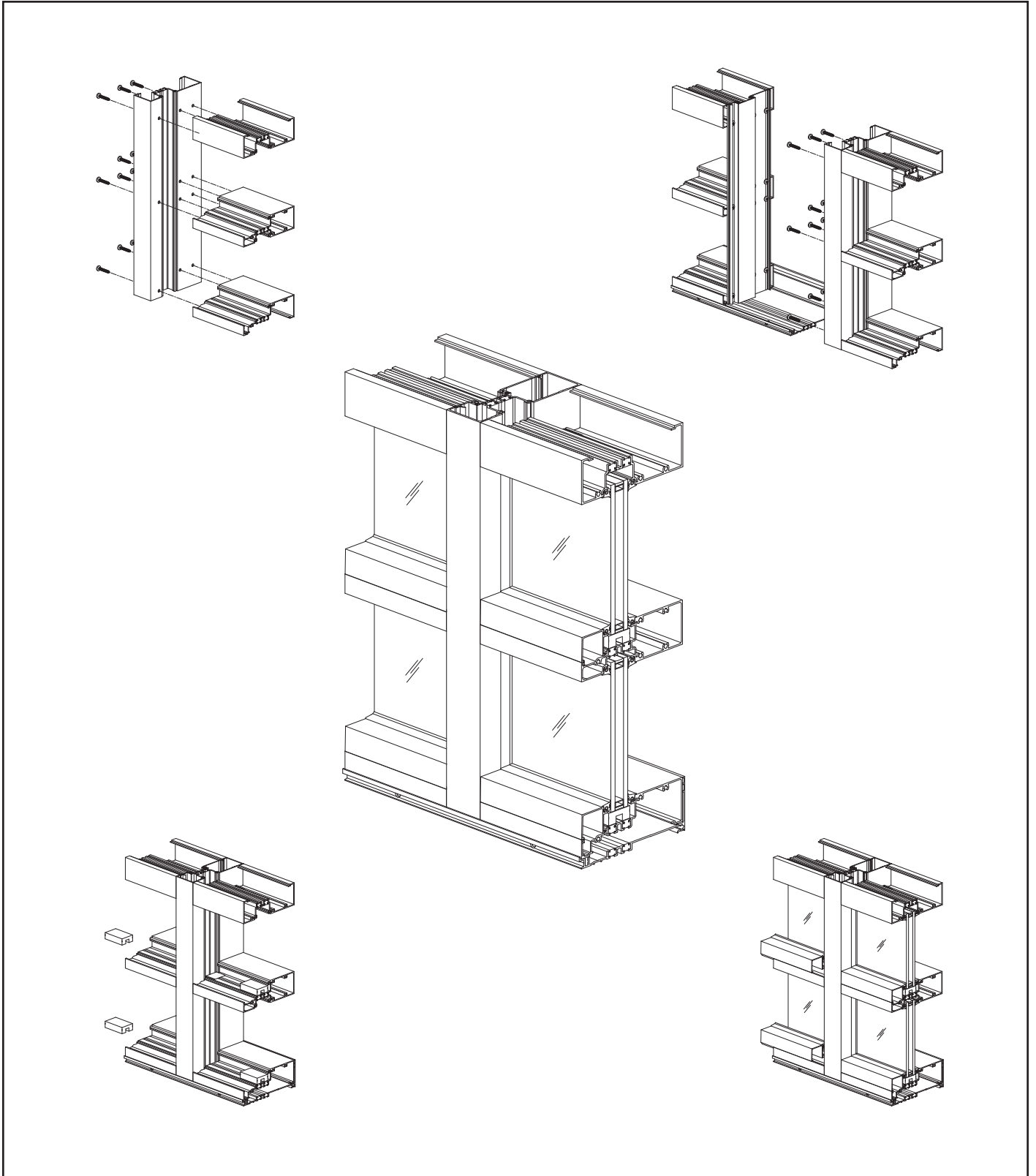


**YES 60 XT Storefront System**



**Installation Manual**








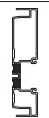


















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## Installation Notes



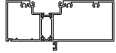





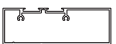






1. Do not drop, roll or drag boxes of aluminum framing. Move and stack boxes with proper support to prevent distortion. If fork lifts are used be especially careful about striking the boxes when lifting or moving.
2. Store in a dry, out of the way area. If rain exposure, condensation or any water contact is likely, then all packaging material should be removed. Wet packaging materials will discolor and may stain aluminum finishes and paints.
3. All materials should be checked for quality and quantity upon receipt, YKK AP must be notified immediately of any discrepancies in shipment. Check to make sure that you have the required shims, sealants, supplies and tools necessary for the installation.
4. Carefully check the openings and surrounding conditions that will receive your material. Remember, if the construction is not per the construction documents, it is your responsibility to notify the general contractor in writing. Any discrepancies must be brought to the general contractor's attention before you proceed with the installation.
5. Gather your shop drawings, materials, packing list, and this installation manual. Carefully review parts location, the sequence it goes therein, when you glaze it and how you seal it. Installation instructions are of a general nature and may not cover every condition you will encounter. The shop drawings and/or installation manuals were prepared specifically for the product.
6. Any material substitutions must be of equal or greater quality.
7. Make certain that material samples have been sent for compatibility testing for all manufacturer's sealants involved. Make certain sealants have been installed in strict accordance with the manufacturer's recommendations and specifications.
8. Remember to isolate, in an approved manner, all aluminum from uncured masonry or other incompatible materials.
9. System-to-structure fasteners are not supplied by YKK AP. Fasteners called out on shop drawings are to indicate minimum sizes for design loading.
10. Entrances are to be installed plumb, square, level, and true.
11. If any questions arise concerning YKK AP products or their installation, contact YKK AP for clarification before proceeding.
12. YKK AP storefront and/or curtain wall framing is typically completed before drywall, flooring and other products which may still be in process. Take the extra time to wrap and protect the work produced.
13. Cutting tolerances are plus zero (0"), minus one thirty second (-1/32") unless otherwise noted.
14. Check our website, [www.ykkap.com](http://www.ykkap.com), for the latest installation manual update prior to commencing work.

YES 60 XT FRAMING MEMBERS

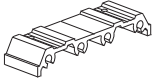

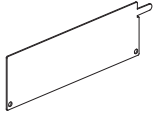



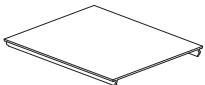

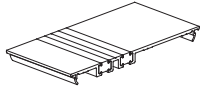

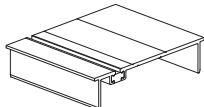

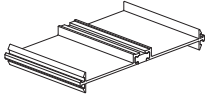

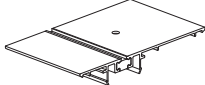

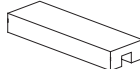






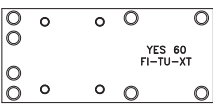
	<b>Mullion</b> 2" x 6"	BE9-2922		<b>Head Receptor Stop</b>	E9-1033
	<b>Head / Jamb</b>	BE9-2919		<b>Expansion Mullion</b> (Male)	BE9-2936
	<b>Horizontal</b>	BE9-2918		<b>Expansion Mullion</b> (Female)	BE9-2935
	<b>Sill</b>	BE9-2917		<b>90° Corner Cover (Male)</b>	E9-2938
	<b>Glass Stop</b>	E9-1015		<b>90° Corner Cover (Female)</b>	E9-2939
	<b>Flat Filler</b>	BE9-2920		<b>Adaptor for High Sill Cover</b>	BE9-2937
	<b>Sill Flashing</b>	BE9-2916		<b>135° Corner Mullion</b>	BE9-2940
	<b>Heavy Duty Mullion</b> 2" x 6"	BE9-2921		<b>Pocket Filler</b>	BE9-2570
	<b>Heavy Duty Mullion</b> 2-1/4" x 6"	BE9-2942		<b>Glazing Adaptor</b> For 1/2", 5/8" & 3/4" glazing	E9-1039
	<b>Pocket Filler</b>	BE9-2910		<b>Glazing Adaptor</b> For 3/16", 1/4", 5/16", & 3/8" glazing	E9-1040
	<b>Deep Pocket Filler</b>	BE9-2912		<b>2-1/2" x 3/4" Face Cover *</b> For Custom Mullions and Horizontals	E9-1206
	<b>Head Receptor</b>	BE9-7361		<b>5" x 3/4" Face Cover *</b> For Custom Mullions and Horizontals	E9-3542

\* Other sizes available. Contact YKK AP for more information.

## YES 60 XT DOOR FRAMING MEMBERS

	<b>Door Jamb</b>	<b>BE9-2923</b>		<b>Door Stop</b> For 35XT, OHCC	<b>AS-0718</b>
	<b>Door Head</b>	<b>BE9-2924</b>		<b>Door Stop O/P Assembly</b> E9-0409 and E2-0051	<b>AS-0409</b>
	<b>Transom Adaptor</b> For 35XT / 50XT Doors	<b>BE9-1591</b>		<b>Door Stop Base</b> Used with AS-0409	<b>E9-1113</b>
	<b>Transom Glass Stop</b> For 35XT / 50XT Doors	<b>E9-1592</b>		<b>Transom Glass Stop</b> For 1" glazing	<b>E9-0413</b>
	<b>6" x 2" Door Head O/P</b> For Non-Thermal Doors	<b>AS-9480</b>		<b>Transom Glazing Pocket</b> For 1" glazing	<b>E9-0435</b>
	<b>6" Door Jamb</b> For Non-Thermal Doors	<b>AS-9562</b>		<b>Threshold</b> For Non-Thermal Doors	<b>E9-0407</b>
	<b>6" x 2" Door Head OHCC</b>	<b>E9-2945</b>		<b>Threshold</b> For 35XT / 50XT Doors	<b>BE9-1535</b>
	<b>Door Stop</b> For OHCC	<b>AS-0215</b>			

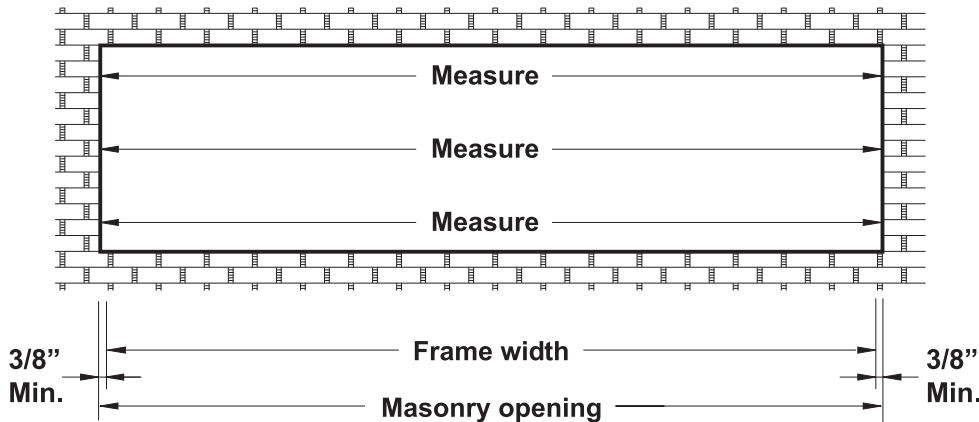
## YES 60 XT ACCESSORIES

	<b>Shear Block</b> For Transom Bar E9-2945	<b>E1-0317</b>		<b>Glazing Gasket</b> 3/16" F.C.	<b>E2-0052</b>
	<b>End Dam</b> For Sill Flashing BE9-2916	<b>E1-9989</b>		<b>Glazing Gasket</b> 1/8" F.C.	<b>E2-0053</b>
	<b>Splice Sleeve</b> For Sill Flashing BE9-2916	<b>E2-0070</b>		<b>Glazing Gasket</b> 1/4" F.C.	<b>E2-0064</b>
	<b>PVC Flat Filler</b> 12'-0" Long	<b>E3-9905</b>		<b>Elastomer Weathering</b> For Head Receptor	<b>E2-0051</b>
	<b>Flat Filler</b> Use at all anchor locations	<b>E1-2901</b>		<b>Weathering Gasket</b> For Expansion Mullion	<b>K2-2441</b>
	<b>Optional Head Anchor</b> 4" Long	<b>E1-2905</b>		<b>#10 x 3/4" FHSMS Type AB</b> Zinc Plated Steel For Attachment of Horizontal to Shear Block E1-0317	<b>FC-1012</b>
	<b>Mullion Clip</b> 3" Long	<b>E1-2906</b>		<b>#10-24 x 1/2" PHMS</b> Stainless Steel For Attachment of Sill to Sill Flashing	<b>PM-1008- SS</b>
	<b>Sidelite Base Clip</b> For compound horizon- tals, 3" Long	<b>E1-2907</b>		<b>#12 x 3/4" UFHSMS Type A</b> Zinc Plated Steel For End Dam Attachment	<b>UA-1212</b>
	<b>Setting Block</b> For outside glazed Horizontal & sill	<b>E2-0068</b>		<b>#12 x 1" PHSMS Type AB</b> Zinc Plated Steel For Screw Spline Attachment	<b>PC-1216</b>
	<b>Water Deflector</b>	<b>E2-0047</b>		<b>#12 x 1-1/4" PHSMS Type AB</b> Zinc Plated Steel, For Screw Spline Attachment When Using BE9-2919 as Vertical	<b>PC-1220</b>
	<b>"W" Side Block</b> For Deep Pocket	<b>E2-0153</b>		<b>#12 x 1-1/4" PHSMS</b> Type AB, Zinc Plated Steel For Attachment of Shear Block E1-0317 to Vertical	<b>PC-1228</b>
	<b>Pile Weathering Seal</b>	<b>E2-0062</b>		<b>Drill Fixture</b>	<b>H-7204</b>

