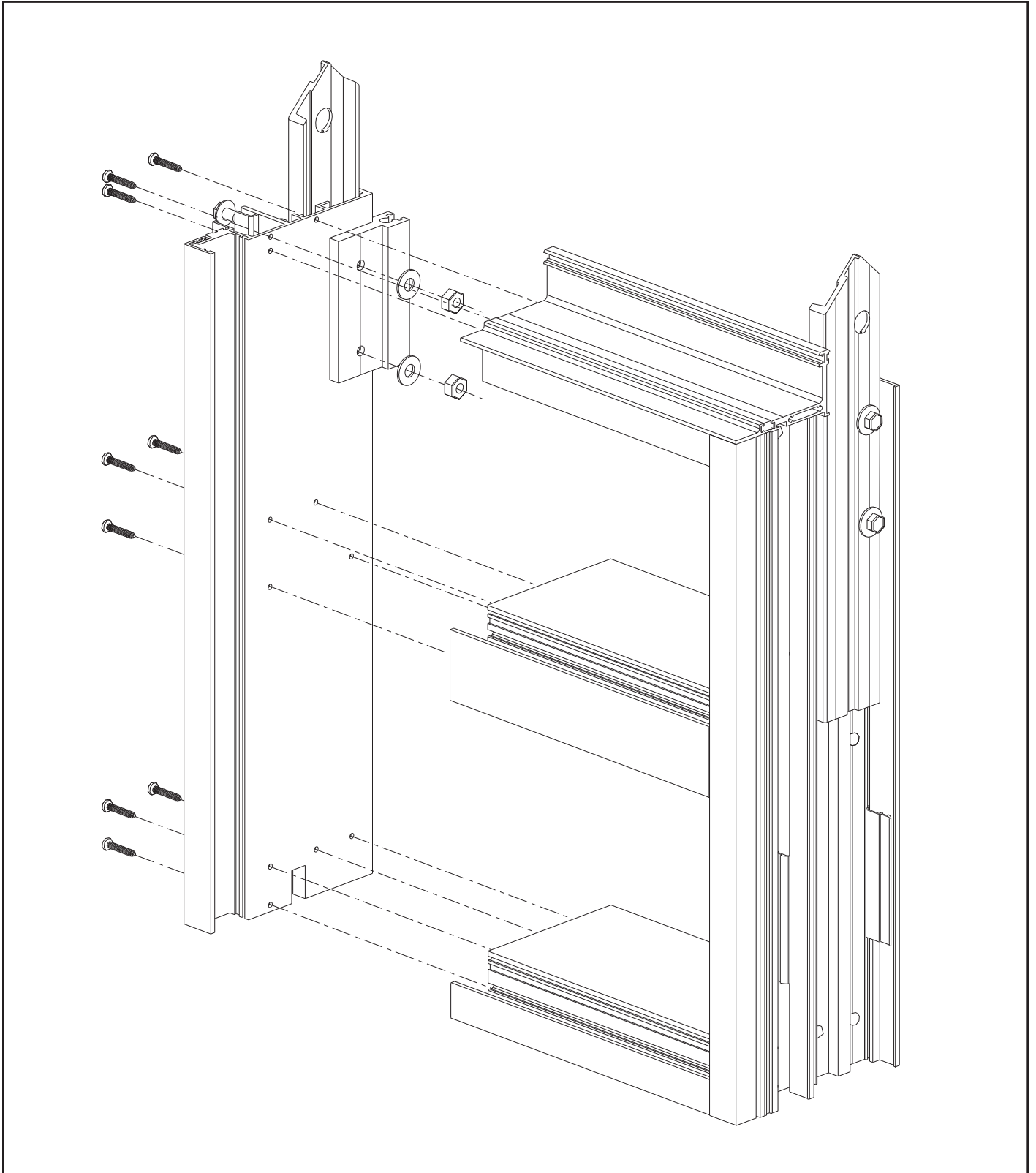


ASSEMBLY INSTRUCTIONS



Assembly Manual



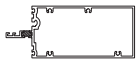


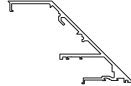

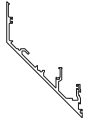




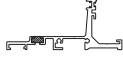

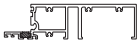







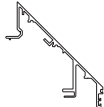
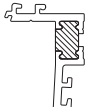
## TABLE OF CONTENTS

Installation Notes .....	Page ii
<b>PARTS DESCRIPTION</b>	
YCU 750 TU Framing Members.....	Page 1
YCU 750 TU Accessories.....	Page 2 to 4
<b>FRAME ASSEMBLY</b>	
Attach Verticals Mullions to Horizontals Mullions.....	Page 5 & 6
Outside Corner Mullion Assembly .....	Page 7
Inside Corner Mullion Assembly.....	Page 8
Apply Sealant to Frame Joints .....	Page 9
Install Mullion Clips.....	Page 10
Install Mullion Splice Sleeves and Leveling Brackets .....	Page 11
Install Setting Block Chairs and Setting Blocks.....	Page 12
Install Gaskets to Vertical Mullions.....	Page 13 & 14
Install Jamb Gaskets .....	Page 15
<b>GLAZING</b>	
Install Glazing Adaptors.....	Page 16
Install Interior Glazing Gaskets .....	Page 17
Install Glass .....	Page 18
Insert Side Blocks .....	Page 19 & 20
Apply Sealant .....	Page 21
Attach Stacking Tray .....	Page 22 & 23
Apply Sealant to Frame Connections.....	Page 24
Install Glass Stops.....	Page 25
Install Exterior Glazing Gaskets .....	Page 26
<b>FRAME ASSEMBLY</b>	
Install Stacking Tray Gasket and Spacer .....	Page 27 & 28
Install End Dam .....	Page 29
Install End Caps .....	Page 30
Install Horizontal Thermal Gasket .....	Page 31
Assemble Sill Starter .....	Page 32 & 33

## 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. If any questions arise concerning YKK AP products or their installation, contact YKK AP for clarification before proceeding.
11. 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.
12. Cutting tolerances are plus zero, minus one thirty second unless otherwise noted.
13. Check our website, [www.ykkap.com](http://www.ykkap.com), for the latest installation manual update prior to commencing work.

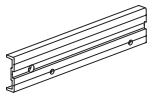

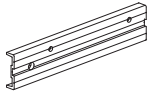

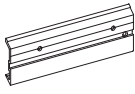

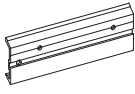






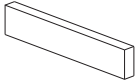

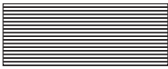




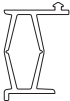



## FRAMING MEMBERS

	<b>Intermediate Horizontal</b>	<b>BE9-3806</b>		<b>Outside Corner Mullion Female</b>	<b>E9-3814</b>
	<b>Head</b>	<b>E9-3803</b>		<b>Inside Corner Mullion Male</b>	<b>E9-3817</b>
	<b>Stacking Tray</b>	<b>BE9-3804</b>		<b>Inside Corner Mullion Female</b>	<b>E9-3818</b>
	<b>Vertical Mullion Male</b>	<b>BE9-3801</b>		<b>Glass Stop</b>	<b>E9-3807</b>
	<b>Vertical Mullion Female</b>	<b>BE9-3802</b>		<b>Head Glass Stop</b>	<b>E9-3808</b>
	<b>Heavy Duty Sill Starter</b>	<b>BE9-3834</b>		<b>Horizontal Glass Stop</b>	<b>E9-3809</b>
	<b>Sill</b>	<b>BE9-3805</b>		<b>Male Mullion Adaptor</b>	<b>E9-3819</b>
	<b>Jamb</b>	<b>BE9-3810</b>		<b>Inside Corner Adaptor</b>	<b>BE9-3820</b>
	<b>Jamb Trim</b> Use with BE9-3810	<b>BE9-3811</b>		<b>Inside Corner Glazing Adaptor</b>	<b>E9-3821</b>
	<b>Jamb Interior Cover</b>	<b>E9-3812</b>		<b>Outside Corner Glass Stop</b>	<b>E9-3816</b>
	<b>Outside Corner Mullion Male</b>	<b>E9-3813</b>		<b>Outside Corner Adaptor</b>	<b>BE9-3815</b>

## ACCESSORIES

	<b>Mullion Clip</b>	<b>E1-3901</b>		<b>Jamb End Dam</b>	<b>E1-3913</b>
	<b>Setting Block Chair</b>	<b>E1-3902</b>		<b>Mullion Splice Sleeve For Left Outside Corner Mullion</b>	<b>E1-3914</b>
	<b>Mullion Splice Sleeve Left</b>	<b>E1-3903</b>		<b>Mullion Splice Sleeve For Right Outside Corner Mullion</b>	<b>E1-3915</b>
	<b>Mullion Splice Sleeve Right</b>	<b>E1-3904</b>		<b>Outside Corner Leveling Bracket</b>	<b>E1-3916</b>
	<b>Leveling Bracket</b>	<b>E1-3905</b>		<b>L Anchor For Outside Corner</b>	<b>E1-3917</b>
	<b>Bracket Sleeve</b>	<b>E1-3906</b>		<b>Mullion End Cap For Outside Corner</b>	<b>E1-3918</b>
	<b>L Anchor</b>	<b>E1-3907</b>		<b>Inside Corner Leveling Bracket</b>	<b>E1-3919</b>
	<b>Lock Washer</b>	<b>E1-3908</b>		<b>Reinforcement Adaptor</b>	<b>E1-3920</b>
	<b>Stopper</b>	<b>E1-3909</b>		<b>Reinforcement Adaptor For Outside Corner</b>	<b>E1-3921</b>
	<b>Mullion End Cap</b>	<b>E1-3910</b>		<b>Slab Edge Anchor</b>	<b>E1-3922</b>
	<b>Mullion End Cap For Inside Corner</b>	<b>E1-3911</b>		<b>Slab Edge Anchor Spacer</b>	<b>E1-3923</b>
	<b>Mullion End Cap For Jamb</b>	<b>E1-3912</b>		<b>Heavy Duty Sill Starter Reinforcement Clip</b>	<b>E1-3924</b>

## ACCESSORIES

	<b>Top Unit Lift Bracket For Left Mullion</b>	<b>E1-3925</b>		<b>Side Block EPDM</b>	<b>E2-3903</b>
	<b>Top Unit Lift Bracket For Right Mullion</b>	<b>E1-3926</b>		<b>Side Block Silicone</b>	<b>E2-3913</b>
	<b>Top Unit Lift Bracket For Left Outside Corner Mullion</b>	<b>E1-3927</b>		<b>Side Block EPDM</b>	<b>E2-3914</b>
	<b>Top Unit Lift Bracket For Right Outside Corner Mullion</b>	<b>E1-3928</b>		<b>Side Block Silicone</b>	<b>E2-3915</b>
	<b>Vertical Air Tight Gasket</b>	<b>E2-3901</b>		<b>Setting Block EPDM</b>	<b>E2-3907</b>
	<b>Vertical Thermal Gasket</b>	<b>E2-3902</b>		<b>Setting Block Silicone</b>	<b>E2-3917</b>
	<b>Exterior Gasket</b>	<b>E2-3904</b>		<b>Side Block for 1/4" Glass at Inside Corner</b>	<b>E2-9907</b>
	<b>Stacking Tray Gasket</b>	<b>E2-3905</b>		<b>Silicone Splice Sleeve</b>	<b>E2-0070</b>
	<b>Stacking Tray Spacer</b>	<b>E2-3906</b>		<b>#12 x 1" FHSMS</b> Stainless Steel, For Attachment of Stacking Tray to Head E9-3803	<b>FS-1216 -SS</b>
	<b>Interior Gasket for Inside Corner Mullion</b>	<b>E2-3910</b>		<b>3/8" x 2 1/4" HWHMS</b> Zinc Plt. Stl., For Attach. of Mullion Splice Sleeve and Leveling Bracket to Vertical	<b>HM-3836</b>
	<b>Horizontal Thermal Gasket</b>	<b>E2-3911</b>		<b>#10 x 5/8" PHSMS</b> Stainless Steel For End Cap Attachment	<b>PC-1010 -SS</b>
	<b>Interior Gasket</b>	<b>E2-3912</b>		<b>#10 x 3/4" TEKPMS</b> Stainless Steel, For Attachment of Corner Adaptor Assembly	<b>PS-1012 -SS</b>

## ACCESSORIES

	<p><b>#12 x 1 1/4" HWHS</b> Stainless Steel For Frame Assembly</p>	<p><b>HC-1220</b> <b>-SS</b></p>	<p><b>3/8" Lock Washer</b> Zinc Plt. Stl., For Attach. of Mullion Splice Sleeve and Leveling Bracket to Vertical</p>	<p><b>WS-3800</b></p>
	<p><b>#12 x 1 3/4" HWHS</b> Stainless Steel For Corner Mullion Assembly</p>	<p><b>HC-1228</b> <b>-SS</b></p>	<p><b>3/8" - 13 Nut HHMS</b> Zinc Plated Steel For Anchor Attachment</p>	<p><b>HM-5000</b></p>
	<p><b>3/8" - 16 Nut HHMS</b> Zinc Plt. Stl., For Attach. of Mullion Splice Sleeve and Leveling Bracket to Vertical</p>	<p><b>HM-3800</b></p>	<p><b>1/2" x 2 1/2" HWHMS</b> Zinc Plated Steel For Anchor Attachment</p>	<p><b>HM-5040</b></p>
	<p><b>1/2"-13 x 1/2" Set Screw</b> Zinc Plated Steel, For Leveling Bracket</p>	<p><b>YM-5008</b></p>	<p><b>1/2" Lock Washer</b> Zinc Plated Steel For Anchor Attachment</p>	<p><b>WS-5000</b></p>
	<p><b>#10 x 1" TEKPHS</b> Stainless Steel, For Inside Corner Adaptor Assembly</p>	<p><b>PS-1216</b> <b>-SS</b></p>		



