener holes.***

FIG. 2.

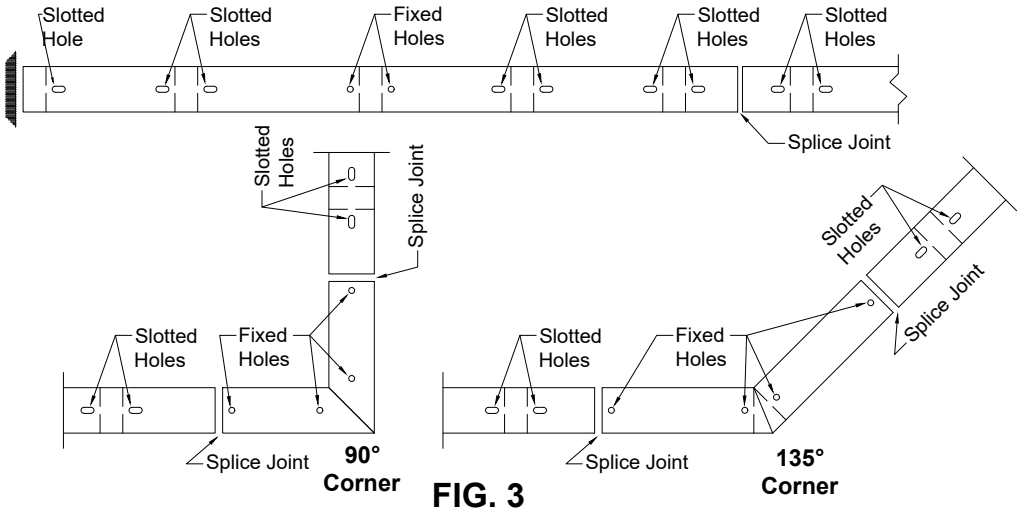


FIG. 3

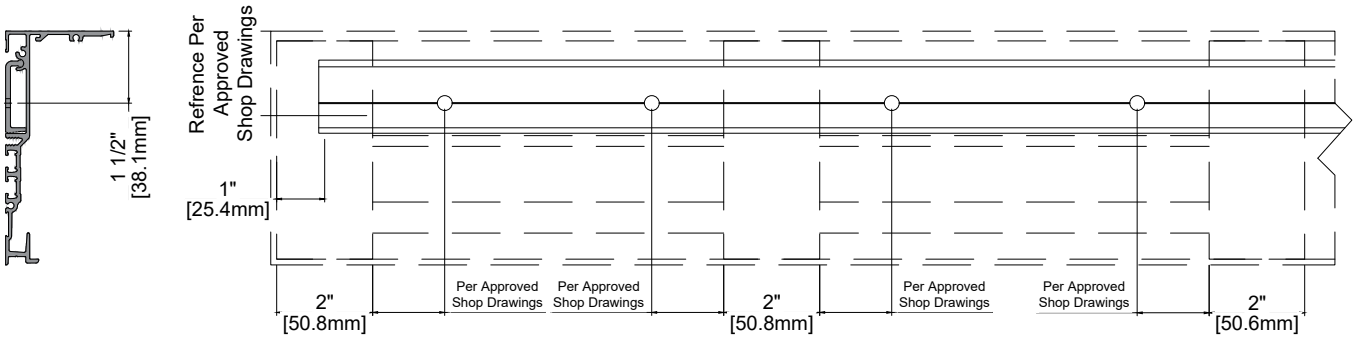
Typical Sill Flashing Anchor Hole Patterns (Head channel similar)
(Refer to approved shop drawings for project requirements)

Frame Fabrication

STEP 3

Step 3: Fabricate Sill Flashing

A. When using E/T/TU15259 with E15260 Starter, cut E15260 starter 2" short of sill flashing length (1" short each end). Use V-notch in E15260 Starter to guide anchor locations. V-notch is 1-1/2" from interior face of E/T/TU15259 sill flashing. Follow anchor layout in E15260 Starter shown on previous page, or alternatively prep for anchors 24" O.C. and 2" from each end or E15260. Defer to approved shop drawings.



* Reference approved shop drawings for anchor hole sizes, locations, and quantity

FIG. 1.

B. When using the E15260 Starter at a corner condition, cut Starter 1" short of shortest dimension of mitered sill flashing. Not necessary to miter the E15260 Starter. Run E15260 starter through at a sill flashing splice, or stagger starter splice and sill flashing splice. Not necessary to seal the splice gap of the E15260 Starter.

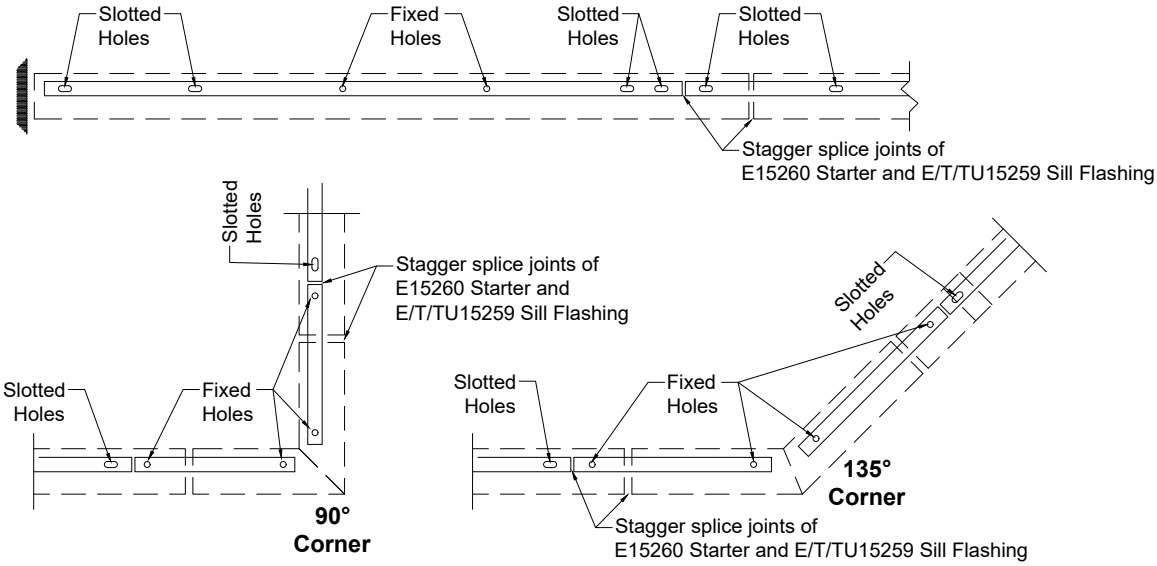


FIG. 2

Typical Anchor Hole Patterns for E15260 Starter at Corner and Splice Conditions
(Refer to approved shop drawings for project requirements)

FRAME FABRICATION

STEP 3

Step 3: Fabricate Sill Flashing (optional Flashing)

E14059, T14055, and T14259 sill flashing are only tested to 10 PSF water

A. When using T14259 or E14059, drill two $\frac{7}{32}$"(5.6mm) dia. weep holes at 2"(50.8") and 6"(152.4mm)from each side of the verticals

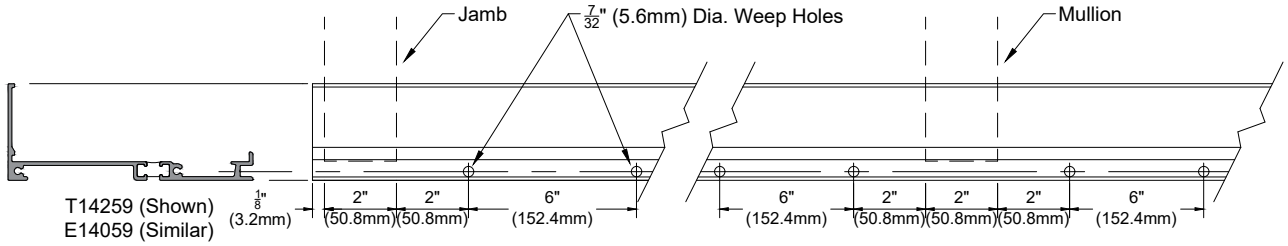
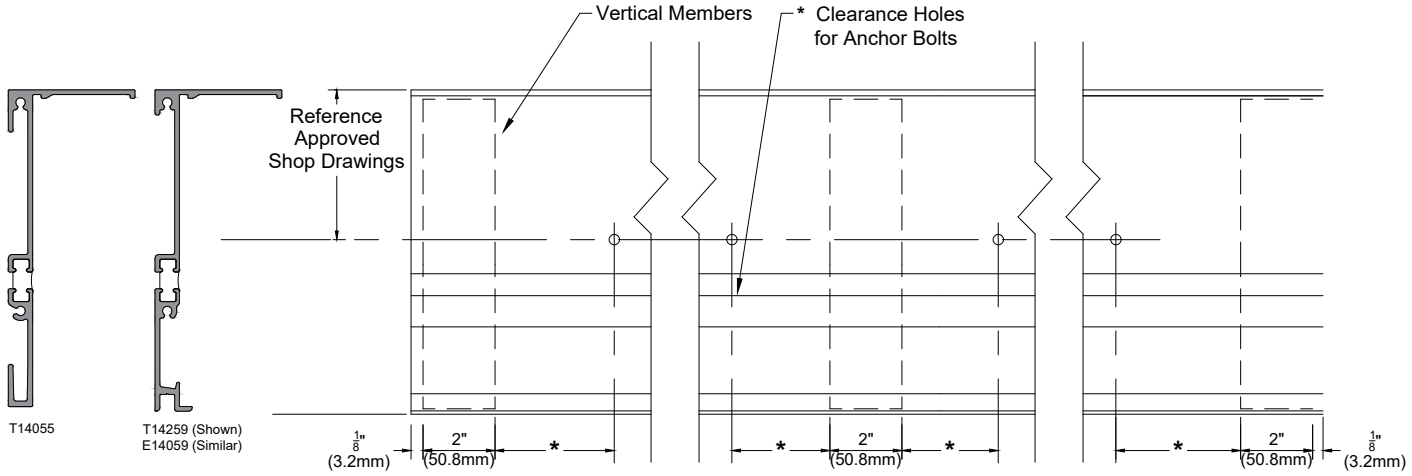


FIG. 1.

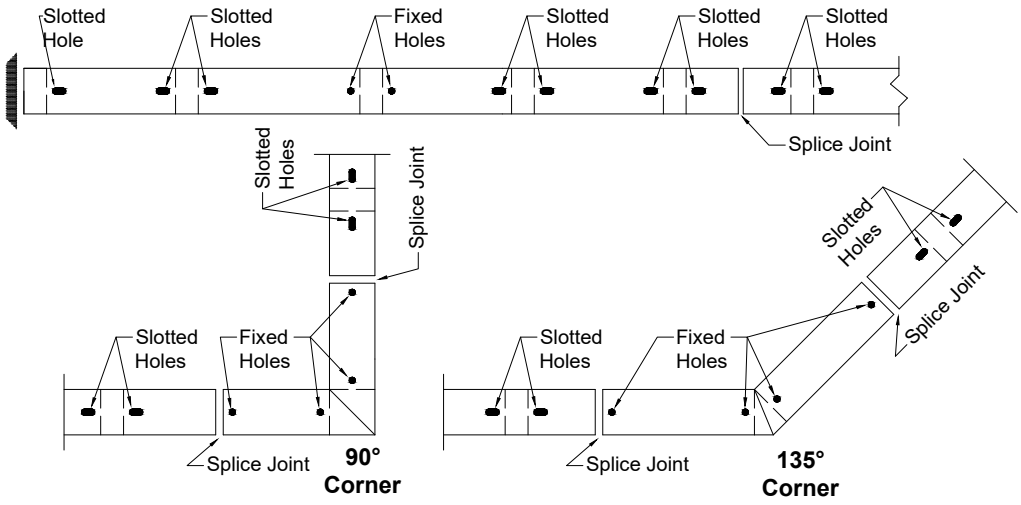
B. Drill clearance holes for perimeter anchors. Size and quantity vary per job. Refer to to approved shop drawings.
Note: if head receptors are used, follow the same procedure as on the sill flashing



NOTE: *DLO's Larger than 42" (1066.8mm) require an additional anchor hole at the mid-point of the bay*

FIG. 2.

* Reference approved shop drawings for anchor hole sizes, locations, and quantity



Typical Sill Flashing Anchor Hole Patterns (Head channel similar)
(Refer to approved shop drawings for project requirements)

FIG. 3.

FRAME FABRICATION

STEP 4

Step 4: Fabricate Head Receptor

A. Drill clearance holes for perimeter anchors. Size and quantity vary per job. Refer to to approved shop drawings.

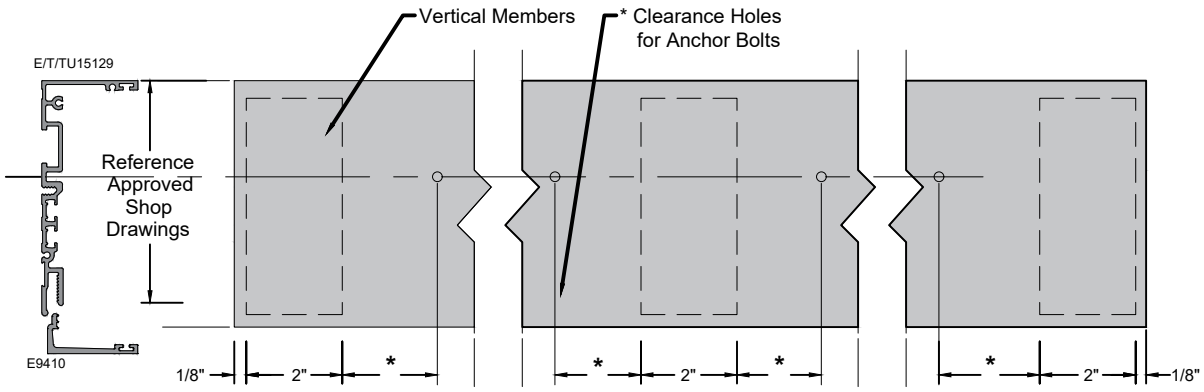
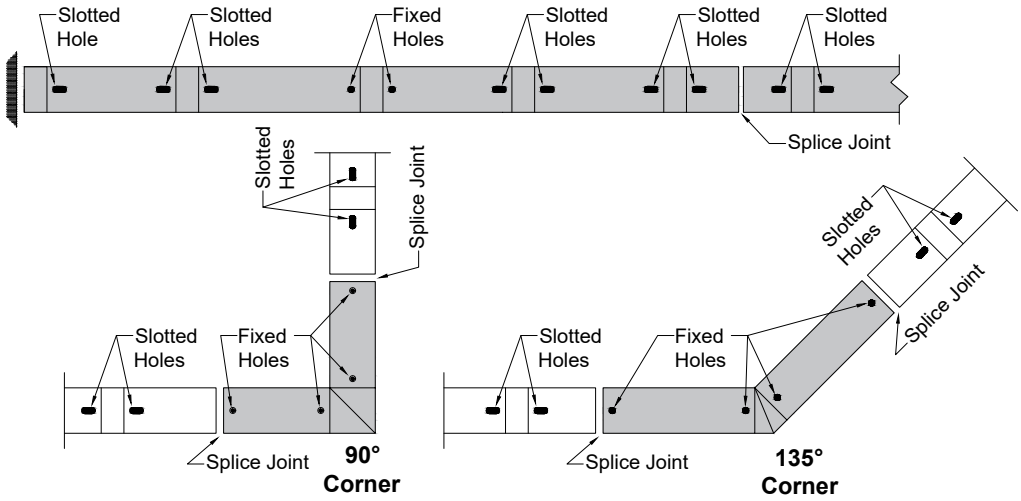


FIG. 1.

NOTE:
Additional fasteners may be required on either side of mullion

* Reference approved shop drawings for anchor hole sizes, locations, and quantity



Typical Head Receptor Anchor Hole Patterns
(Refer to approved shop drawings for project requirements)

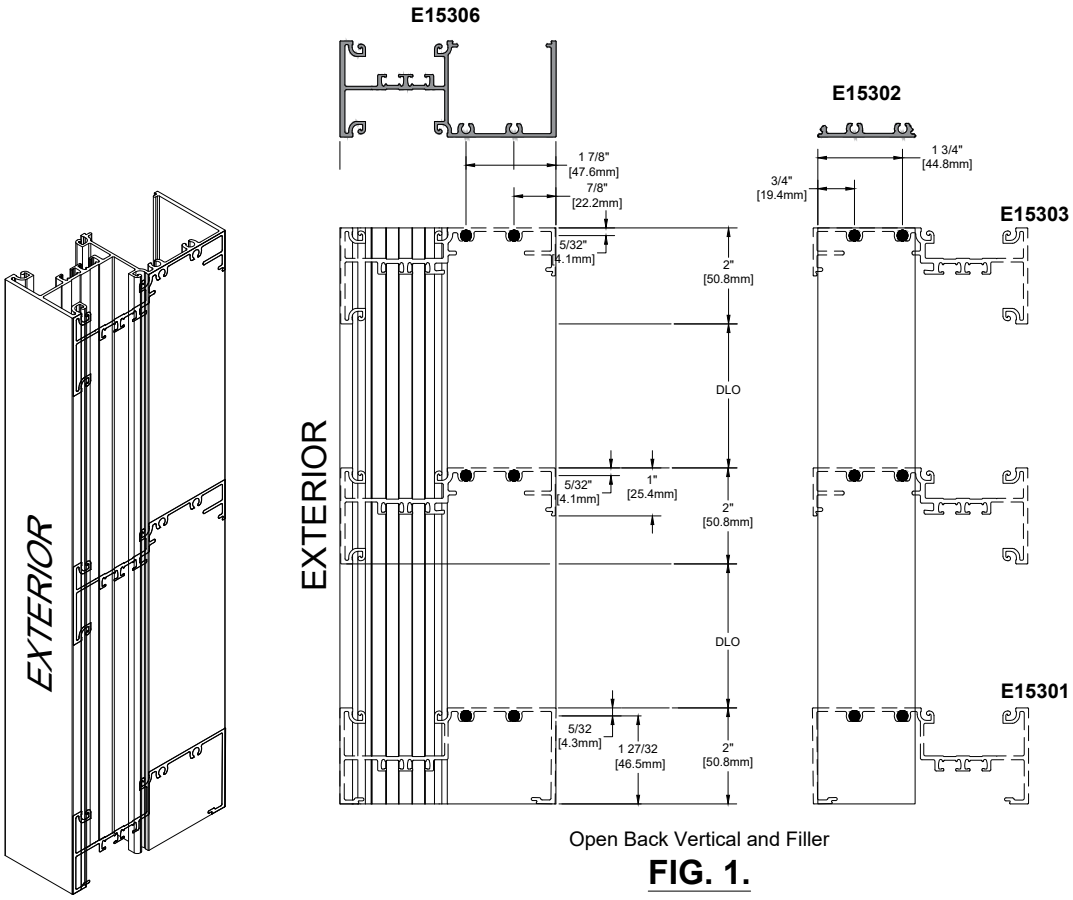
FIG. 2.