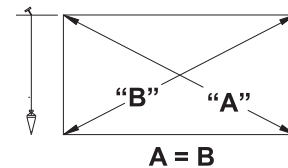
## FRAME FABRICATION

### STEP 1 DETERMINE FRAME SIZE

#### Determine Frame Width:



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

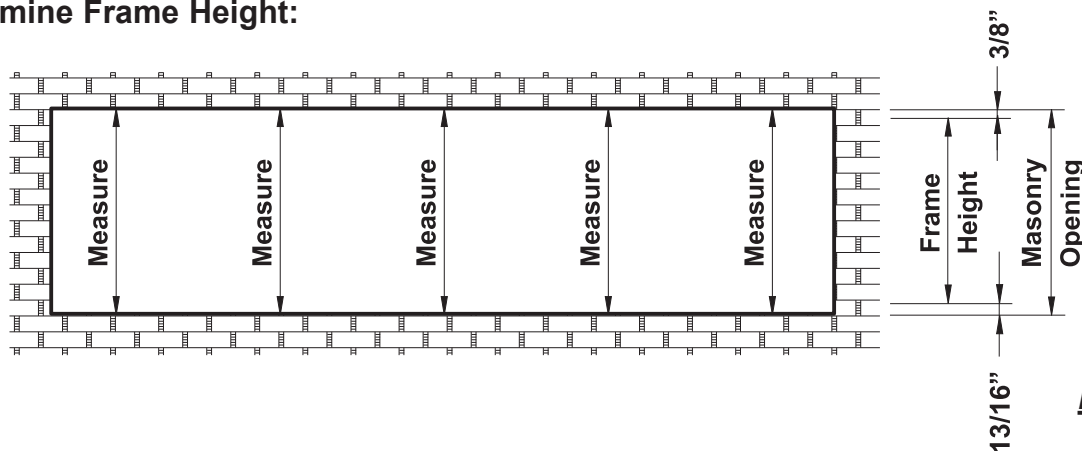


**Detail 1**

- Measure the width of the masonry opening at the top, middle and bottom.
- Select the smallest dimension measured and subtract 3/4" to the determine the frame width to be used. See **Detail 1**.

**NOTE:** Frame widths over 24'-0" require expansion mullions every 12 to 15 feet (best location at vertical next to the door jamb.)

#### Determine Frame Height:



**Detail 2**

- Measure the height of the masonry opening in several places along the entire length of the opening.
- Select the smallest dimension measured and subtract 1-3/16" to determine the frame height to be used:

Minimum 3/8" shim/caulk joint at the head.

7/16" for sill flashing.

Minimum 3/8" shim/caulk joint below the sill flashing.

See **Detail 2**.



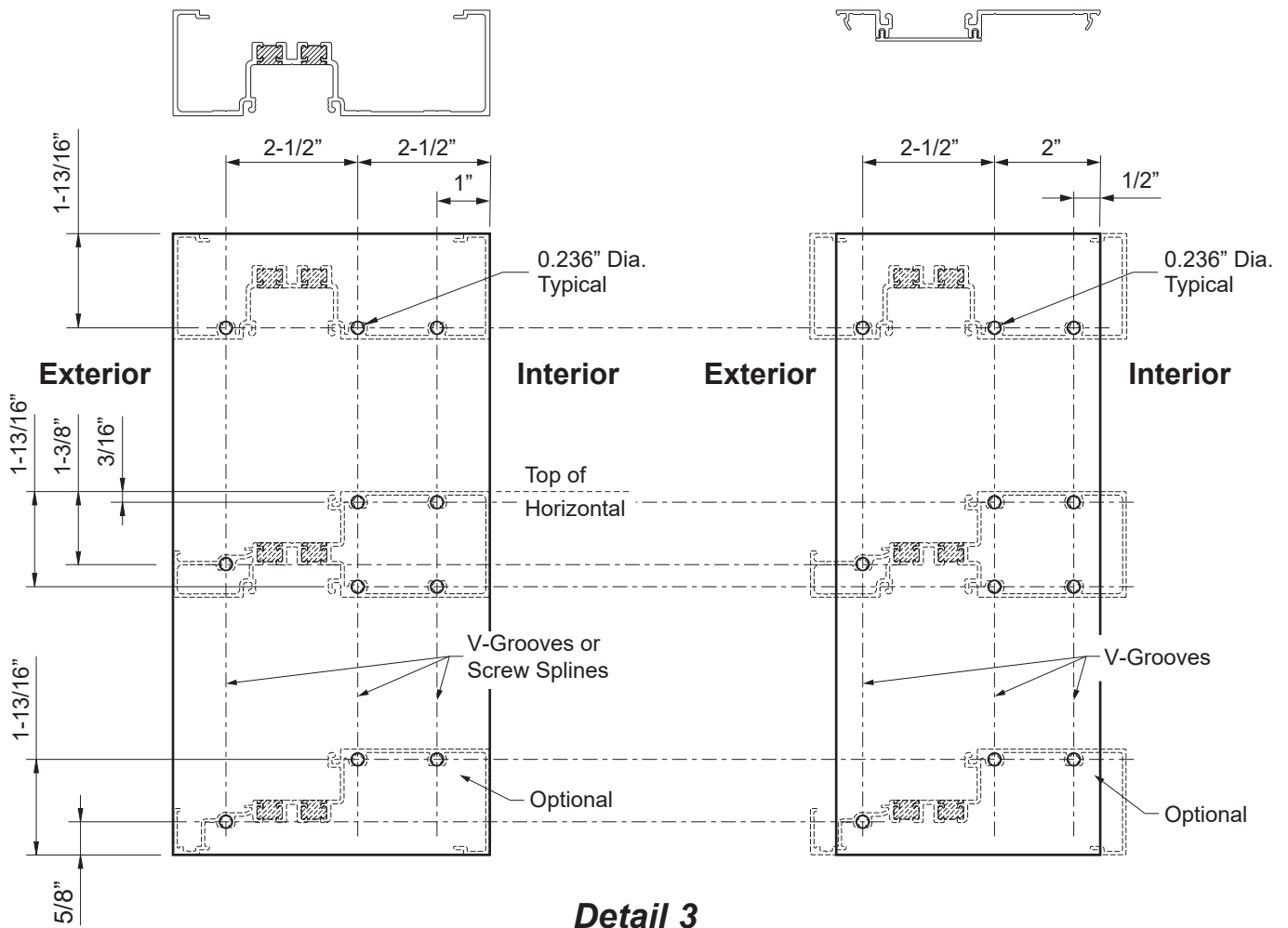
## FRAME FABRICATION

### STEP 2 FABRICATE TWO PIECE VERTICAL MULLIONS FOR SCREW SPLINE ASSEMBLY

-Cut the two piece vertical and jamb members to the frame height determined in **Step 1**.  
-Fabricate holes in vertical members for screw spline attachment using one of the methods below:

1. Layout the hole locations as shown in **Detail 3** and drill a 0.236" dia. (#B drill bit) clearance hole at each location marked.
2. Use the YKK AP drill fixture, H-7204, to drill the holes.
3. Use punch press with appropriate die set.

See **Detail 3**.



**FRAME FABRICATION****STEP 3****FABRICATE HEAD, HORIZONTAL & SILL MEMBERS**

-Cut head, horizontal, and sill members to the daylight opening (D.L.O.) as indicated on the shop drawings.

**STEP 4****FABRICATE GLASS STOPS & GLAZING ADAPTORS**

-Cut glass stops to the same dimensions as their respective horizontals minus(-) 1/32".

-Cut vertical glazing adaptors to the frame height.

-Cut horizontal glazing adaptors to the daylight opening minus(-) 1/32".

## FRAME FABRICATION

### STEP 5 FABRICATE HOLES FOR SILL MEMBERS

-For mullion end reactions over 500 lbs., fabricate sill members for anchoring to sill flashing:

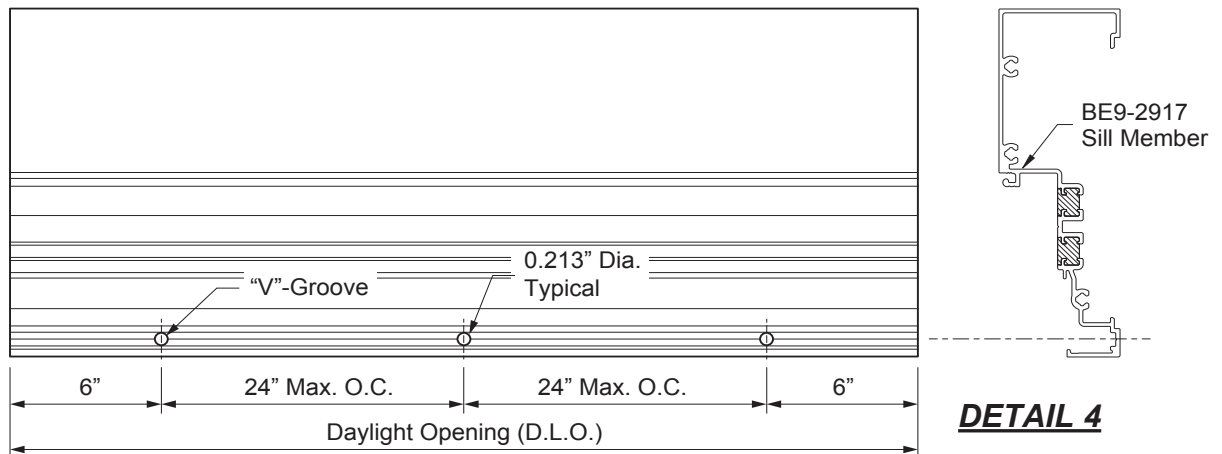
-Measure in 6" from each end of the sill member and mark hole locations along the "V"-groove as shown in **Detail 4**.

-Mark additional hole locations a maximum of 24" on center (O.C.).

-Drill a 0.213" diameter (#3 drill bit) hole at each location marked.

-If mullion end reaction is under 500 lbs., one (1) 0.213" dia. weep hole is required at the center of each daylight opening.

See **Detail 4**.



### STEP 6 FABRICATE SILL FLASHING

**For elevations without door framing:**

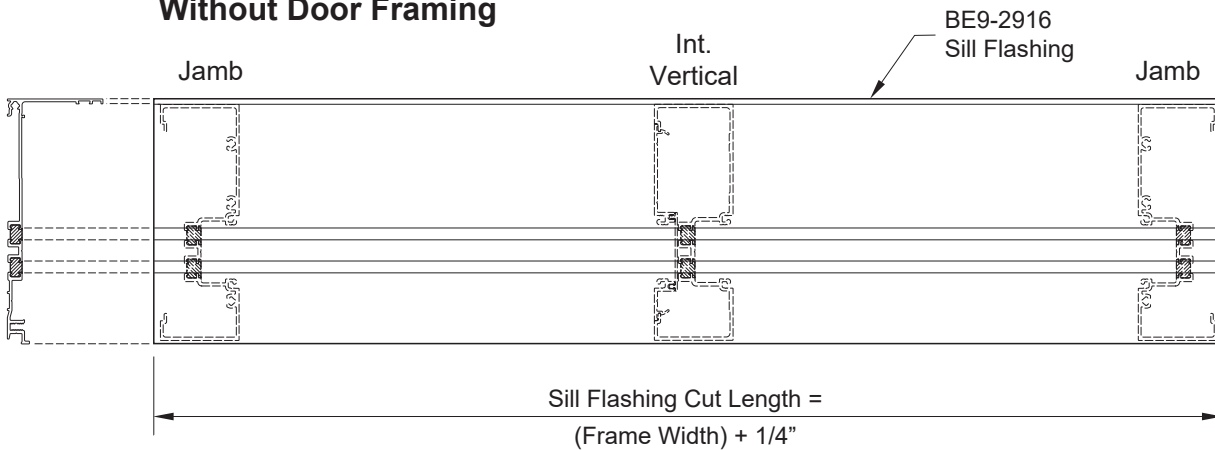
-Cut sill flashing, BE9-2916, to the length of frame width plus (+) 1/4".