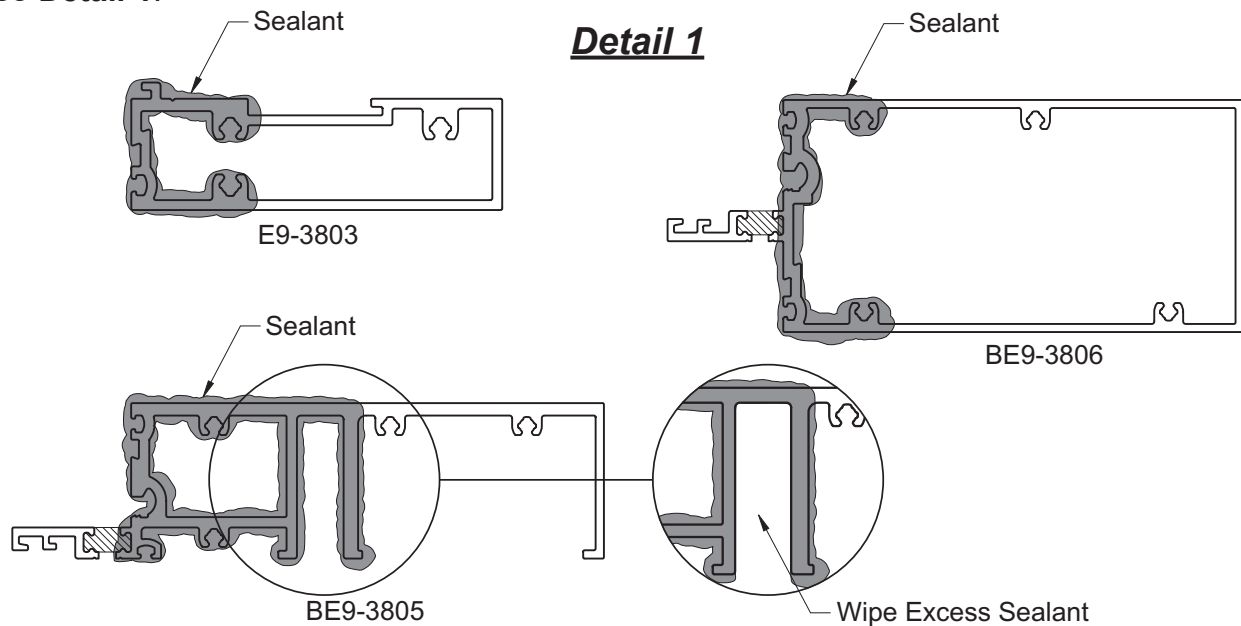
## FRAME ASSEMBLY

### STEP 1

#### ATTACH VERTICAL MULLIONS TO HORIZONTAL MULLIONS

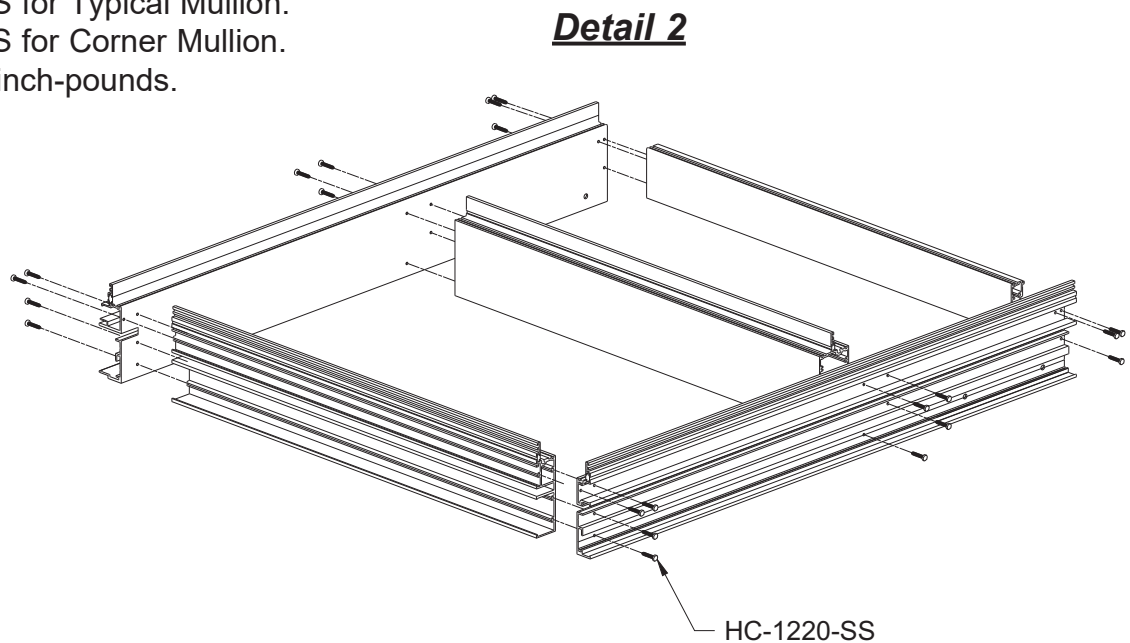
- Apply medium modulus silicone sealant to each end of the horizontal members prior to attaching to the vertical members.
- Wipe away excess sealant from area indicated in BE9-3805.

See **Detail 1**.



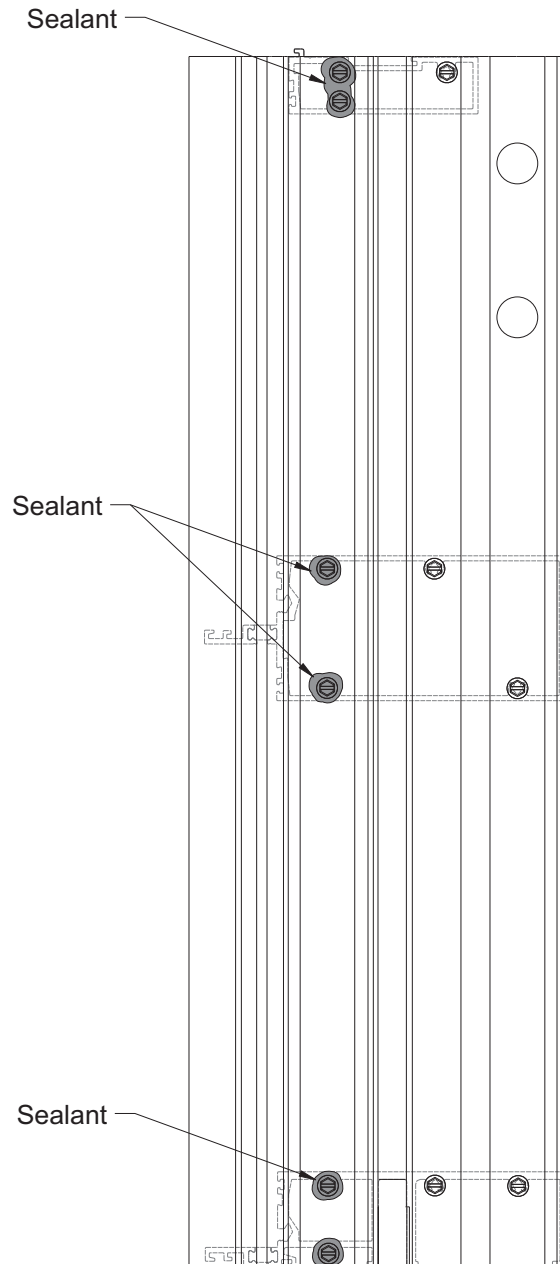
- Assemble horizontal members using #12 screws.  
 HC-1220-SS for Typical Mullion.  
 HC-1228-SS for Corner Mullion.
- Torque to 50 inch-pounds.

See **Detail 2**.



**FRAME ASSEMBLY****STEP 2****APPLY SEALANT TO SCREW HEADS ON VERTICAL MULLION**

-Apply and tool medium modulus silicone sealant to screw heads at areas shown in **Detail 3**.



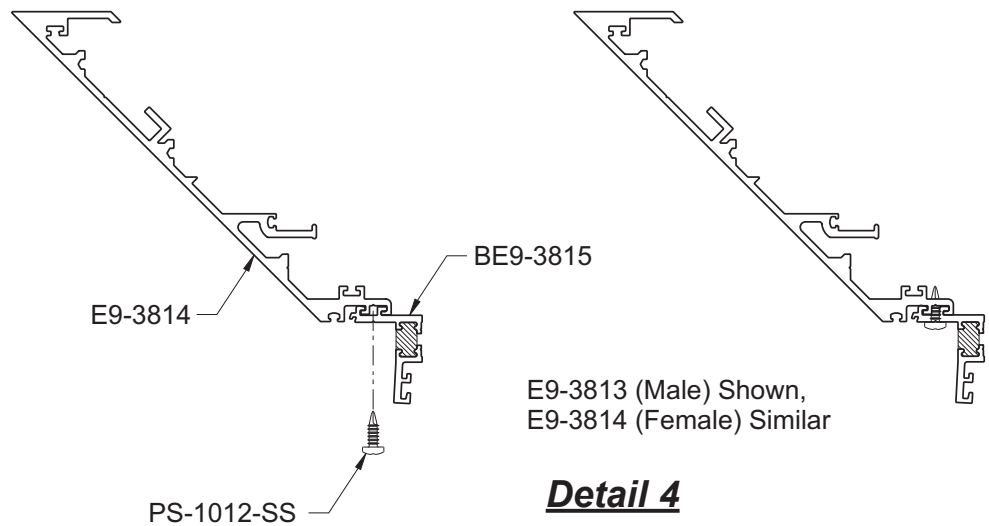
***Detail 3***

## CORNER FRAME ASSEMBLY

### STEP 3 OUTSIDE CORNER MULLION ASSEMBLY

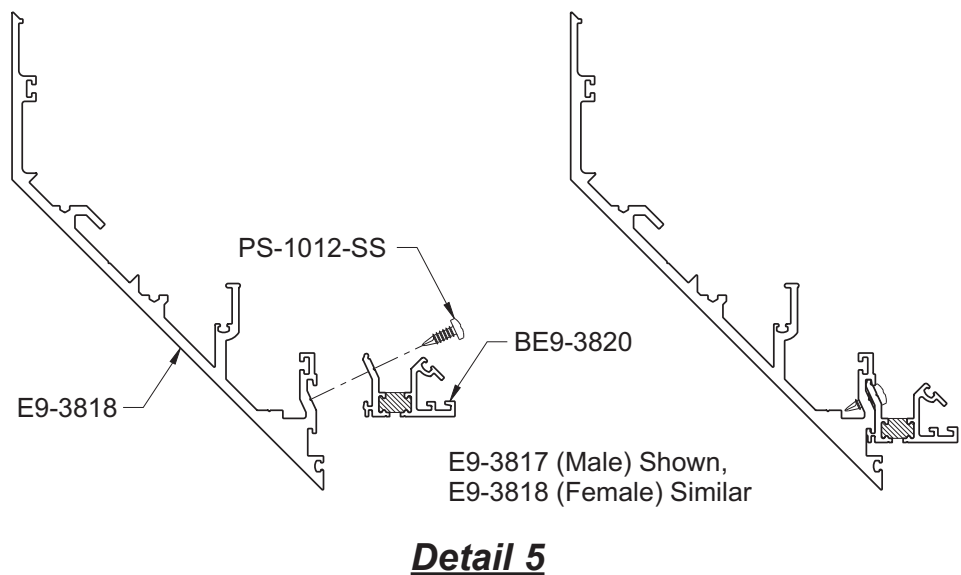
-Attach the outside corner adaptor, BE9-3815, to outside corner mullions E9-3813 and E9-3814 using PS-1012-SS screws.

See **Detail 4**.



-Attach the inside corner adaptor, BE9-3820, to inside corner mullions E9-3817 and E9-3818 with PS-1012-SS screws.

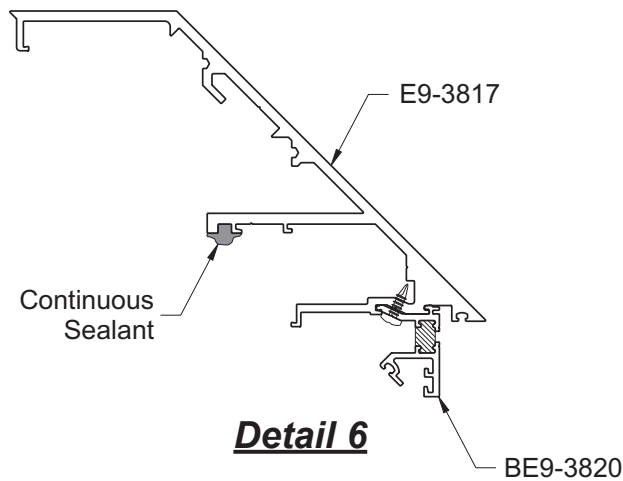
See **Detail 5**.



## CORNER FRAME ASSEMBLY

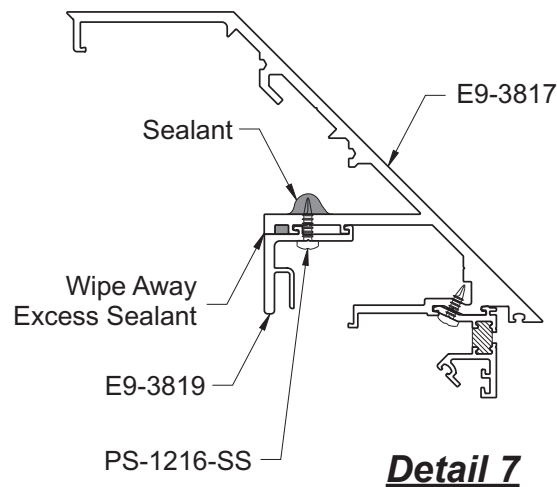
### STEP 4 INSIDE CORNER MULLION ASSEMBLY

-Apply a medium modulus silicone sealant continuously to the groove on the inside corner male mullion, E9-3817, prior to attaching the male mullion adaptor E9-3819 as shown in **Detail 6**.



- Install the male mullion adaptor, E9-3819, using PS-1216-SS screws.
- PS-1216-SS screw should be located 1-1/2" for each end, and 12" on center thereafter.
- Wipe away excess sealant as shown in **Detail 7**.
- Apply a medium modulus silicone sealant to each screw point location.

