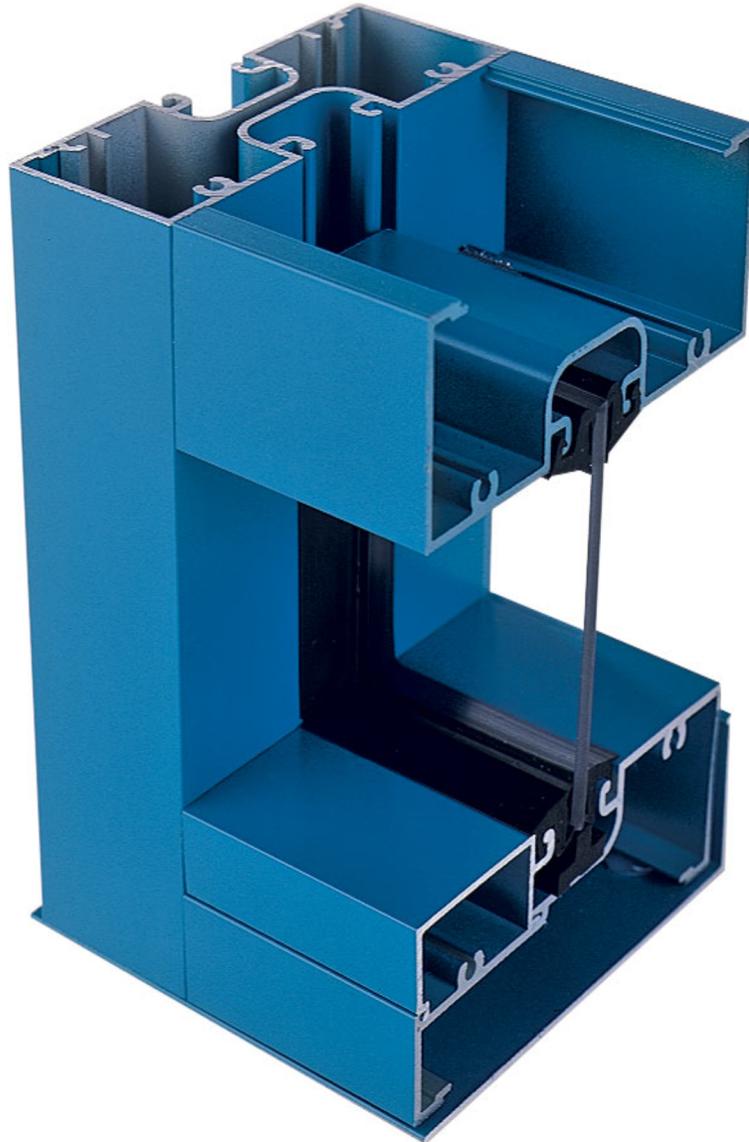


TUBELITE®

DEPENDABLE

LEADERS IN ECO-EFFICIENT STOREFRONT,
CURTAINWALL AND ENTRANCE SYSTEMS



4500 SERIES STOREFRONT

INSTALLATION INSTRUCTIONS

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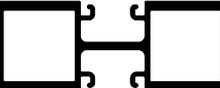
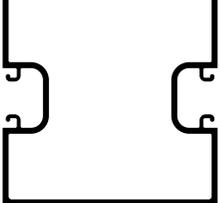
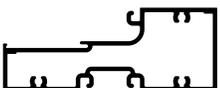
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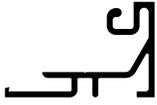
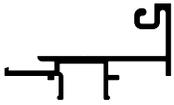
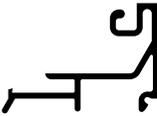
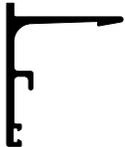
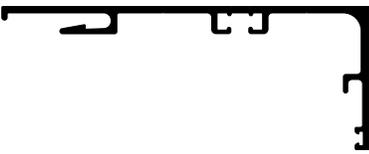
GENERAL CONSTRUCTION NOTES

1. These instructions cover typical product application, fabrication, installation and standard conditions and are general in nature. They provide useful guidelines, but the final drawings may include additional details specific to this 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 record of where various materials are stored.
3. All field welding must be done in accordance with American Institute of Steel Construction (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.
4. Coordinate protection of installed work with general contractor and/or other trades.
5. 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.).
6. 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.
7. 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.
8. 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.
9. Sealant must be compatible with all materials with which they have contact, including other sealant surfaces. Consult sealant manufacturer for recommendations relative to shelf life, compatibility, cleaning of substrate, priming, tooling adhesion, etc.
10. 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.
11. This product requires clearances at head, sill and jambs to allow for thermal expansion and contraction. Refer to final distribution drawings for joint sizes. Joints smaller than ¼" may be subject to failure. Consult your sealant supplier.
12. All materials are to be installed plumb, level and true with regard to established bench marks and column center lines established by the general contractor and checked by the erector, installer and/or glazing contractor.
13. Cleaning of exposed aluminum surfaces should be done per American Architectural Manufacturer's Association (AAMA) recommendations.
14. Due to varying perimeter conditions and job performance requirements, anchor fasteners are not specified in these instructions. For anchor fastening, refer to the shop drawings or consult the fastener supplier.
15. Check tubeliteinc.com for any updates on installation instructions.

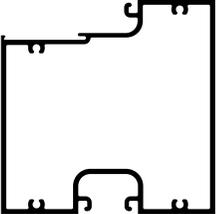
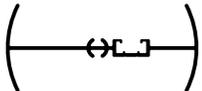
EXTRUSIONS

SHAPE	DESCRIPTION	PART No.
	Standard Open Back Head/Jamb/Vertical	E4541
	Open Back Sill/Horizontal	E4540
	Heavy Wall Vertical	E4561
	Vertical	E4562
	4 1/2" x 4 1/2" Vertical	E45009
	Intermediate Horizontal	E4503
	Male Expansion Vertical	E4506
	Female Expansion Vertical	E4507
	Alternate Sill Flashing	E45159
	Standard Sill Flashing	E14059

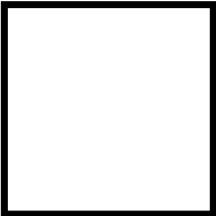
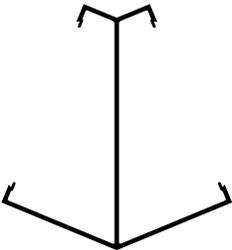
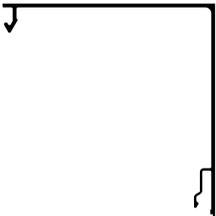
EXTRUSIONS

SHAPE	DESCRIPTION	PART No.
	Screw Applied Gutter for 1/4" Glass	E4014
	Glass Stop for 1/4" Glass	E4015
	Snap-In Gutter for 1" Glass	E4013
	Glass Stop	E4504
	Snap-in Gutter for 1/4" Glass	E4026
	Gutter for 1" Glass	E14024
	Male Head Receptor	E14130
	Female Head Receptor	E14129
	Head Receptor	E45116
	Snap-in 1/4" Pocket Filler	E4011

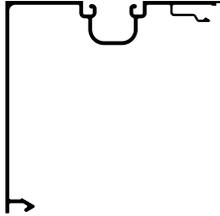
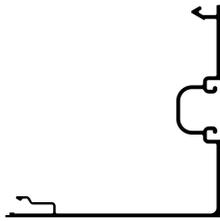
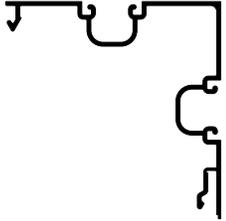
EXTRUSIONS

SHAPE	DESCRIPTION	PART No.
	Flat Snap-in Filler	E4543
	Snap-in Filler	E4542
	4" x 2 1/2" Sidelite Base	E14026
	Sidelite Base Channel	E14027
	4 1/2" x 4 1/2" Sidelite Base/Horizontal	E4534
	Rotational Mullion	E45248
	Rotational Mullion	E14247

EXTRUSIONS

SHAPE	DESCRIPTION	PART No.
	1 3/4" x 4 1/2" Tube	E0041
	4 1/2" x 4 1/2" Tube	E0133
	135 Degree Corner Mullion	E45005
	Smooth Corner Post Half	E45110

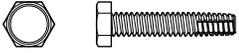
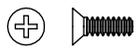
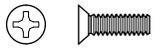
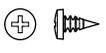
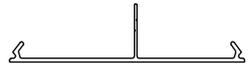
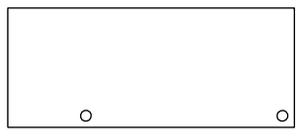
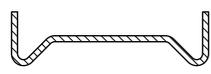
EXTRUSIONS

SHAPE	DESCRIPTION	PART No.
	<p>Corner Mullion</p>	<p>E45108</p>
	<p>Corner Mullion</p>	<p>E45109</p>
	<p>Corner Mullion</p>	<p>E45111</p>

GASKETS and SETTING BLOCKS

SHAPE	DESCRIPTION	PART No.
	Roll-in Glazing Gasket for 1/4" Glass (standard)	P2728
	Roll-in Glazing Gasket for 3/8" Glass	P487
	Bulb Gasket	P2511
	Wiper Gasket	P1221
	Setting Block	P575
	Horizontal/Sill Frame Clip	P531
	Door Head Frame Clip	P917
	Head Frame Clip	P532
	Sidelight Base Anchor	P1137
	Water Diverter	P878
	Sill Splice for E14059 & E45159	P3444

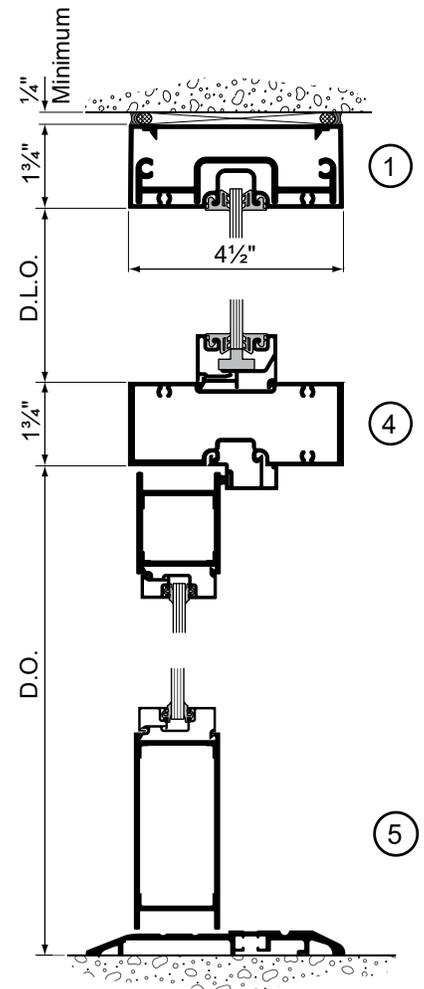
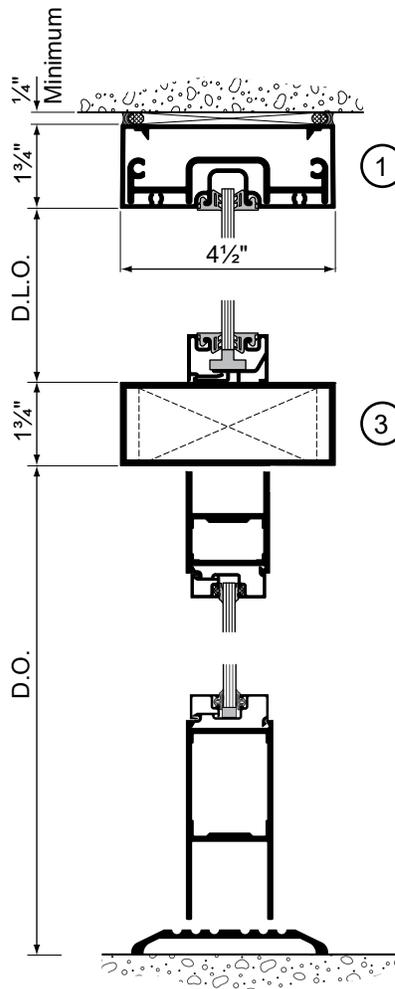
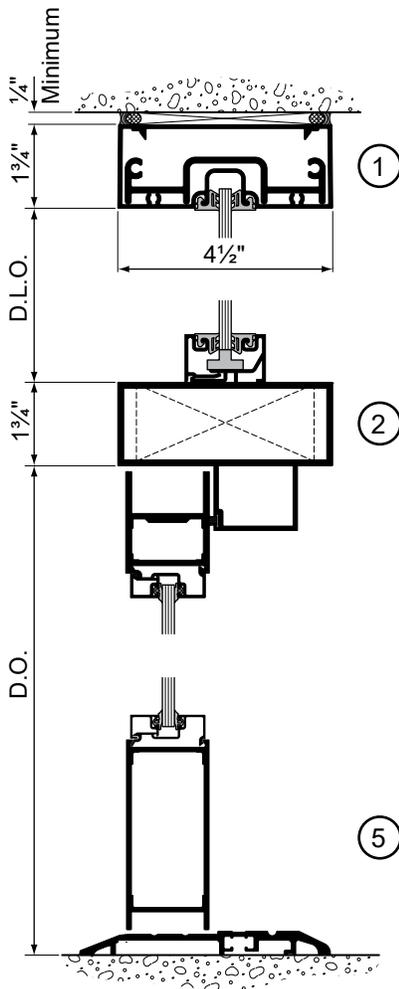
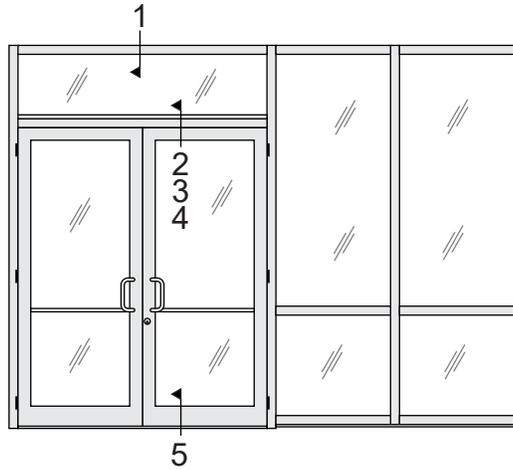
ACCESSORIES