**For elevations with door framing:**

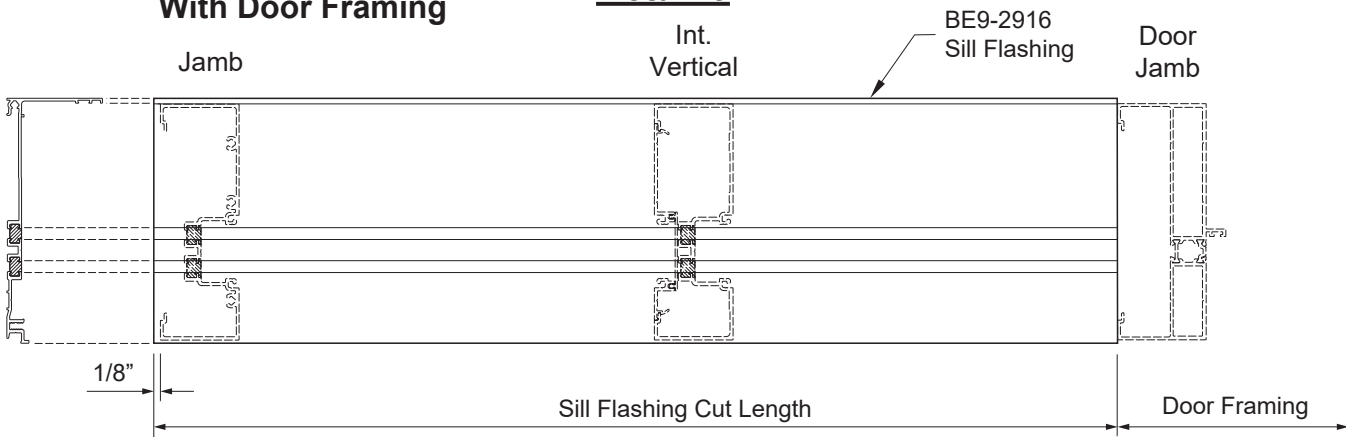
-Cut the sill flashing to length as shown in **Detail 5** and or as shown in the approved shop drawings.

**FRAME FABRICATION**

**Without Door Framing**



**With Door Framing**

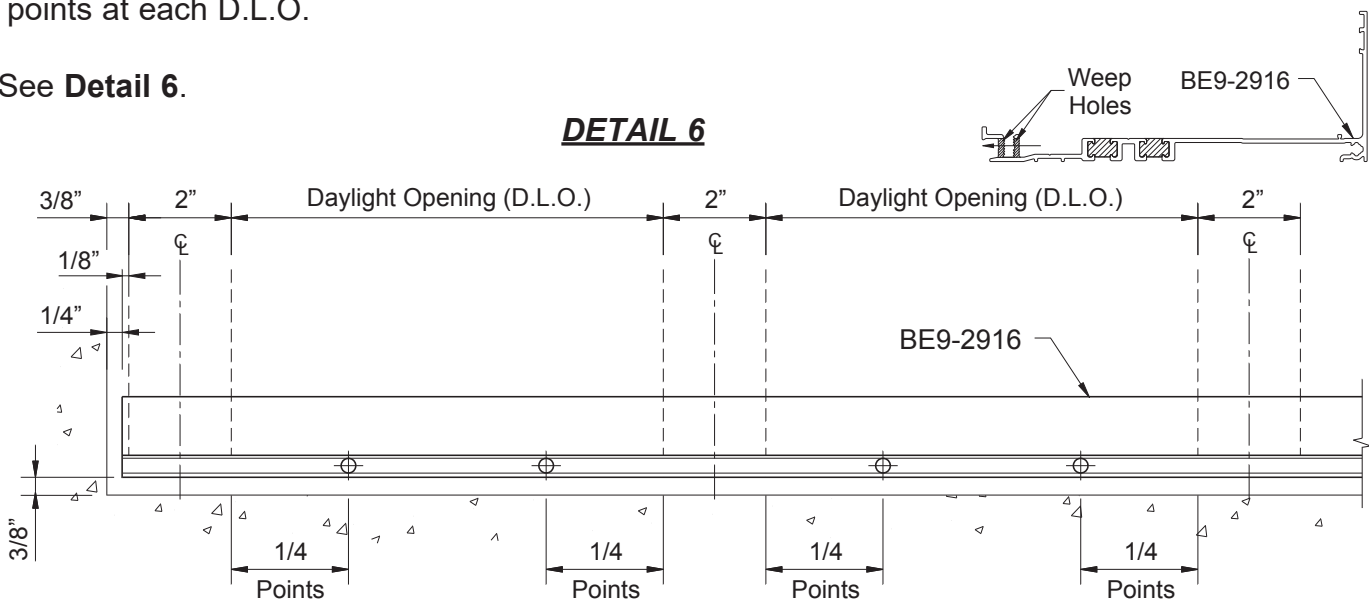


**Detail 5**

-Drill 5/16" diameter weep holes in the front of the sill flashing at the quarter points at each D.L.O.

See **Detail 6**.

**DETAIL 6**

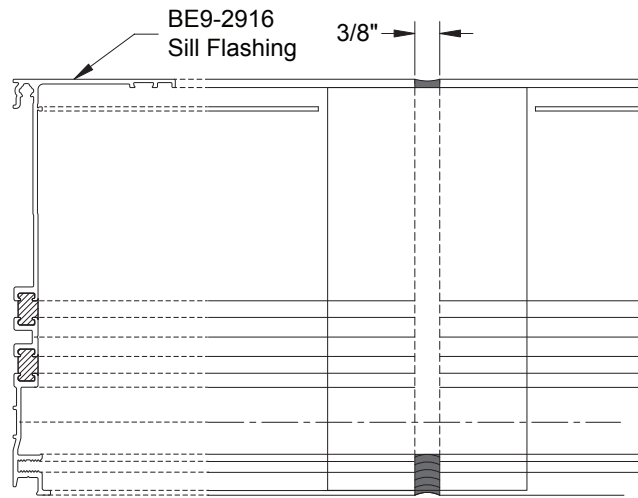


## FRAME INSTALLATION

### STEP 6 (Continued) FABRICATE SILL FLASHING

- For openings longer than 24'-0" the sill flashing needs to be spliced every twelve to fifteen feet at the center of a D.L.O.
- Allow for a 3/8" joint for expansion between sill flashing members.

See **Detail 7**.



**DETAIL 7**

## FRAME ASSEMBLY

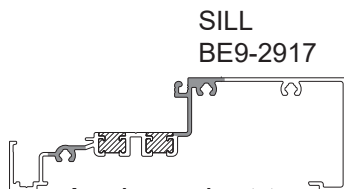
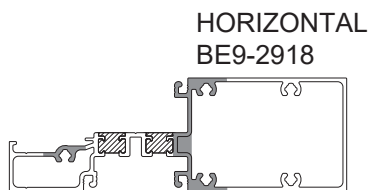
### STEP 7

### ASSEMBLE FRAMES (SCREW SPLINE ASSEMBLY)

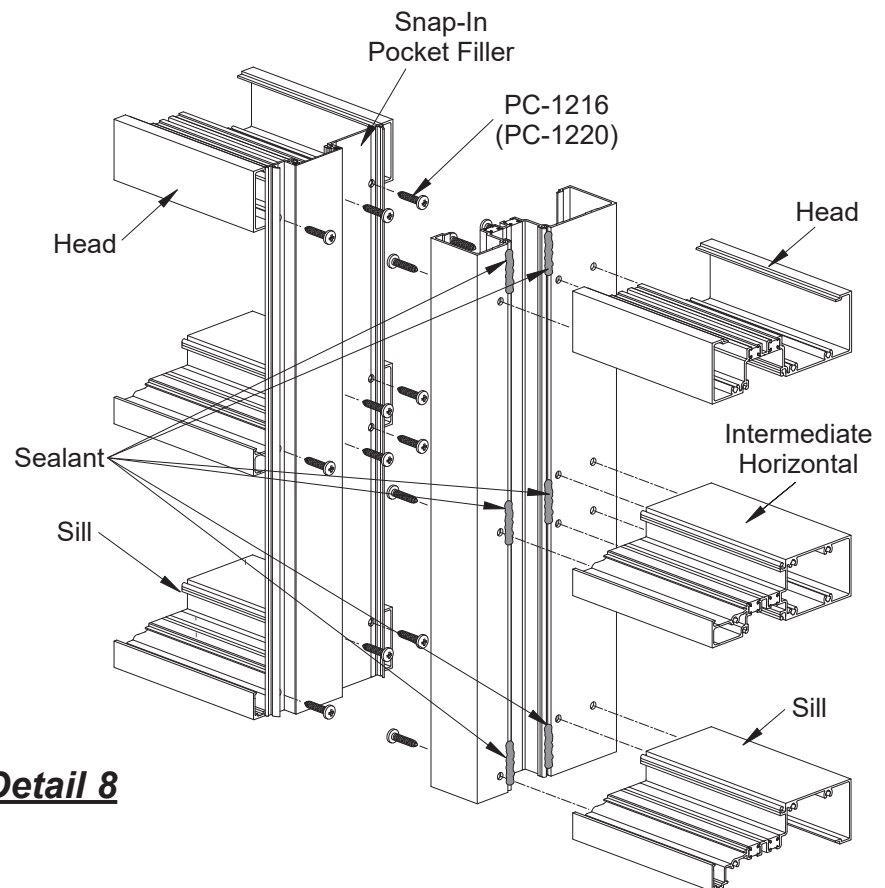
- Clean all joint surfaces using cleaner approved by sealant manufacturer.
- Apply sealant into the reglet of the vertical mullion at the head, horizontal, and sill locations as shown in **Detail 8**. Tool flat if not assembling immediately.
- Apply sealant to both ends of head, horizontal and sill members just prior to assembly.
- Attach head, intermediate horizontal, and sill members to vertical mullions and pocket fillers with PC-1216 fasteners at each end as shown in **Detail 8**.

**Note:** Fastener PC-1220 must be substituted for PC-1216 when the head member (with screw splines) is used as a vertical.

- Tool the sealant into the joints and wipe away any excess sealant.
- See **Detail 8**.



Apply sealant to the shaded areas at each end.



**Detail 8**

**CAUTION:** Always assemble frames such that each lite of glass will have a minimum of one deep vertical glazing pocket.

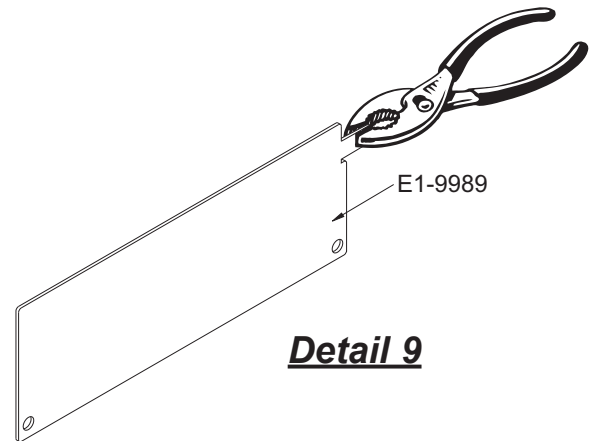
## FRAME INSTALLATION

### STEP 8 INSTALL SILL FLASHING END DAMS

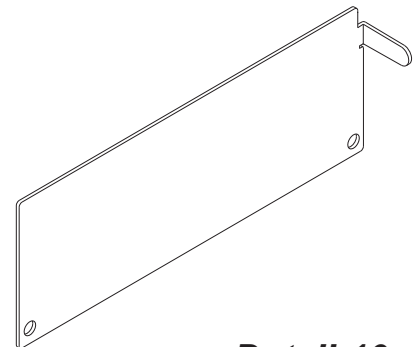
-Bend the end dam tab left or right 90 degrees in order to “hand” the end dam for the left or right end of the flashing.

See **Details 9 & 10**.

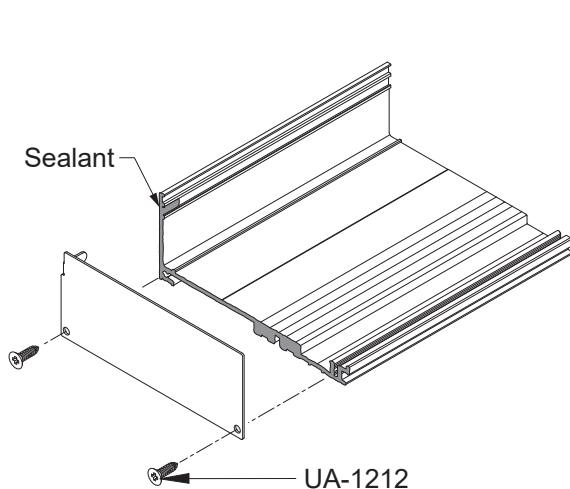
- Clean all joint surfaces using cleaner approved by sealant manufacturer.
- Apply sealant to the end of the sill flashing as shown in **Detail 11**.
- Slide the tab into the top portion of the sill flashing.
- Tap the tab into place with a small tool until the end dam is snug against the end of the flashing.
- Fasten the end dam to the sill flashing with two UA-1212 screws, starting at the back, followed by the front as shown in **Detail 11**.
- Tool sealant along the joint between the end dam and the sill flashing as shown in **Detail 12**.
- Seal over any exposed screw threads.



