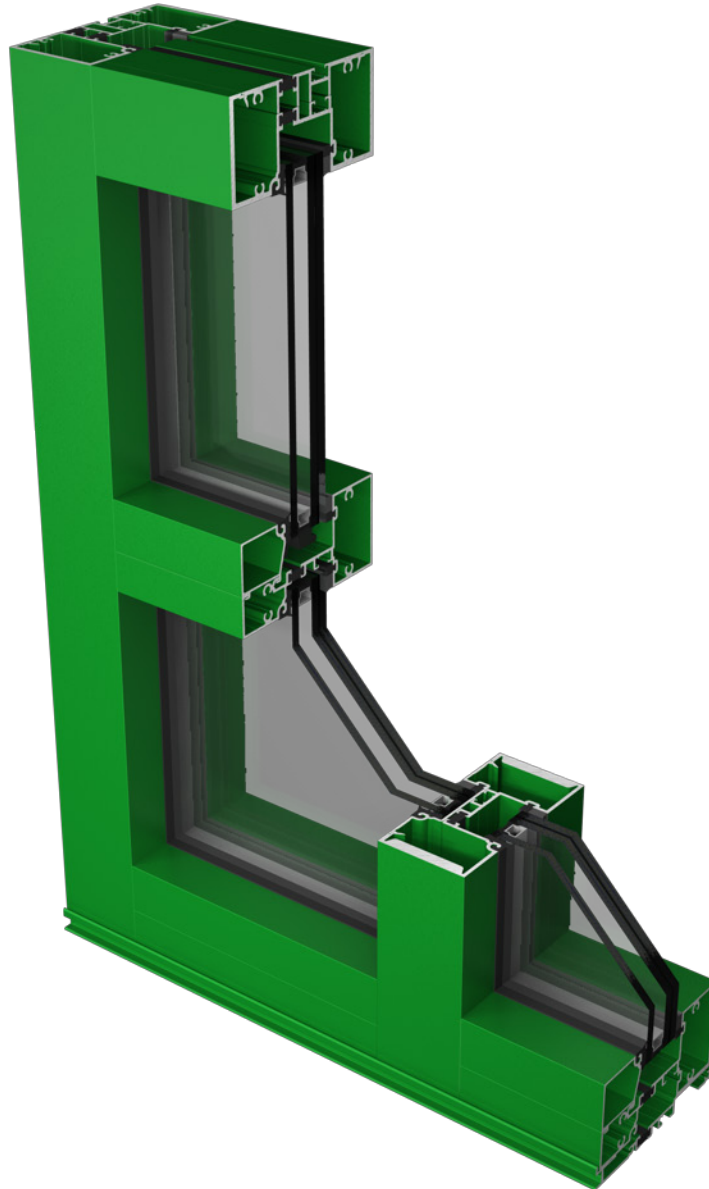


# TUBELITE®

**DEPENDABLE**

LEADERS IN ECO-EFFICIENT STOREFRONT,  
CURTAINWALL AND ENTRANCE SYSTEMS



**34000 SERIES STOREFRONT  
HURRICANE IMPACT**

## INSTALLATION INSTRUCTIONS

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



# TABLE OF CONTENTS

**GENERAL CONSTRUCTION NOTES.....5**

**PARTS LIST ..... 6-13**

**QUICK REFERENCE CHECKLIST ..... 14**

**ELEVATION DETAILS ..... 15-17**

**FRAME FABRICATION**

    Step 1 Determine Frame Size ..... **18**

    Step 2 Cut Material to Length ..... **18**

    Step 3 Sill Flashing ..... **19**

    Step 4 Closure Plates ..... **19**

    Step 5 Verticals & Closure Pockets for Horizontals ..... **19**

    Step 6 Head & Sill ..... **20**

    Step 7 Jamb ..... **20**

    Step 8 Steel Stiffener ..... **21**

**FRAME ASSEMBLY**

    Step 9 Sill Flashing End Dams ..... **22**

    Step 10 Assemble Frames ..... **23**

    Step 11 Gasket Installation ..... **24**

    Step 12 Sill Flashing Installation ..... **24**

    Step 13 Sill Flashing Splice ..... **25**

**FRAME INSTALLATION**

    Step 14 Install Frames ..... **26-28**

**GLAZING**

    Step 15 Glazing Preparation ..... **29**

    Step 16 Installing Glazing Units ..... **29**

    Step 17 Wet Glazing ..... **30**

**DOOR & FRAME INSTALLATION**

    Step 18 Preparation ..... **31**

    Step 19 Door Frame Assembly ..... **31-32**

    Step 20 Door Frame Installation ..... **33**

    Step 21 Door Installation ..... **33**

    Step 22 Transom Sash Installation ..... **34**

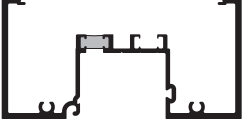
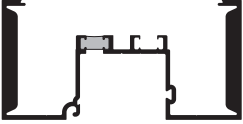
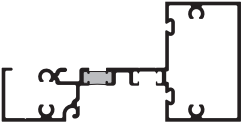
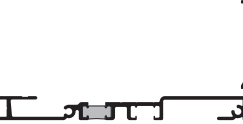


    Step 23-24 Door Glazing ..... **35-36**



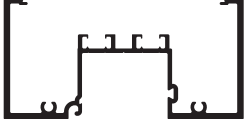
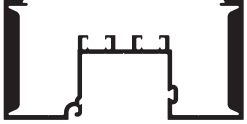
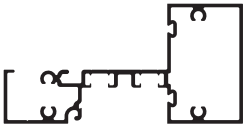





## GENERAL CONSTRUCTION NOTES

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. 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.
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. Fasteners attaching framing to building structure are typically not provided by Tubelite.
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 the sealant manufacturer for recommendations relative to shelf life, compatibility, cleaning of substrate, priming, tooling adhesion, etc. Recommend sealant manufacturer perform adhesion "pull test" at "wet" glazing for quality assurance.
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 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 1/4" may be subject to failure. Consult the sealant manufacturer for proper sizing of joints.
12. 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.
13. 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.
14. Cleaning of exposed aluminum surfaces should be done per AAMA recommendations.
15. Check [www.tubeliteinc.com](http://www.tubeliteinc.com) for any installation instruction updates.




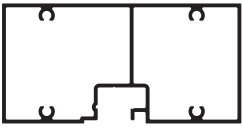
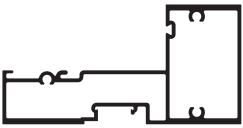



## THERMAL EXTRUSIONS

| SHAPE  | DESCRIPTION   | PART No. |
|--|---|----------|
|   | Jamb, Vertical and Head   | T34441   |
|   | Heavy Wall Vertical   | T34261   |
|   | Horizontal and Sill   | T34143   |
|    | Sill Flashing   | T34259   |
|  <p data-bbox="87 1262 402 1291">(Do not use at door jambs)</p> | Shallow Closure Pocket (Slotted)<br>Use only E34445 or E34022 closure pockets at door jambs | T34445   |
|   | Snap-In Filler<br>at Head and Wall Jamb   | T34442   |

## NON-THERMAL EXTRUSIONS








| SHAPE   | DESCRIPTION   | PART No. |
|---|---|----------|
|    | Jamb, Vertical and Head   | E34441   |
|    | Heavy Wall Vertical   | E34261   |
|    | Horizontal and Sill   | E34143   |
|   | Sill Flashing   | E34259   |
|  | Deep Closure Pocket<br>(Only required in door jamb when two door frames occur within elevation) | E34022   |
|  | Shallow Closure Pocket<br>(Standard)  | E34445   |
|  | Snap-In Filler<br>at Head and Wall Jamb   | E34442   |
|  | Glass Stop at Horizontal,<br>Sill and Door Header   | E34104   |

## DOOR FRAME EXTRUSIONS

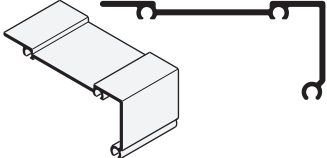
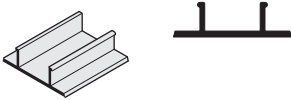






| SHAPE   | DESCRIPTION  | PART No. |
|---|--|----------|
|    | Snap-In Filler at Door Jamb  | E34242   |
|    | Standard Door Jamb<br>(Use only non-thermal closure pockets at door jambs)   | E34144   |
|    | Heavy Duty Door Jamb<br>(Use only non-thermal closure pockets at door jambs) | E34244   |
|   | Door Header<br>(Without Transom)   | E34224   |
|  | Door Header<br>(With Transom)  | E34124   |
|  | Door Header<br>at OHCC Closer<br>(Use P4441 Shear Clip)                      | E34125   |
|  | Horizontal Transom Gutter<br>(OHCC Door Header)<br>Wet glazing required      | E34006   |
|  | Transom Glass Stop<br>(Use with E34006)                                      | E6644    |







## DOOR FRAME EXTRUSIONS

| SHAPE   | DESCRIPTION   | PART No. |
|---|---|----------|
|    | Vertical Gutter<br>(Use at Standard and Heavy Duty Door Jamb)<br>Wet glazing required | E3521    |
|    | Transom Stop<br>(Use with E3521)  | E3522    |
|    | Inner Door Stop<br>(Use with E6505 Door Stop)   | E6507    |
|   | Outer Door Stop<br>(Use with E6507 Inner Door Stop)                                   | E6505    |
|  | Door Stop Channel<br>(Use with E2298 Door Stop)                                       | E6504    |
|  | Door Stop<br>(OHCC Door Header)   | E2298    |
|  | Door Threshold<br>(Use with P3450 Bulb Gasket)  | E3550    |

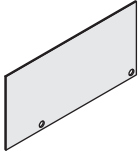
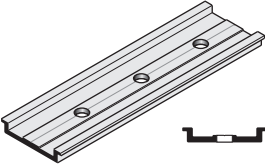
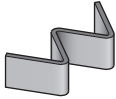
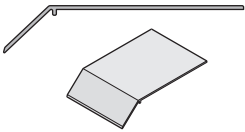
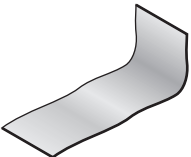
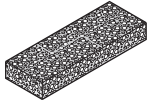


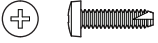
## ACCESSORIES

| SHAPE   | DESCRIPTION  | PART No.                                 |
|---|--|--|
|     | <p style="text-align: center;">Shear Clip<br/>(Use with E34125 Door Header)</p>                  | <p style="text-align: center;">P4441</p> |
|    | <p style="text-align: center;">Filler Plate<br/>(Mates with E34124/E34224 at Door Stop Ends)</p> | <p style="text-align: center;">P503</p>  |
|    | <p style="text-align: center;">Setting Block<br/>at Horizontal, Sill and Transom</p>             | <p style="text-align: center;">P6541</p> |
|   | <p style="text-align: center;">Typical Exterior Gasket</p>                                       | <p style="text-align: center;">P6503</p> |
|  | <p style="text-align: center;">Interior Gasket<br/>for Dry Glaze System</p>                      | <p style="text-align: center;">P6586</p> |
|  | <p style="text-align: center;">Interior SSG Spacer Gasket<br/>for Wet Glaze System</p>           | <p style="text-align: center;">P6587</p> |
|  | <p style="text-align: center;">Door Stop Bulb Gasket</p>   | <p style="text-align: center;">P6296</p> |
|  | <p style="text-align: center;">Steel Reinforcement Channel<br/>1¼" X 4¼" X 10 ga</p>             | <p style="text-align: center;">P3437</p> |





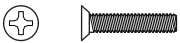



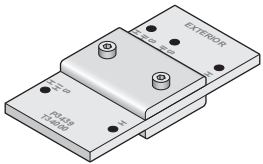
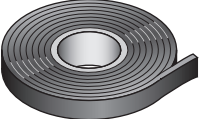
## ACCESSORIES

| SHAPE   | DESCRIPTION  | PART No. |
|---|--|----------|
|    | 3" Long Thermal Snap-In Filler at Head and Jamb                    | P3445T   |
|   | 9" Long Thermal Snap-In Filler at Head and Jamb                    | P3446T   |
|    | 3" Long Non-Thermal Snap-In Filler at Head and Jamb                | P3445    |
|   | 9" Long Non-Thermal Snap-In Filler at Head and Jamb                | P3446    |
|  | 3" Long Optional Thermal Snap-In Strap Anchor at Head and Jamb     | P3431T   |
|   | 9" Long Optional Thermal Snap-In Strap Anchor at Head and Jamb     | P3432T   |
|  | 3" Long Optional Non-Thermal Snap-In Strap Anchor at Head and Jamb | P3431    |
|   | 9" Long Optional Non-Thermal Snap-In Strap Anchor at Head and Jamb | P3432    |

## ACCESSORIES

| SHAPE   | DESCRIPTION   | PART No. |
|---|---|----------|
|    | End Dam<br>(Use at E34259 and T34259 Sill Flashing)   | P1156    |
|     | Sill Block<br>(Use at Sill Flashing Termination at Doors)   | P3426    |
|    | EPDM AntiWalk "W" Block<br>(Use at Deep Pockets on Verticals and Jambs)<br>for Dry Glazed Only                      | P1916    |
|   | Water Diverter<br>(Use at Intermediate Horizontals)   | P6581    |
|  | Silicone Splice Sleeve<br>(Use at E34259 and T34259 Sill Flashing)  | P3444    |
|  | Weep Baffle (Optional)<br>(Use at E34259 and T34259 Sill Flashing at each weep hole location)                       | PTB42    |
|  | Bulb Gasket<br>(Use at E3450 Threshold)   | P3450    |
|  | #10-24 X 1/2" PH<br>(Use at E6507 Inner Door Stop, E0190 Door Stop Angle,<br>Sill to Subsill and E3521 to Vertical) | S206     |
|  | #10-24 X 3/4" SS PH<br>(Use at E34006 Glass Stop Horizontal)  | S270     |

## ACCESSORIES

| SHAPE   | DESCRIPTION   | PART No.        |
|---|---|-----------------|
|    | #8-32 X 5/16" SS UC FH<br>(Use at E6504 Door Stop Channel)                                    | S131            |
|    | #12-24 X 5/8" Type 23 UC FH<br>(Use to attach the E34125 door header to the P4441 Shear Clip) | S286            |
|    | #12-24 X 1/2" SS UC FH<br>(Use at threshold attachment to door jamb clip)                     | S070            |
|    | #12-24 X 2" HWH<br>(Use at P4441 Shear Clip)  | S205            |
|   | #10-24 X 1" FH<br>(Use at Strap Anchor to Head/Jamb)  | S422            |
|  | #10-24 X 1/2" FH<br>(Use at Closure Pocket to Vertical)                                       | S161            |
|  | #12-14 X 1 1/2" HWH Self-Drilling, #3 pt<br>Frame Assembly Screw                              | S419            |
|  | #8 X 3/8" PH<br>(Use at Sill Flashing End Dam)  | S196            |
|  | Drill Fixture   | P3439           |
|  | Glazing Tape for Doors (Wet Glazed)<br>Tremco SGT921 One-Sided                                | Not<br>Included |

## QUICK REFERENCE CHECKLIST

1. Make sure the opening is square and the caulk joints are 1/2" minimum around the frame.
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 abutts 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 all transom conditions using E34006 and E3521 gutters are wet glazed only.**
17. Provide glazing tape (Tremco SGT921 One-Sided) for door glazing (Not Included).