SHAPE	DESCRIPTION	PART No.
	#10-24 x 1" IND HEX Head Type F Screw Spline Frame Assembly Screw	S449
	#10 X 1 3/4" type B Phillips Pan Head Attaching Shear Clips to Verticals	S009
	#10 X 5/8" type B Phillips Flat Head Attaching Horizontals to Shear Clips	S192
	#10 X 1/2" Phillips Truss Head Attaching Sidelite Base to Clip	S191
	#12 X 3/4" Phillips Flat Head Attaching Head to Shear Clip	S149
	#8 x 3/8" Phillips PH, Type A Attach end dams to sill flashing	S196
	Drill Fixture	P796B
	Rigid PVC Perimeter Caulk Backup	P4543A
	End Dam For E14059 Sill Flashing	P2455
	Alternate End Dam for Sill Flashing	P1142
	Steel Reinforcing	P1437
	Snap-In Filler at Anchors	P1745

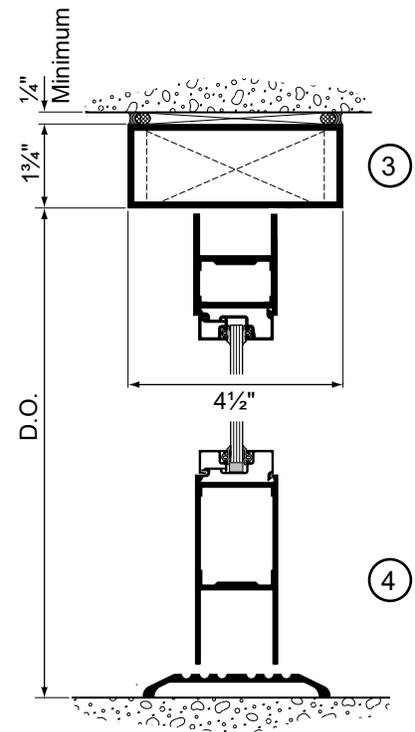
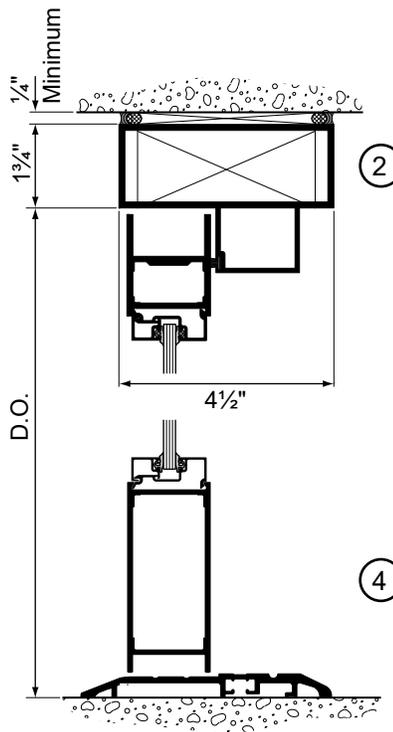
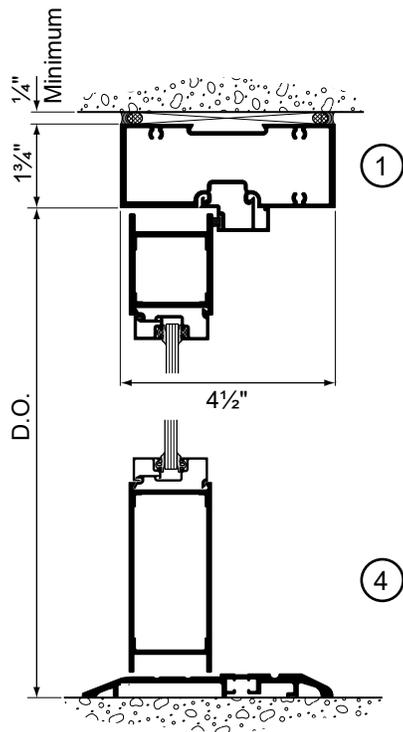
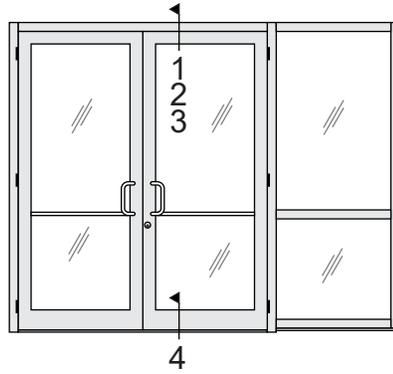
QUICK REFERENCE CHECKLIST

1. Make sure the opening is square and the caulk joints are 1/4" minimum around the frame.
Note: Frames that utilize the E14059 sill flashing must have a minimum of 3/8" 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. 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. Butter 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.

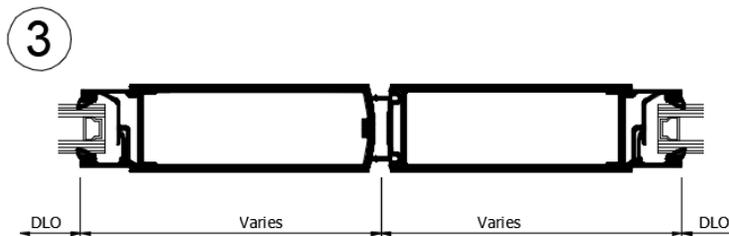
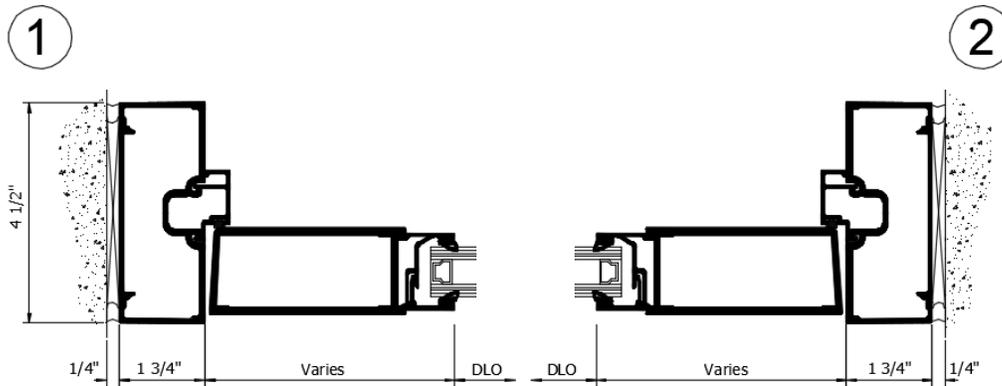
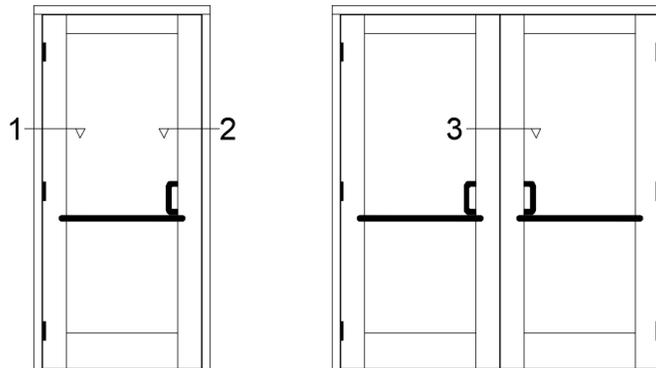
DOOR FRAME ELEVATION with HORIZONTAL DETAILS



DOOR FRAME ELEVATION with HORIZONTAL DETAILS



DOOR FRAME ELEVATION with VERTICAL DETAILS



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FRAME FABRICATION

Step 1: Determine Frame Size

Frame Width

- A. Make sure the opening is square and plumb. Measure each diagonal of the opening. **SEE Fig. 19.1.**

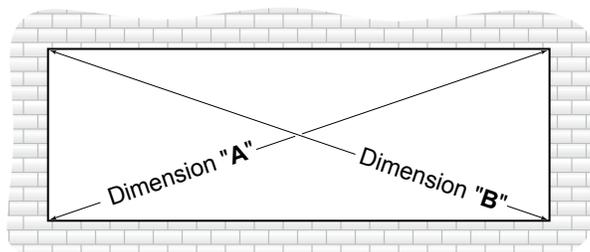


Fig. 19.1 Dimension "A" = "B"

- 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 (1/4" min caulk joint at each jamb). **SEE Fig. 19.2.**

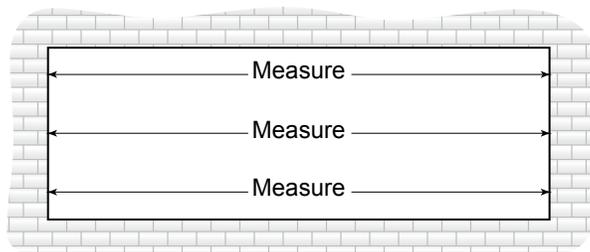


Fig. 19.2

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 as follows for frame height:
 Without sill flashing - 1/2"
 With E45159 sill flashing - 11/16"
 With E14059 sill flashing - 1"
 Allow larger clearance if necessary to accommodate building tolerances or out of square openings. **SEE Fig. 19.3.**

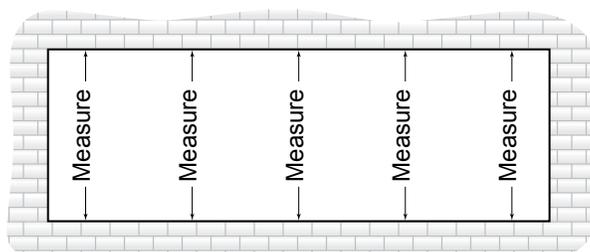


Fig. 19.3

Step 2: Cut Extruded Sill Flashing to Size

- A. Field cut extruded sill flashing to frame width + 1/4" determined in Step #1 (rough opening minus clearances). If the installation includes an entrance, flashing should butt against back of door jamb (no clearance).

Sill Flashing Note:

For openings wider than 24', the sill flashing must be spliced every twelve to fifteen feet near center line of D.L.O. Splice joint should be 3/8" wide. **SEE Step 7, Page 24 & 25** for sill flashing splice details.

FRAME FABRICATION

Step 2: Cut Extruded Sill Flashing to Size (continued)

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

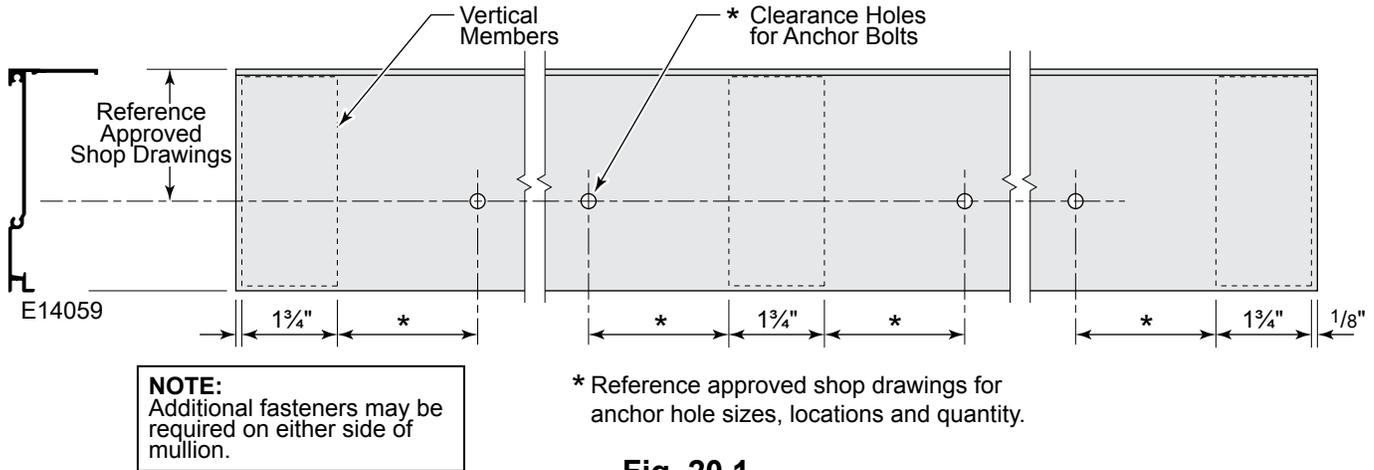
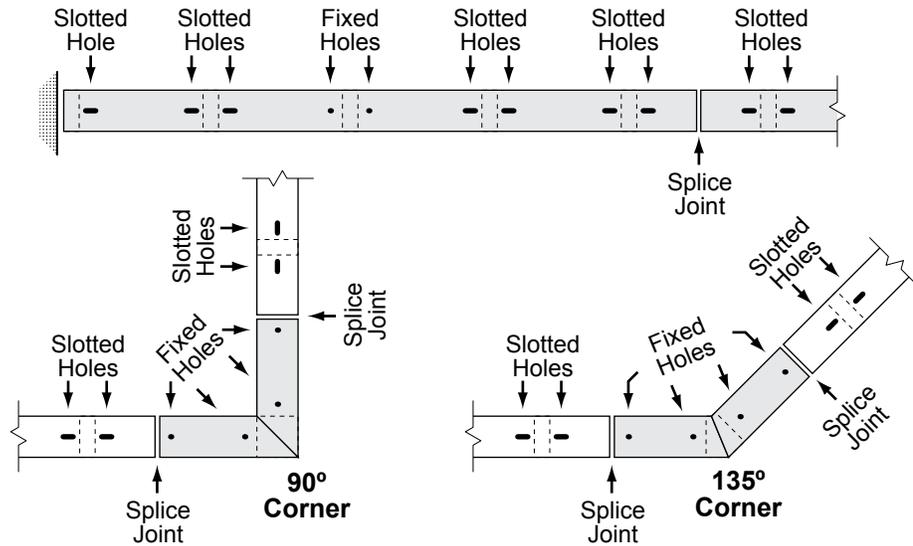


