VINYL WINDOWS AND DOORS

Manufactured by Pella Corporation

SLIDING PATIO DOOR, SIDELIGHT, & TRANSOM INSTALLATION INSTRUCTION FOR MULLION

IMPORTANT: Read this entire instruction prior to attempting the process.

REMEMBER TO USE APPROPRIATE PERSONAL PROTECTIVE EQUIPMENT

The processes described in this instruction were developed and tested for use with vinyl window or door combinations using 1/2" mullion covers based on the following parameters. Mulling products together that fall outside these parameters will void the Limited Warranty. Determining the appropriate mulling process is the responsibility of you, your architect, or building professional.

PARAMETERS:

- Only 2 panel welded frame doors are to be mulled.3 and 4 panel welded frame and Knockdown doors are not to be mulled.
- Only mull sidelights and transoms to vinyl sliding patio door.
- Mull has to be width or height of the product.
- Only 2-way joints, no 3-way or 4-way joints.
- Nail fin, Block Frame, and J-Channel can be mulled. Dual wall flush flange and 5/8 Flange cannot be mulled.
- The length of any mullion may not exceed 96".
- It is not recommended to install mullions in temperatures less than 60° F which can cause damage to the mullion.
- Horizontal and vertical mullions are not permitted in the same combination.
- Mullions must be reinforced with a minimum 1/4" x 4-3/4" 6061-T6 aluminum flat bar reinforcement.
- Patio door sidelights may not be mulled to the lock side jamb of a patio door and must be mulled to the fixed side jamb only.

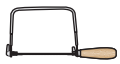
YOU WILL NEED TO SUPPLY:

- High quality exterior grade polyurethane or silicone sealant 

Additional tools for reinforced application:

- 3/16" Drill bit
- #2 Phillips screwdriver 

TOOLS REQUIRED:

- Tape measure 
- Sealant gun 
- Utility knife 
- Rubber mallet 
- 1" wide wood chisel
- Pliers 
- 3/8" Drill bit
- Drill guide for 3/8" bit 
- Drill 
- Coping Saw 

1 Preparing Doors, Sidelights & Transoms for Mulling:





NOTE: Before starting, verify the products when mulled together will fit the rough opening.

A. **Determine which surfaces of the products will be mulled together.**

B. **Remove the nail fin from the surfaces to be mulled.** Lay the products, exterior surface down on a firm, clean flat surface.

C. **Using a utility knife, score the fin 3 times** at the point where the fin meets the frame. Be careful not to gouge frame.

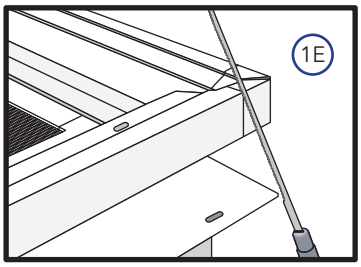
D. **Bend the fin back and forth** 2 to 3 times, and peel it off the unit.

If the product does not have J-mould proceed to Step 1H.

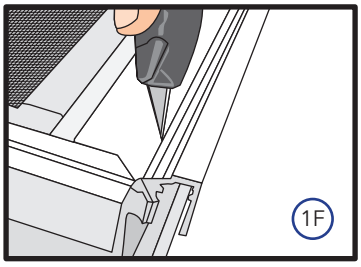
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1 Preparing Windows for Mulling (continued):

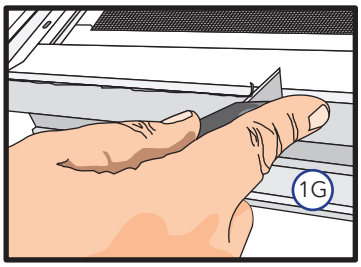
E. **Remove the J-mould (if applicable)** from the surfaces that will be mulled together. Lay the product (with the interior surface down) on a smooth clean surface. Using a coping saw, make a horizontal and a vertical cut that align with the point where the J-mould meets the exterior face of the product. Cut until the blade reaches the point where the vertical and horizontal J-mould meet. Bend and remove the cut out section of the J-mould corner.



F. **Using a utility knife, score (3 times) the point where the J-mould attaches to the exterior face of the product.** Beginning at one end of the J-mould, grasp the J-mould with pliers and bend the J-mould toward the interior of the product. Continue along the entire length of the product until the J-mould is removed from the product.



G. **Using a utility knife, cut off any excess material** that does not break off the accessory groove.



H. **Position the door and sidelight or transom as they will be assembled** with the exterior side up.

NOTE: A sidelight will always go on the side opposite the door latch.



I. **Horizontal Mullions Only:** Drill 3/8" diameter, 1/4" deep weep holes into the top of the bottom window or door. Drill holes 6" from each end of the product, and 1" from the exterior edge of the product. If the mullion width of the unit is greater than 69", drill an additional weep hole at the mid point of the lower product, 1" from the exterior of the product.

NOTE: A drill guide set at 1/4" is recommended to prevent drilling through the second wall of vinyl.



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2 Install Mullion Reinforcement:

A. **Prep the mull bar** (if only clean with Isopropyl alcohol).

B. **Pre-drill 3/16" holes in the mullion reinforcement** spaced 10" on center, the entire length of the reinforcement. The holes should be centered across the width of the reinforcement.

C. **Position 3/8" flat washers over the holes** on the door/lower unit side of the mull bar and tape in place.

D. **Attach the reinforcement** to one of the products to be mulled, for horizontal mullions, attach the reinforcement to the top of the bottom product.

   Position the mull bar against the door/lower unit so the holes in the mull bar are closer to the interior of the unit and the mull bar is 3/4" from each end.

   Use #8 x 3/4" screws (provided) and place flat washers (provided) between the product and the reinforcement.