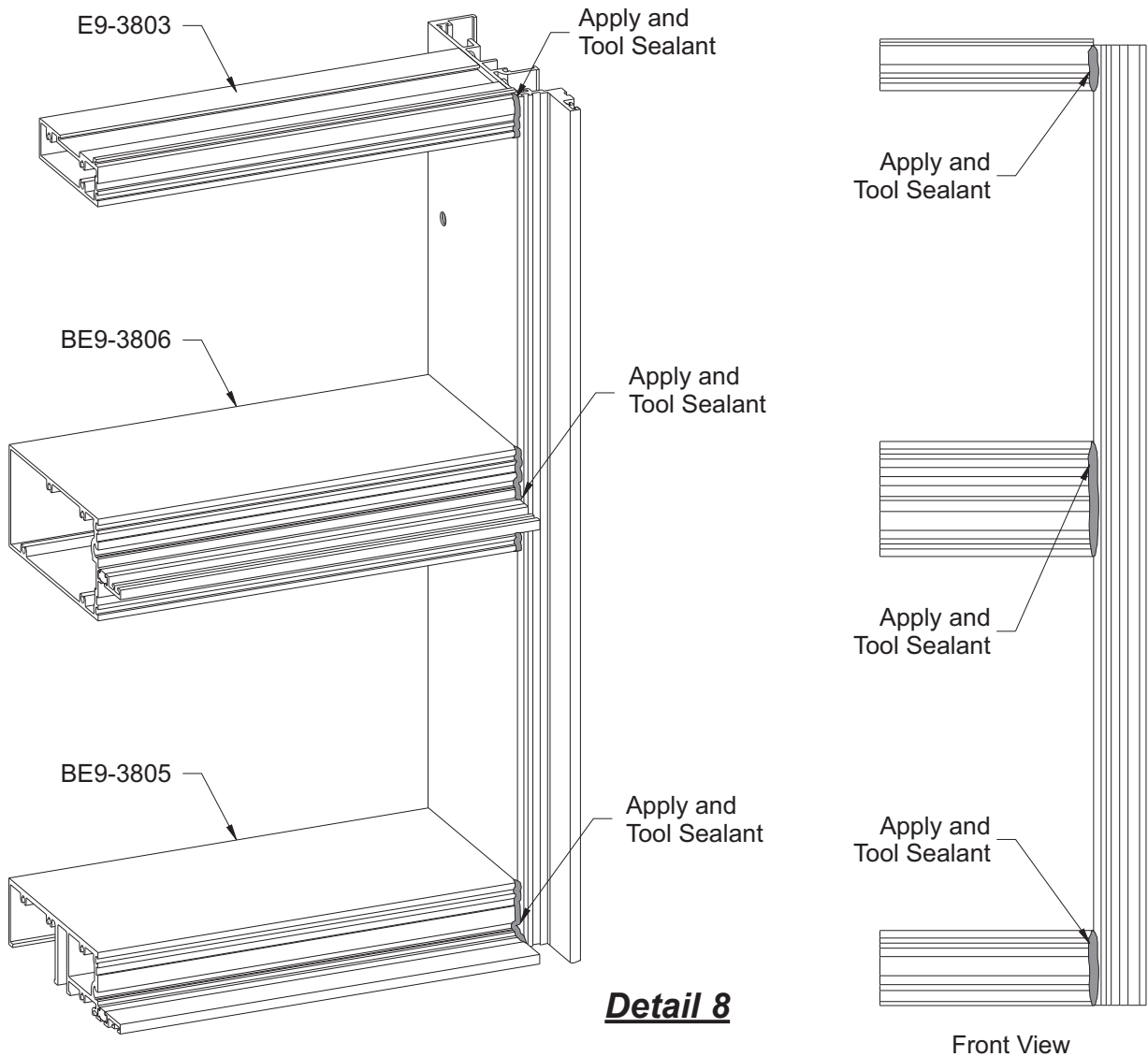
See **Detail 7**.



## FRAME ASSEMBLY

### STEP 5 APPLY SEALANT TO FRAME JOINTS

-Apply and tool a medium modulus silicone sealant to areas indicated in **Detail 8**.



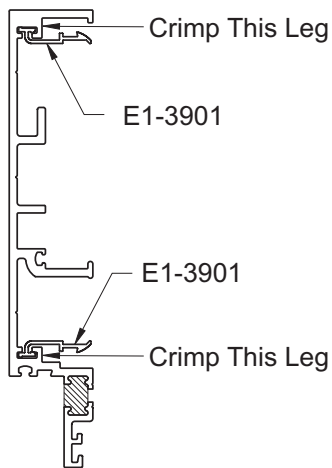
**FRAME ASSEMBLY****STEP 6  
SLIDE MULLION CLIPS INTO FEMALE MULLION**

-Reference shop drawings for correct spacing, quantity, and location of mullion clip E1-3901.

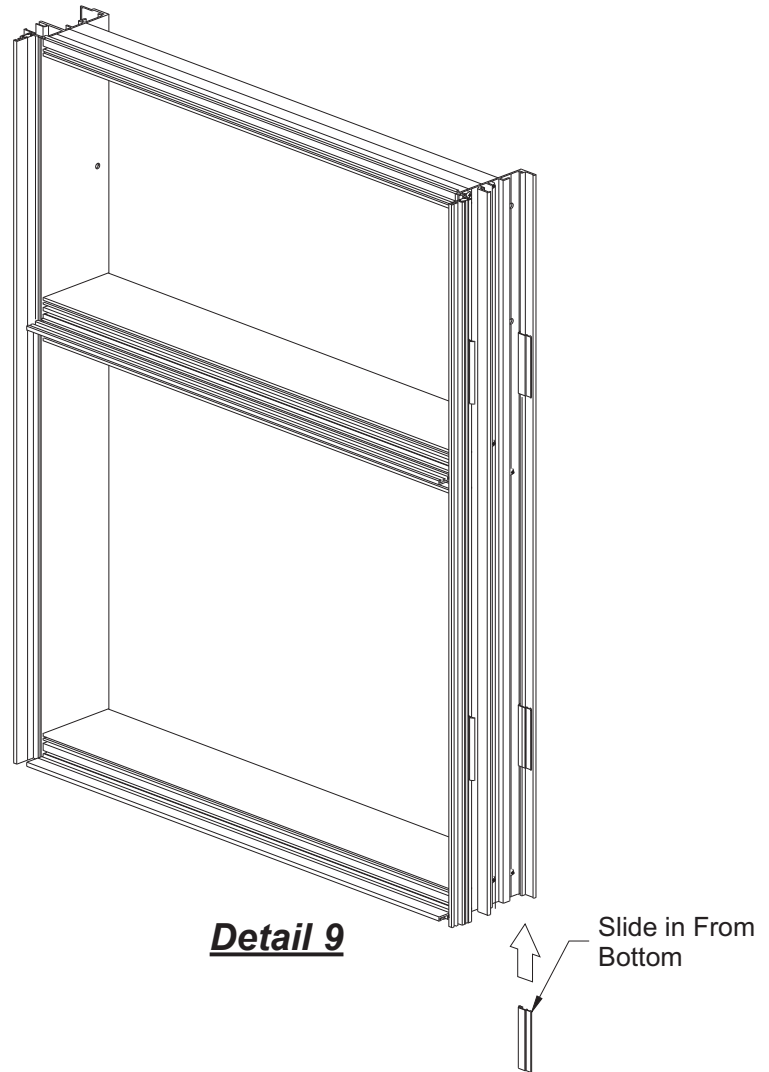
See **Detail 9**.

-Crimp the leg of the female mullion above and below each mullion clip to prevent the mullion clip from sliding out of place.

See **Detail 10**.



**Detail 10**

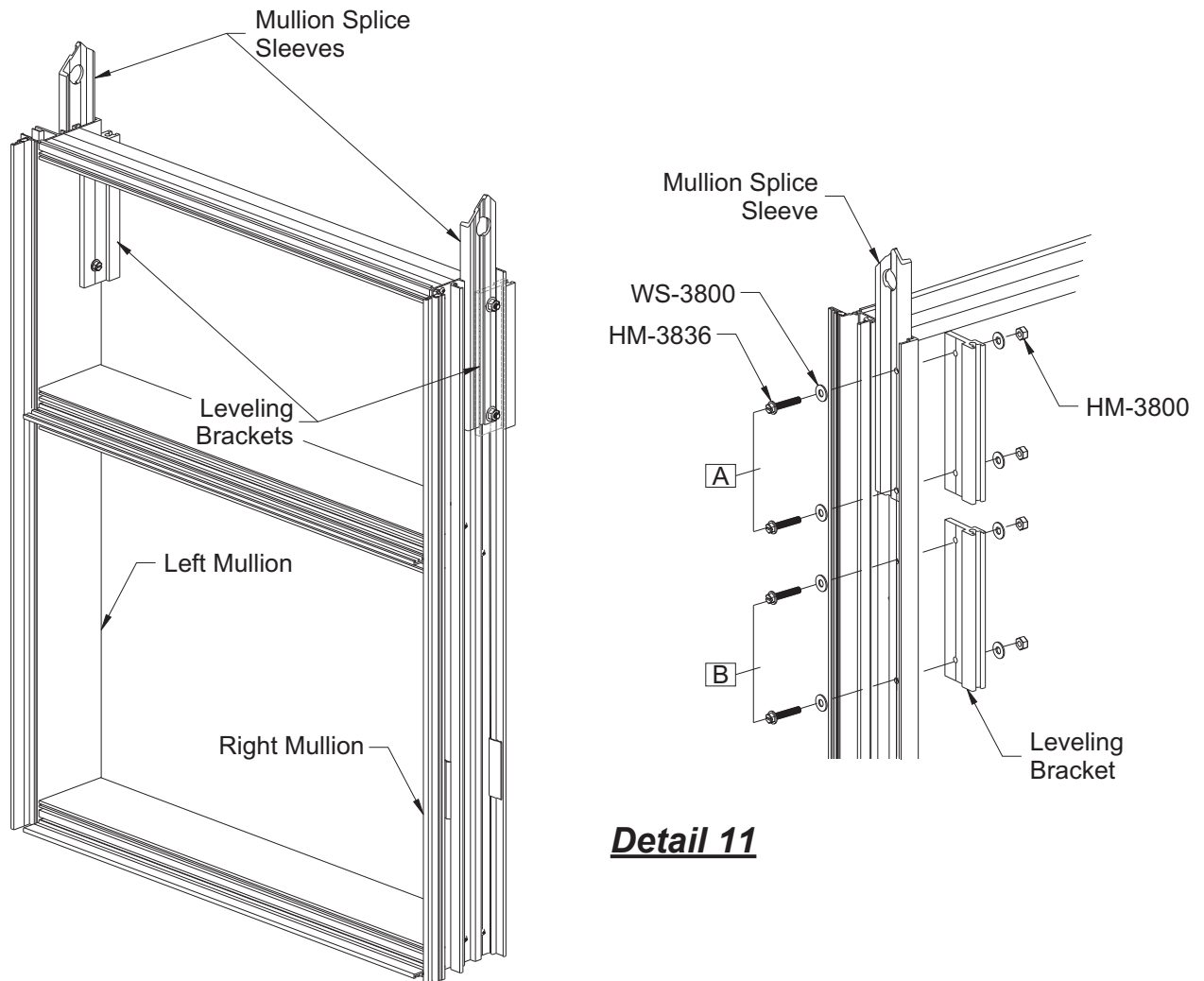


## FRAME ASSEMBLY

### STEP 7

### INSTALL MULLION SPLICE SLEEVES AND LEVELING BRACKETS

- Install the mullion splice sleeves and leveling brackets using two (2) HM-3800 nuts, four (4) WS-3800 washers, and two (2) HM-3836 bolts as shown in **Detail 11**.
- Location "A" for typical conditions.
- Location "B" for cantilever locations, refer to shop drawings.



**Mullion Splice Sleeve and Leveling Bracket Chart**

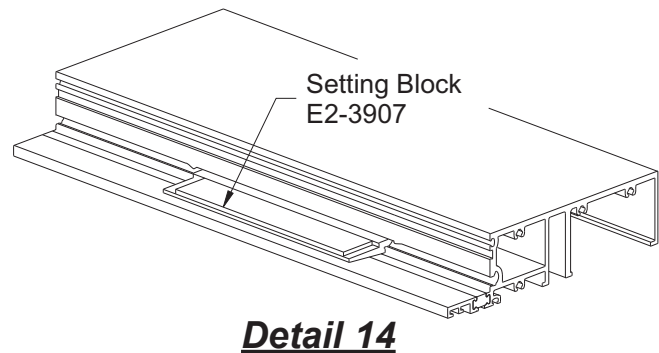
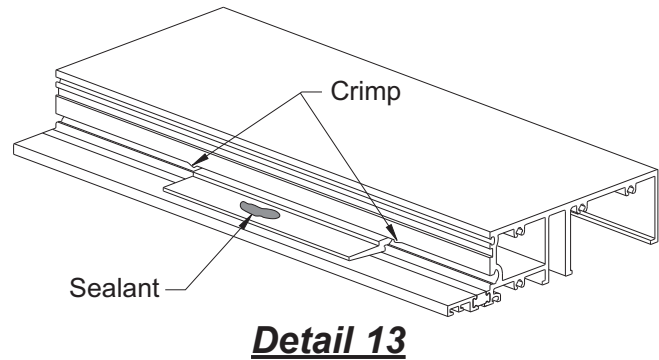
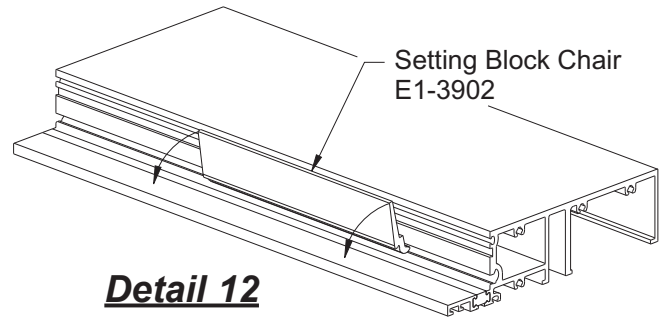
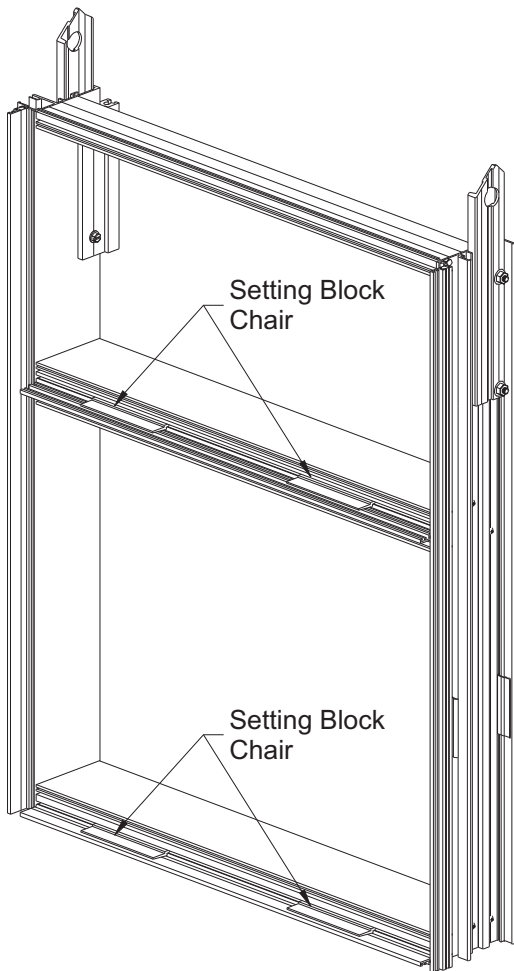
		TYPICAL FLOOR		TOP FLOOR	
		Mullion Splice	Leveling Bracket	Lift Bracket	Leveling Bracket
Typical Mullion	LEFT	E1-3903	E1-3905	E1-3925	E1-3905
	RIGHT	E1-3904		E1-3926	
Outside Corner Mullion	LEFT	E1-3914	E1-3916	E1-3927	E1-3916
	RIGHT	E1-3915		E1-3928	
Inside Corner Mullion	LEFT	E1-3903	E1-3919	E1-3925	E1-3919
	RIGHT	E1-3904		E1-3926	

**FRAME ASSEMBLY**

**STEP 8**

**INSTALL SETTING BLOCK CHAIRS AND SETTING BLOCKS**

- Install the setting block chair, E1-3902 at 1/4 points as shown in **Detail 12**.
- Crimp the area indicated on both sides of the setting block chair shown in **Detail 13**.
- Apply a small amount of medium modulus silicone sealant to the topside of the setting block chair as shown in **Detail 13**.
- Adhere setting block E2-3907 to the topside of the setting block chair as shown in **Detail 14**.