FRAME FABRICATION - SCREW SPLINE
OUTBOARD PLANE - INSIDE GLAZE

STEP 5

Step 5: Fabricate Verticals & Closure Pockets for Horizontals

A. Drill frame assembly holes in verticals, jambs, & vertical closure pockets for screw spline assembly.
   a. Drill #12 clearance hole (#2 drill bit) as shown in **FIG.1** below.
   b. Use short cut-off of horizontals to aid in hole layout.



Open Back Vertical and Filler

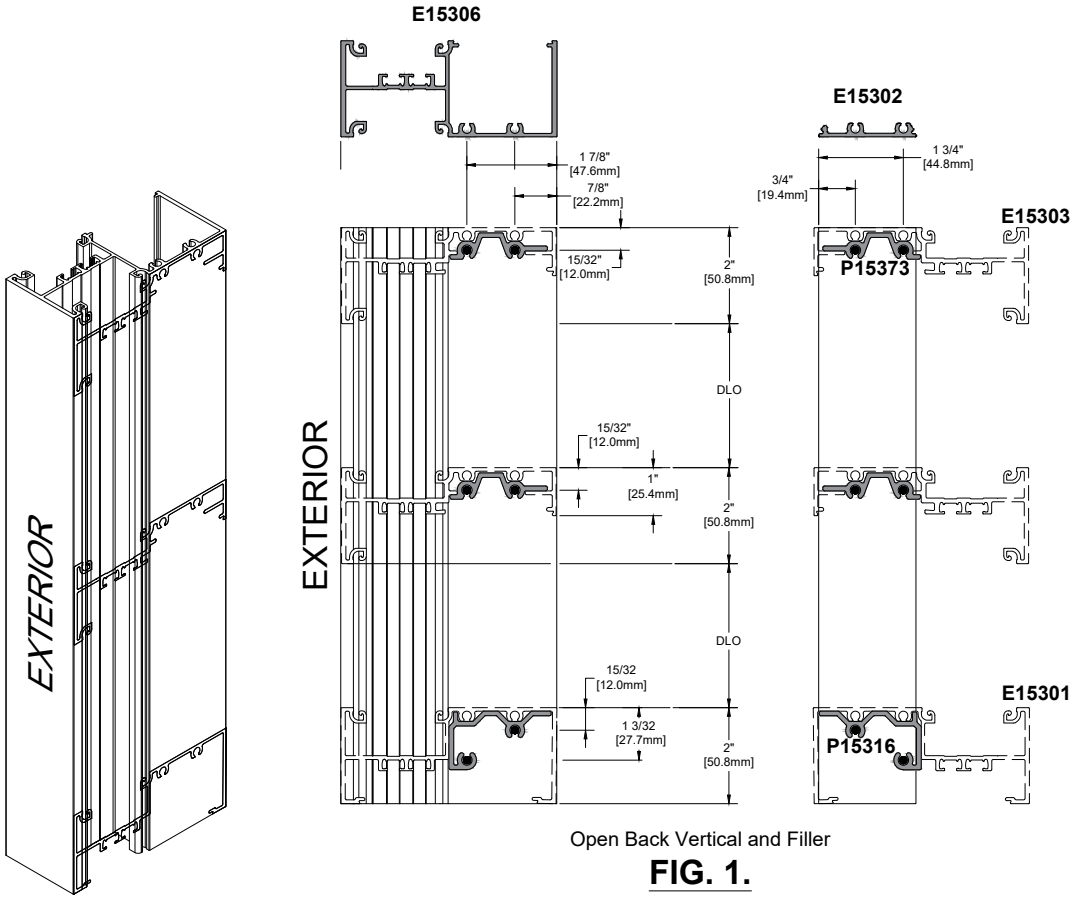
FIG. 1.

FRAME FABRICATION - SHEAR CLIP
OUTBOARD PLANE - INSIDE GLAZE

STEP 5

Step 5: Fabricate Verticals & Closure Pockets for Horizontals

A. Drill frame assembly holes in verticals, jambs, & vertical closure pockets for shear clip assembly.
   a. Drill #10 pilot hole .149"(3.8mm) dia. as shown in **FIG.1** below.
   b. Use short cut-off of horizontals to aid in hole layout.



Open Back Vertical and Filler

FIG. 1.

FRAME FABRICATION - SCREW SPLINE
OUTBOARD PLANE - OUTSIDE GLAZE

STEP 5

Step 5: Fabricate Verticals & Closure Pockets for Horizontals

A. Drill frame assembly holes in verticals, jambs, & vertical closure pockets for screw spline assembly.
   a. Drill #12 clearance hole (#2 drill bit) as shown in **FIG.1** below.
   b. Use short cut-off of horizontals to aid in hole layout.

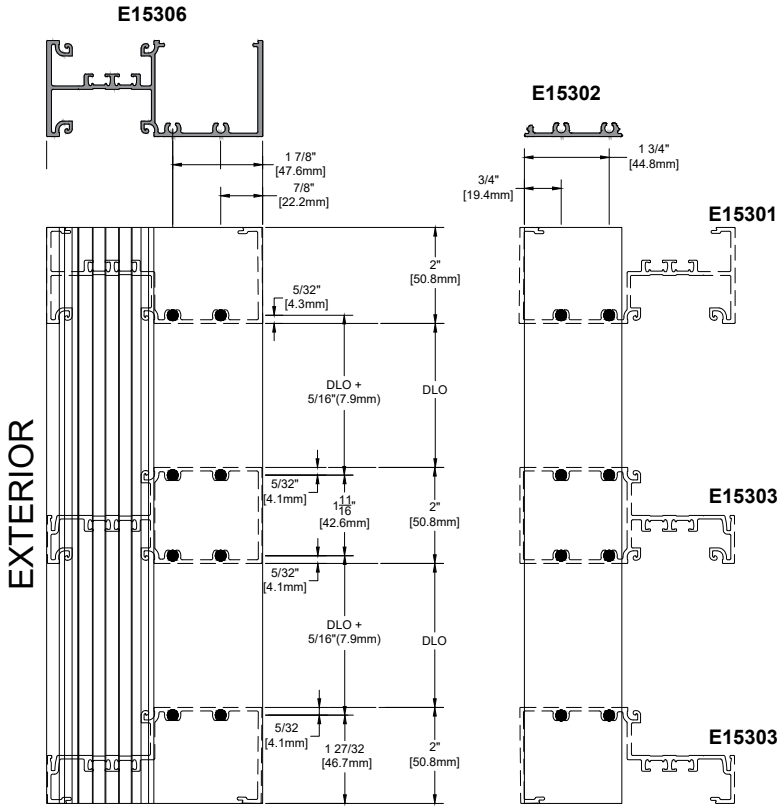


FIG. 1.

FRAME FABRICATION - SHEAR CLIP
OUTBOARD PLANE - OUTSIDE GLAZE

STEP 5

Step 5: Fabricate Verticals & Closure Pockets for Horizontals

A. Drill frame assembly holes in verticals, jambs, & vertical closure pockets for shear clip assembly.
   a. Drill #10 pilot hole .149"(3.8mm) dia. as shown in **FIG.1** below.
   b. Use short cut-off of horizontals to aid in hole layout.

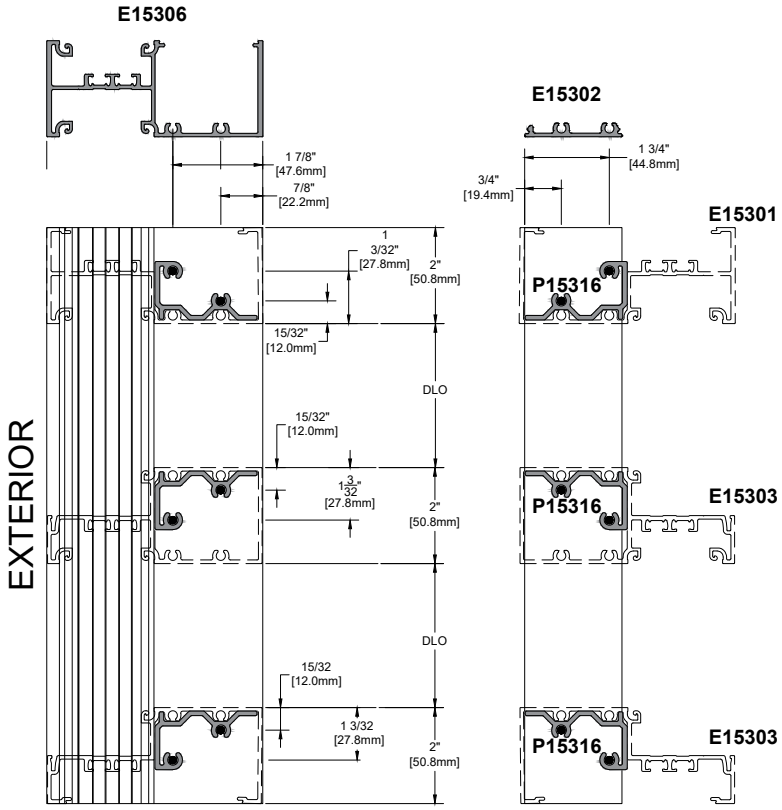


FIG. 1.

FRAME FABRICATION

STEP 6

Step 6: Fabricate Intermediate Horizontal Members for Alignment Key, P15315

A. Drill .1695" (4.3mm) dia. clearance holes (#18 drill bit) for #8 screw 1.25" (31.8mm) from each end of intermediate horizontal members, as shown in **Fig. 1 (Head & Sill members optional)**. Center hole in V-notch.

B. Required for D.L.O. 32" (812.8mm) or above, optional use in head, sill, and D.L.O. under 32" to aid in horizontal to vertical joinery.

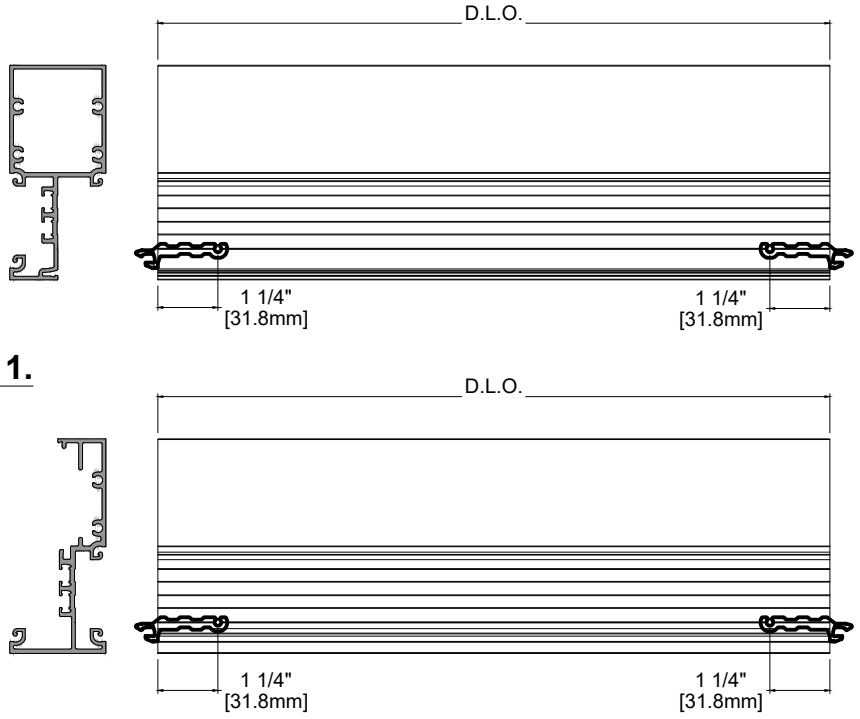


FIG. 1.

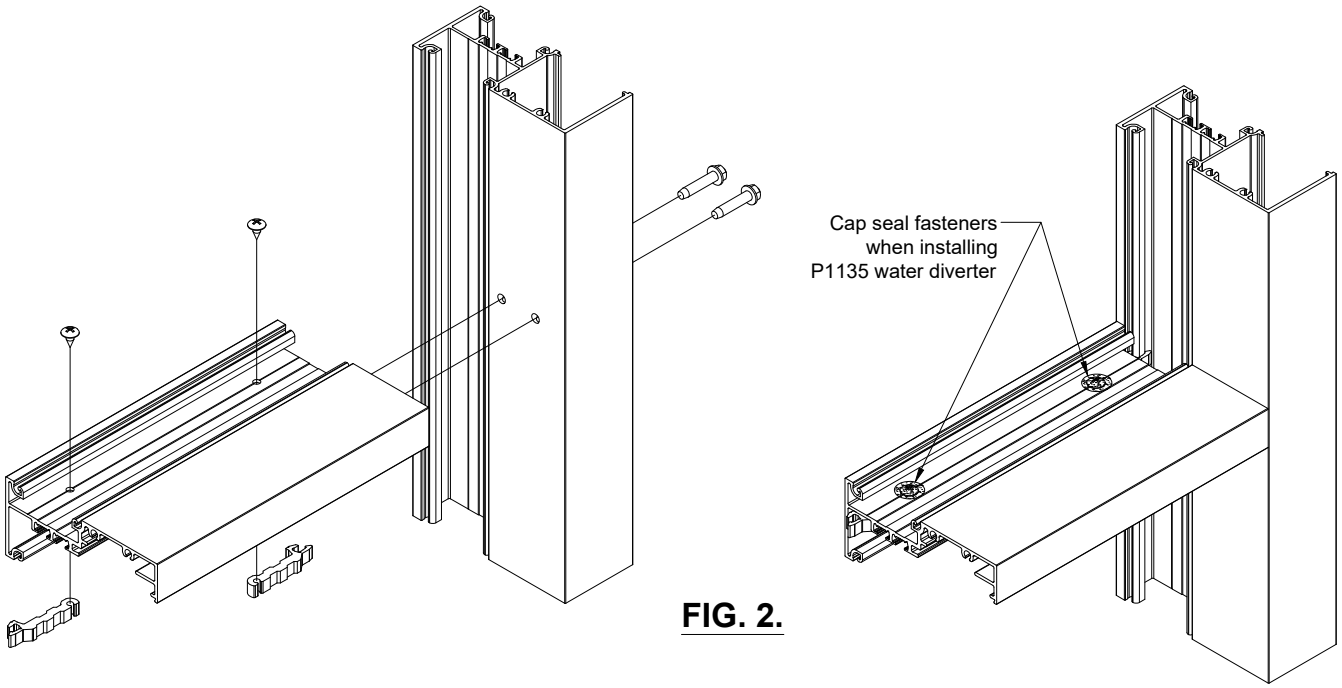


FIG. 2.

FRAME FABRICATION

STEP 7

Step 7: Fabricate Horizontal Members for Shear Blocks

A. For shear block assembly of E/T/TU15303, drill .201"(5.1mm) dia. holes in the hidden interior leg on the underside of the horizontal as shown in **FIG. 1.**
B. For E/T/TU15301, drill .221"(5.6mm) dia. holes in the top face, and drill countersink for flat head S286 screw as shown in **FIG. 2.** **(Note: exposed fasteners are necessary)**.
C. For E/T/TU15313 & E/T/TU15310 horizontals, drill .201"(5.1mm) dia. holes through back wall of glazing pocket as shown in **FIG. 3.**

FIG. 1.

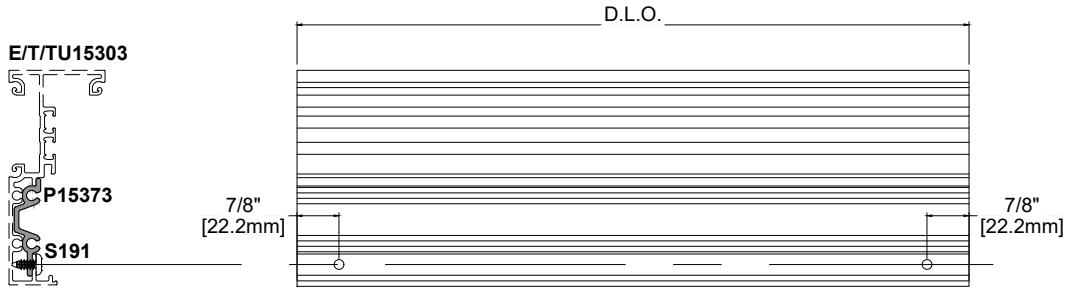
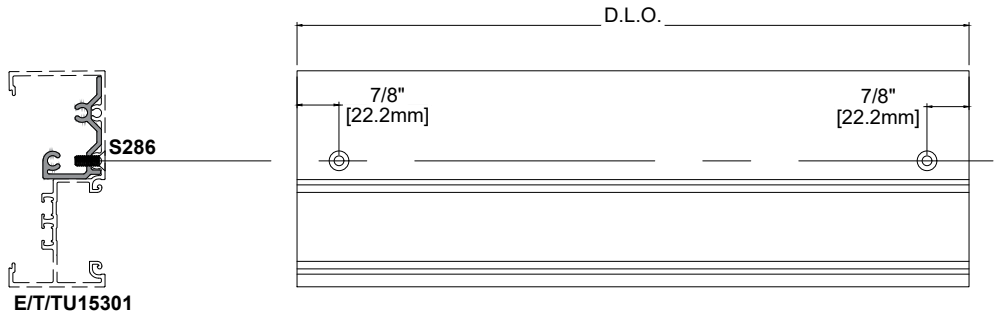


FIG. 2.