## GLASS SIZE CALCULATION

Width tolerance = + 0", - 1/16"

### Typical Framing:

Glass Width = D.L.O. plus 1 1/4"

Glass Height = D.L.O. plus 1 1/4"

### Transoms with Sash:

Glass Width = D.L.O. plus 1 1/4"

Glass Height = D.L.O. plus 1 1/4" (Ref. Fig. 14.1)

### Entrance Doors (Single):

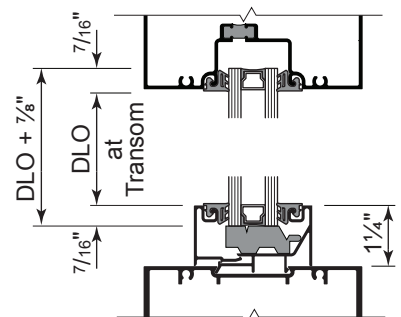
Glass Width = Door Opening minus 9 1/4"

Glass Height = Door Opening minus 15 5/8"

### Entrance Doors (Pair):

Glass Width = (Door Opening minus 18 1/2") / 2

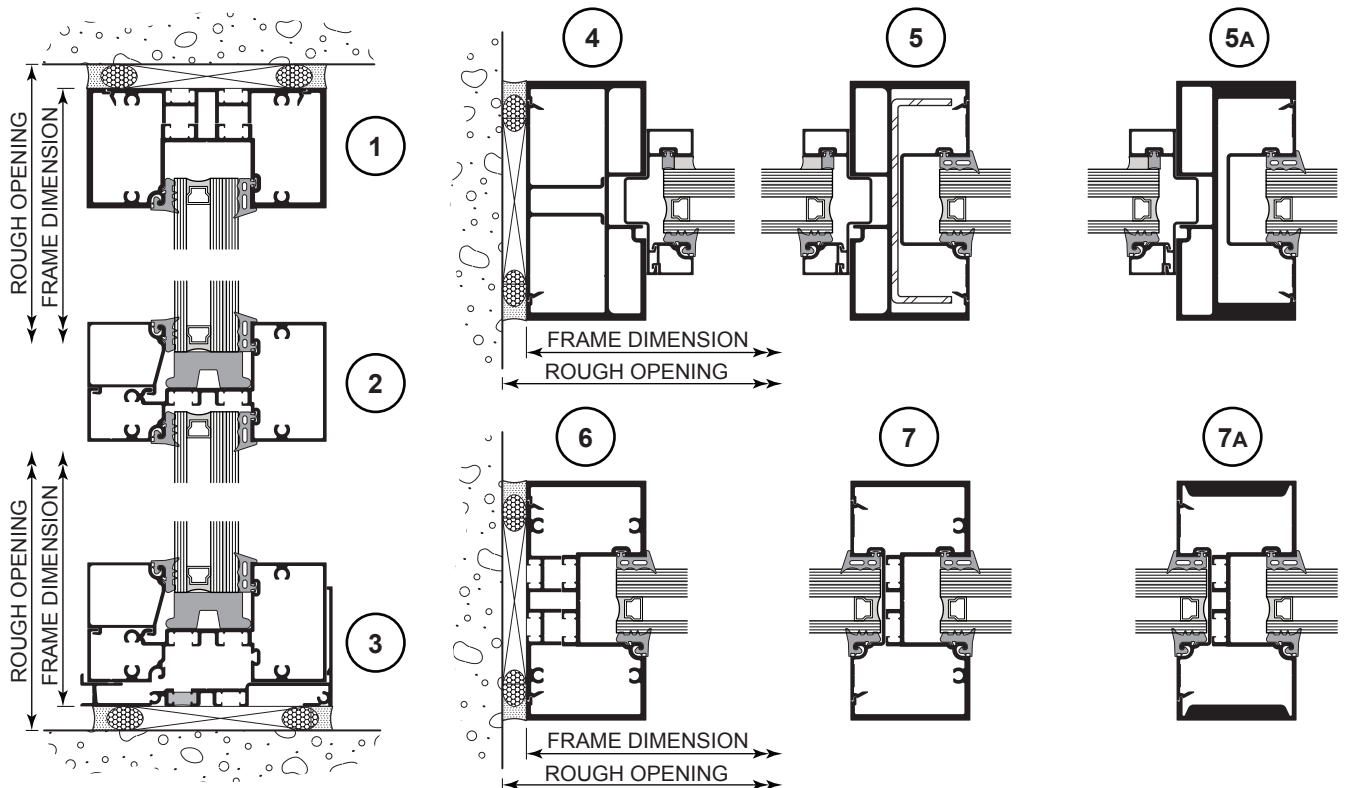
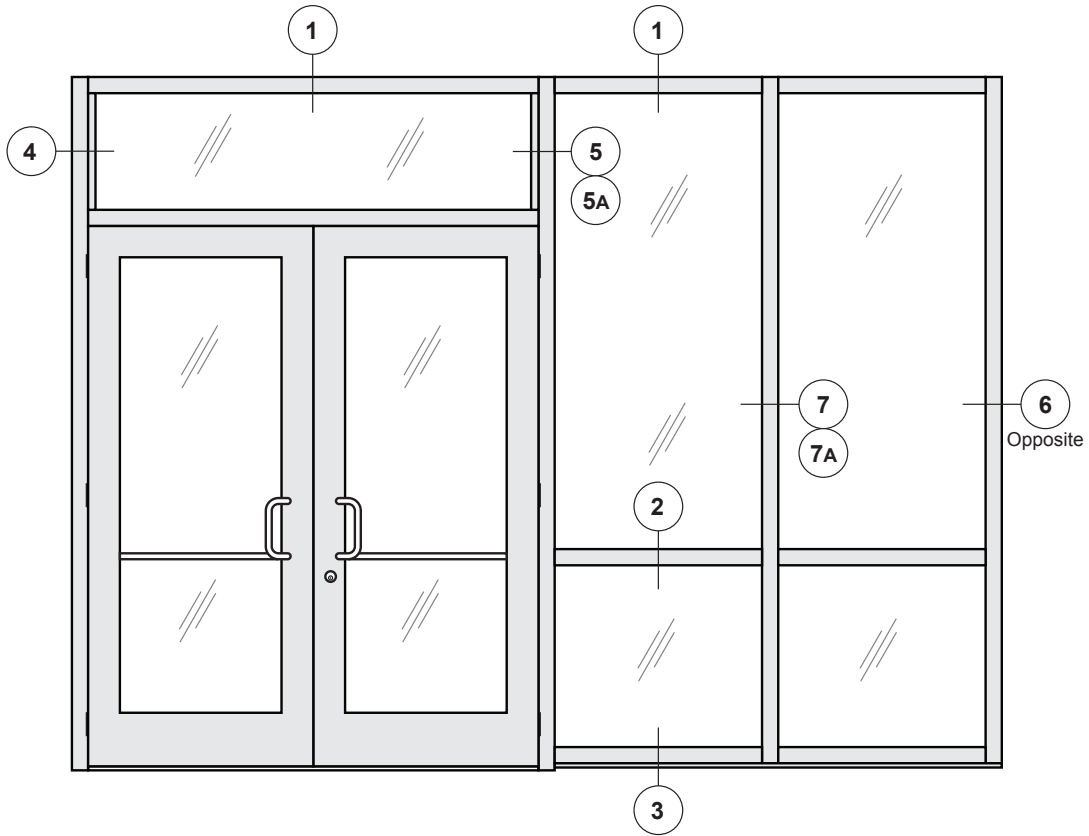
Glass Height = Door Opening minus 15 5/8"



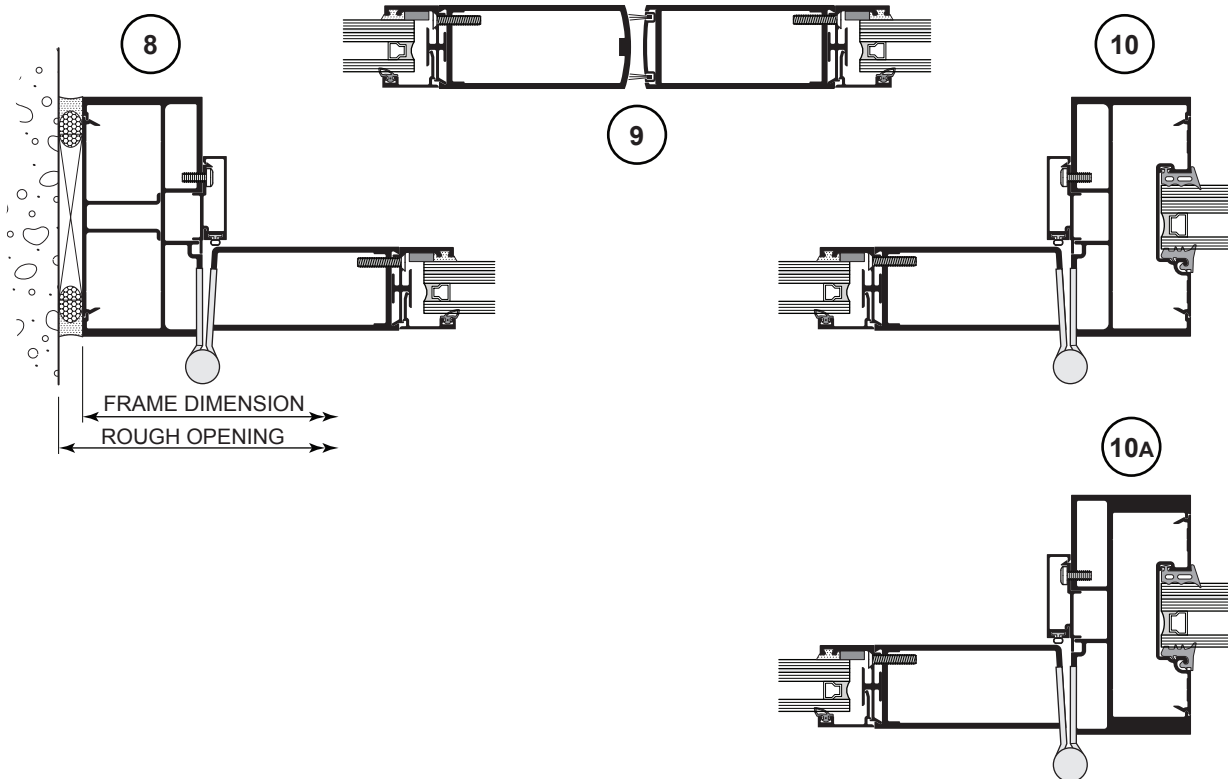
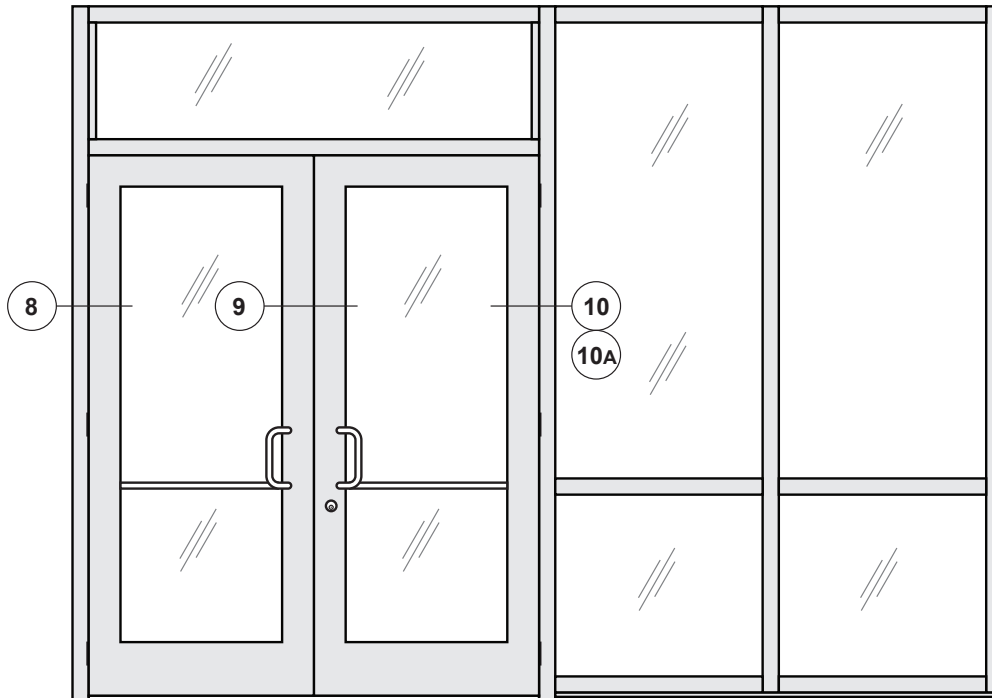
VERTICAL D.L.O. at SASH  
**Fig. 14.1**

