Field 1/2” Aluminum Reinforced Mullion Assembly of Aluminum-Clad Wood Transom Window to Sliding Patio Doors

IMPORTANT **Determining and meeting the structural load requirements and design of the rough opening is the responsibility of the architect, engineer, and/or contractor. Windows, doors, and/or mullions are not designed to support additional elements or components of the building wall system. Refer to published technical recommendations for window and door combinations or your local distributor for more information. For applicable warranty and arbitration information, please refer to the product website. Field combinations not in accordance with the following parameters and/or the technical recommendations will void warranty.**

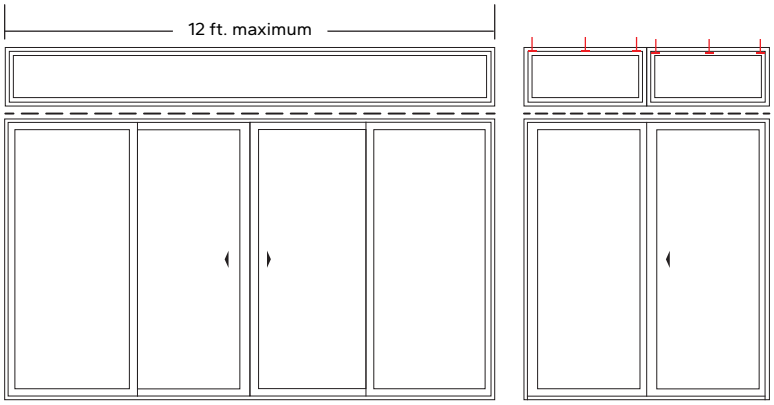
Parameters:

- 1/2” reinforced mull span limitation for two-way mulls is 12 ft
- Three-way mullions with transoms over venting doors must be checked for dead load. Transom frame may require anchors through frame to opening header structure to carry the weight of the transom windows.
- Openings exceeding 10 ft are recommended to utilize 1/2” perimeter rough opening installation clearances.
- Ensure the 1/2” mullion has been validated for resistance to wind load.

WARNING **Window combinations can be extremely heavy. Installation will require (2) or more persons for safety reasons.**

Remember to use personal protective equipment.

Read the entire instruction before proceeding.



Two-way Door Transom

Three-way Door Transom
Consider Deadload

You Will Need to Supply:



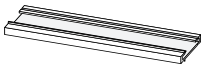
- Cedar or impervious shims/spacers



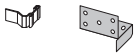
- Foil backed butyl window and door flashing tape or equivalent
- High quality exterior grade polyurethane or silicone sealant



- 1/2” mullion reinforcement – #0A6G or #0A6K



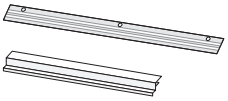
- Mullion end splice – #72WQ
- Mullion anchor brackets – #512D or #000F



- Nailing fins – #42G7 (if applicable)
- Fin corners – #751Q



- Head drip cap - #72WA



- Interior mull cover tape (0.5” wide x 0.062” thick)
- #8 x 1-1/2” pan head screws

Tools Required:



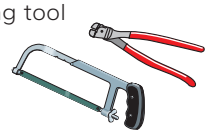
- Tape measure



- Utility knife



- Hammer or rubber mallet
- Wood block
- Corner notching tool or hacksaw



- Pliers

Mullion Covers:

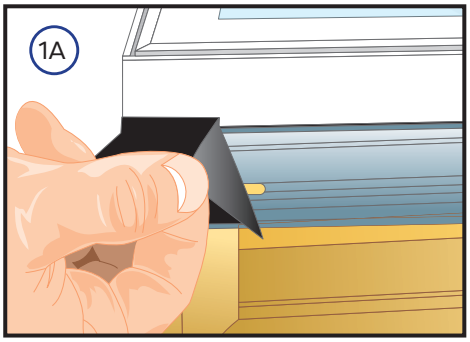
- Exterior 1/2” mull cover #736M
- Interior mull cover options:
  1-1/2” mull cover #260D
  or 1/2” mull cover #260A

1 Removing the Installation Fin:

Note: For mullion transom to transom intermediate mullions (if applicable), refer to the field mullion instructions for mulling window to window. If transom and door do not have fins, proceed to step 2.
For combination assembled in opening option, proceed to the last page.