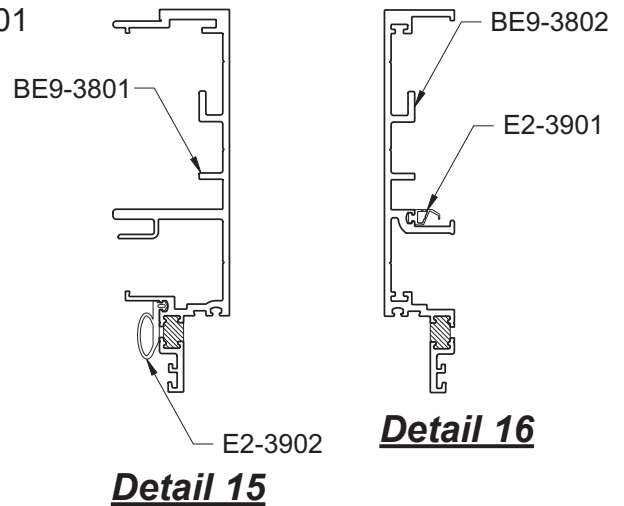




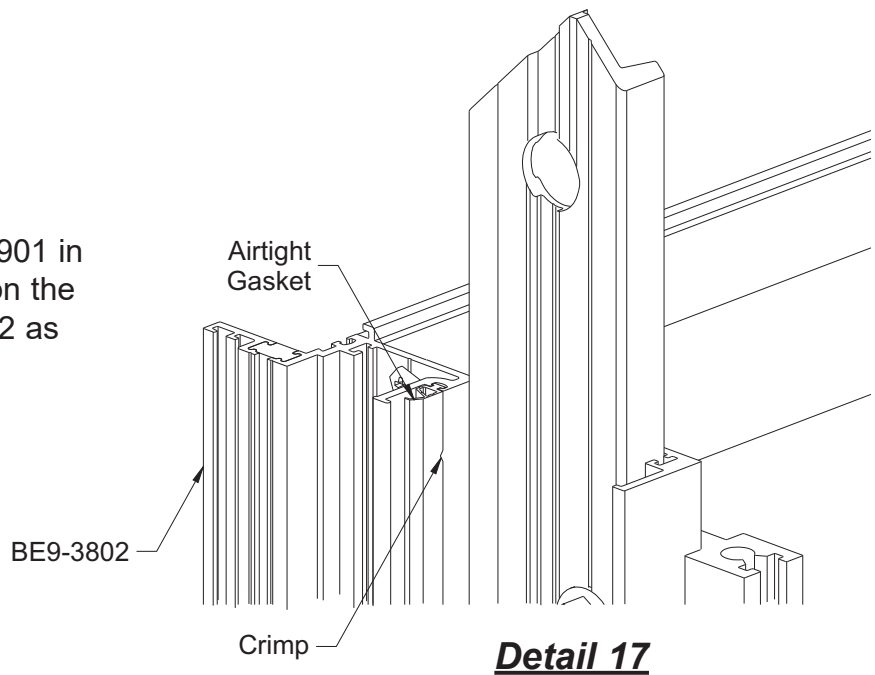
## FRAME ASSEMBLY

### STEP 9 INSTALL VERTICAL MULLION GASKETS

- Attach thermal barrier gasket, E2-3902, to BE9-3801 as shown in **Detail 15**.
- Slide in airtight gasket, E2-3901 to BE9-3802 as shown in **Detail 16**.



- To hold the airtight gasket, E2-3901 in place, crimp the area indicated on the female vertical mullion, BE9-3802 as shown in **Detail 17**.

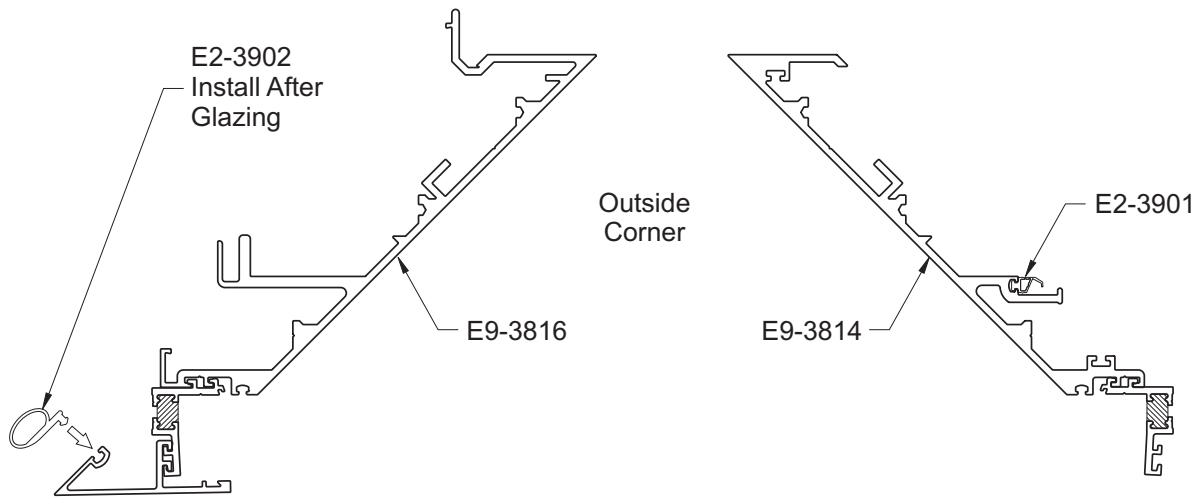


**CORNER FRAME ASSEMBLY**

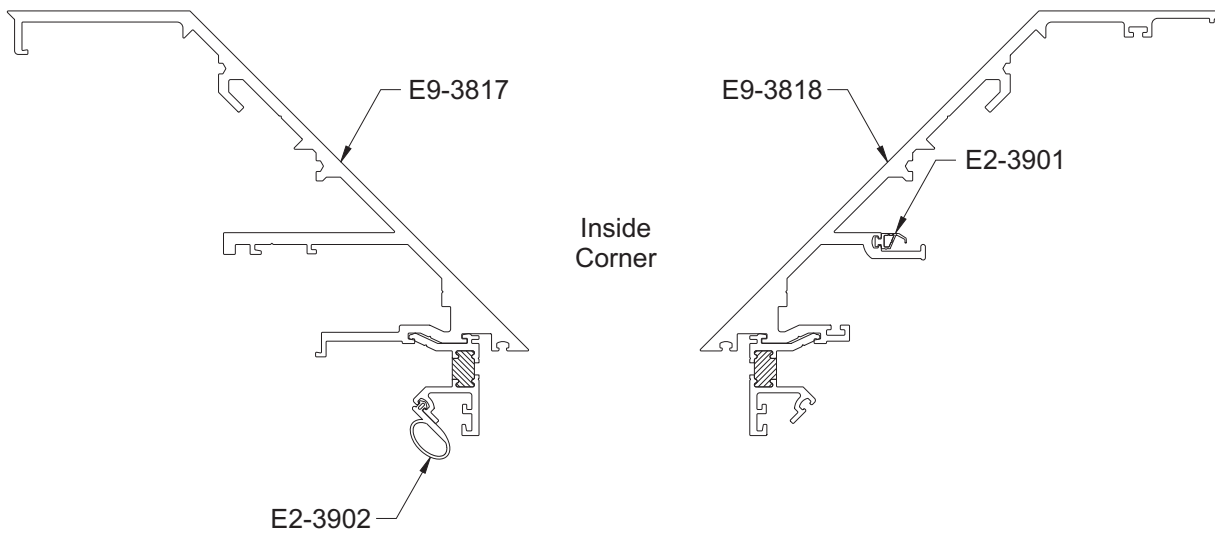
**STEP 10  
INSTALL VERTICAL MULLION GASKETS**

-Install gaskets as shown in **Detail 18** using the same technique as **Step 9**.

**\*NOTE:** E2-3902 must be installed to the outside corner mullion glass stop E9-3816 **After** glazing.



**Detail 18**



## FRAME ASSEMBLY

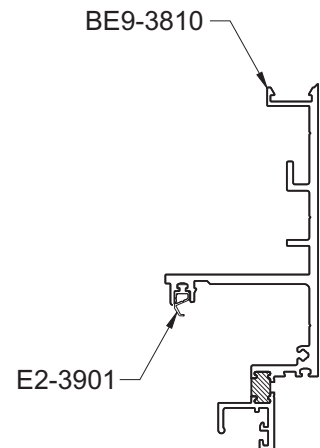
### STEP 11 INSTALL JAMB GASKETS

-Slide in airtight gasket, E2-3901 to BE9-3810 as shown in **Detail 19**.

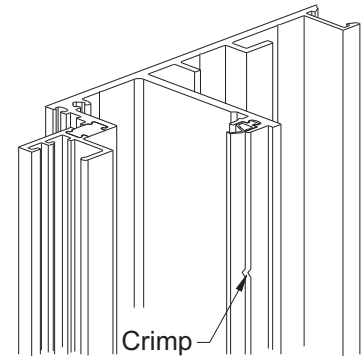
-Crimp the area indicated on the jamb, BE9-3810 as shown in **Detail 20**.

-Attach jamb trim, BE9-3811 to jamb BE9-3810 using PS-1012-SS screws as shown in **Detail 21**. Locations indicated on fabrication drawings.

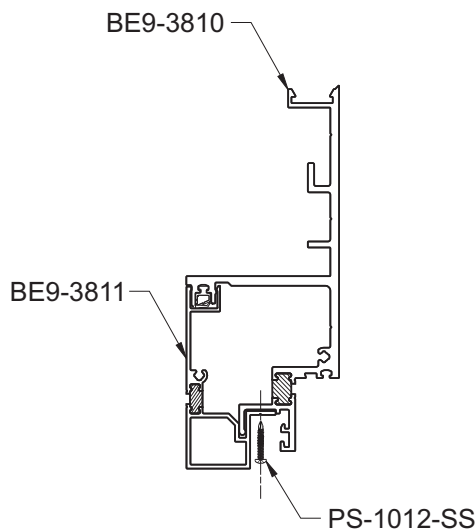
-At the bottom of the jamb assembly, apply a medium modulus silicone sealant to the end of the airtight gasket and run a bead of medium modulus silicone sealant 8" up the seam between the jamb and jamb trim as shown in **Detail 22**.



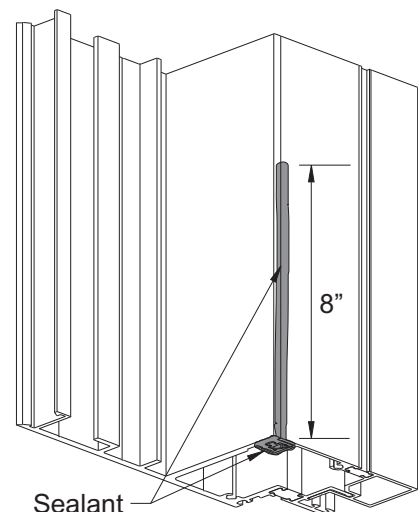
**Detail 19**



**Detail 20**



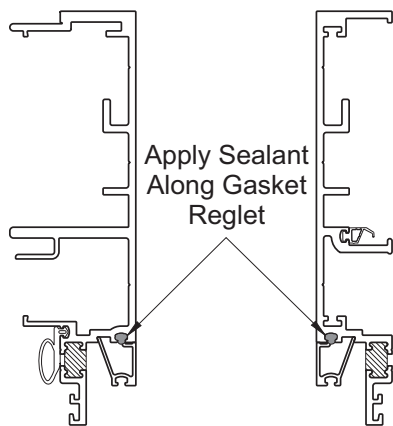
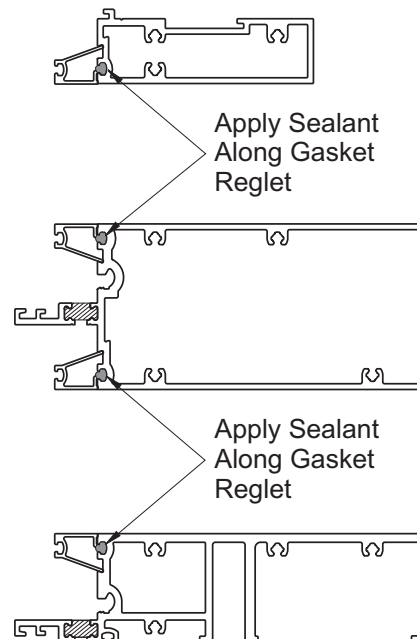
**Detail 21**



**Detail 22**

**GLAZING****STEP 12****INSTALL GLAZING ADAPTORS AS REQUIRED**

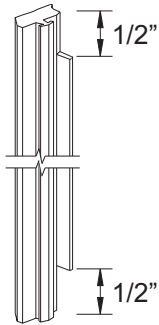
- Apply medium modulus silicone sealant continuously along gasket reglet as shown in **Detail 23**.
- Vertical adaptors snap in first, and run through.
- Snap in horizontal adaptors between vertical adaptors.