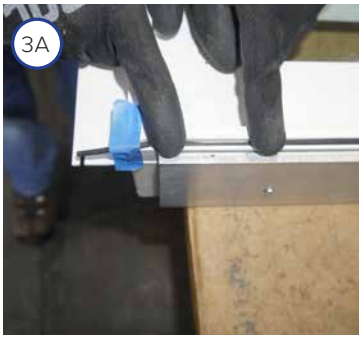


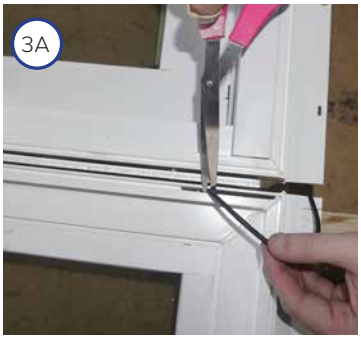
3 Install the Exterior Mullion Cover:

Two or more people will be required for the following steps.

A. **Install the round foam weatherstrip into the accessory groove** on both sides of the mull, with the products interior side down on a smooth clean surface.

NOTE: Door transoms have weep slots in the accessory groove. Cut the foam weatherstrip to leave the weep slots open. Notch the mullion cover to match the weep slot location to allow the top product to weep.





B. **Seal across the mull cavity** as shown equal to the height of the sill on the interior side of the mull prior to installing the interior mull cover.



3 Install the Exterior Mullion Cover (continued):

C. **Lay the mullion cover over the mullion joint,** beginning 6" from one end, drive the legs of the mullion cover into the accessory grooves of the products.



D. **At each end of the mullion joint, insert a foam backer plug** (included) into the 1/2" space. The plugs should be set approximately 3/8" from the end of the mullion joint.



E. **Seal the ends of the mullion joint** using high quality exterior grade polyurethane or silicone sealant.

Horizontal Mullions: Ensure both ends of the mullion joint are sealed, including the notched ends of the mullion.

Vertical Mullions: Ensure the top end of the mullion is completely sealed, including the notched ends of the mullion. When sealing the bottom end of the mullion, leave a 1/4" gap toward the exterior of the window to act as a weep for the mullion joint.



NOTE: On products without nail fins, fill top and bottom end of the mullion joint completely. Drill a 1/4" diameter weep hole 1-1/2" from the bottom of the mullion cover.

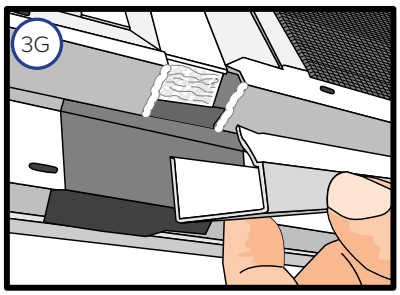
F. **Cover the mullion joint and the gap in the fin** with a piece of flashing tape (provided).

Vertical mullion joints: Begin 1/8" on the interior face of the product, cover top of the product to the inside surface of the fin, cover the interior and exterior of the fin. Cut the tape at the base of the exterior face of the fin.

Products with no fin: Begin 1/8" on the interior face of the product, cover the complete mullion joint and end 1/8" on the exterior face of the window.



G. **J-mould products:** Install the J-mould joint cover (provided). Place a small bead of sealant on each cut edge of the J-mould. Snap the joint cover into position.



H. **Screw truss plate centered to both sides of unit** using #8 x 3/8" screws. 4 screws on each side of mull.

For vertical mulls screw truss plate centered to the head using #8 x 3/8" screws. Fasten the truss plate centered to the sill with VHB tape (do not use screws at the sill).



I. **Carefully flip the products over** so the interior side is up.

4 Install the Interior Mullion Cover:

A. **Install the round foam weatherstrip** into the accessory groove on both sides of the mull.

B. **Apply a 4" long bead of sealant on top of the foam weatherstrip** at the top and bottom of each accessory groove.



C. **Beginning 6" from one end,** use a rubber mallet to drive the legs of the mullion cover into the accessory grooves of the windows.

NOTE: Beginning too close to the end may cause damage to the accessory groove.



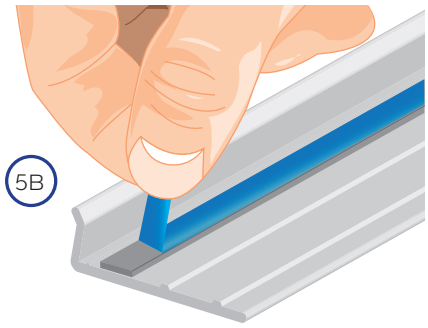
5 Head Drip Installation:

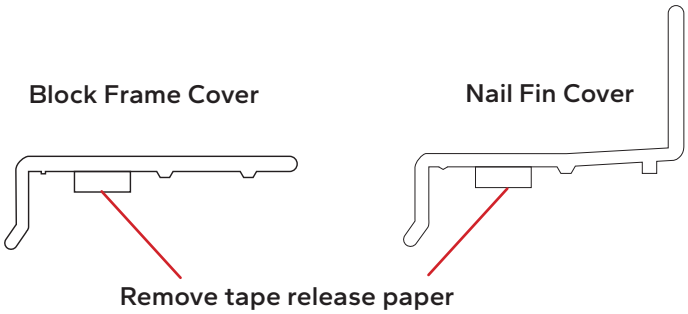
A. **Prior to applying head drip cover,** apply a continuous 1/4" bead of sealant across the head of the combination on the exterior side.



5 Head Drip Installation (continued):

B. **Prior to installing the head drip cover,** peel release liner from tape before placing drip cover on head.





C. **Align the head drip on the head of the combination.**



D. **Press the head drip onto the head** along the entire length to get proper seal.

Proceed to install the products according to the installation instructions provided with the product.