

General Storefront Installation Instructions

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These recommendations are for general erection and installation procedures only. Refer to approved Shop Drawings for actual job conditions. For perimeter anchor types and spacing consult structural design professional. Verify caulking and sealants are compatible with substrates and application. Apply sealants per manufacturers' instructions.



General Overview

1. General Notes

A. Basics

1. Install all frames and glazing infills with skilled tradesman in accordance with approved shop drawings, these installation instructions, project specifications and GANA glazing guidelines, AAMA 101/I.S.2 standard, and AAMA storefront manual SFM1-14.

B. Lineal Storefront Framing Systems

1. Manko Window Systems, Inc. supplies stock length lineals to its certified dealers. It is the responsibility of the installing dealer to ensure proper frame sizing, drilling or punching of the assembly screw holes, and assembly of the frames. By definition, the certified dealer becomes the manufacturer of the storefront system with project support from Manko.
2. Storefront systems are designed for first floor slab-to-head (single span) anchorage conditions. Consult Manko for any other design considerations or applications.
 - a. Storefront systems are not allowed in residential applications.
 - b. Storefront systems are not allowed in twin span applications or areas where the frame is not resting flat on a slab or structural wall.
 - c. Storefront systems are designed for ground floor applications. When used in applications above ground floor, configuration and application must be factory approved.
 - d. Storefront systems are generally designed for openings not exceeding 126" in height with vertical mullion spacing on 54" centers (or less), and glass lites not exceeding 84" in height. Consult factory wind load and dead load charts, or qualified design professional on every situation exceeding these sizes to verify suitability. Failure to do this could result in structural failures, excessive air infiltration, water leakage, and invalidates factory warranty.

C. Check Material

1. Check material upon delivery for damage and discrepancies. Any visible damage must be noted on the freight bill at time of receipt. If a claim is required, the receiving party must process a claim with the freight carrier. If the delivery is by a Manko truck, any damage or variance in the quantity of stock lengths, units or boxes must be reported to Manko Window Systems, Inc. personnel as per standard terms and conditions.

D. Protection and Storage

1. Handle all material in a safe and careful manner.
2. Do not drag or drop material when handling.



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3. Use dollies, carts or other appropriate devices to properly support material during handling to avoid racking, bowing, twisting, bending or other types of damage to material.
4. Store/stack doors and frames in the upright position with adequate separation to ensure framing and hardware will not rub or scratch. Never store doors or frames flat, or on their side.
5. Do not store products on ground. Insure adequate ground separation with pallets, or other suitable planking materials.
6. Protect against the weather and other trades by using an appropriate well ventilated covering.
7. If frames, accessories, or packaging material get wet, immediately remove from contact with water soluble products (Ie. cardboard, paper, etc.). Wash, dry, and inspect effected areas and move to a dry location.

E. Cleaning Framing

1. Cement, plaster, terrazzo, alkaline, and acid based materials used to clean masonry are very harmful to finishes and should be removed with water and mild soap immediately; otherwise, permanent staining will occur. A spot test is recommended before any cleaning agent is used.
2. For cleaning of anodized aluminum surfaces, refer to AAMA 609.1 Voluntary Guide Specification for Cleaning and Maintenance of Architectural Anodized Aluminum.
3. For cleaning of painted aluminum surfaces, refer to AAMA 610.79 Voluntary Guide Specification for Cleaning and Maintenance of Painted Aluminum Extrusions and Curtain Wall Panels.

F. Product Performance

1. All testing, certification, and published performance levels are achieved under controlled laboratory conditions using standard frame members and fabrication techniques. Size and configuration of test samples are as required and set forth in the test procedure. Field performance of the system will deviate from listed values as configurations, sizes, members, and installation methods will vary from tested samples.



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2. **Construction Notes**

A. Reference Shop Drawings

1. Check shop drawings and installation instructions to become thoroughly familiar with the project. Job specific, Manko prepared, approved shop drawings take precedence over other literature, and include only project specific details. Manko does not recommend or endorse shop drawings or details drawn by others without Manko's specific consent and written review. These installation instructions are generic in nature and cover the most common conditions with minimal procedures and detail.

B. Check Openings

1. Check opening conditions and verify that openings are in accordance with the contract documents and approved shop drawings. If not, notify the General Contractor of discrepancies in writing and resolve the situation before proceeding.

C. Plumb/Level/True

1. All materials must be installed plumb, level, true, and in proper alignment. All products are to be installed maintaining maximum tolerances of 1/8".

D. Aluminum Isolation

1. Isolate aluminum that contacts masonry, steel, treated lumber, or other non-compatible material with a heavy coat of zinc chromate, plastic isolators, bituminous paint, or other approved bond breaking material.

E. Poured and Debridged or Thermal Strut Sections

1. Do not drill, punch, penetrate, or alter thermal break material in any manner.

F. Fastening

1. Fastening refers to any method of securing one part to another or to adjacent materials. Due to varying opening conditions, configurations, design pressures, and methods of anchorage (subframe, anchors, etc.), perimeter fasteners are not specified in these instructions. For anchor fastening, consult the project design professional.

G. Blocking and Shims

1. All blocking and shims will be high strength plastic or non-corrosive materials. All blocking is by others. Blocking must be of sufficient size and shape to support the frame at all anchorage locations. The blocking must prevent the anchorage fasteners from bowing, racking, twisting, or distorting the frames and accessories in any manner.



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H. Sealants

1. All caulking and sealants must be compatible with all materials they contact, including substrates and other caulking or sealants. Any caulking or sealant details shown, unless specifically called out to be by Manko, are by others. Manko will not assume any liability or responsibility for the selection, compatibility, or application of sealant, or caulking types not specifically furnished and applied by Manko. Consult the caulking or sealant supplier for recommendations relative to compatibility, adhesion, priming, tooling, shelf life, and joint design. It is the sole responsibility of the customer to perform all caulking and sealant adhesion and compatibility testing that is required by the caulking or sealant manufacturer of choice.

D. Attachments to Frame

1. Do not attach window treatments, ceiling supports, HVAC accessories, or any other items to frames without written permission. Failure to comply will invalidate manufacturer's warranty.

3. Building Codes

- A. Glass and glazing codes governing the design and use of products vary widely. Manko does not control the selection of products, configurations, operating hardware, or glazing materials; therefore, we assume no responsibility in these areas. It is the responsibility of the owner, architect, and the installer to make these selections in strict conformity to all applicable codes.



Basic Frame Fabrication

1. Determine Frame Size

A. Check Openings

1. Carefully check the openings and surrounding conditions that will receive your material. Remember, if the construction is not per the construction documents, it is your responsibility to notify the general contractor in writing. Any discrepancy must be brought to the general contractor's attention before you proceed with the fabrication and installation.

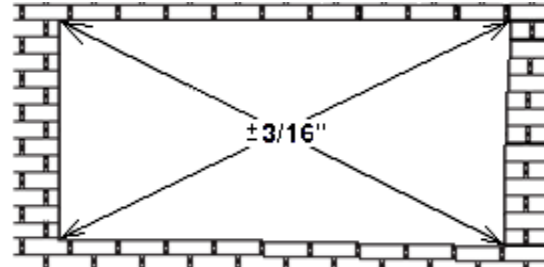


Figure 1

2. Check and confirm each opening is square, plumb, and level at all sides and corners. See Figures 1 and Figure 2 for maximum allowable

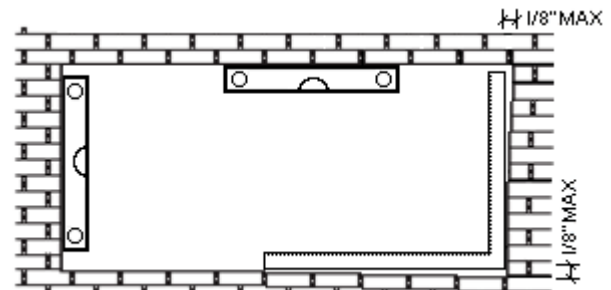
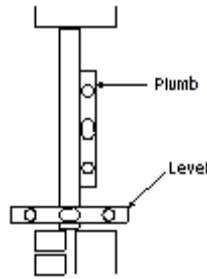


Figure 2

deviations.