**Detail 23**

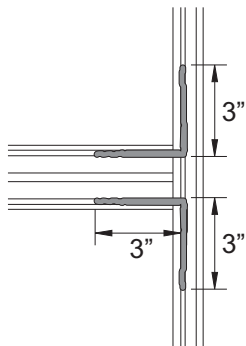
## GLAZING

### STEP 13 INSTALL GLAZING GASKETS

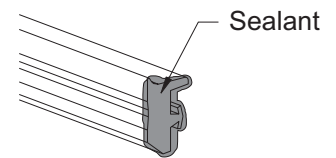
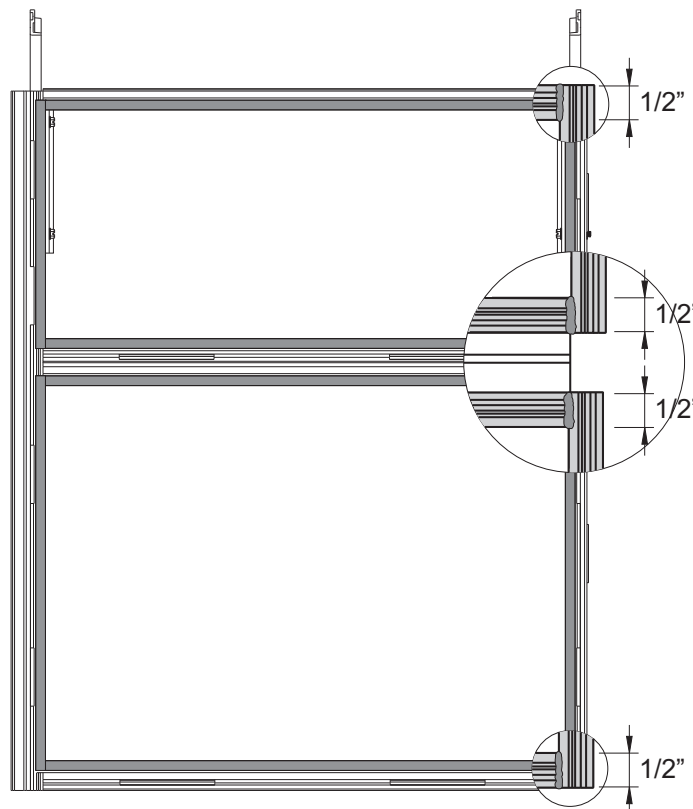
- Cut interior glazing gaskets to size:  
 Vertical Gasket = Daylight Opening + 1".  
 Horizontal Gasket = Daylight Opening + 1/4" per each foot of opening width.
- Install vertical gaskets first, centered along the daylight opening. Notch the lip at both ends of the vertical gasket as shown in **Detail 24**.
- Install horizontal glazing gaskets next.
- Insert the glazing gasket into the reglet at each end first.
- Press the rest of the glazing gasket into the reglet starting at the center and work towards each end.
- Pull the last 3" of each gasket away from the reglet.
- With gasket end held out of the way, run a 3" bead of sealant into the reglet at the ends as shown in **Detail 25**.
- Apply a medium modulus silicone sealant at the ends of the horizontal gaskets as shown in **Detail 26**.
- Reinsert the ends of the gaskets pressing them firmly against the face of the mullions.
- Apply and tool sealant at the intersection of the vertical and horizontal gaskets as shown in **Detail 27**.



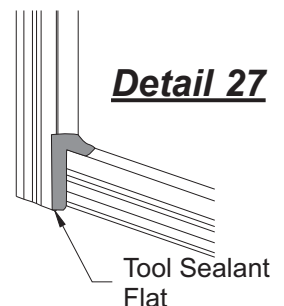
**Detail 24**



**Detail 25**



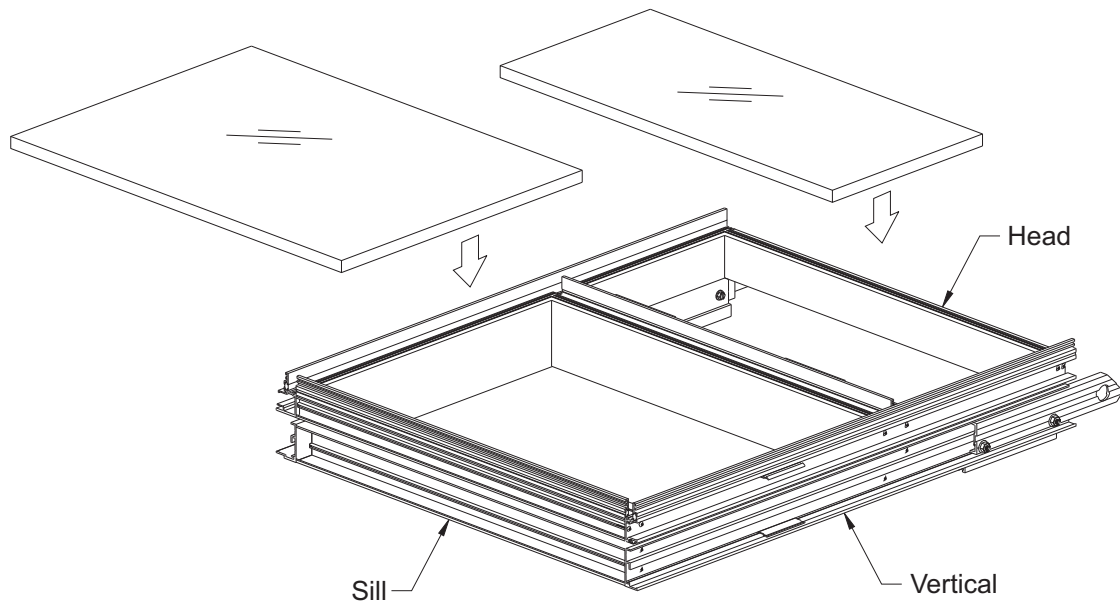
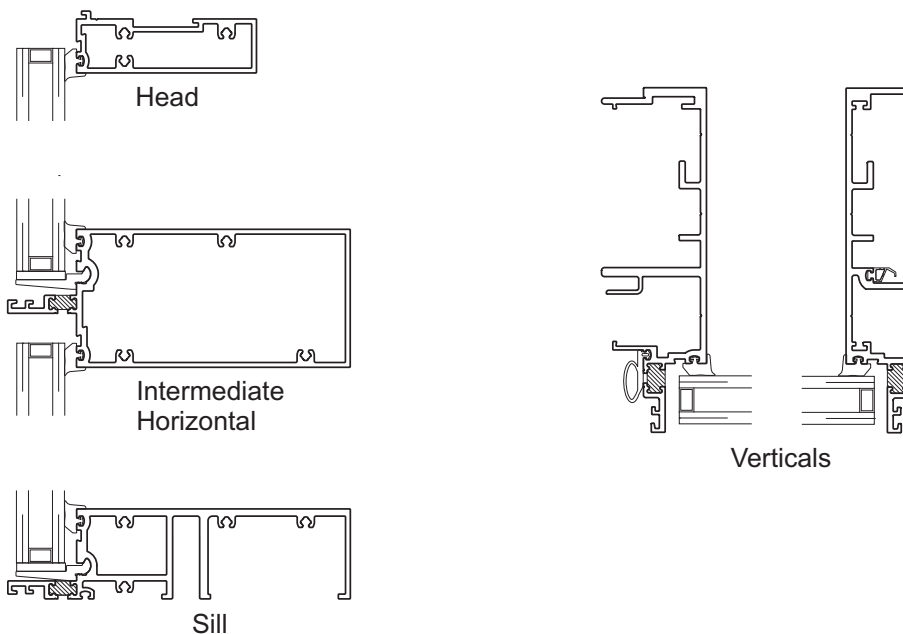
**Detail 26**



**Detail 27**

**GLAZING****STEP 14  
INSTALL THE GLASS**

-Install the glass as shown in **Detail 28**.

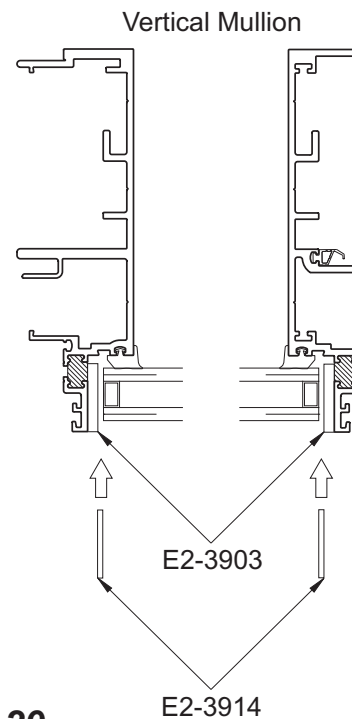
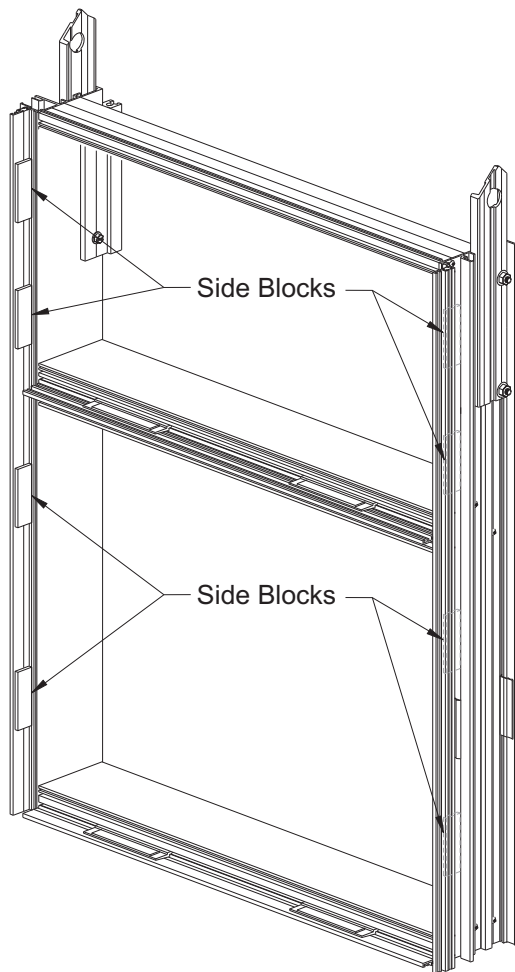
**Detail 28**

## GLAZING

### STEP 15 INSERT SIDE BLOCKS

- Insert E2-3903 side blocks at 1/4 points of the daylight opening.
- To ensure a tight fit between the glass and side block, the addition of side block E2-3914 may be used.

See **Detail 29**.



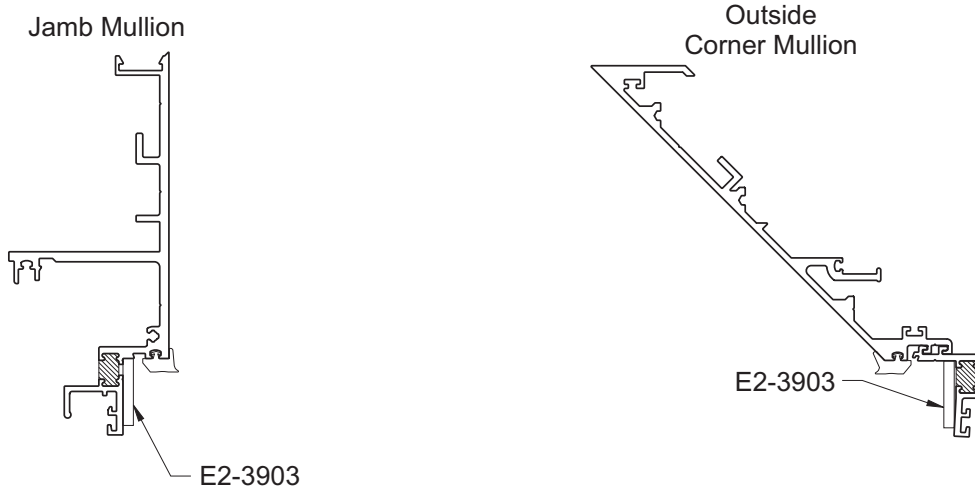
***Detail 29***

**GLAZING**

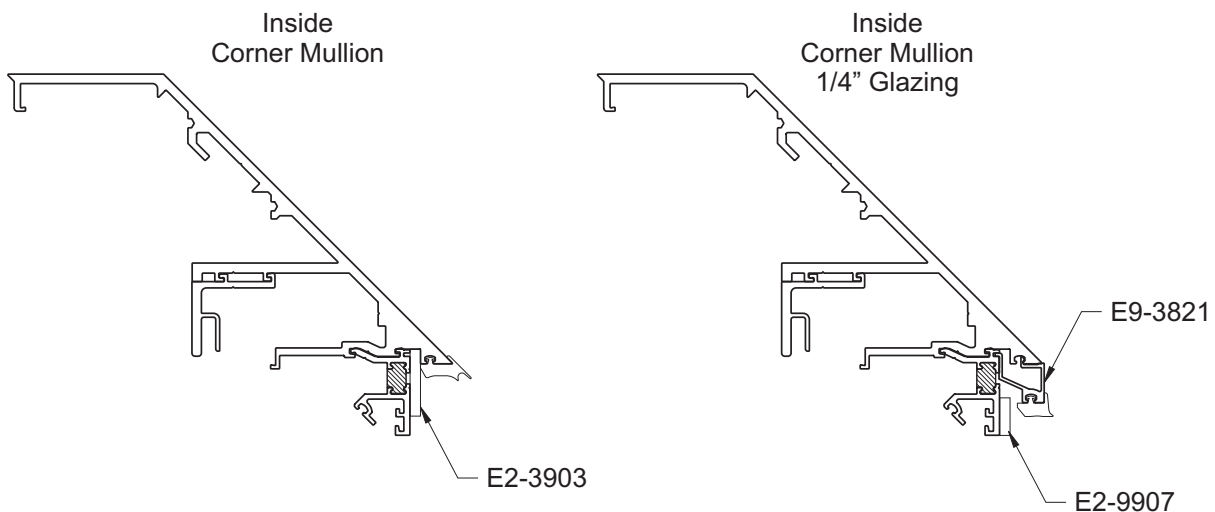
**STEP 15 Continued  
INSERT SIDE BLOCKS**

- Insert E2-3903 side blocks at 1/4 points of the D.L.O. to jamb mullion BE9-3810.
- Insert E2-3903 side blocks at 1/4 points of the D.L.O. to outside corner mullion E9-3814.
- Insert E2-3903 side blocks for 1" glazing, and E2-9907 side blocks for 1/4" glazing at 1/4 points of the D.L.O. to inside corner mullion E9-3817.

See **Detail 30**.