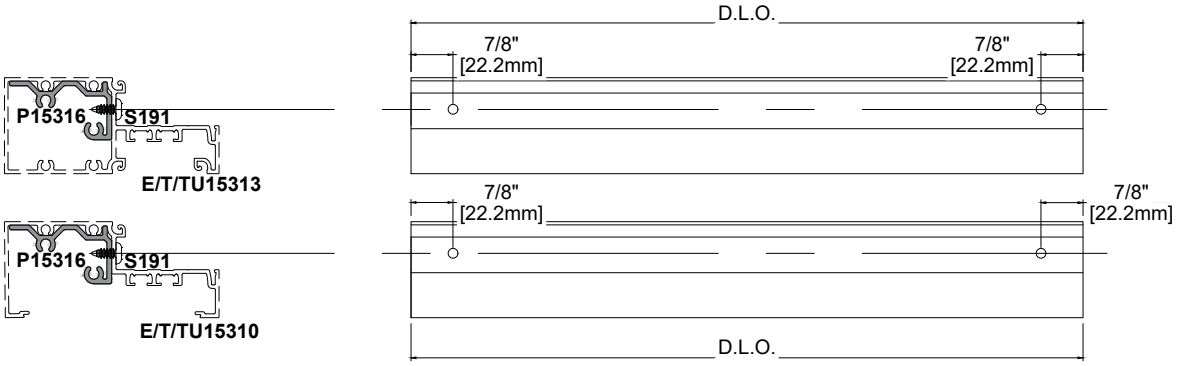


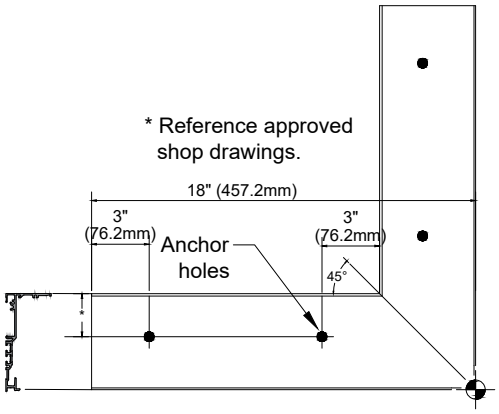
FIG. 3.

FRAME FABRICATION

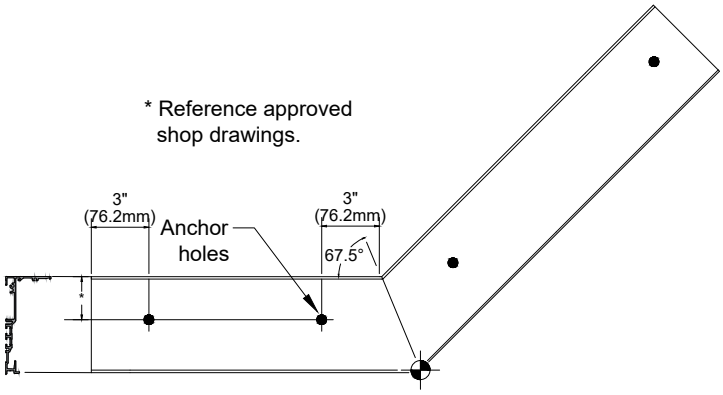
STEP 8

Step 8: Corner Sill Flashing Fabrication

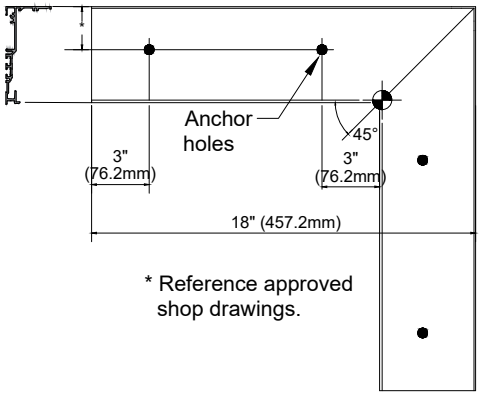
A. Miter ends of sill flashing as shown in **FIGs. 1-4** (One left hand and one right hand.)
B. Drill anchor holes as show.



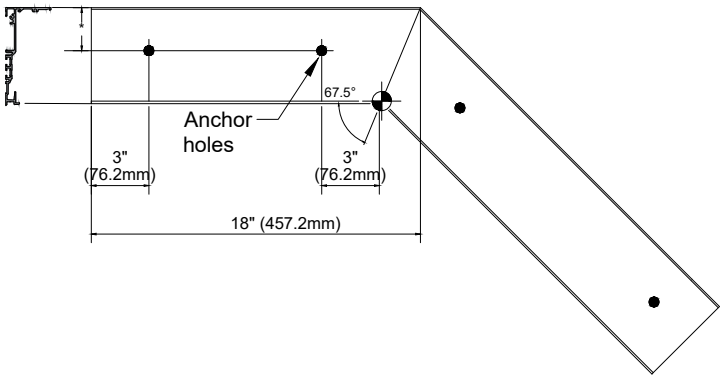
90° OUTSIDE CORNER
FIG. 1.



135° OUTSIDE CORNER
FIG. 2



90° INSIDE CORNER
FIG. 3



135° INSIDE CORNER
FIG. 4

FRAME ASSEMBLY

STEP 9

Step 9: Install End Dams

A. Install end dams to sill flashing.
   - E/T/TU15259 sill flashing, use P15455 end dam.
   - E/T14259 or E/T14055 sill flashing, use P2455 end dam.

B. Apply sealant to the end of the sill flashing.

C. Install end dam to sill flashing with S196, #8 x $\frac{3}{8}$" pan head screws.
   - P15455 use (3) S196 screws
   - P2455 use (2) S196 screws

D. Cap seal heads of all S196 screws, and tool sealant at end dam connection. Apply additional sealant if needed.

NOTE:
If sill flashing is spliced, install end dams on jamb-end only. Refer to **Step 12, page 47** for splicing instructions.

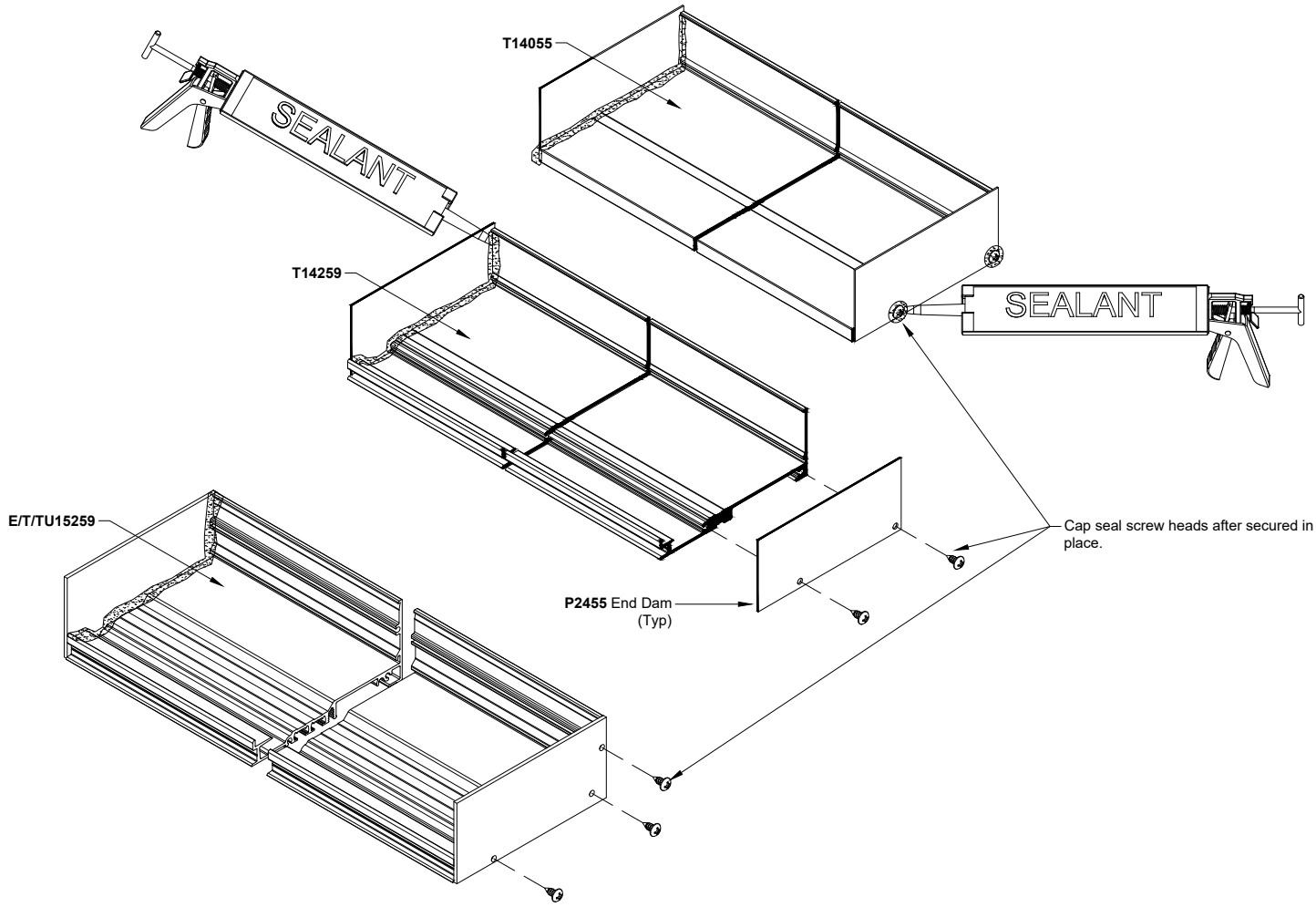


FIG. 1.

FRAME ASSEMBLY

STEP 9

Step 9: Install End Dams

A. Install end dams to head receptor.
   - E/T/TU15259 sill flashing, use P15455 end dam.
B. Apply sealant to the end of the sill flashing.
C. Install end dam to head receptor with S196, #8 x $\frac{3}{8}$" pan head screws.
   - P15455 use (3) S196 screws
D. Cap seal heads of all S196 screws, and tool sealant at end dam connection. Apply additional sealant if needed.

NOTE:
If sill flashing is spliced, install end dams on jamb-end only. Refer to **Step 12, page 47** for splicing instructions.

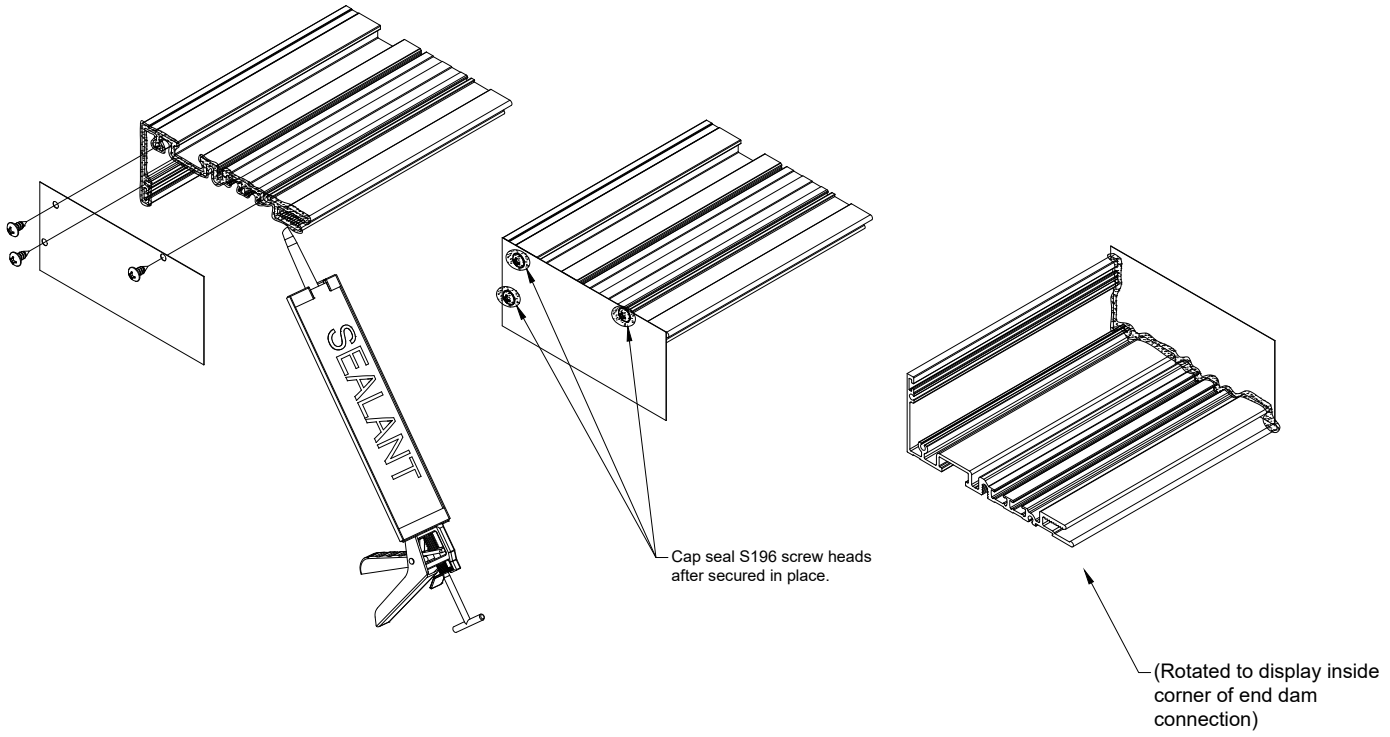


FIG. 1.

FRAME ASSEMBLY - SCREW SPLINE
OUTBOARD PLANE - INSIDE GLAZED

STEP 10

Step 10: Assemble Frames

Screw Spline Assembly

A. Clean all mating surfaces on horizontal & vertical.
B. Apply sealant to ends of the head, horizontal and sill members prior to attaching to the vertical members. **SEE Fig. 1**.
C. Attach head, horizontal and sill members to the vertical and closure pocket members with S204 frame assembly screw.
D. Tool sealant at each joint.

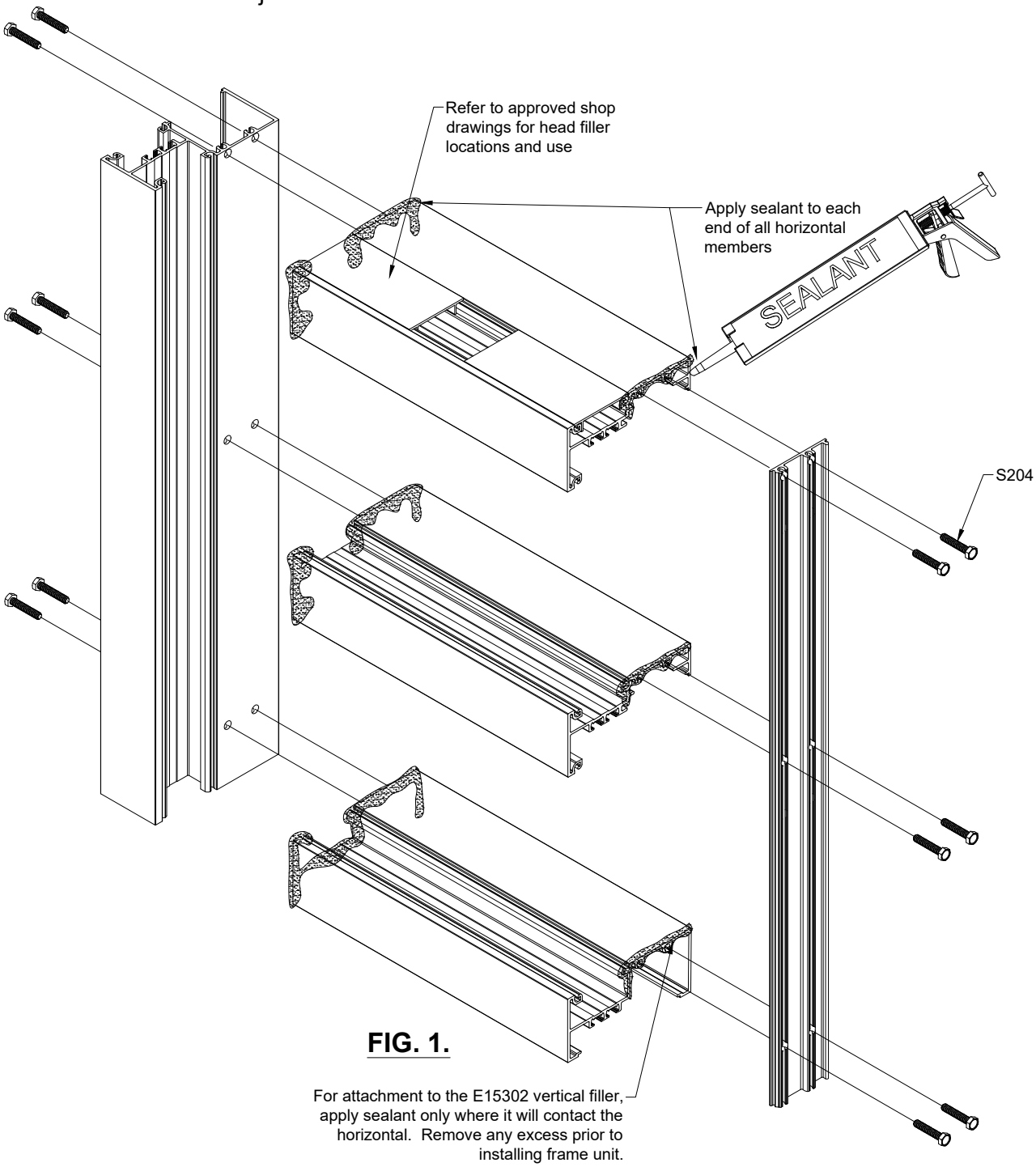


FIG. 1.