B. Standard Frame Size Deductions

3. Measure the opening width at a minimum of three places as shown in figure 3. Be sure that measurements are taken on horizontally level planes. The smallest of these measurements is referred to as the R.O. (rough opening) width, or M.O. (masonry opening) width.

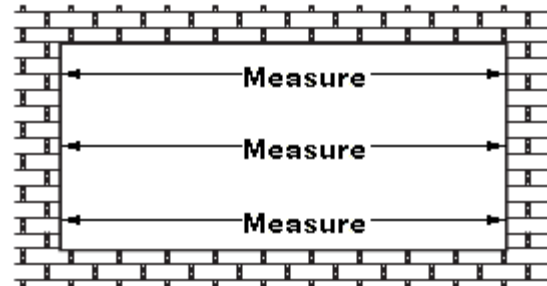


Figure 3

- a. For standard installation methods that do not require special trim pieces at the jambs (jamb receptors, panning systems, or any other installation accessory) deduct $\frac{1}{2}$ " from the R.O. width dimension to determine the F.S. (frame size) width dimension. This dimension leaves a $\frac{1}{4}$ " caulk joint at each jamb to account for thermal expansion, building movement, and other possible issues. If this joint is not large enough to account for these issues, or the sealant being used requires a larger minimum joint, then increase the deduction as required.



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- b. Frame widths over 288" require expansion mullions at a minimum of every 180". A temperature change of 100 degrees Fahrenheit can result in a .18" dimensional change in an aluminum profile every 12'.
4. Measure the opening height at a minimum of three places as shown in figure 4. In longer runs these measurements should be performed every 48". Ensure that measurements are taken in plumb vertical planes. The smallest of these measurements is referred to as the R.O. (rough opening) height, or M.O. (masonry opening) height.

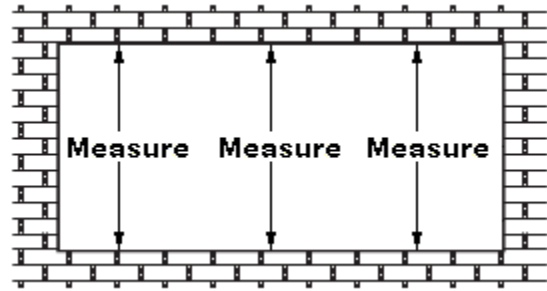


Figure 4

- a. For standard installation methods that do not require special trim pieces (specialty subsills, head receptors, panning systems, or any other installation accessory) deduct 1" from the R.O. height dimension to determine the F.S. (frame size) Height. This allows for a 1/2" deduction for the standard thermally broken subsill, a 1/4" shim space under the subsill, and a 1/4" caulk joint at the head to account for thermal expansion, building movement, lintel deflection, or any other possible issues. If this 1/4" joint is not large enough to account for these issues, or the sealant being used requires a larger minimum joint, then increase the deduction as required.
- b. Consult factory for deductions associated with special pieces or situations.
- c. A temperature change of 100 degrees Fahrenheit can result in a .18" dimensional change in an aluminum profile 12' in length.

2. Fabricate and Size Sill Flashing (Subsill)

A. For Elevations Without Door Frames and Without Splice Joints

1. If frame size width is less than 18', then a splice joint is not required.
2. Cut subsill 1/8" longer than calculated F.S. width and insert rubber gasket.
3. Apply compatible sealant to ends of subsill.
4. Attach End Dams to subsill with #6x3/8" self-tapping screws and apply sealant over head of screws.
5. Apply and tool sealant along outside and inside edges between end dam and subsill.

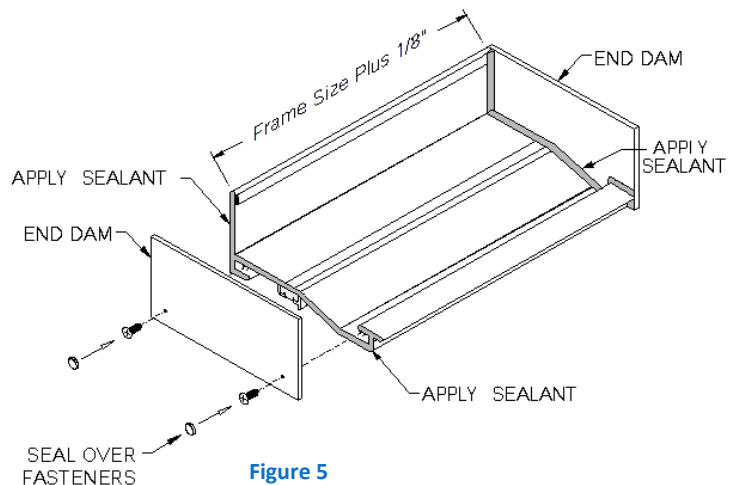


Figure 5



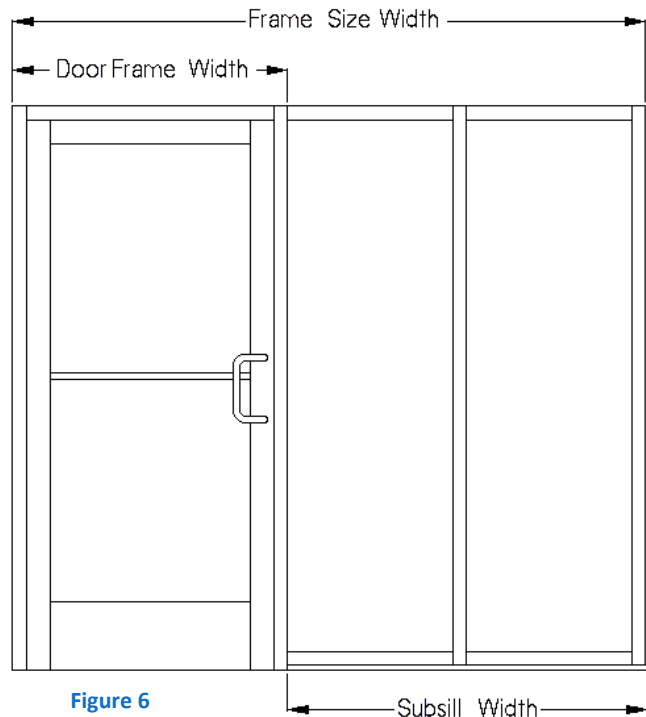
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6. Allow sealant to cure prior to installation.
7. These instructions are generic in nature and meant to convey critical procedures and areas of concern. Actual subsill used may differ from illustration. Contact factory if there is any doubt or confusion.

**NOTE – PROPER ASSEMBLY AND SEALING OF
SUBSILL IS CRITICAL TO SYSTEM PERFORMANCE**

B. For Elevations With Door Frames and Without Splice Joints

1. Determine subsill size by deducting door frame width from frame size width, and then adding 1/16". See Figure 6.
2. If subsill size is less than 18', and frame size width is less than 24', then a splice joint is not required and continue with next step. Otherwise proceed to **C.1** on page 9.
3. Note that during installation, the subsill does not extend under the door jamb. But rather butts up with little or no spacing. Identify which end of subsill will be installed next to door frame jamb. There is no prep performed on this part until installation.
4. Identify end of subsill that will be installed next to terminal sidelite frame. Apply end dam and sealant as per previous section **1.A** on page 7, and figure 5.



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C. For Elevations Requiring Splice Joints in Subsill

1. If frame size width is greater than 24', or subsill size calculated in step 1.B is greater than 18', then a splice joint is required in the subsill for thermal expansion.
2. A splice joint is required at a minimum of every 18' in the subsill.