**Detail 30**

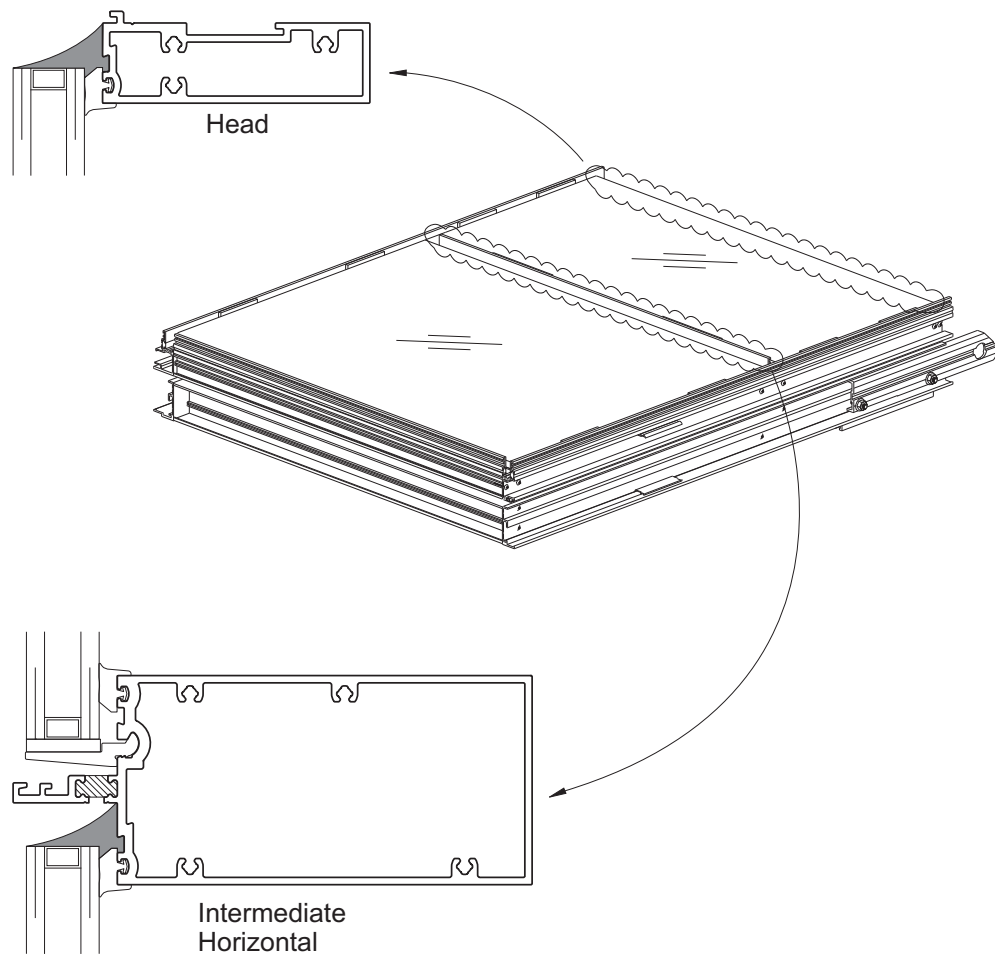




## GLAZING

### STEP 16 APPLY SEALANT

-Apply a medium modulus silicone sealant to the edge of the glass and mullions at the head and intermediate horizontal locations as shown in **Detail 31**.



**Detail 31**

**GLAZING**

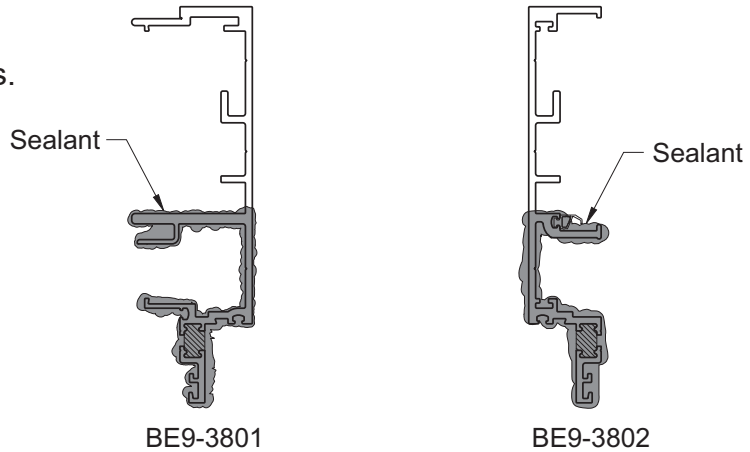
**STEP 17  
ATTACH STACKING TRAY**

-Apply a medium modulus silicone sealant continuously to the top edge of the vertical mullions prior to head attachment.

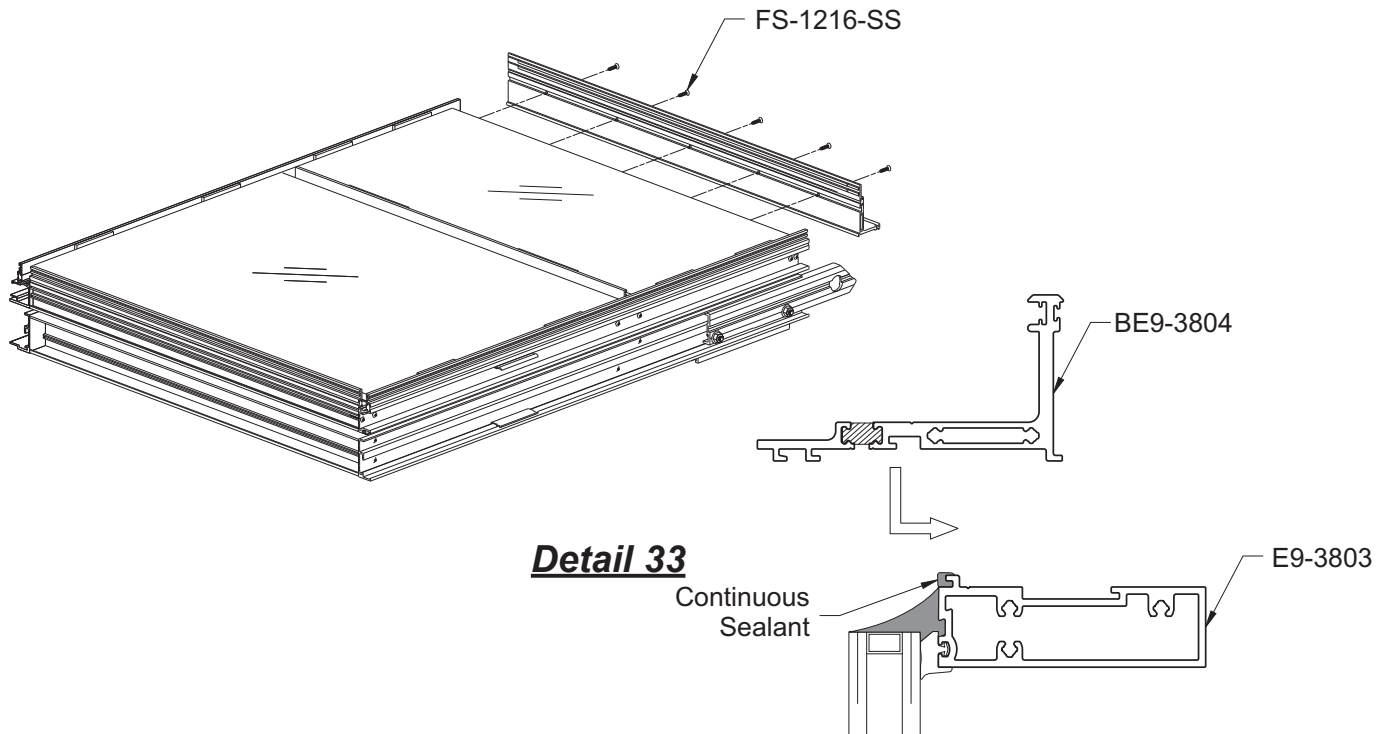
See **Detail 32**.

-Attach head using FS-1216-SS screws.

See **Detail 33**.



***Detail 32***

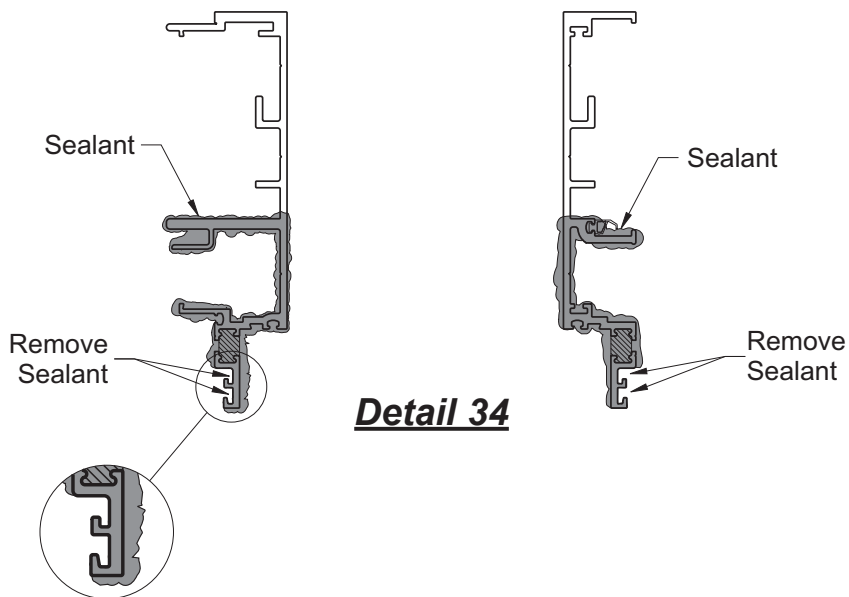


***Detail 33***

## GLAZING

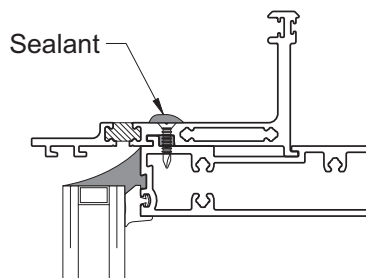
### STEP 17 Continued ATTACH STACKING TRAY

-Wipe away excess sealant at areas indicated in **Detail 34** for glass stop installation.



**Detail 34**

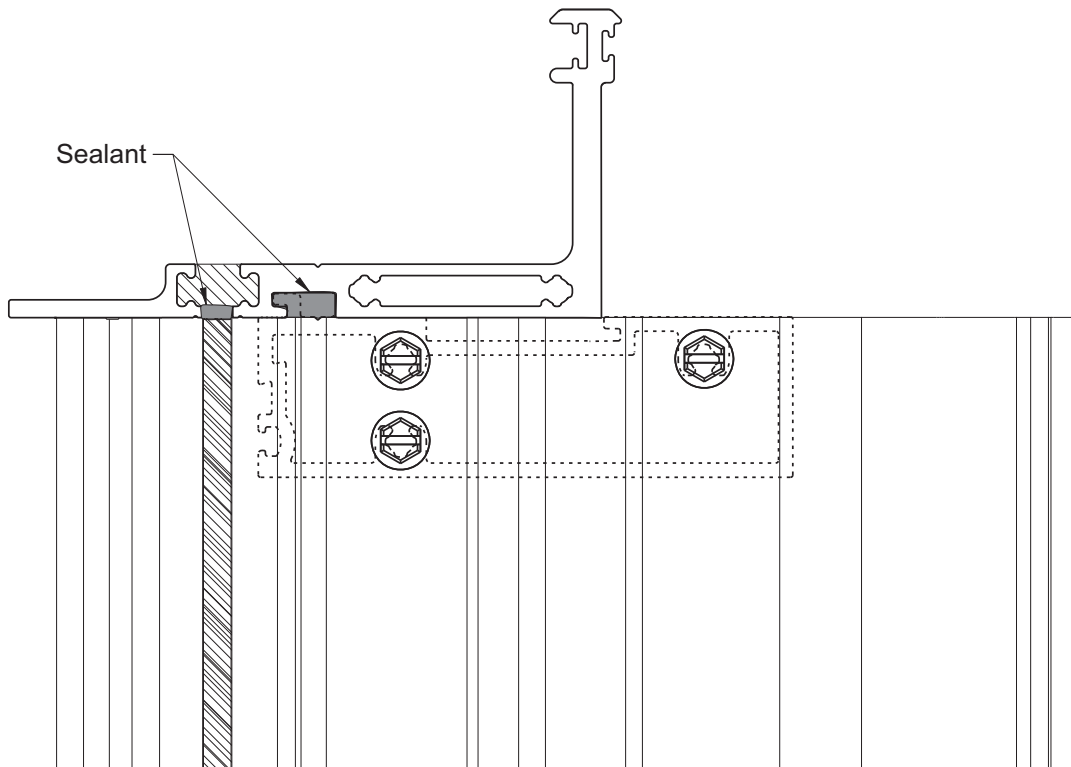
-Seal all screw heads with a medium modulus silicone sealant as shown in **Detail 35**.



**Detail 35**

**GLAZING****STEP 18****APPLY SEALANT TO THE FRAME CONNECTIONS**

-The spaces at the ends of the head attachment and verticals need to be sealed with a medium modulus silicone sealant as shown in **Detail 36**.



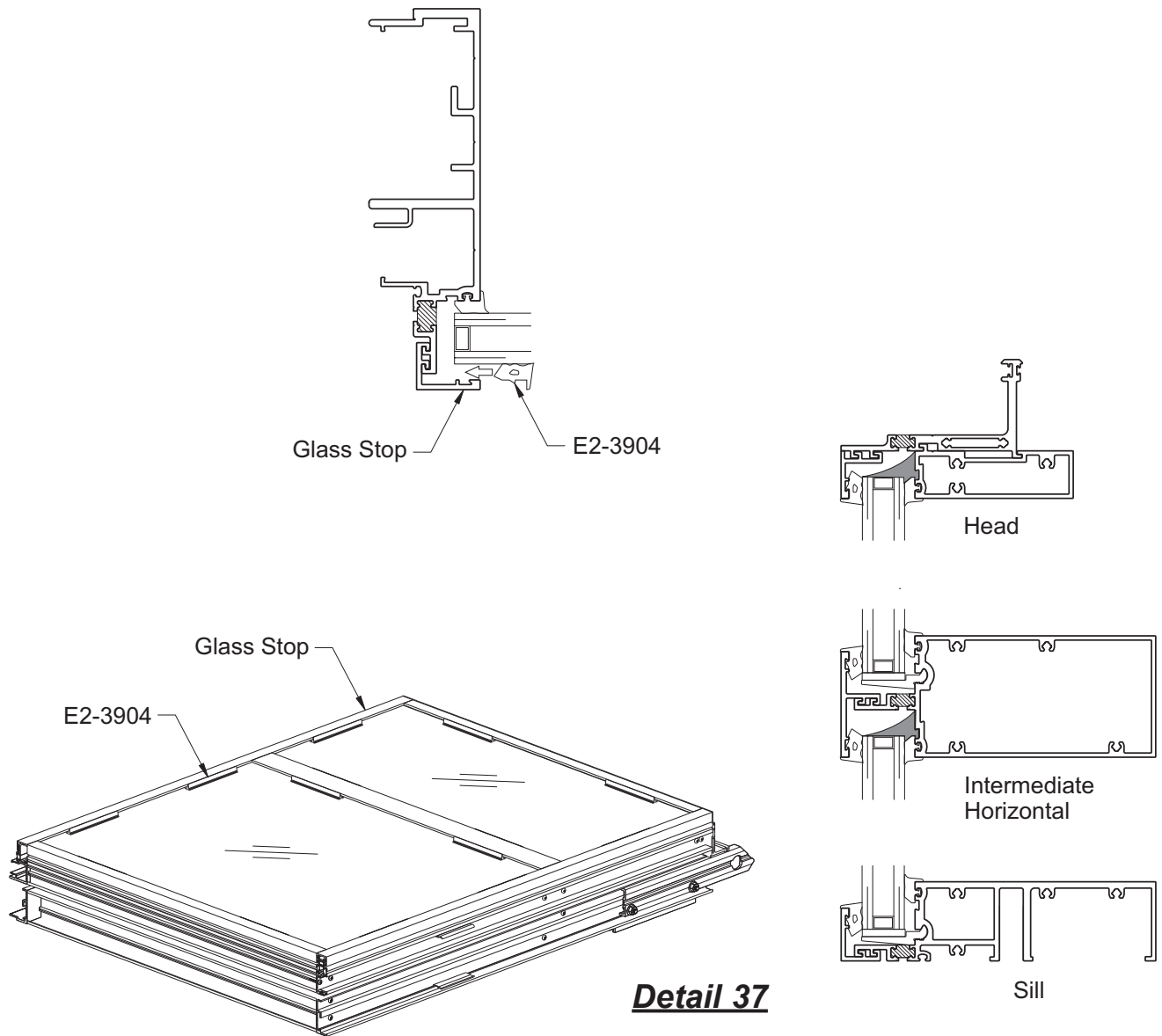
**Detail 36**

## GLAZING

### STEP 19 INSTALL GLASS STOPS

-Install glass stops. Use a piece of gasket E2-3904 temporarily to hold glass stop in place.

