

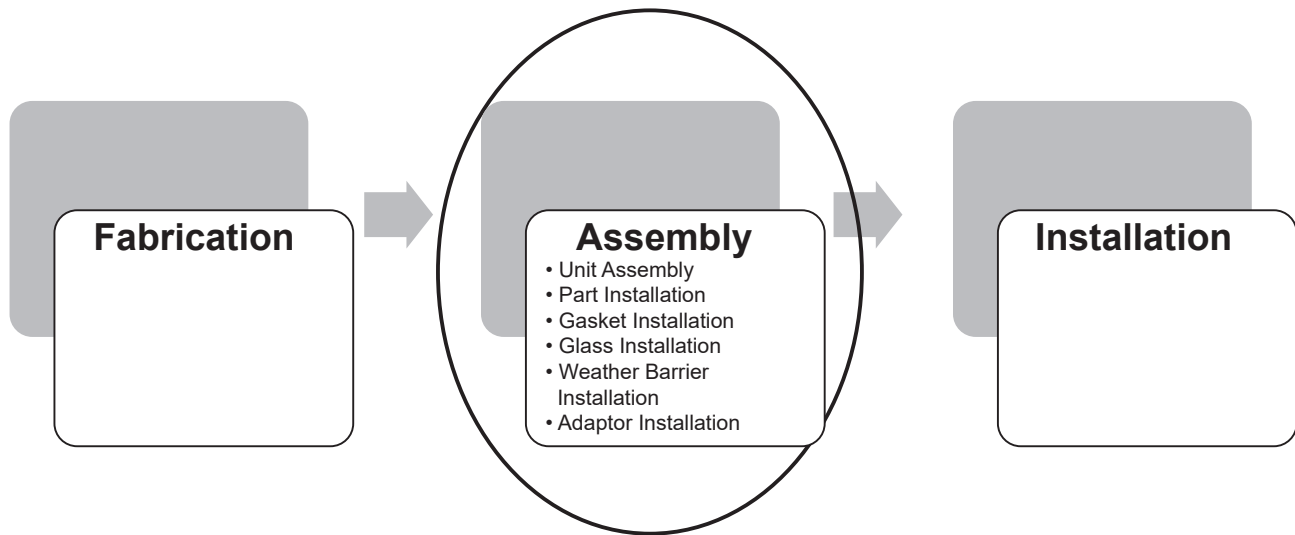
Assembly Manual

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INTRODUCTION

YKK AP Fabrication, Assembly, and Installation instructions for YUW 750 TU are separated into three specific documents. The focus of this manual is the assembly and glazing of the fabricated parts.



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 products are 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, for the latest installation manual update prior to commencing work.

Important Notice for SSG Curtain Wall Systems:

In order to properly perform and to maintain structural integrity, in addition to all other installation requirements, structurally glazed curtain wall systems rely specifically upon effective and appropriate structural sealant selection and installation.

It is the responsibility of the glazing contractor to take all steps to ensure the installed structural sealant is capable of meeting all applicable project requirements in accordance with industry standards. Such steps on each project may include, but are not limited to, design reviews, formal adhesion testing, project specification compliance, validating applications, field testing, auditing, sealant design strength analysis, and the quality control review of the installation and surrounding conditions.

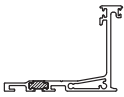

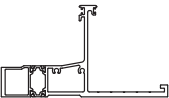

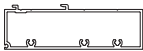

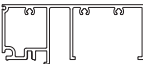



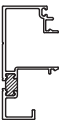


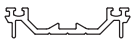
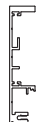
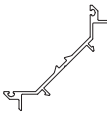
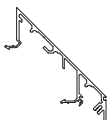

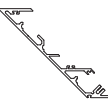
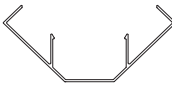

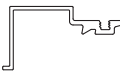

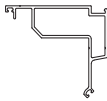
Subject to project specific design pressures, requirements, and/or specifications, the structural sealant that is used between the glass and framing system must be capable of withstanding tensile and shear stresses imposed by the curtain wall without failing adhesively or cohesively.

The structural sealant's capability to withstand these stresses are dependent on several factors including, but not limited to, type of structural sealant, method of application (i.e. cleaning, primer), construction of glazing material (i.e. insulating glass unit (IGU), other infill, and finish of framing (i.e. anodizing, paint)).

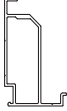
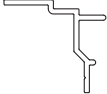
- Adhesive failure occurs when sealant pulls away from substrate cleanly, leaving no sealant material behind.
- Cohesive failure occurs when sealant breaks or tears within itself but does not separate from each substrate because sealant-to-substrate bond strength exceeds sealant's internal strength.

The IGU and/or other infill must be constructed for installation into structurally sealant glazed curtain walls. This YUW 750 TU is categorized in "4-sided SSG" application, even with captured option. Notify the manufacturer or fabricator of the IGU and/or infill and advise of the product's application into 4-sided structurally sealant glazed curtain walls along with the project's design requirements so that appropriate fabrication steps are taken.

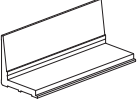

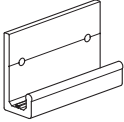

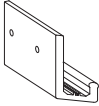




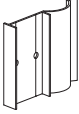

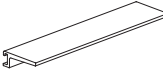



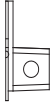

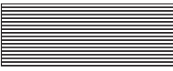

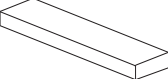
FRAMING MEMBERS

	Stacking Tray	BE9-3844		Polyamide SSG Mullion Adaptor (Not certified for FPA)	AS-7028
	Sill Starter	BE9-3864		90° SSG Corner Adaptor	BE9-3872
	5-1/4" Head	E9-3843		Captured Sill Adaptor	BE9-3849
	5-1/4" Sill	E9-3845		SSG Sill Adaptor	BE9-3852
	5-1/4" Horizontal	E9-3846		Captured Horizontal Adaptor	BE9-3850
	Jamb Adaptor	BE9-3860		Polyamide Face Cover Base	AS-7027
	5-1/4" Male Mullion	E9-3841		Optional Aluminum Face Cover Base	E9-3847
	5-1/4" Female Mullion	E9-3842		90° Corner Face Cover Base	E9-3868
	5-1/4" Male Corner Mullion	E9-3866		2-1/2" x 3/4" Face Cover	E9-1206
	5-1/4" Female Corner Mullion	E9-3867		90° Corner Face Cover	E9-3869
	Captured Mullion Adaptor	BE9-3848		Jamb Interior Cover	E9-3861
	SSG Mullion Adaptor	E9-3851		Inside Corner Adaptor (Male)	E9-3875

FRAMING MEMBERS (Continued)

	Inside Corner Adaptor (Female)	E9-3876		Inside Corner Cover Base	E9-3877
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ACCESSORIES

	Sill Starter Reinforcement	E1-3954		Mullion Splice Sleeve (Right)	E1-3941
	J-Anchor	E1-3949		Corner Mullion Splice Sleeve (Left)	E1-3947
	Corner J-Anchor (Left)	E1-3950		Corner Mullion Splice Sleeve (Right)	E1-3948
	Corner J-Anchor (Right)	E9-3951		Mullion Clip	E1-3942
	Bracket Stopper	E1-3955		Inside Corner Clip	E1-3956
	Leveling Bracket	E1-3944		Setting Block Chair For SSG Horizontal	E1-3943
	Corner Leveling Bracket	E1-3952		End Dam	E1-3953
	Bracket Sleeve (Left)	E1-3945		End Cap For 2-1/2" x 3/4" Face Cover	E3-7024
	Bracket Sleeve (Right)	E1-3946		Silicone Splice Sheet	E2-0070
	Mullion Splice Sleeve (Left)	E1-3940		Setting Block (Silicone) 6" Long	E2-9611S

ACCESSORIES

	Horizontal Wiper Gasket	E2-3842		Joint Plug	E2-3844
	3/4" Spacer Sponge	E2-0725		Wiper Gasket	E2-3841
	Vertical Airtight Gasket	E2-3901		SSG Spacer For 1/4" F.C.	E2-3843
	Stacking Tray Gasket	E2-7004		SSG Corner Spacer	E2-7014
	Stacking Tray Spacer	E2-3906		SSG Wiper Gasket	E2-7009

FASTENERS

	#12 x 1" FHTS (Tek) Stainless Steel, For Attachment of Stacking Tray to Head	FS-1216-SS		#8-32 x 1/2" FHUCMS Stainless Steel, Safety Screw for Vertical Face Cover	UF-0808-SS
	#12 x 1-1/4" HWHS Stainless Steel, For Screw Spline Attachment	HC-1220-SS		3/8"-16 x 1" HHMS Zinc Plated Steel, For Leveling Bracket	HM-3816
	#12 x 1-3/4" HWHSMS Stainless Steel, For Screw Spline Attachment at Corner	HC-1228-SS		3/8"-16 Nut HHMS Zinc Plated Steel, For Leveling Bracket	HM-3800
	1/4"-20 x 1-1/4" HWHS Type CA, Zinc Plated Steel For Splice Sleeve	HD-2520-W3		3/8" Lock Washer Zinc Plated Steel, For Leveling Bracket	WS-3800
	#12 x 2" PHSMS Type AB Zinc Plated Steel For Jamb Adaptor Attachment	PC-1232		1/2"-13 x 1/2" Set Screw Zinc Plated Steel For Leveling Bracket	YM-5008
	#10-24 x 3/8" PHMS Stainless Steel, For Attachment of Adaptors	PM-1006-SS			

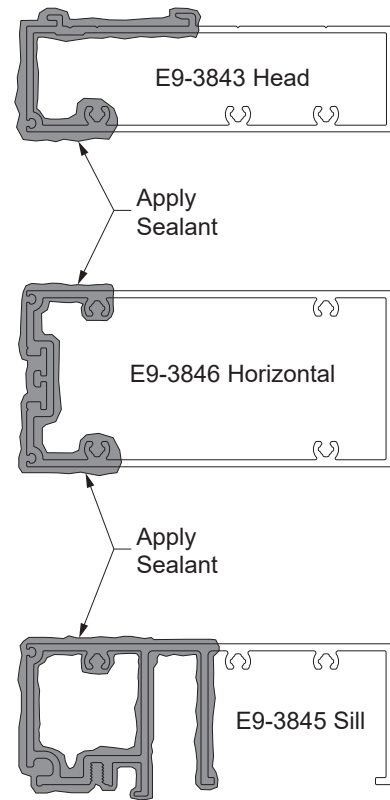
UNIT ASSEMBLY

STEP 1

APPLY SEALANT TO FRAMING MEMBERS

-Clean, prime, and apply sealant to both ends of horizontals per typical unit detail and approved shop drawings.

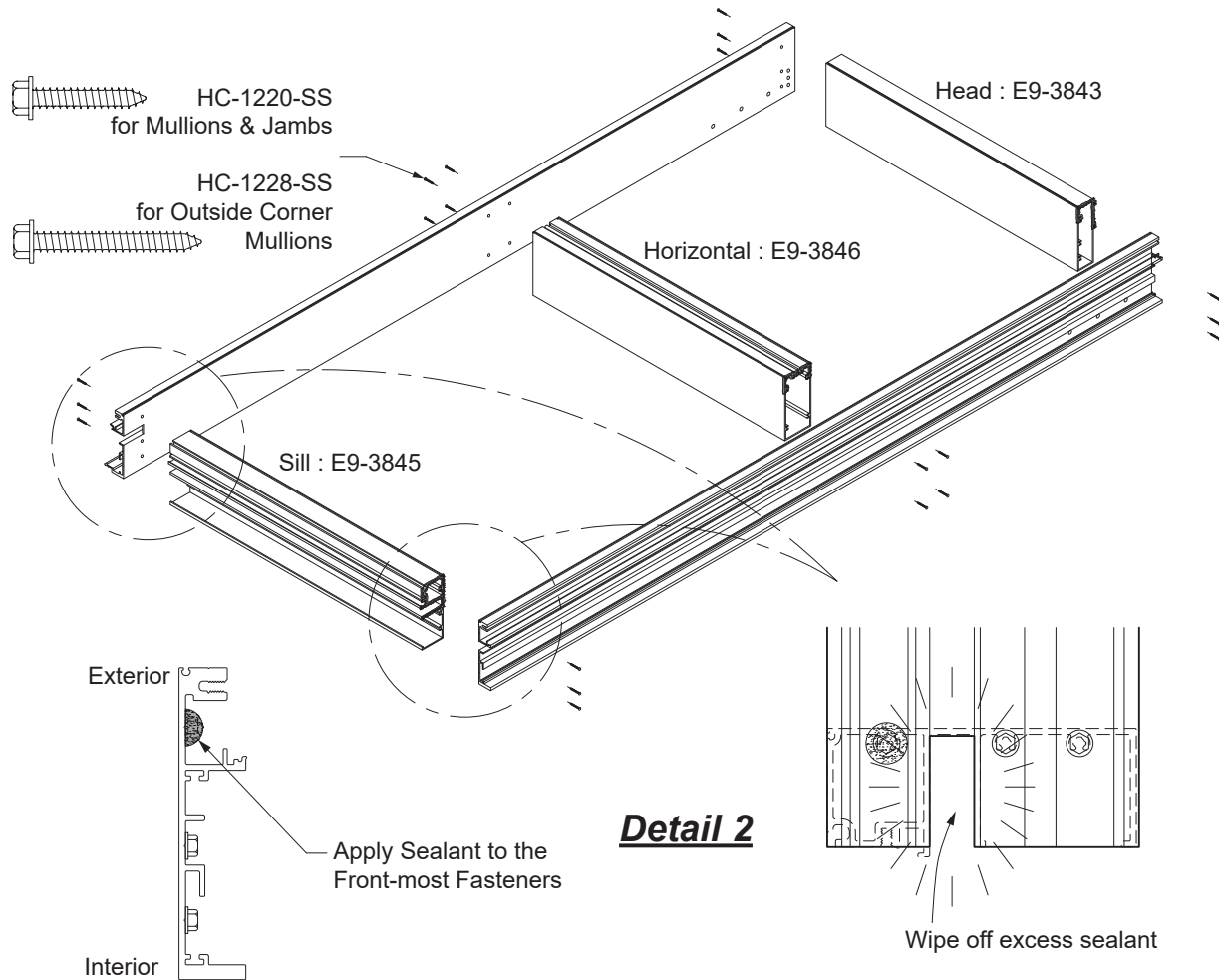
See **Detail 1**.



Detail 1

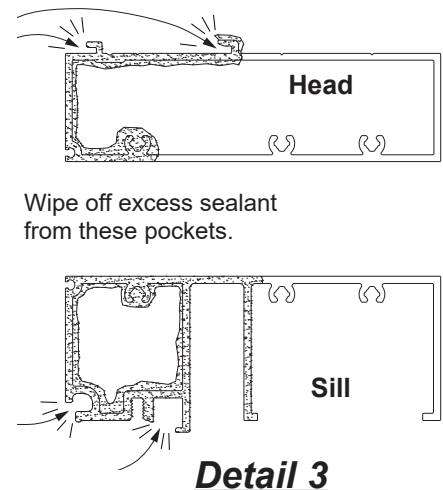
UNIT ASSEMBLY

**STEP 2
ATTACH HORIZONTALS TO VERTICAL MULLIONS**



-Position horizontal members aligning splines with screw holes in the verticals and assemble with HC-1220-SS fasteners as shown in **Detail 2**. For outside corner mullions, use HC-1228-SS fasteners. Tighten fasteners to 50 inch-pounds. Tool sealant flush.

-Apply sealant to the heads of the front-most fasteners.
-Wipe off excess sealant to the horizontals, the inside of the notch at the bottom of the mullion, and in the pockets at the head and sill as shown in **Detail 3**.

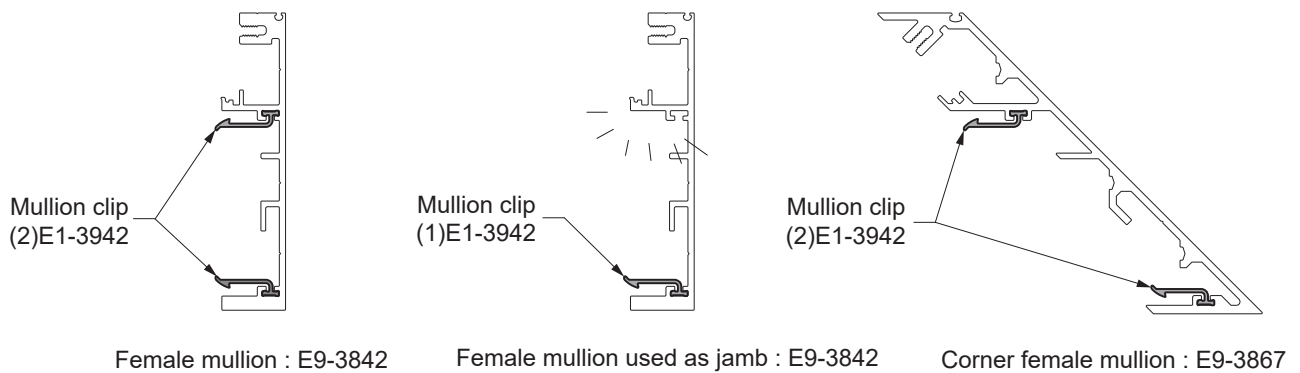


PARTS INSTALLATION

STEP 3
INSTALL MULLION CLIPS

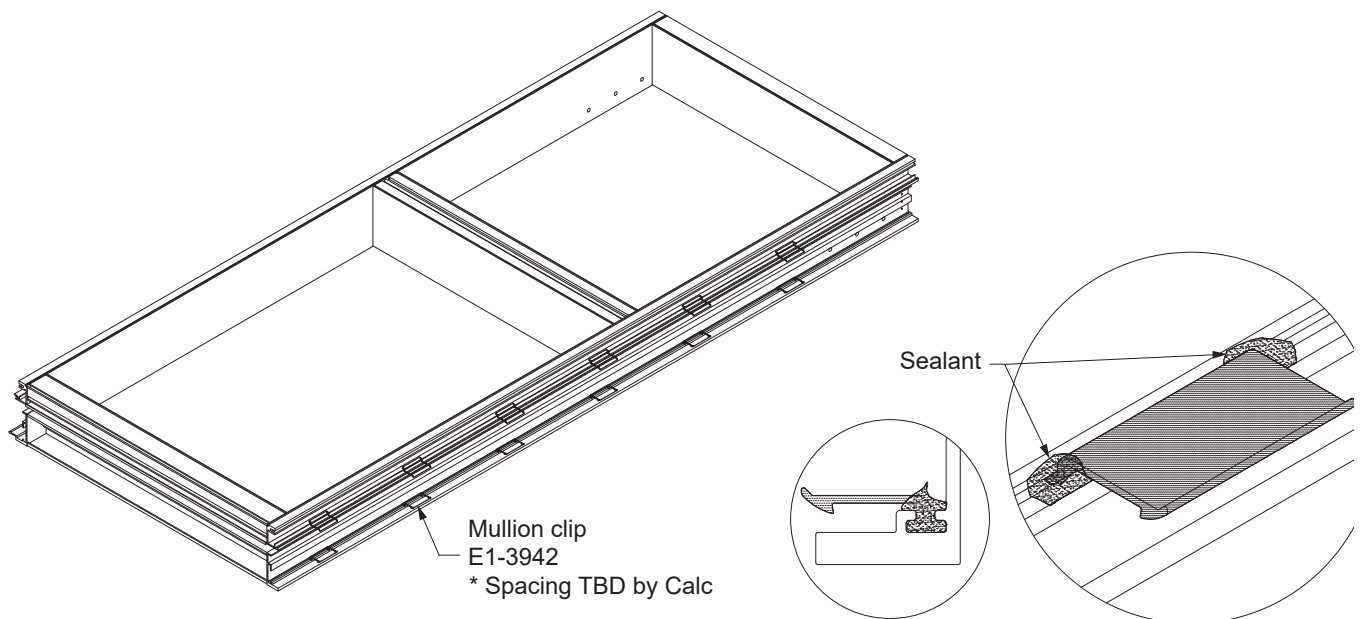
-Install E1-3942 mullion clips to the female mullion as shown in **Detail 4**. The number and spacing of the mullion clips is to be determined by P.E. calculations.

Note: When the female mullion is used at the jamb, the mullion clips are installed only at the interior reglet.



Detail 4

-To hold the mullion clips in place, apply sealant to both ends of every mullion clip. See **Detail 5**.