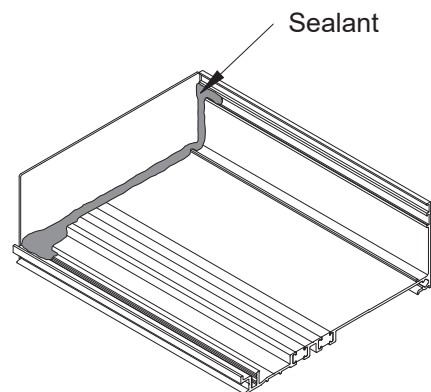
**Detail 9**



**Detail 10**



**Detail 11**



**Detail 12**

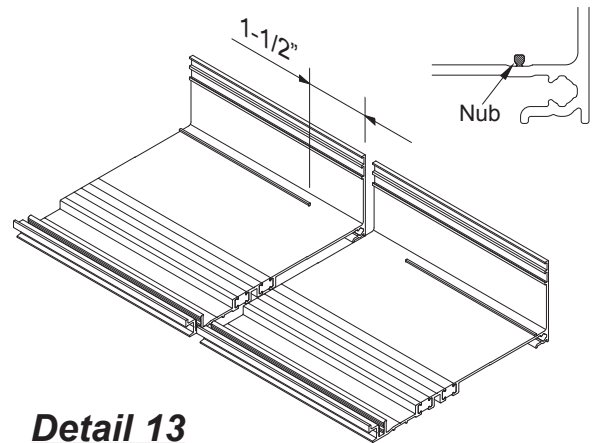
## FRAME INSTALLATION

### STEP 9 INSTALL SILL FLASHING

- Install the sill flashing with a minimum of 3/8" shim space underneath. Sill flashing must be installed level.
- Anchor the sill flashing to the structure a maximum of 4" from each end and then 18" to 24" on center, or per P.E. calculations.
- Apply and tool sealant to cover the heads of all anchors and screws.

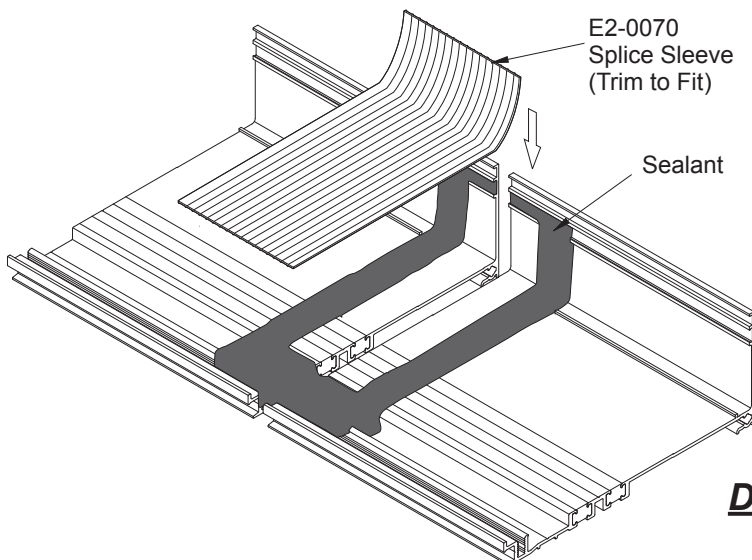
### STEP 10 INSTALL SILL FLASHING SPLICE SLEEVE

- Remove the nub with a chisel or pliers on both sides of the splice joint 1-1/2" as shown in **Detail 13**.
- After the sill flashing has been shimmed and anchored to the building structure, insert a small backer rod under the sill flashing as shown in **Detail 14**.
- Position the Silicone Splice Sleeve against the back wall below the groove.
- Bend the Silicone Splice Sleeve into the front on the channel as shown. Mark and cut the sleeve at this position.
- Clean Sill Flashing and Silicone Splice Sleeve with isopropyl alcohol at the splice location.
- Seal the flashing at the splice location as shown in **Detail 14**, before positioning the flashing. Set the Silicone Splice Sleeve into the sealant.
- Tool sealant tight as shown in **Detail 14**, squeezing the sheet flat with a seam roller.

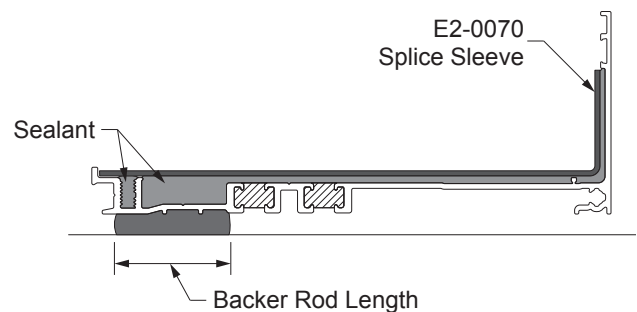


**Detail 13**

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



**Detail 14**





## FRAME INSTALLATION

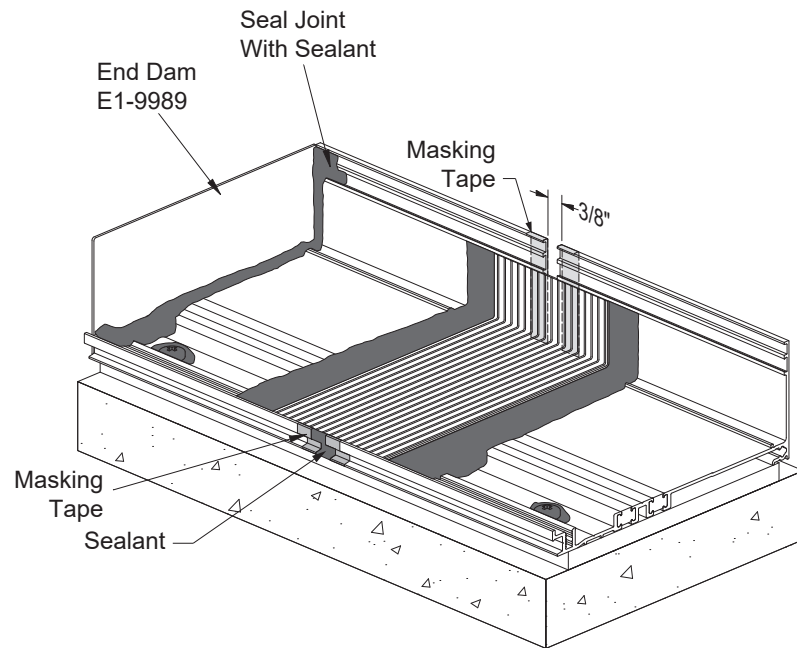
### STEP 10

#### INSTALL SILL FLASHING SPLICE SLEEVE (Continued)

-Apply masking tape to the back of the sill flashing at the splice and at the front as shown in **Detail 15**.

-Thoroughly seal the small joint directly in front of the Silicone Splice Sleeve. Carefully remove masking tape from the front gap before the sealant skins over.

**Detail 15**

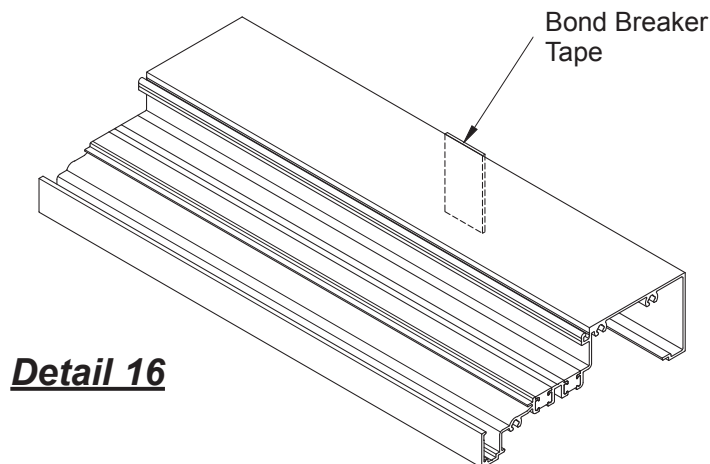


### STEP 11

#### SILL PREPARATION

At every splice condition, apply bond breaker tape to the back of the sill member before the joint is sealed between the sill and sill flashing.

See **Detail 16**.



**Detail 16**

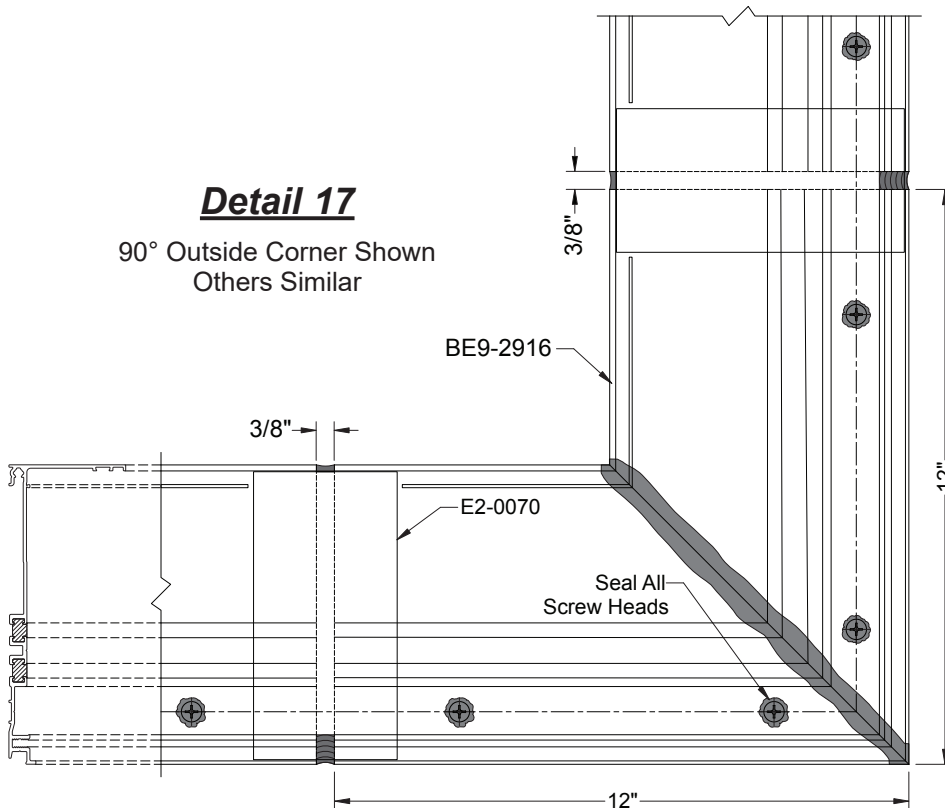
**FRAME INSTALLATION**

**STEP 12  
FABRICATE SILL FLASHING FOR CORNERS**

**Install sill flashing at corners:**

- Cut two 12" long pieces of sill flashing BE9-2916 and miter (45° for 90° corners and 67.5° for 135° corners).
  - Align the two pieces at the corner condition with the mitered ends pushed together tight and anchor the sill flashing as called out on shop drawings.
  - Apply and tool sealant to the mitered joint and anchor heads.
- See **Detail 17**.

-Continue installing the rest of the sill flashing providing a 3/8" expansion joint at splices as shown in **Step 10** on **Page 12**.



## FRAME INSTALLATION

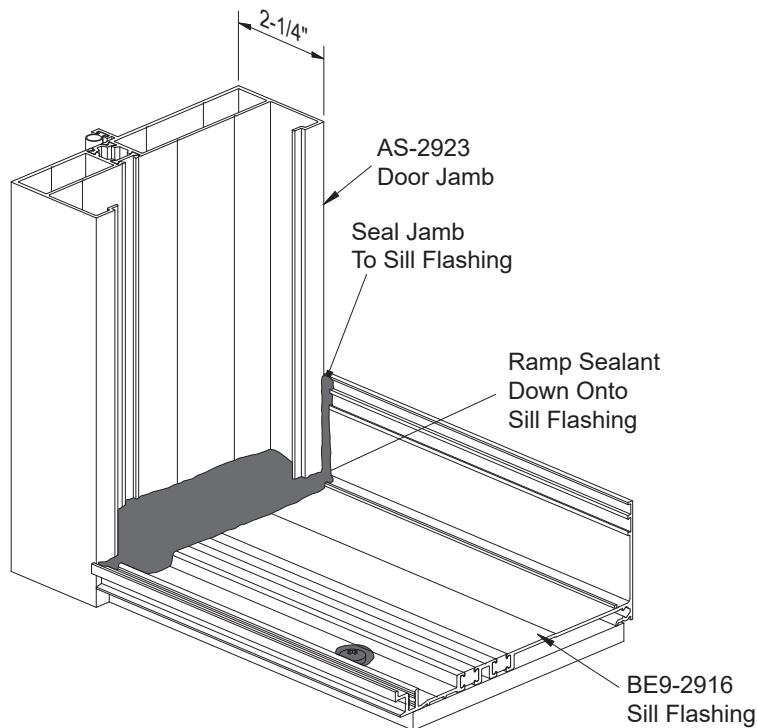
### STEP 13 PREPARE DOOR JAMBS

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

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

See **Detail 18**.