## ELEVATION DETAILS

Dry glazed shown; wet glazed similar

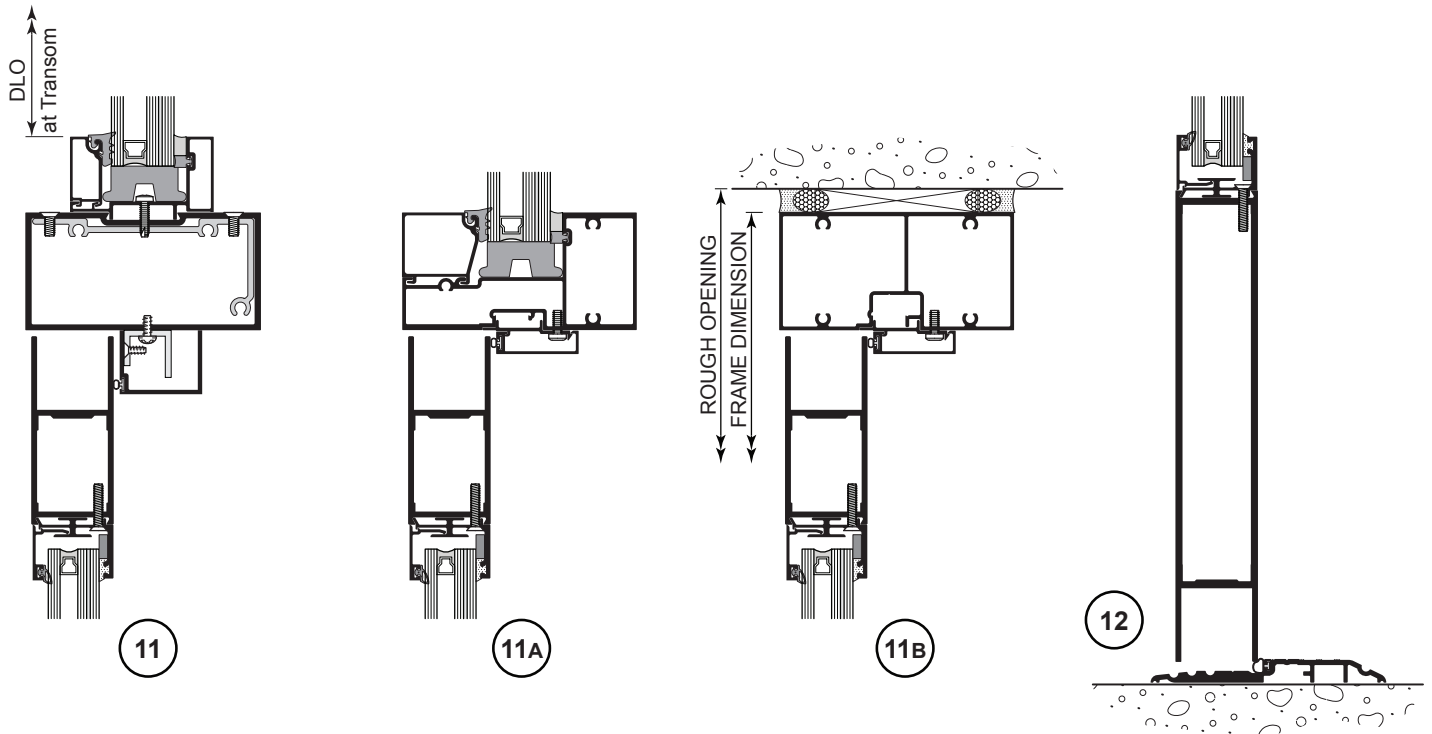


## ELEVATION DETAILS





## ELEVATION DETAILS



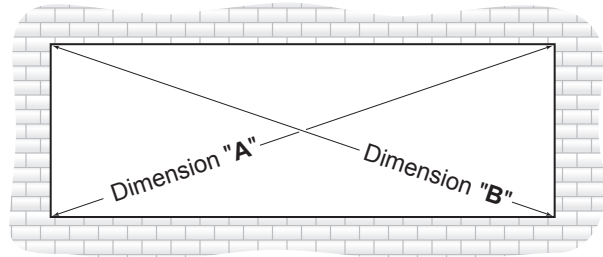
## FRAME FABRICATION

**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

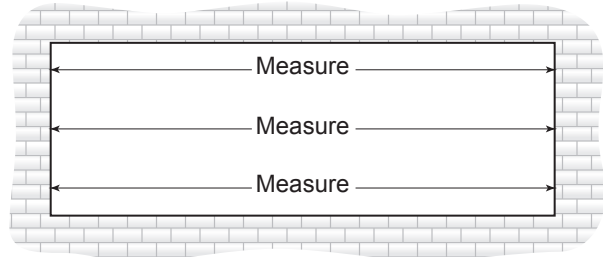
#### Frame Width

- A. Make sure the opening is square and plumb. Measure each diagonal of the opening. **SEE Fig. 18.1.**



**Fig. 18.1** Dimension "A" = "B"

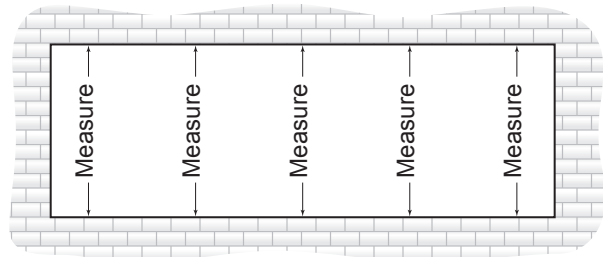
- B. Measure the width of the opening at the top, middle and bottom. Select the smallest of these dimensions and subtract the left and right caulk joint width per approved shop drawings (1/2" min at each jamb). **SEE Fig. 18.2.**



**Fig. 18.2**

#### 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 (1/2" min at head and 1/2" min at sill). **SEE Fig. 18.3.**



**Fig. 18.3**

### 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.

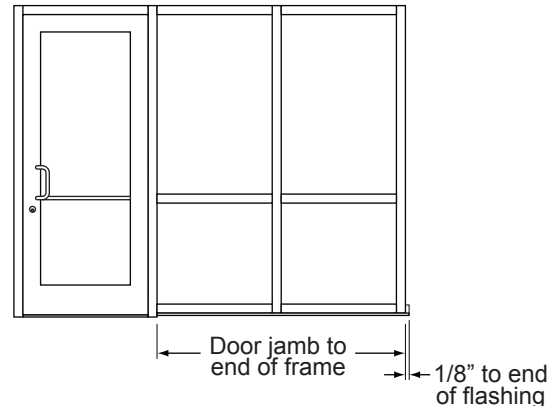
#### Framing Members

|                                      |                                  |
|--------------------------------------|----------------------------------|
| Sill Flashing with Entrance .....    | Door Jamb to End of Frame + 1/8" |
|                                      | <b>(SEE Fig. 18.4)</b>           |
| Sill Flashing without Entrance ..... | Frame Width + 1/4"               |
| Verticals .....                      | Frame Height - 1/2"              |
| Head, Horizontal & Sill .....        | D.L.O.                           |
| Horizontal & Sill Glass Stops .....  | D.L.O. - 1/32"                   |
| Closure Pockets at Verticals .....   | Frame Height - 1/2"              |
| Snap-in Fillers .....                | Refer to Approved Shop Drawings  |

#### Accessories

|                                 |   |
|---------------------------------|---|
| Exterior Gasket .....           | D.L.O. + Allowance*                     |
| Interior Dry Glaze Gasket ..... | D.L.O. + Allowance*                     |
| Interior SSG Spacer .....       | D.L.O. + 1/4" at Verticals + Allowance* |
|                                 | D.L.O. at Horizontals + Allowance*      |

\*Allowance = 1/8" extra length per foot of D.L.O.



**Fig. 18.4**

#### Sill Flashing Note:

For openings wider than 24', the sill flashing must be spliced at the centerline of a D.L.O. every twelve to fifteen feet. Splice joint should be 3/8" wide. **SEE Fig. 25.1 - Fig. 25.3** for sill flashing splice details.

## FRAME FABRICATION

### Step 3: Fabricate Sill Flashing

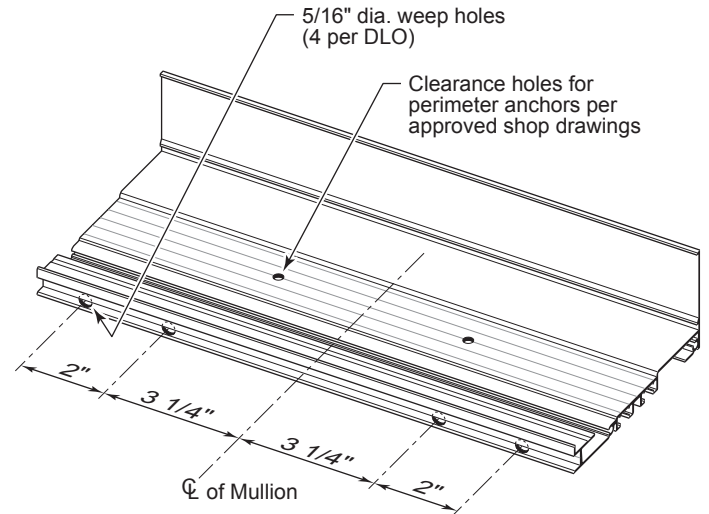
- Drill two 5/16" dia. weep holes at each side of the verticals. **SEE Fig. 19.1.**
- Drill clearance holes for perimeter anchors. Size and quantity vary per job. Refer to approved shop drawings.

### Step 4: Fabricate Closure Pockets

- Drill #7 (.201 dia) clear hole with countersink for a #10 FH screw 6" from ends and 1/4 points of closure pocket length. **SEE Fig. 19.2.** Verticals will be match drilled during installation of frame. See Step 14.H, page 28.

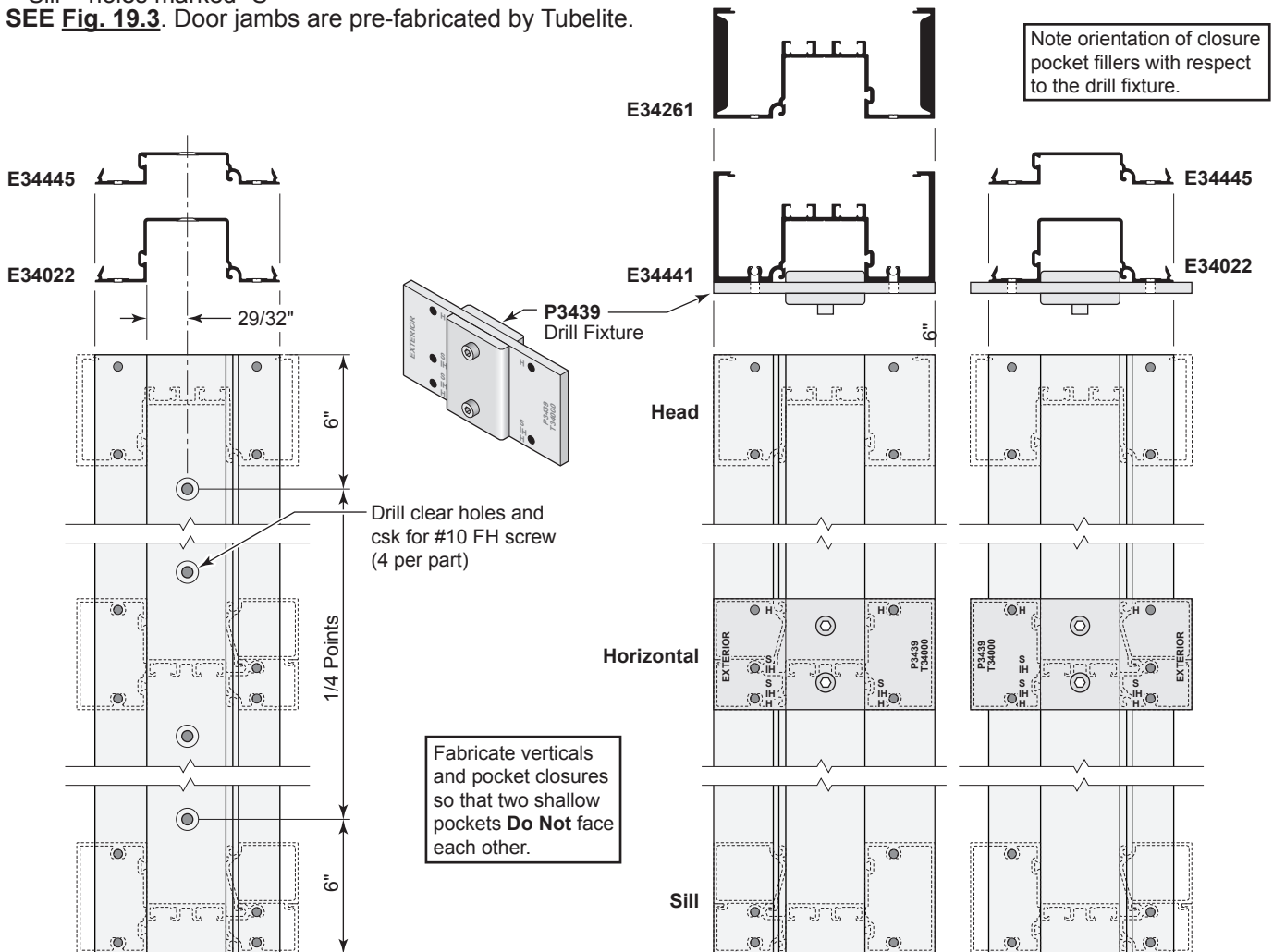
### Step 5: Fabricate Verticals & Closure Pockets for Horizontals

- Drill frame assembly holes in verticals, jambs & closure pockets with drill fixture **P3439**:  
Head = holes marked "H"  
Intermediate Horizontal = holes marked "IH"  
Sill = holes marked "S"  
**SEE Fig. 19.3.** Door jambs are pre-fabricated by Tubelite.