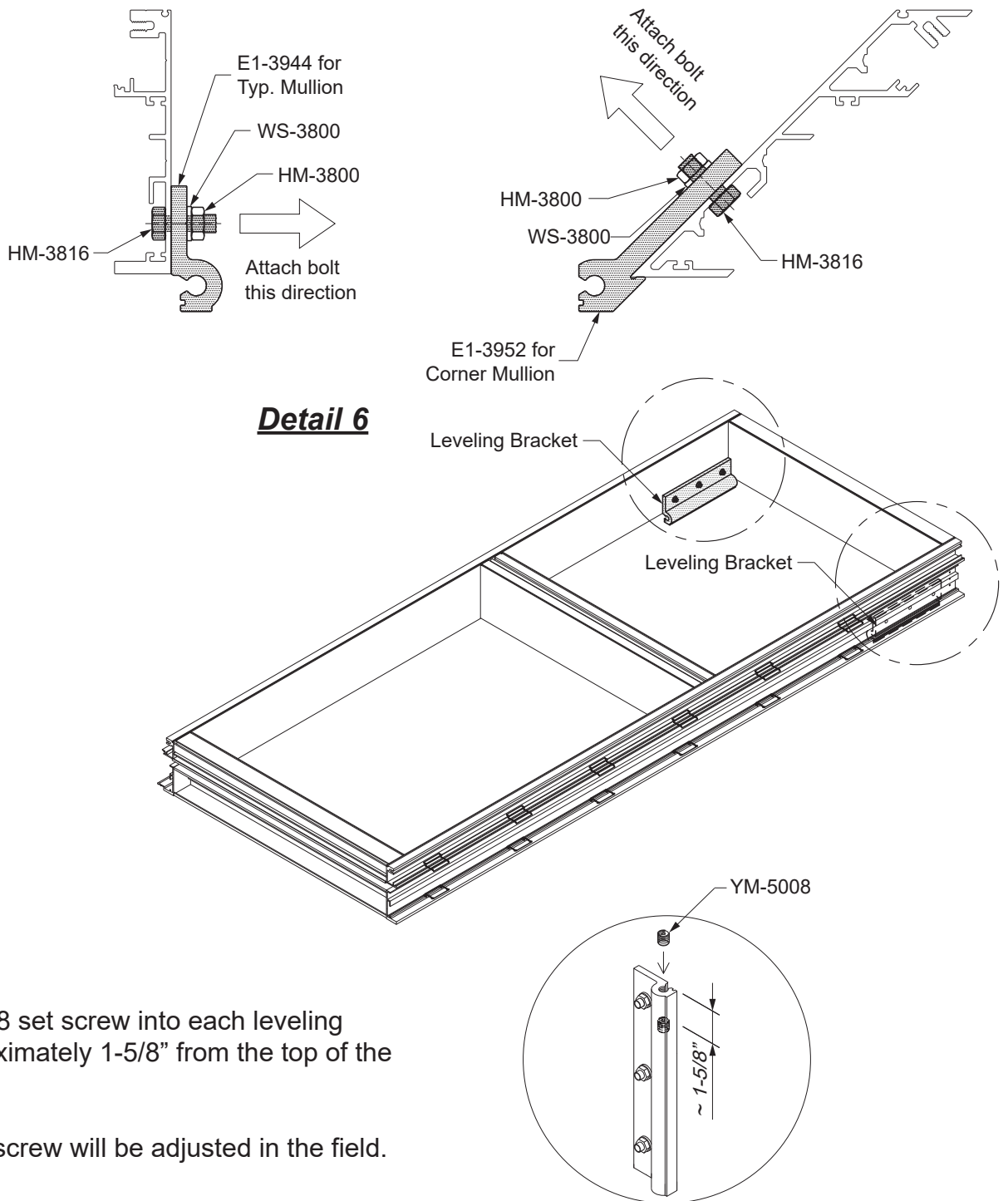


Detail 5

PARTS INSTALLATION

**STEP 4
INSTALL LEVELING ANCHORS**

-Install leveling anchors using fasteners as shown in **Detail 6**. Refer to shop drawings for leveling bracket locations.



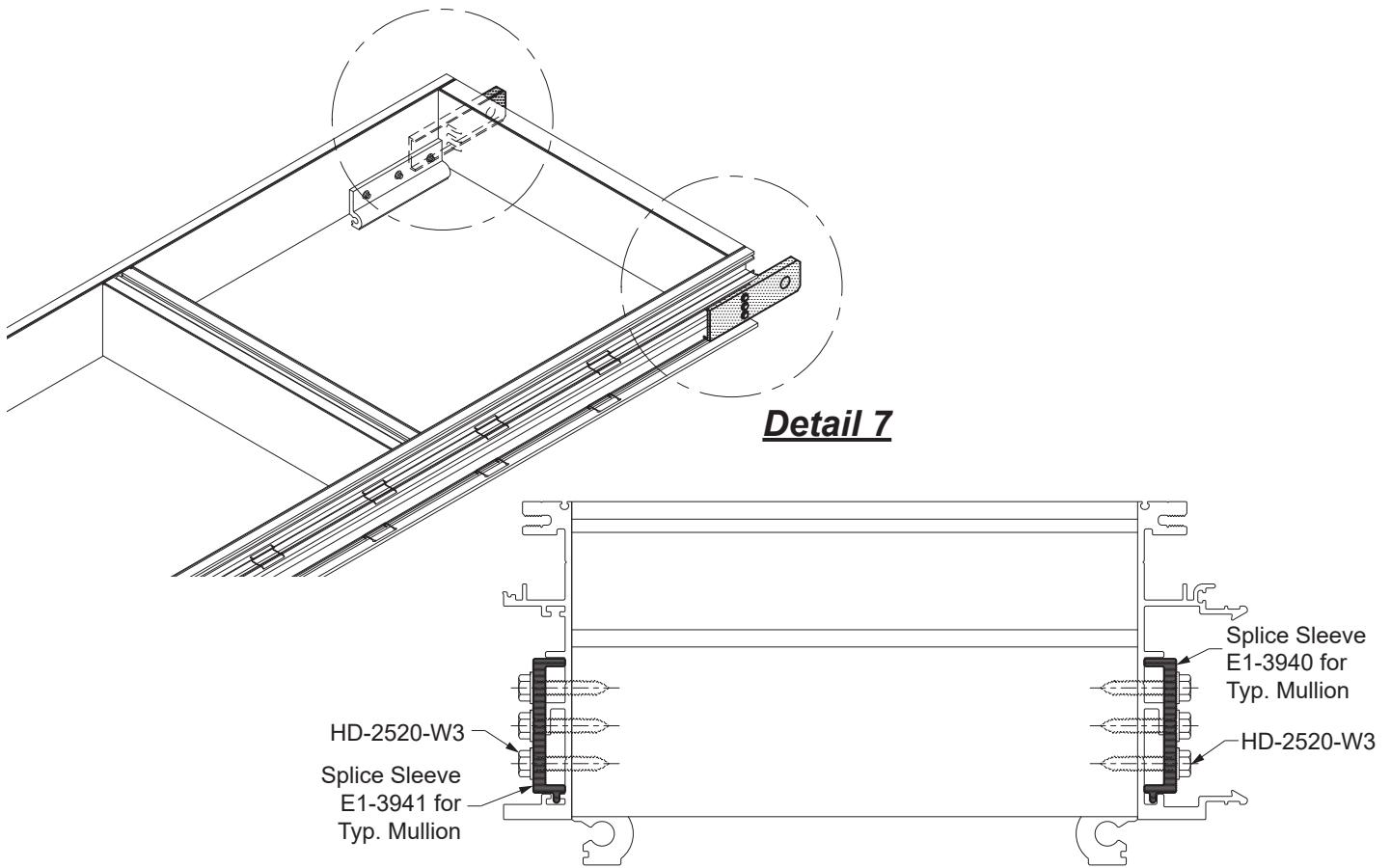
-Install YM-5008 set screw into each leveling bracket, approximately 1-5/8" from the top of the bracket.

Note: This set screw will be adjusted in the field.

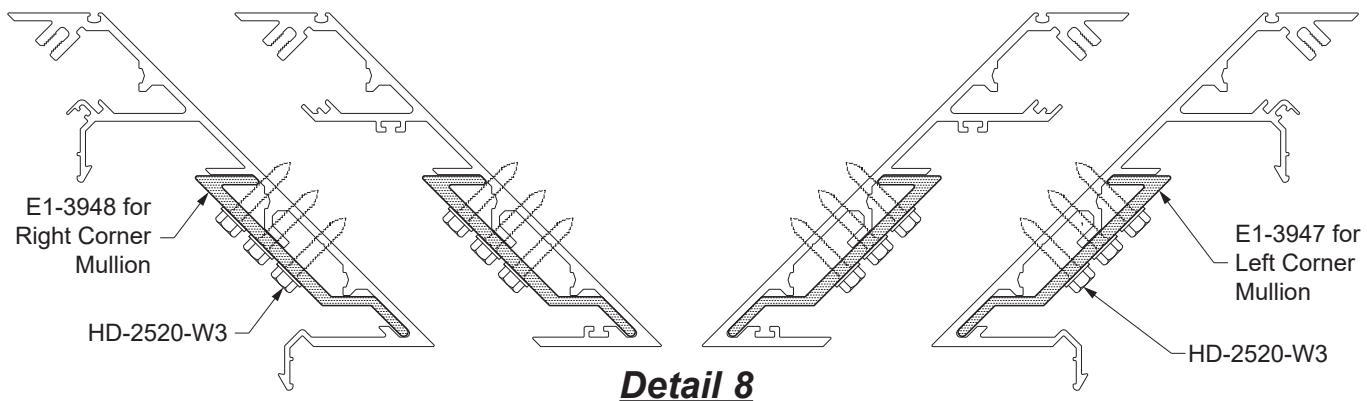
PARTS INSTALLATION

STEP 5 INSTALL SPLICE SLEEVES

-Install the mullion sleeves as shown in **Detail 7**, using HD-2520-W3 fasteners, unless otherwise specified on the approved shop drawings.



-Installation of corner mullion splice sleeves is similar. See **Detail 8**.

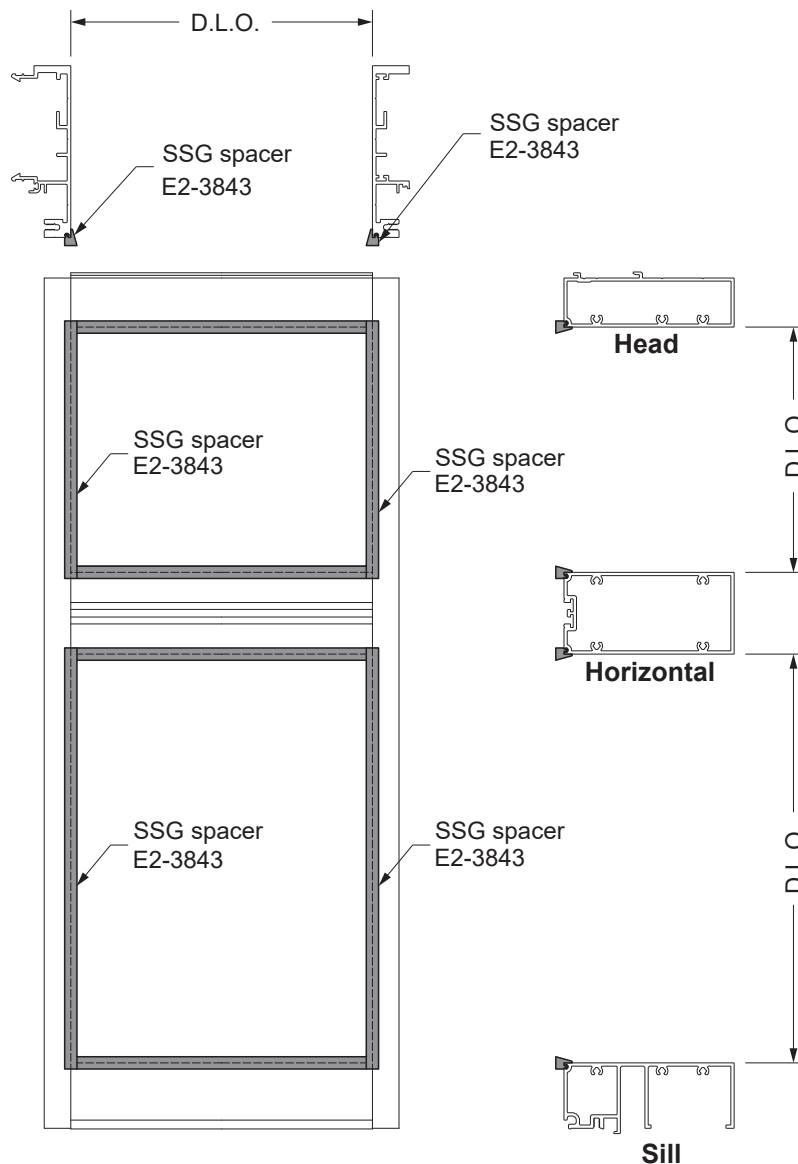


GASKET INSTALLATION

**STEP 6
INSTALL SSG SPACER GASKET**

- Cut SSG spacer gasket E2-3843 to Daylight Opening plus (+) 1/4" for every foot of length.
- Vertical gaskets are to run through.

See **Detail 9**.



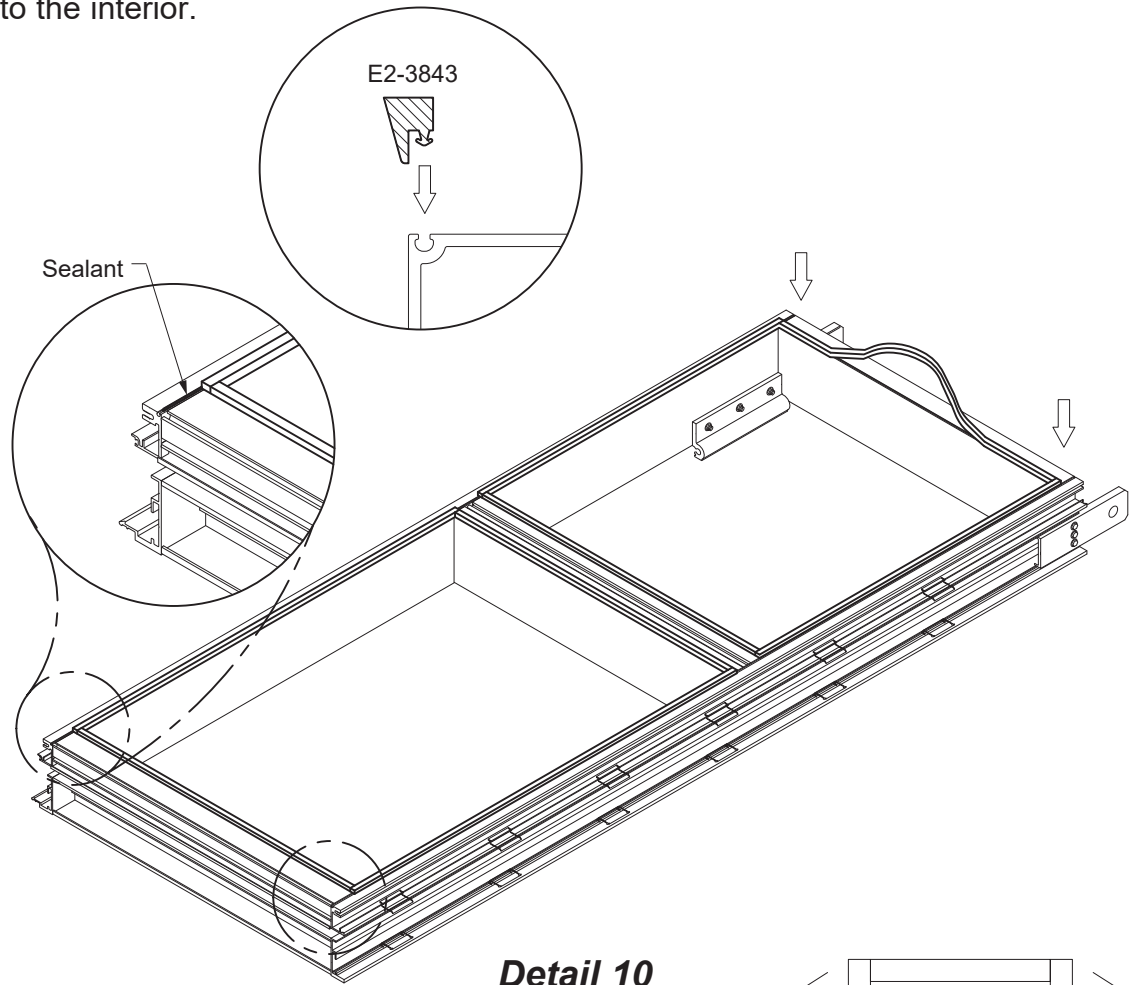
Detail 9

GASKET INSTALLATION

**STEP 6 (Continued)
INSTALL SSG SPACER GASKET**

-Install the spacer gasket into the reglet. Push the gasket in starting at the ends first, then work towards the middle of the Daylight Opening.
See **Detail 10**.

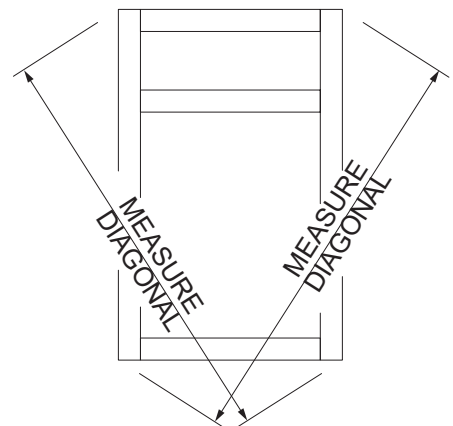
Note: Be sure to fill the gasket reglet at the bottom of each mullion with sealant to prevent water from leaking into the interior.



Detail 10

Note:

Before installing the glass, double-check squareness of frame by measuring diagonals. The maximum difference between diagonals is 1/16". Sight down mullions to make sure unit is not bowed. A unit glazed in an "out of square" or "bowed" position will cause installation problems.



GASKET INSTALLATION

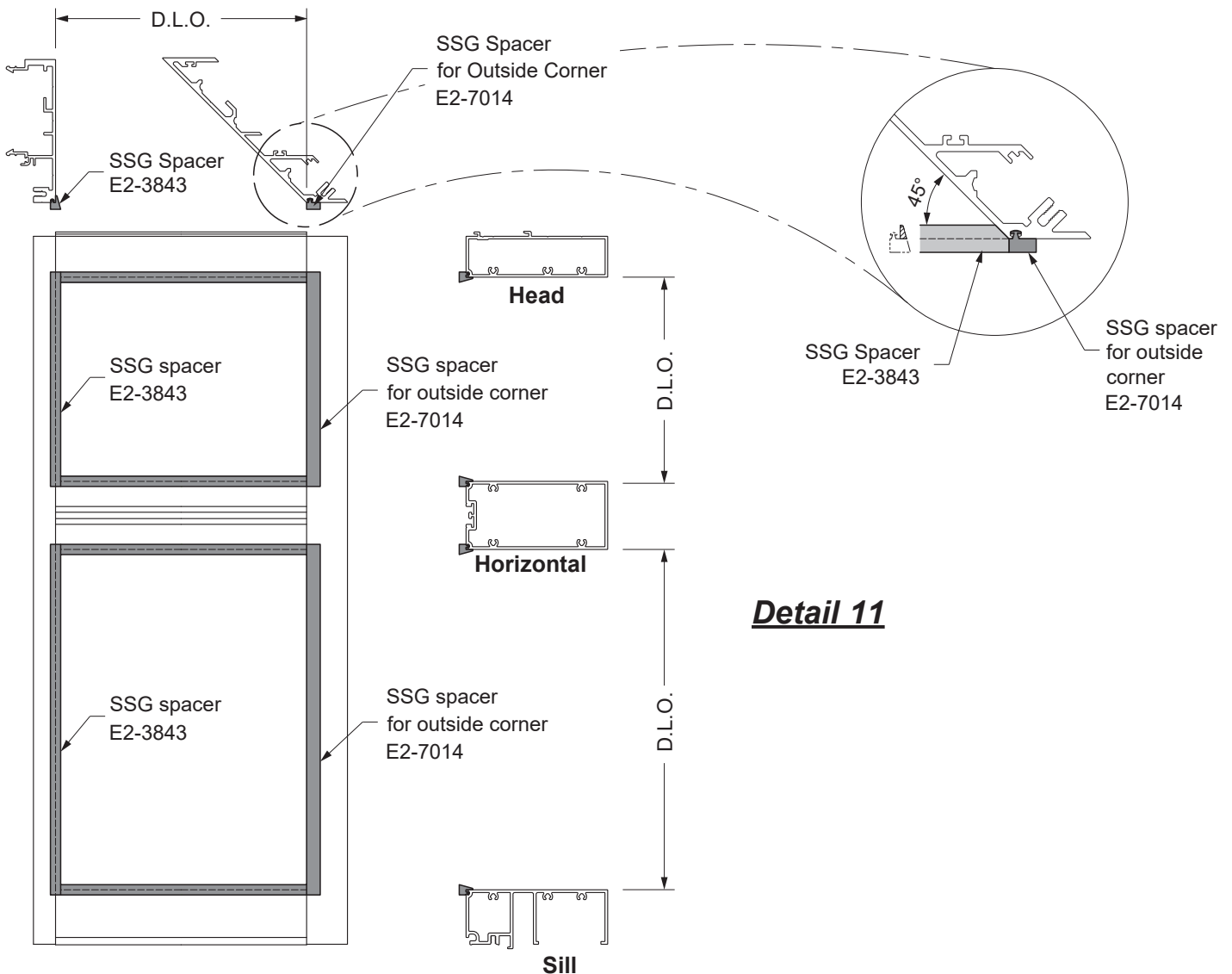
STEP 6 (Continued)

INSTALL SSG SPACER GASKET FOR OUTSIDE CORNER UNIT

-Installation of the SSG spacer gasket at an outside corner unit is similar except:

1. E2-7014 is used at the corner mullion.
2. Horizontal gaskets E2-3843 are miter cut only at the rear to fit with the corner mullion.