FRAME ASSEMBLY - SHEAR CLIP
OUTBOARD PLANE - INSIDE GLAZED

STEP 10

Step 10: Assemble Frames

Shear Clip Assembly

A. Clean all mating surfaces on horizontal, vertical, and shear clip.
B. Attach shear clips to vertical members with S009 screws.
C. Apply sealant to ends of the horizontals and on mating surfaces of the shear clip. **SEE FIG. 1**.
D. Attach horizontal members to the vertical and secure the horizontal to the vertical by fastening the horizontal to the shear clip with S191 (S286 for exposed flat head fastener).
E. Tool sealant at each joint.

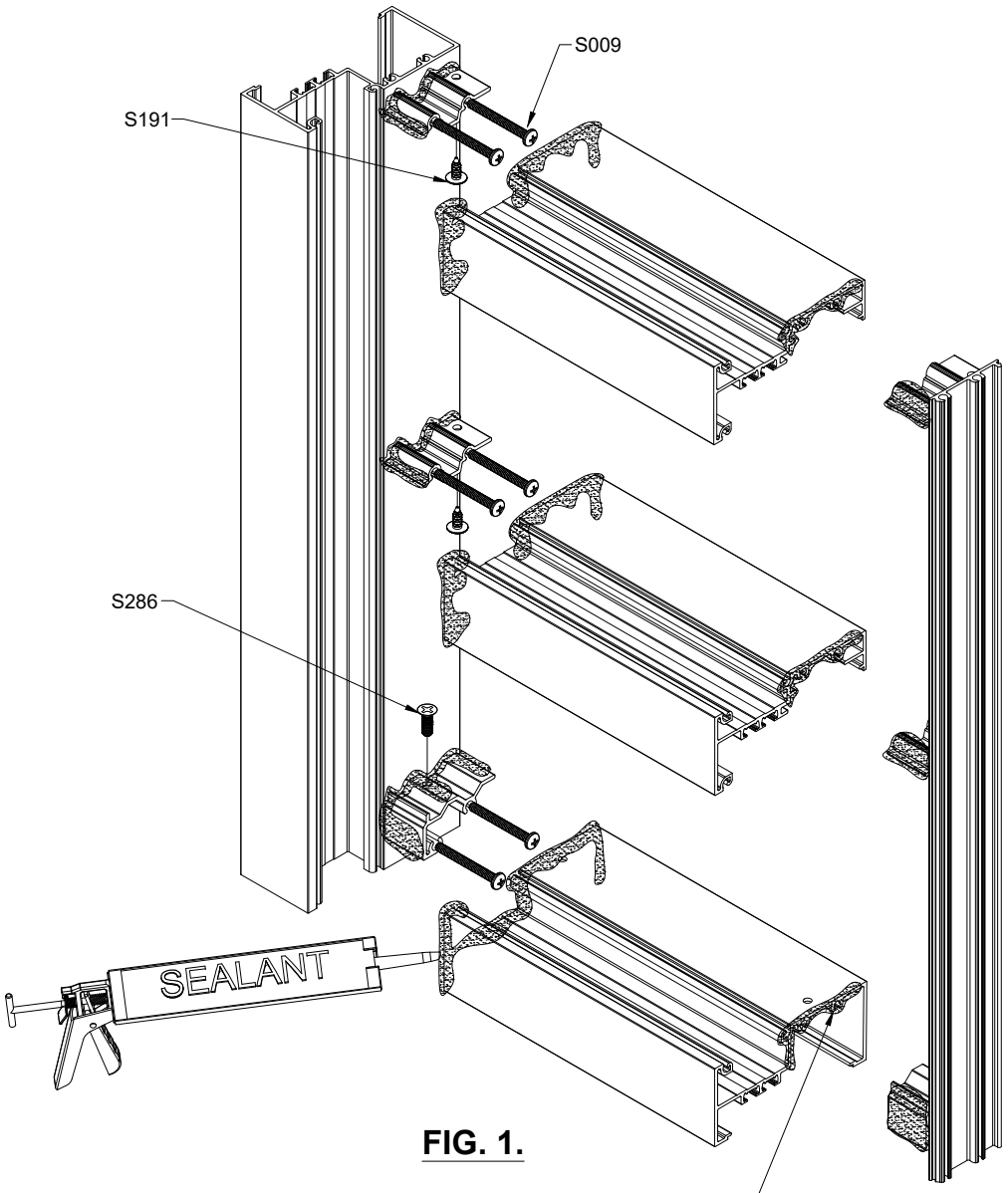


FIG. 1.

For attachment to the E15302 vertical filler, apply sealant only where it will contact the horizontal. Remove any excess prior to installing frame unit.

FRAME ASSEMBLY - SCREW SPLINE
OUTBOARD PLANE - OUTSIDE GLAZED

STEP 10

Step 10: Assemble Frames

Screw Spline Assembly

A. Clean all mating surfaces on horizontal & vertical.
B. Apply sealant to ends of the head, horizontal and sill members prior to attaching to the vertical members. **SEE Fig. 1**.
C. Attach head, horizontal and sill members to the vertical and closure pocket members with S204 frame assembly screw.
D. Tool sealant at each joint.

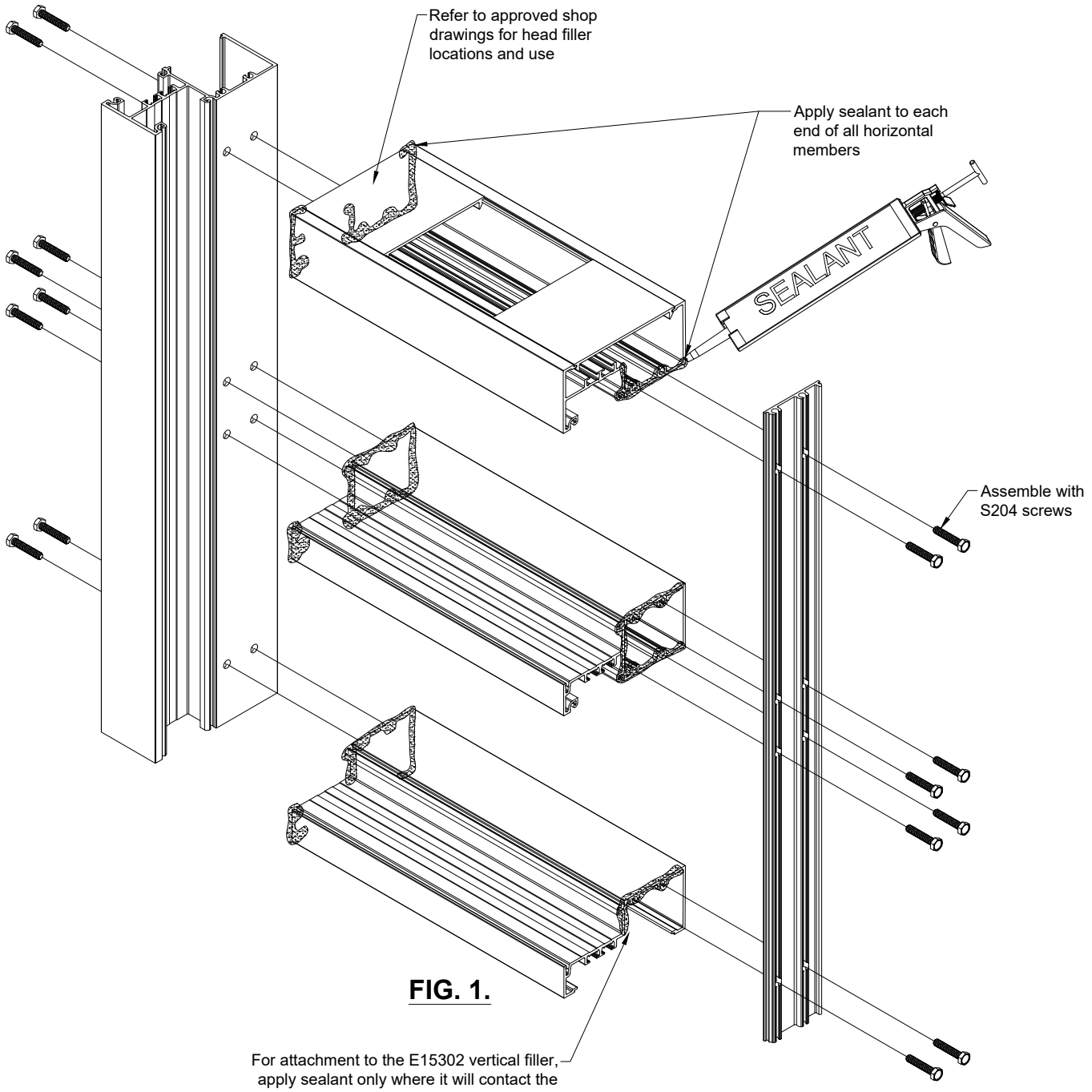


FIG. 1.

FRAME ASSEMBLY - SHEAR CLIP
OUTBOARD PLANE - INSIDE GLAZED

STEP 10

Step 10: Assemble Frames

Shear Clip Assembly

A. Clean all mating surfaces on horizontal, vertical, and shear clip.
B. Attach shear clips to vertical members with S009 screws.
C. Apply sealant to ends of the horizontals and on mating surfaces of the shear clip. **SEE FIG. 1**.
D. Attach horizontal members to the vertical and secure the horizontal to the vertical by fastening the horizontal to the shear clip with S191 (S286 for exposed flat head fastener).
E. Tool sealant at each joint.

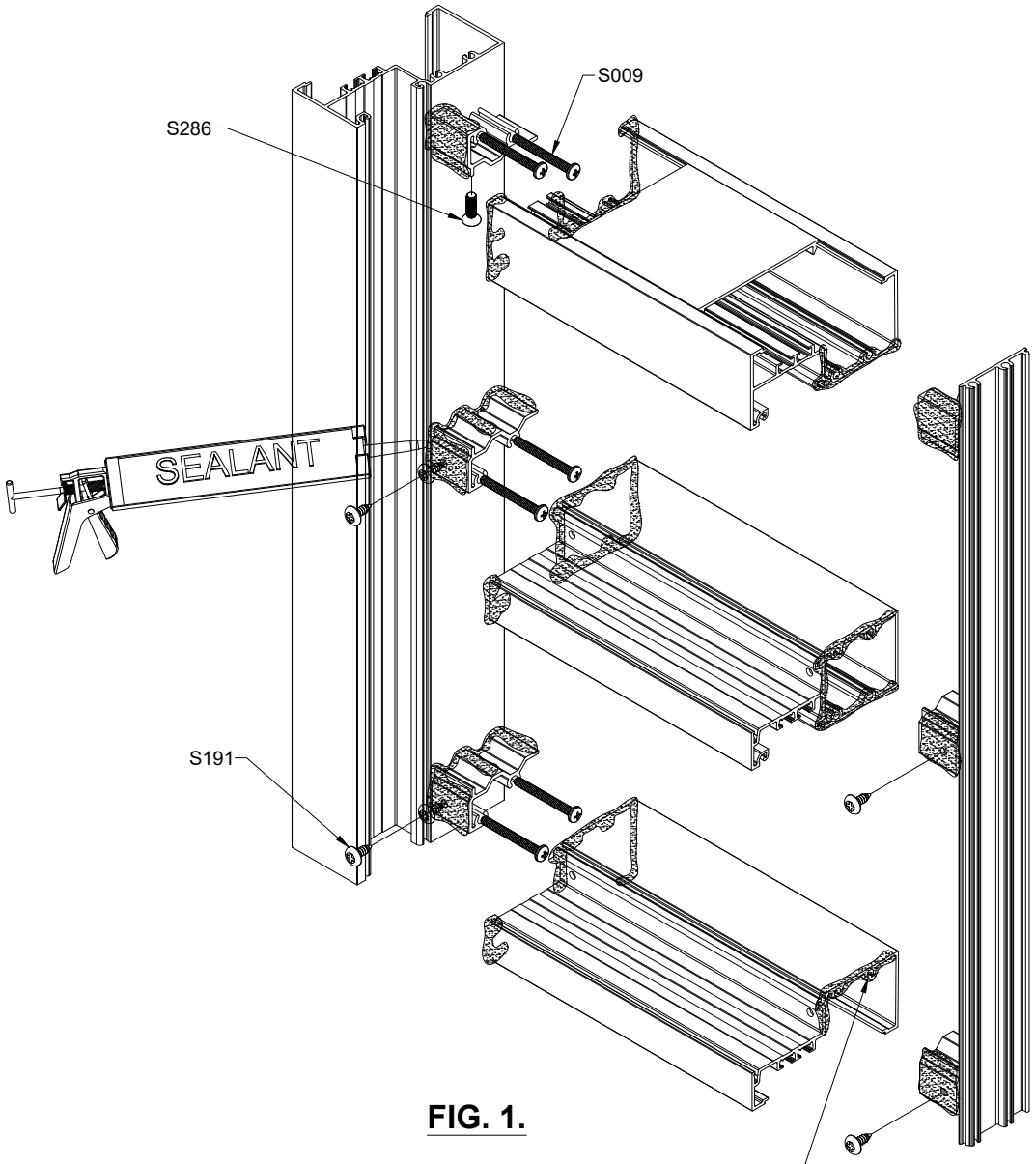


FIG. 1.

For attachment to the E15302 vertical filler, apply sealant only where it will contact the horizontal. Remove any excess prior to installing frame unit.

FRAME INSTALLATION

STEP 11

Step 11: Corner Sill Flashing Installation

A. Install flashing corner members in place.
B. Apply sealant full length of mitered joint. See **Fig. 2**.
C. Splice corner flashing to sill flashing using procedures shown on page 47

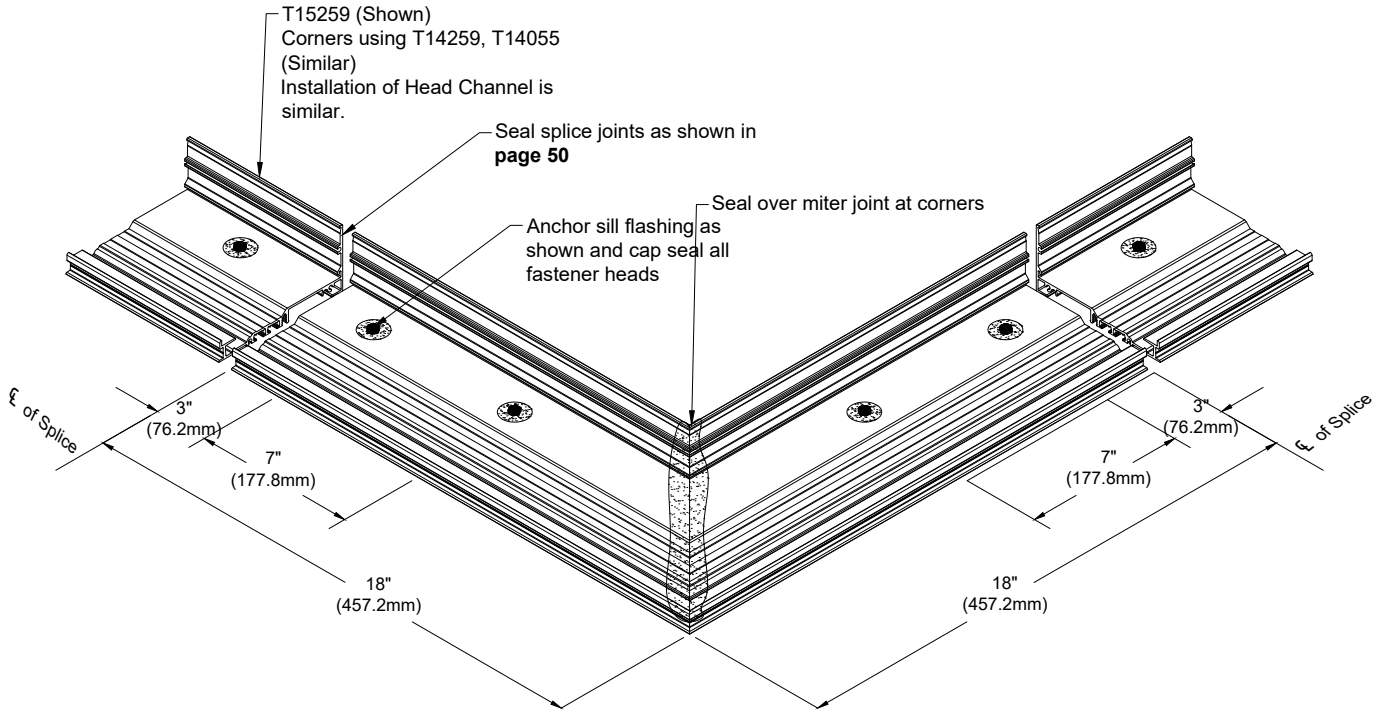


FIG. 1.