**NOTE:**  
At jamb member, locate (2) weep holes at 3/4" from jamb and 2" O.C.

**Fig. 19.1**



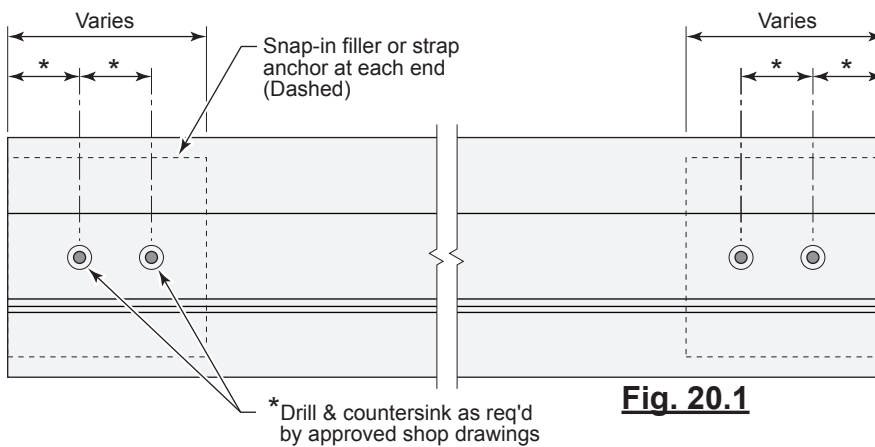
**Fig. 19.2**

**Fig. 19.3**

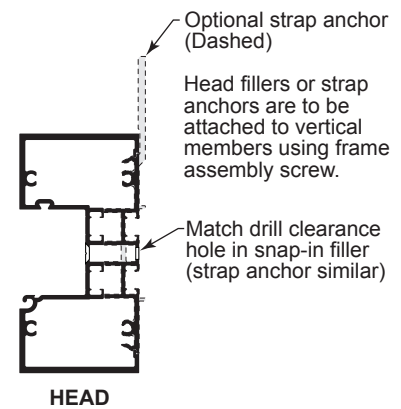
## FRAME FABRICATION

### Step 6: Fabricate Head & Sill

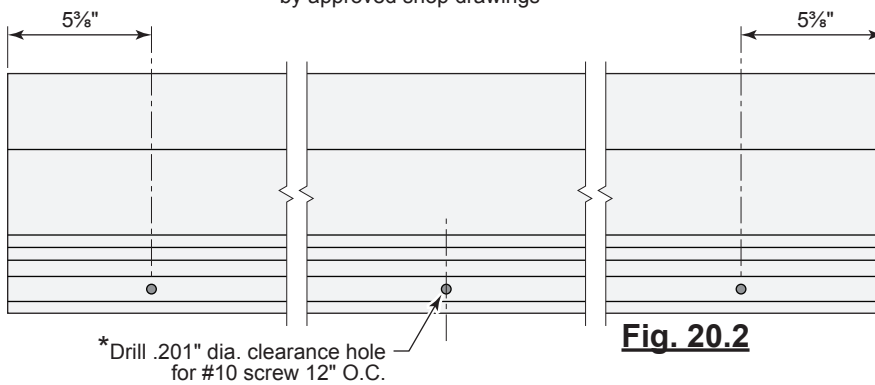
- A. For typical snap-in fillers (not strap anchors), drill and countersink ends of head member at v-groove line for flat head anchors as specified on approved shop drawings. For optional strap anchors, drill and countersink ends of head member for #10 clearance hole.
- B. When using typical snap-in fillers (not strap anchors), attach fillers to ends of head member and match drill clearance hole through snap-in fillers. When using optional strap anchors, drill and countersink head member for #10 clearance holes. Match drill strap anchor for #10 pilot hole and fasten the strap anchor to the head with (2) S422 #10-24 x 1" FH. **SEE Fig. 20.1.**
- C. Drill clearance hole for #10 screw in sill member at v-groove. Locate 5 3/8" from ends and 12" O.C. **SEE Fig. 20.2.**



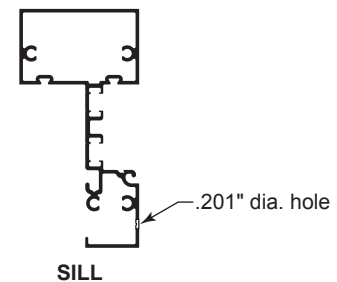
**Fig. 20.1**



HEAD



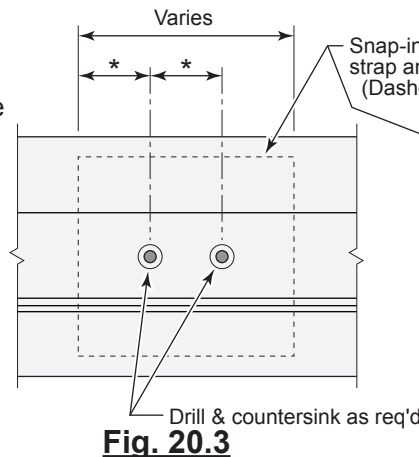
**Fig. 20.2**



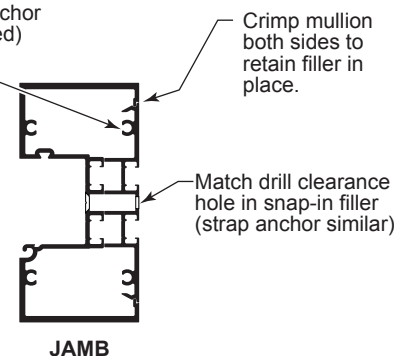
SILL

### Step 7: Fabricate Jambs for Anchors

- A. Drill and countersink jamb member at v-groove line for flat head anchors as specified on approved shop drawings. For optional strap anchors, drill and countersink jamb member for #10 clearance hole.
- B. Attach fillers to jamb member and match drill clearance hole through snap-in fillers. When using optional strap anchors, drill and countersink head member for #10 clearance holes. Match drill strap anchor for #10 pilot hole and fasten the strap anchor to the jamb with (2) S422 #10-24 x 1" FH. **SEE Fig. 20.3.**



**Fig. 20.3**

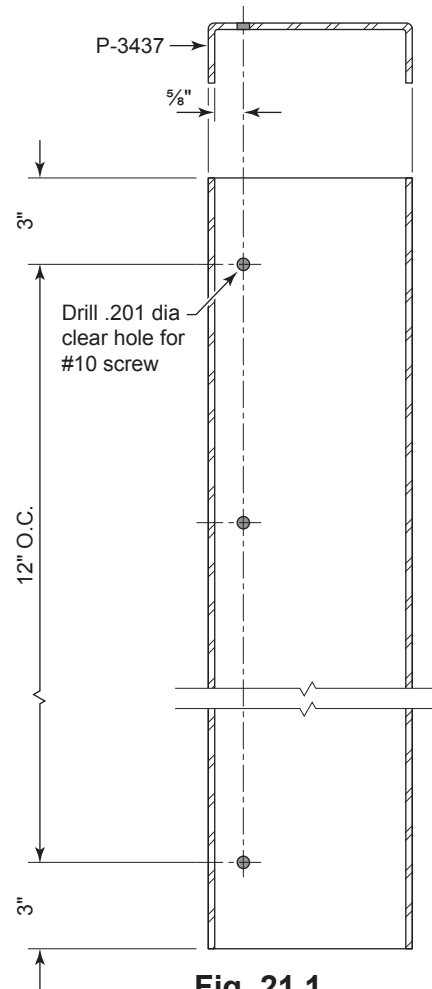


JAMB

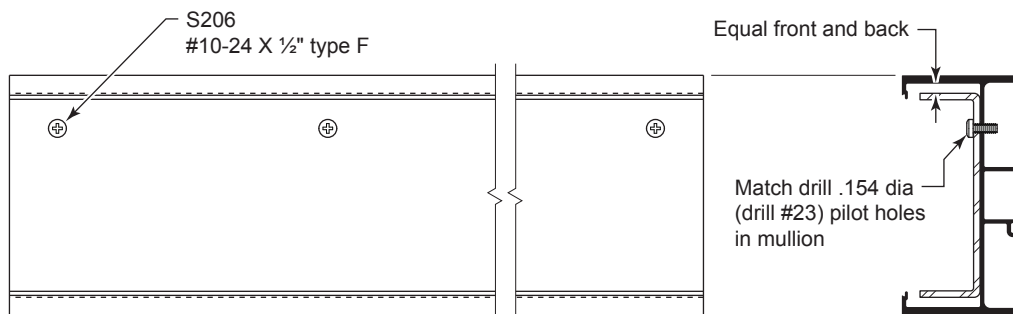
## FRAME FABRICATION

### Step 8: Steel Stiffener (As required)

- A. If **P3437** steel stiffeners are required in the door jamb mullions, pre-drill .201 dia (drill 7) clearance holes for S-206 #10 screw at 12" O.C. (3" from ends). **SEE Fig. 21.1.**
- B. Install **P3437** steel stiffener into door jamb mullion. Match drill .154 dia (drill #23) pilot holes. Attach steel to door jamb mullion with **S206 #10-24 x 1/2"** PH type F screw. **SEE Fig. 21.2.**



**Fig. 21.1**



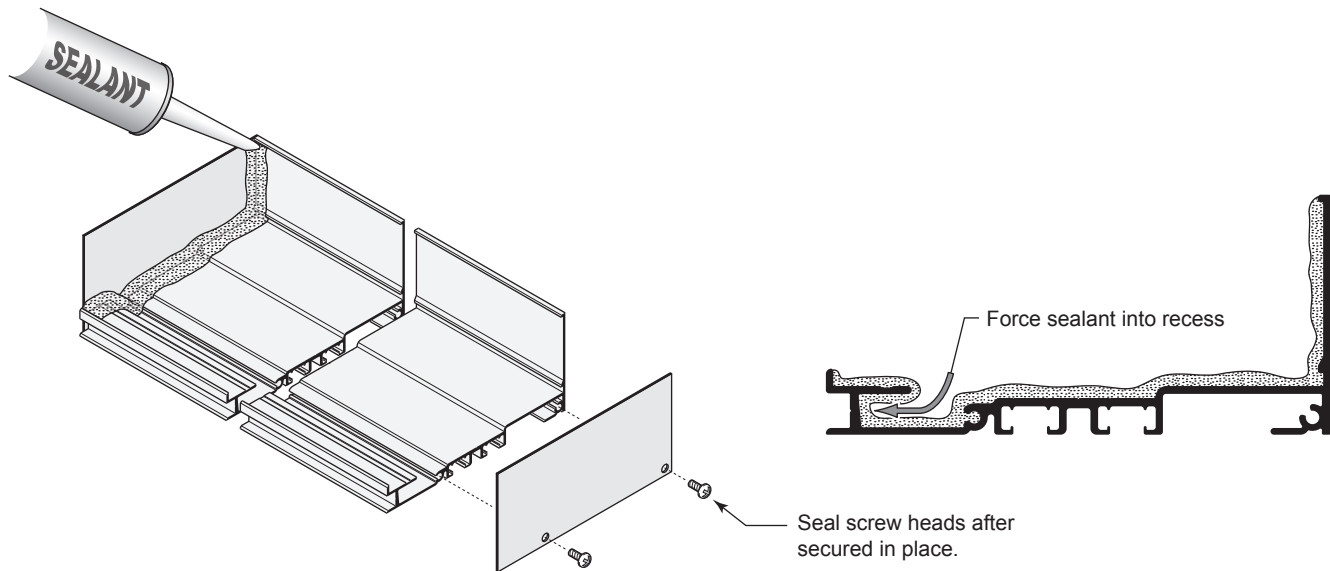
**Fig. 21.2**

## FRAME ASSEMBLY

### **Step 9: Install Sill Flashing End Dams**

- A. Install **P1156** end dam at each end of sill flashing with (2) **S196** #8 x 3/8" PH screws. Set aside and allow sealant to cure. **SEE Fig. 22.1.**

**NOTE:** If sill flashing is spliced, install on jamb-end only. Refer to **Step 13**, page 25 for splicing instructions.

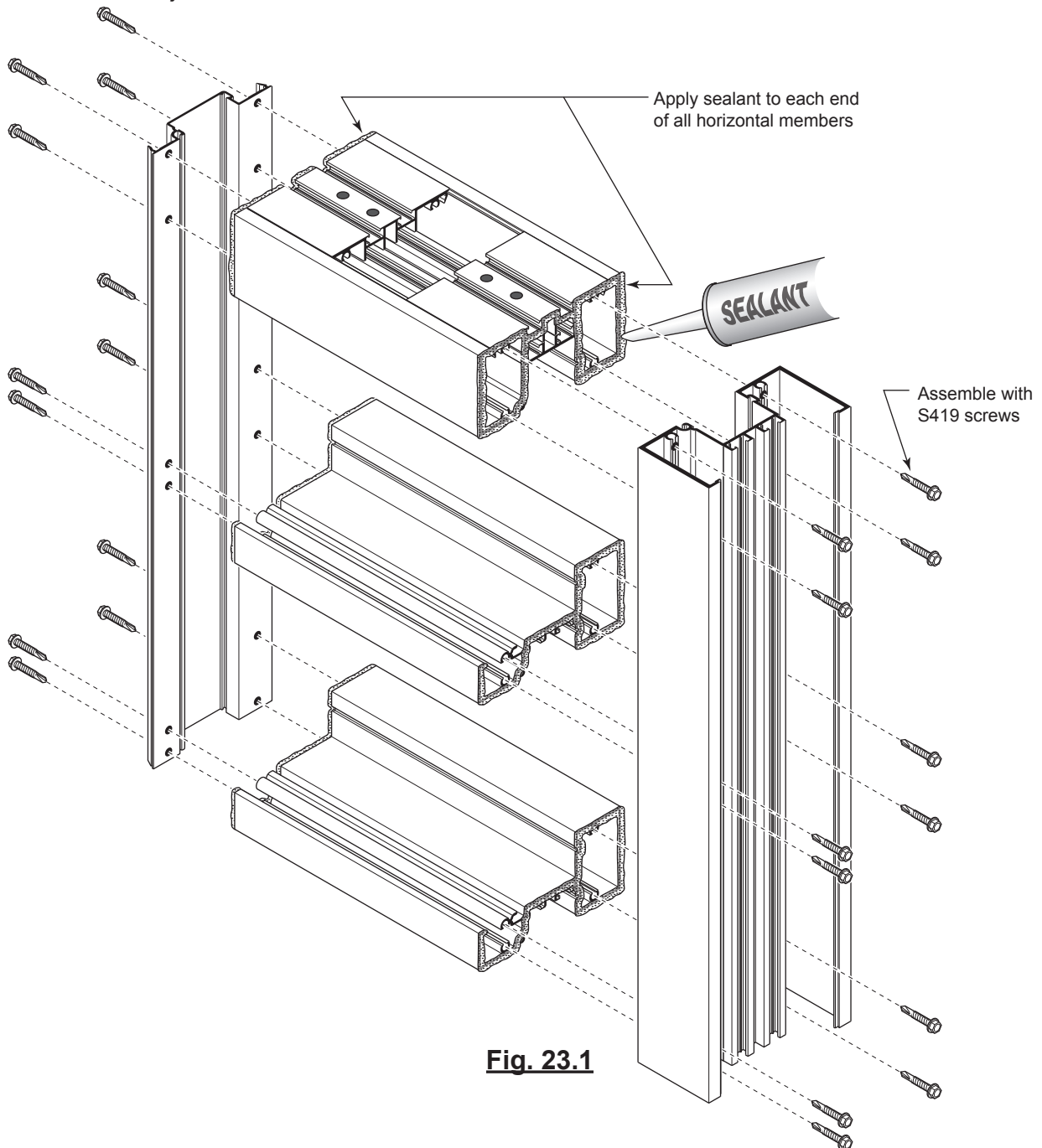


**Fig. 22.1**

## FRAME ASSEMBLY

### Step 10: Assemble Frames

- A. Clean all mating surfaces on horizontal & vertical.
- B. Apply sealant to ends of the head, head anchor, horizontal and sill members prior to attaching to vertical members. **SEE Fig. 23.1.**
- C. Attach head, head anchor, horizontal and sill members to the vertical and closure pocket members with **S419** #12-14 x 1 1/2" HWH frame assembly screws. **SEE Fig. 23.1.**
- D. Tool sealant at each joint.