Fig. 20.1



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

Fig. 20.2

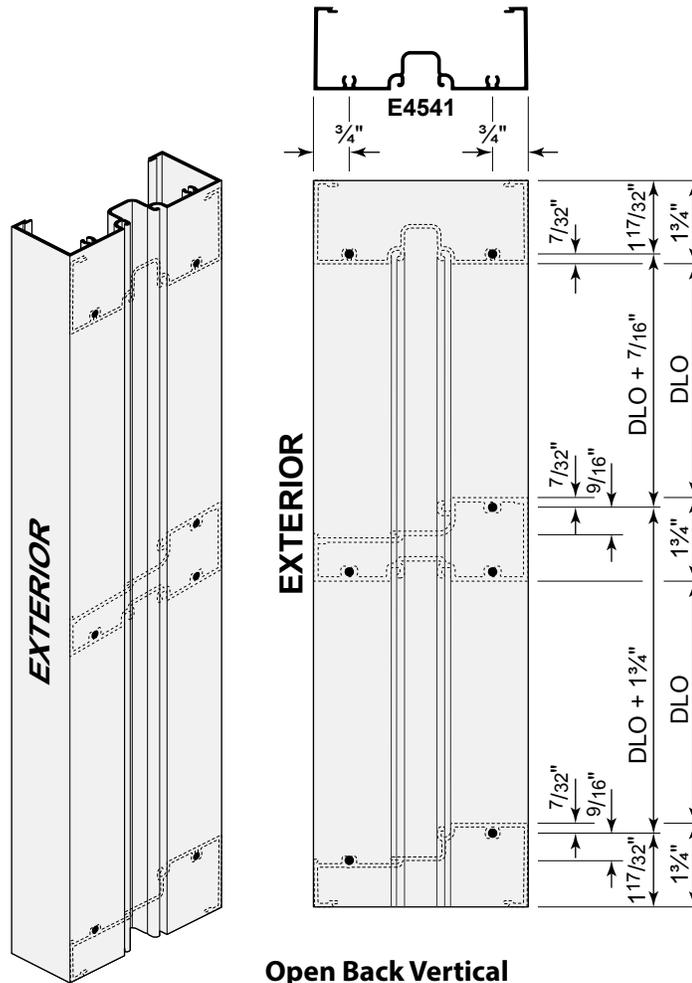
Step 3: Cut Mullions to Size

- Verticals should be frame height found in Step #1 (rough opening height minus clearances).
- Vertical framing members run through.
- Cut horizontal framing members to the daylight opening (the distance between verticals).

FRAME FABRICATION

Step 4: Drill Holes in Vertical Framing Members (screw spline)

- B. Drill .201" diameter holes in the vertical framing members using a drill fixture, **SEE Fig. 21.1** & **SEE Fig. 21.2**. Distances for holes will vary vertically depending on horizontals used.



Open Back Vertical

Fig. 21.1

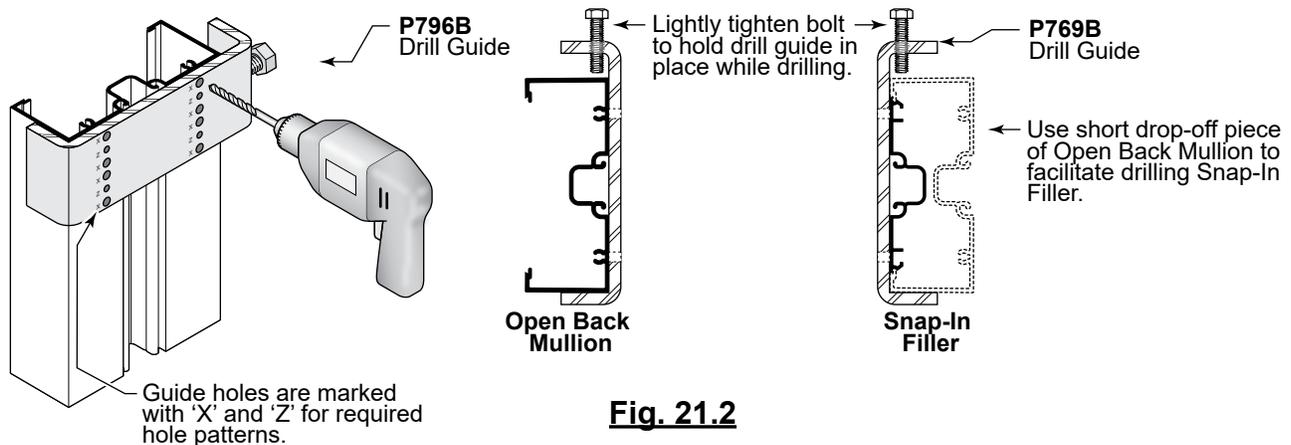


Fig. 21.2

FRAME FABRICATION

Step 5: Drill Holes in Vertical Framing Members (shear block)

- A. In shear block assembly, the installer secures frame clips to the vertical members with fasteners, slides horizontal members over the frame clips and secures the horizontal members to the frame clips with fasteners.
- B. Drill 0.149" diameter holes in the vertical framing members using a drill fixture, as shown at right. Distances for holes will vary vertically depending on horizontals used.

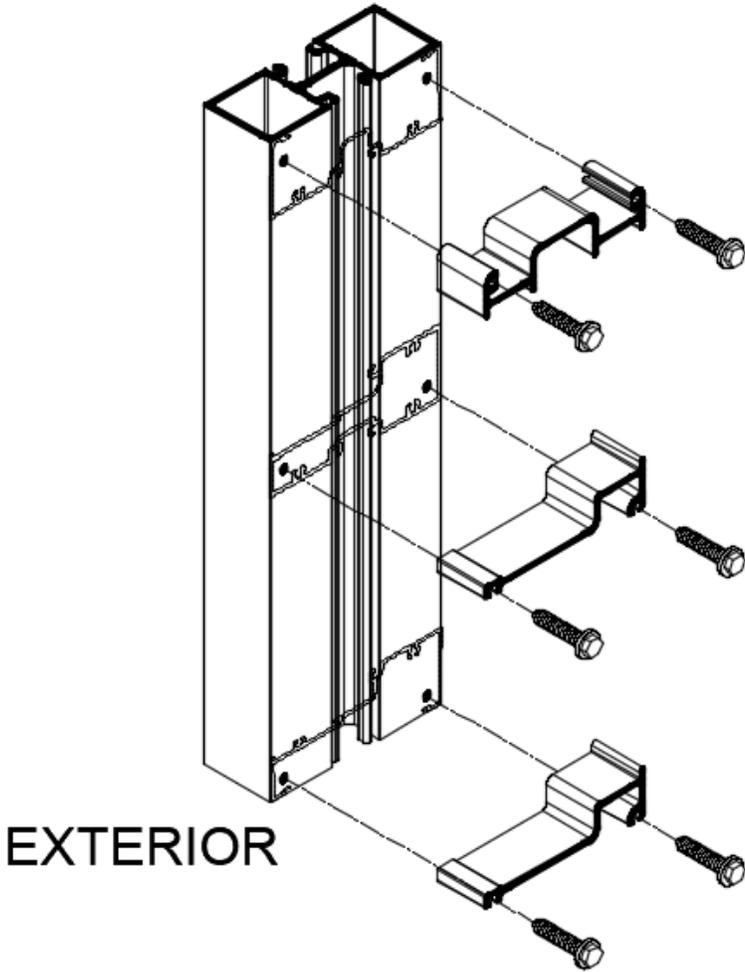


Fig. 22.1

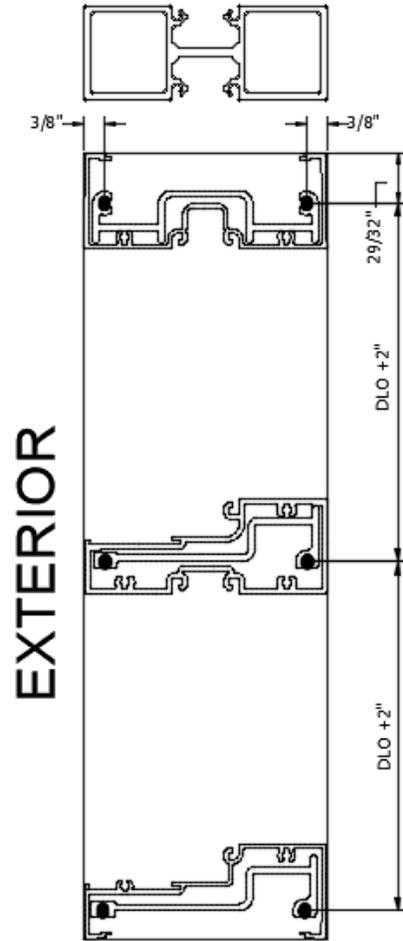
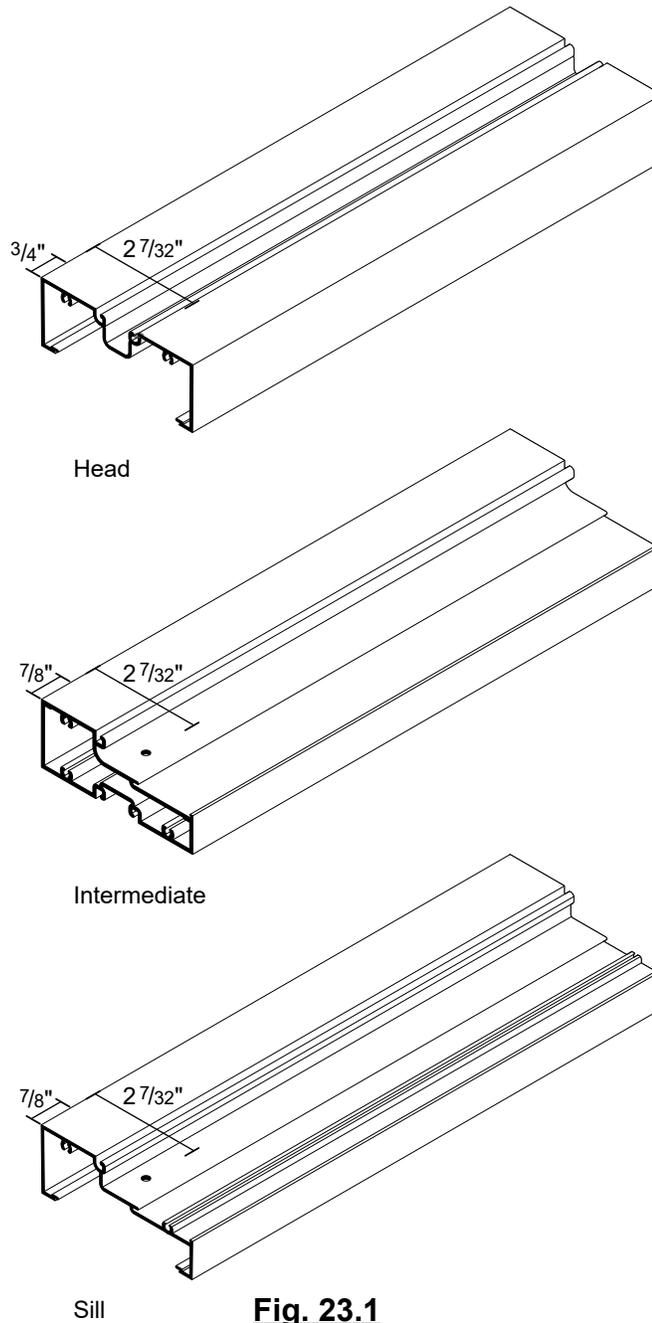


Fig. 22.2

FRAME FABRICATION

Step 6: Drill Holes in Horizontal Framing Members (shear block)

- A. Shear block assembly requires drilling of horizontals so they can be fastened to frame clips.
- B. Drill and countersink 0.201" diameter holes in the head, intermediate and sill



FRAME ASSEMBLY

Step 7: Splice the Sill Flashing Where Required (silicone splice, optional)

- A. If there is an entrance, it should be installed first, taking care to locate it accurately within the opening.
- B. Properly prepare floor surface as recommended by sealant manufacturer.
- C. Flashing longer than 24' in length should be spliced.
- D. Lay silicone splice sleeve (P3444) into sill flashing at splice location and cut to length as shown in **Fig. 24.1**. Do not run sleeve onto the lip of the flashing; run the sleeve to the lower portion.
- E. Install backer rod under the sill slashing at the splice joint.
- F. Clean surfaces where splice will be applied. Apply sealant as shown in **Fig. 24.1**.
- G. Set splice sleeve in place and tool sealant as shown in **Fig. 24.1**. Seal front and back joints.