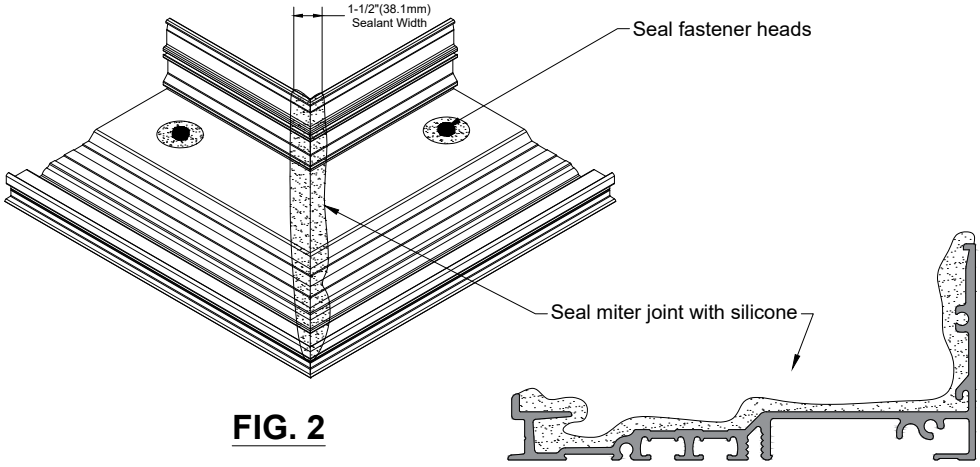


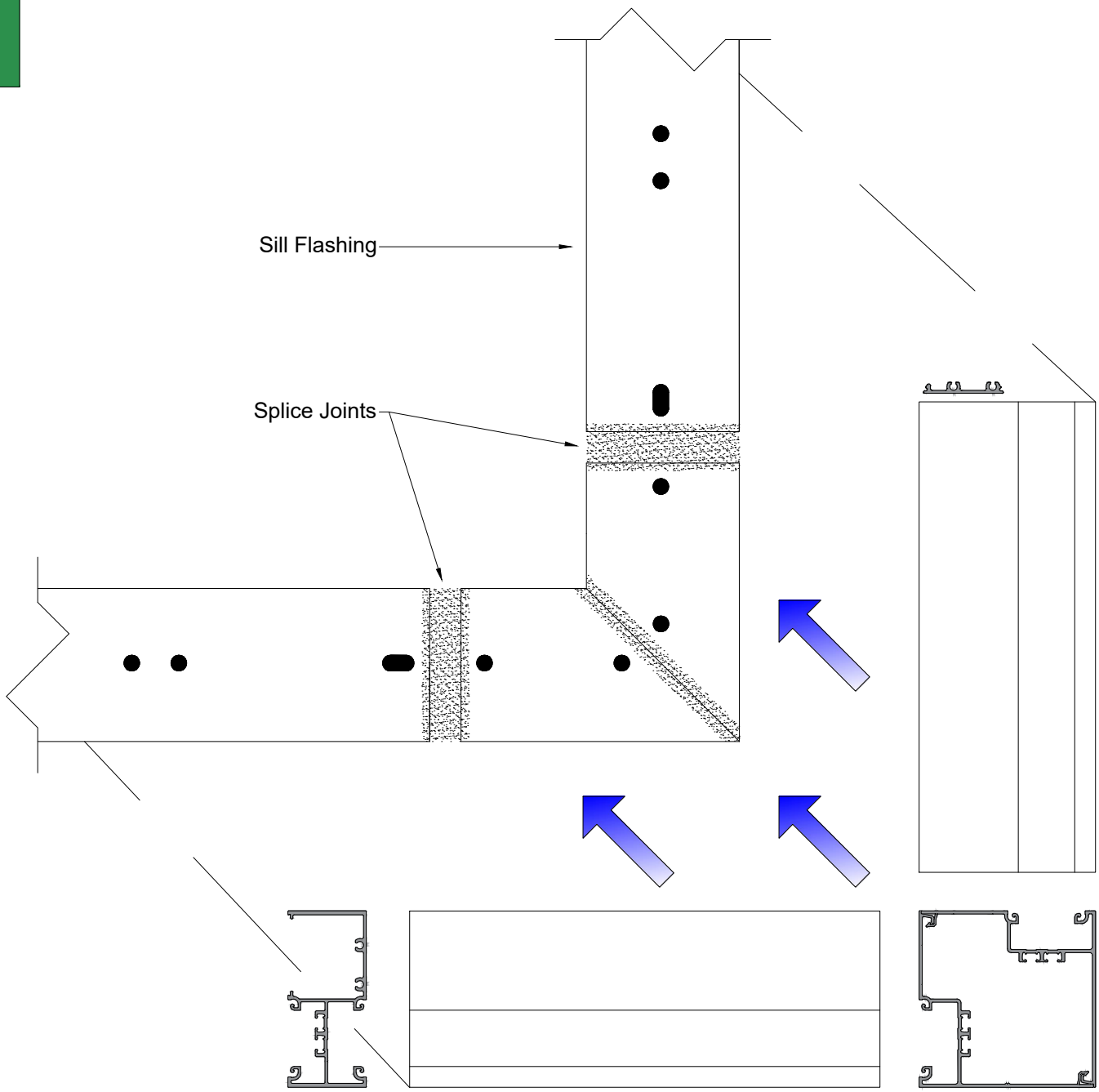
FIG. 2

FRAME INSTALLATION

STEP 12

Step 12: Corner Frame Installation

A. Recommended to assemble the 2 adjacent corner frame units together.
B. Set corner frame assembly into sill flashing as a single unit.



Assemble and install corner unit in one piece
(90° corner shown. 135° corner is similar)

FIG. 1.

FRAME INSTALLATION

STEP 13

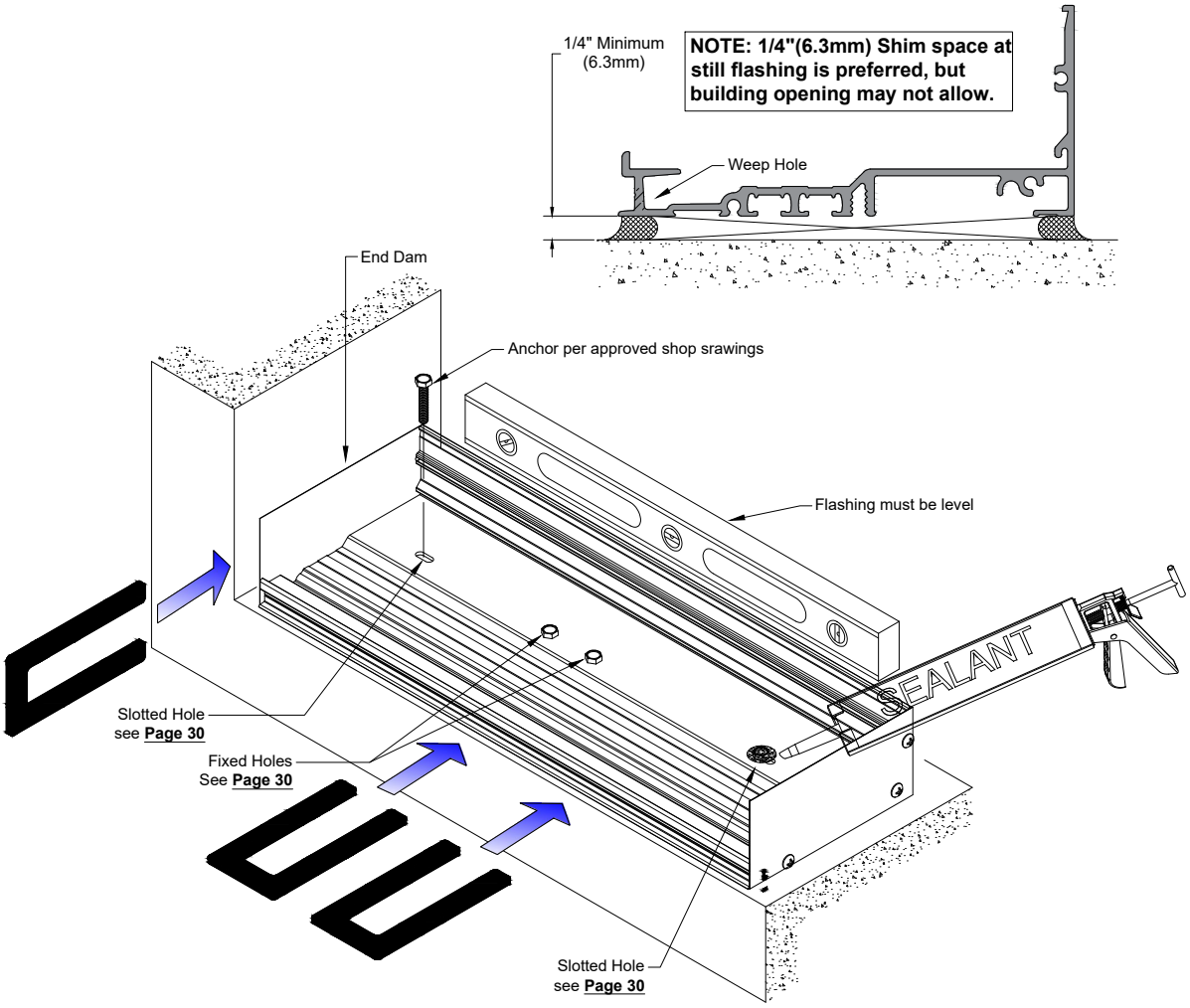
Step 13: Install Sill Flashing (If required)

A. Center the sill flashing in the opening. If sill flashing is spliced, be sure the joint at the jamb is per approved shop drawings (jamb caulk joint minus $\frac{1}{8}$"(3.2mm)). Splice joint to be $\frac{3}{8}$"(9.5mm) minimum.

B. At the highest point of the sill (smallest rough opening height), shim the sill flashing with a minimum $\frac{1}{4}$"(6.3mm) shim space. Sill flashing must be installed level side to side and front to back.

C. Shim tight between the sill flashing end dam and building condition to ensure end dam is not dislodged during frame installation. Remove shim after frames are set in place.

D. Anchor sill flashing to building substrate per approved shop drawings. Cap seal anchors after installation. Where the sill flashing abuts a door jamb, the sill flashing anchor must be located within 6"(152.4mm) of the door jamb.



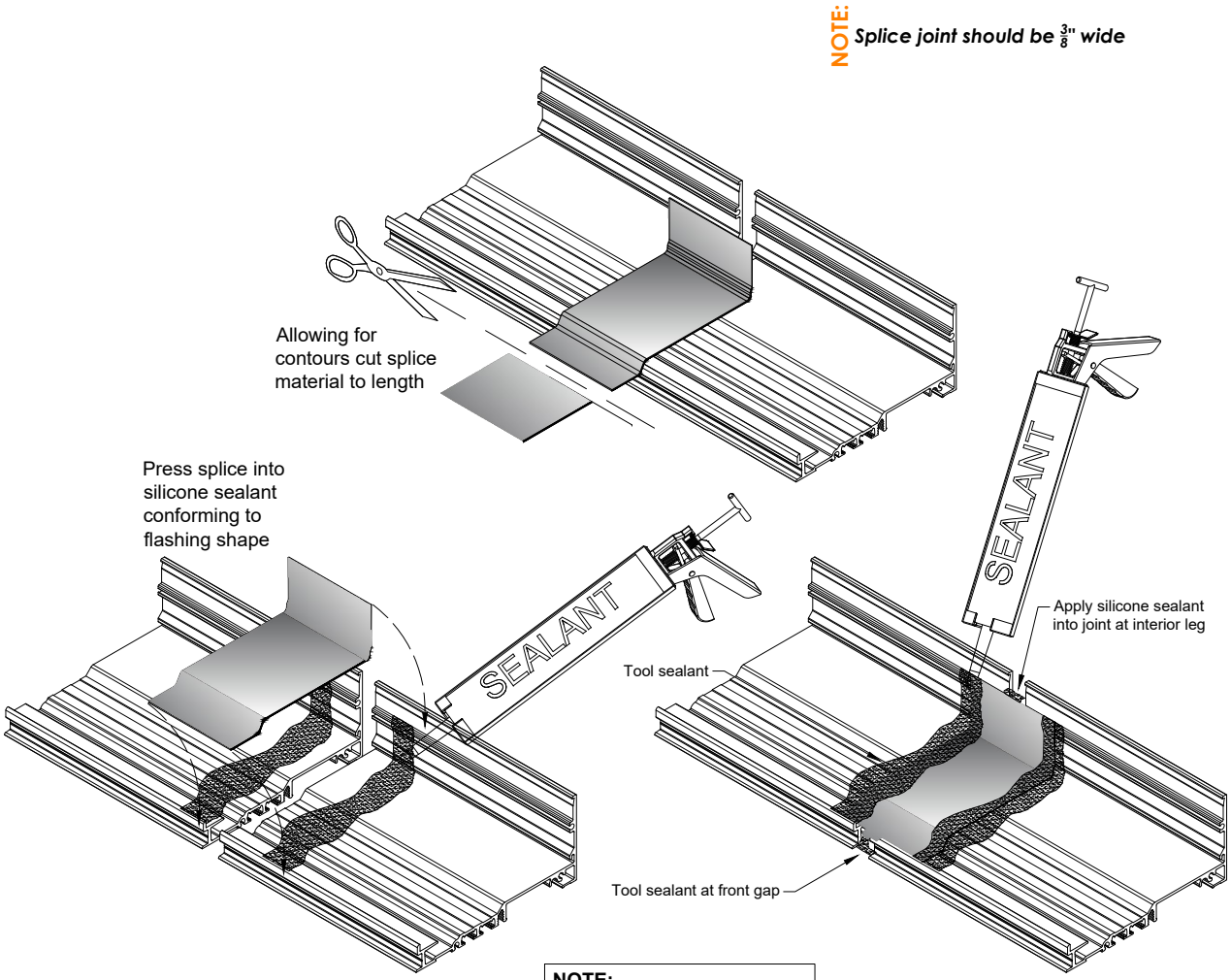
FRAME INSTALLATION

STEP 14

Step 14: Sill Flashing Splice

Continue installing sill flashing per Step 13 across the opening.

A. Lay P3444 silicone sheet into sill flashing at splice location (center of D.L.O.) and cut to length.
B. Install backer rod under the sill flashing at the splice joint.
C. Clean surfaces where splice will be applied. Apply sealant as shown in **Fig. 1**.
D. Set silicone splice sleeve in place and tool sealant. Seal front and back joints.
E. Do not locate a splice directly below a vertical mullion. Center line of D.L.O. is preferred.



NOTE:
Consult sealant manufacturer for comparability of sealant with silicone splice

FIG. 1.

FRAME INSTALLATION

STEP 15

Step 15: Install Frames

A. Starting on one side of the opening, apply a bead of silicone to the back of the sill flashing and the end dam prior to installing each frame. Apply a sealant bead on the back of the flashing only for the frame to be installed.
B. Lift the first frame onto the sill flashing, snug against the end dam.
C. Lift each frame onto the sill flashing and engage with the previous frame.
D. Check to ensure frame is plumb, level and jamb caulk joint is per approved shop drawings.
E. Install P2901 wedge gasket into the flashing along the length of the frames
F. Shim head and jamb at anchor points and attach to the building structure. Size, quantity and location of anchors are per approved shop drawings. Remove shims between sill flashing end dams and secure before proceeding.
G. When the frame is anchored to the structure, apply the exterior perimeter seal at the head, sill and jambs. Interior perimeter seal must be applied to the head, sill and jambs.

NOTE: When using P4543A, make sure clearance holes are made in the snap-in filler to avoid the sill flashing anchors.

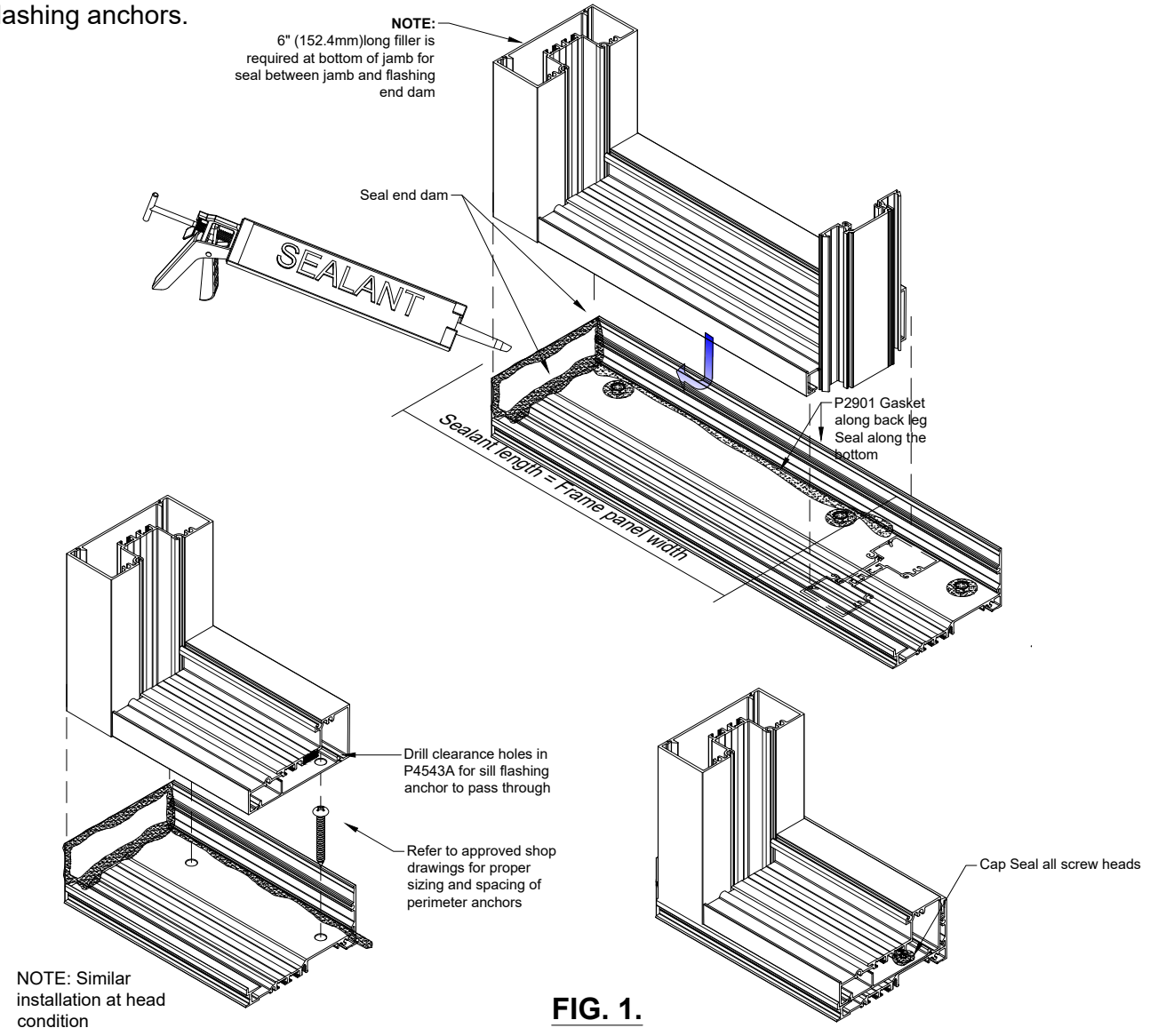


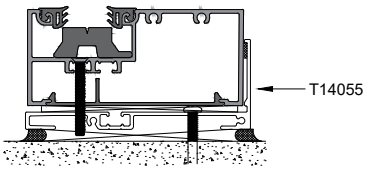
FIG. 1.