See **Detail 37**.

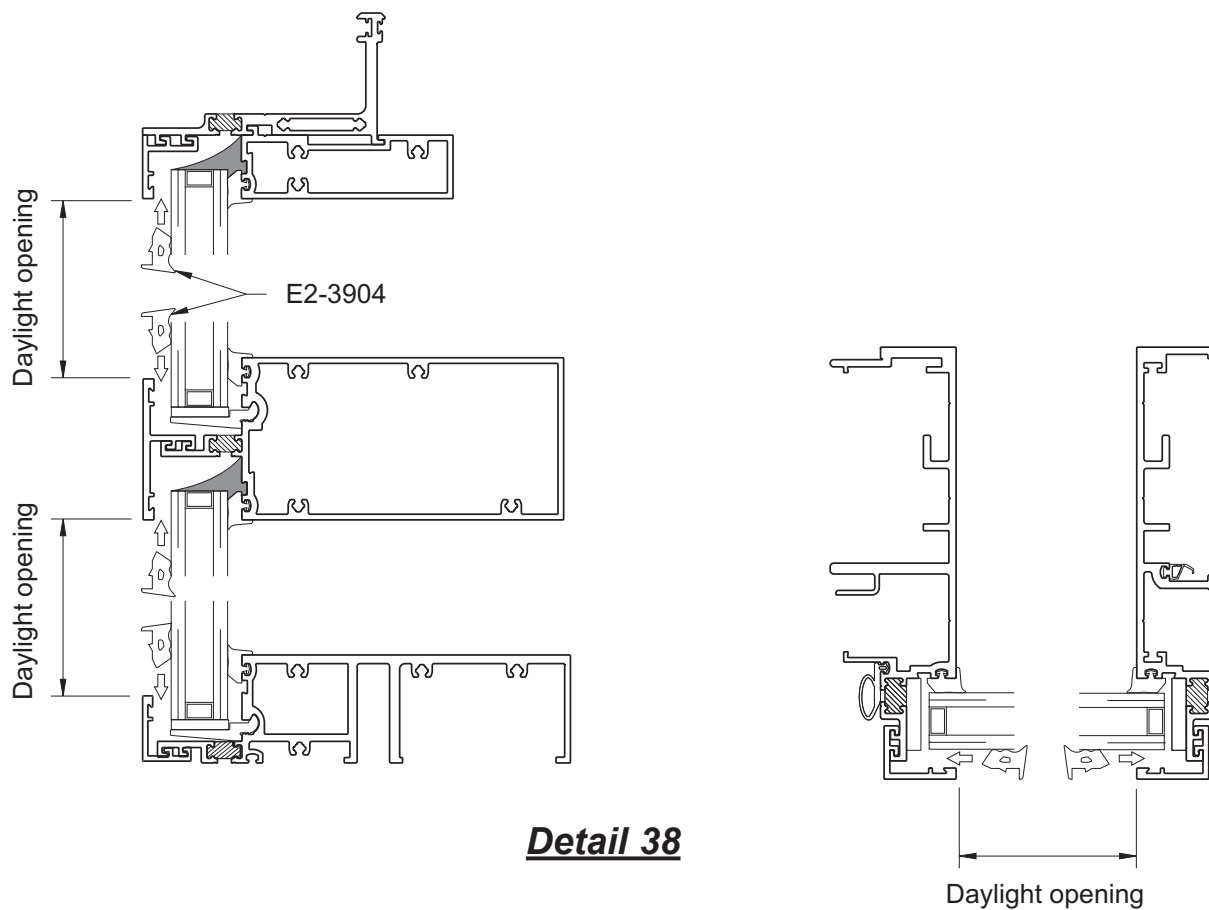


**GLAZING****STEP 20  
INSTALL EXTERIOR GLAZING GASKETS**

- Cut exterior vertical glazing gaskets, E2-3904 to the same length as the daylight opening plus 1/4" per foot of daylight opening height.
- Cut exterior horizontal glazing gaskets, E2-3904 to the same length as the daylight opening plus 1/4" per foot of daylight opening width.

**Caution:** Do not stretch the gaskets.

See **Detail 38**.



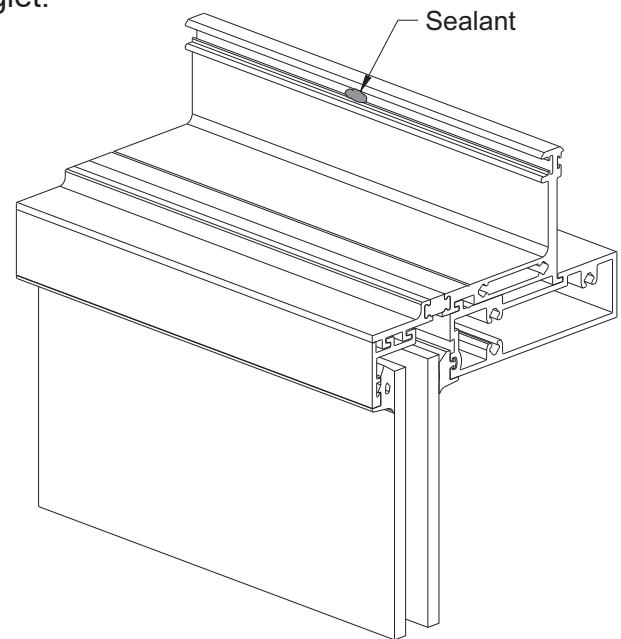
**Detail 38**

## FRAME ASSEMBLY

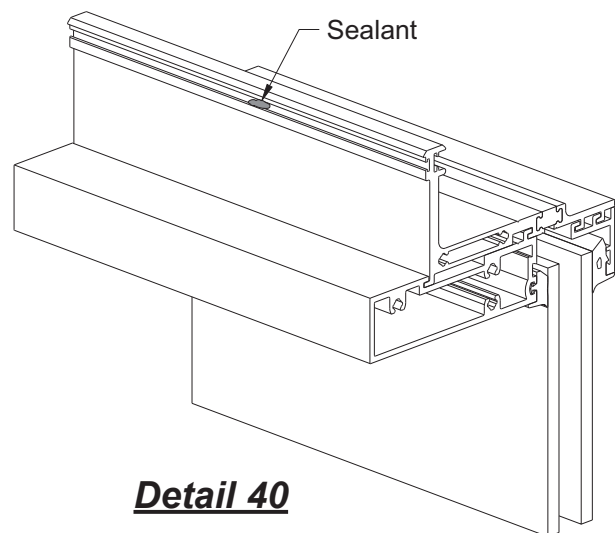
### STEP 21 INSTALL STACKING TRAY GASKET AND SPACER

-To hold the gaskets in place, apply a small amount of medium modulus silicone sealant to the stacking tray gasket reglet and the stacking tray spacer reglet.

See **Details 39 & 40**.



**Detail 39**

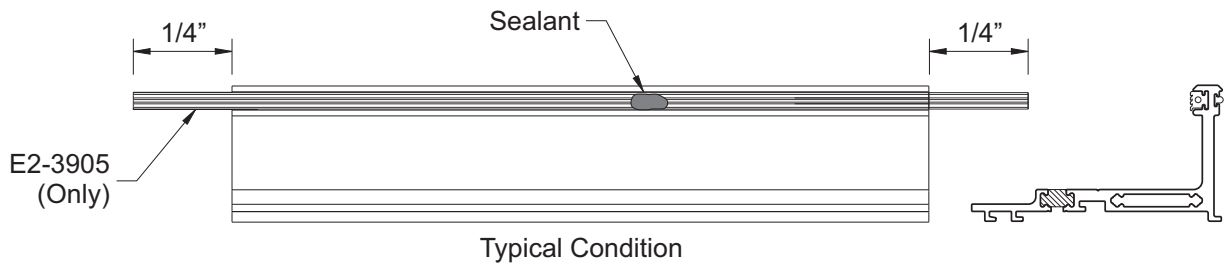
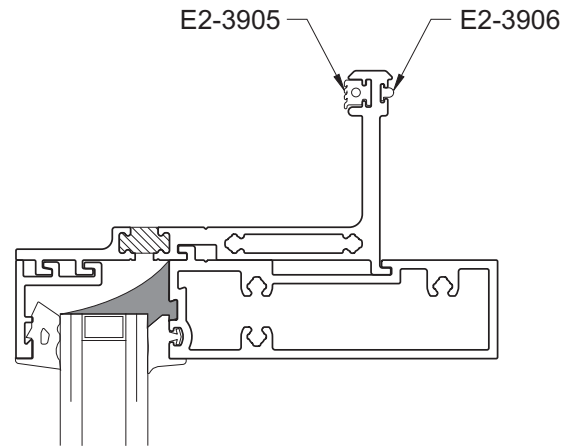


**Detail 40**

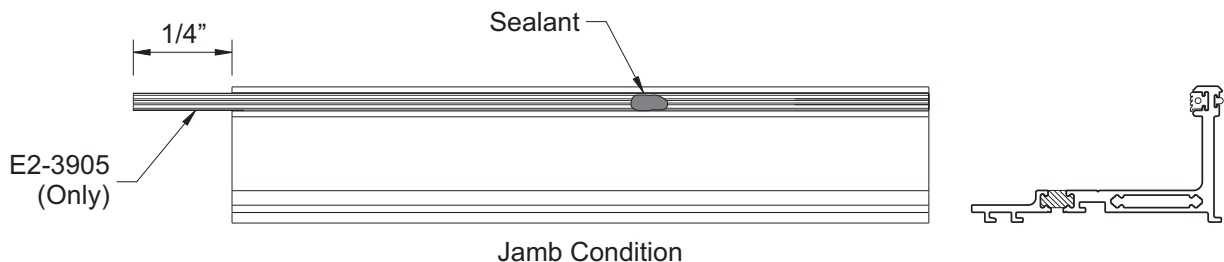
## FRAME ASSEMBLY

### STEP 21 Continued INSTALL STACKING TRAY GASKET AND SPACER

- For typical conditions, cut the stacking tray gasket E2-3905 to the stacking tray length plus 1/2".
- For jamb conditions, cut the stacking tray gasket E2-3905 to the stacking tray length plus 1/4".
- Cut stacking tray spacer E2-3906 to the stacking tray length.
- For typical conditions, install stacking tray gasket E2-3905 to the stacking tray leaving 1/4" protruding off each end of the stacking tray as shown in **Detail 41**.
- For jamb conditions, install stacking tray gasket E2-3905 to the stacking tray leaving 1/4" protruding off the non-jamb end of the stacking tray as shown in **Detail 42**.
- Install stacking tray spacer E2-3906 flush with the ends of the stacking tray.



**Detail 41**



**Detail 42**



## FRAME ASSEMBLY

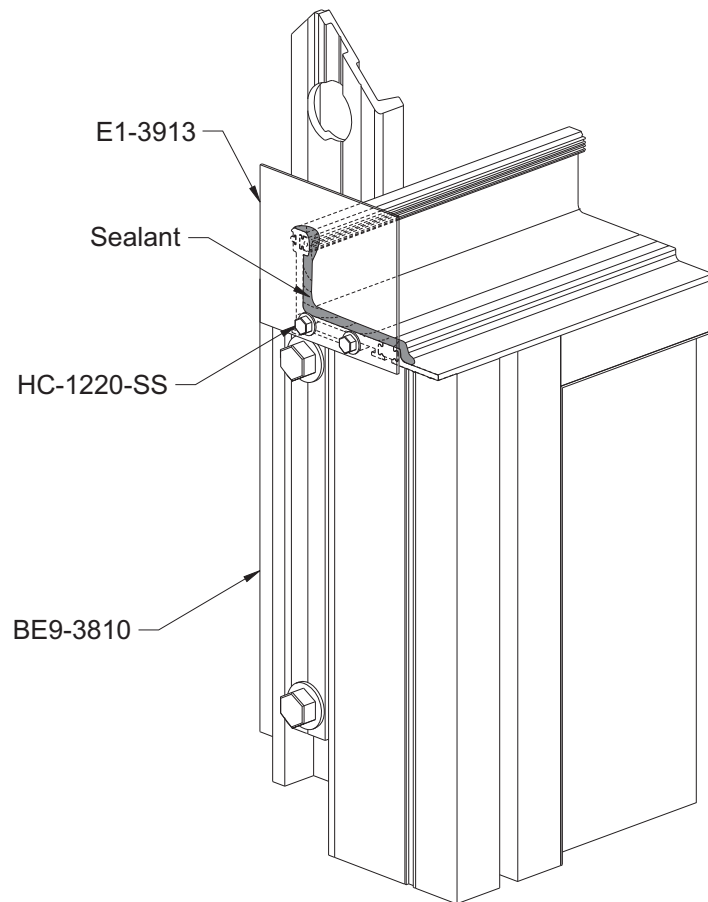
### STEP 22

### SEAL AND ATTACH END DAM TO THE STACKING TRAY AT PERIMETER END JAM

**Note:** Apply medium modulus silicone sealant to the profile of the stacking tray. Attach the end dam to the stacking tray, and tool sealant.

-Use two (2) HC-1220-SS screws to fasten E1-3913 end dam to BE9-3804 stacking tray.