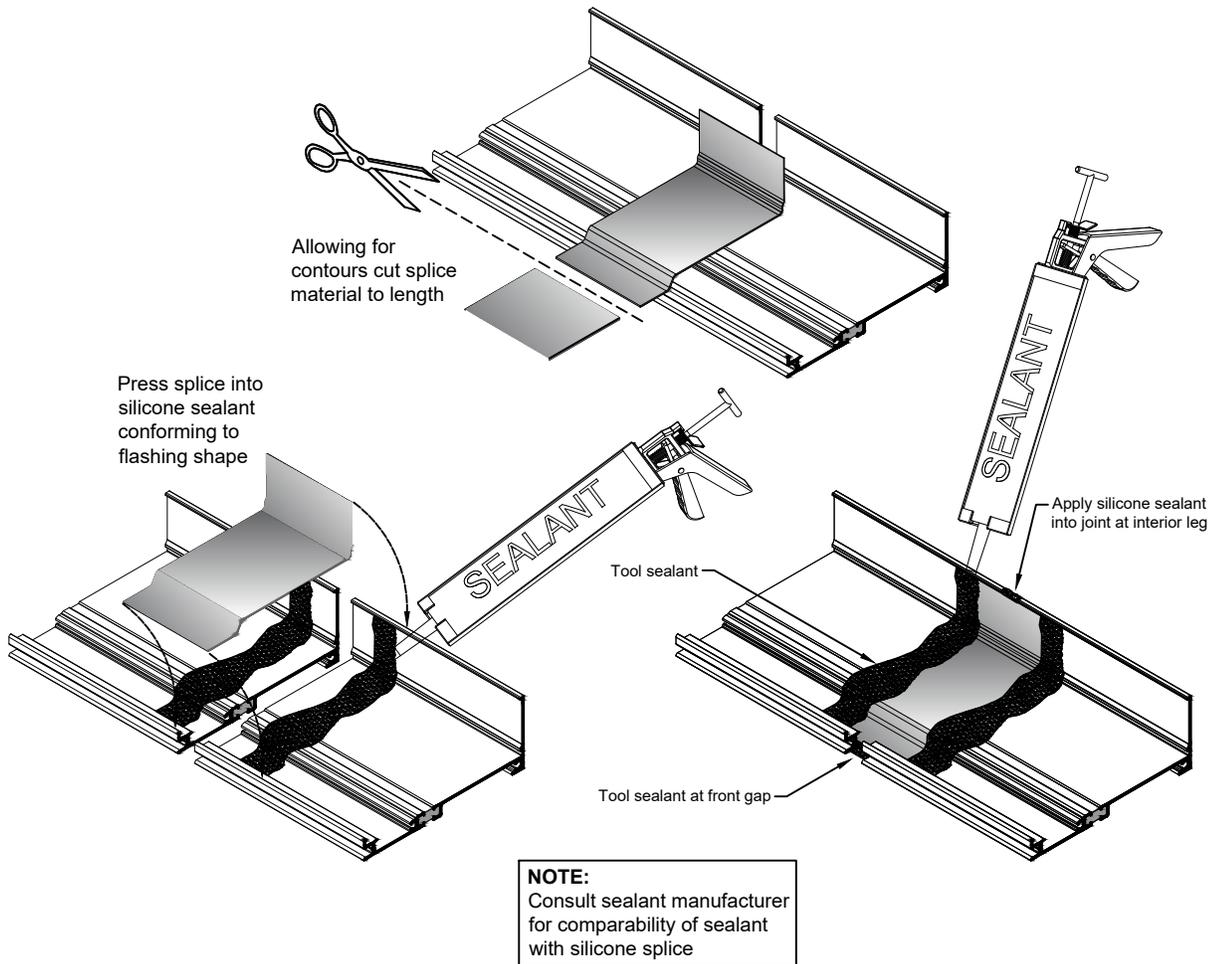


Fig. 24.1

FRAME ASSEMBLY

Step 8: Attach End Dam to Sill Flashing at Building Structure

- A. At a building structure, attach an end dam (P2455) to the end of the sill flashing with two S196 fasteners and seal the sill to the end dam as shown in **Fig. 25.1**.
- B. End dam must be completely sealed on all sides.

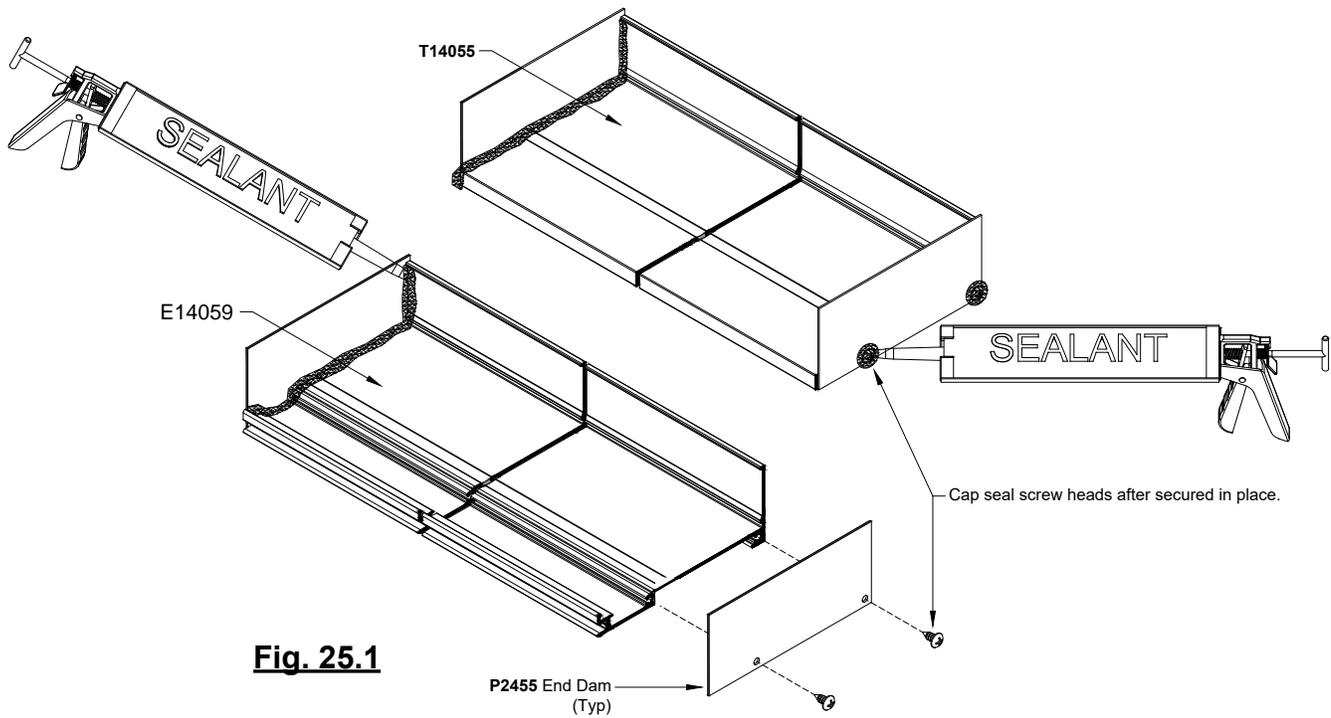


Fig. 25.1

FRAME ASSEMBLY

Step 9: Seal and Anchor the Sill Flashing

- A. At jamb conditions, butt the sill flashing up against the back of the door jamb and seal the sill to the back of the entrance frame as shown in **Fig. 26.1**. Place shims (not by Tubelite) under the flashing as needed to support the sill and level it.
- B. Fill the jamb pocket cavity completely with sealant.
- C. Drill holes for anchor bolts (not by Tubelite) through the sill and into the masonry, and secure the sill as specified in the approval shop drawings.
- D. Cap seal all anchor bolts with sealant. Before the fastener is inserted, force sealant into the hole for the sill perimeter fastener to ensure that the hole through is sealed.
- E. Do not block weep holes in sill flashing. **NOTE:** Sill flashing not required on interior applications.

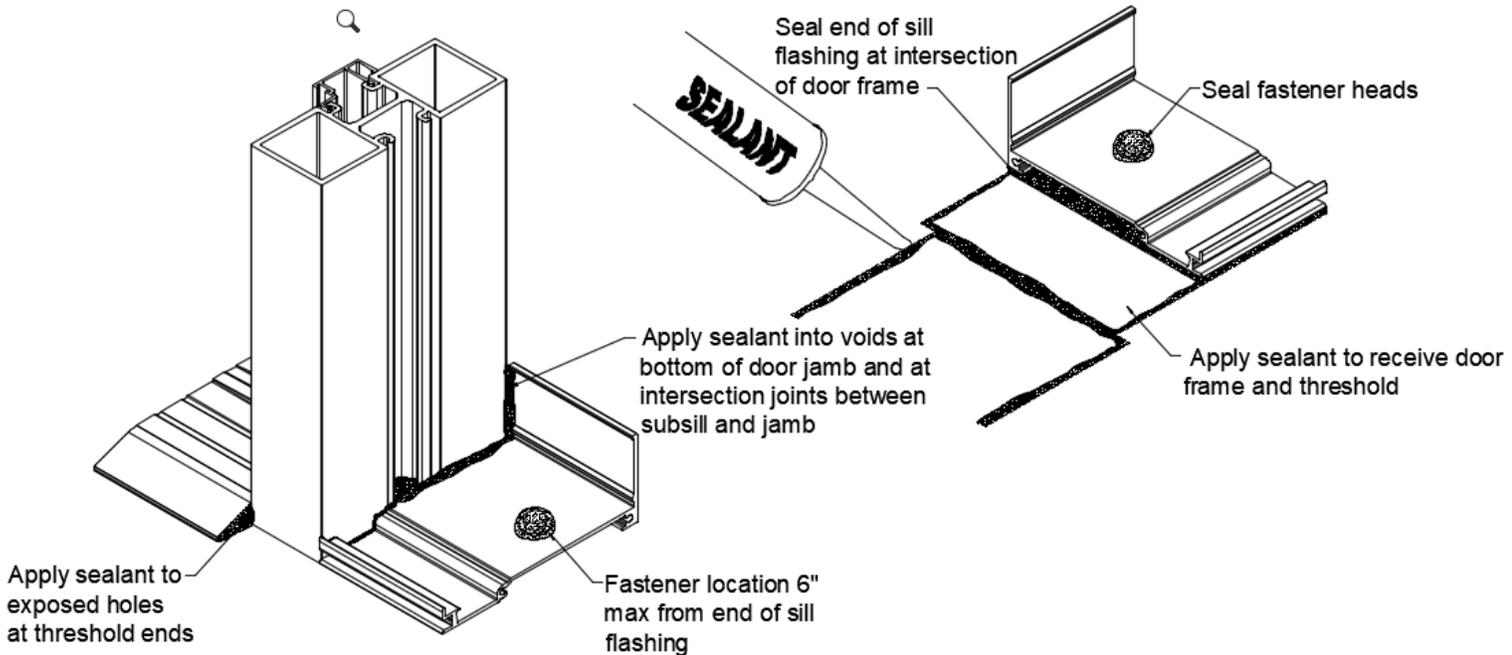
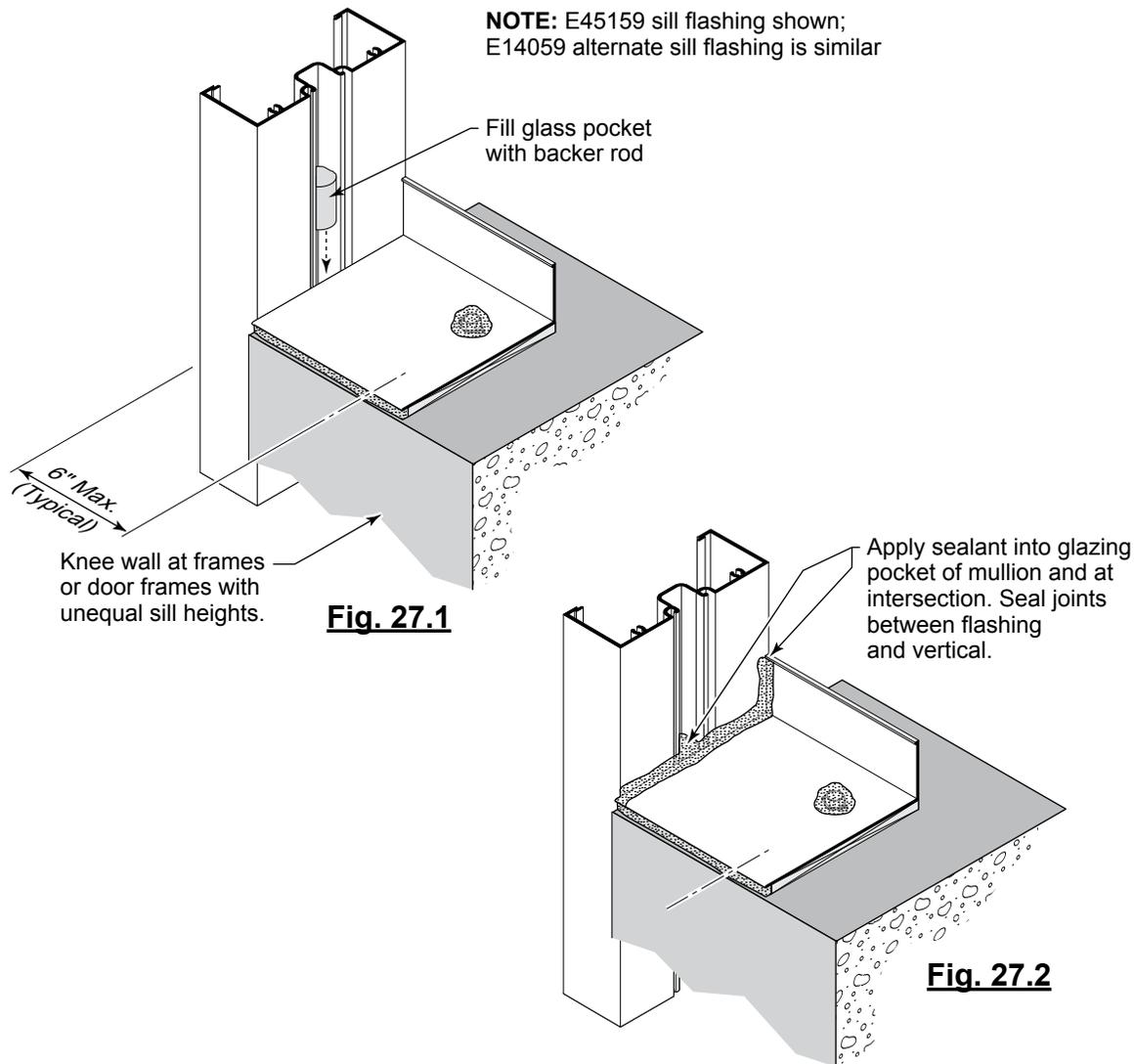


Fig. 26.1

FRAME ASSEMBLY

Step 9: Seal Sill Flashing to Vertical Above Knee Wall

- A. Above a knee wall condition, the sill flashing needs to be sealed to the vertical.
- B. Fill void in glass pocket adjacent to sill flashing with backer rod.
- C. Seal over backer rod and ramp sealant up to drain water coming down the vertical into the sill flashing. **SEE Fig. 27.1.**
- D. Seal 4" above the sill flashing where the filler attaches to the vertical.