See **Detail 11**.

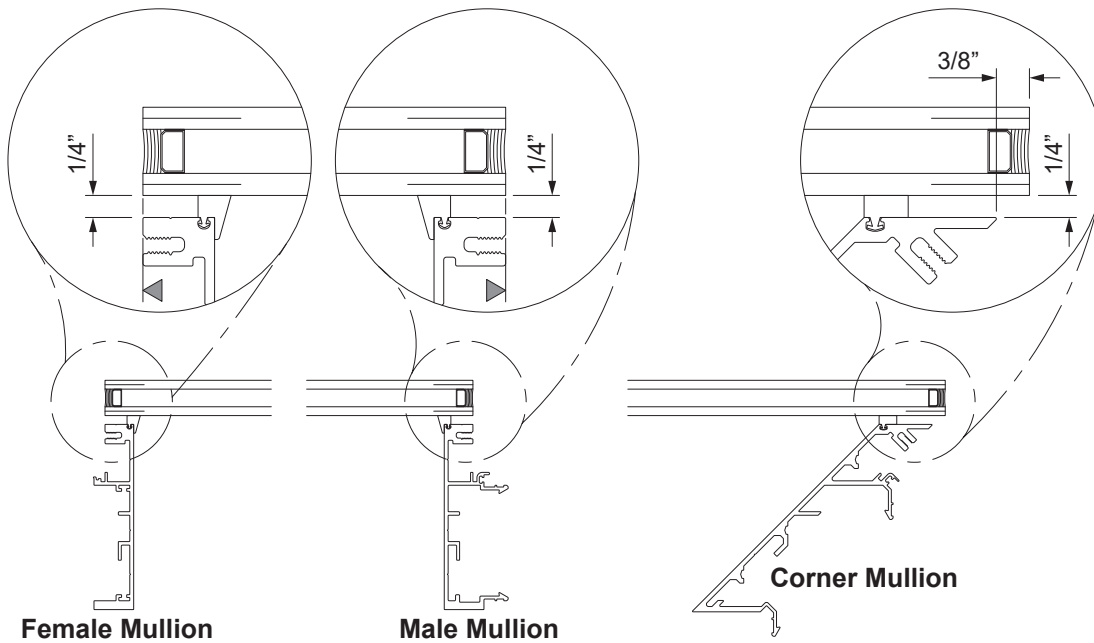


GLAZING

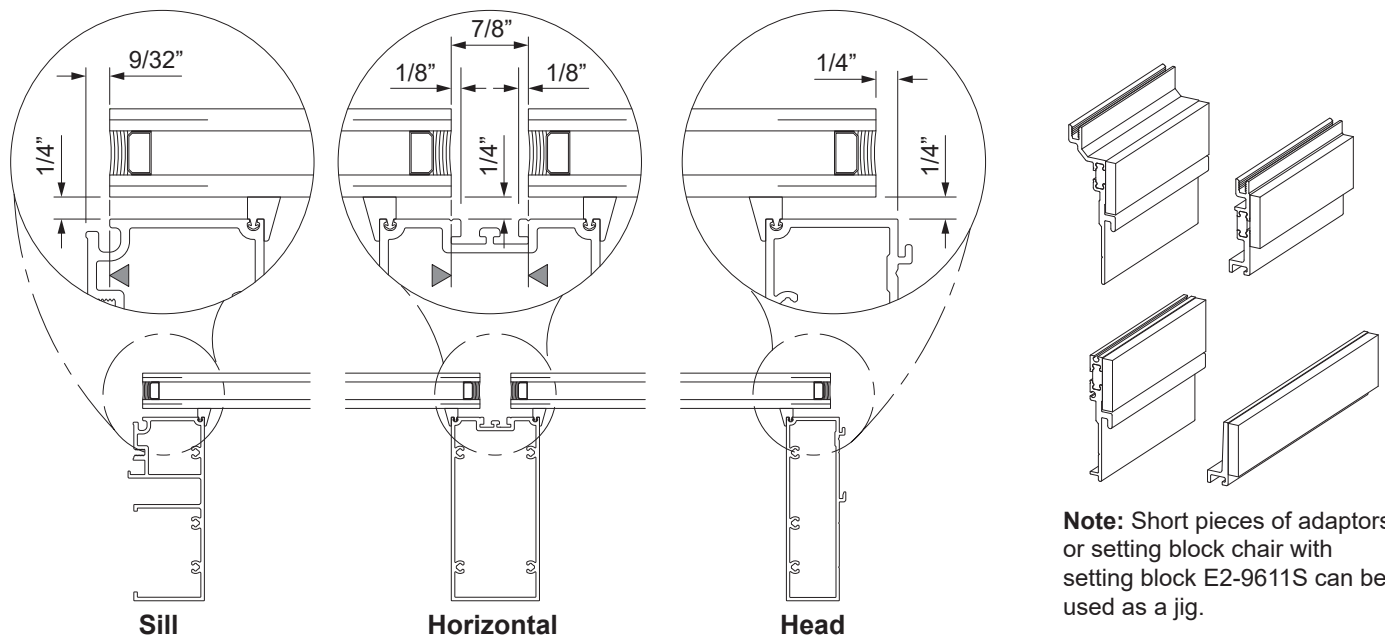
STEP 7
INSTALL GLASS

-Set the glass onto the framing unit, according to the dimensions shown below in **Detail 12**.

Note: Symbol ► indicates location of glass edge. If glass is over or undersized, center glass equally across both ends.



Detail 12

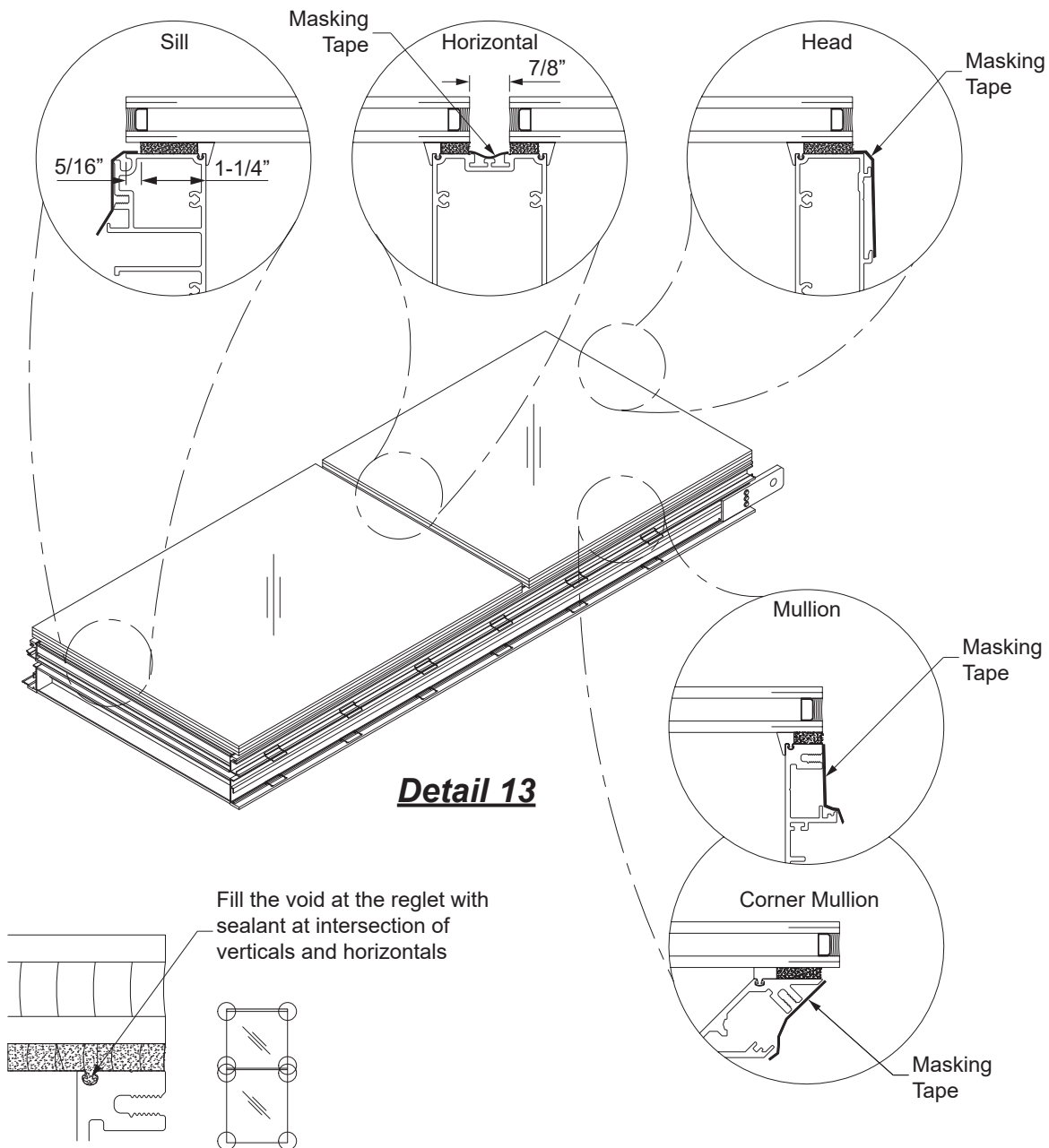


Note: Short pieces of adaptors or setting block chair with setting block E2-9611S can be used as a jig.

GLAZING

**STEP 7 (Continued)
INSTALL GLASS**

- Apply masking tape to the areas shown in **Detail 13**. Ensure the glass and metal surfaces are clean and prepared per sealant manufacturer's specifications and recommendations.
- Apply and tool sealant into the gap between the framing and the glass as shown.
- Immediately remove the masking tape after it has been tooled. Inspect to make certain there are no voids or gaps in the sealant. Do not move the framing until the sealant has cured.



Captured Adaptors Assembly

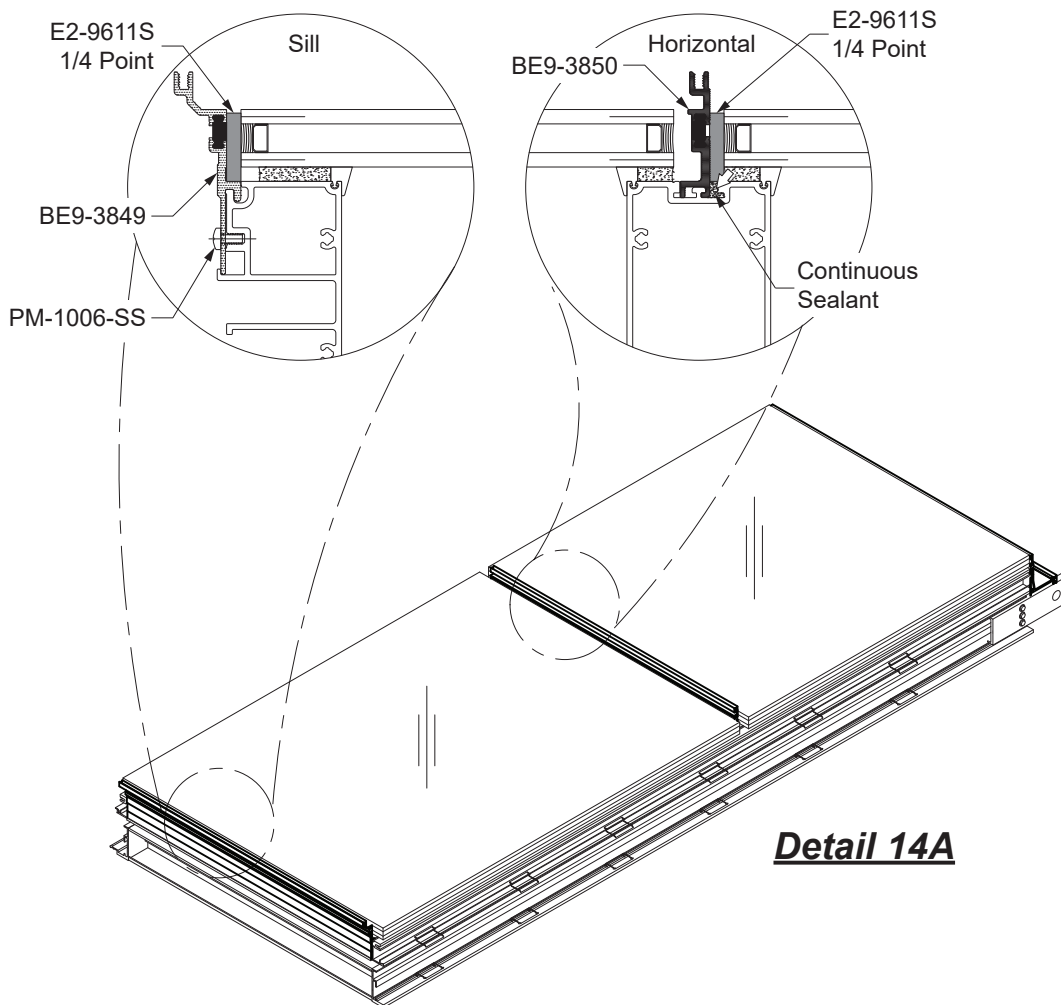
**See Page 24 for SSG Adaptor
Installations**

CAPTURED ADAPTORS ASSEMBLY**STEP 8A****ATTACH HORIZONTAL ADAPTORS, SETTING BLOCKS, & STACKING TRAY**

-Attach the horizontal adaptors into the horizontals. Secure the sill adaptor onto the sill with PM-1006-SS fasteners.

-Insert setting blocks between the horizontal/sill adaptors and the glass, two per Daylight Opening at 1/4 points unless otherwise specified in the approved shop drawings.

See **Detail 14A**.



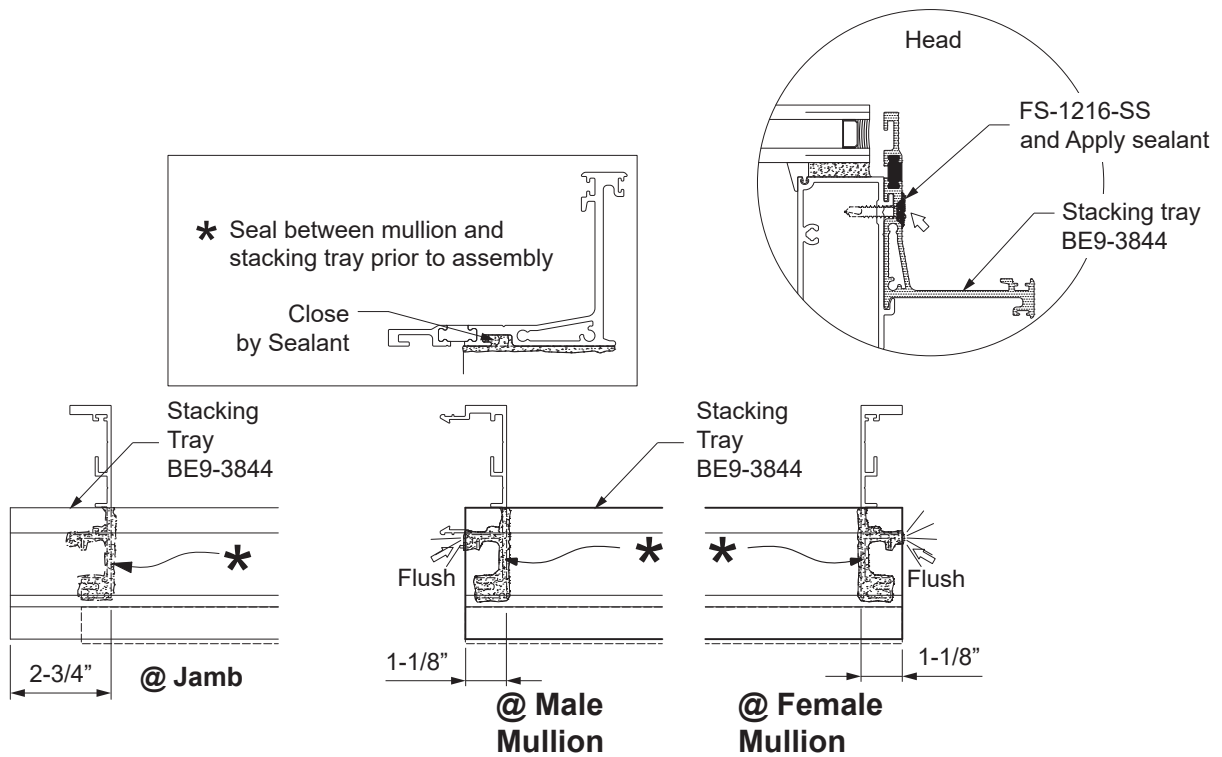
CAPTURED ADAPTORS ASSEMBLY

STEP 8A (Continued)

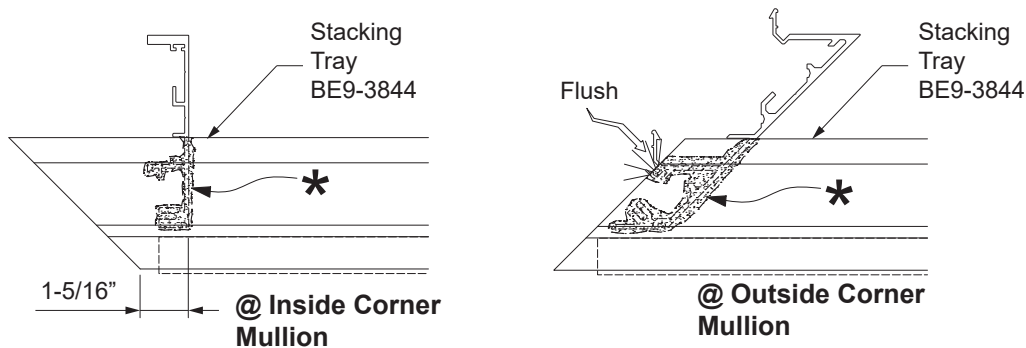
ATTACH HORIZONTAL ADAPTORS, SETTING BLOCKS, & STACKING TRAY

- Before installing the stacking tray, apply sealant to the top end of the mullions as shown in **Detail 15A** (indicated by *.)
- Install the BE9-3844 stacking tray onto the top of the framing unit, locating it according to the dimensions shown. Secure it to the framing unit using FS-1216-SS fasteners (minimum 3 fasteners required). Seal the fastener heads.
- Apply and tool sealant between the top of the mullion and the stacking tray, filling any voids.

See **Detail 15A**.