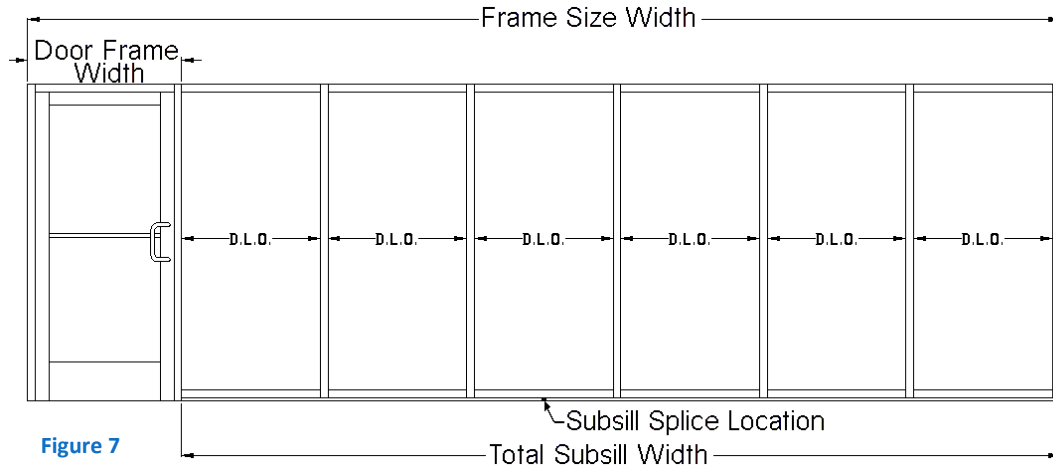


Figure 7

3. Splice joint locations should never correspond to vertical mullion locations in the frames. Splice joints should correspond as close as possible to the center of a D.L.O. (Daylight Openings) located in the frame. Splice joint should also be located as close as practical to the center of the opening. See figure 7.
4. If multiple splice joints are required, then spread out splice joints as evenly as practical while maintaining a center of D.L.O. occurrence.
5. There is no fabrication prep for splice joints other than proper calculation of subsill size, and splice locations. For sizing, deduct $\frac{1}{2}$ " from total subsill width for each splice joint.
6. Properly size and cut subsill, apply end dam to terminal ends as per section 1.A.

D. Consult factory for special conditions not covered in these instructions.

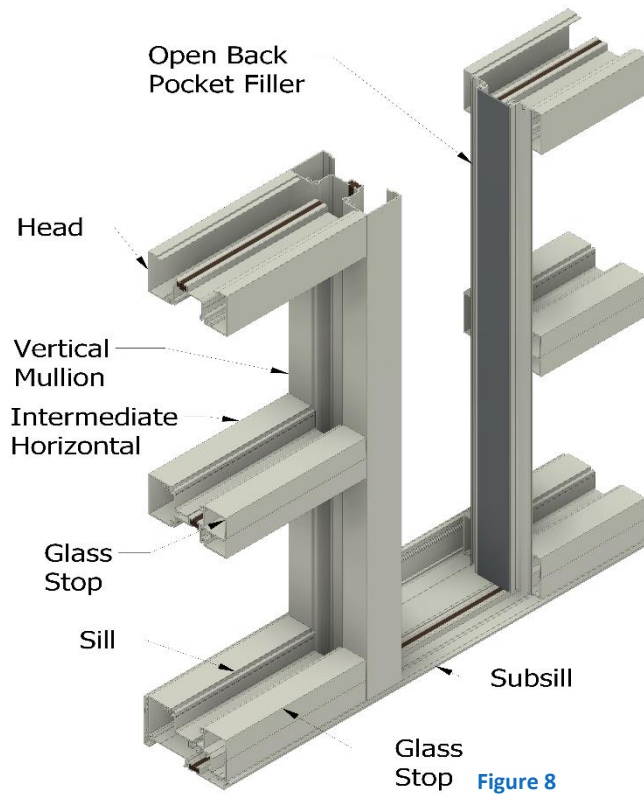


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3. Frame Fabrication – Standard Screw Spline Construction

A. Cut Horizontal Members

1. Cut all head, sill, and intermediate horizontal members to the proper dimension of the opening where they will be utilized.
2. If frame finish is an anodized finish, then cut glass stops $1/16''$ shorter than the associated member in which it will be utilized.
3. If frame finish is a painted finish, then cut glass stops $3/32''$ shorter than the associated member in which it will be utilized.



B. Cut Vertical Members

1. Cut all terminal jambs, intermediate vertical jambs, and pocket filler members to the frame size height as previously determined.
2. Note that door jambs must run to floor and are longer than other verticals. Add sill flashing thickness and associated blocking thickness to door jambs.
3. Special care should be taken to insure that mullions of adjoining sections will fit together properly after assembly (see figure 9). Be sure that all openings have at least one "Deep Pocket" jamb member or proper assembly and glass installation will be impossible.

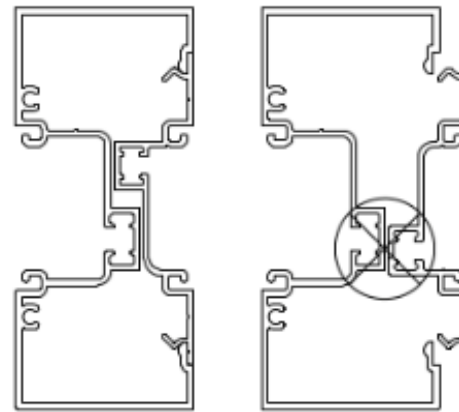


Figure 9



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C. Screw Spline Hole Layout and Fabrication

1. Locate and drill screw holes in all vertical frame members using one of these methods.
 - a. Using a short piece of horizontal member as a template, center the template on the face of the vertical and mark the location of each screw spline. Drill a $\frac{7}{32}$ " diameter hole at each location marked. See Figure 10.
 - b. Layout and drill hole locations as shown in figures 11, 12, and 13 for the correct series.

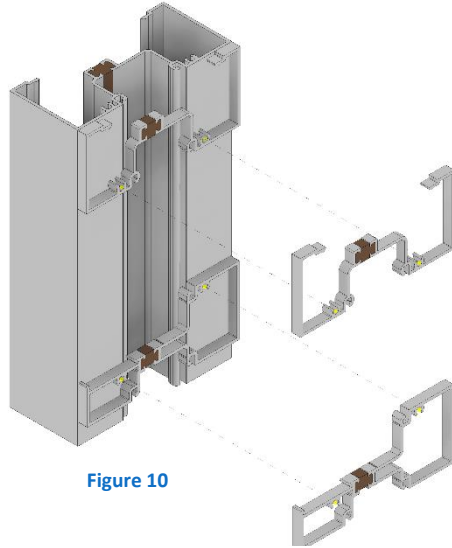
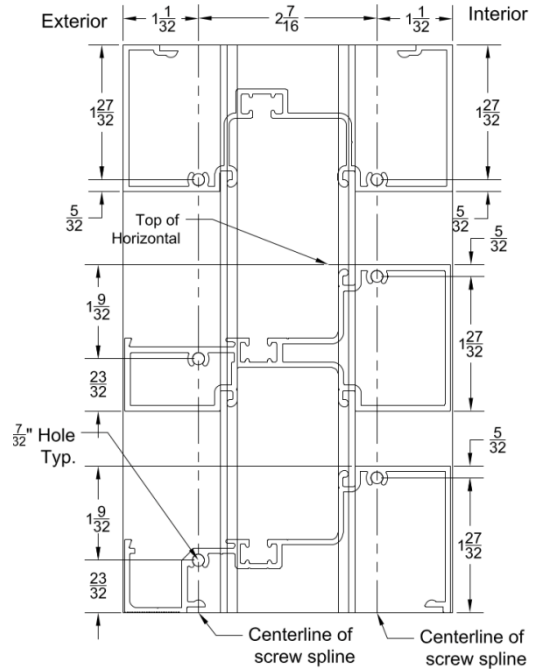