See **Detail 43**.



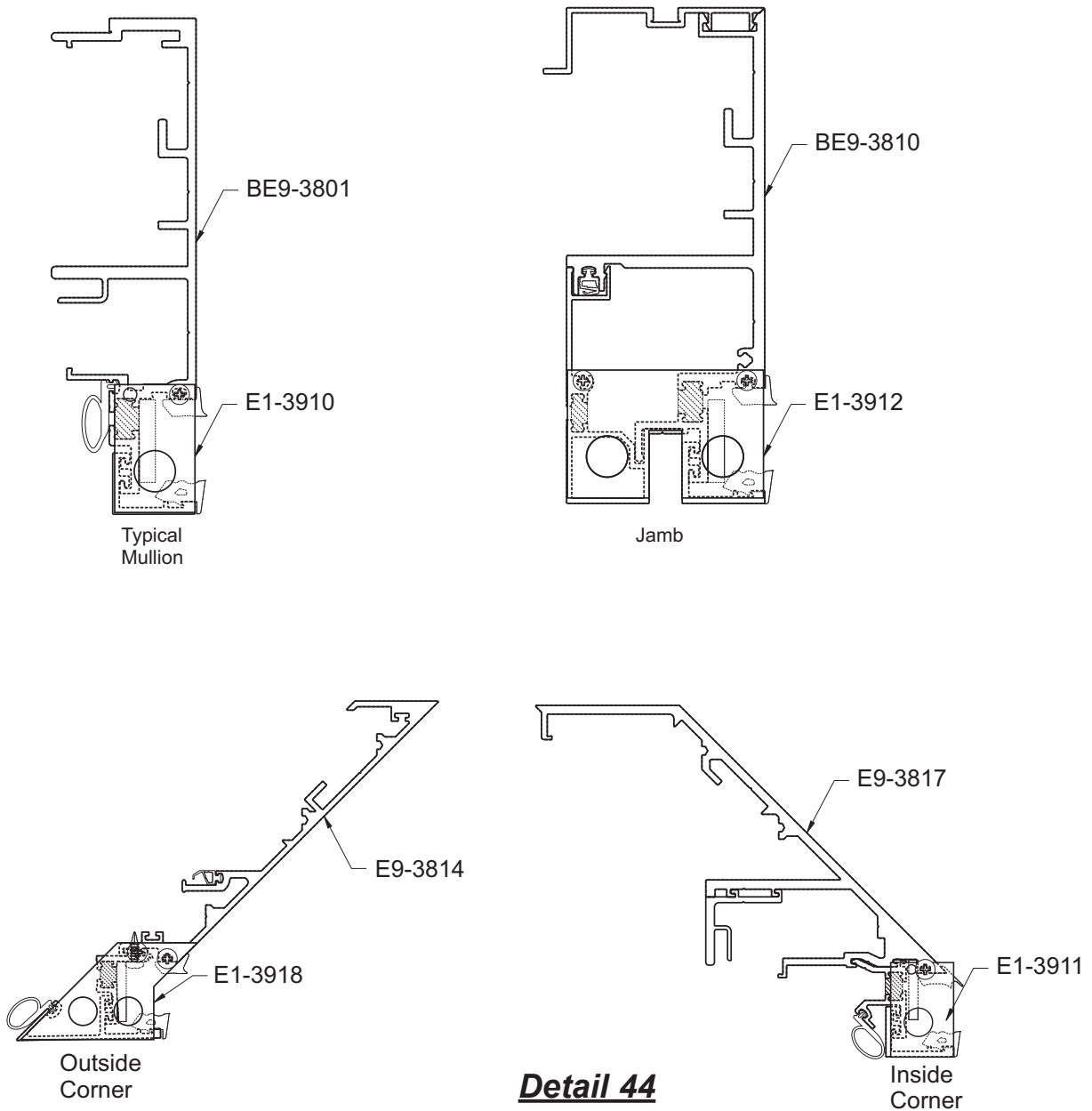
**Detail 43**

**FRAME ASSEMBLY**

**STEP 23  
ATTACH MULLION END CAPS**

-Attach mullion end caps using PC-1010-SS screws.

See **Detail 44**.

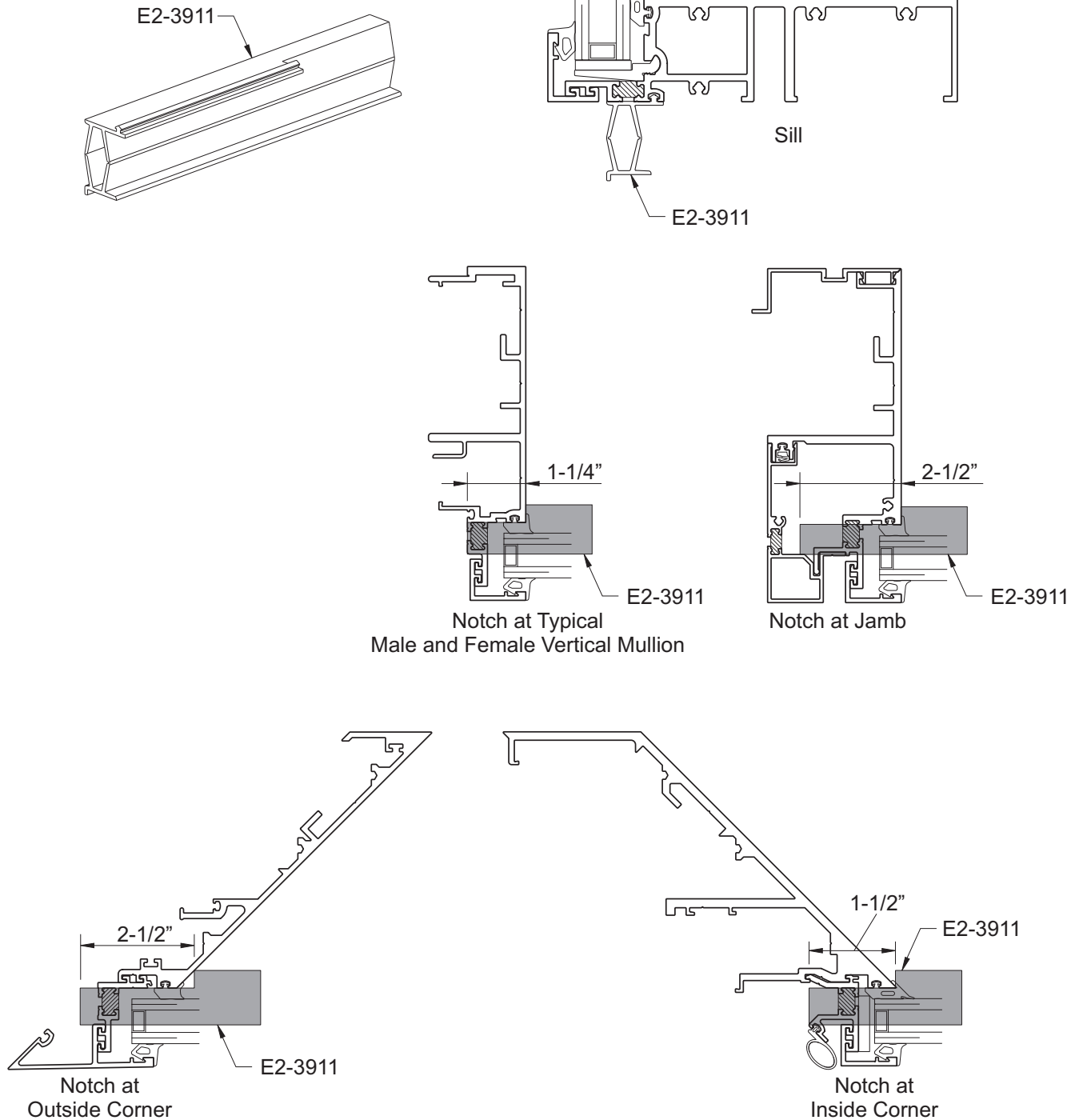


## FRAME ASSEMBLY

### STEP 24 INSTALL HORIZONTAL THERMAL GASKET

-Cut and Notch horizontal thermal gasket E2-3911, per condition, as shown in **Detail 45**.

#### Detail 45



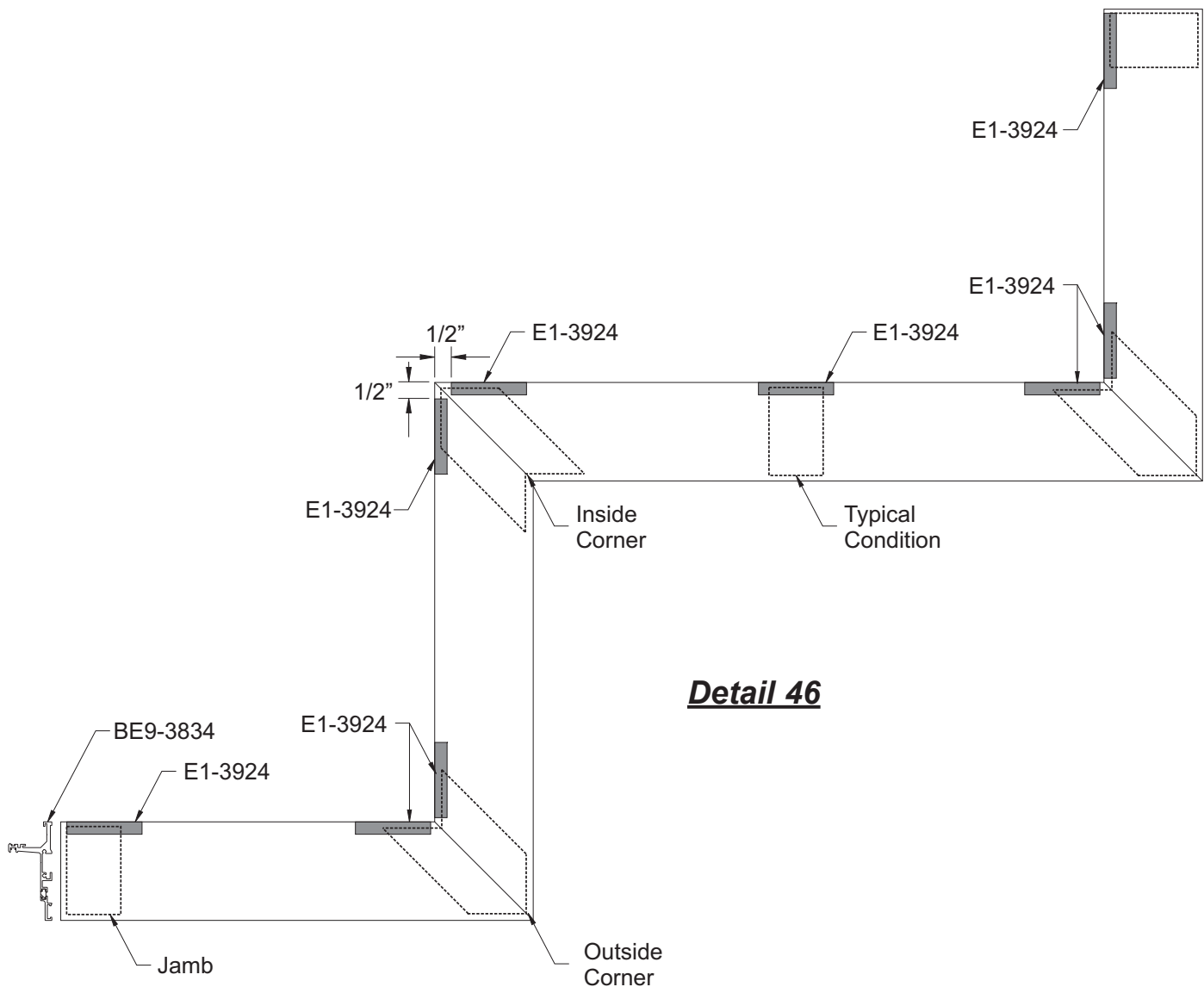
## FRAME ASSEMBLY

### STEP 25 ASSEMBLE SILL STARTER

-Sill starter reinforcement clip E1-3924 must be placed at all vertical mullion locations.

See **Detail 46**.

**Note:** If the vertical mullion is located directly on top of the sill starter splice, then two reinforcement clips must be used located 1/2" of each side of splice joint.



## FRAME ASSEMBLY

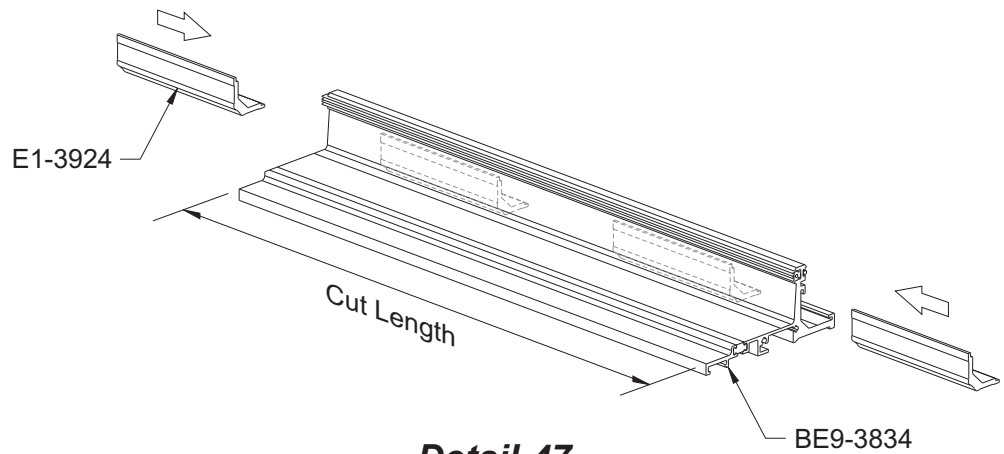
### STEP 25 Continued ASSEMBLE SILL STARTER

-Slide in sill starter reinforcement clip E1-3924 from the end of sill starter BE9-3834.

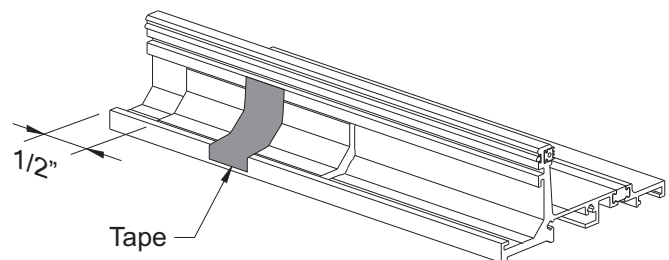
See **Detail 47**.

-Tape the reinforcement clip to the sill starter to hold in place.

See **Detail 48**.



**Detail 47**



**Detail 48**



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