Detail 15A



CAPTURED ADAPTORS ASSEMBLY

STEP 9A

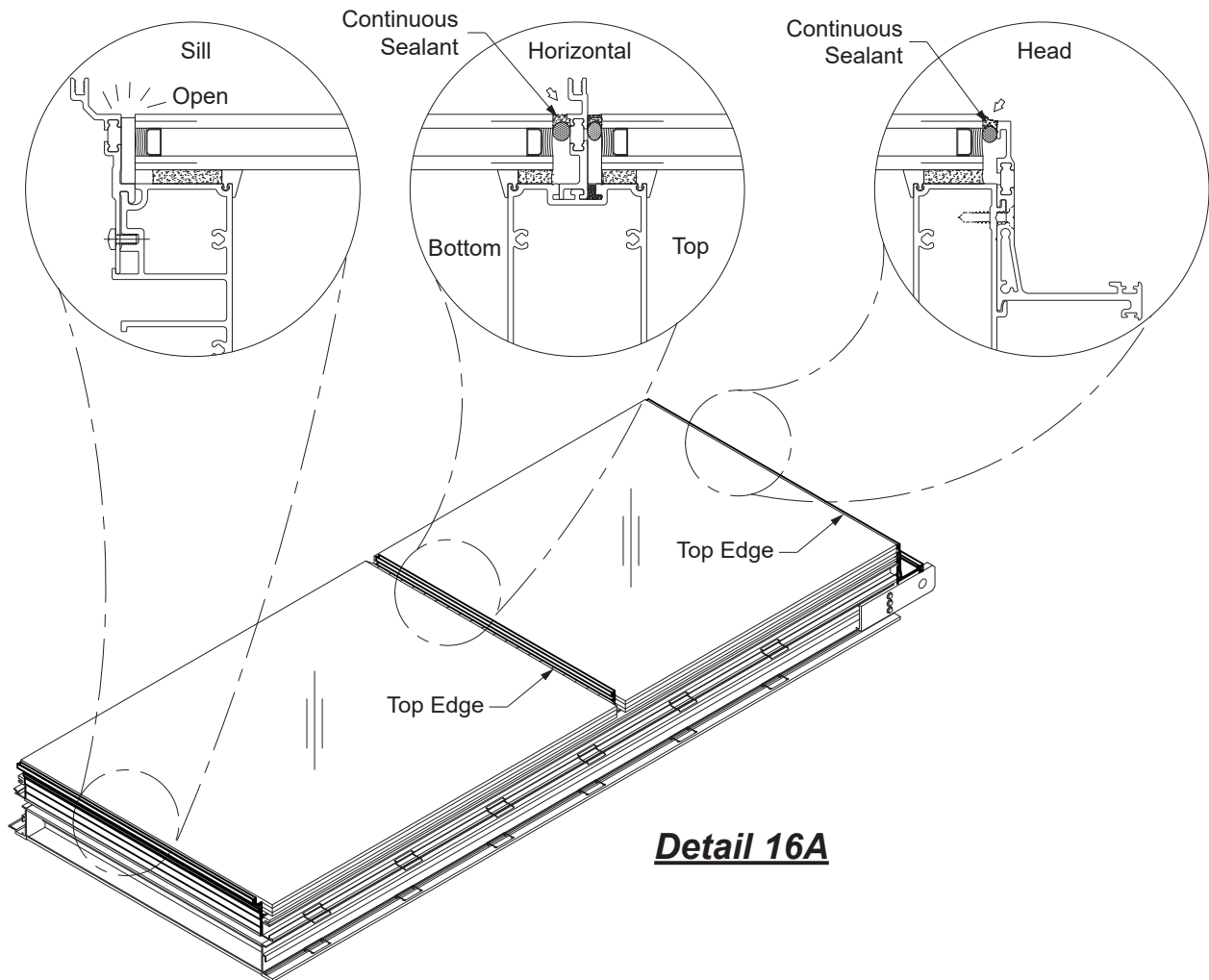
APPLY SEALANT TO GLASS EDGE

-Insert backer rods along the horizontal adaptor and stacking tray.

Note: The sill will be left open.

-Apply and tool sealant to the gap between the glass and the horizontal adaptor and stacking tray as shown in **Detail 16A**.

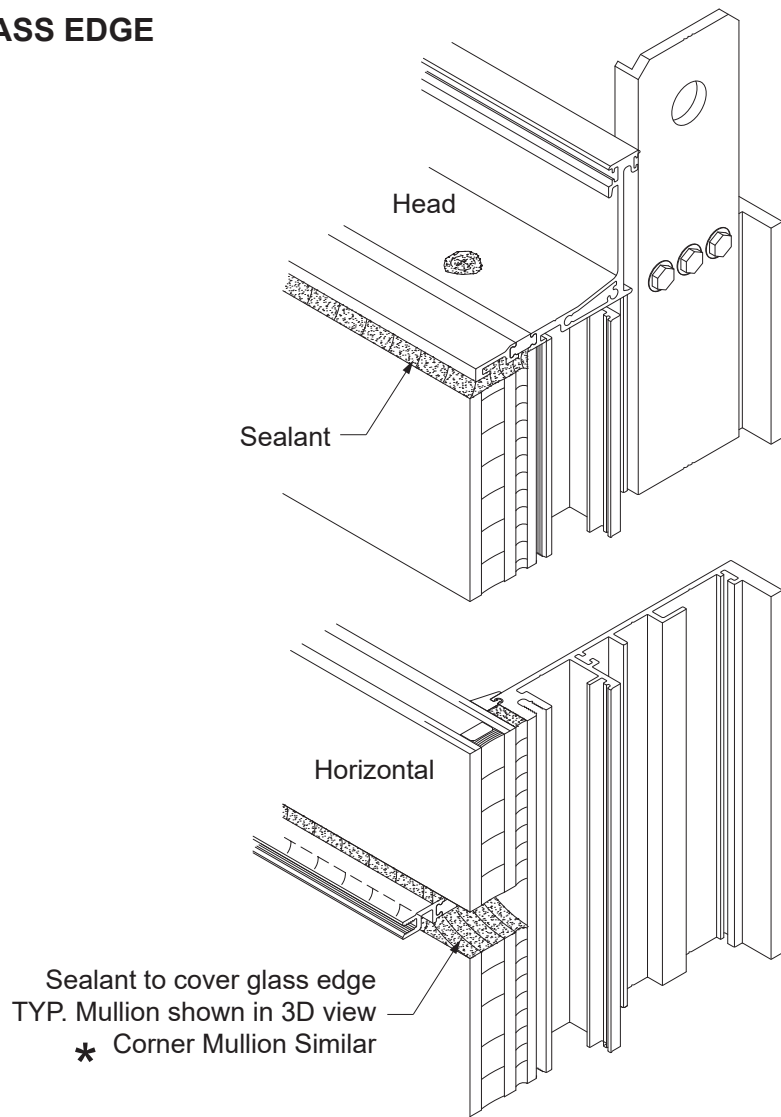
-Be sure to cover the glass edge at the top of the glass in its entirety. See **Detail 17A**.



Detail 16A

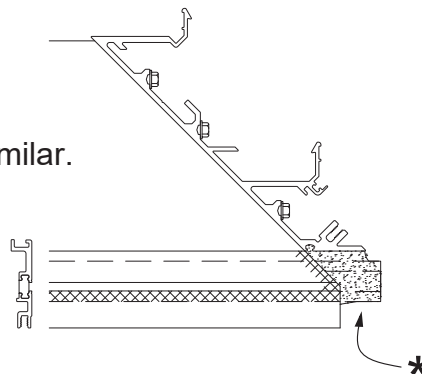
CAPTURED ADAPTORS ASSEMBLY

STEP 9A (Continued)
APPLY SEALANT TO GLASS EDGE



Detail 17A

Note: Application of sealant at corner mullion similar.

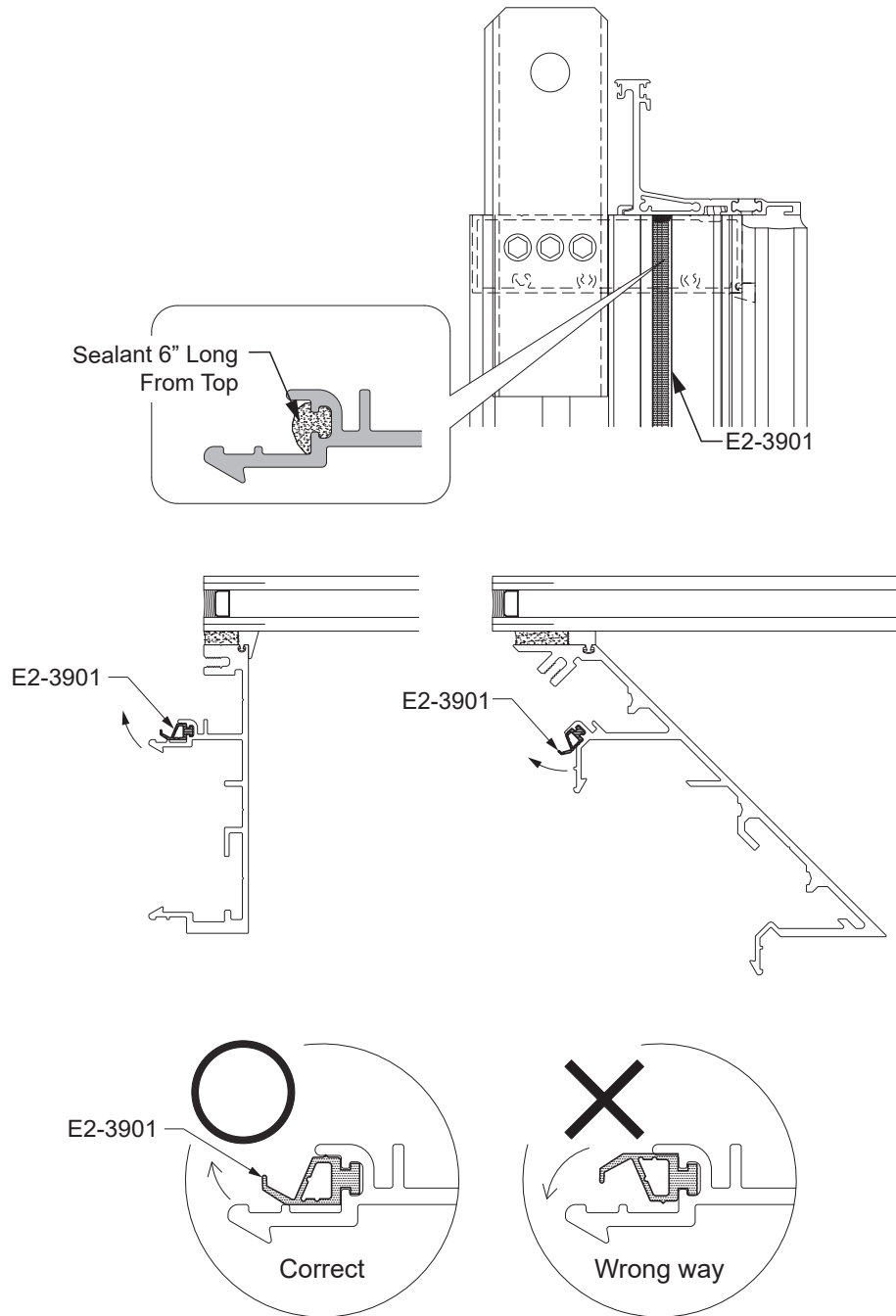


WEATHER BARRIER INSTALLATION (CAPTURED)

**STEP 10A
INSTALL AIR TIGHT GASKET**

- Apply sealant to the gasket reglet, 6" long from the top of the mullion.
- Slide the E2-3901 gasket into the mullion. Ensure the correct orientation is achieved.

See **Detail 18A**.



Detail 18A

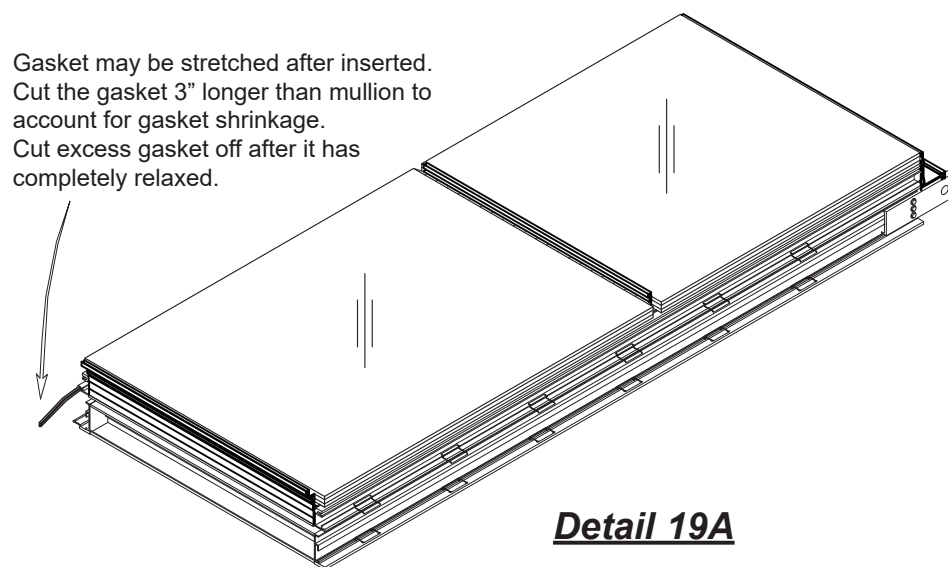
WEATHER BARRIER INSTALLATION (CAPTURED)

STEP 10A (Continued)

INSTALL AIR TIGHT GASKET

- Cut the E2-3901 air tight gasket to length of mullion plus (+) 3" to account for gasket shrinkage.
- Allow the gasket to contract before trimming off the excess gasket from the bottom.

See **Detail 19A**.

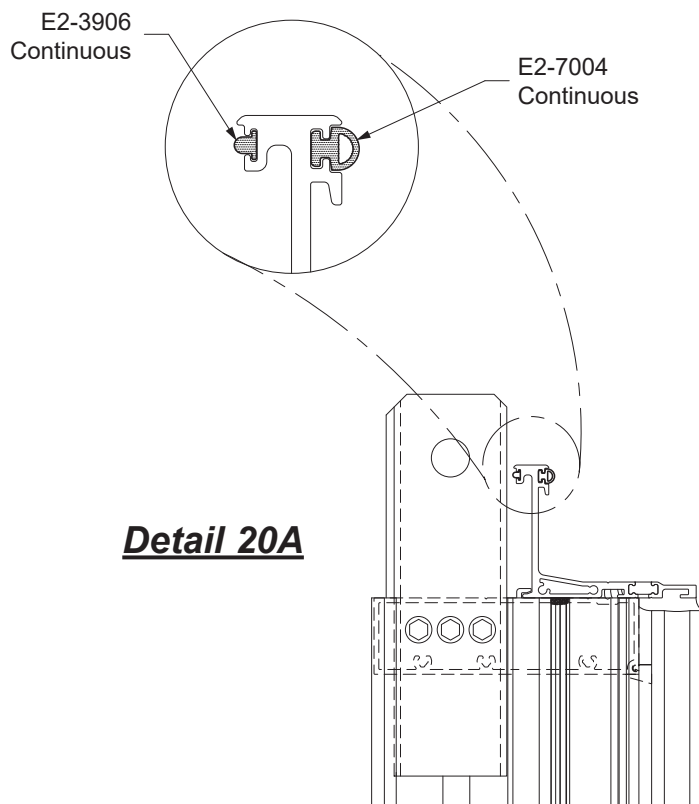


WEATHER BARRIER INSTALLATION (CAPTURED)

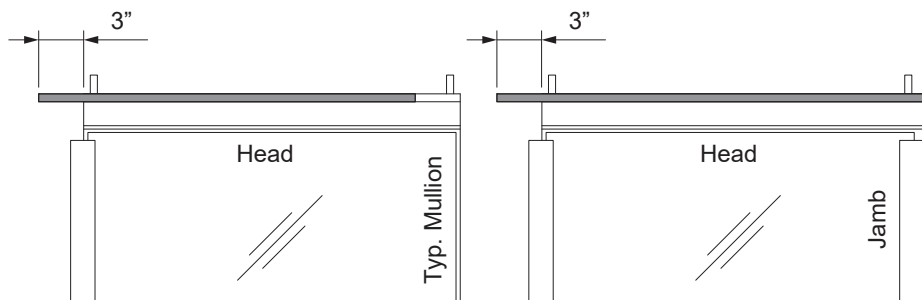
STEP 11A

INSTALL STACKING TRAY WEATHERSEALS

- Insert the gasket and spacer into their reglets as shown in **Detail 20A**.
- For the first unit near the jamb, cut the E2-7004 stacking tray gasket to the length of the stacking tray plus (+) 3”.
- For all other unit frames, cut the gasket and spacer to length of stacking tray. See **Detail 21A**.
- Cut the E2-3906 spacer to the length of the stacking tray.



Detail 20A



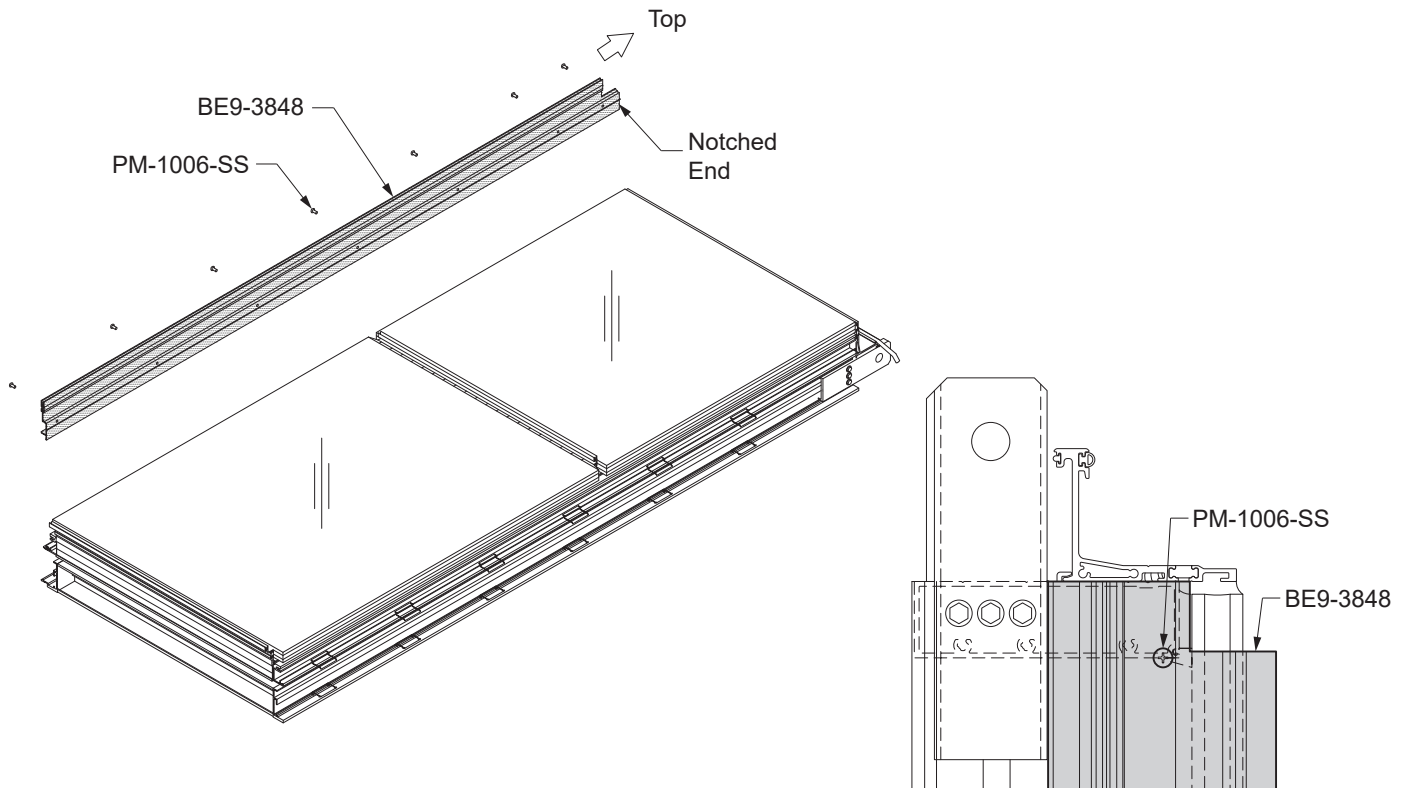
Detail 21A

WEATHER BARRIER INSTALLATION (CAPTURED)

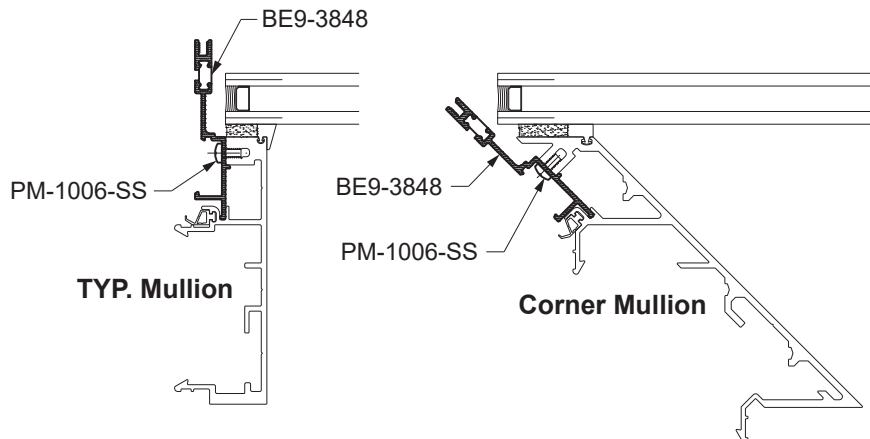
STEP 12A INSTALL VERTICAL ADAPTORS

-Install the BE9-3848 vertical adaptor flush (end to end) to the male mullion using PM-1006-SS fasteners. Ensure the notched end is at the top of the unit frame.