FRAME INSTALLATION

STEP 16

Step 16: Install Frames (Continued)

Frame installation when using the optional T14055 sill flashing.



G. Install frame units as directed in steps A and B on page 50.
H. Push frame tight to vertical fin of sill flashing and match drill through sill anchor holes into sill flashing. See **FIG. 1**. Sill anchor not by Tubelite and is to be sized according to project loading requirements.
I. Shim between sill and flashing centered on anchor. See **FIG. 2**.
J. Inject sealant into anchor hole to cover hole in flashing. See **FIG. 2**.
K. Apply sealant to threads of fastener and secure frame to sill flashing. See **FIG. 3**.
L. Cap seal all fastener heads. See **FIG. 4**.

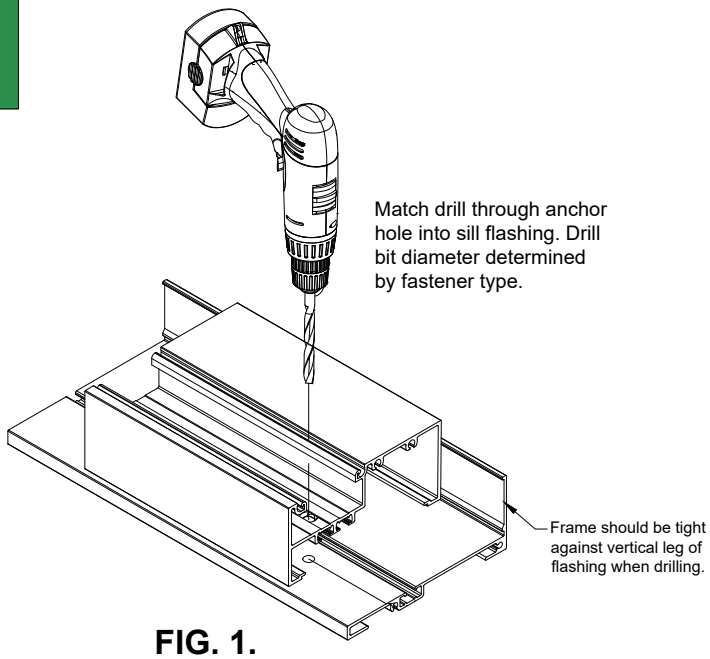


FIG. 1.

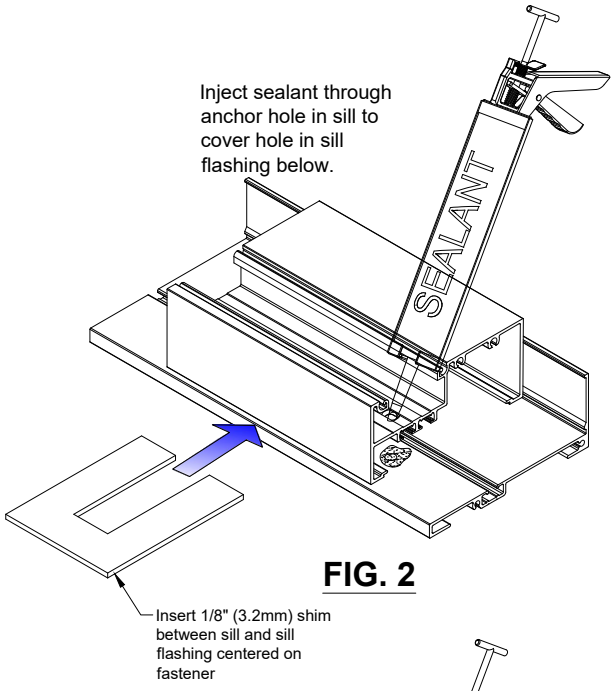


FIG. 2

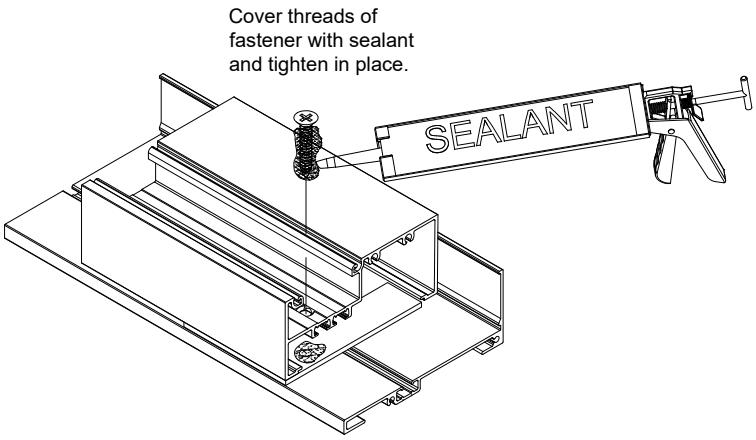


FIG. 3

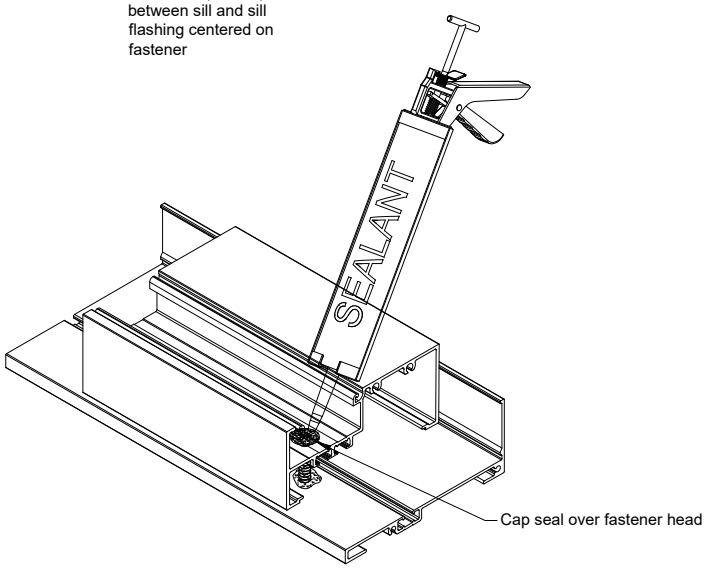


FIG. 4.

FRAME INSTALLATION

STEP 17

Step 17: Install Frames at Door Jamb

A. Establish footprint of door frame and threshold. Apply sealant to footprint of door jamb (and threshold if applicable).
B. Seal end of sill flashing intersecting the door frame.
C. Set door frame in bed of sealant and tool the door frame to floor intersection. Seal any holes at end of threshold to prevent water intrusion.
D. Fill void within door jamb with sealant and tool for water to flow into sill flashing.

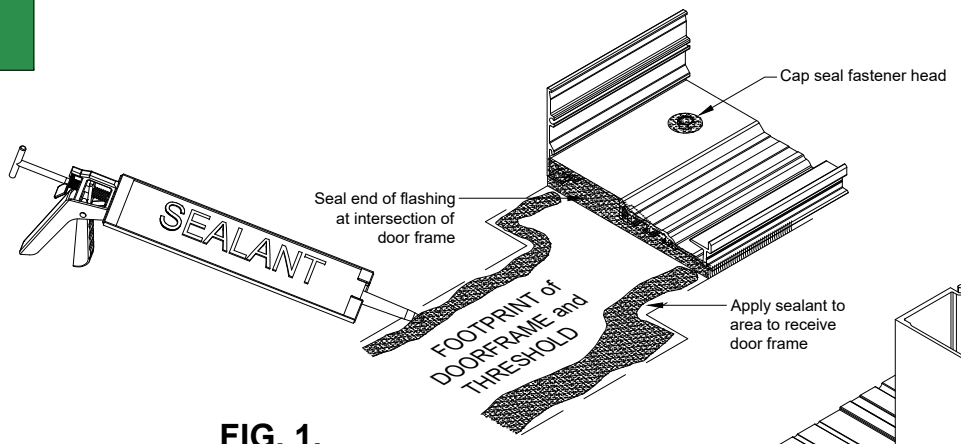


FIG. 1.

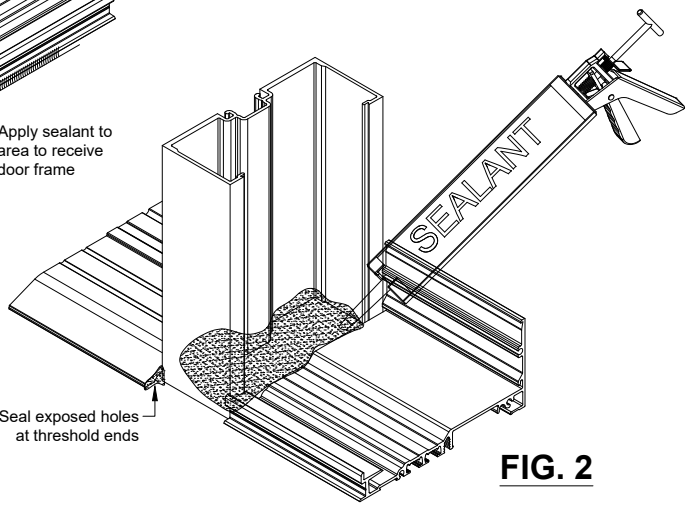


FIG. 2

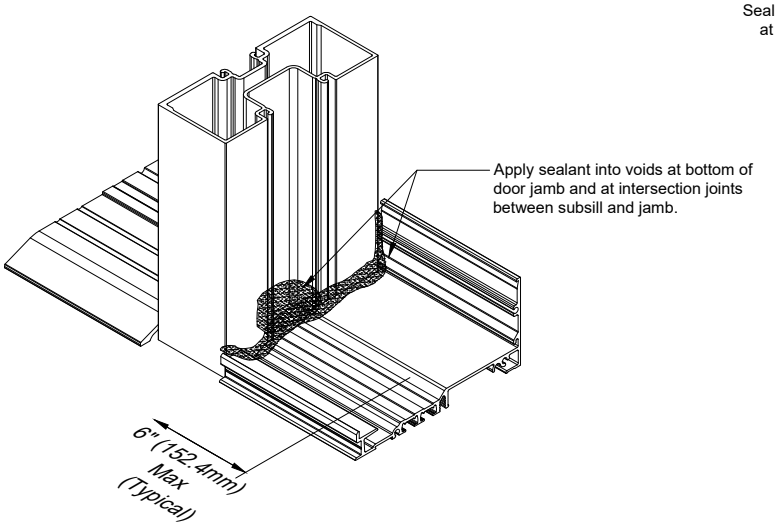


FIG. 3

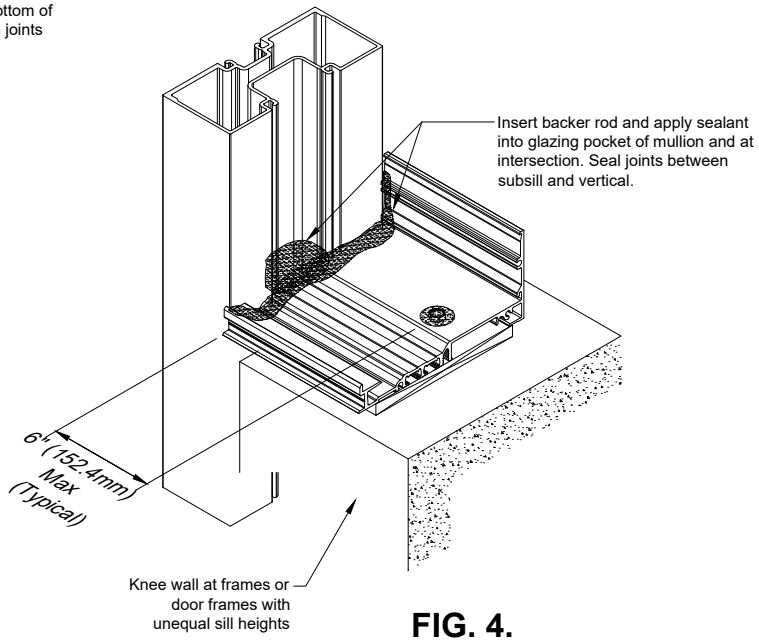


FIG. 4.

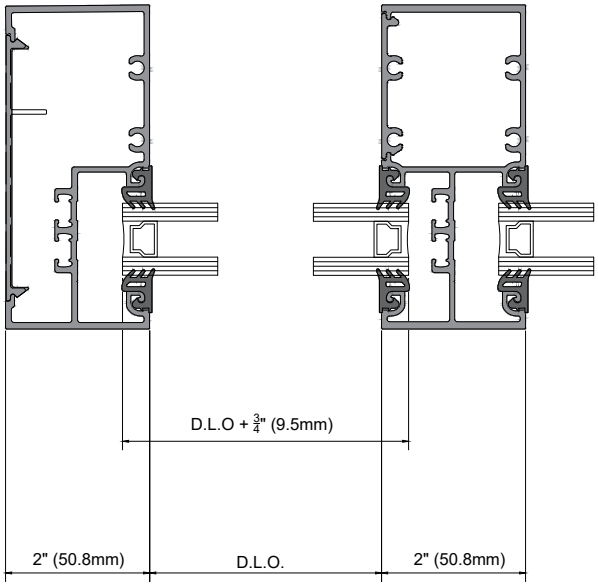
GLAZING

STEP 18

Step 18: Glazing Preparation

A. Remove any debris from the glazing pockets.
B. Trim excess silicone from edges of glazing units to allow for maximum glazing clearance.

Glazing pockets are designed to accept IGU's up to and including 1-1/8" (28.6mm) thick. Refer to our online details for a full list of glazing size options for this system.



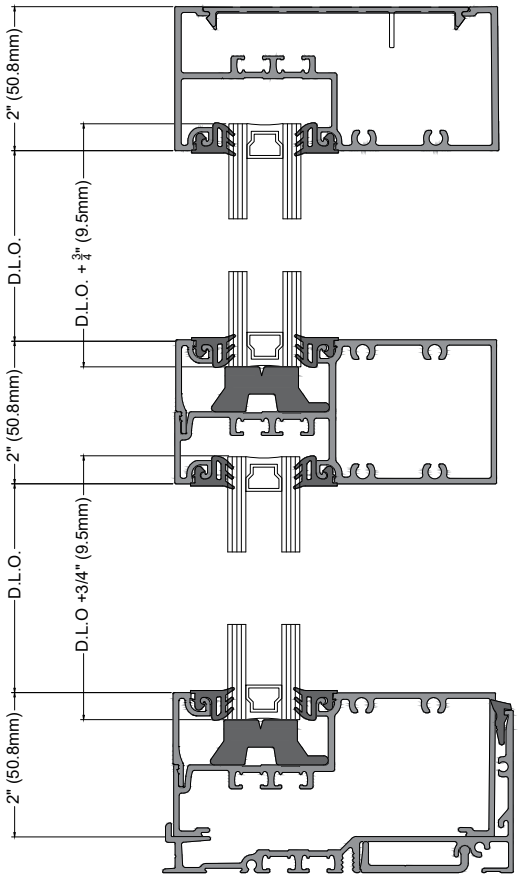


FIG. 1.
GLASS LITE SIZES

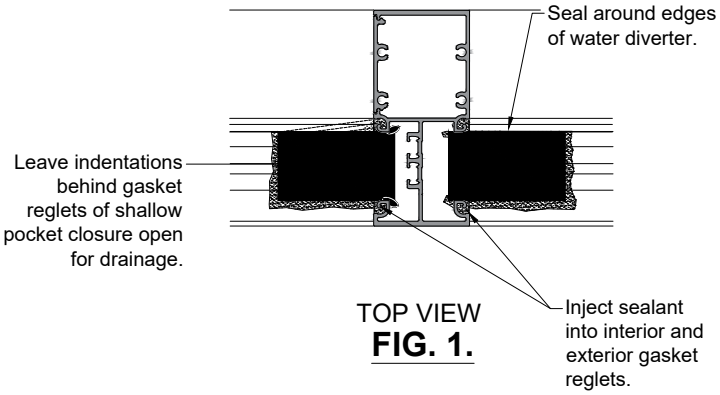
GLAZING

STEP 19

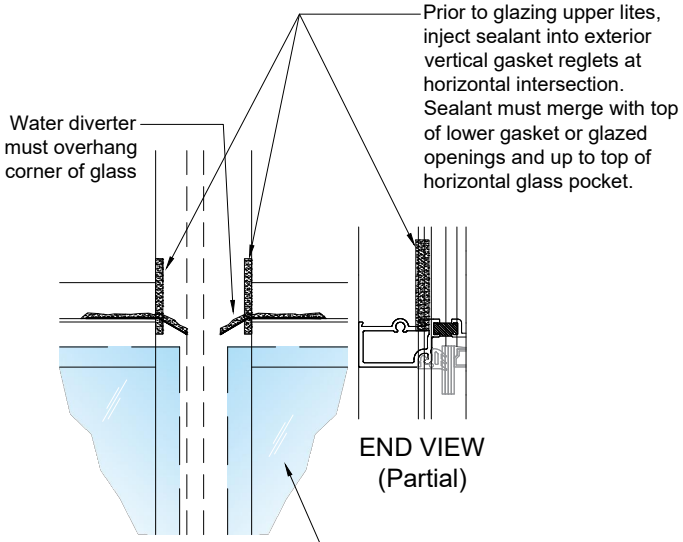
Step 19: Installing the Glazing Units

NOTE: Glazing must be done from bottom of frame up.