NOTE:
 When a "Knee Wall" occurs within an elevation, the sill flashing must be sealed to intersecting vertical member as shown in **Fig. 27.2**.

FRAME ASSEMBLY

Step 10: Secure Frame Clips to Verticals (shear block)

A. Attach frame clips to verticals with S009 fasteners as shown in **Fig. 28.1**.

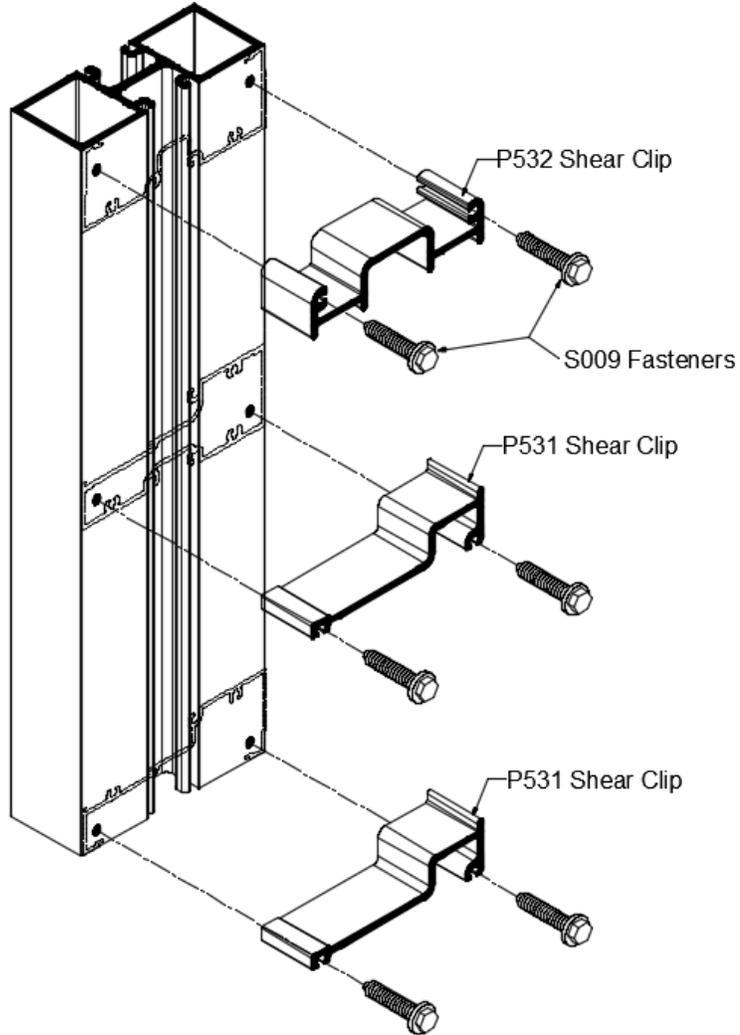


Fig. 28.1

FRAME FABRICATION

Step 11: Attach Horizontals to Frame Clips (shear block)

- A. Apply sealant to the perimeter of the frame clips.
- B. Apply sealant to contact edge of the horizontal.
- C. Slide horizontals onto frame clips as show in **Fig. 29.1**.

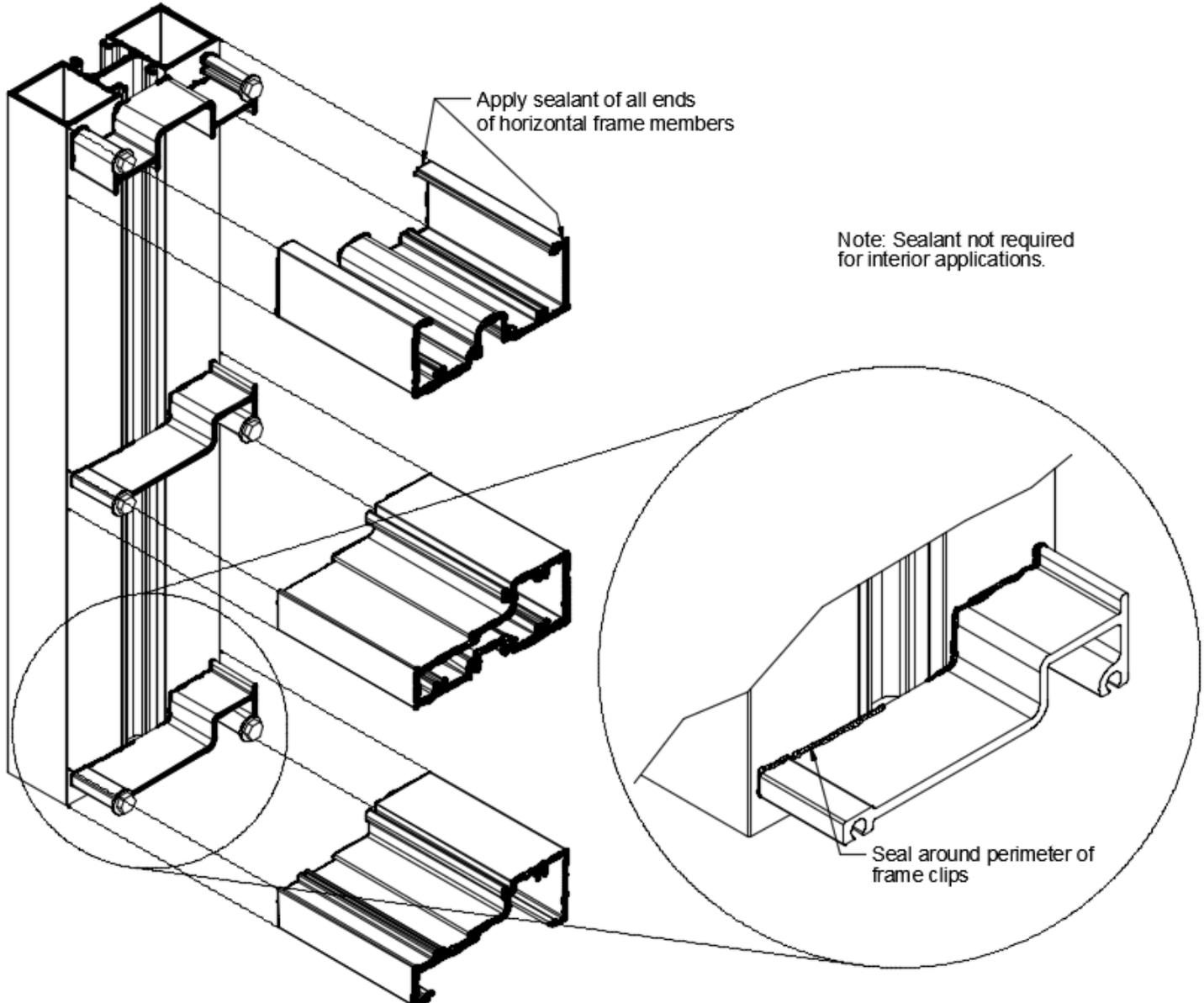


Fig. 29.1

FRAME ASSEMBLY

Step 11: Attach Horizontals to Frame Clips (shear block) (Continued)

- D. Match drill tap holes in the frame clips using holes in the horizontals as guides and secure horizontals to frame clips with S192 fasteners.
- E. Apply sealant to the heads of the fasteners which secure the horizontals to the frame clips.

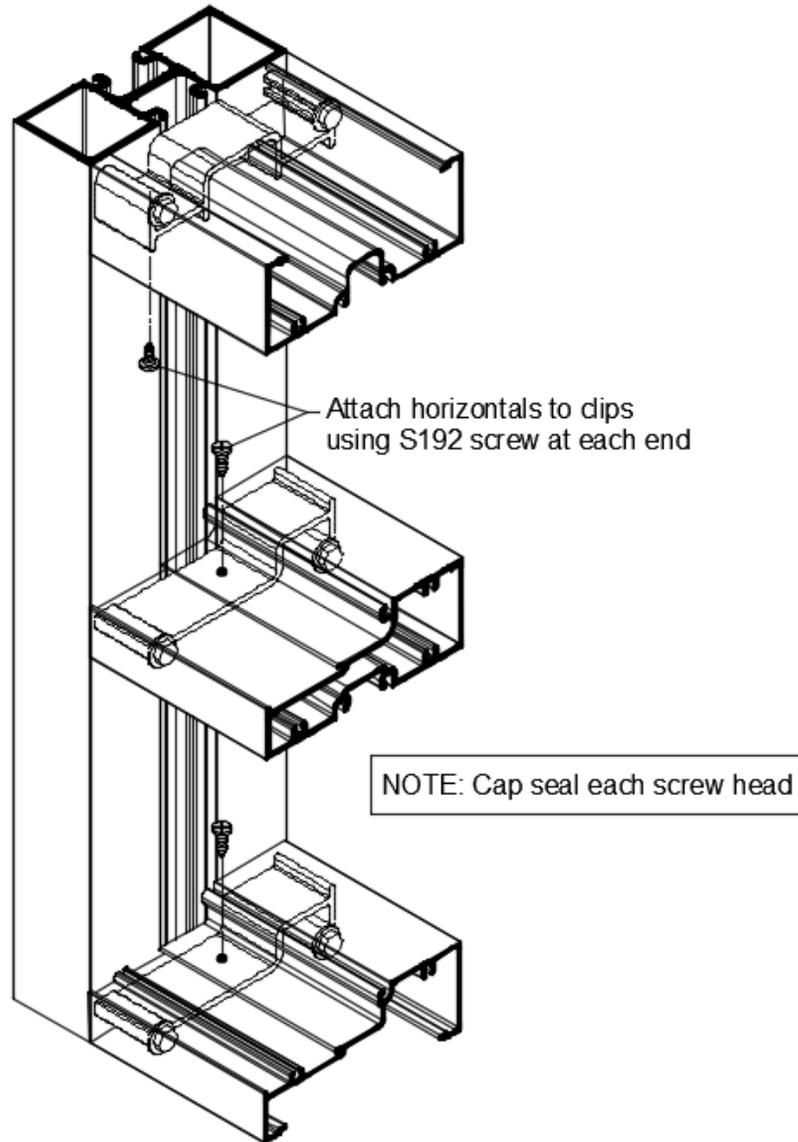


Fig. 30.1

FRAME ASSEMBLY

Step 12: Attach Horizontals to Verticals (screw spline)

- A. Apply sealant to all the contact edges of the horizontal.
- B. Secure horizontals to vertical using S449 fasteners as shown in **Fig. 31.1**.

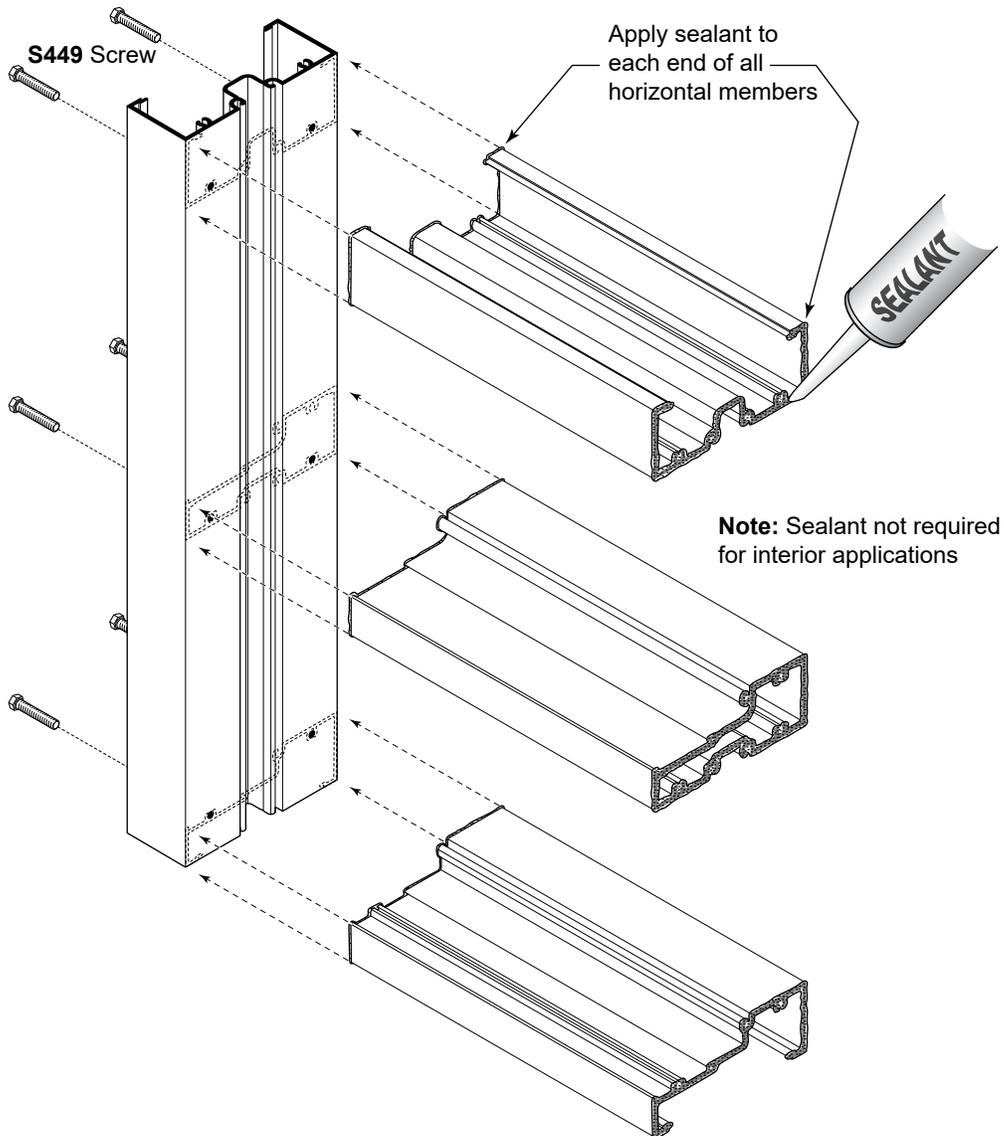


Fig. 31.1

FRAME INSTALLATION

Step 13: Install Assembled Units

- A. Run a bead of sealant at the top of the upturned sill flashing leg.
- B. Install the assembled units beginning at the entrance and working towards the jambs. If there is no entrance, work from jamb to jamb. In the case of smaller units, the last two may need to be snapped together and pivoted into position.
- C. Where expansion verticals are present, seal the interior reveal 3" up from the sill flashing, marrying with the sealant at the sill flashing noted in A above.