Figure 10



Layout Dimensions For:
1450 Series
2450CG Series
2450CGxpt Series

Figure 11

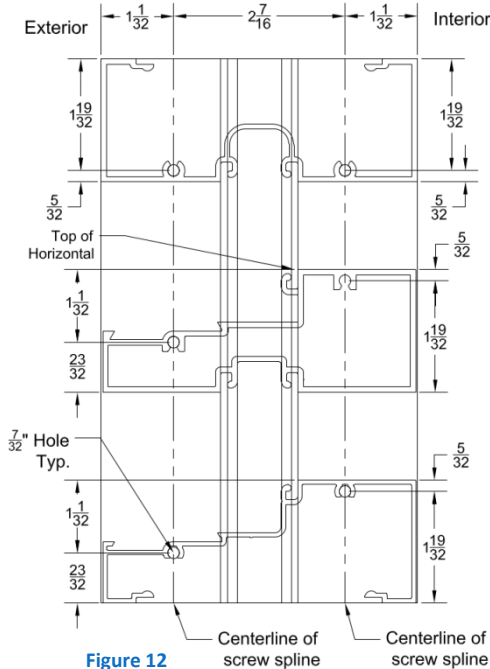
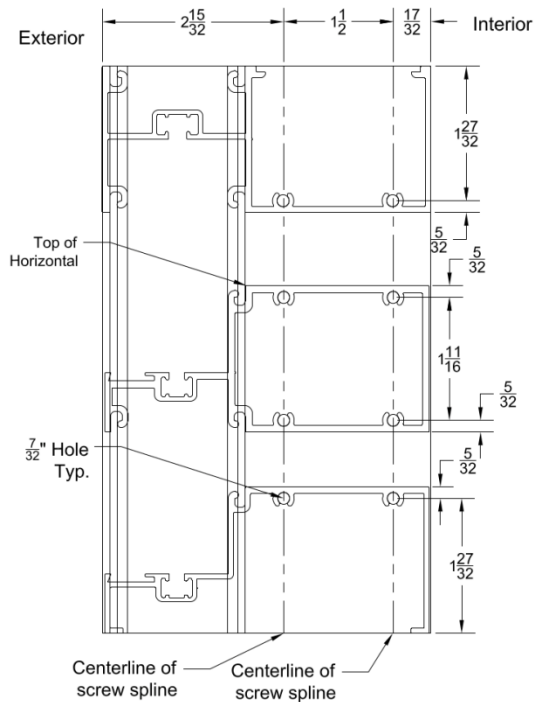


Figure 12

450 Series Layout



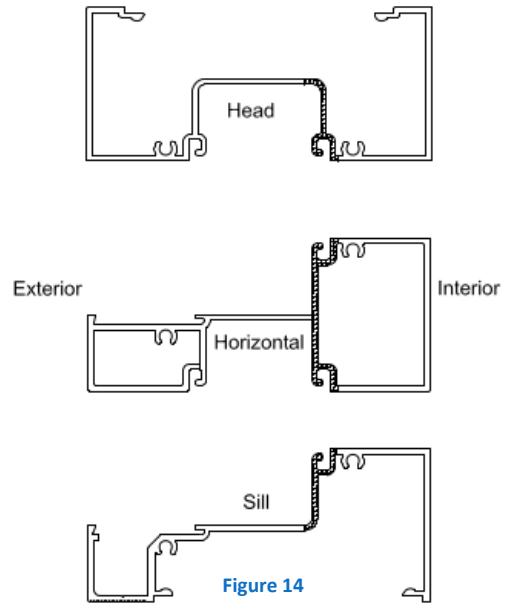
2450FS Layout Dimensions



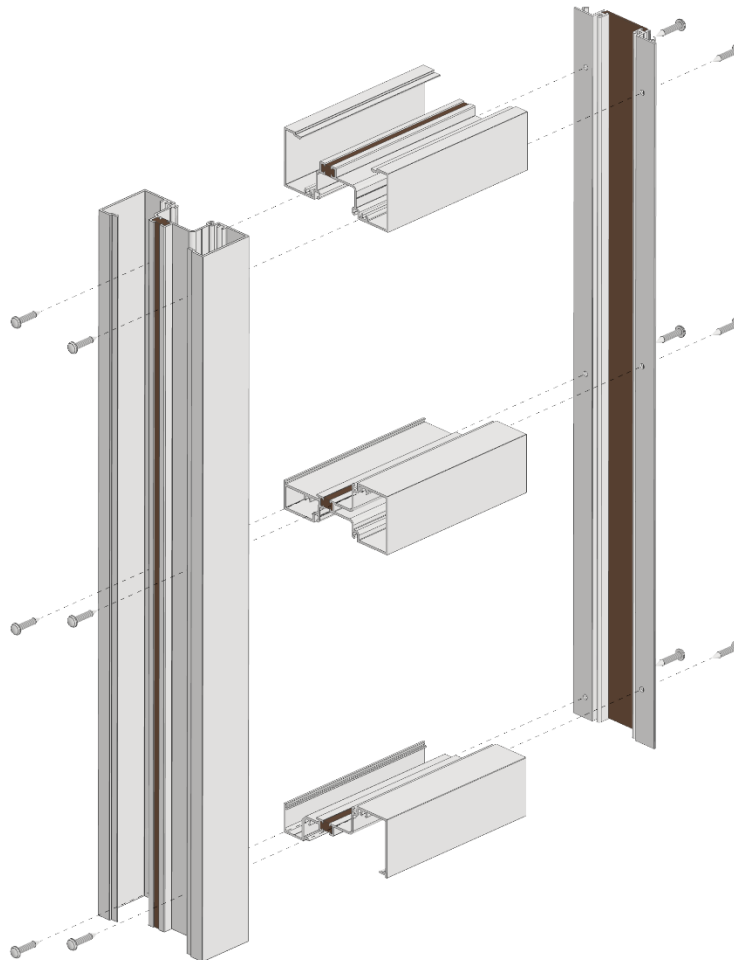
General Storefront Installation Instructions

D. Frame Assembly

1. Check that all horizontal member cuts are smooth, straight, and free of debris.
2. Clean all joint surfaces using cleaner approved by sealant manufacturer.
3. Apply sealant to both ends of horizontal members at shaded areas depicted in figure 14 just prior to assembly.
4. Attach head, horizontal, and sill members to verticals with FRS-1 Frame Screws.
5. Tool sealant into joints as required in areas shown in figure 14. Special attention should be given to areas where horizontal members terminate into vertical members.
6. Wipe away excess sealant.



Apply sealant to shaded areas at each end of horizontal members.



Subsill Installation

1. Install Sill Flashing

A. Check Openings

1. Carefully check the openings and surrounding conditions that will receive your material. Remember, if the construction is not per the construction documents, it is your responsibility to notify the general contractor in writing. Any discrepancy must be brought to the general contractor's attention before you proceed with the fabrication and installation.
2. Check each opening for square, plumb, and level at all sides and corners. See Figures 15 and Figure 16 for maximum allowable deviations.

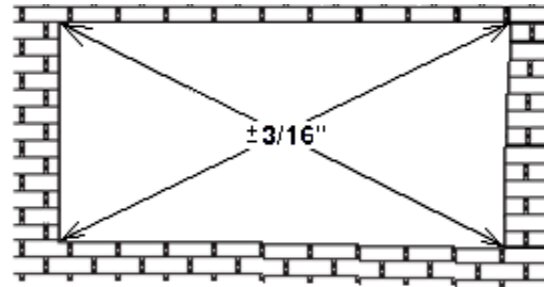


Figure 15

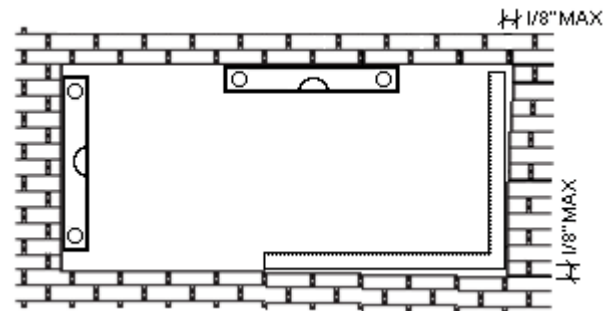


Figure 16

B. Installation of Subsill with No Doors in Opening

Note – If doors are present in opening, locate and install door frames prior to subsill installation

1. Place previously sized and fabricated subsill (refer to “Fabricate and Size Sill Flashing” on page 7 of these instructions) into opening. Starting at the location of the smallest R.O. height, install 1/4” shim (minimum recommended height) and anchor to structure at that location with appropriate anchor. Verify subsill is level as per figure 18. Working out from initial anchor location, shim subsill level (see figure 17 and figure 18) and anchor to structure every 12” to 24” on center as appropriate for anchor types* and to maintain level. Also anchor subsill to structure at a maximum of 4” from each end. Seal all anchors thoroughly.