**Fig. 23.1**

## FRAME ASSEMBLY

### Step 11: Install Gaskets

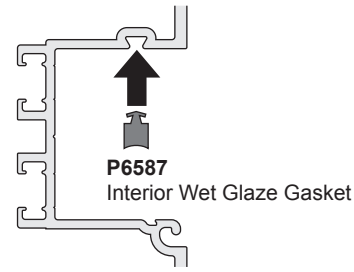
#### Wet Glazing:

- A. Install **P6587** silicone spacer gasket at interior side of framing members. **SEE Fig. 24.1.**

#### Dry Glazing:

- B. Install **P6586** dry glaze gasket at interior side of framing members. **SEE Fig. 24.2.**

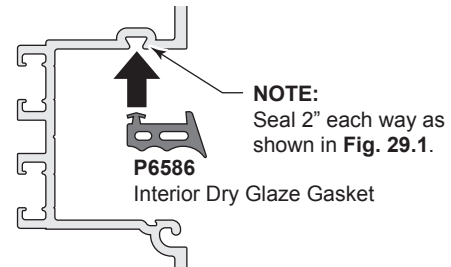
DO NOT STRETCH GASKETS WHEN INSTALLING.  
 Start at the center of the D.L.O. and work towards ends.



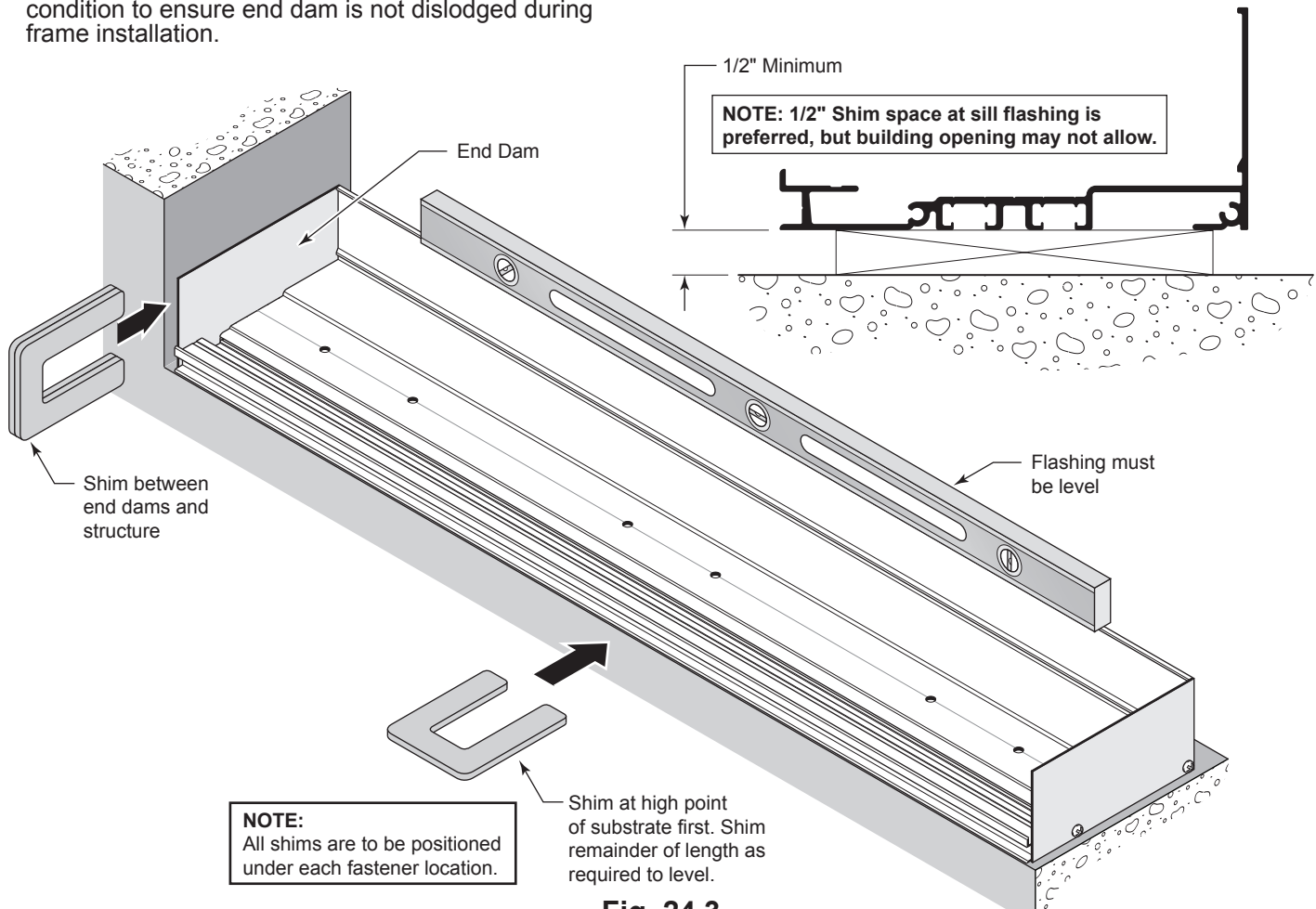
**Fig. 24.1**

### Step 12: Install Sill Flashing

- 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 1/8"). **If there is an entrance door in the opening, refer to Step 21, page 32 for instructions.** Splice joint to be 3/8" min.
- B. At the highest point of the sill (smallest rough opening height), shim the sill flashing with a minimum 1/4" shim space. Sill flashing must be installed level side to side and front to back. **SEE Fig. 24.3.**
- C. Shim tight between the sill flashing end dam and building condition to ensure end dam is not dislodged during frame installation.



**Fig. 24.2**



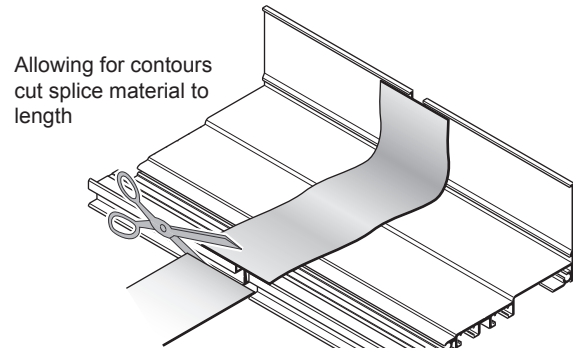
**Fig. 24.3**



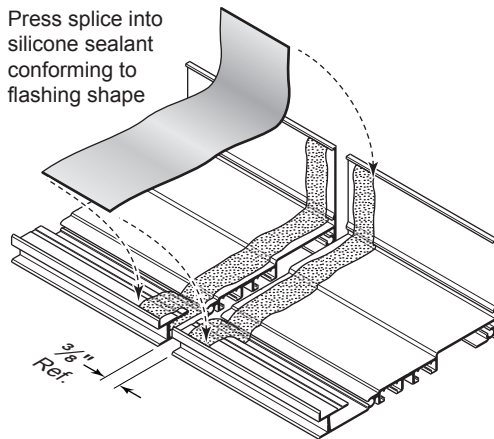
## FRAME ASSEMBLY

### Step 13: Install Sill Flashing Splice (If required)

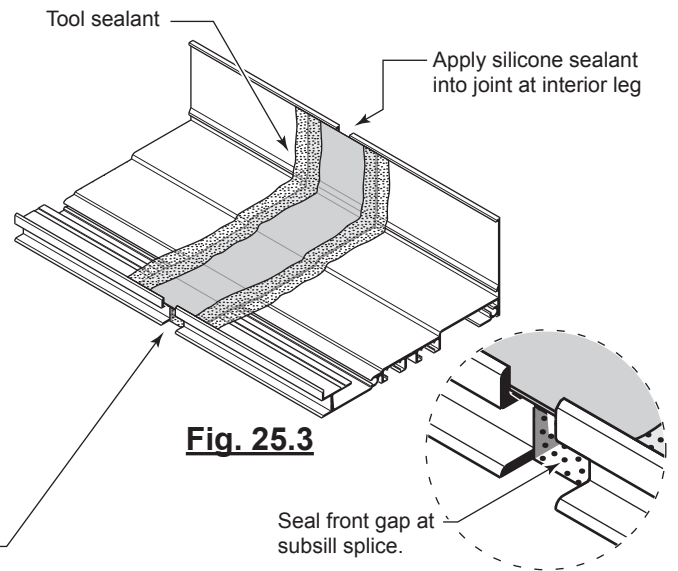
- A. Continue installing sill flashing per Step 12 across the opening.
- B. Lay silicone sheet into sill flashing at splice location and cut to length. **SEE Fig. 25.1.**
- C. Install backer rod under the sill flashing at the splice joint.
- D. Clean surfaces where splice will be applied. Apply sealant as shown in **SEE Fig. 25.2.**
- E. Set splice sleeve in place and tool sealant. Seal front and back joints. **SEE Fig. 25.3.**



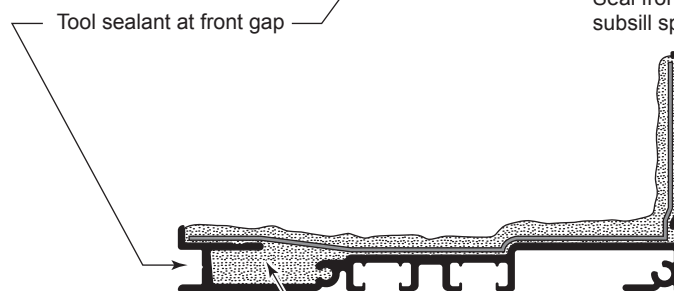
**Fig. 25.1**



**Fig. 25.2**



**Fig. 25.3**



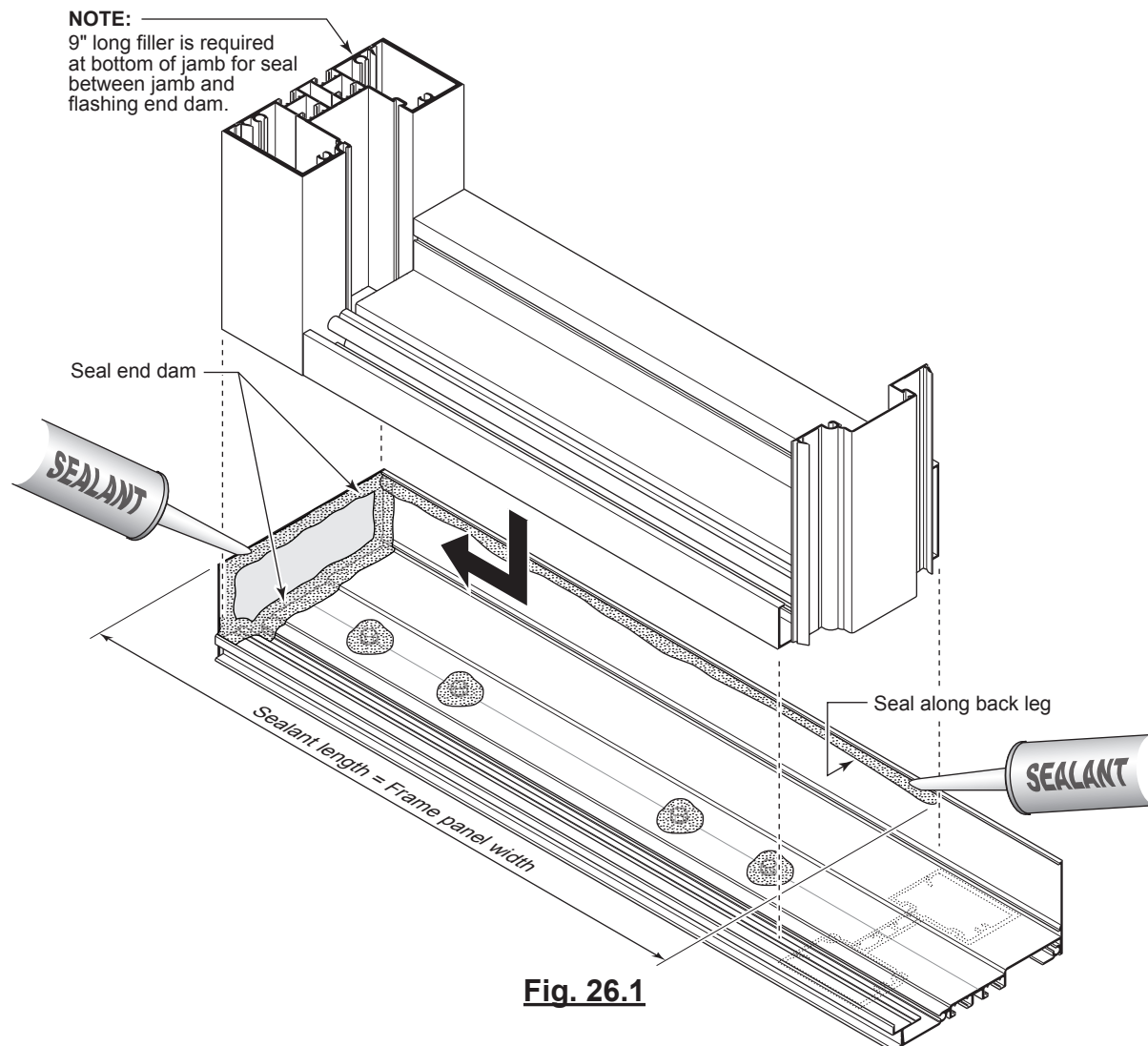
**Fig. 25.4**

## FRAME INSTALLATION

### Step 14: Install Frames

**NOTE:** If there is an entrance door within the frame, the sill block must be installed against the door jambs prior to setting the assembled frame next to a door opening. **SEE Fig. 33.1 & Fig. 33.2.**

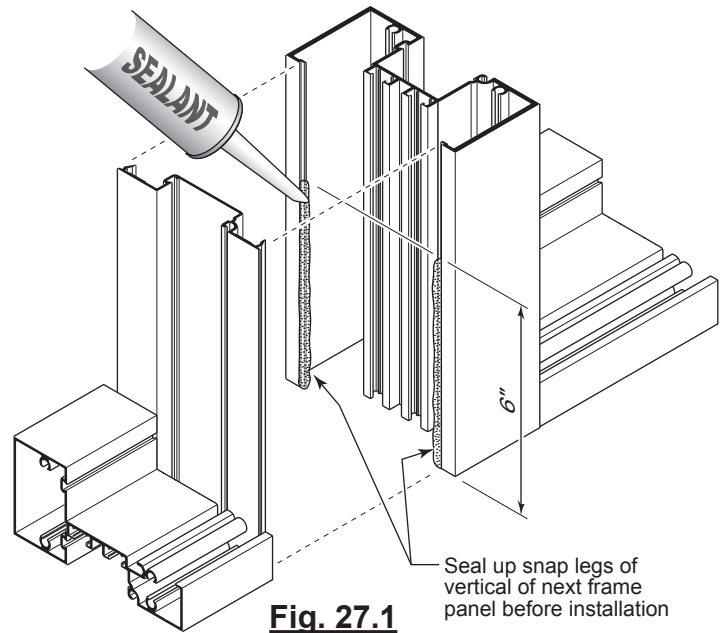
- A. Starting on one side of the opening, apply a bead of silicone to the back leg of the sill flashing and the end dam prior to installing each frame. **SEE Fig. 26.1.** Apply a sealant bead on the back leg of the sill flashing only for the frame to be installed.
- B. Lift first frame onto the sill flashing, snug against the end dam.