Step 14: Add Steel Reinforcement (if necessary)

- A. Refer to approved shop drawings to determine whether the application requires steel reinforcement.
- B. Cut steel reinforcement channel, P1437, 4" shorter than mullion length or as indicated on shop drawings. Paint ends to prevent rust.
- C. Insert steel into the mullion as shown in **Fig. 32.1**. Align and center the steel with mullion, then drill .213" diameter holes through the mullion and steel at 16" O.C.
- D. Drill and clear hole for a #10 x 1/4" flat head countersunk fastener (not by Tubelite) at 16" on center or as specified on shop drawings. Grind down the fasteners inside the glass pocket when installed as shown.

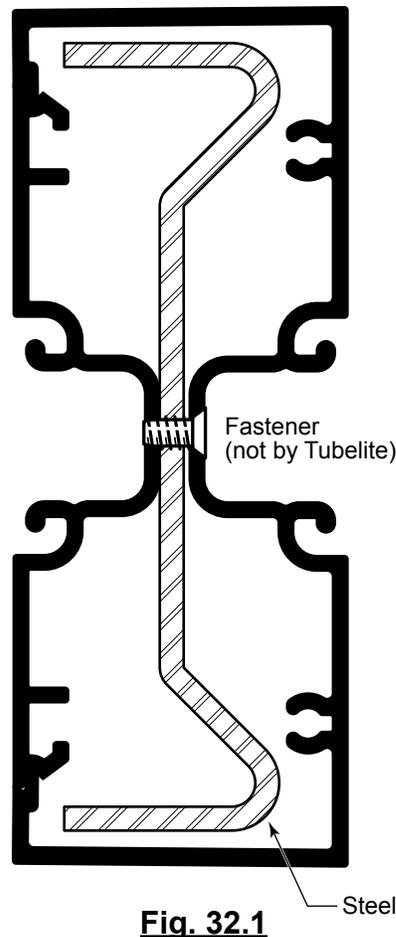


Fig. 32.1

FRAME INSTALLATION

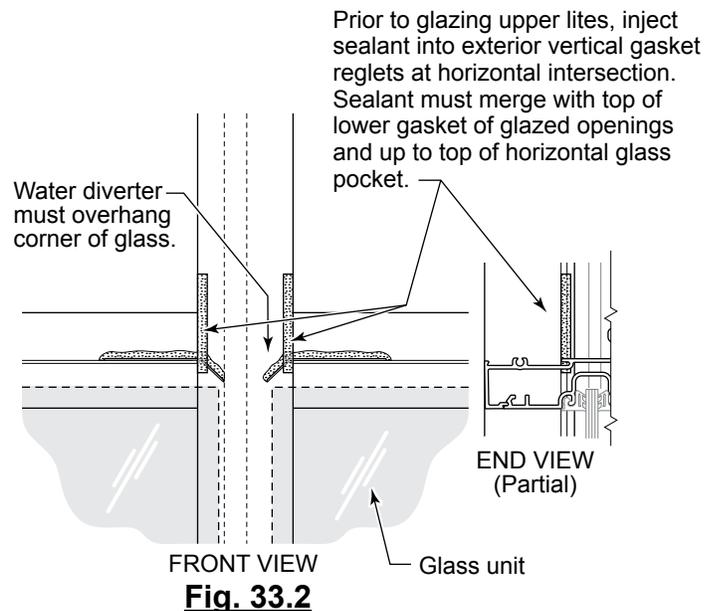
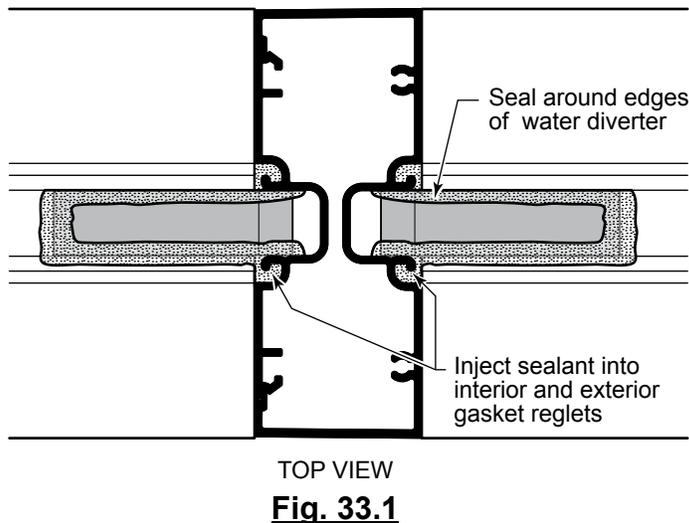
Step 15: Attach Frame to Structure

- A. Install shims at head and jambs and ensure frames are installed plumb and true. Use a snap-in anchor support (P1745) to provide back-up support for shimming.
- B. Attach the jambs and head to the perimeter of the opening with suitable fasteners. Perimeter anchors should be located within 6" of each side of the vertical mullion.

Note: This is for general erection procedures only. For actual job conditions, refer to shop drawings for appropriate fastener and hole location as determined by a qualified engineer or consult the project design professional.

Step 16: Install Water Diverters (For Exterior Application Only)

- A. Use a solvent and a clean cloth to clean the surfaces of the horizontals where water diverters will be installed. Also clean the vertical reglets on both sides to at least 1" above the gasket reglets on the horizontal member.
- B. When the surfaces are dry, butter the underside of the water diverter (P878) with sealant and press the diverter to the horizontal in the glazing pocket as shown in **Fig. 33.1**.
- C. Pump sealant into both vertical gasket reglets, and seal the edges of the diverter on all sides EXCEPT the edge facing the pocket as shown in **Fig. 34.1** on Page 34. You must avoid getting sealant in this area in order to allow the system to drain.
- D. Seal the joint between the vertical and horizontal members from the diverter to the top of the horizontal gasket reglet.
- E. Cap seal fastener heads and embed water diverter in sealant.



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. 33.1 & 33.2**.

(Also see isometric details on page 34)

GLAZING

Step 16: Install Water Diverters (continued)

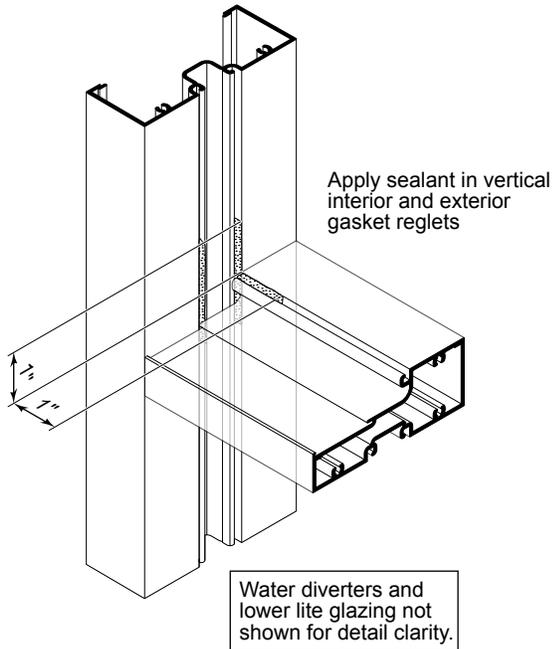


Fig. 34.1

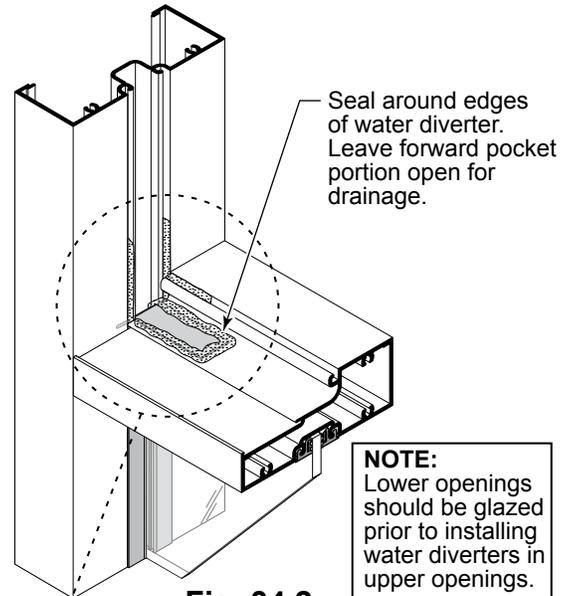


Fig. 34.2

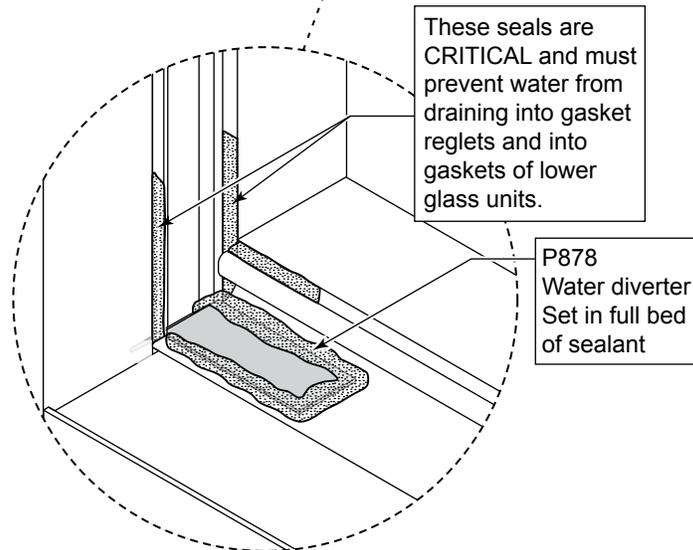


Fig. 34.3

GLAZING

1. All glazing pockets are 11/16" wide, and will accept glazing up to and including 3/8" thick, dry glazed.
2. Glass dimensions should not be less than daylight opening (D.L.O.) plus 5/8", except when using E4540 horizontal/sill, in which glass size is D.L.O. plus 9/16" as shown in **Fig. 35.1**. This formula does not take into account out-of-square openings or glass tolerances. Consult the glass manufacturer before determining final glass sizes.
3. When cutting gaskets, add 1/16" to 1/8" per foot of daylight opening for shrinkage (an eighth of an inch per foot is approximately 1%). Open, unsealed gasket joints are a potential source of leakage and water damage to interior finishes.
4. When installing gaskets, start at the center of D.L.O. and work towards the ends. **DO NOT STRETCH GASKETS WHEN INSTALLING.**

GLASS SIZE CALCULATION

$$\text{Width tolerance} = + 0", - 1/16"$$

Typical Framing:

$$\text{Glass Size} = \text{D.L.O.} + 5/8"$$

Framing With E4540 Horizontal/Sill:

$$\text{Glass Size} = \text{D.L.O.} + 9/16"$$

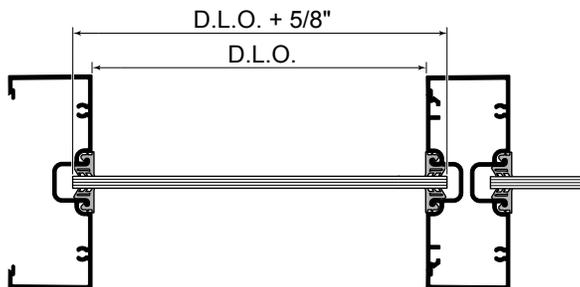
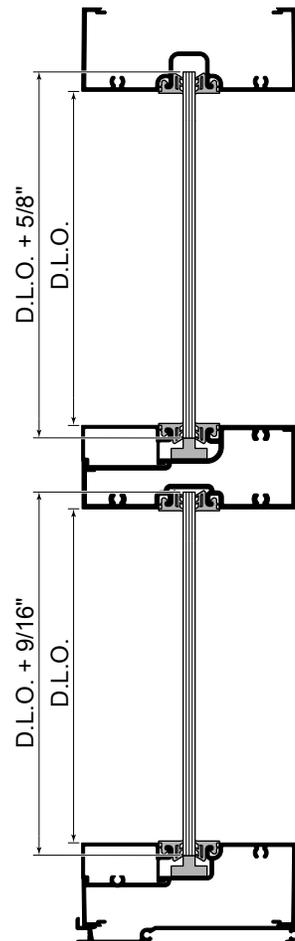


Fig. 35.1



NOTE: Glass dimensions should not exceed daylight opening (D.L.O.) plus 5/8", except when using the E4540 horizontal/sill, in which glass size is D.L.O. plus 9/16".

GLAZING

Step 17: Cut and Install Interior Gaskets

- A. Cut the interior gaskets.
- B. Install gaskets on the side of frame opposite glass stop first.
- C. Apply sealant in the gasket reglet for 1" from the intersection of the vertical member.
- D. Install the interior vertical gaskets, at each end and work toward the center, firmly pushing the gasket in place, as shown in **Fig. 36.1**.
- E. Apply sealant in the gasket reglet for 1" from the intersection of the horizontal member.
- F. Install the interior horizontal gaskets at each end and work toward the center, firmly pushing the gasket in place as shown in **Fig. 36.2**.
- G. Apply sealant at the intersection to marry the vertical and horizontal glazing gaskets. Tool all sealant to present a neat, clean appearance.