Refer to the **Entrances Installation Manual** for door installation instructions.



**Detail 18**

**FRAME INSTALLATION**

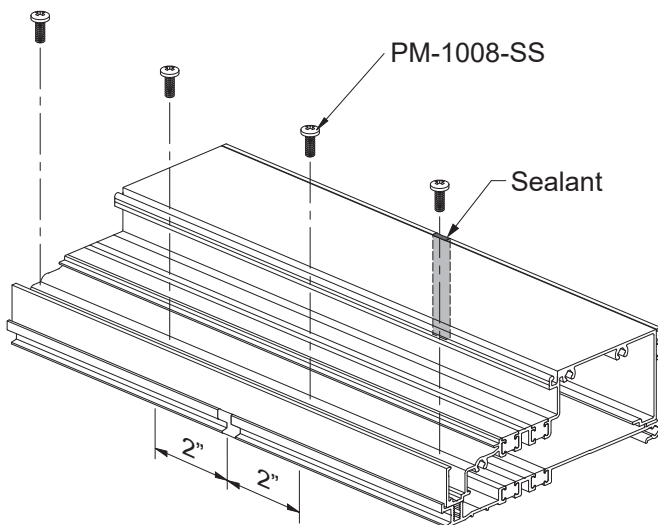
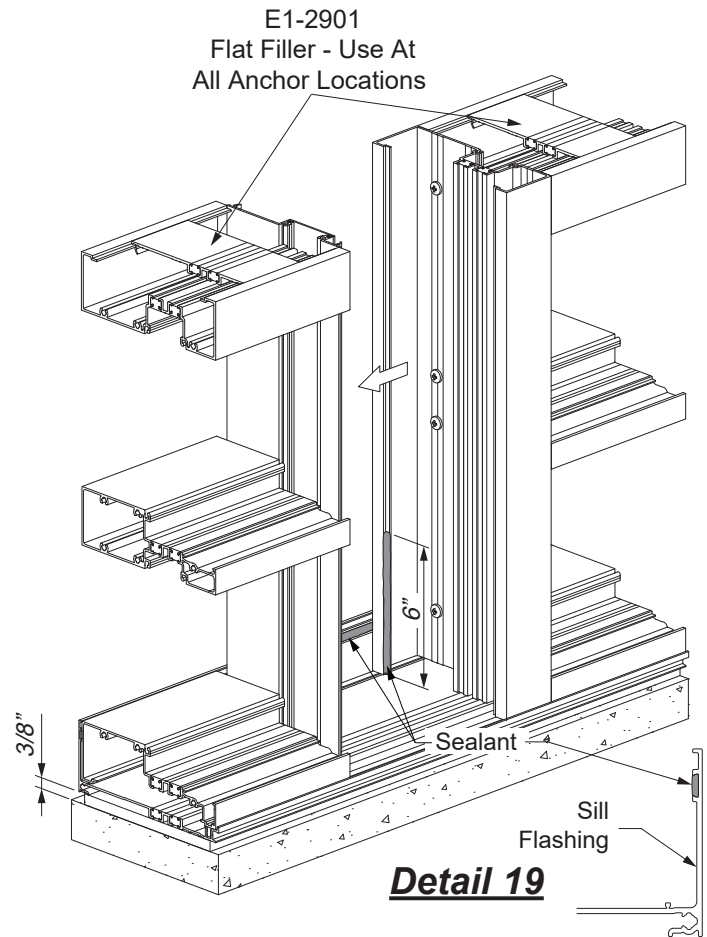
**STEP 14  
INSTALL FRAMES**

- Snap in flat fillers, E1-2901, or 2-1/2" long pieces of BE9-2920 at head and jamb anchor locations.
- Prior to snapping the assemble frames together, apply sealant to the interior snap interface of the mullion, 6" up from the bottom.
- Apply sealant continuously to the front of the back leg of the sill flashing and immediately set the frame into the opening.
- Snap assembled frames together.

See **Detail 19**.

- Shim jamb and head members with a minimum of 3/8" shim.
- Anchor the frame to the structure at the sill\*, head, and jamb: 3" from the ends and then 24" on center, or as required by P. E. calculations.
- Always shim at all anchor locations.

**Note:** Use only flat head fasteners at head and jamb conditions.



**Detail 20**

- For mullion end load reactions over 500 lbs., attach the sill to the sill flashing using PM-1008-SS screws.\*
- Also add one (1) PM-1008-SS fastener 2" in both directions from the center line of the splice.

-Apply and tool sealant to the gap in the back of the sill flashing splice. Remove the masking tape after application.  
See **Detail 20**.

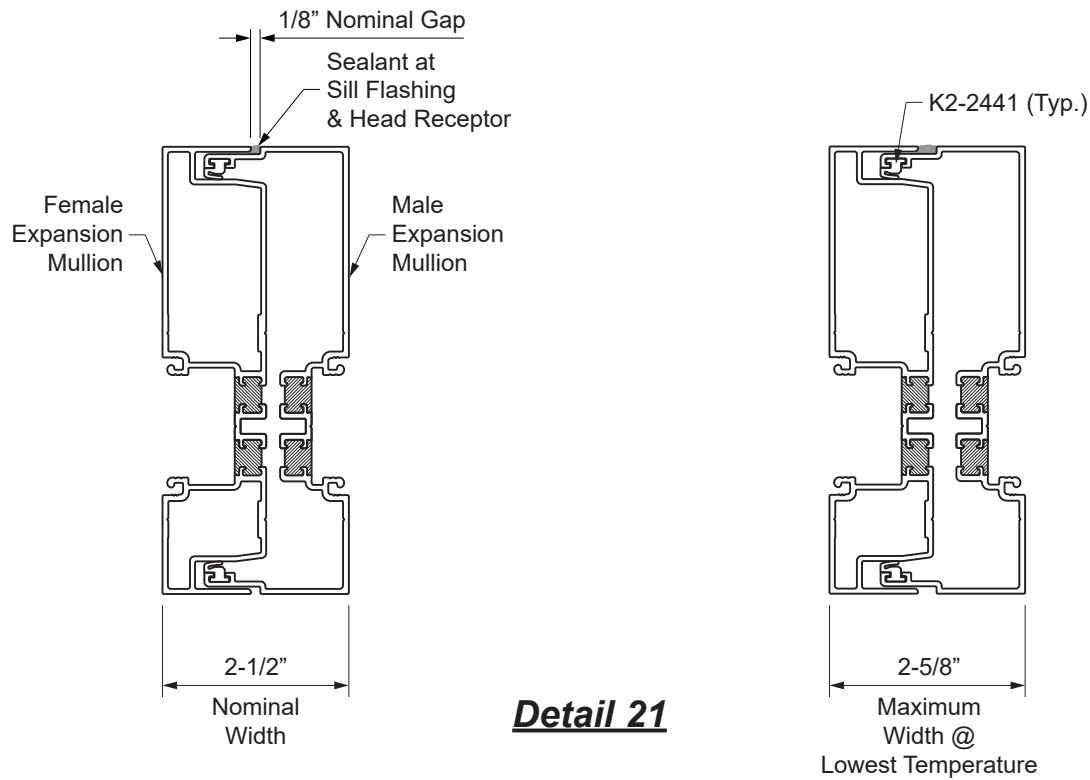
\*To determine end load reactions, consult YKK AP DirecTech or refer to approved shop drawings or P. E. calculations.

## FRAME INSTALLATION

### STEP 14 (Continued) INSTALL EXPANSION MULLIONS WHERE REQUIRED

- Expansion mullions require the K2-2441 weathering gasket in both front and rear reglets.
- During installation, the current air temperature should be taken into account to determine the proper spacing between the mullion halves such that the expansion mullion stays within its allowable width limits during its service in hot and cold weather conditions.
- Fill the interior gap between the mullion halves with sealant at the sill flashing and head receptor.

See **Detail 21**.



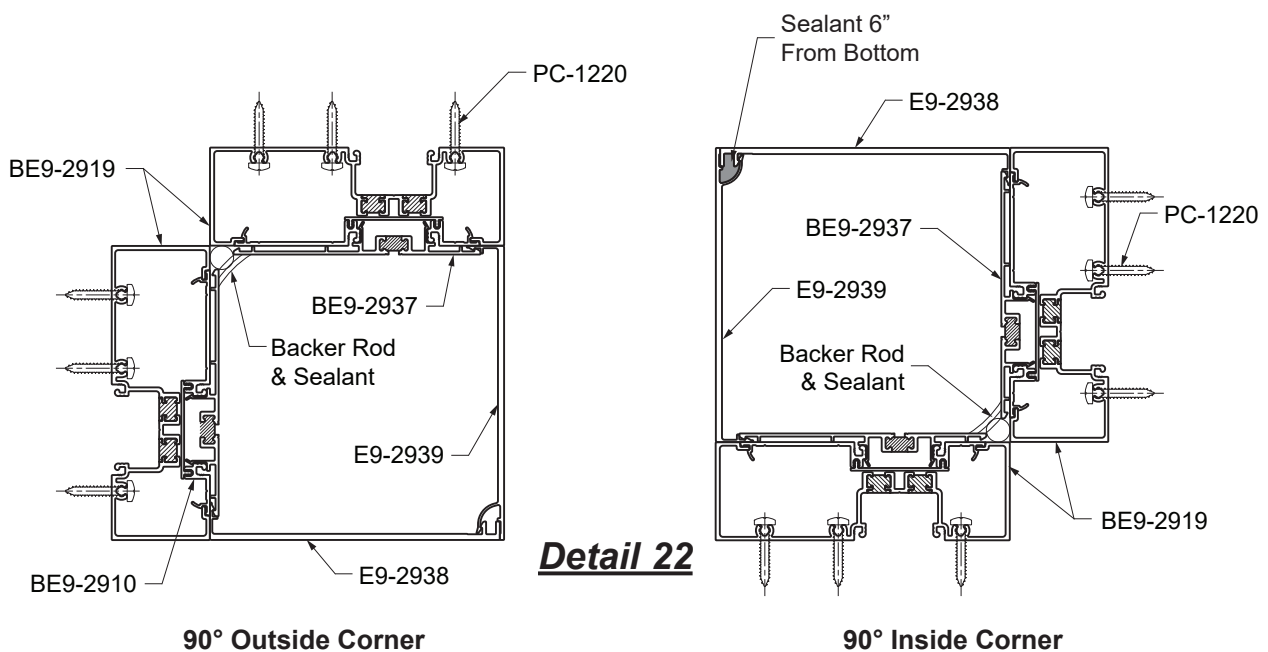
## FRAME ASSEMBLY

### STEP 14 (Continued) INSTALL CORNER ASSEMBLIES

#### For 90° Corner Assemblies:

- Attach horizontal members to standard mullions as shown before in **Step 7**.
- Attach the other end of the horizontals to the jamb mullions to be used at the corners.
- Attach shallow pocket fillers to the jamb mullions and snap the BE9-2937 adaptors to the pocket fillers.
- Apply backer rod and sealant to the cavity between the adaptors at the jamb mullions. Tool the sealant. For inside corners, apply sealant to the snap receptor of the E9-2939 female corner cover, 6" up from the bottom.
- Snap the E9-2939 female corner cover onto the corner first, then snap on the E9-2938 male corner cover.

See **Detail 22**.



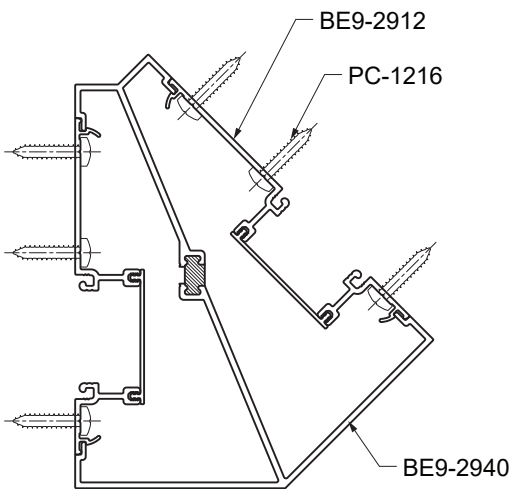
## FRAME INSTALLATION

### STEP 14 (Continued) INSTALL CORNER ASSEMBLIES

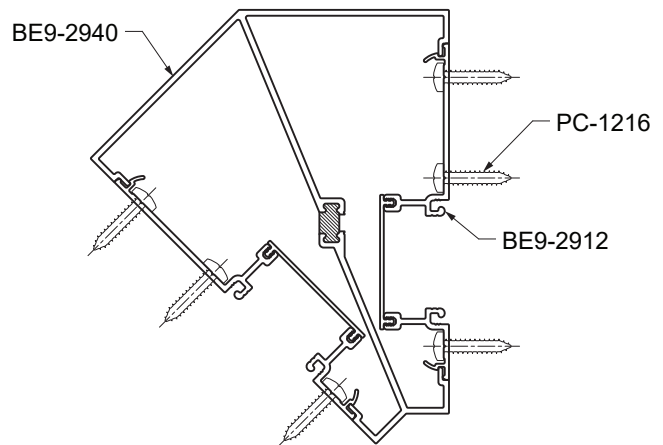
#### For 135° Corner Assemblies:

- Attach horizontal members to standard mullions as shown before in **Step 7**.
- Attach the other end of the horizontals to the deep pocket fillers using the same technique.
- Snap the corner framing members together to form the corner assemblies.
- Carefully move the corner assembly into place and snap it into the rest of the frame one side at a time.