See **Details 22A**.



Detail 22A

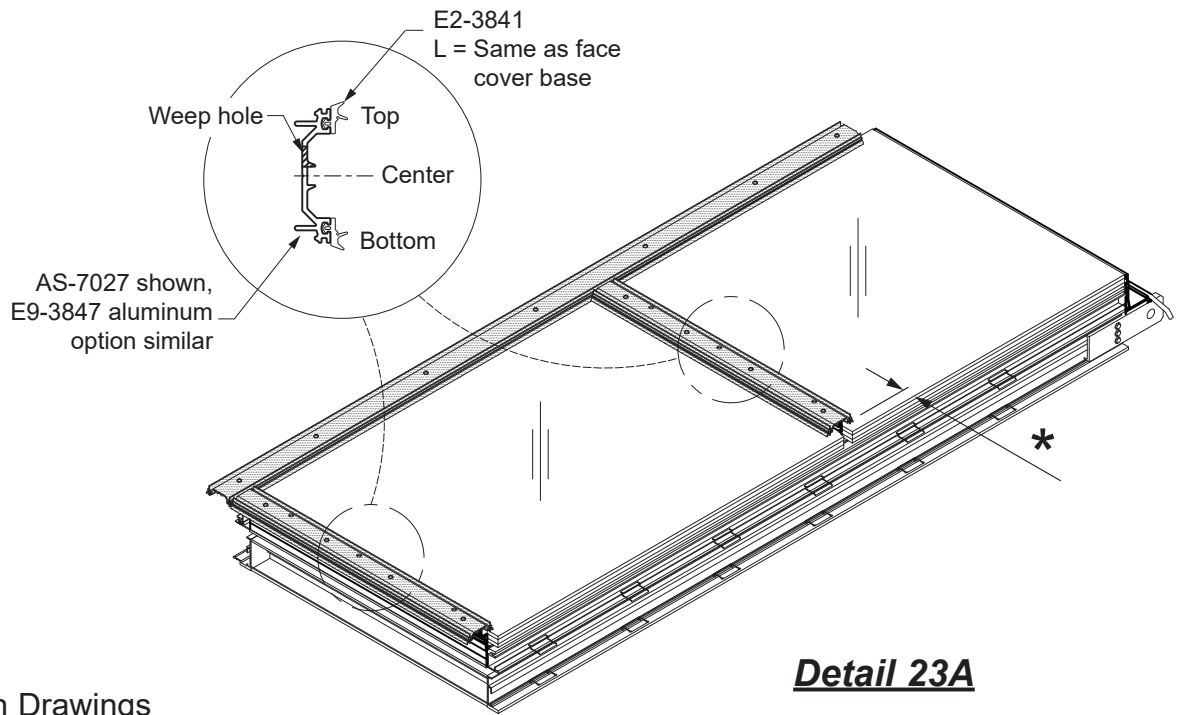


WEATHER BARRIER INSTALLATION (CAPTURED)

**STEP 13A
INSTALL FACE COVER BASES**

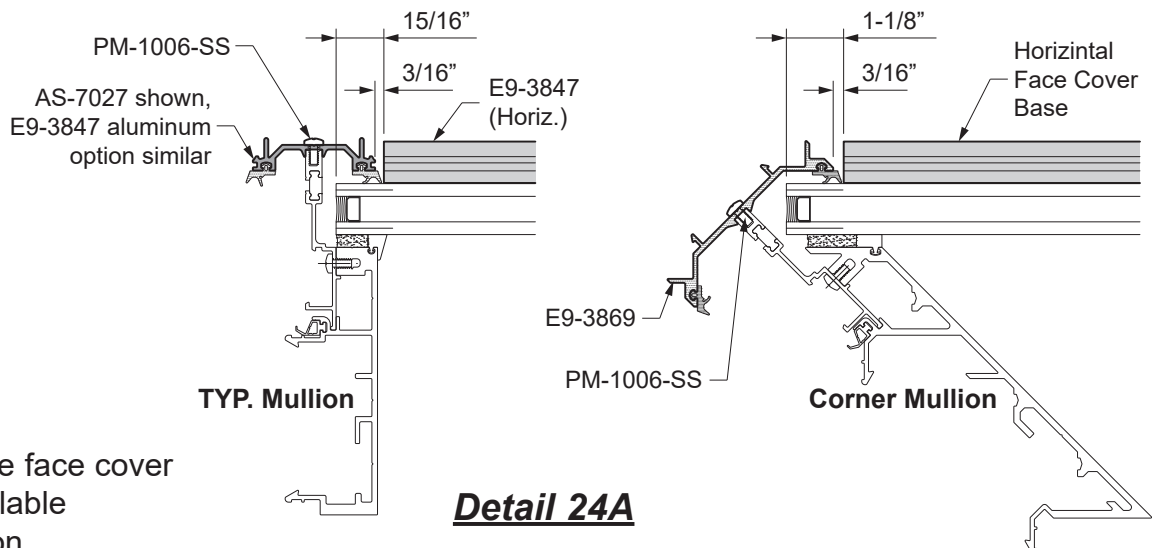
- Cut E2-3841 gasket to the same length as the face cover base and insert them into the face cover bases.
- Install the vertical face cover bases first, using PM-1006-SS fasteners.
- Install the horizontal face cover bases next, leaving a 3/16" gap between the end of the horizontal cover base and the vertical cover base.

See **Detail 23A**
& **Detail 24A.**



Detail 23A

* See Fabrication Drawings
YUW750TU-12 to 20 for this
dimension at each condition.



Detail 24A

Note: Polyamide face cover
base is not available
for corner mullion.

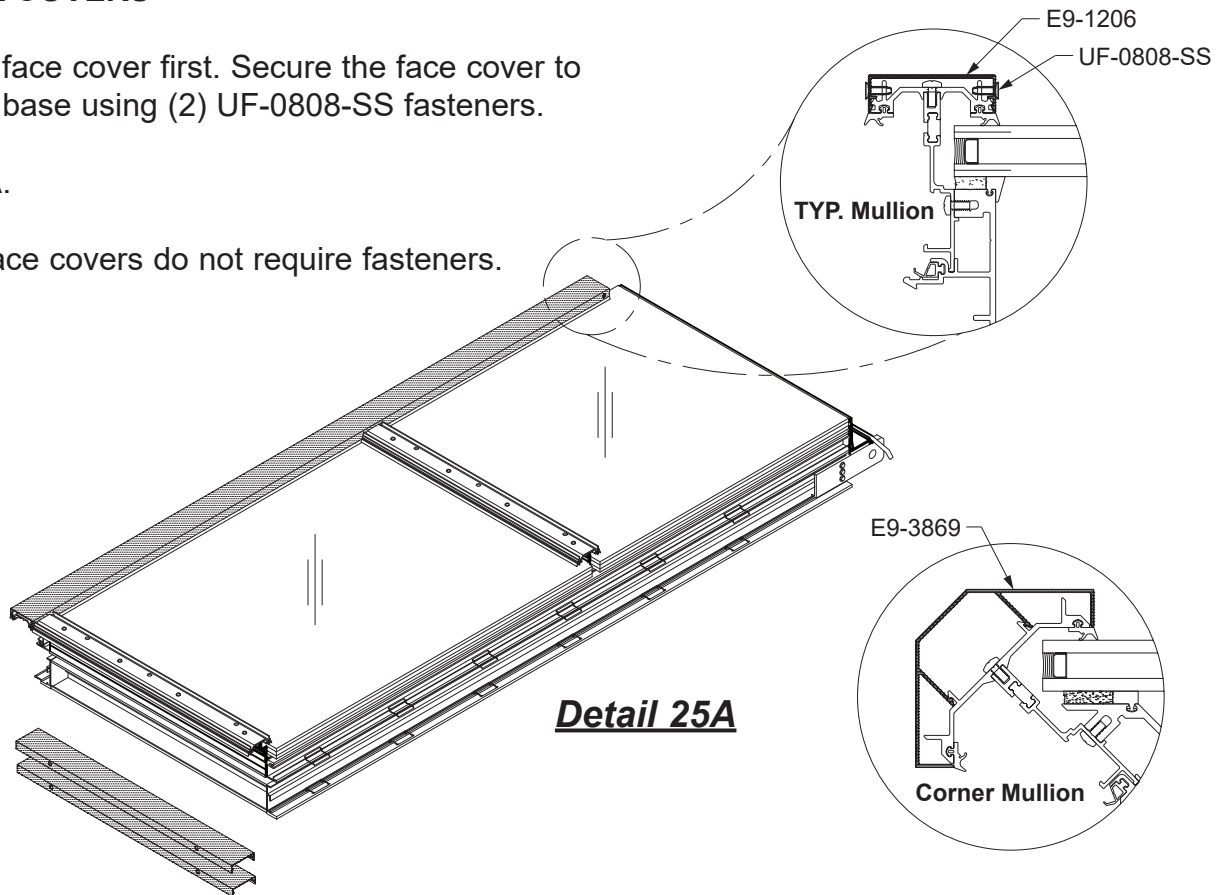
WEATHER BARRIER INSTALLATION (CAPTURED)

STEP 14A INSTALL FACE COVERS

-Attach vertical face cover first. Secure the face cover to the face cover base using (2) UF-0808-SS fasteners.

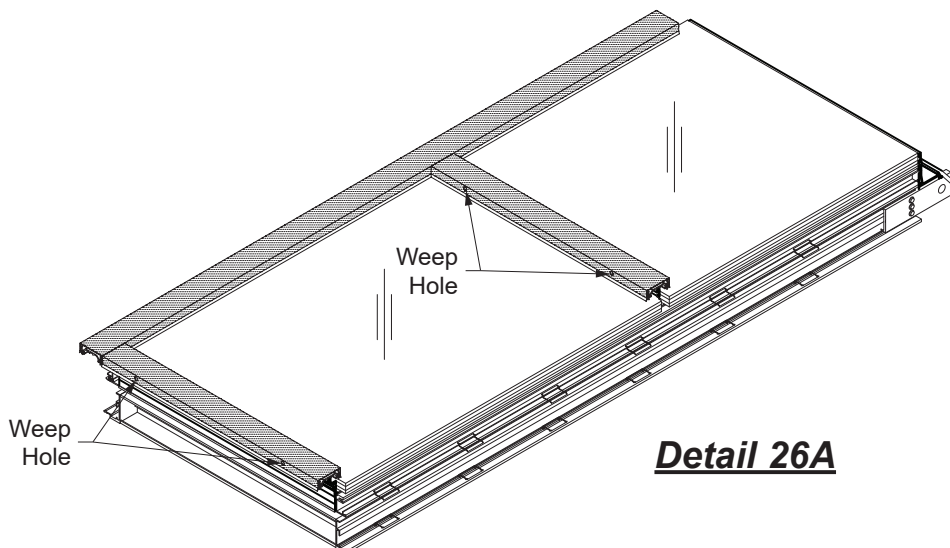
See **Detail 25A**.

Note: Corner face covers do not require fasteners.



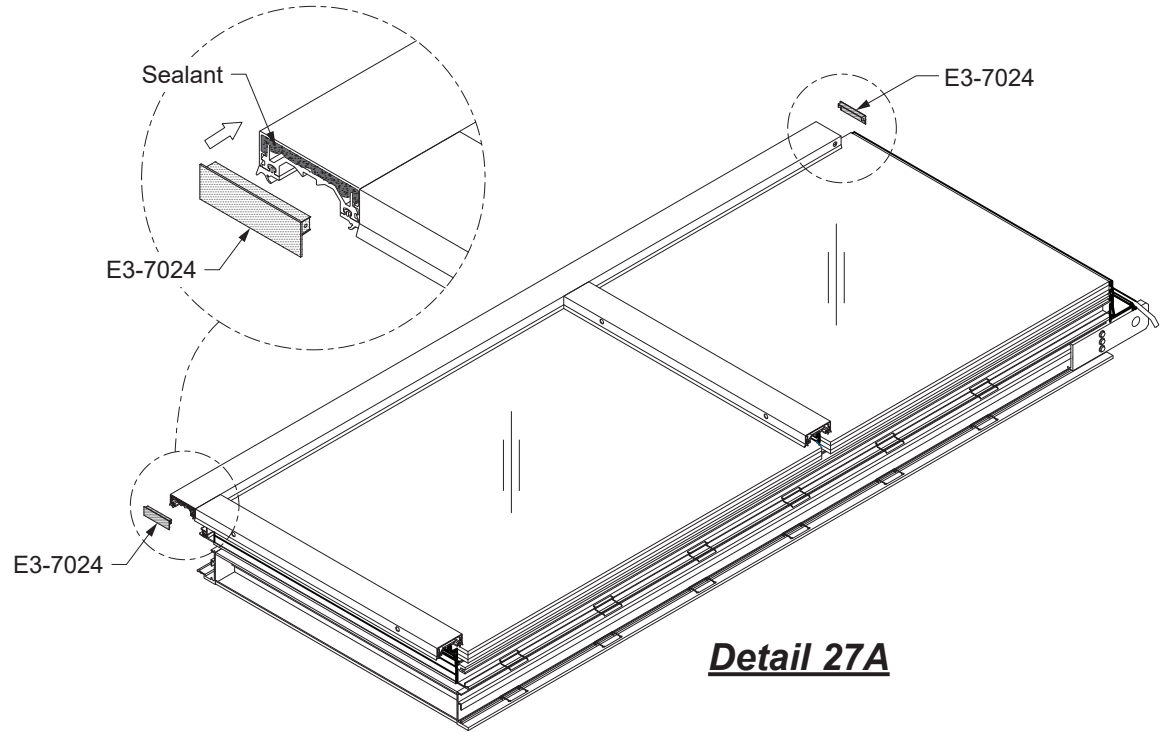
-Attach horizontal face covers with the weep holes facing the bottom of the framing unit.

See **Detail 26A**.



WEATHER BARRIER INSTALLATION (CAPTURED)

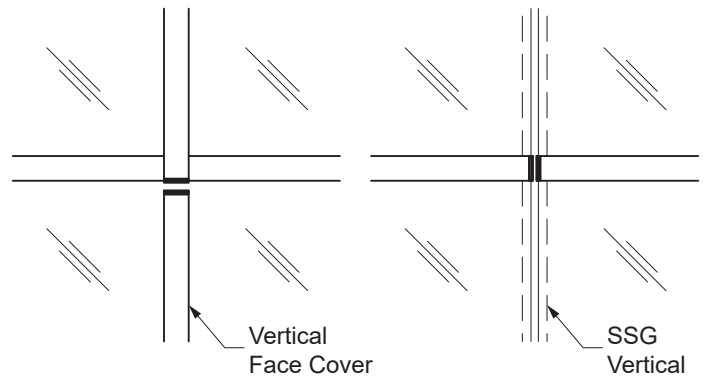
**STEP 15A
INSTALL FACE COVER END CAPS**



Detail 27A

-E3-7024 end caps are used at the ends of vertical face covers and at the horizontal face cover at the SSG vertical. See **Detail 28A**.

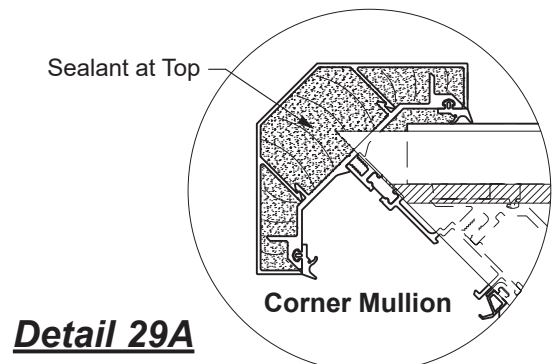
- Apply a small amount of sealant between the face cover and the face cover base.
- Insert the end cap into the face cover cavity.
- Wipe off excess sealant. **Detail 27A**.



Detail 28A

-At the top of the corner mullion, fill the cavity between the face cover base and the face cover with backer rods and sealant. Tool the sealant flush.

See **Detail 29A**.



Detail 29A

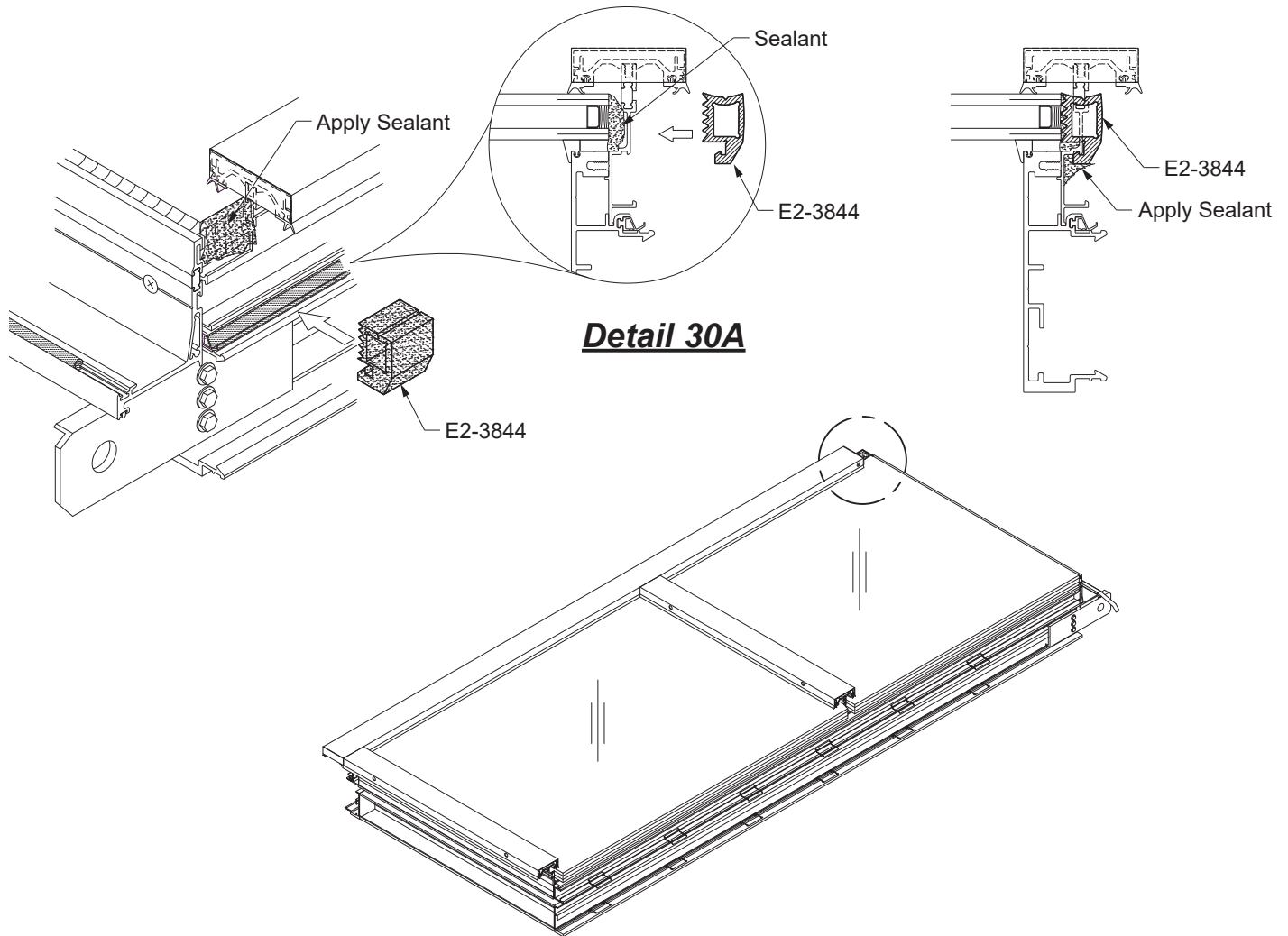
WEATHER BARRIER INSTALLATION (CAPTURED)

STEP 16A

INSTALL JOINT PLUGS FOR CAPTURED MULLION

- Apply sealant to the top of the glass edge.
- Snap the E2-3844 joint plug onto the top of the mullion.
- Seal the interior of the joint plug onto the mullion.

See **Detail 30A**.



Note: Corner mullion requires the sealant application instead of attaching the joint plug after unit installation as previously shown in **Detail 29A**.