A. Seal the corners of the previously installed gaskets (refer to Step 21, page 56).
B. Set the glass by installing into the deep pocket of the vertical first, then carefully sliding into the shallow pocket. Set glass onto (2) setting blocks located at quarter points or per approved shop drawings. Consult glass manufacturer if glass size exceeds 40 sq. ft. (3.72 sq.m)
C. In applications where glass shifting is anticipated through seismic activity or other forces acting on the frame, install P1917 anti-walk blocks into the deep pocket side of the vertical per glazing manufacturer recommendations.
D. Install remaining gaskets on the vertical sides of the glass, holding back at the bottom to allow for glass stop installation.
E. Install glass stop at the bottom of the lite.
F. Pump sealant into glazing reglet 1" (25.4mm) away from each corner and the horizontal-to-vertical joint from the water diverter up to the glazing reglet.
G. Finish installing gaskets at top and bottom of D.L.O.
H. Repeat steps 19 A-G for the remaining row of lites.
I. Prior to glazing the next row of lites, install water diverter P1135 at ends of intermediate horizontals. See **Fig. 1**.



TOP VIEW
FIG. 1.

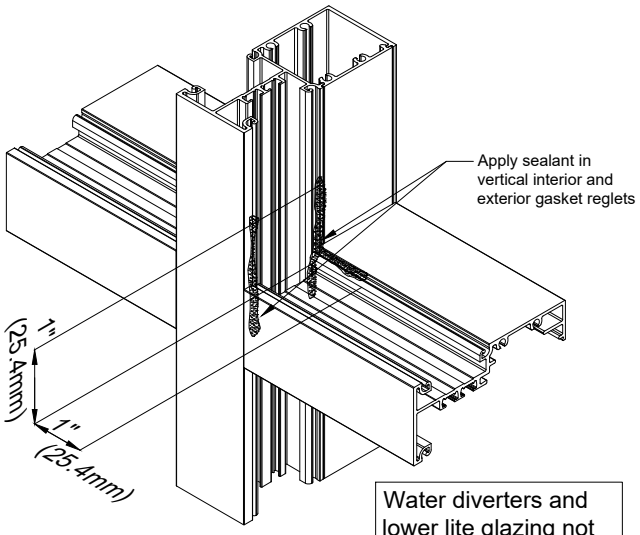


FRONT VIEW
FIG. 2

NOTE: **Position water diverter to cover glass corner.** Seal diverter to horizontal, leaving the gap at the front and side open in the vertical glazing pocket. See **Fig. 1 & 2**. (Also see isometric details on page 55)

STEP 20

Step 20: Installing the Glazing Units (Continued)



Water diverters and lower lite glazing not shown for detail clarity

FIG. 1

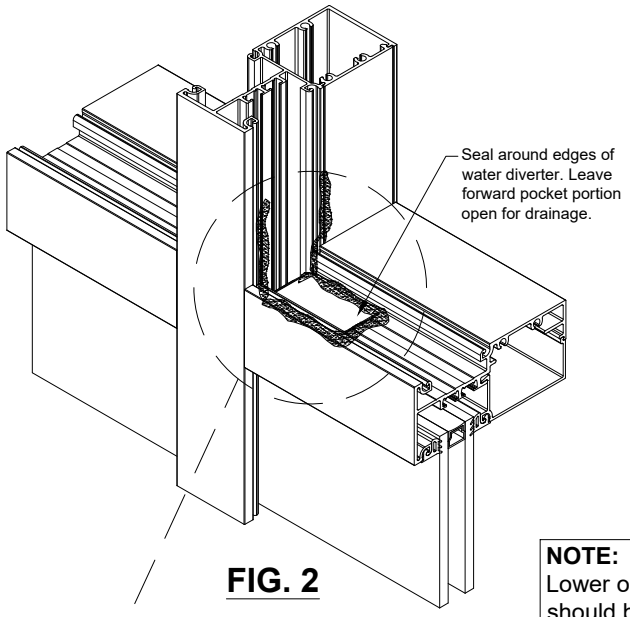


FIG. 2

NOTE:
Lower openings should be glazed prior to installing water diverters in upper openings.

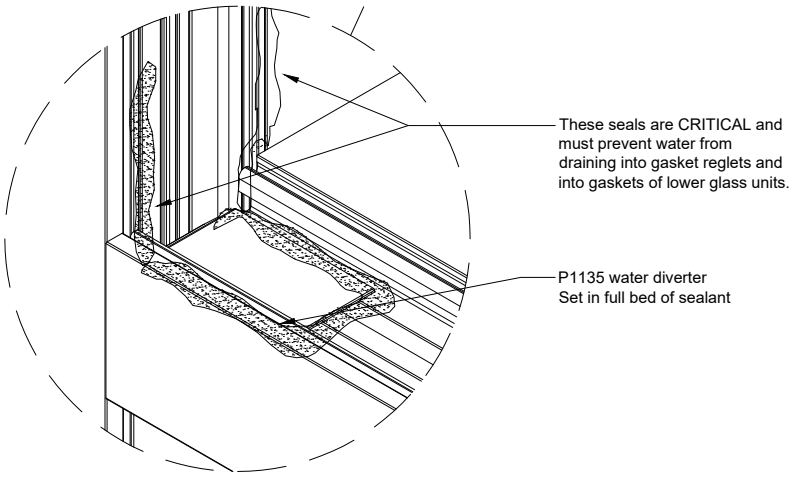


FIG. 3

GLAZING

STEP 21

Step 21: Install Gaskets

A. Install glazing gasket on one side of the framing member, depending upon direction of glazing.

1. For inside glazing, install gaskets on exterior side of framing first.
2. For outside glazing, install gaskets on interior side of framing first.

DO NOT STRETCH GASKETS WHEN INSTALLING. Start at the center of D.L.O. and work towards the ends.

Allowance = $\frac{1}{8}$"(3.2mm) extra length per foot of D.L.O.

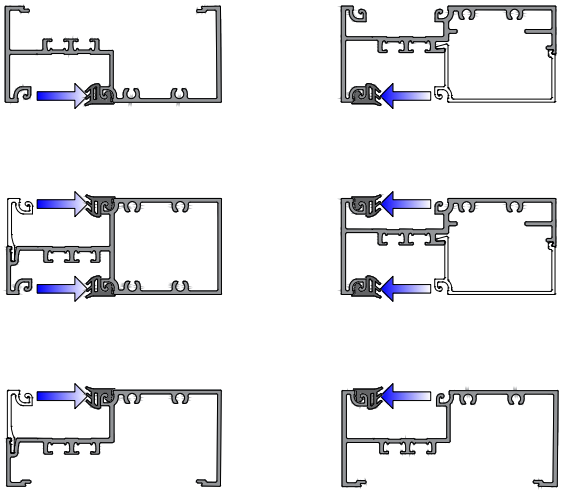


FIG. 1.

IMPORTANT NOTE: Clean ends of gaskets with IPA prior to sealing the corners.

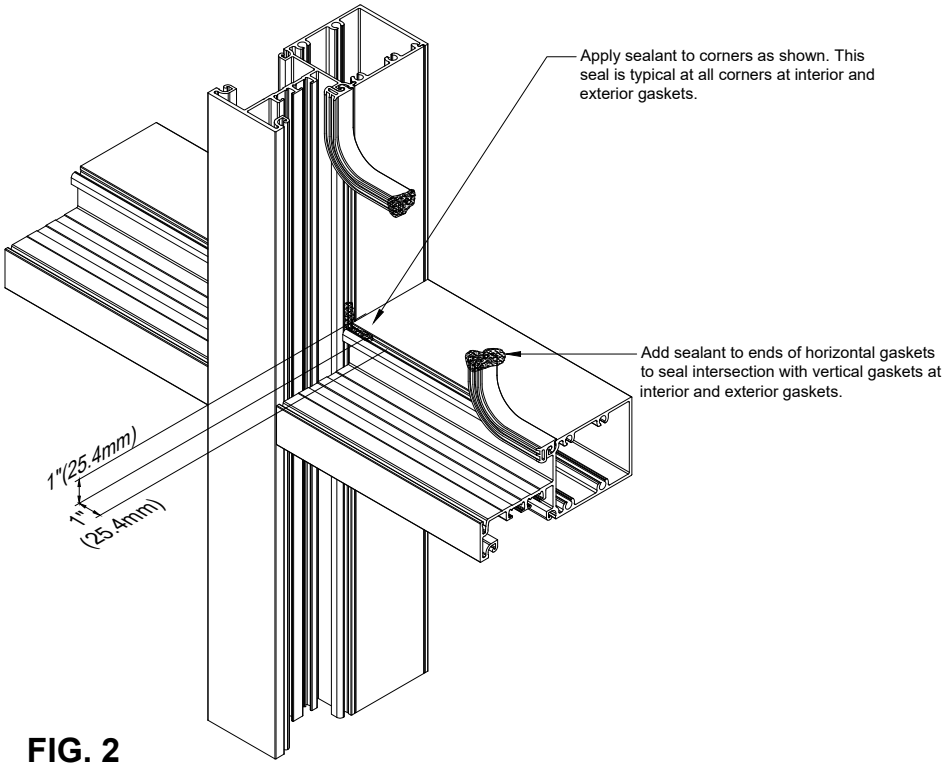


FIG. 2

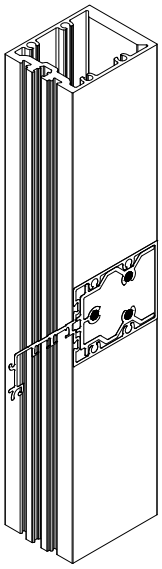
SSG - STEP 1-2

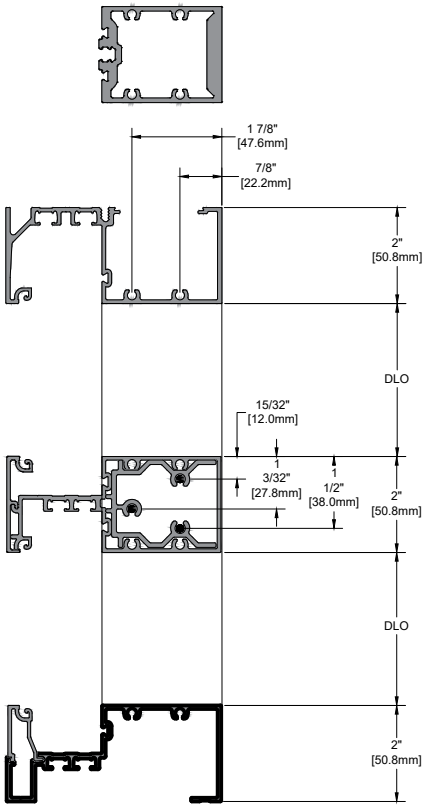
Step 1: Fabricate Sill Flashing

A. Refer to Step 3 of Frame Fabrication on page 30.

Step 2: Fabricate Vertical Framing Members

A. Drill frame assembly holes in verticals & jambs as shown in **FIG. 1**.
B. Use short off-cut of horizontal to aid in assembly hole locations.





SSG - STEP 3

Step 3: Fabricate Horizontal Members for Shear Blocks

A. For SSG condition, shear block assembly must be used. Drill 0.221" dia holes in the horizontal members as shown in **FIG. 2.**

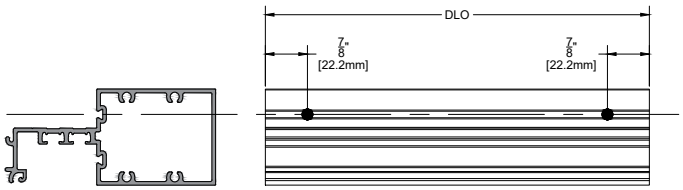


FIG. 1

STRUCTURAL SILICONE GLAZED - SSG

Step 4: Assemble Frames

Shear Block Assembly - **SSG**

A. Install shear blocks onto vertical with S009 #10 x 1 $\frac{3}{4}$" PH screw as shown in **FIG. 1**.
B. Clean all mating surfaces on horizontal, vertical, and shear blocks.
C. Apply sealant to ends of the horizontal and shear blocks prior to attaching to the horizontal members to the vertical members.
D. Slide horizontal over the shear blocks.
E. Match drill hole in horizontal shear blocks with drill for #10 screws.
F. Secure intermediate horizontal E/T/TU15323 with (1) S191 #10 x $\frac{1}{2}$" truss head screw. See **FIG. 1**.
G. Head and sill members run through between jambs.

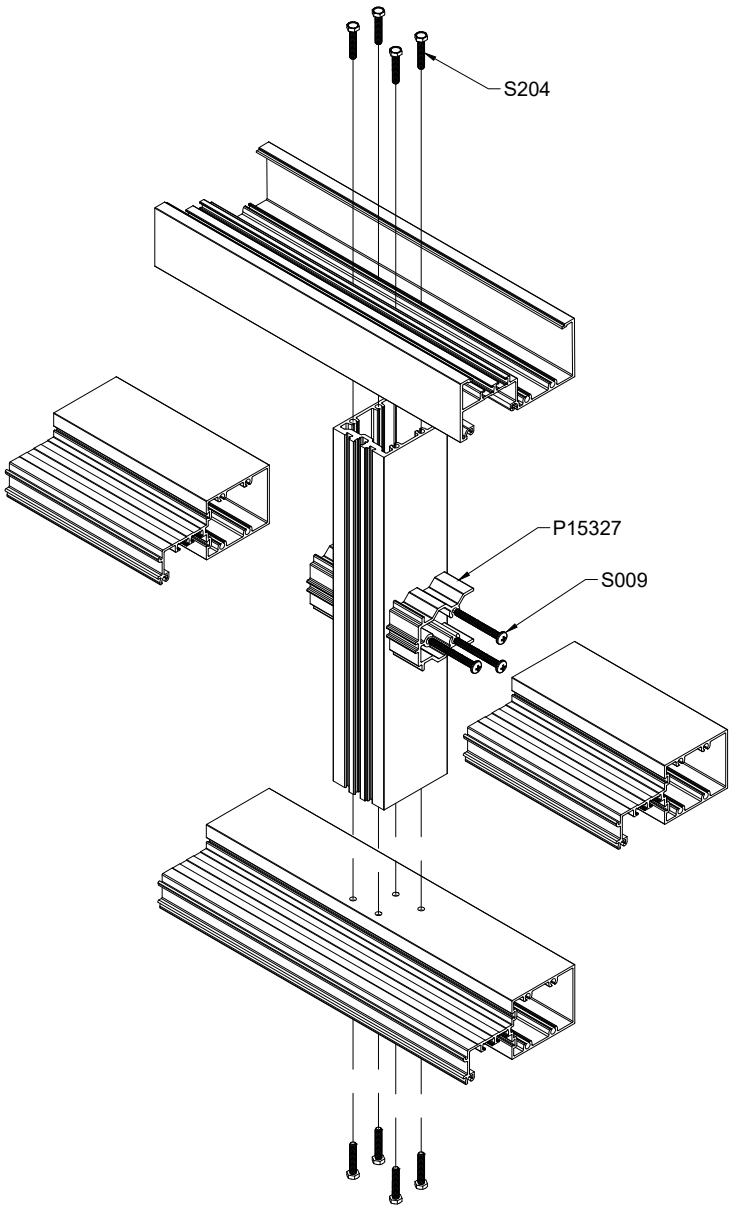


FIG. 1

Step 4: Assemble Frames

Shear Block Assembly - **SSG Expansion Mullion**

A. Clean all mating surfaces on horizontals & verticals.
B. Apply sealant to ends of the horizontal, prior to attaching to the vertical members.
C. Attach horizontal members to expansion verticals with (4) S204 screws. See **FIG. 1**.
D. Attach head & sill members to verticals with (4) S204 screws. See **FIG. 2.**
E. Fabricate bond breaker splices at head and sill for both exterior and interior locations. See **FIG. 2**.
F. Head and sill members run through between jambs.

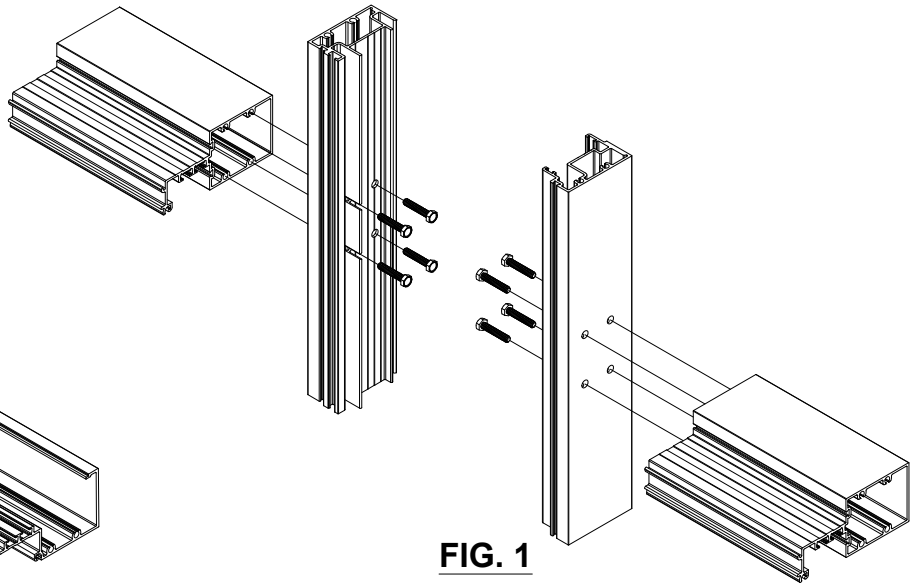


FIG. 1

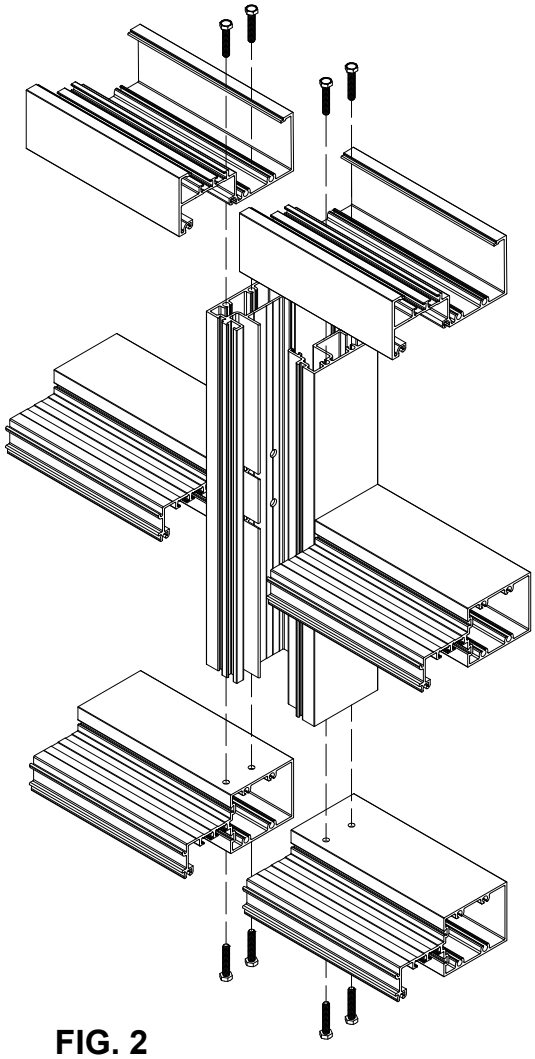


FIG. 2

STRUCTURAL SILICONE GLAZED - SSG

SSG - STEP 5

Step 5: Install Water Diverter

A. Water diverters can onlyu be installed once the frame is assembled.
B. Apply silicone to horizontal glazing pocket where the water diverter will be resting. See **FIG. 1**.
C. Place P2407 water diverter evenly across the horizontal to cover the void between the horizontal members.
D. Bend the water diverter 90 degrees.
E. Seal around edges of water diverter. THIS IS A CRITICAL SEAL. Do not seal front of water diverter. See **FIG. 3**.