See **Detail 23**.



135° Outside Corner



135° Inside Corner

### Detail 23

**FRAME INSTALLATION**

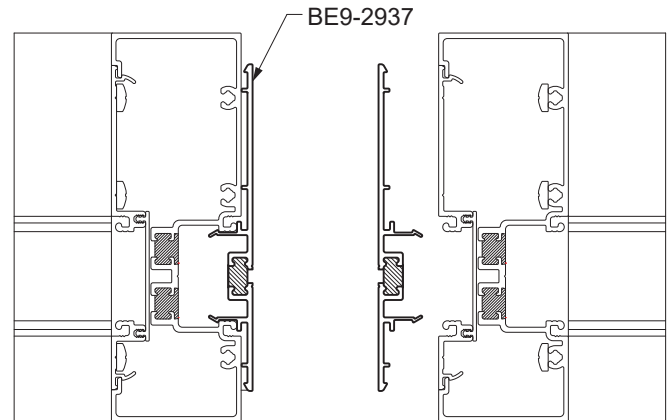
**STEP 14 (Continued)  
INSTALL OPTIONAL COMPOUND MULLIONS**

-Snap in the BE9-2937 adaptors (cut full length of the mullion) into the mullions for each frame as shown in **Detail 24**.

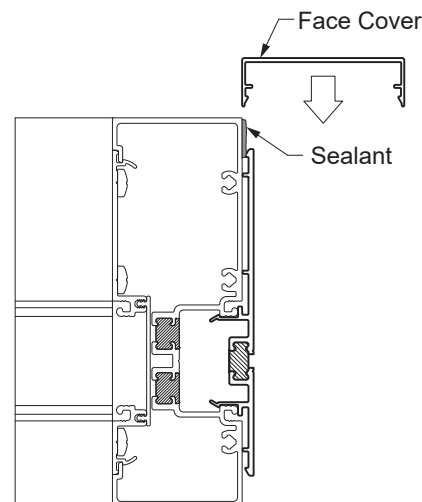
-Apply sealant to the full length of the first mullion for which the rear face cover will snap into.

-Snap the face cover into place.

See **Detail 25**.



**Detail 24**



**Detail 25**



## FRAME INSTALLATION

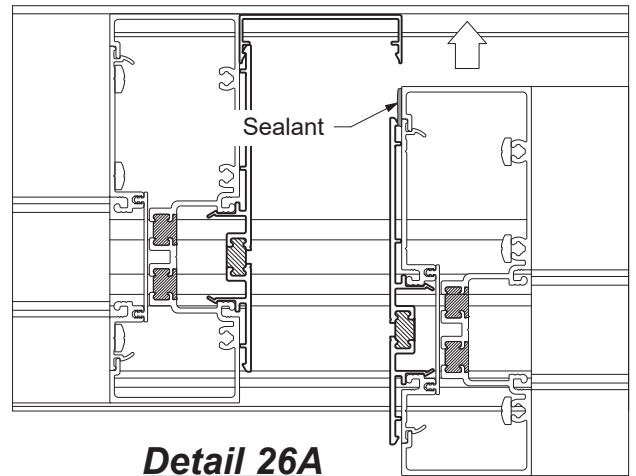
### STEP 14 (Continued) INSTALL OPTIONAL COMPOUND MULLIONS

-Apply sealant to the full length of the mullion for the second frame.

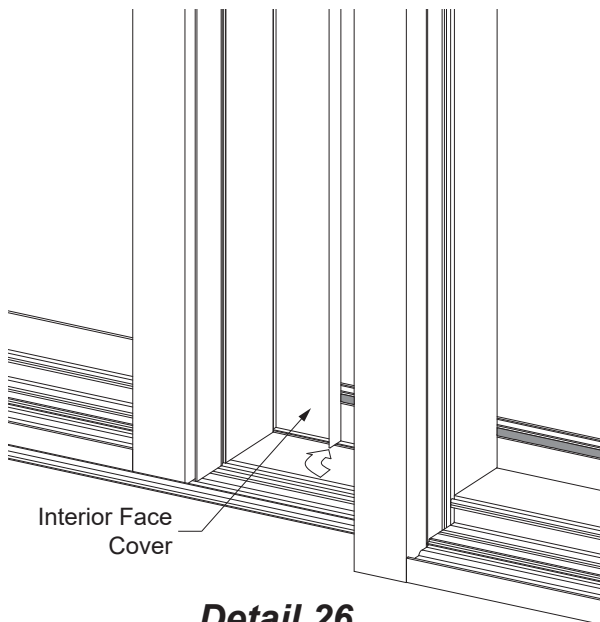
-Snap the second frame into place from the front, engaging the face cover as shown in **Detail 26 & 26A**.

-Snap the front face cover into both frames. Start at the sill to clear the front lip of the sill flashing.

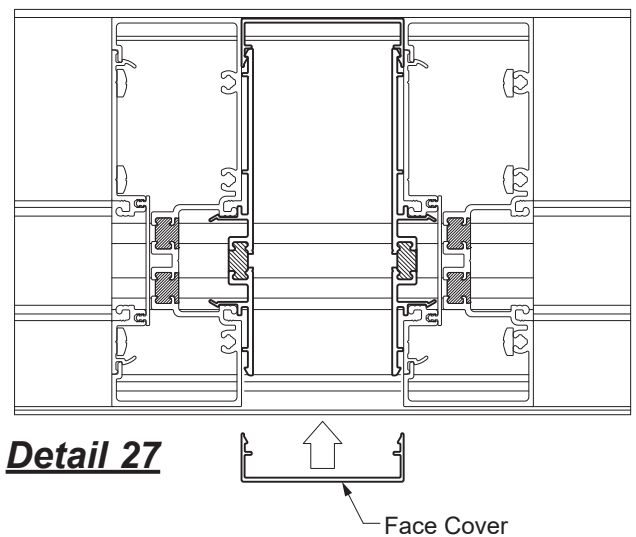
See **Detail 27**.



**Detail 26A**



**Detail 26**



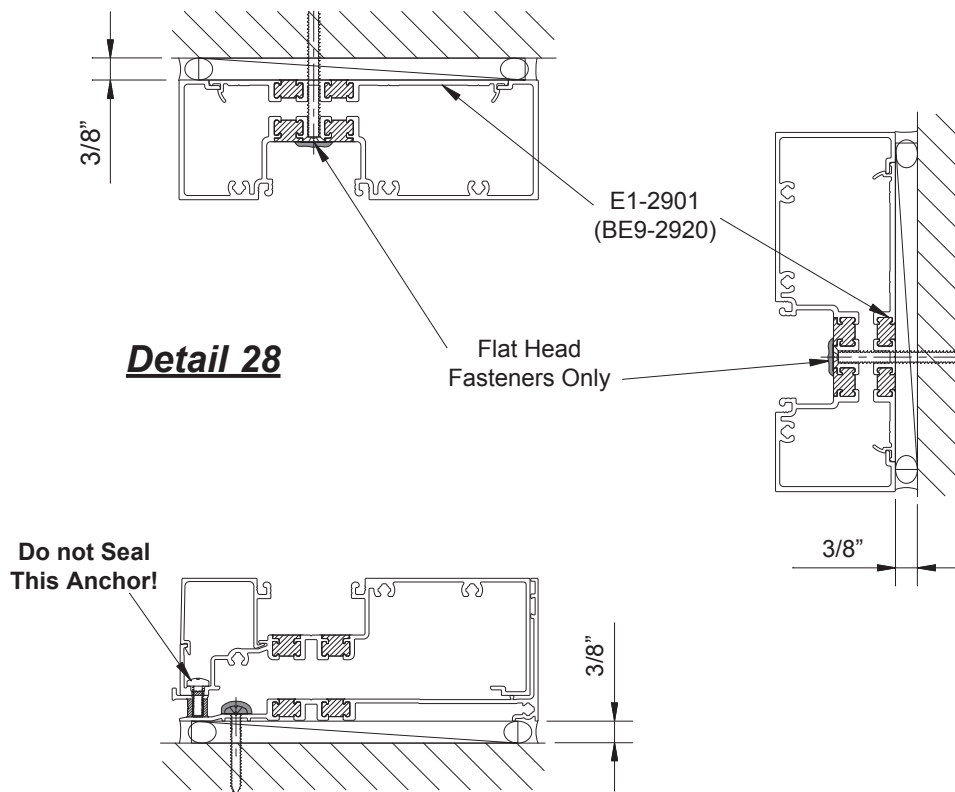
**Detail 27**

**FRAME INSTALLATION**

**STEP 15  
APPLY PERIMETER SEALANT**

- Perimeter seal required on interior and exterior.
- Install backer rod around the perimeter of the frame.
- Apply and tool perimeter sealant to the joint between the frame and the structure.
- Do not** seal sill flashing weep holes.
- Seal anchor heads at head and jambs.

See **Detail 28**.



## FRAME INSTALLATION

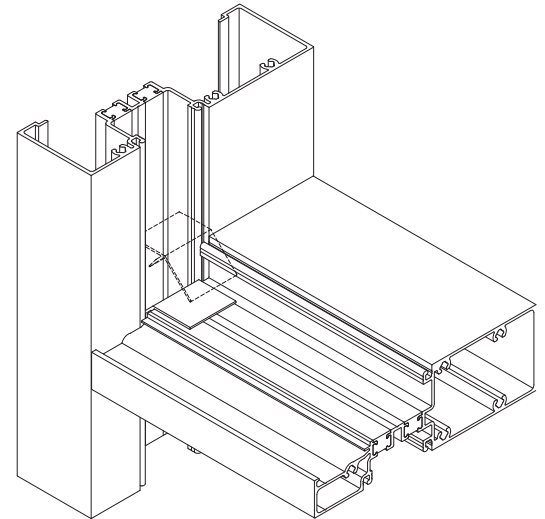
### STEP 16 INSTALL WATER DEFLECTORS

YES 60 XT requires the installation of a water deflector, E2-0047, at the ends of every intermediate horizontal to keep water off of the insulating glass units (IGU). Optional compound horizontals require water deflectors at the ends of both horizontal members.

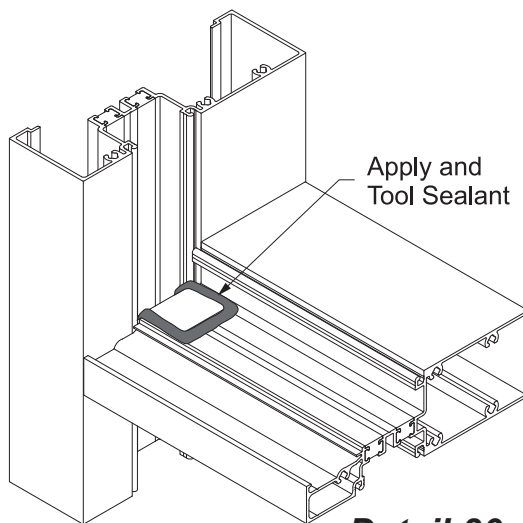
- Peel away the protective paper from the bottom of the water deflector, E2-0047, and install the water deflector by rotating it over each end of the horizontal.
- Position the vertical leg of the water deflector against the end of the horizontal.

**Note:** For best adhesion, make sure that the horizontal is clean and dry.

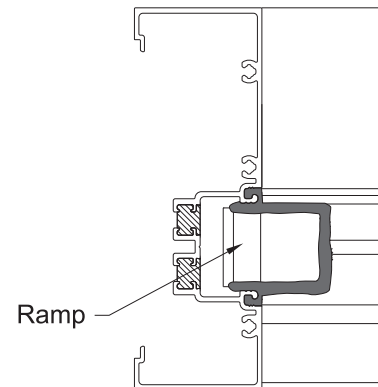
See **Detail 29**.



**Detail 29**



**Detail 30**



**Detail 31**

-Apply and tool sealant along the edges of the water deflector and down onto the horizontal.

See **Detail 30**.

-Seal the ramp of the water deflector to the sides of the vertical gasket reglets.

See **Detail 31**.