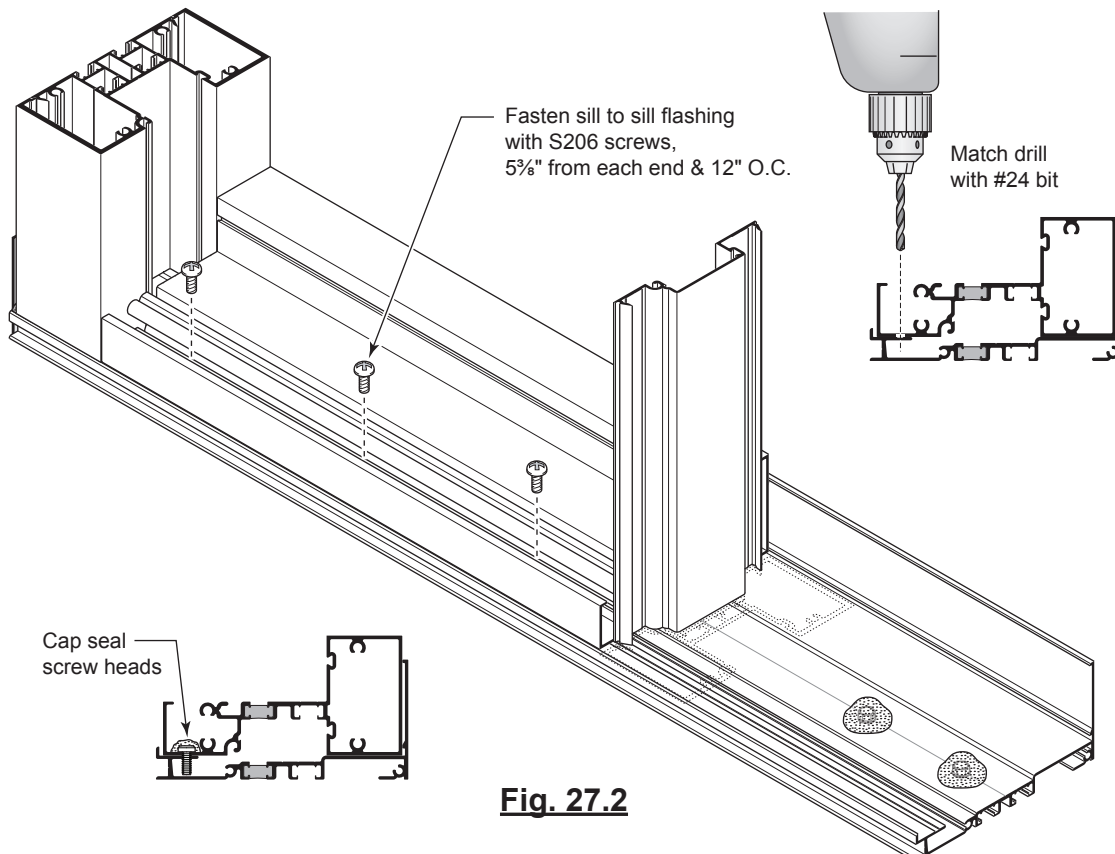
## FRAME INSTALLATION

### Step 14: Install Frames (Continued)

- C. Prior to installing the next frame, run a 6" bead of sealant at the bottom of the vertical mullion snap detail. **SEE Fig. 27.1.**
- D. Lift each frame onto the sill flashing and engage with the previous frame, sealing per step 14 C.
- E. Check to ensure frame is plumb, level and jamb caulk joint is per approved shop drawings.



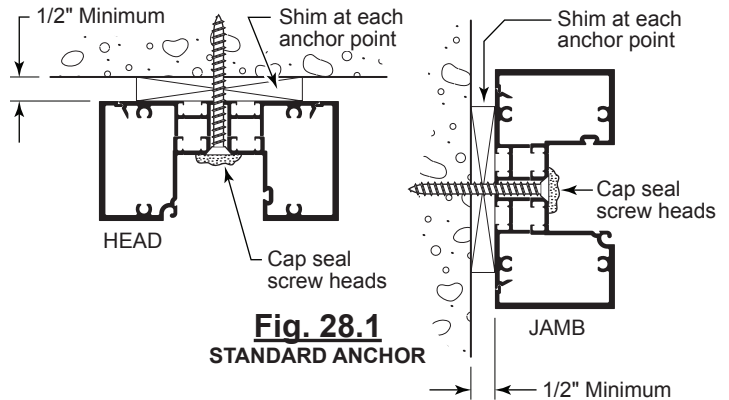
- F. Match drill into sill flashing at holes in sill member with drill #24 (.152 dia) pilot hole for #10 screw. Anchor sill to sill flashing with S-206 #10-24 x 1/2" PH screw. Cap seal heads. **SEE Fig. 27.2.**



## FRAME INSTALLATION

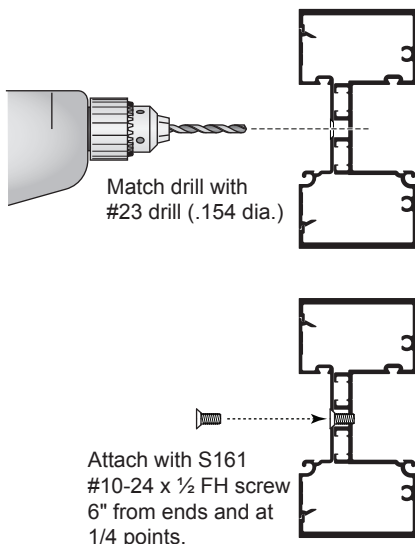
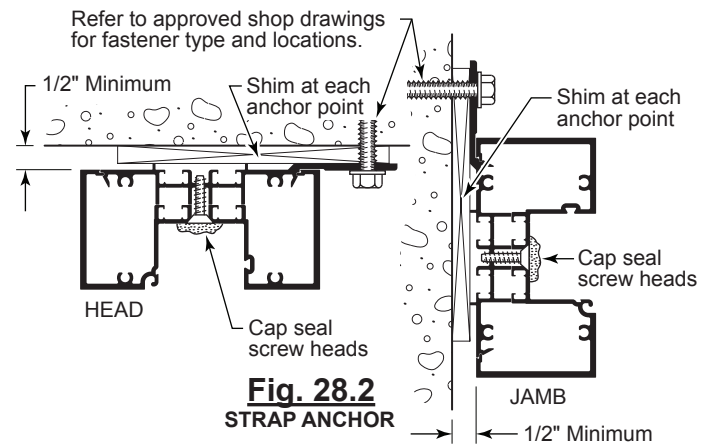
### Step 14: Install Frames (Continued)

- G. Shim head and jamb at anchor points and attach to structure with flat head fasteners. **SEE Fig. 28.1 & SEE Fig. 28.2.**
- H. Match drill the vertical mullion through the vertical pocket closure with drill #23 (.154 dia) pilot hole for #10 screw. Fasten pocket closure to mullion with S161 #10-24 x 1/2" UC FH. **SEE Fig. 28.3.**
- I. Once the frame is anchored to the structure, apply exterior perimeter seal at head, sill and jambs. At interior, apply perimeter seal at head and jambs. Seal at sill flashing is for cosmetic purposes as required. **SEE Fig. 28.4.**

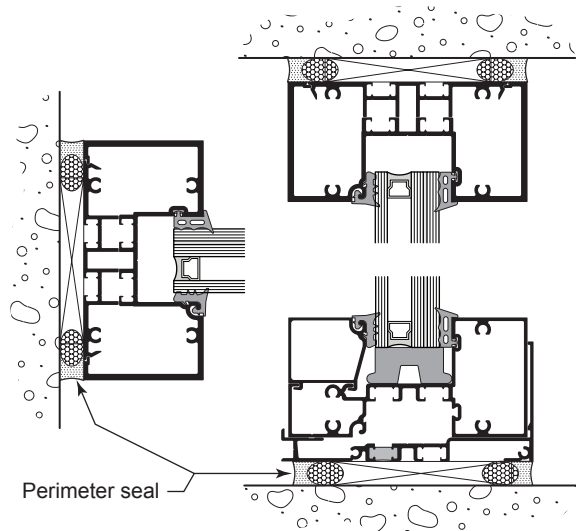


### Step 15: Glazing Preparation

- A. Remove any debris from glazing pockets.
- B. Trim excess silicone from edges of glazing units to allow for maximum glazing clearance.
- C. For wet glazed applications: Clean areas where structural silicone will be applied.



**Fig. 28.3**



**Fig. 28.4**

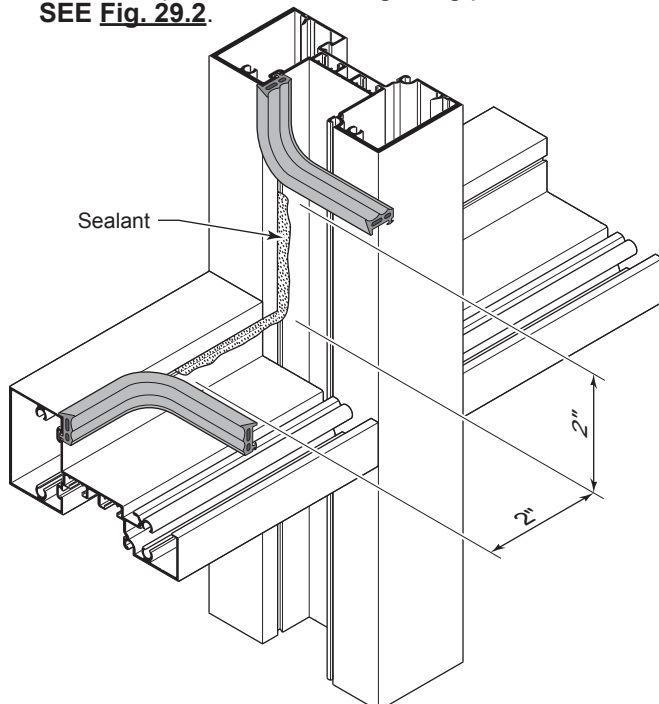
## GLAZING

### Step 16: Installing Glazing Units

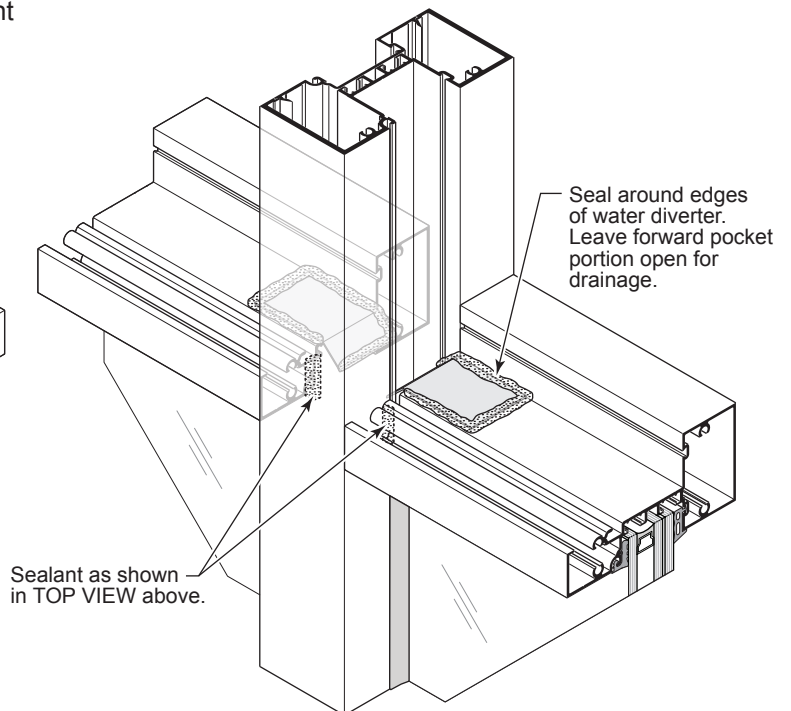
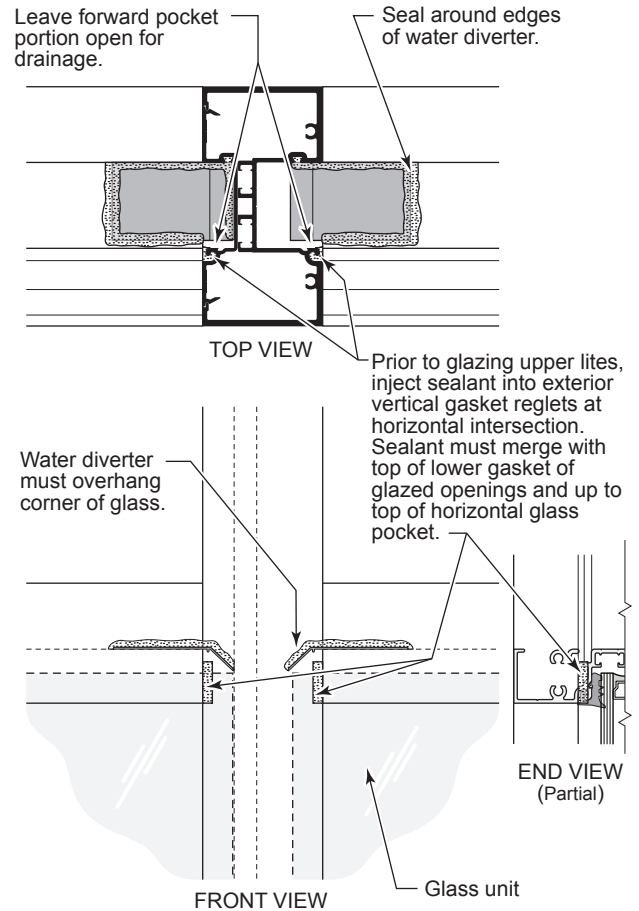
**NOTE:** Glazing must be done from bottom of frame up.