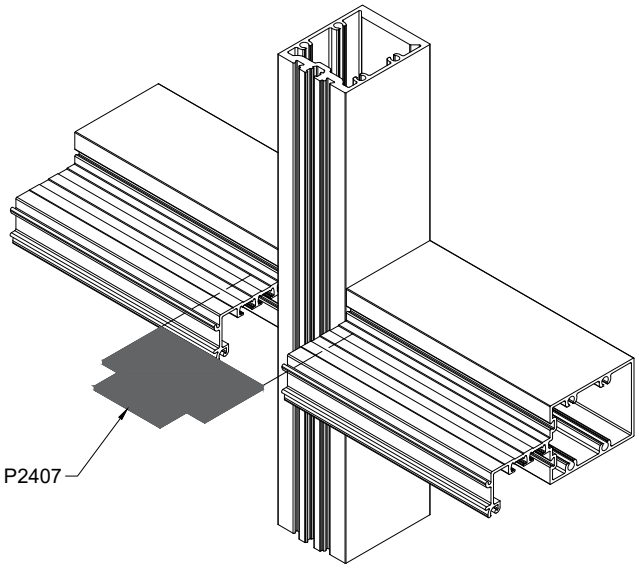


FIG. 1

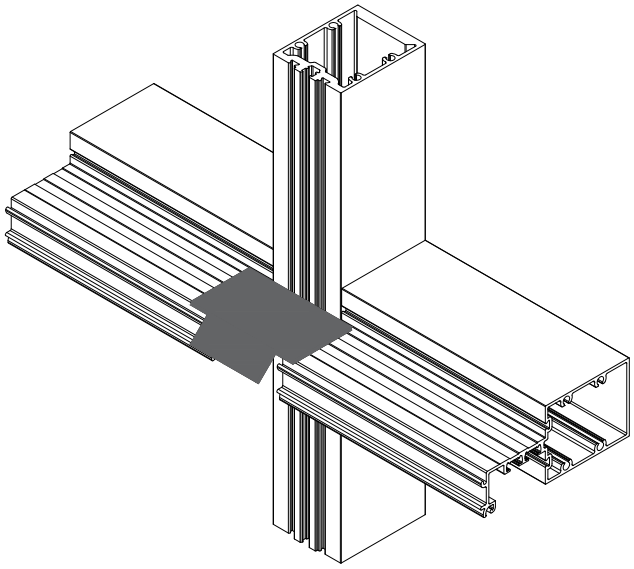


FIG. 2

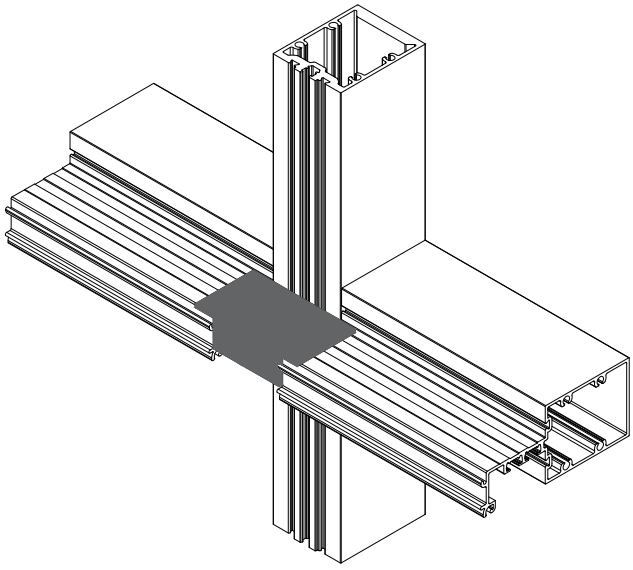


FIG. 3

STRUCTURAL SILICONE GLAZED - SSG

SSG - STEP 6

Step 6: Install Glazing Gaskets

A. Remove any debris from the glazing pockets and reglets.
B. Install P6587 gasket into the reglets of the mullions to be structurally sealed. See **FIG. 1**.
C. Refer to approved shop shop drawings for mixed dry and structural glazed applications. Install P2728 gasket for any dry glazed sections.

DO NOT STRETCH GASKETS WHEN INSTALLING
Start at the center of D.L.O. and work toward ends.

NOTE: Allowance = $\frac{1}{8}$" extra length per foot of D.L.O. to allow for gasket to relax after installation.

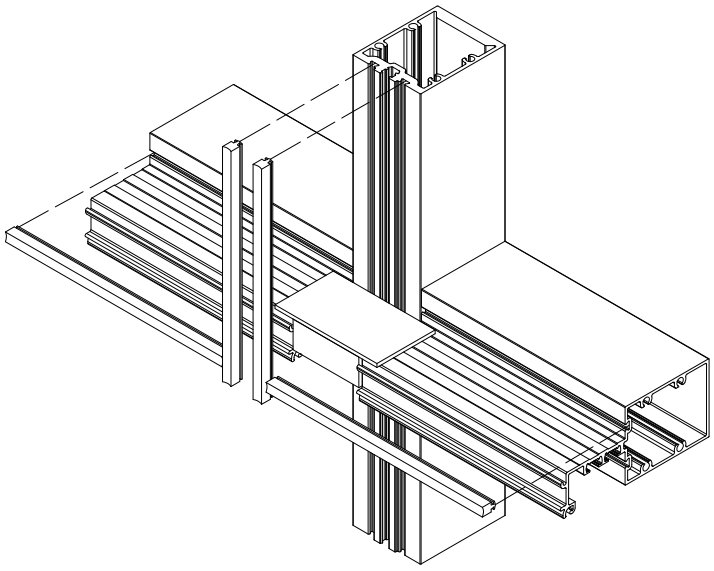


FIG. 1

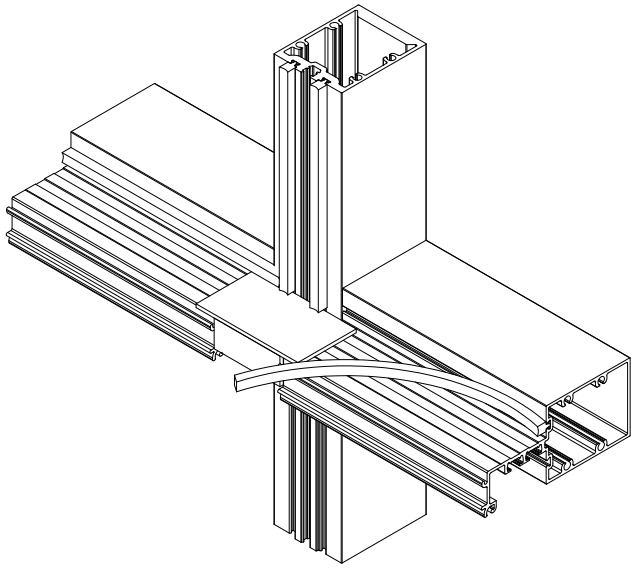


FIG. 2

STRUCTURAL SILICONE GLAZED - SSG

SSG - STEP 7

Step 7: Install Glazing Units

A. Set glass onto (2) setting blocks located at quarter points or per approved shop drawings.
B. Tape off side of SSG vertical and glass prior to applying structural sealant. Apply structural sealant as shown on interior. See **FIG. 2**. Use P1108 temporary glazing clip to secure glass as interior seal cures.
C. Apply structural sealant as shown in **FIG. 3.**
D. Install exterior gaskets (P2728) on head, sill, and jambs. Install outside glass stop (E15324) on horizontal. See **FIG. 4.**

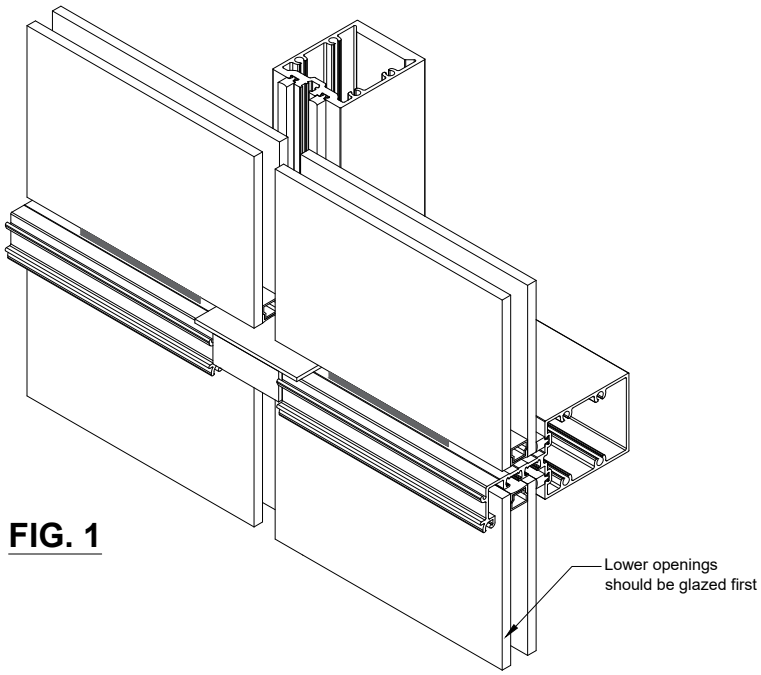


FIG. 1

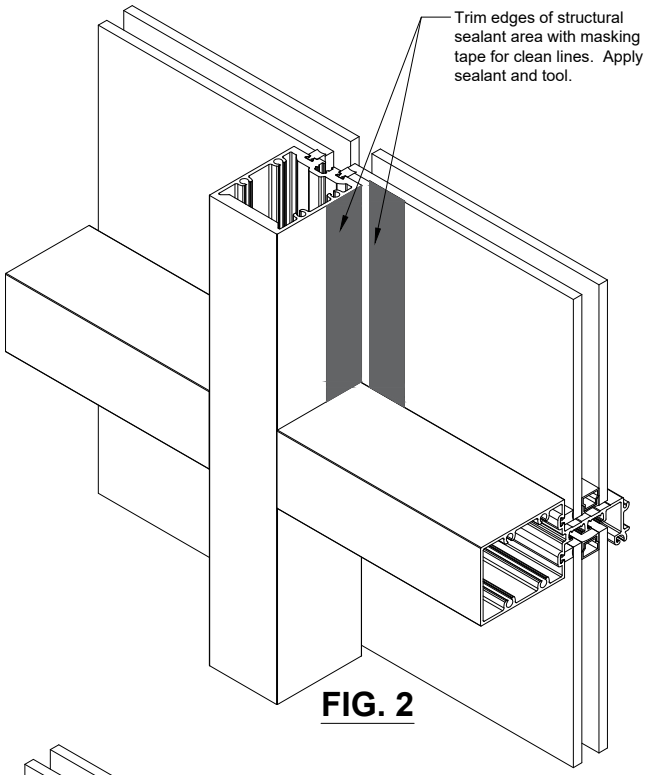


FIG. 2

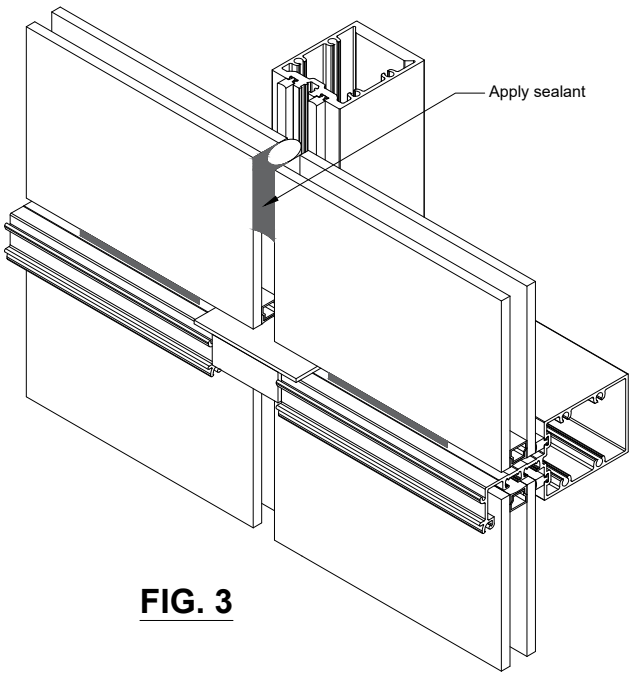


FIG. 3

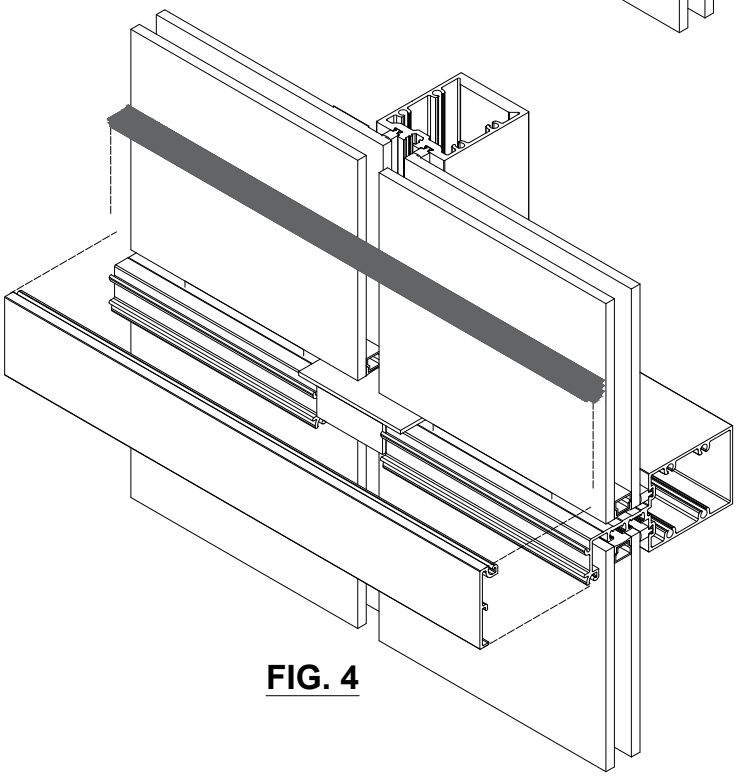


FIG. 4

SSG - STEP 8

Step 8: Install SSG Corner

A. Place the male SSG corner member (E15348) and female SSG corner member (E15349).
B. Install P6587 glazing gaskets to corner members
C. Set glass. Tape off side of SSG vertical and glass prior to applying sealant. Apply backer rod and structural sealant as shown in **FIG. 1** & **FIG. 2**

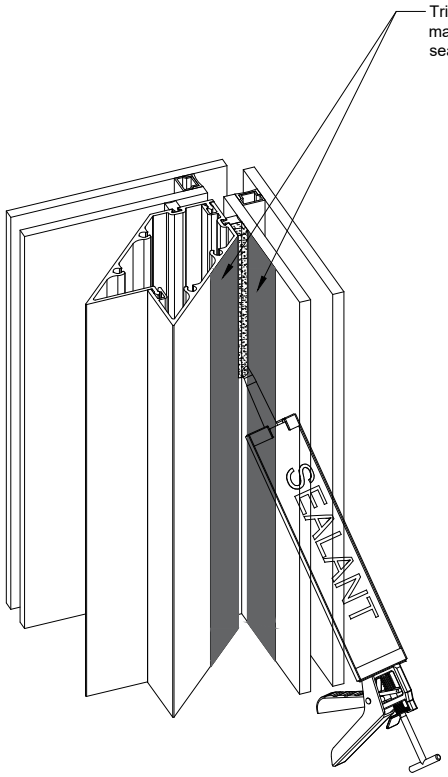


FIG. 1

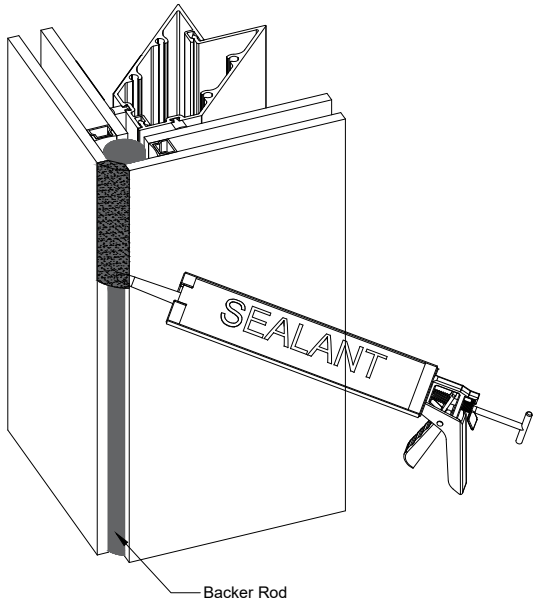


FIG. 2