## FRAME INSTALLATION

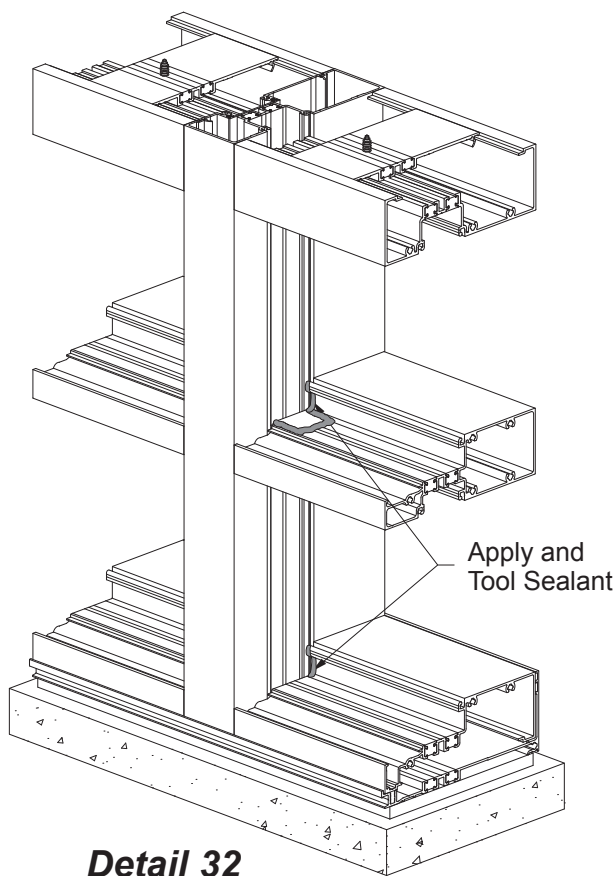
### STEP 17 APPLY INTERNAL SEALANT

- Apply sealant to the vertical intersection of the horizontal and vertical members.
- Tool all of the sealant to ensure a water tight joint.

See **Detail 32**.

**Glazing Table - YES 45 TU**

Glass Thickness	Adaptor	Exterior	Interior
3/16"	E9-1040	E2-0052	E2-0064
1/4"	E9-1040	E2-0052	E2-0052
5/16"	E9-1040	E2-0053	E2-0052
3/8"	E9-1040	E2-0053	E2-0053
1/2"	E9-1039	E2-0064	E2-0064
5/8"	E9-1039	E2-0052	E2-0052
3/4"	E9-1039	E2-0053	E2-0053
7/8"	—	E2-0064	E2-0064
1"	—	E2-0052	E2-0052



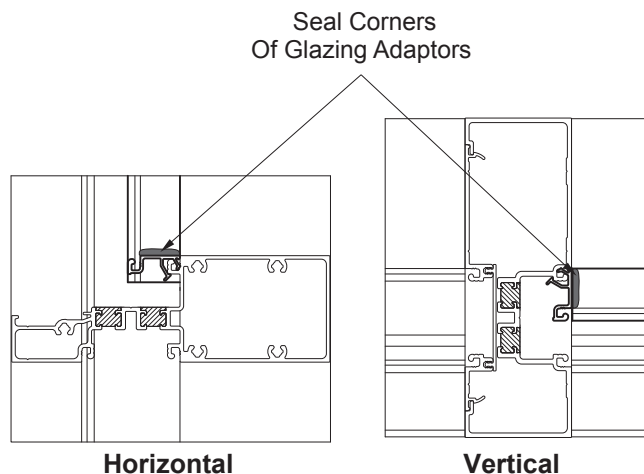
**Detail 32**

### STEP 18 (Optional) INSTALL GLAZING ADAPTORS

Glazing adaptors, E9-1039 and E9-1040, allow for glazing infills other than the standard 1/4" or 1". Please refer to the glazing tables above for possible adaptor/gasket combinations.

- Snap glazing adaptors into the interior gasket reglets of the verticals.
- Snap glazing adaptors into the interior gasket reglets of the horizontals.
- Apply and tool sealant to the joint between vertical and horizontal glazing adaptors.

See **Detail 33**.



**Detail 33**

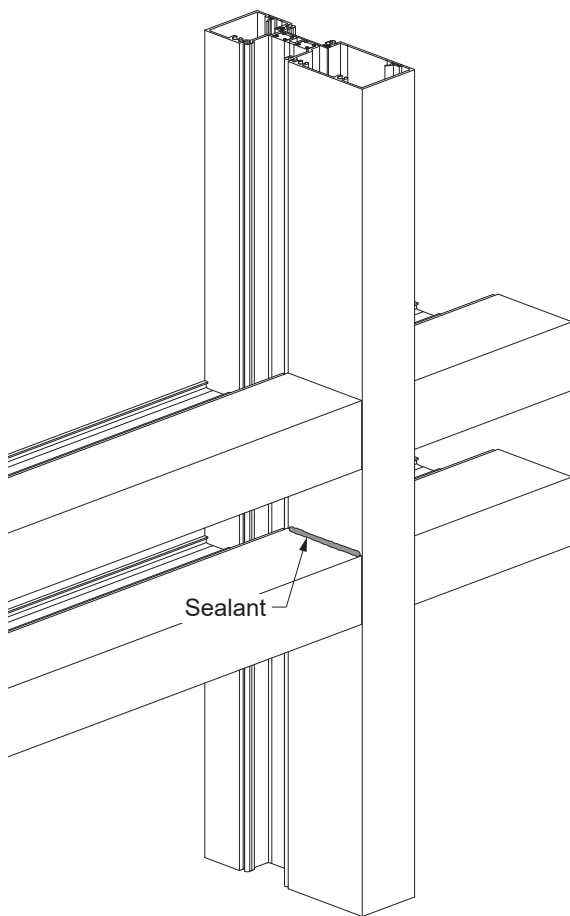
## FRAME INSTALLATION

### STEP 19 (Optional) INSTALL OPTIONAL COMPOUND HORIZONTALS

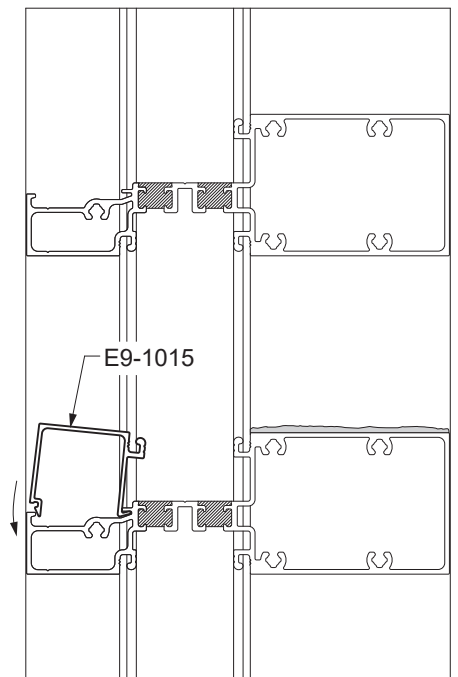
-Apply sealant to the top of of the lower horizontals where they intersect with the vertical. Tool the sealant. Do not seal the upper horizontal.

See **Detail 34**.

-Snap the E9-1015 glass stop into the lower horizontal as shown in **Detail 35**. Do not snap glass stops into the upper horizontals yet.



**Detail 34**

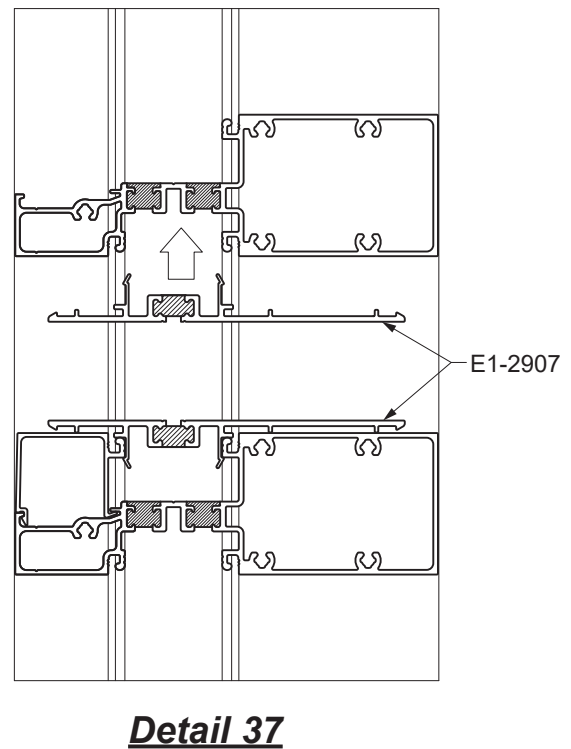
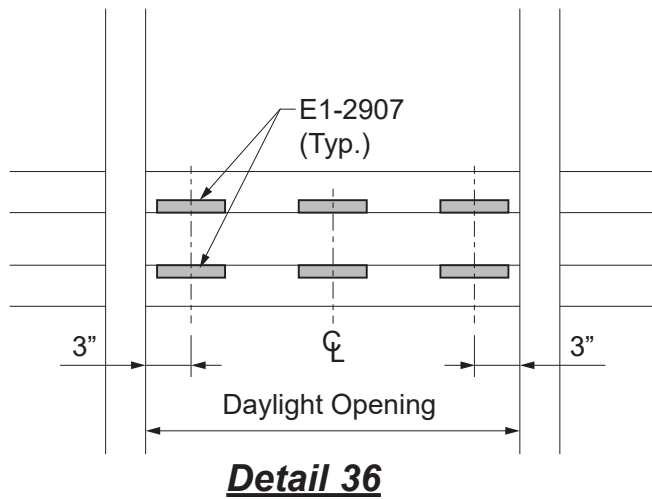


**Detail 35**

**FRAME INSTALLATION**

**STEP 19 (Optional, Continued)  
INSTALL OPTIONAL COMPOUND HORIZONTALS**

-Snap in the E1-2907 adaptors into the horizontals, one at 3" from each end of each horizontal and one at the middle of each horizontal as shown in **Details 36 & 37**.



## FRAME INSTALLATION

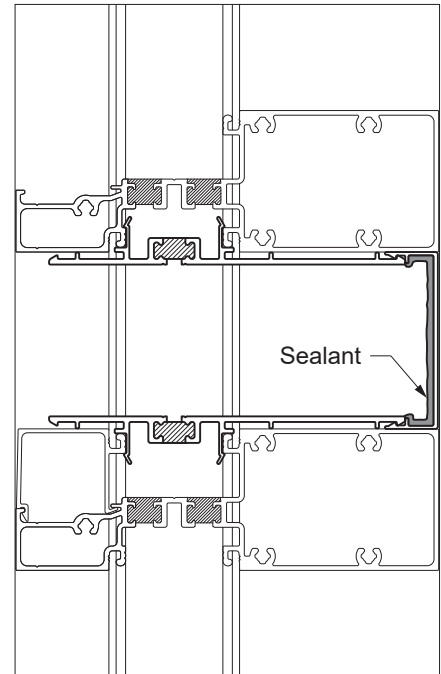
### STEP 19 (Optional, Continued) INSTALL OPTIONAL COMPOUND HORIZONTALS

-Cut the front and rear horizontal face covers to Daylight Opening minus(-) 1/16". Apply continuous sealant to the full length of the back of both horizontals where the rear face cover will snap into as shown in **Detail 38**. Snap the rear face cover into place.

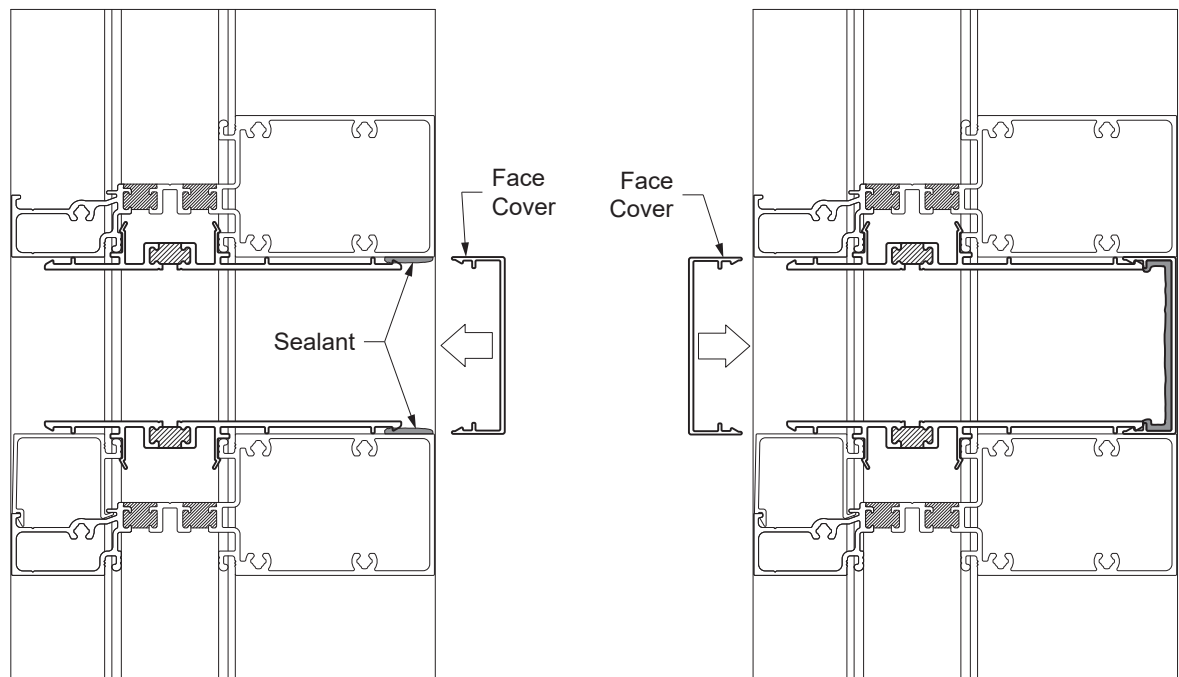
-Seal the joint between the edge of the face cover and the verticals as shown in **Detail 39**.