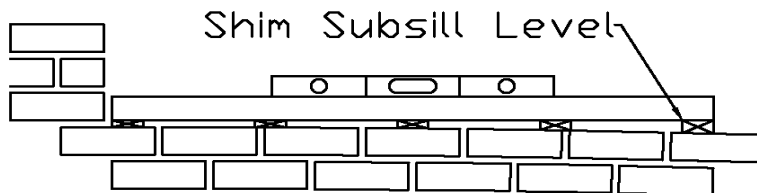


Figure 17

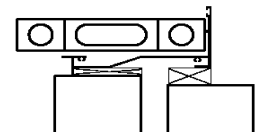


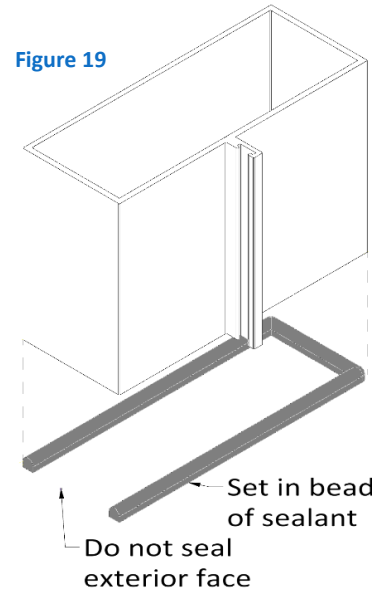
Figure 18

*Engineering note – if mullion end reactions exceed 500lbs, anchor locations need to be coordinated with mullion locations and verified by engineer of record. Structural reinforcement may be required.

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C. Installation of Subsill at Door Frame

1. Correctly Locate the entrance frame in opening
2. Apply a bead of sealant around the interior portion of the jamb to set frame member into. The intent is to have a continuous bead of sealant at the interior of the frame connected to the subsill condition on one side, and then continuing through to the threshold on the other side of frame member (Figures 19 and 20).
3. Set assembled door frame in opening plumb and level. Anchor frame as required. Note that hardware function, door type, and operation might dictate anchorage methods. See section on door frame installation for more details.
4. Seal end of subsill that terminates at door frame jamb. Do not install end dam at this location (Figure 21).
5. Completely fill door jamb cavity and ramp sealant down onto subsill to drain any infiltrating water onto subsill (Figure 22).
6. Apply and tool sealant to all subsill and door frame joints (Figure 22).



Note: Door Jamb extends to finish floor and is longer than other vertical members.

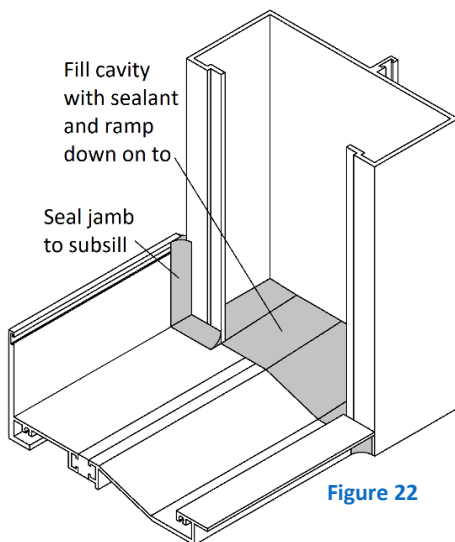
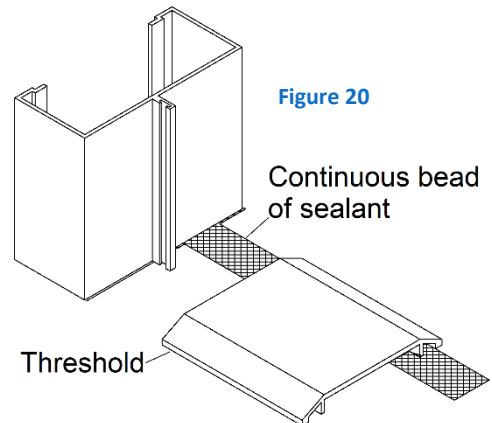


Figure 21

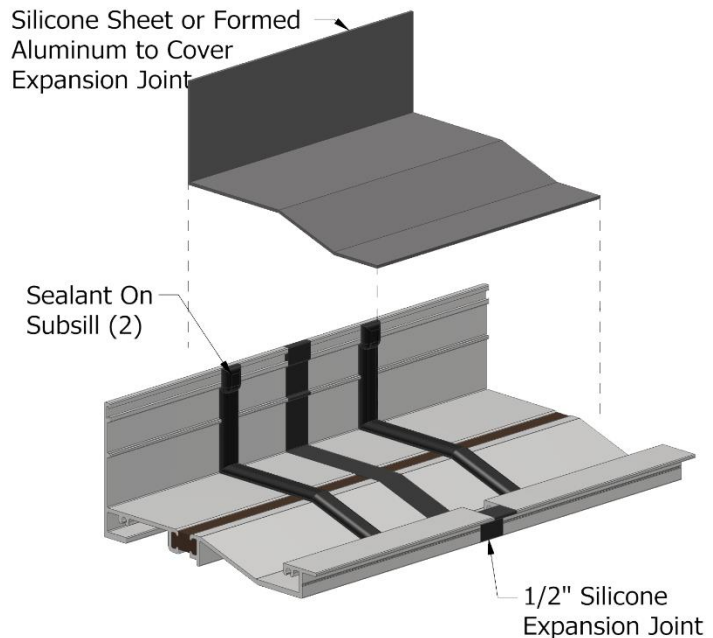
Fill end of subsill at door frame jamb

D. Prep of Splice Joint



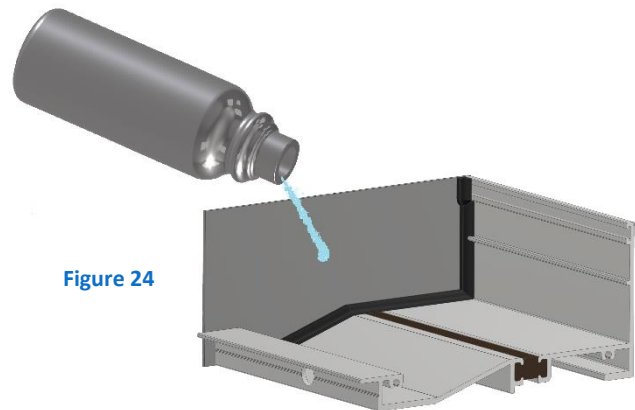
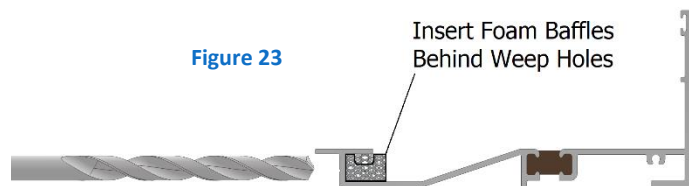
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1. Verify that splice joint gap is approximately $\frac{1}{2}$ " wide.
2. Fill gap with compatible sealant to level of subsill member.
3. Run generous beads of sealant approximately 1" from splice gap on subsill surface.
4. Apply splice sleeve as shown. Tool edges to guarantee seal.
5. Fill and tool back side of splice joint.



- E. Drill weep holes and verify that installed and anchored subsill is level and watertight.

1. Drill $\frac{5}{16}$ " (minimum) weep holes (figure 23) approximately 4"-6" from each end of subsill.
2. Test subsill by filling with water (figure 24) and verifying that no leaks exist, and that water drains completely and evenly.
3. Drill additional weep holes as required. Opening size, exposure, frame configuration, and series can dictate minimum number and location of weep holes required. However, most conditions require weep holes located approximately 4" from each vertical frame member. Consult factory if in doubt. Install foam baffles behind weep holes (figure 23).