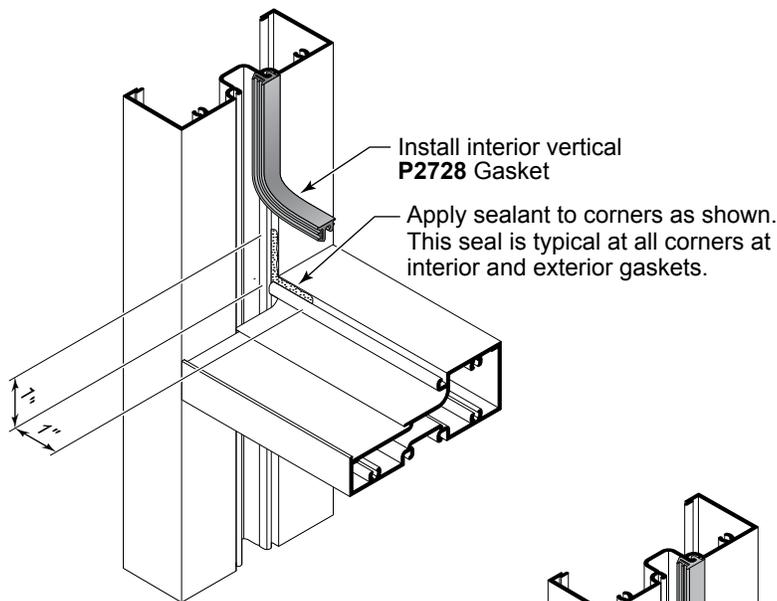


Fig. 36.1

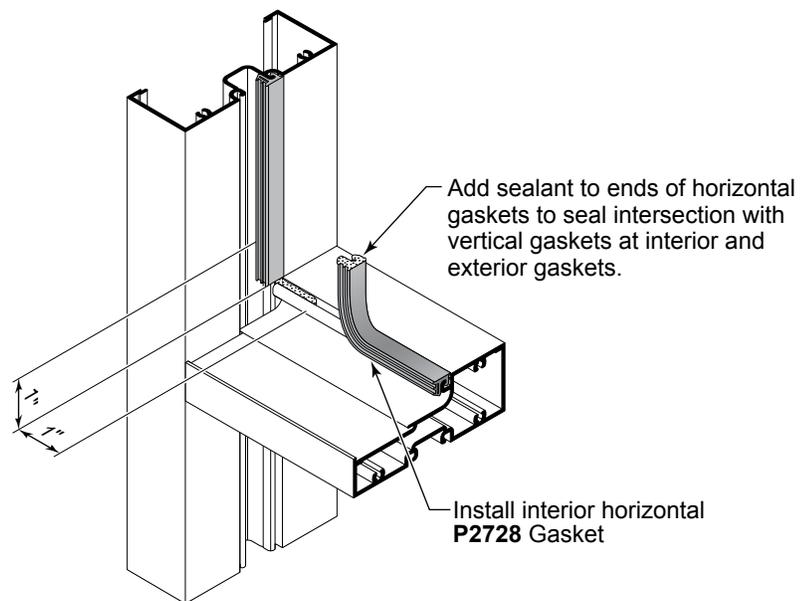


Fig. 36.2

GLAZING

Step 18: Install the Glass

- A. Position the glass in the frame.
- B. Raise the glass off the horizontal, and place a setting block at each quarter point (two setting blocks per light) or as required by project.
- C. Lower the glass on the setting blocks as shown in **Fig. 37.1**.
- D. Consult glass manufacturer about setting blocks if glass size is more than 40 square feet.

Step 19: Install Glass Stop

- A. Install the glass stop into the horizontal after the glass has set, as shown in **Fig. 37.2**.

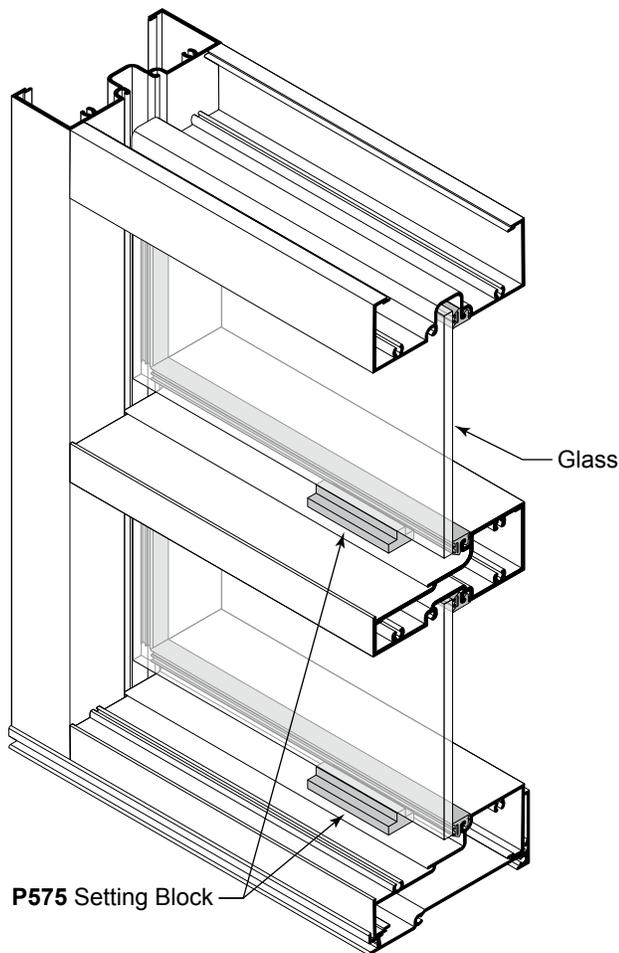


Fig. 37.1

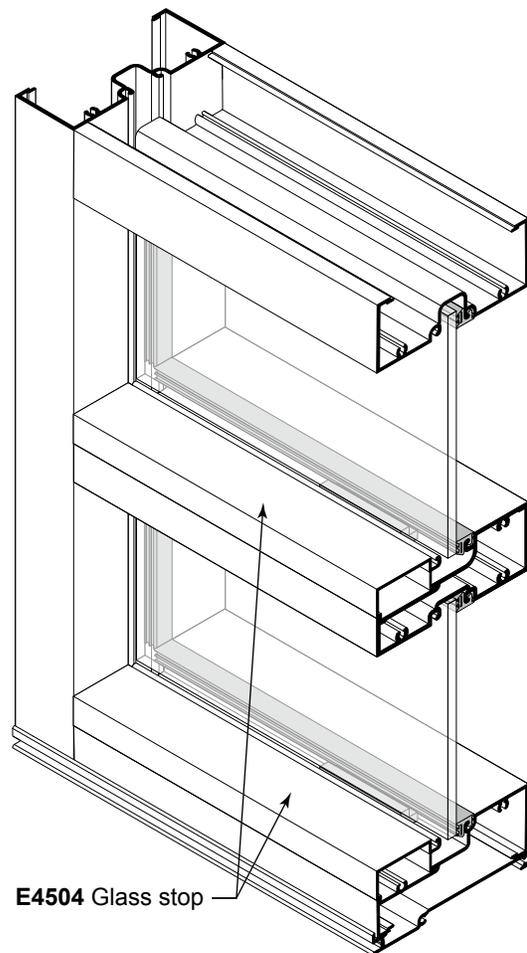


Fig. 37.2

GLAZING

Step 20: Cut and Install the Exterior Gaskets

- A. Cut the exterior vertical gaskets.
- B. Apply sealant in the gasket reglet for 1" from the intersection of the vertical member.
- C. Install the exterior vertical gaskets at each end and work toward the center, firmly pushing the gasket in place, as show in **Fig. 38.1**.
- D. Cut the exterior horizontal gaskets.
- E. Apply sealant in the gasket reglet for 1" from the intersection of the horizontal member.
- F. Install the exterior horizontal gaskets, at each end and work toward the center, firmly pushing the gasket in place, as show in **Fig. 38.2**.

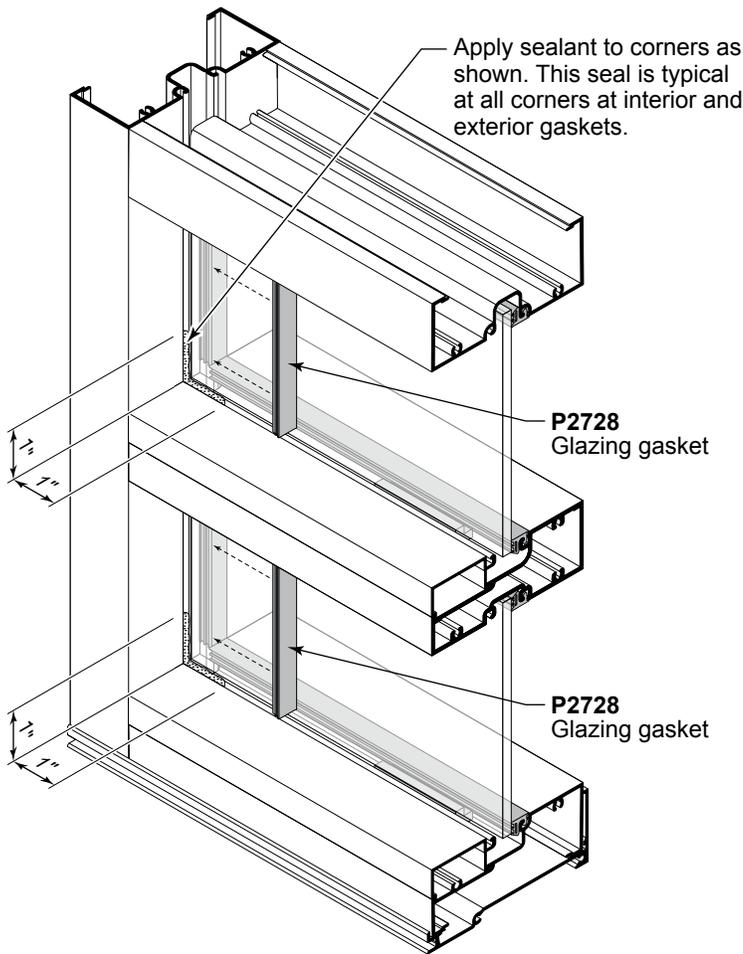


Fig. 38.1

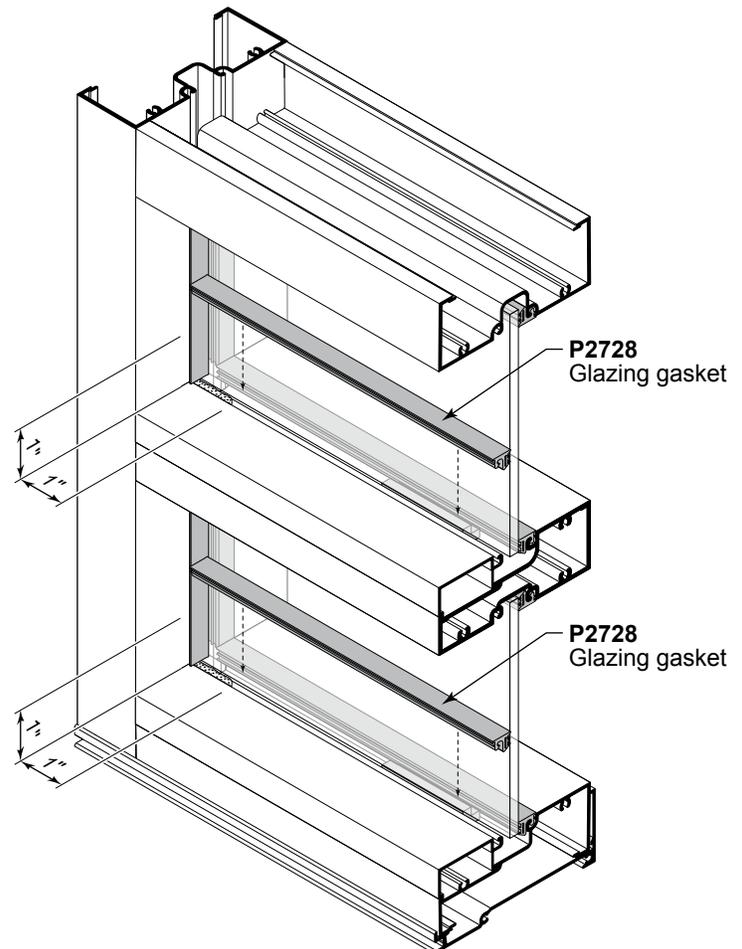


Fig. 38.2

GLAZING

Step 21: Seal Perimeter of Installation

- A. The primary, critical seal location is at the interior leg of the framing members, including the interior leg at the bottom of the sill flashing.
- B. Insert backer rod into the gap between the frame and the building substrate on top, sides and bottom of the installation as shown in **Fig. 39.1**.
- C. Apply sealant to fill the void.
- D. Tool the sealant smooth.