SSG Adaptors Assembly

**See Page 11 for SSG Adaptor
Installations**

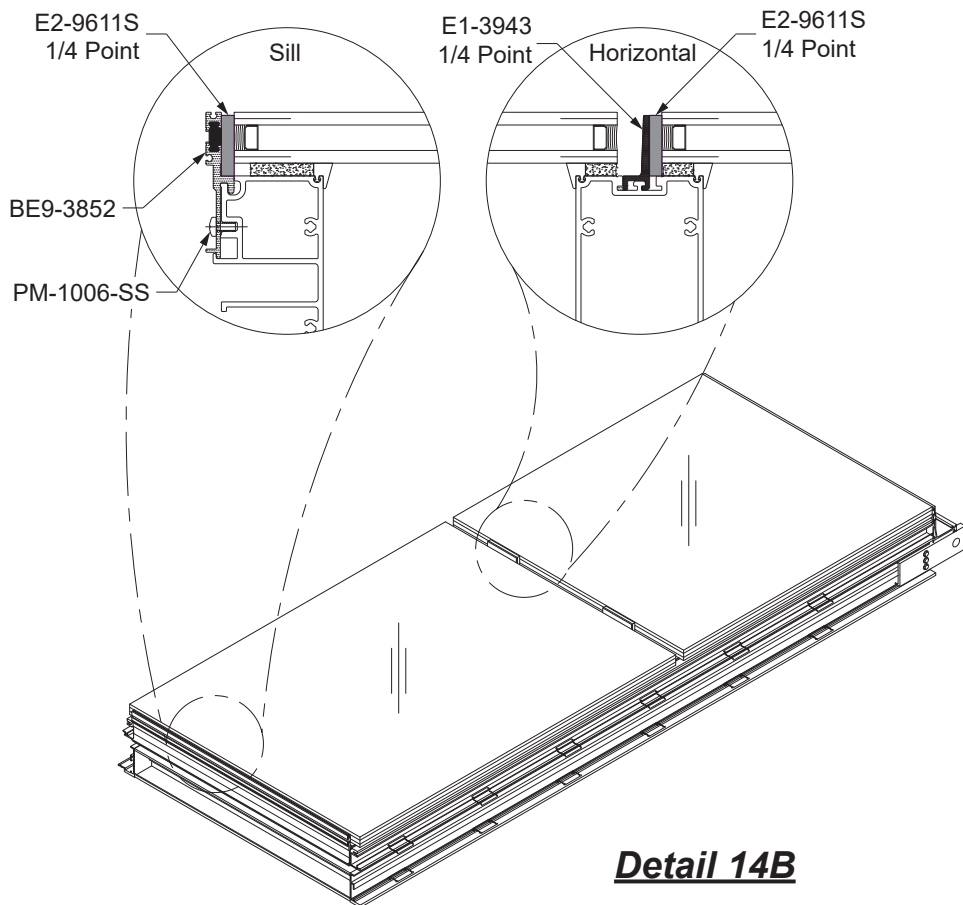
SSG ADAPTORS ASSEMBLY

STEP 8B

ATTACH HORIZONTAL ADAPTORS, SETTING BLOCKS, & STACKING TRAY

- Attach the horizontal adaptors into the horizontals. Secure the sill adaptor onto the sill with PM-1006-SS fasteners.
- Insert setting blocks between the horizontal/sill adaptors and the glass, two per Daylight Opening at 1/4 points unless otherwise specified in the approved shop drawings.

See **Detail 14B**.



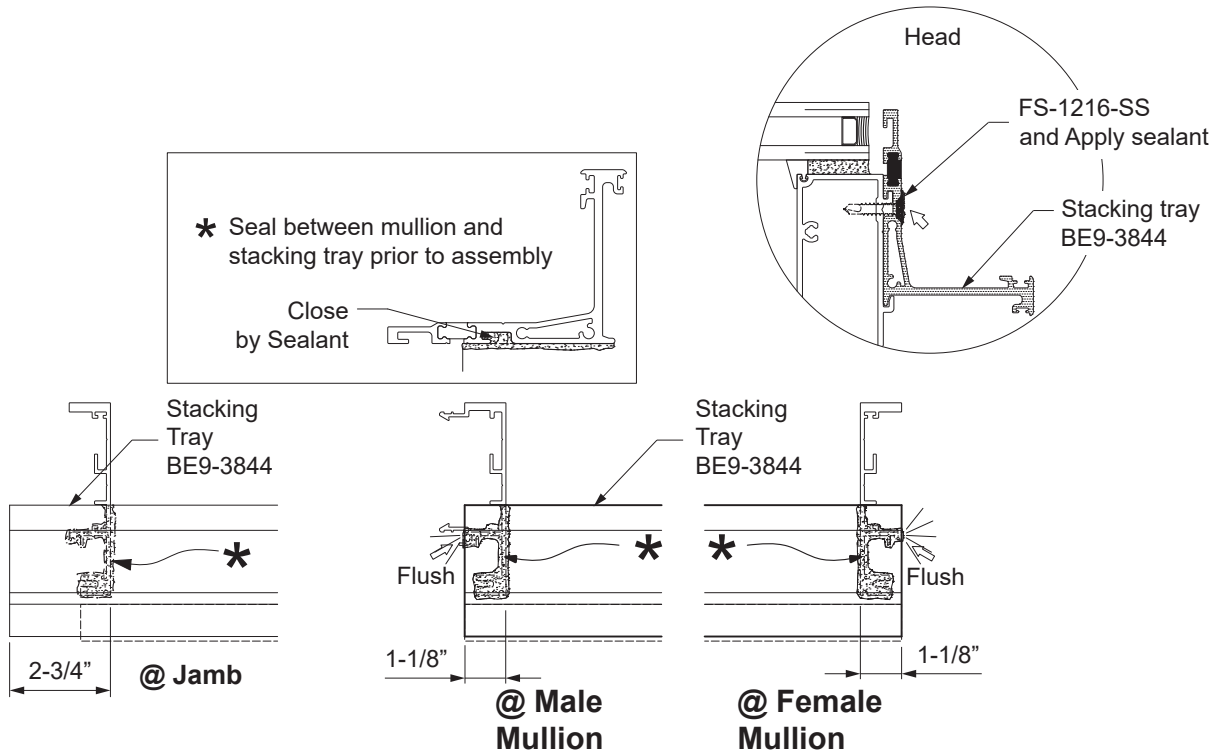
SSG ADAPTORS ASSEMBLY

STEP 8B (Continued)

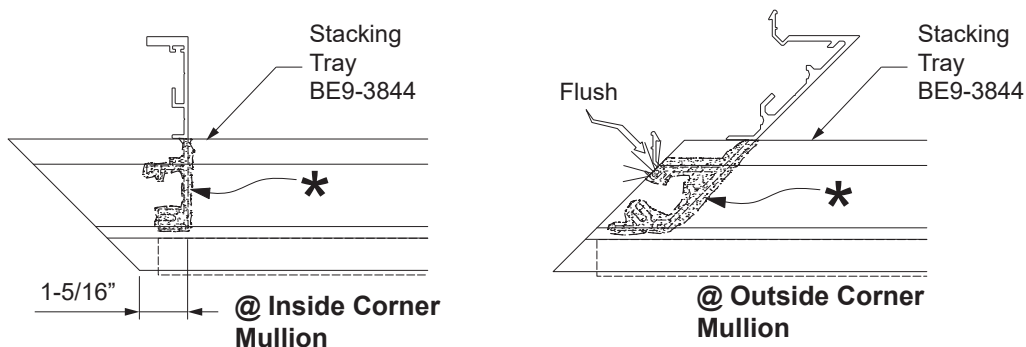
ATTACH HORIZONTAL ADAPTORS, SETTING BLOCKS, & STACKING TRAY

- Before installing the stacking tray, apply sealant to the top end of the mullions as shown in **Detail 15B** (indicated by * .)
- Install the BE9-3844 stacking tray onto the top of the framing unit, locating it according to the dimensions shown. Secure it to the framing unit using FS-1216-SS fasteners (minimum 3 fasteners required). Seal the fastener heads.
- Apply and tool sealant between the top of the mullion and the stacking tray, filling any voids.

See **Detail 15B**.



Detail 15B



SSG ADAPTORS ASSEMBLY

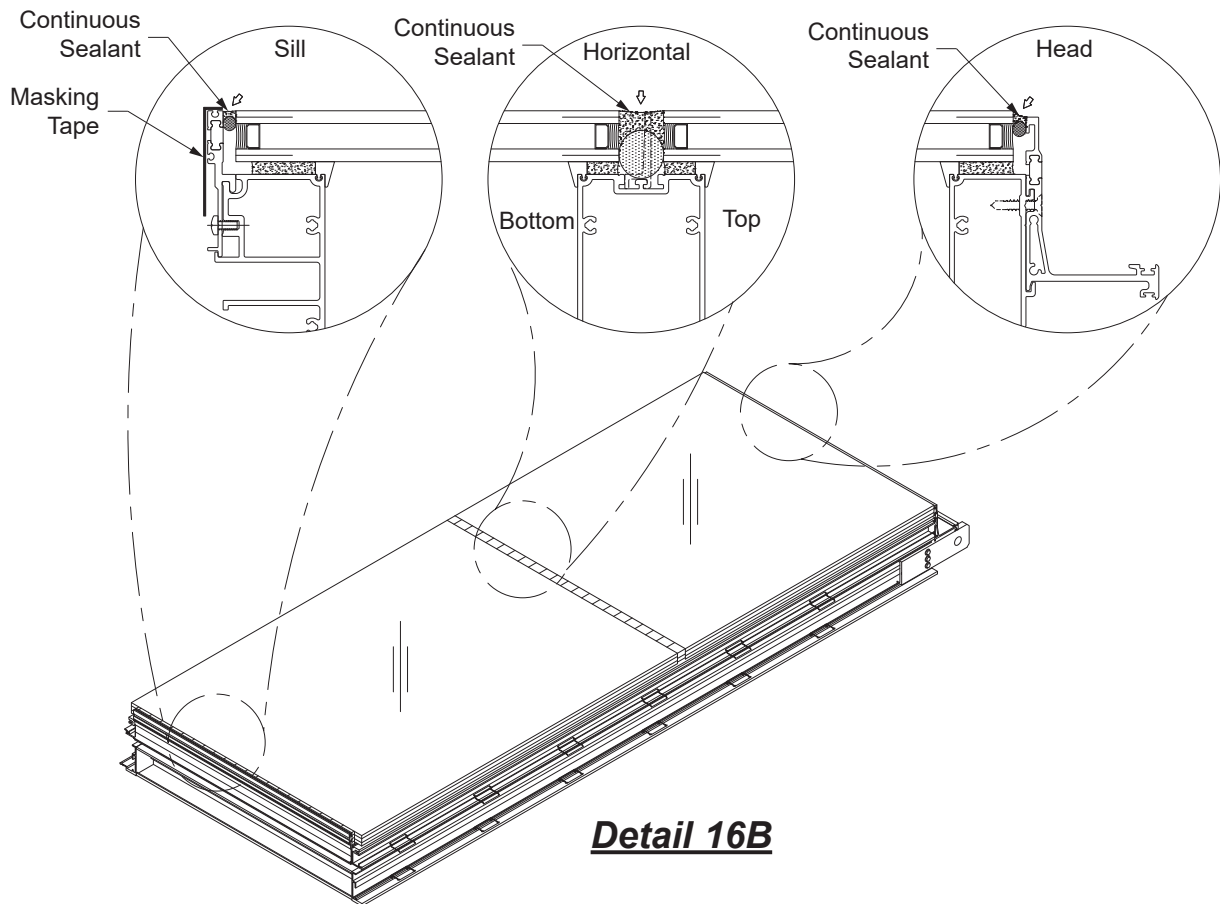
STEP 9B

APPLY SEALANT TO GLASS EDGE

-Insert backer rods along the sill, horizontal adaptor, and stacking tray.

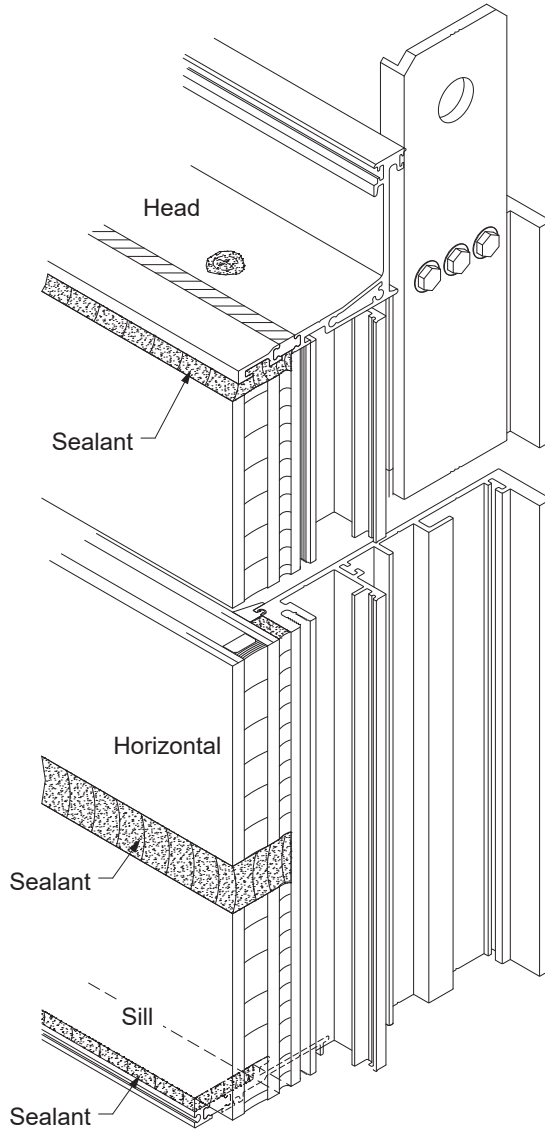
-Apply and tool sealant to the gap between the glass and the horizontal adaptor and stacking tray as shown in **Detail 16B**.

-Be sure to cover the glass edge at the top of the glass in its entirety. See **Detail 17B**.

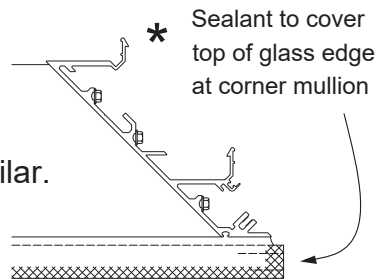


SSG ADAPTORS ASSEMBLY

**STEP 9 (Continued)
APPLY SEALANT TO GLASS EDGE**



Detail 17B

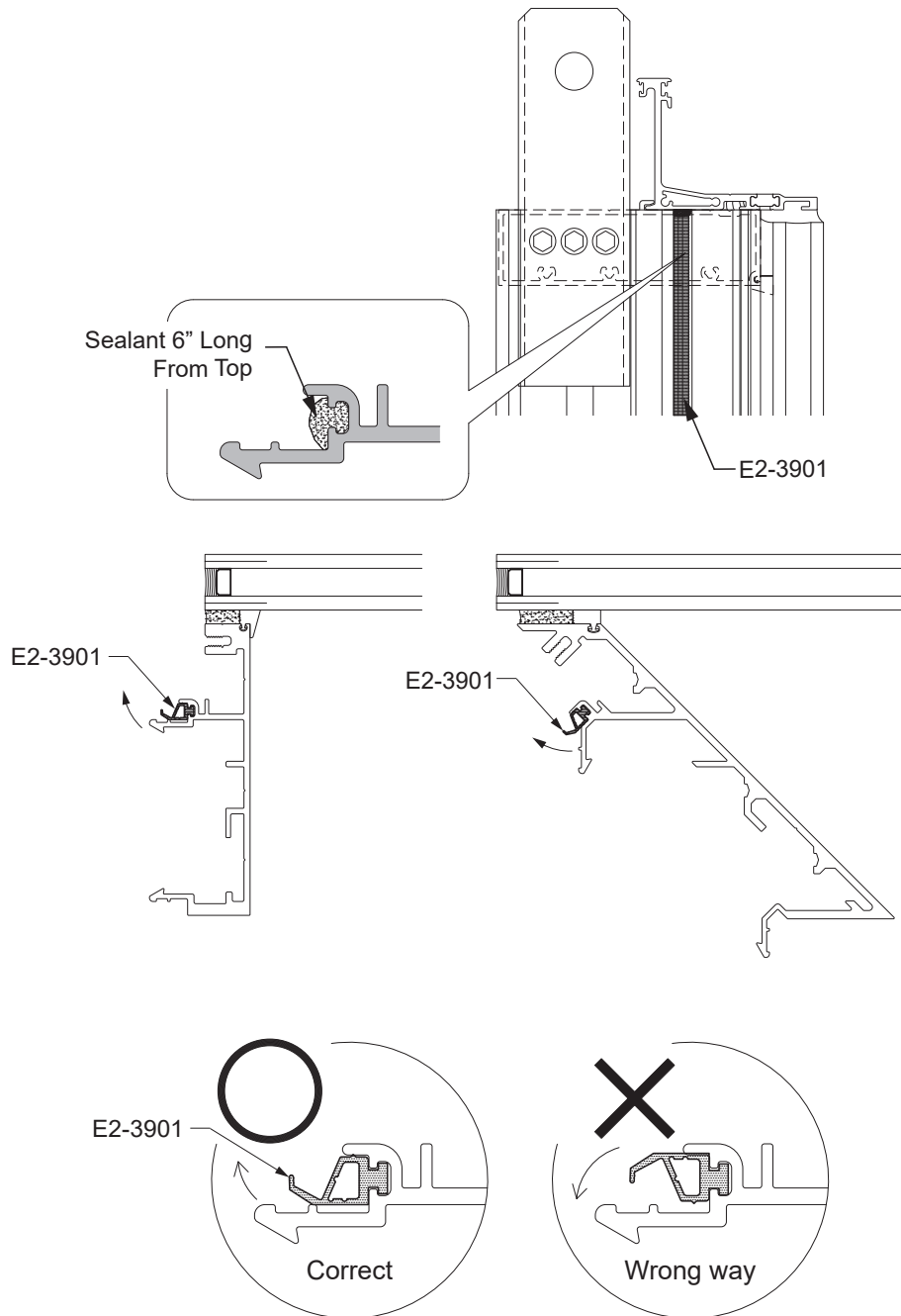


Note: Application of sealant at corner mullion similar.

WEATHER BARRIER INSTALLATION (SSG)

STEP 10B INSTALL AIR TIGHT GASKET

- Apply sealant to the gasket reglet, 6" long from the top of the mullion.
- Slide the E2-3901 gasket into the mullion as shown in **Detail 18B**. Ensure the correct orientation is achieved.

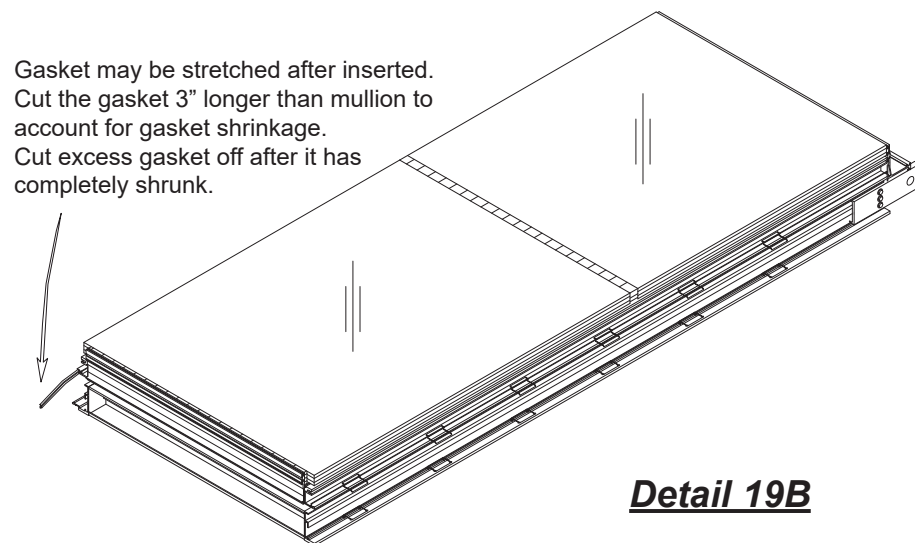


Detail 18B

WEATHER BARRIER INSTALLATION (SSG)**STEP 10B (Continued)
INSTALL AIR TIGHT GASKET**

- Cut the E2-3901 air tight gasket to length of mullion plus (+) 3" to account for gasket shrinkage.
- Allow the gasket to contract before trimming off the excess gasket from the bottom.