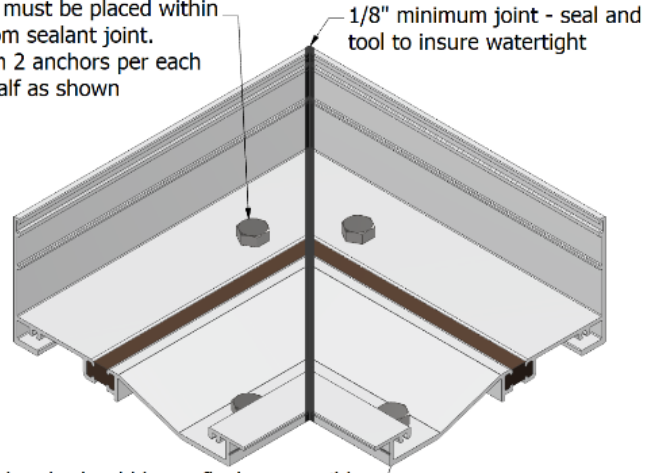


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F. Subsill installation at corners

1. Cut subsill members to appropriate angles.
2. Do not use end dams at corners. Seal ends of subsills with compatible sealant (Figure 25).
3. Abut subsill corner members then seal and tool joint weathertight.
4. Place anchors within 1"-3" of corner on both sides of joint (Figure 25).

Anchors must be placed within 1"-3" from sealant joint. Minimum 2 anchors per each subsill half as shown

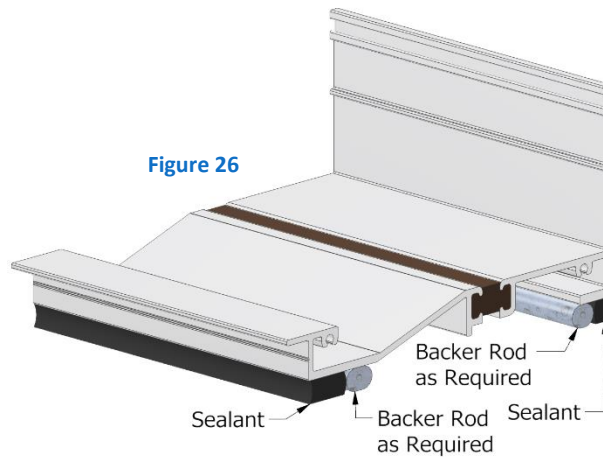


Anchor heads should be as flush as possible and sealed watertight. Shown here enlarged and without sealant for clarity.

Figure 25

- ## G. Apply appropriate compatible sealant to interior and exterior of subsill (figure 26) using backer rod where required. Tool sealant as required to assure watertight seal. Comply with sealant manufacturers written instructions.

Figure 26



- ## H. Form continuous bead of sealant around end dam between end dam and wall. Start at seal between exterior subsill and floor then extend up and around end dam and continue to seal between subsill and floor on interior. Tool as required to guarantee watertight seal (Figure 27).

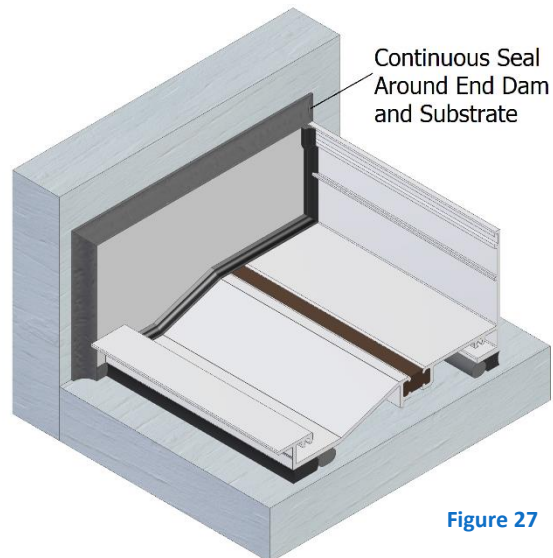


Figure 27



Frame Installation

1. Installation without a Head Receptor

A. Install flat fillers at all head and jamb anchor locations to aid in shimming and anchoring frame (figure 28).

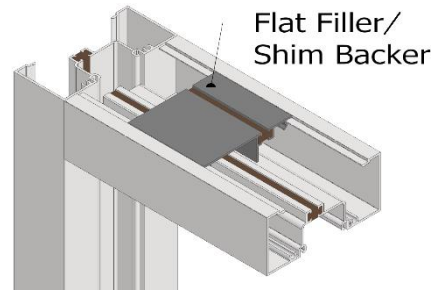


Figure 28

B. Snap assembled frame sections together.

C. Apply sealant to the exterior side of the upturned leg on the subsill as per figure 29.



Figure 29

D. Set assembled frame sections on to subsill.

E. Push frame firmly against upturned leg of subsill to fully engage sealant and gasket. Screw alignment groove on sill member should line up directly above the screw race in subsill.

F. Install FRS-68 anchor screws.

1. Install anchors through sill within 3" of each vertical mullion, and on 18" centers between mullions*.

2. Drill 1/8" pilot holes thru sill and subsill as shown in figure 30. Care must be taken so that anchor hole only penetrates first face of subsill. Anchor Hole or anchor is not to penetrate bottom wall of subsill.

3. Install FRS-68 screws into holes.

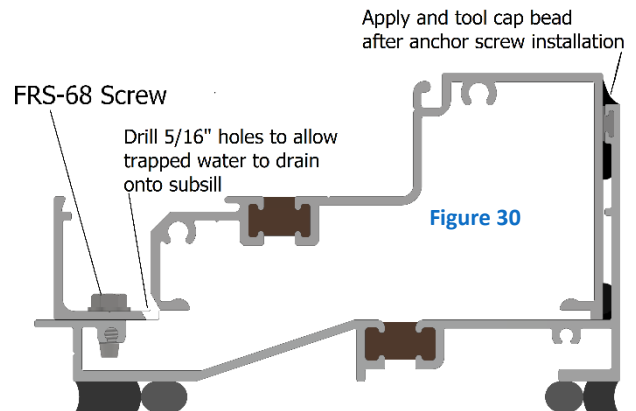


Figure 30

G. Apply cap bead between top of the interior leg of subsill and exposed vertical face of sill member. See figure 30.

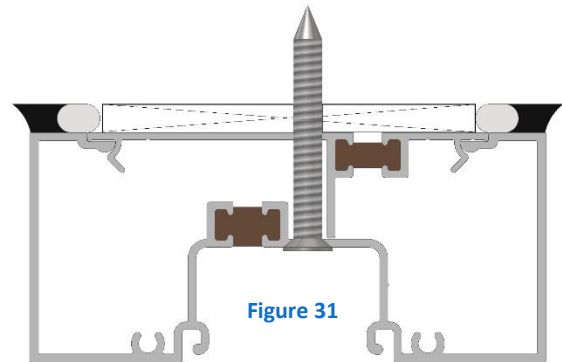
*Engineering note – if mullion end reactions exceed 500lbs, anchor locations and quantities need to be verified by engineer of record. Additional anchors may be required.

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H. Install shims as required at head and jambs to ensure that framing is level and plumb. Shims must be installed at all anchor locations.

I. Install anchors.

- 1.** Install anchors within 3" of each vertical mullion, and on 18"-24" centers between mullions*.
- 2.** Anchors should be countersunk and anchors should not extend in to glass pocket.
- 3.** Seal all anchor heads watertight.



J. Install backer rod around the perimeter at head and jambs.

K. Apply (and tool as required) perimeter sealant to joint between frame and structure.

*Engineering note – if mullion end reactions exceed 500lbs, anchor locations and quantities need to be verified by engineer of record. Additional anchors may be required.



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General Storefront Installation Instructions

3. Glass Installation

- A. Install water diverters at all intermediate horizontals.
 - 1. Attach water diverters by applying sealant under, and along edges of deflector and on to the horizontal.
 - 2. Apply sealant to the vertical intersection of the horizontal and vertical member (see figure 32).
 - 3. Tool all sealant to ensure watertight joints.

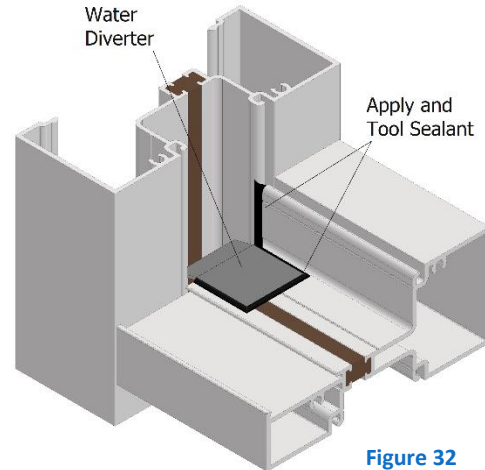


Figure 32

- B. Install glazing gaskets. Glazing gaskets are prone to shrinkage and pulling away from corners over time. This allows for excessive air and water infiltration. Special treatment must be given to corners in anticipation of this.