-Snap the front face cover into place.

See **Detail 40**.



**Detail 39**



**Detail 38**

**Detail 40**

**GLAZING**

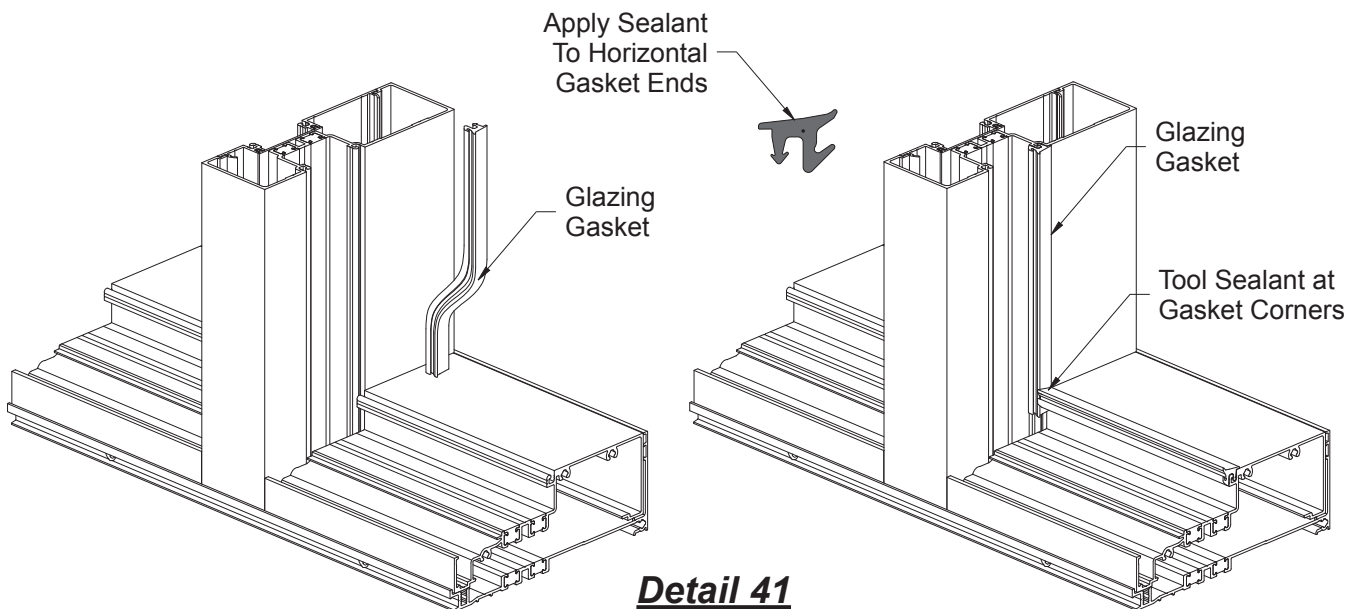
**STEP 20  
INSTALL INTERIOR GLAZING GASKETS**

The interior glazing gaskets must be installed prior to the glazing process.

-Using a small brush clean out any dirt that may have accumulated in the gasket reglets.

Vertical glazing gaskets must be installed first:

- Cut vertical glazing gaskets to Daylight Opening plus(+) 1/4" for each foot of length.
- Insert the gasket into the reglet at each end first, and then insert the gasket at the midpoint of the opening.
- Push the gasket into the reglet starting at the midpoint and work towards each end.



Install horizontal glazing gaskets next:

- Cut horizontal glazing gaskets to Daylight Opening plus(+) 1/4" for each foot of length.
- Apply sealant to each end of the horizontal glazing gasket prior to inserting into the reglet.
- Insert the gasket into the reglet at each end first and push each end tight against the vertical gasket.
- Then insert the gasket at the midpoint of the opening and push the gasket into the reglet starting at the midpoint and work towards each end.
- Tool the excess sealant at the gasket corners to ensure a watertight seal.

See **Detail 41**.



## GLAZING

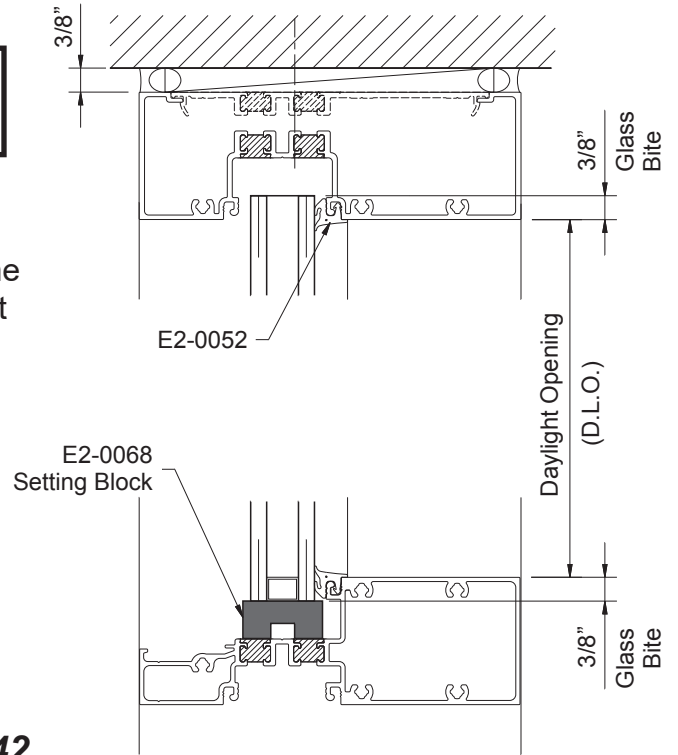
### STEP 21 INSTALL GLASS

Determine the glass size:

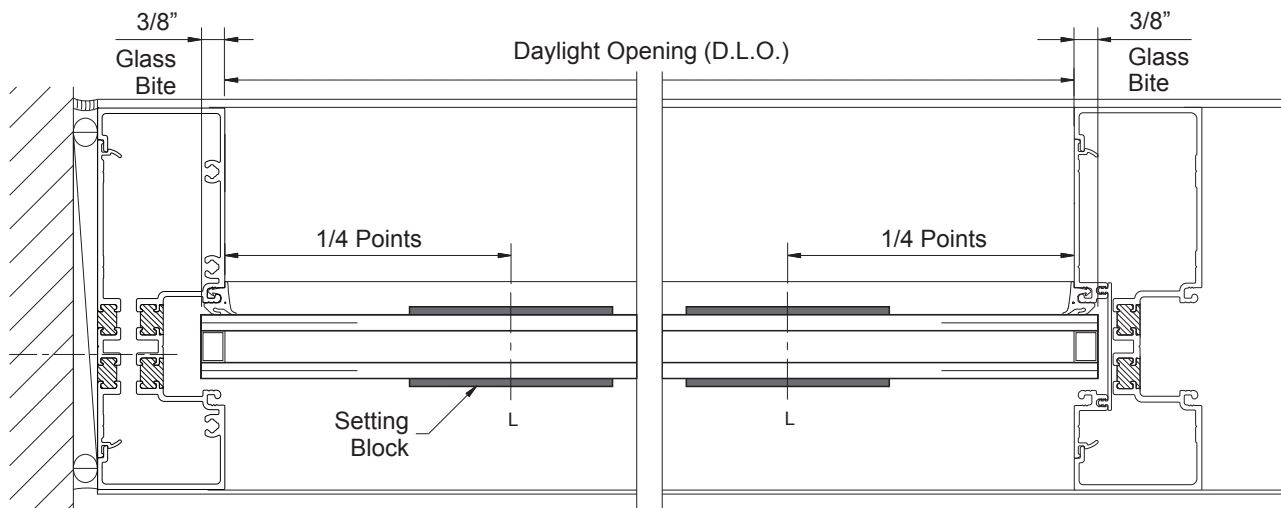
**Horizontal Glass Size = D.L.O. plus(+) 3/4"**  
**Vertical Glass Size = D.L.O. plus(+) 3/4"**

- Carefully install the glass into the opening: insert the leading edge of the lite up and into the deep pocket first and then rotate the trailing edge in place.
- Carefully lift lite of glass, install setting blocks at quarter points of horizontal D.L.O. or according to engineering calculations.
- Make sure the glass is properly positioned on all setting blocks.

See **Detail 42**.



**Detail 42**



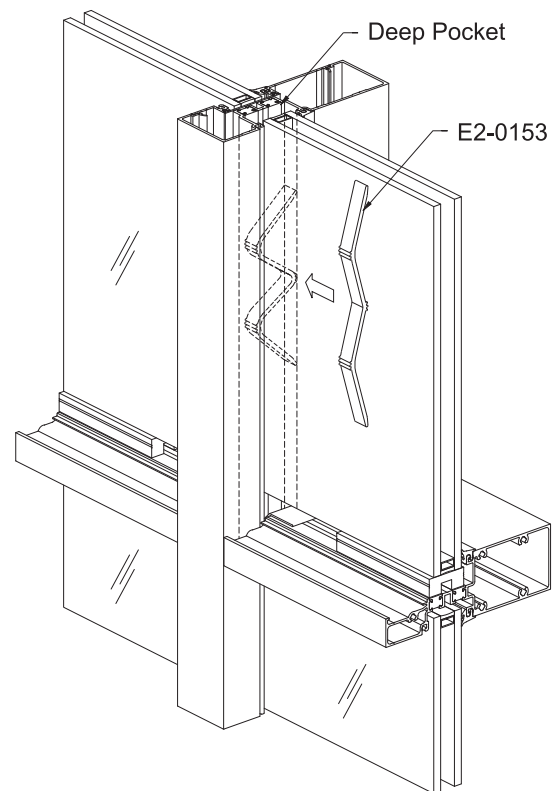
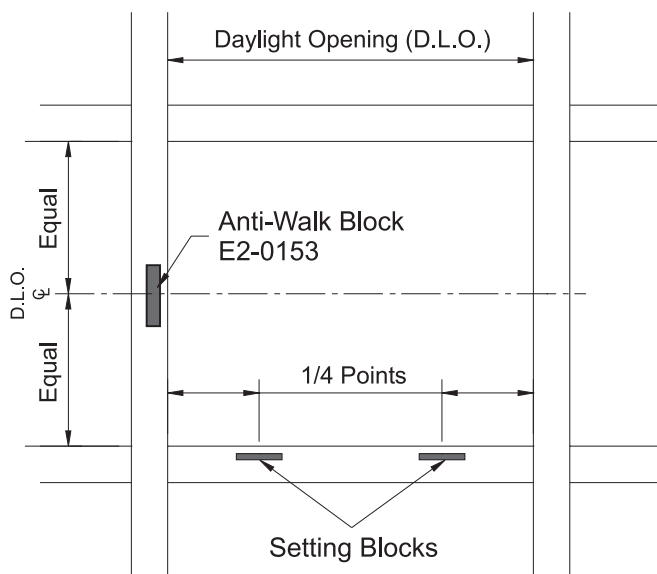
**GLAZING**

**STEP 22  
INSTALL ANTI-WALK BLOCKS**

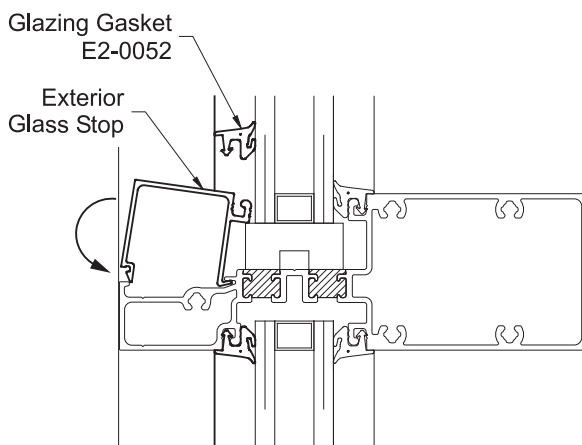
YES 60 XT frames require the installation of an anti-walk block, E2-0153, in the deep mullion glazing pocket of each lite centered on the daylight opening.

-Flatten the anti-walk block against the exterior surface of the glass and push it into the opening between the glass and the mullion until it is released into the glazing pocket.

See **Detail 43**.



**Detail 43**



**Detail 44**

**STEP 23  
INSTALL EXTERIOR GLASS STOPS  
& GLAZING GASKETS**

-Snap the exterior glass stops into place as shown in **Detail 44**.

-Install the exterior glazing gaskets using the same technique described in **Step 20** on **Page-28**. Always install the vertical glazing gasket first.

Repeat **Steps 20 through 23** until all lites are installed.





101 Marietta Street NW  
Suite 2100  
Atlanta, Georgia 30303  
[www.ykkap.com](http://www.ykkap.com)