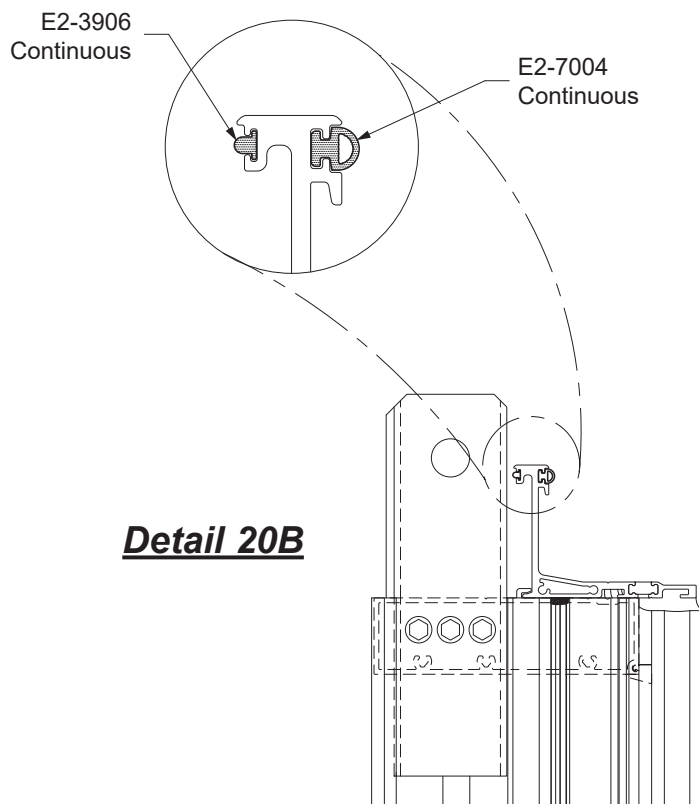
See **Detail 19B**.



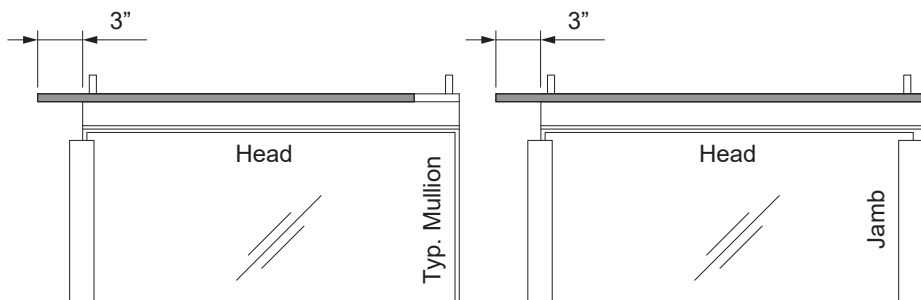
WEATHER BARRIER INSTALLATION (SSG)

**STEP 11B
INSTALL STACKING TRAY WEATHESEALS**

- Insert the gasket and spacer into their reglets as shown in **Detail 20B**.
- For the first unit near the jamb, cut the E2-7004 stacking tray gasket to the length of the stacking tray plus (+) 3”.
- For all other unit frames, cut the gasket and spacer to the length of the stacking tray.
- Cut the E2-3906 spacer to the length of the stacking tray. See **Detail 21B**.



Detail 20B



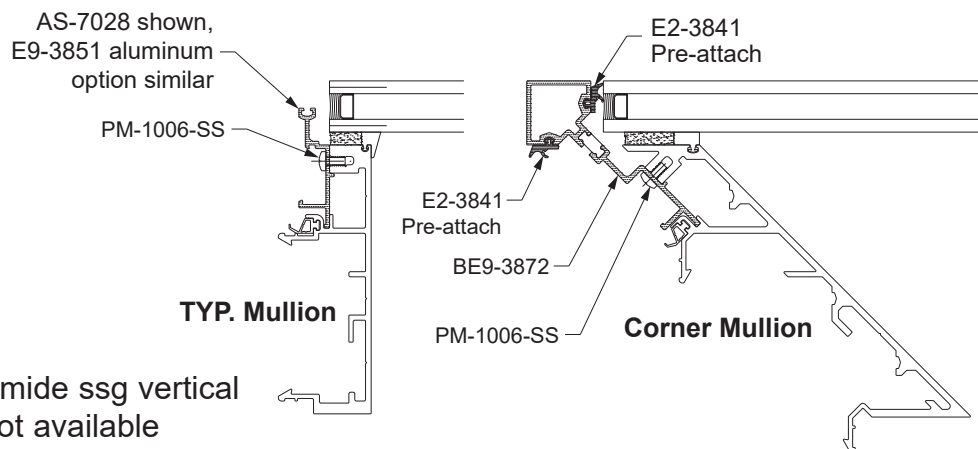
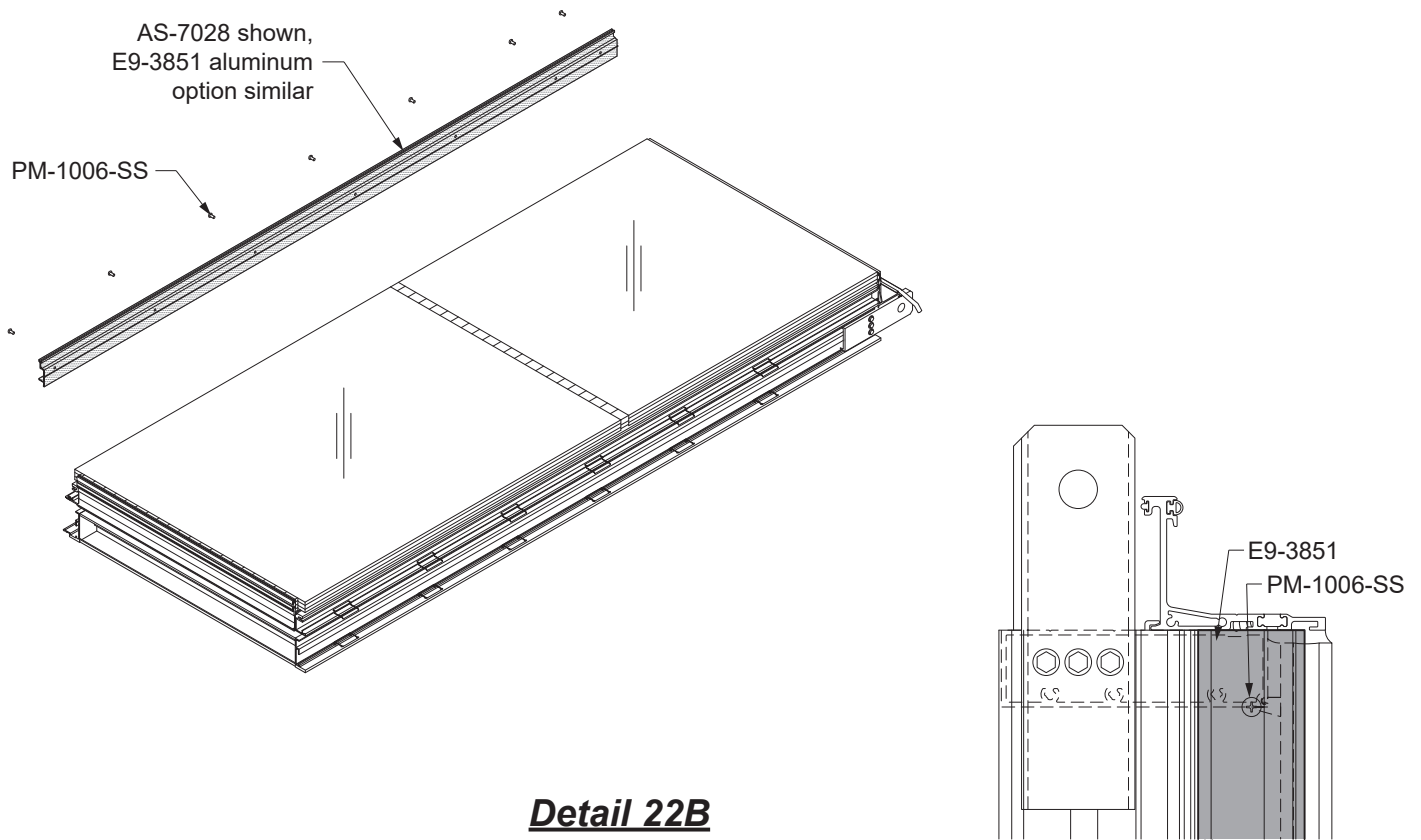
Detail 21B

WEATHER BARRIER INSTALLATION (SSG)

**STEP 12B
INSTALL VERTICAL ADAPTORS**

- Install the vertical ssg adaptor to the male mullion using PM-1006-SS fasteners.
- Use BE9-3872 for outside corner

See **Details 22B**.



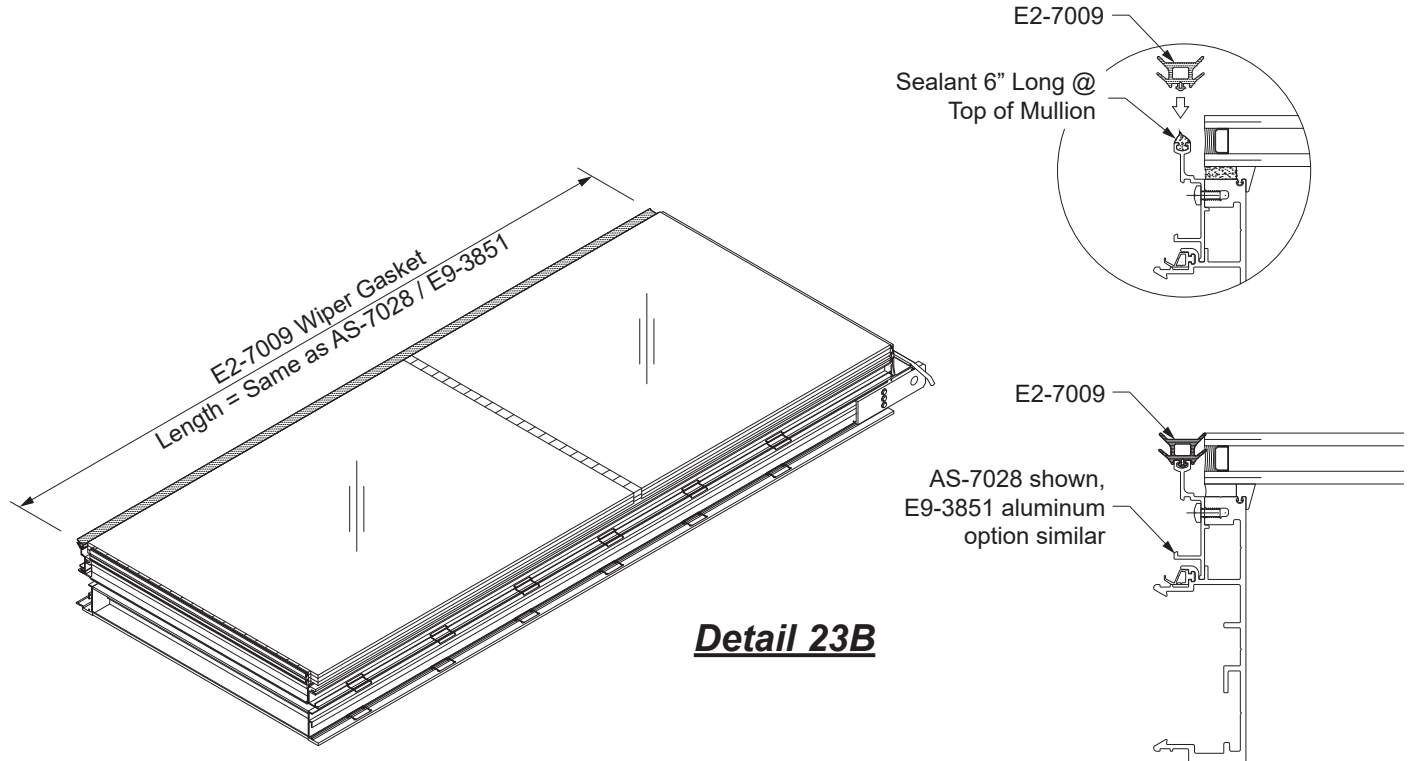
Note: Polyamide ssg vertical adaptor is not available for corner mullion.

WEATHER BARRIER INSTALLATION (SSG)

STEP 13B INSTALL VERTICAL WIPER GASKET

- Cut the E2-7009 vertical wiper gasket the same length as the mullion vertical adaptor.
- Apply sealant into the reglet of the vertical adaptor, 6" long from the top of the vertical adaptor. This will prevent the wiper gasket from sliding down.
- Insert the wiper gasket into the vertical adaptor.

See **Detail 23B**.

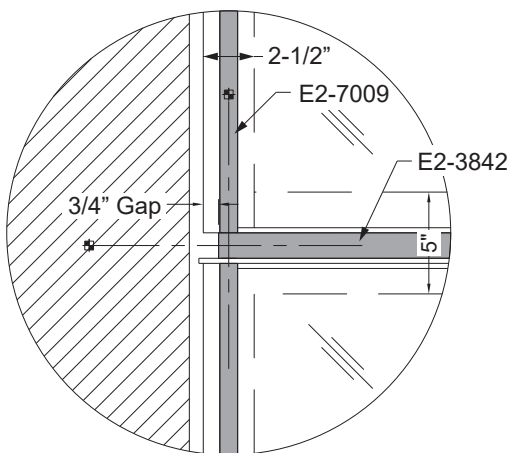
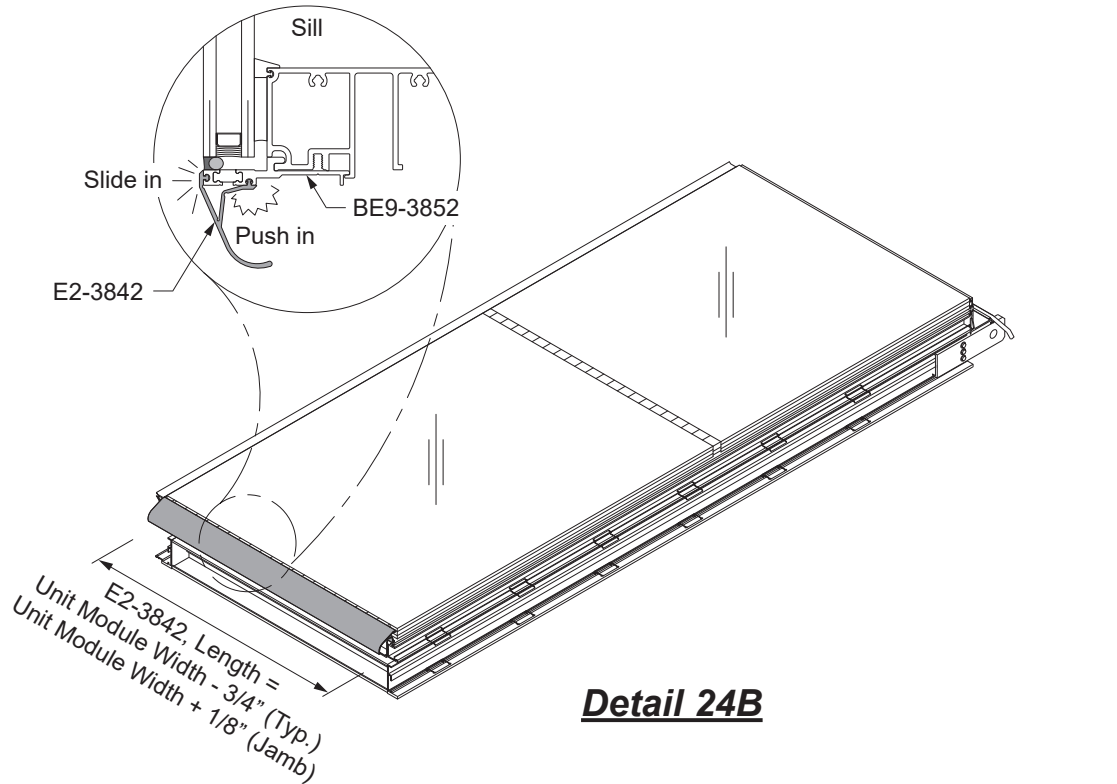


WEATHER BARRIER INSTALLATION (SSG)

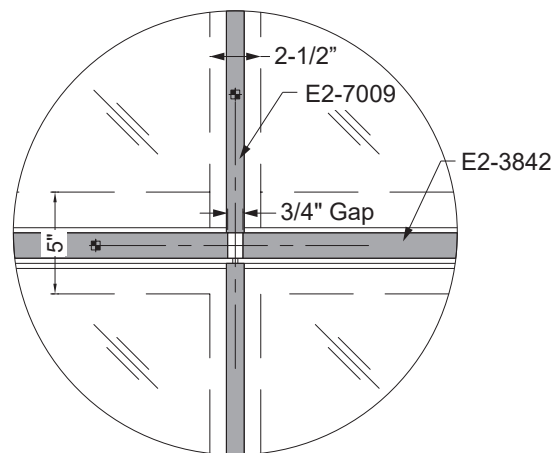
**STEP 14B
INSTALL HORIZONTAL WIPER GASKET**

-Install the horizontal wiper gasket E2-3842 into the sill adaptor.

See **Details 24B**.



After unit installation (Jamb)



After unit installation (Typ.)



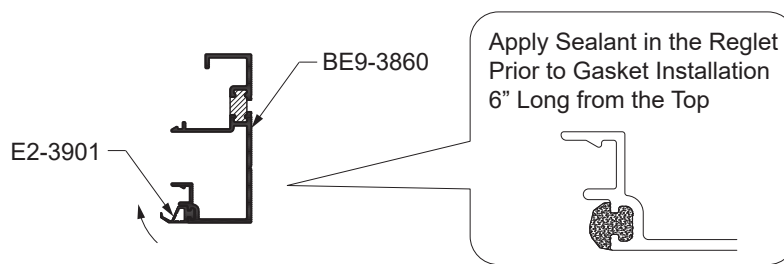
Jamb Adaptors Assembly

JAMB ADAPTORS ASSEMBLY

**STEP 17
INSTALL JAMB ADAPTORS**

- Cut the E2-3901 air tight gasket to the length of the mullion plus (+) 3” to account for gasket shrinkage.
- Apply sealant into the reglet 6” long from the top.
- Insert the gasket into the jamb adaptor. Trim off the excess gasket after it is completely shrunk.

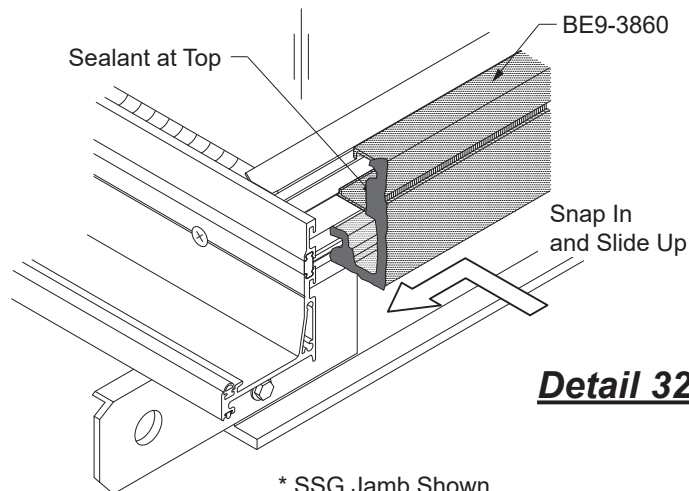
See **Detail 31**.



Detail 31

- Apply sealant to the top end of the BE9-3860 jamb adaptor.
- Snap on the jamb adaptor, and slide it all the way up to the stacking tray.

See **Detail 32**.