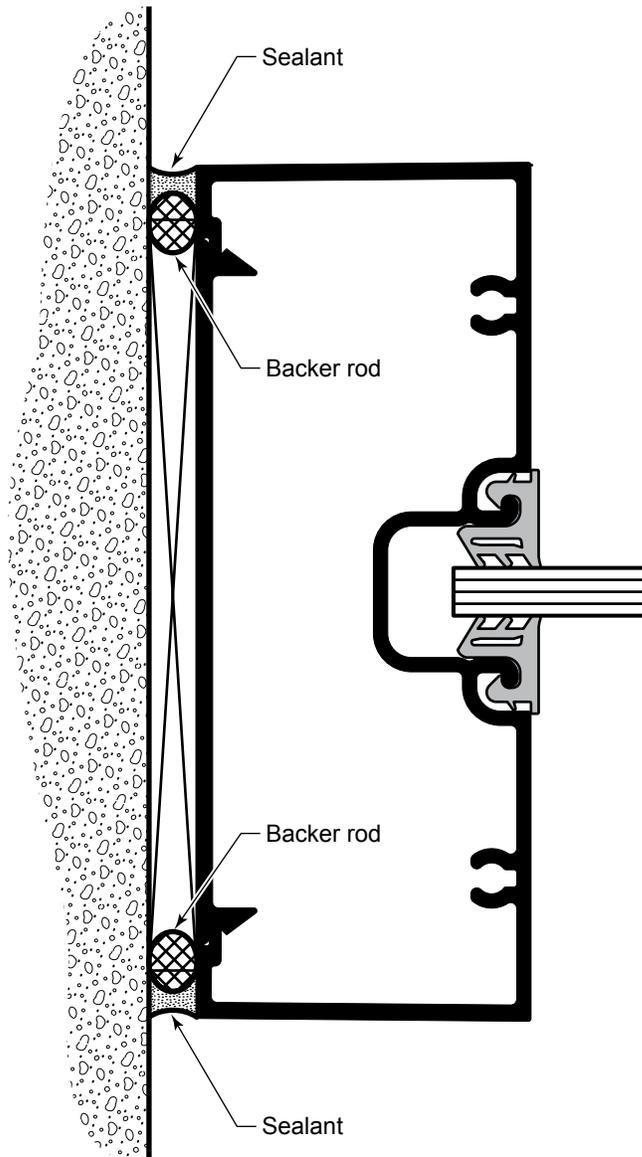


Fig. 39.1

CORNER CONDITIONS

Note: 90 degree corners can be made with combinations of E45110, E45108, E45109 and E45111.

Step 1: Assemble Corner Members & Horizontals

- A. Assemble corner members, sealing where they intersect.
- B. Assemble horizontals to E45108 with a shear block and E45109 using the screw splines as shown in **Fig. 40.1**.
- C. Seal where the horizontals meet the corner assembly.

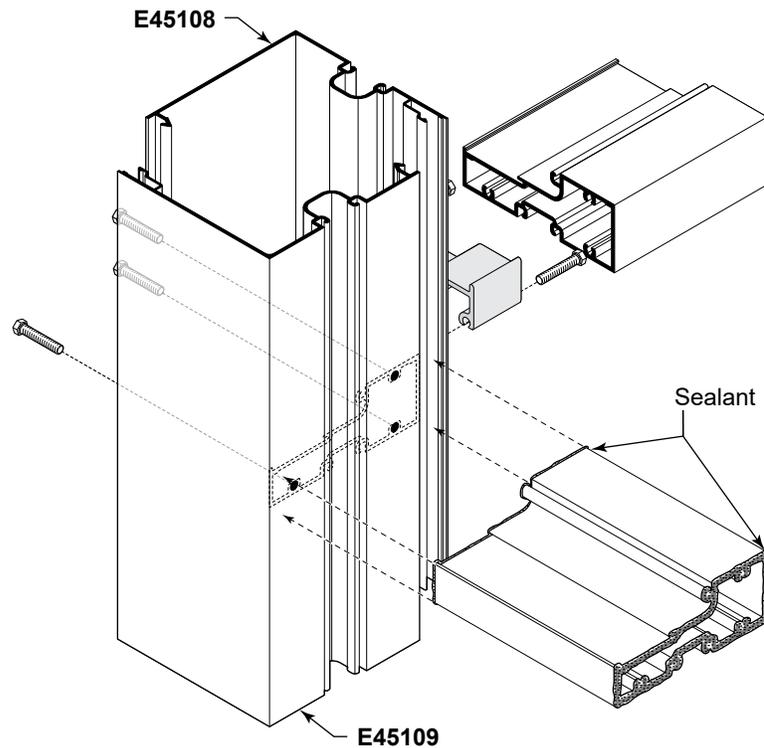


Fig. 40.2

CORNER CONDITIONS

Step 2: Install Interior Gaskets

- A. Install interior gaskets at corner assembly as shown in Fig. 41.1.

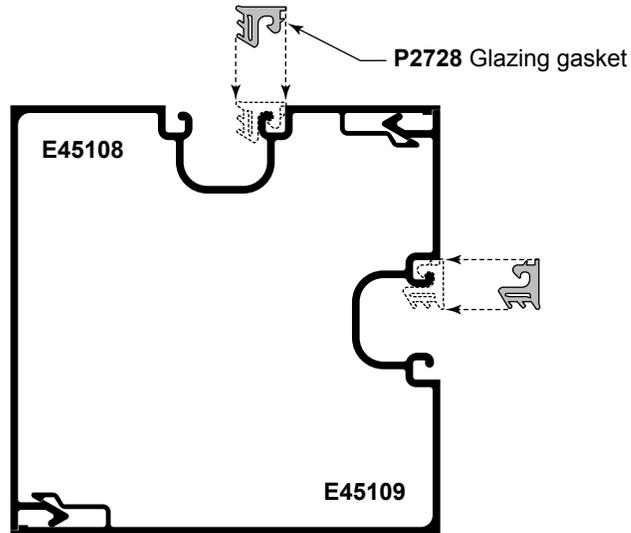


Fig. 41.1

Step 3: Set Glass

- A. Install the glass as shown in Fig. 41.2.

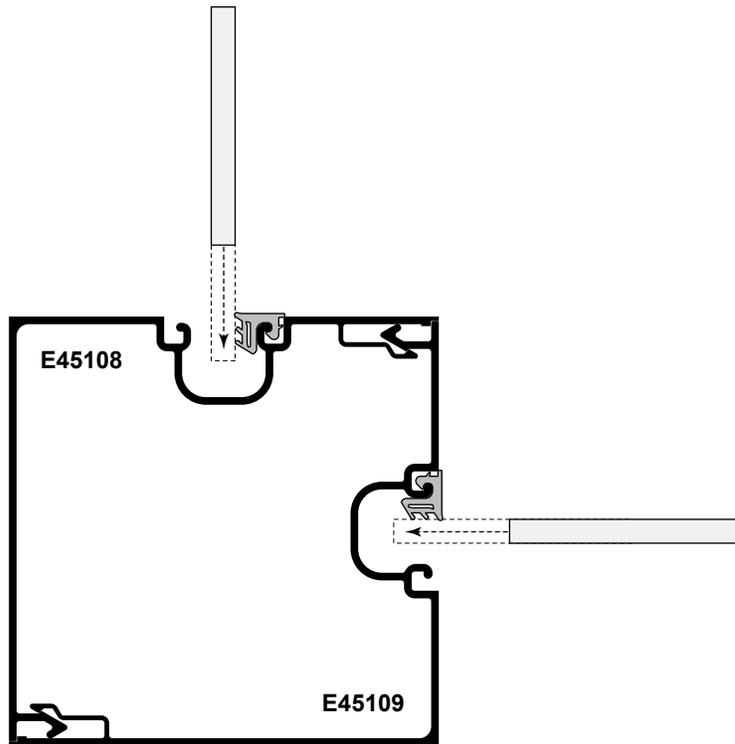


Fig. 41.2

CORNER CONDITIONS

Step 4: Install Exterior Gaskets

A. Install exterior gaskets at corner assembly as shown in **Fig. 42.1**.

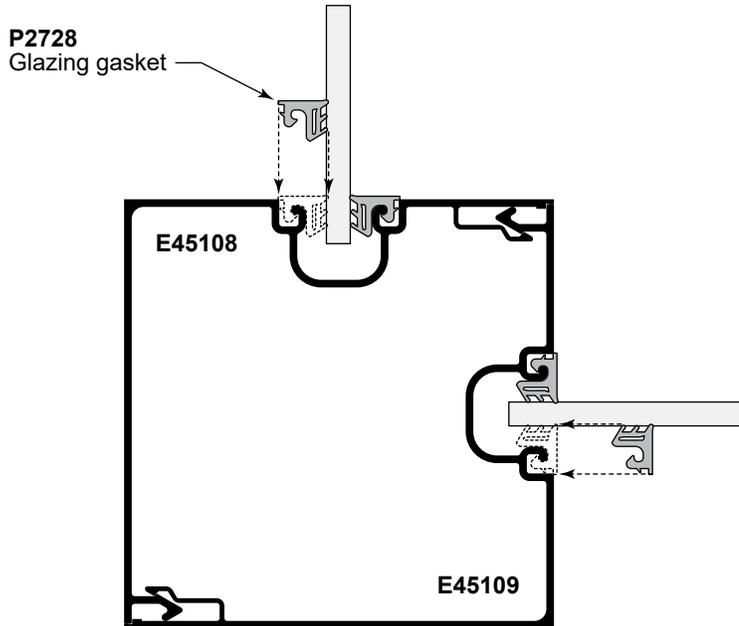


Fig. 42.1

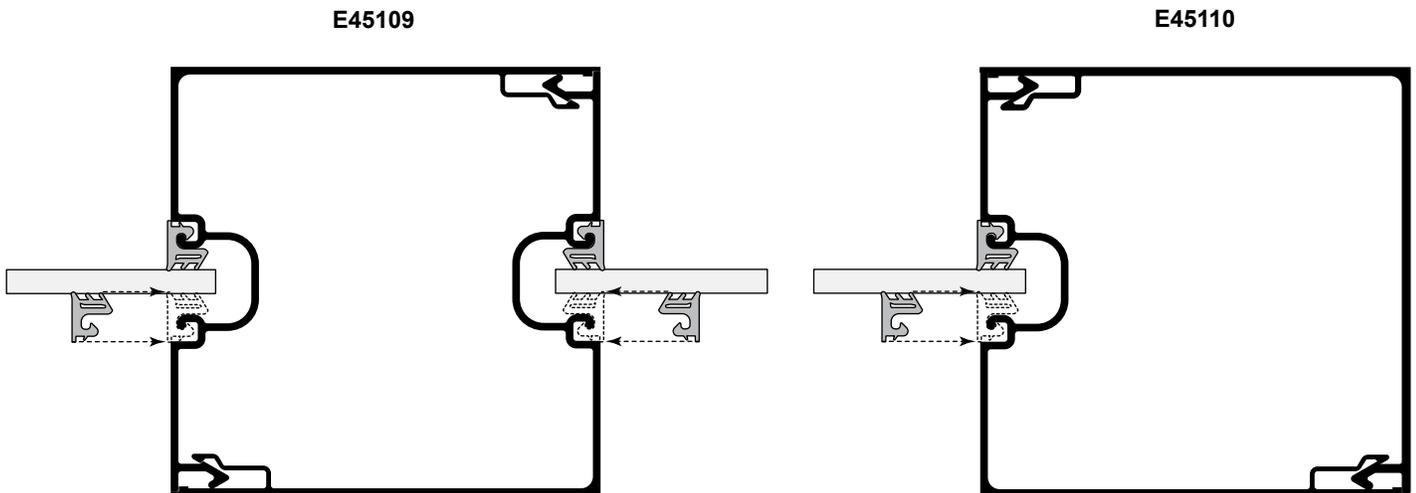


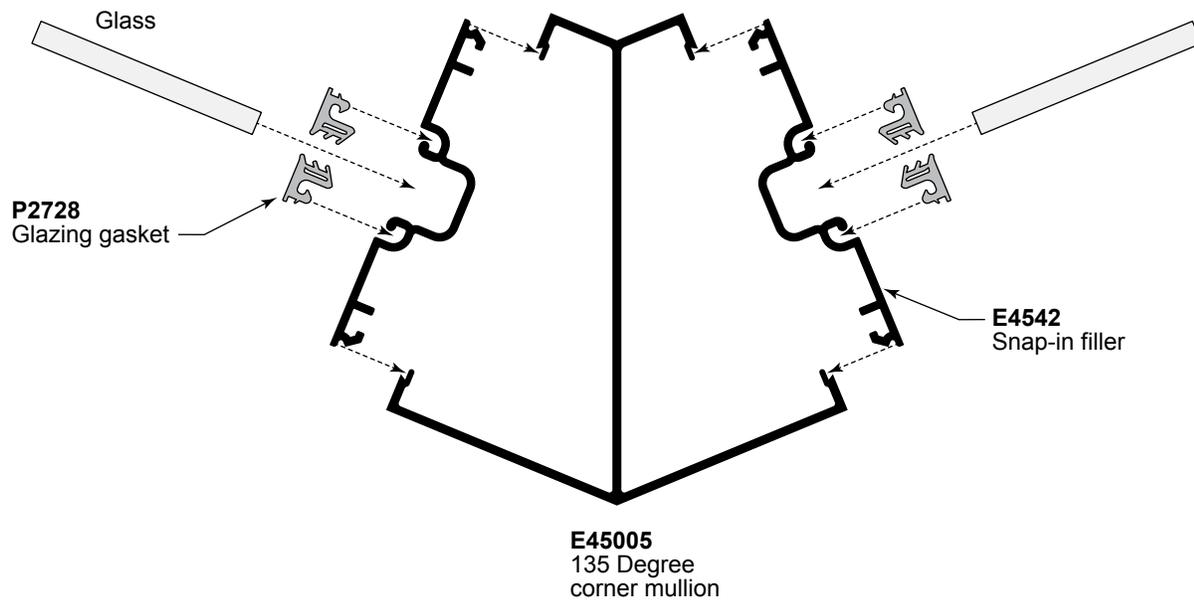
Fig. 42.2

Fig. 42.3

135 DEGREE CORNER ASSEMBLY

Assembly

- A. Install a pair of snap-in fillers (E4542) to the 135 degree corner mullion (E45005).
- B. Seal the joints where the two intersect.
- C. Install the interior glazing gaskets (P2728) to the deep pocket closures.
- D. Set the glass.
- E. Install the exterior glazing gaskets to the deep pocket closures.



ROTATIONAL MULLION ASSEMBLY

Assembly

- A. Install a pair of outer rotational mullions (E45246) to the inner rotational mullion (E14247). Attach using four wiper gaskets (P1221).
- B. Attach interior glazing gaskets (P2728) to the outer rotational mullions.
- C. Set the glass.
- D. Attach exterior glazing gaskets to the outer rotational mullions.