A. **Remove the flexible fin corners from the joining sides of the products to be mulled together**.

Note: You will remove two fin corners per product.

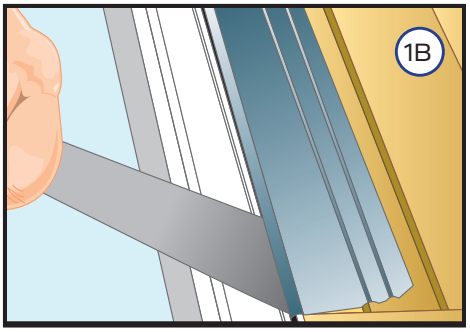


Transom/window shown; removing nail fin from sliding door frames is similar.

1 Removing the Installation Fin (continued):

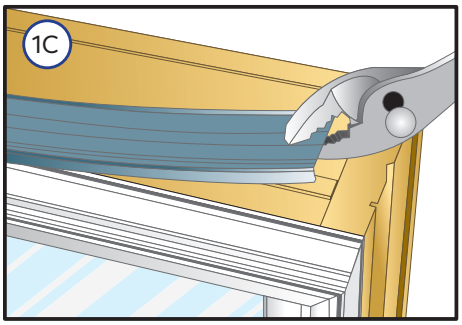
B. **Place the flat end of a pry bar against the front edge of the fin**. Strike the pry bar with a hammer and pry up.

Note: Remove only the fin from the surfaces to be mulled.



C. **Grasp the end of the fin with pliers or vise grips and pull up on the end of the fin**. Continue pulling up along the full length of the fin until it is completely removed from the product.

Note: If using wood blocking as reinforcement, proceed to Step 3.

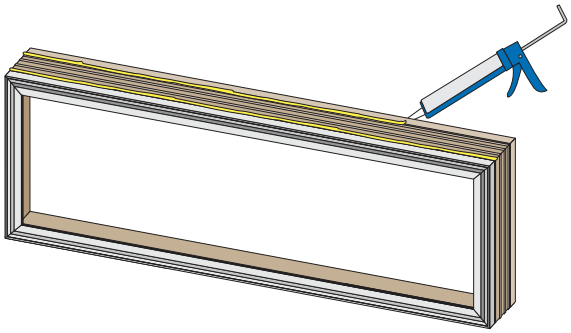


2 Mulling Intermediate Combinations using 1/2" Mullion Reinforcement:

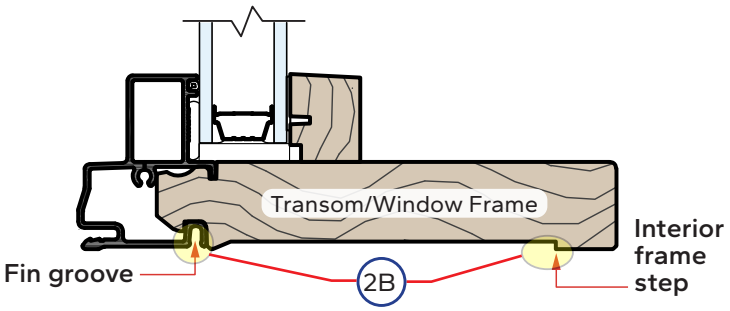
Note: Position units exterior facing up. Consider using cardboard or other material to protect the interior finish of the transom and door frame.