**NOTE:** Laminated portion of the glazing unit must always be installed towards the interior.

- A. For dry glazing, install P6586 interior gasket, sealing the corners of the gaskets per **Fig. 29.1**. For wet glazing, install P6587 at the interior. **SEE Fig. 30.1**
- B. Set glass by installing into deep pocket first, then carefully sliding into shallow pocket. When contact is made with the shallow pocket, set glass onto (2) **P6541** setting blocks located at quarter points or per approved shop drawings.
- C. **DRY GLAZING ONLY:** Install anti-walk blocks **P1916** into deep pocket at third-points of the D.L.O. Stretch the **P1916** so that it fits between the aluminum glazing reglet and glass. Push in until the 'W' shape expands into the opening between the glass and the deep pocket.
- D. Install **P6503** exterior gasket on the vertical sides of the glass, holding back at the bottom to allow for glass stop installation.
- E. Install E34104 glass stop at the bottom of the lite.
- F. Finish installing gaskets at top and bottom of D.L.O.
- G. Repeat steps 16.A-F for the remainder of the row.
- H. Prior to moving to the next row of lites, install water diverter **P6581** at ends of intermediate horizontal. **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. 29.2.**



**Fig. 29.1**

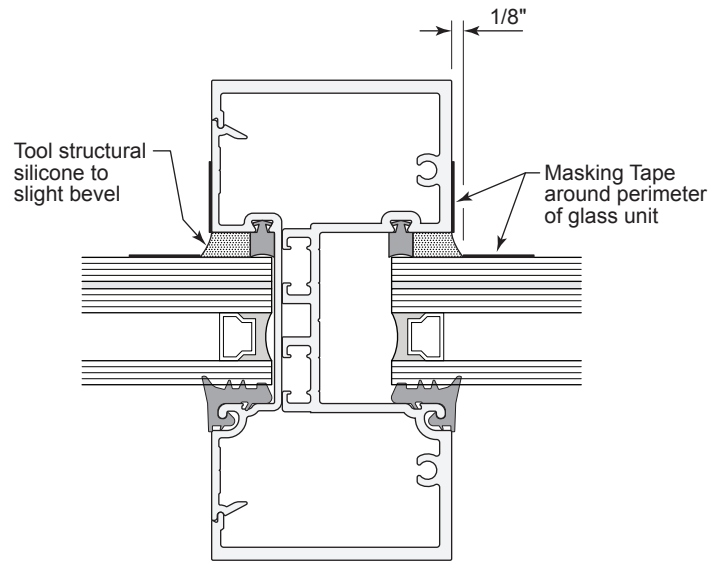


**ISOMETRIC VIEW**  
**Fig. 29.2**

## GLAZING

### Step 17: Wet Glazing (Only)

- A. Apply low adhesion masking to surface of frame and glass. Apply masking to glass 1/8" above the plane of the frame. **SEE Fig. 30.1.**
- B. From bottom to top, apply DOW 995 structural silicone in cavity between the silicone spacer and glass. Make sure the entire void is filled with no air bubbles or voids in the sealant.
- C. Using a beveled non-scratching instrument, tool the sealant immediately after applying the silicone. The resulting joint should have a slight bevel rising from the frame to the glass. **SEE Fig. 30.1.**
- D. Remove masking from glass and frame before the silicone skins over.
- E. Repeat steps 17.A-D until all units are wet glazed.



**Fig. 30.1**



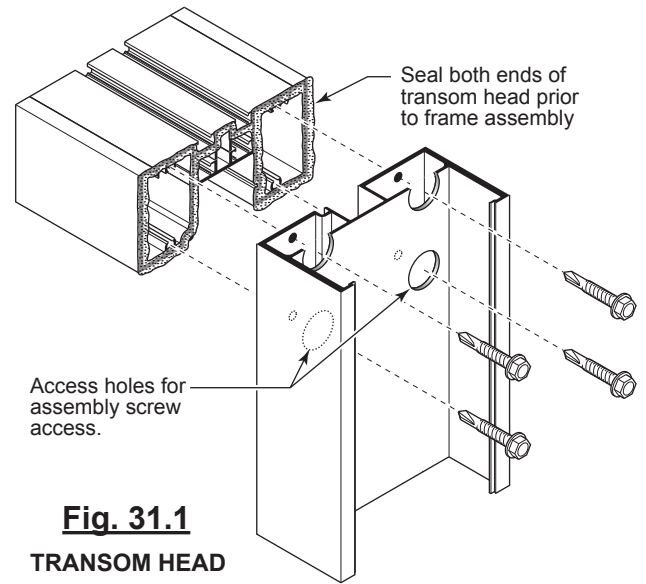
## DOOR and FRAME INSTALLATION

### Step 18: Preparation

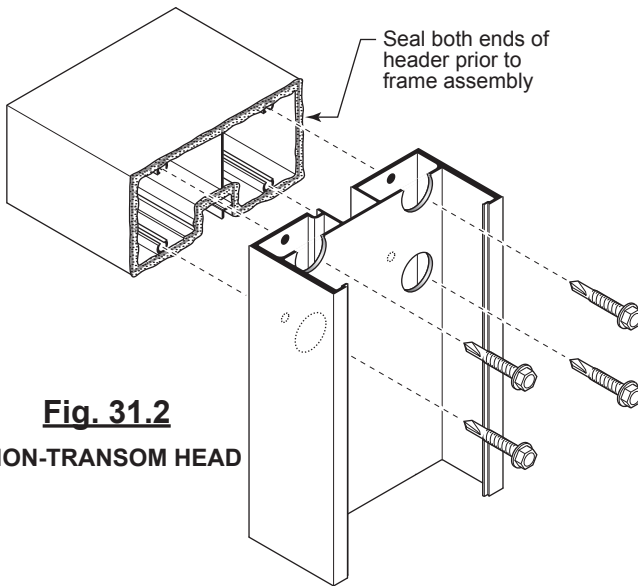
- A. Doors are shipped assembled from factory. Door frames are fabricated and shipped KD.
- B. Frames with transoms are cut long for final adjustment in the field. Once final door frame height is verified in the field and door jambs are cut down, use drill fixture **P3439** to fabricate the tops of the door jamb verticals for the transom head member.

### Step 19: Frame Assembly

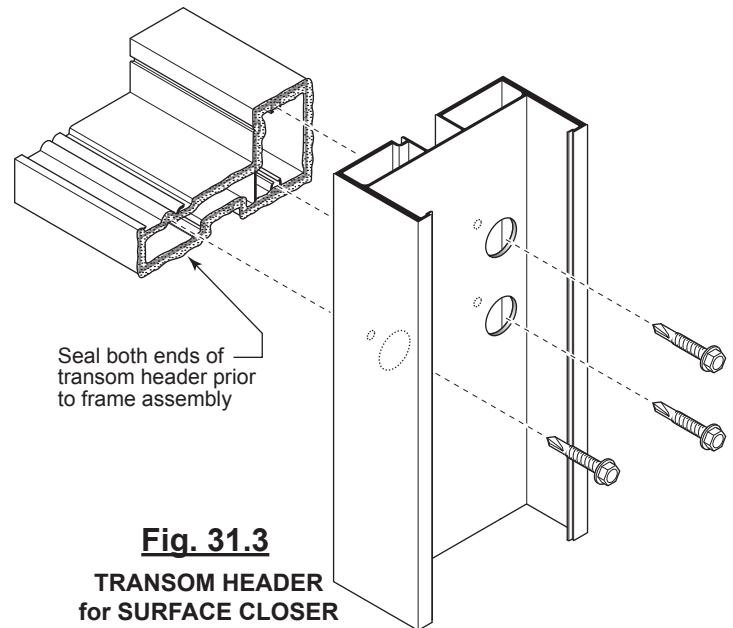
- A. Apply sealant to the ends of the door header and transom head members.
- B. Attach the door header and transom header to the door jambs with (4) **S419** #12-14 x 1 1/2" HWH frame assembly screws. Attach the **P3497** threshold clips to the door jambs with (2) **S293** #12 x 1/2" FH UC screws. SEE **Fig. 31.1** - **Fig. 31.5**.



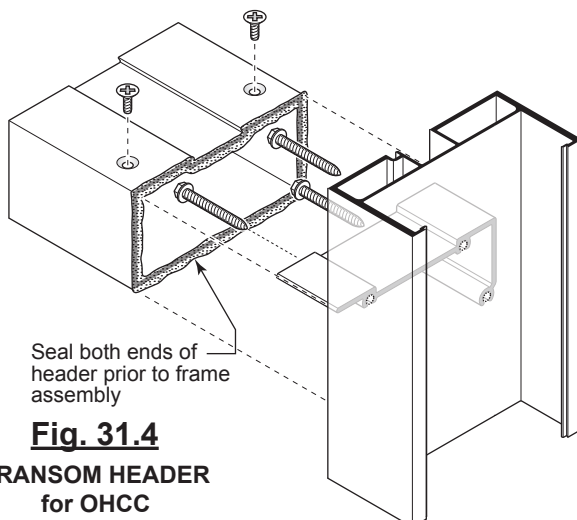
**Fig. 31.1**  
**TRANSM HEAD**



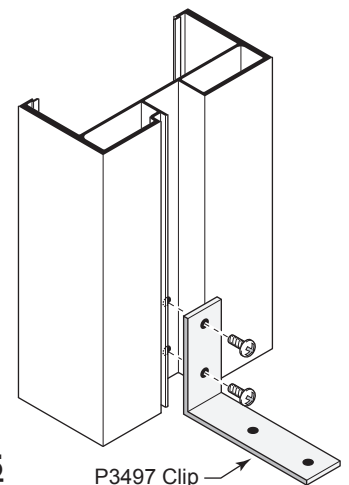
**Fig. 31.2**  
**NON-TRANSM HEAD**



**Fig. 31.3**  
**TRANSM HEADER**  
**for SURFACE CLOSER**



**Fig. 31.4**  
**TRANSM HEADER**  
**for OHCC**

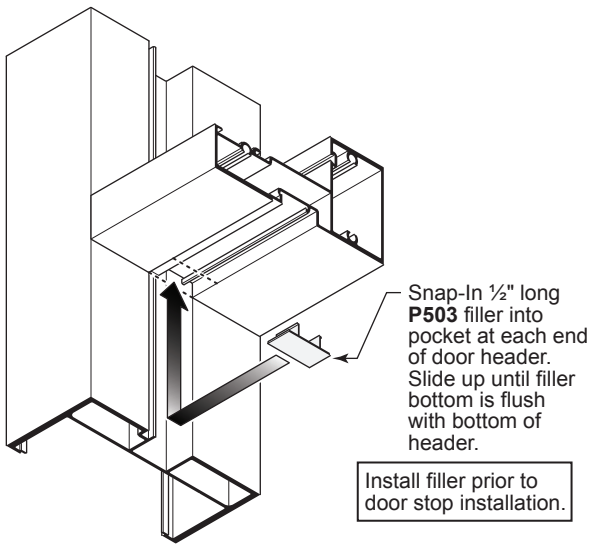


**Fig. 31.5**  
**THRESHOLD**

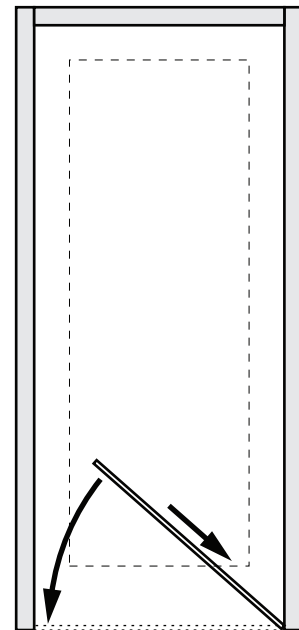
## DOOR and FRAME INSTALLATION

### Step 20: Frame Assembly (Continued)

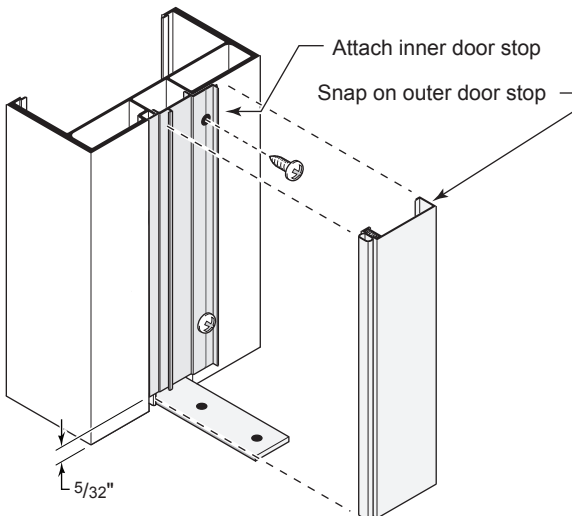
- C. Install 1/2" long pocket filler into each end of door header as shown in **Fig. 32.1**
- D. Attach inner door stop to jambs with S206 #10-24 PH screws 2" from each end and 12" O.C. **Fig. 32.2**.
- E. Attach the threshold to the door jamb clips with (2) **S070** screws provided. Attach threshold to substrate with screws show in approved shop drawings. **SEE Fig. 32.4.**