- 1. Cut gaskets to length (proper gasket length is D.L.O. plus 1/4" per foot to allow for shrinkage).
- 2. Install gaskets as per figure 33. Note that interior gasket is installed prior to glass installation, and exterior gasket is installed after glass installation.
- 3. Insertion of exterior gasket should be somewhat stiff and the use of a vinyl gasket installation roller/tool may be necessary (Figure 34). Always work from the center out to the ends during gasket installation.

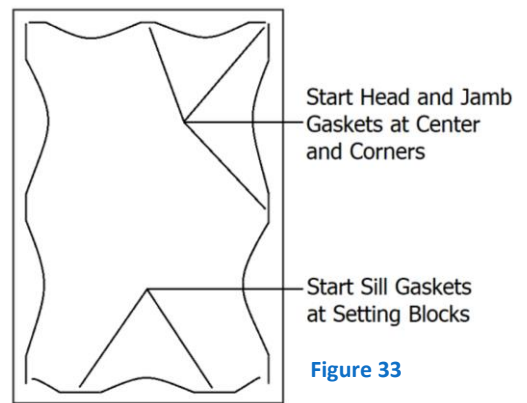


Figure 33

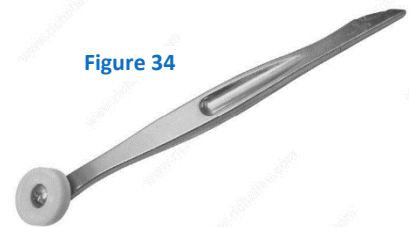


Figure 34

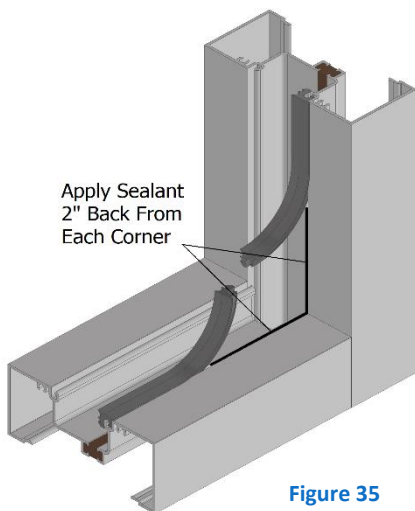


Figure 35

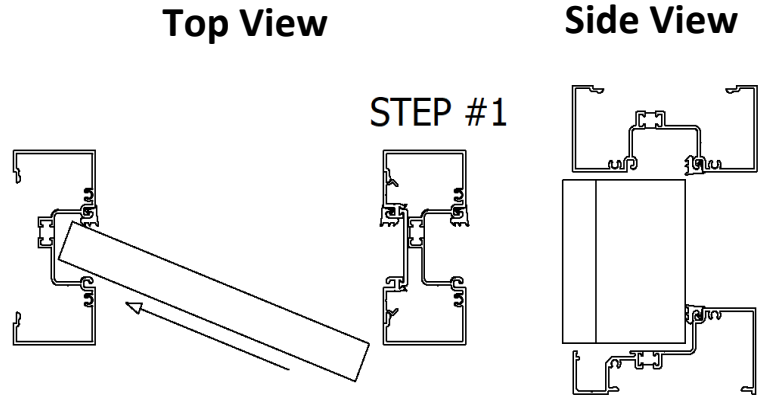
- 4. Pull gaskets back approximately 2" in both directions at all corners and apply sealant into glazing gasket reglet (figure 35).



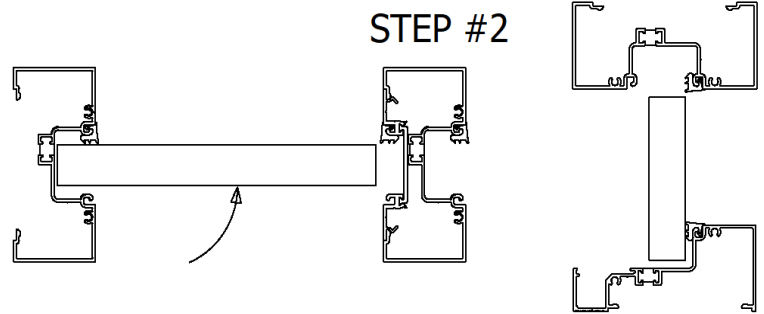
General Storefront Installation Instructions

C. Installation of glass.

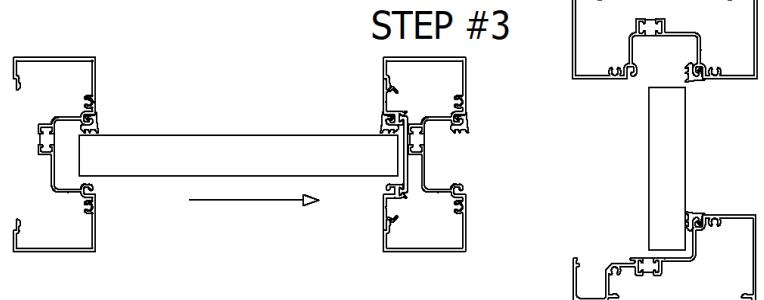
1. Carefully install the glass into the opening by first angling the glass into the deep pocket as far as possible as shown in the Step #1 illustration.



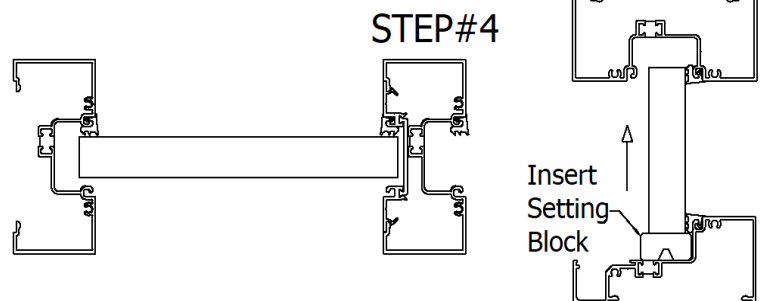
2. Rotate glass into glazing pocket as per Step #2 illustration.



3. Slide glass horizontally into the shallow pocket so that it is centered in the frame opening as per Step #3 illustration.

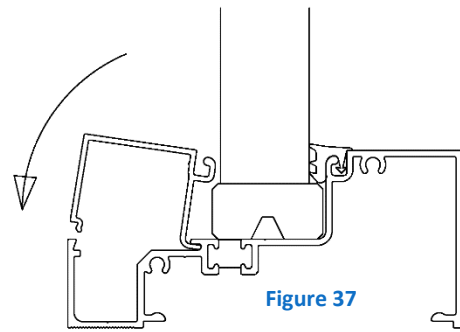
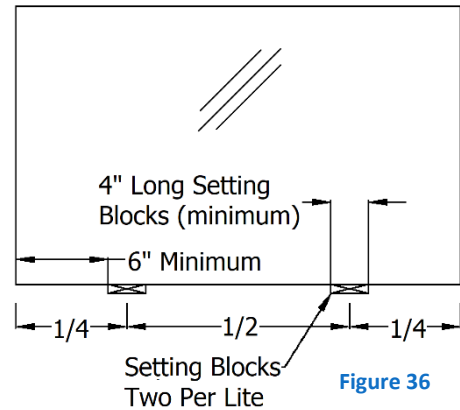


4. Lift glass up into glazing pocket and install setting block as per instructions.



General Storefront Installation Instructions

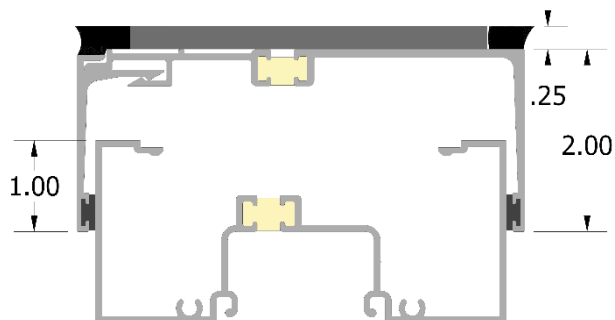
- D.** Install two identical setting blocks in each opening. (Reference Figure 36)
- 1.** Setting block should always be installed at $\frac{1}{4}$ points if possible. Consult Manufacturers' printed dead load chart for verification.
 - a.** If glass weight and width do not allow for installation at $\frac{1}{4}$ points, then install in accordance with manufacturers' dead load charts.
 - b.** Never place setting blocks closer than 6" from edge of glass.
 - c.** Consult factory if in doubt.
 - 2.** Use only factory supplied setting blocks and only the blocks proper for system being used.
 - 3.** Verify that setting blocks do not impede water drainage in framing.
- E.** Snap the glass stop into place as shown in figure 37.
- F.** Install exterior gasket as per section **3.B.**



Appendices

1. Installation with a Head Receptor

A. The primary purpose of head receptor parts 2490/2491 is to allow for minor irregularities in the rough opening height, and to allow for minor head deflection in the supporting framework at the head of the rough opening.