A. **Cut a piece of mullion reinforcement 1/2" shorter than the transom or window**.

B. **Place a 3/8" continuous bead of sealant down the fin groove and interior frame step** of the transom or window.



REFERENCE POINTS
Mullion Reinforcement

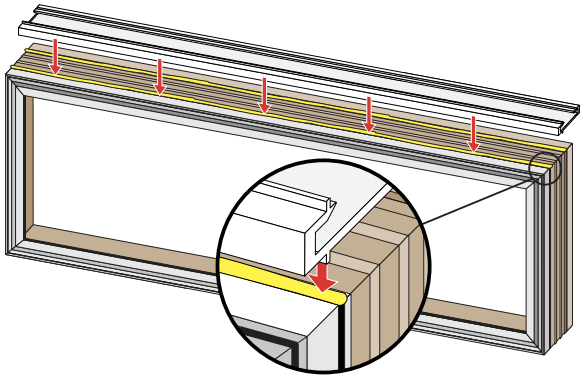




2 Mulling Intermediate Combinations using 1/2” Mullion Reinforcement (continued):

C. **Position the mullion reinforcement as shown in the REFERENCE POINTS**; center on the transom or window and press the leg into the fin groove.

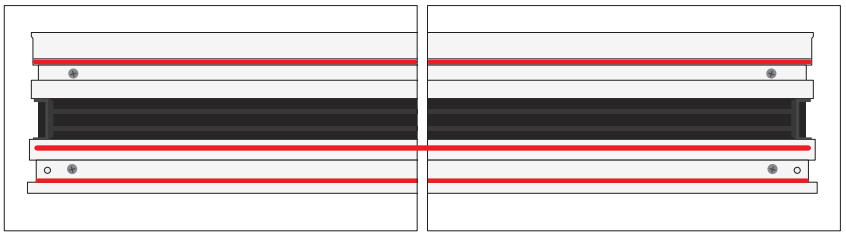
Note: A space of 1/4" from the edge of the transom to the end of the mullion reinforcement is required to allow for fin placement.

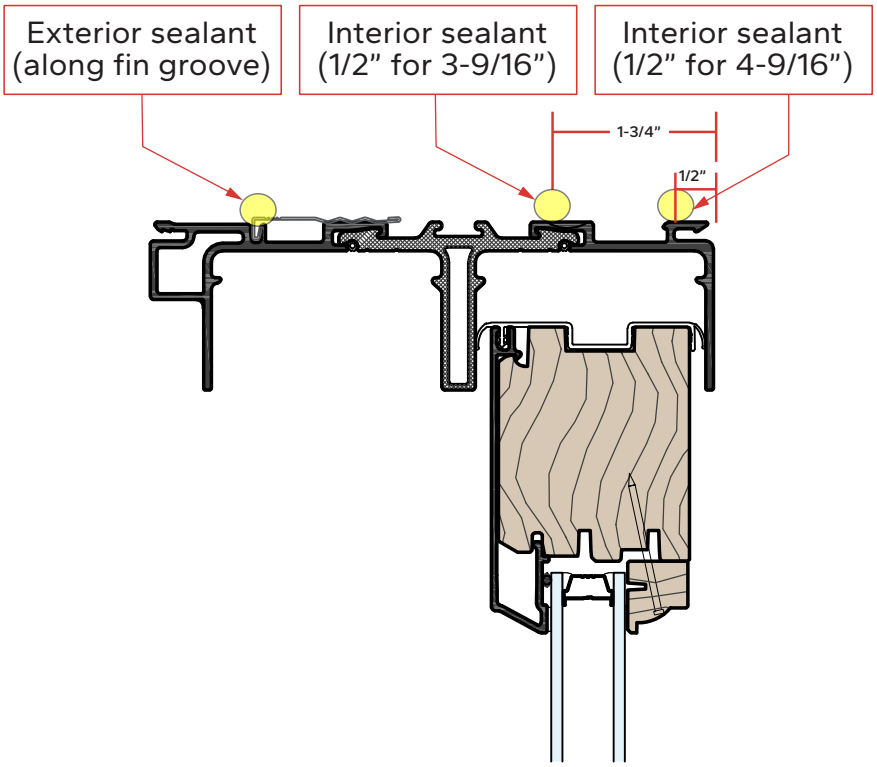


D. **On the edge of the sliding door frame to which the transom/or window will be mulled,** place a 3/8” bead of sealant along the fin groove from end to end.