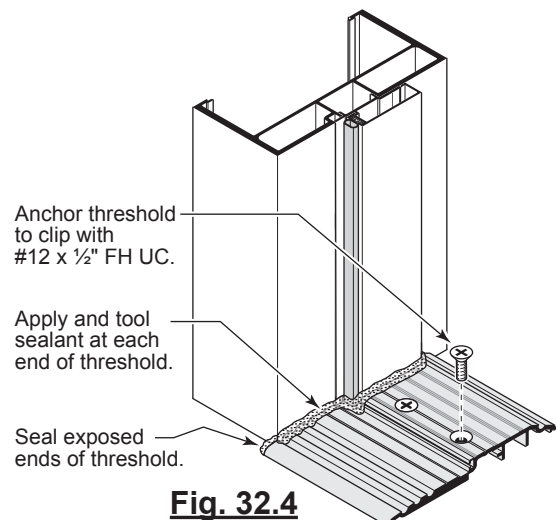
**Fig. 32.1**



**Fig. 32.3**



**Fig. 32.2**



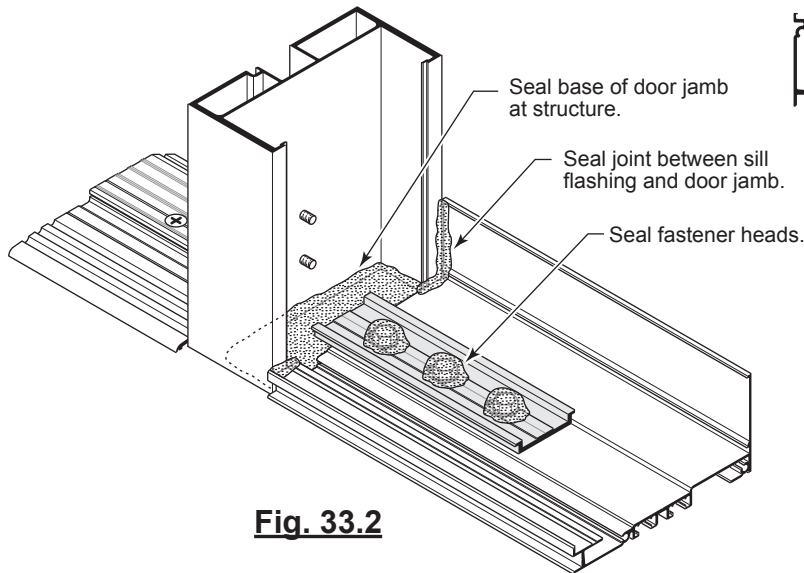
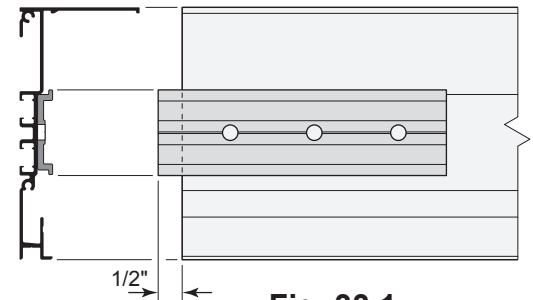
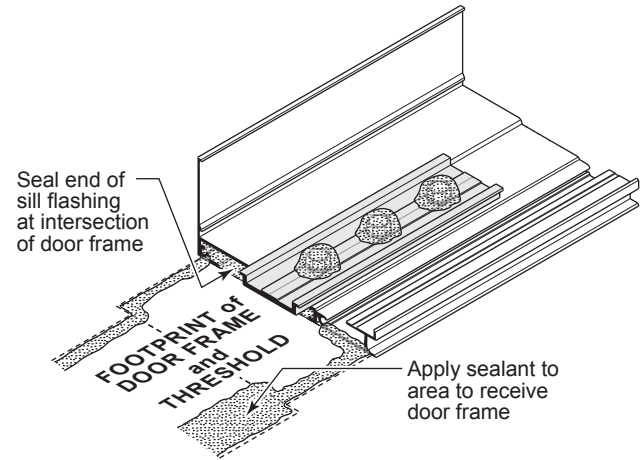
**Fig. 32.4**



## DOOR and FRAME INSTALLATION

### Step 21: Installing Door Frame

- A. Prior to installing door frame, run a bead of silicone on finished floor where threshold will be placed.  
**SEE Fig. 33.1.**
- B. Set assembled door frame into opening. Door frames must be installed plumb, square and level. For frames having sidelites, seal termination of sill flashing and door jamb, then install **P3426** sill block into sill flashing and door jamb adjacent to the door frame. **SEE Fig. 33.2.**
- C. Shim the threshold as required to level and secure to the building floor.
- D. Install inner door stops **E6507** to door jambs 2" from ends and 12" O.C. with **S206**. Inner door stop should be held back 1/8" from the finish floor at bottom.
- E. Snap outer door stops **E6505** onto inner door stops. Like the inner door stop, the outer door stop should be held back 1/8" from the finish floor at bottom.



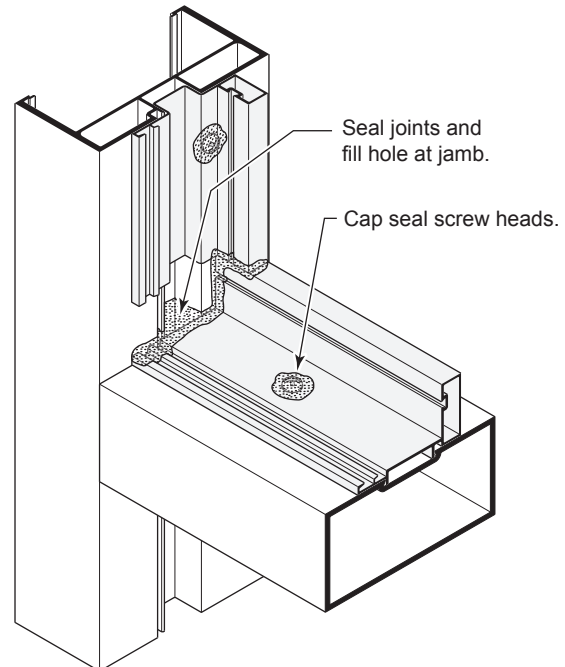
### Step 22: Door Installation

- A. Refer to Tubelite's 'Door and Frame Installation Instructions' for installing the door into the frame.

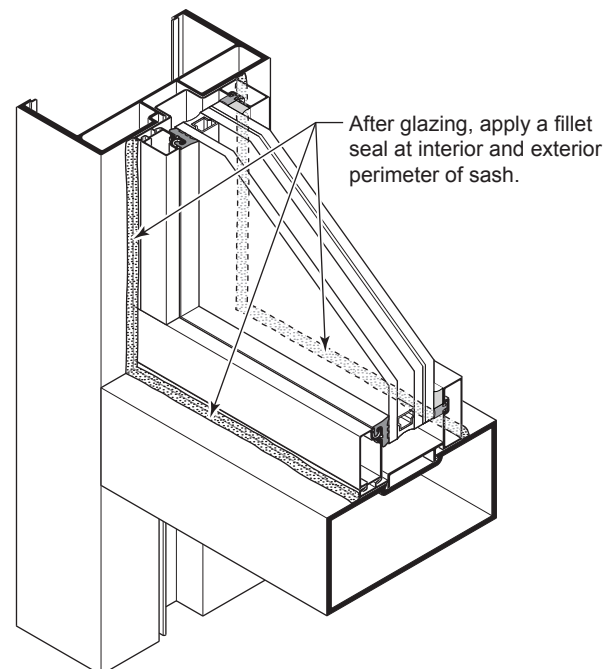
## DOOR and FRAME INSTALLATION

### **Step 23: Transom Sash Sealing**

- A. Install horizontal sash member E34006 with S270 #10-24 x 3/4" PH 2" from ends and 12" O.C. E34006 sash runs continuous between the door jamb members.
- B. Install vertical sash member E3521 with S206 #10-24 x 1/2" PH 2" from ends and 12" O.C. E3521 runs from top of the E34006 horizontal sash to the underside of the transom head member.
- C. Dam ends of E34006 horizontal sash with sealant into the door stop pocket on the door jamb. **SEE Fig. 34.1.**
- D. Install glazing gaskets, glass, setting blocks and glass stops according to typical glazing instructions mentioned previously in the GLAZING section of this manual.
- E. Place a cap bead of sealant around the inside and outside of the E34006 and E3521 sash members. **SEE Fig. 34.2.**



**Fig. 34.1**



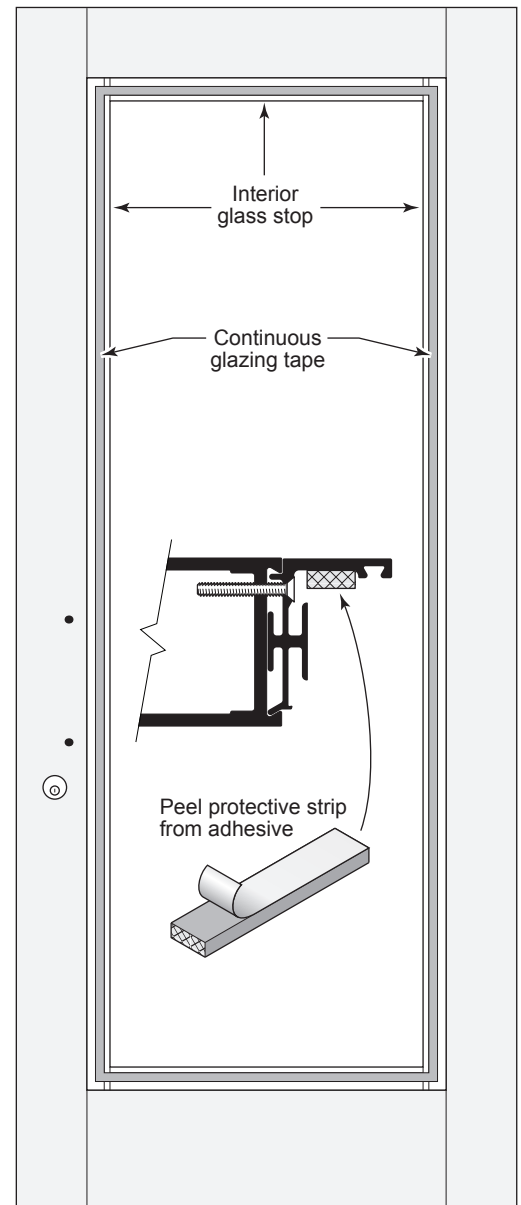
**Fig. 34.2**

## DOOR and FRAME INSTALLATION

### Step 24: Door Glazing

#### Wet Glazing:

- A. Fasten interior door glass stop to rails and stile of the door with **S6504 #6-32 x 1" FH 2"** from ends and 6" O.C.
- B. Apply 3/16" x 1/2" Tremco SGT921 One-Sided glazing tape (Not Included) to interior door glass stop all around the door. **SEE Fig. 35.1.**



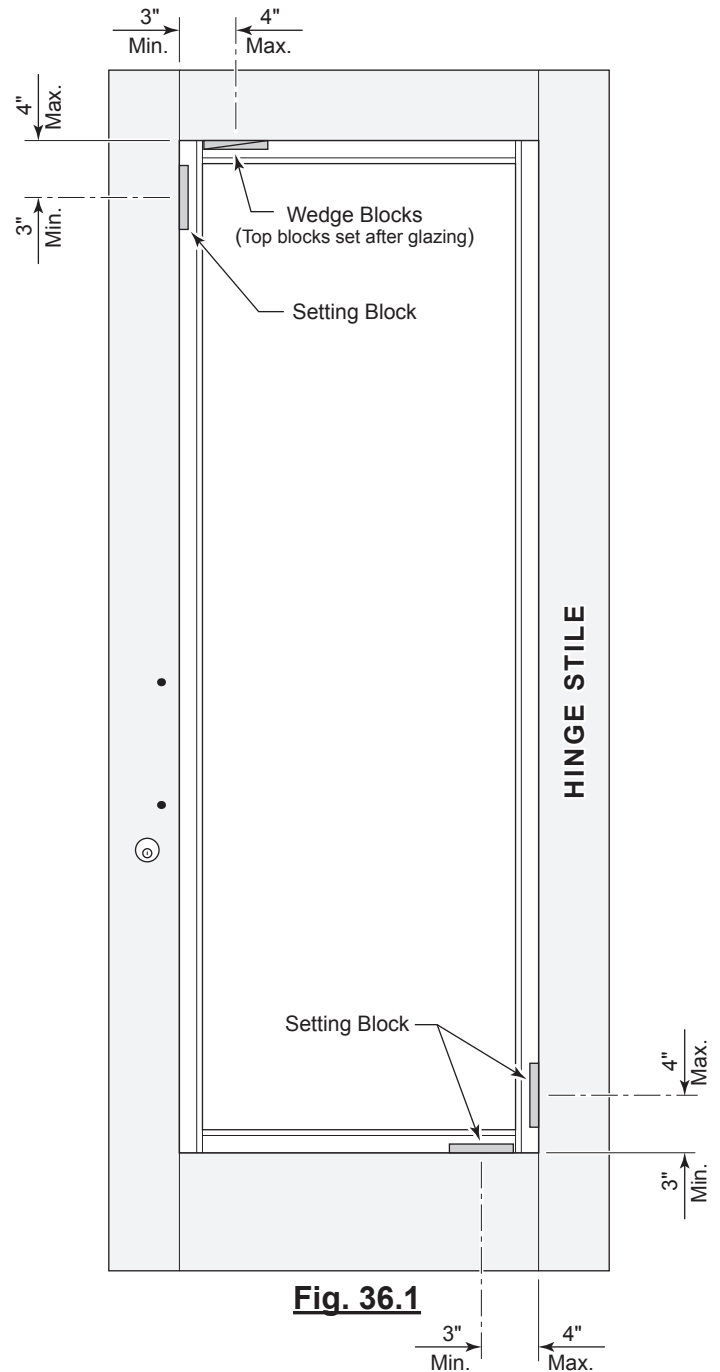
**Fig. 35.1**  
Glazing tape at wet glaze door

**DOOR and FRAME INSTALLATION**

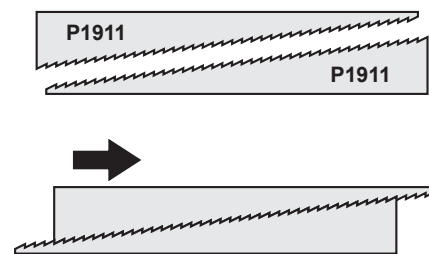
**Step 24: Door Glazing** (Continued)

**Wet Glazing:**

- C. After hanging the door, place **P1912** self adhesive setting blocks in three locations on **E6502** Glazing gutter. **Fig. 36.1**.
- D. **Note:** Gasket is pre-installed in the glazing stops in the factory.
- E. Install glass in door.
- F. Install vertical then horizontal glass stop at bottom.
- G. Square up door as desired and block in place.
- H. Place two wedge blocks as shown in **Fig. 36.2**. If together properly the wedge blocks will interlock and form two flat surfaces.
- I. With the wedge blocks in place, push them together increasing the thickness. Push together until they press tightly against the underside of the glazing gutter and top of the glass holding the door square.
- J. Install top horizontal glass stop.
- K. To square up the door in the future, remove top horizontal glass stop and repeat steps G through J.
- L. Apply low adhesion masking to surface of glass stop and glass.
- M. From bottom to top, apply DOW 995 structural silicone in cavity between the glazing tape and glass. Make sure the entire void is filled with no air bubbles or voids in the sealant.
- N. Using a beveled non-scratching instrument, tool the sealant immediately after applying the silicone.
- O. Remove masking from the glass and glass stop before the silicone skins over.



**Fig. 36.1**



**Fig. 36.2**