B. If vertical mullion end reactions exceed 500lbs, then anchorage and suitability of receptor system must be verified by design professional of record.

C. The procedure for checking the rough opening, and the calculation of frame size when using head receptor, is identical to standard method described on pages 6 and 7. An additional 1" is deducted from R.O. height to calculate F.S. height (Total height deduction is 2" in most circumstances). This allows for plus or minus ½" deflection.

D. Head receptor engagement of frame should never be less than ½".

E. Fabrication and installation of head receptor.

1. Proper length of head receptor is equal to the frames size plus ¼".

2. Install R-9013 rubber into receptor back and face prior to installation.

3. Starting at the location of the smallest R.O. height, install 1/4" shim (minimum recommended height) and anchor to structure at that location with appropriate anchor. Working out from initial anchor location, shim and anchor to structure every 12" to 24" on center as appropriate for anchor types. Also anchor receptor to structure at a maximum of 3" from each end. Seal all anchors thoroughly.

4. Seal between end of receptor and wall. Tool as required to guarantee watertight seal.

5. Insert frame into opening and anchor sill members to subsill using procedures starting on 1.B. on page 17. Once sill is anchored, snap on head receptor face stop.

6. Seal receptor to substrate at head on interior and exterior.



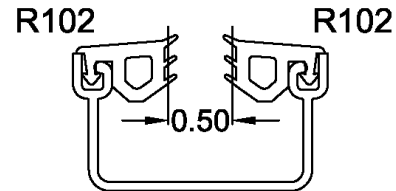
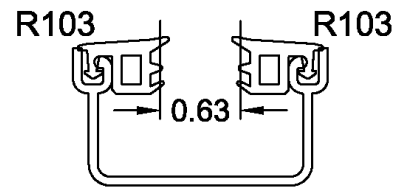
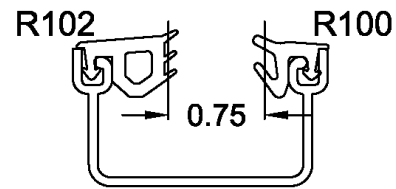
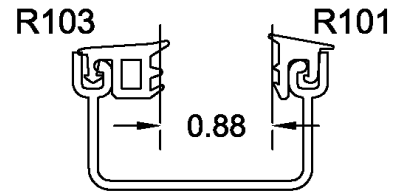
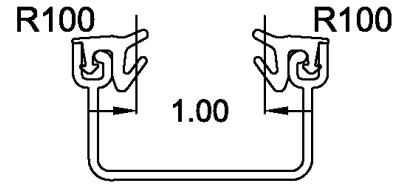
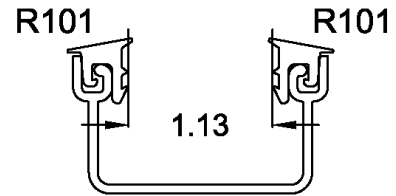
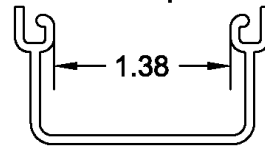
General Storefront Installation Instructions

2. Glazing Infill Thickness Options

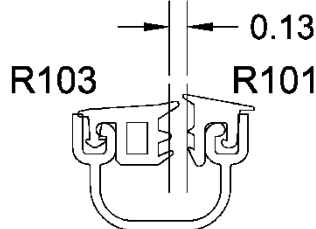
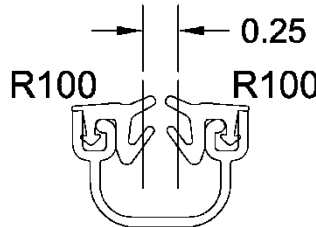
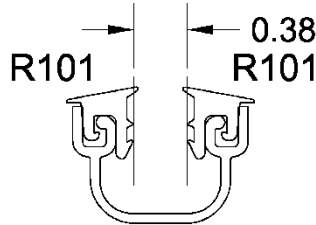
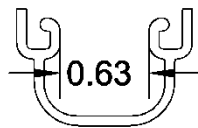
A. Industry standards usually call for 1" or ¼" glazing in most flush glazed systems. However, variations in glass types (especially laminated) and air spacers in insulated units can cause a typical 1" overall unit to vary in thickness. Further glazing options such as spandrel units, composite panels, or insulated glazing panels can require various "non standard" glazing pocket sizes. To accommodate this, different rubber gasket options are available to adapt the pocket to accept the glazing.

B. All flush glazing system pockets can be separated into two categories. Those that have 1-3/8" pockets, and those that have 5/8" pockets. See illustrations on this page for gasket options to obtain nominal glazing infill thickness options.

Standard 1 3/8" Pocket Options



Standard 5/8" Pocket Options



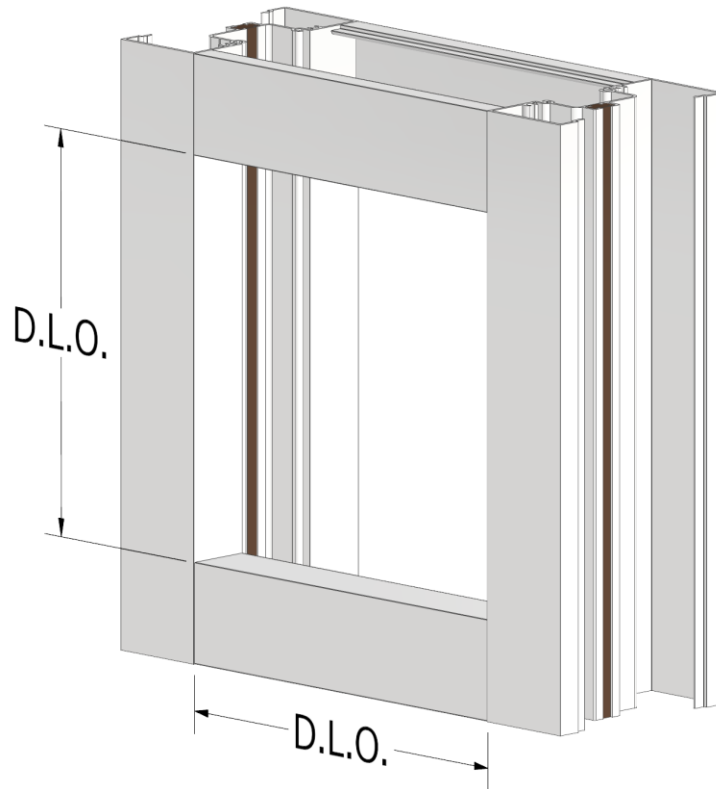
General Storefront Installation Instructions

3. Glass Sizing

A. Glass sizing on all flush glazed framing systems are based on the daylight opening size (D.L.O.) of the frame openings. The D.L.O. is simply the clear opening dimension between the metal frame members that the glass will set into.

B. Glass sizing for frames that have 1-3/8" wide pockets (1450, 2450cg, 2450fs, 2450cgxpt, 2600xpt), use the D.L.O. dimension plus 3/4" for calculating glass size for both width and height*.

C. Glass sizing for frames that have 5/8" wide pockets (450, 471), use the D.L.O. dimensions plus 5/8" for calculating glass size for both width and height*.



*NOTE: These formulae do not take into account glazing tolerances.