Detail 32

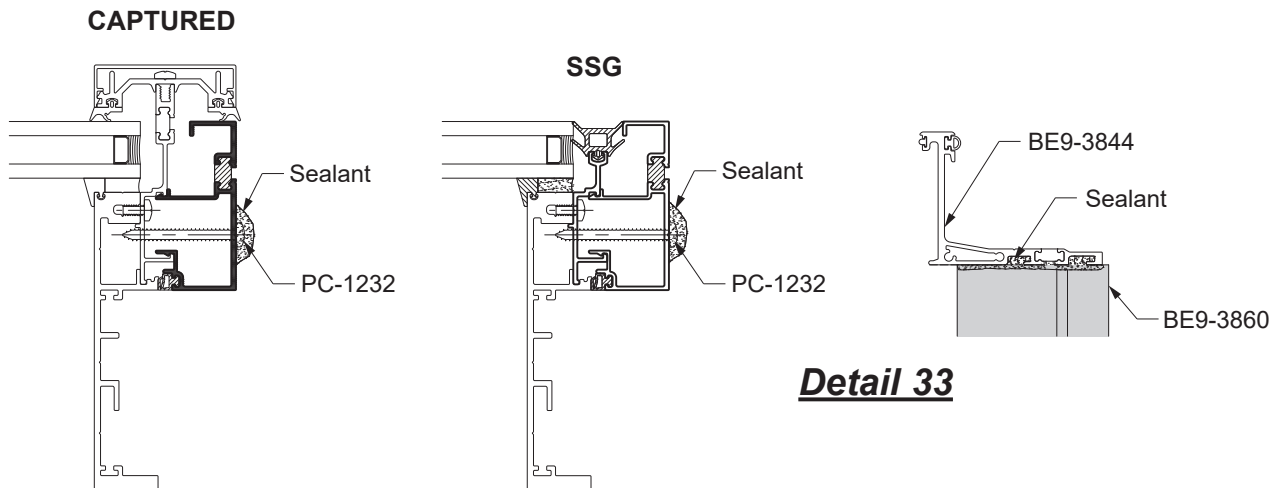
* SSG Jamb Shown
Captured Jamb Similar

JAMB ADAPTORS ASSEMBLY

**STEP 17 (Continued)
INSTALL JAMB ADAPTORS**

- Secure the jamb adaptor to the jamb mullion with (3) PC-1232 fasteners. Apply and tool sealant to the screw head.
- Apply and tool sealant to the joint between the jamb adaptor and the stacking tray.

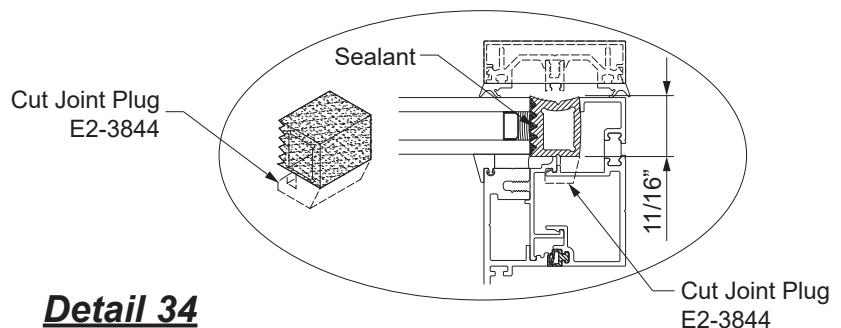
See **Detail 33**.



Detail 33

FOR CAPTURED JAMB

- Cut the joint plug as shown in **Detail 34**.
- Apply sealant to the edge fo the glass at the top of the jamb mullion.
- Insert the joint plug at the top of the jamb mullion.



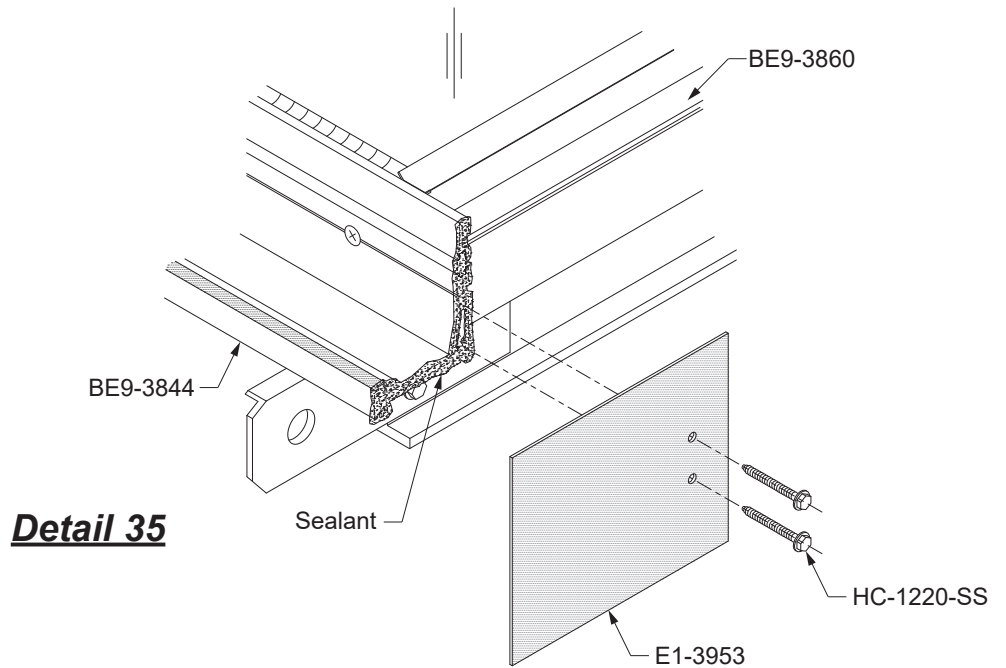
Detail 34

JAMB ADAPTORS ASSEMBLY

**STEP 18
INSTALL END DAMS**

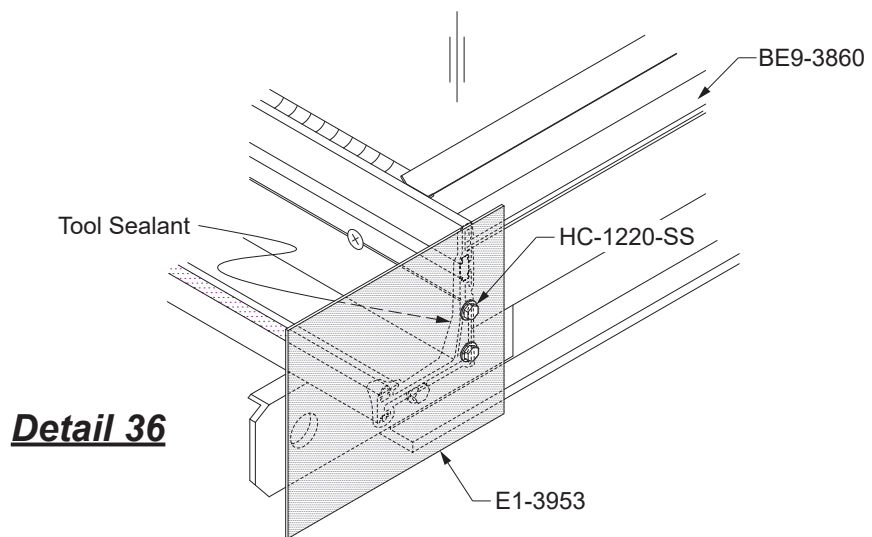
- Apply sealant to the end of the stacking tray at the jamb mullion.
- Install the E1-3953 end dam using (2) HC-1220-SS fasteners.

See **Detail 35**.



- Tool sealant at the inside of the end dams.

See **Detail 36**.



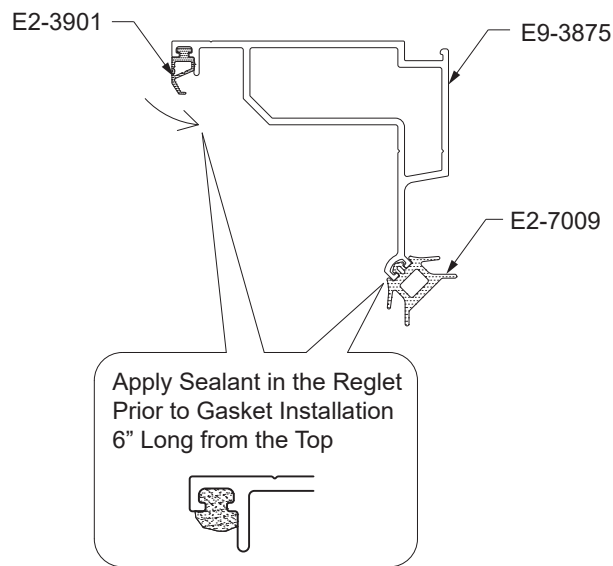
* SSG Jamb Shown
Captured Jamb Similar

**Inside Corner
Adaptors Assembly**

INSIDE CORNER ADAPTORS ASSEMBLY**STEP 19****ASSEMBLE / INSTALL CORNER ADAPTORS**

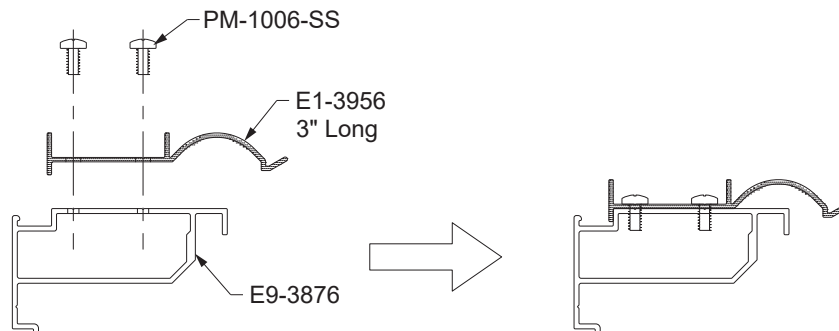
- Apply sealant to the gasket reglets 6" long from the top of the adaptor E9-3875.
- Slide E2-3901 air tight gasket into E9-3875 adaptor.
- Cut E2-3901 to length of mullion plus (+) 3" to account for gasket shrinkage.
- Push E2-7009 vertical wiper gasket into E9-3875 adaptor. Length to be same as E9-3875.

See **Detail 37**.



Detail 37

- Attach E1-3956 inside corner clip to E9-3876 adaptor using PM-1006-SS screws. See **Detail 38**.



Detail 38

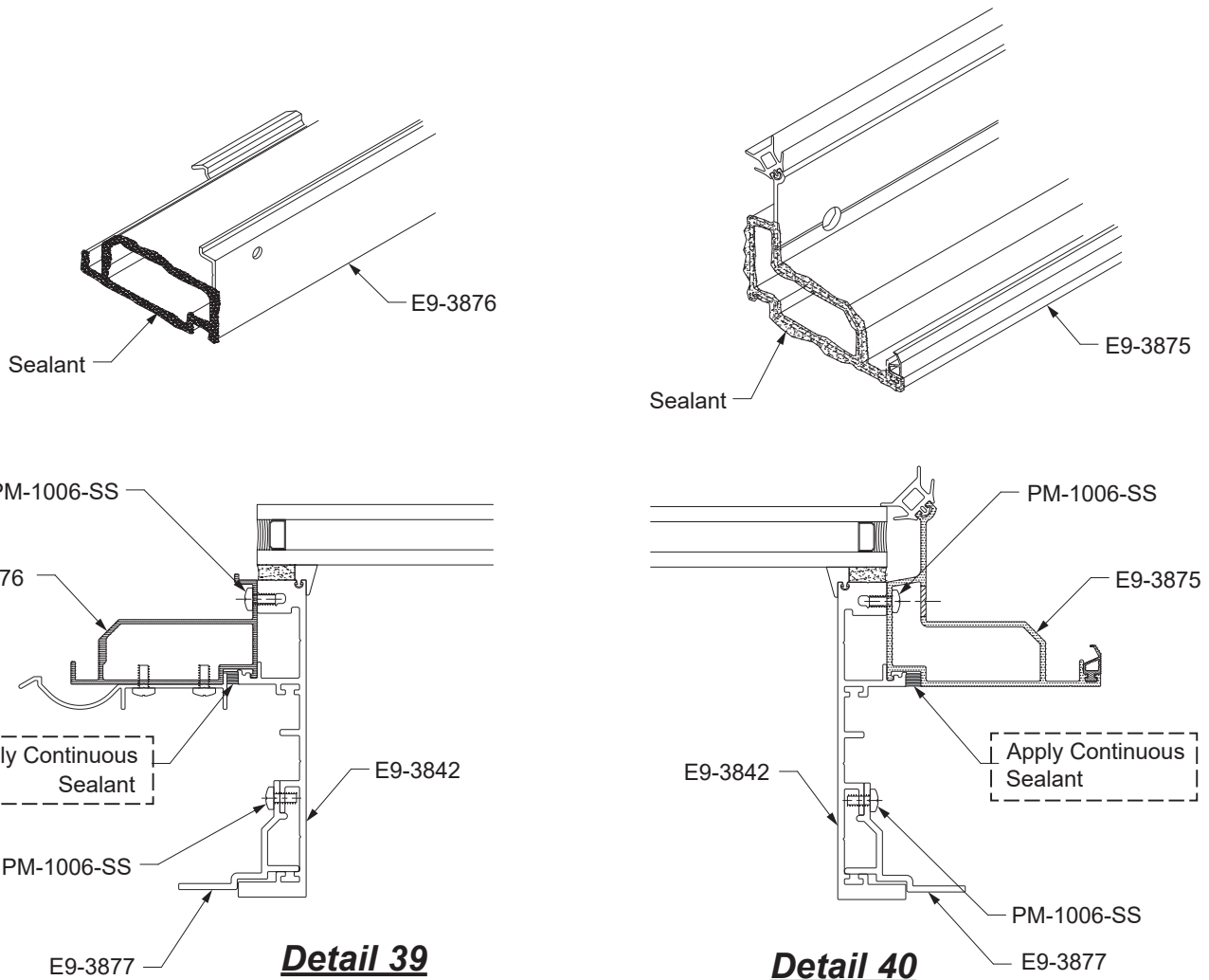
INSIDE CORNER ADAPTORS ASSEMBLY

STEP 19 (Continued)

ASSEMBLE / INSTALL CORNER ADAPTORS

- Apply sealant to the top of the corner adaptor prior to contact with stacking tray.
- Attach the adaptor to the corner using PM-1006-SS fasteners.
- Attach the inside corner cover base E9-3877 to the mullion using PM-1006-SS fasteners.
- Apply continuous sealant to the areas indicated.

See **Details 39 & 40**.



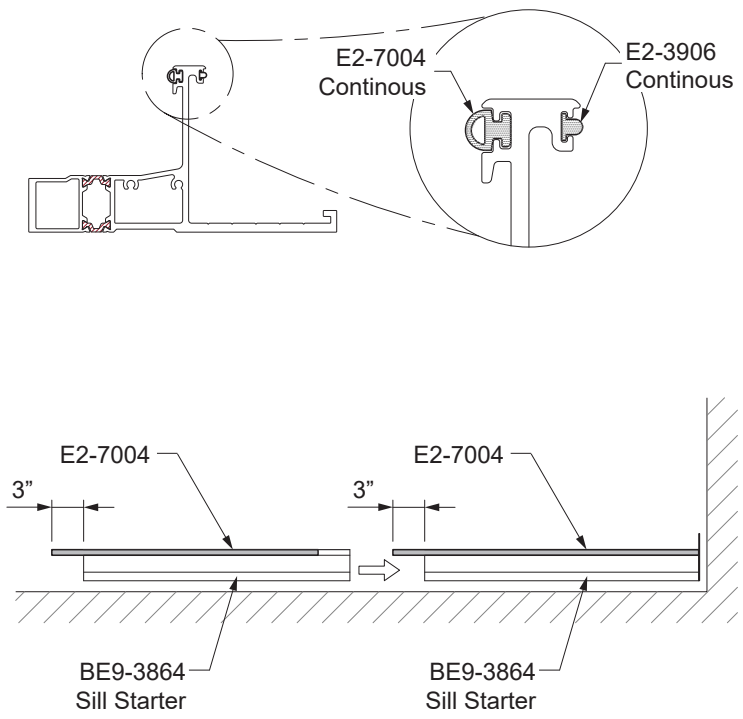
Sill Starter Assembly

SILL STARTER ASSEMBLY

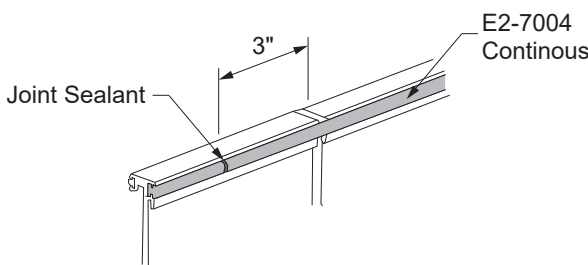
**STEP 20
ASSEMBLE SILL STARTER**

- Insert the stacking tray gasket and the stacking tray spacer to sill starter.
- Cut the stacking tray spacer E2-3906 to length of sill starter BE9-3864.
- Cut the stacking tray gasket to E2-7004 to length of sill starter except at the jamb, where it is to be extended 3" beyond the length of the sill starter.

See **Detail 41**.



Detail 41



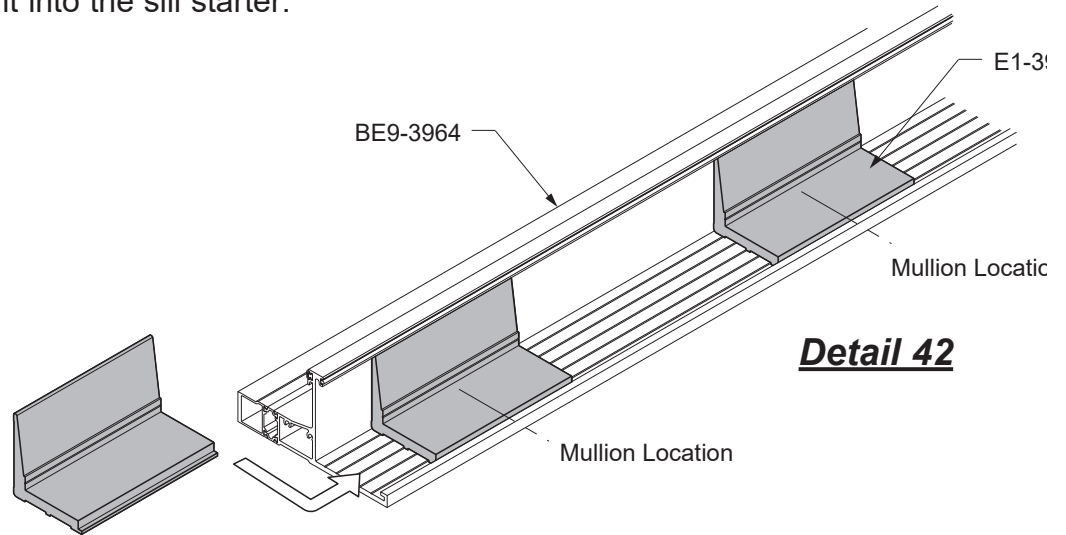
After Sill Starter Installation

SILL STARTER ASSEMBLY

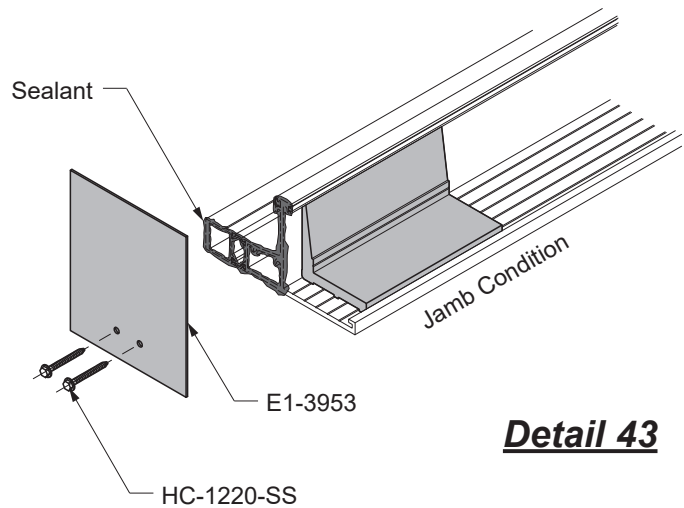
**STEP 20 (Continued)
ASSEMBLE SILL STARTER**

Starter sill reinforcement (E1-3954) is to be located at each mullion location.
-Slide the sill reinforcement into the sill starter.

See **Detail 42**.



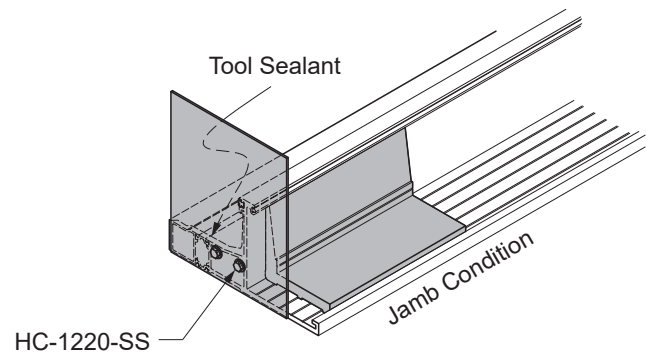
Detail 42



Detail 43

-Apply sealant to the end of the sill starter at the jamb condition.
-Attach the end dam E1-3953 to the sill starter at the jamb using (2) HC-1220-SS fasteners.

See **Detail 43**.





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