For 1/2” mullion for 3-9/16” (#0A6G), place an interior bead approximately 1-3/4” from interior side of the door frame.

For 1/2” mullion for 4-9/16” (#0A6K), place an additional bead approximately 1/2” from the interior side of the door frame.



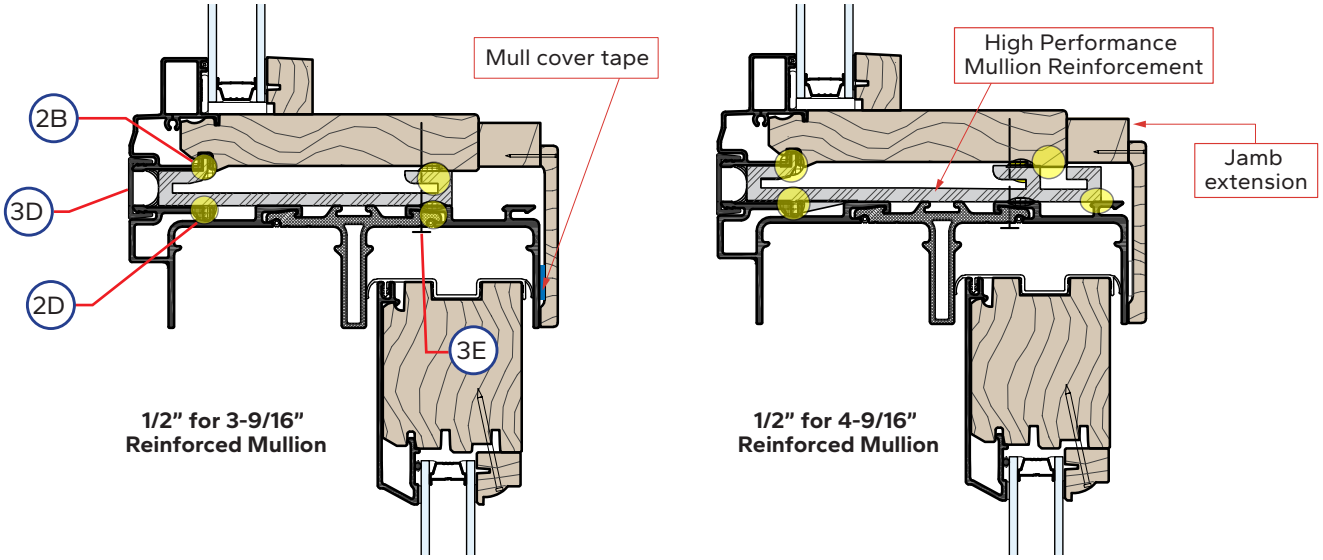


3 Mulling Products Together

Note: Knock down frame assemblies must be assembled prior to performing mullion steps.

A. **Position the transom/window with the mullion reinforcement onto the sliding door**. Align the leg on the mullion reinforcement with the fin groove of the sliding door and press into place.

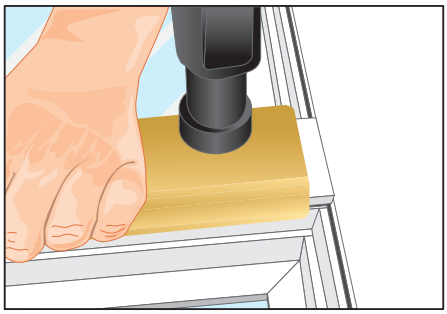
Note: Removing the door panels will lighten the door and make assembling out of the opening easier. It will also allow access to drive the screws indicated in step 3E. Vent panels shown for reference only.



B. **Align the two products and squeeze or clamp tightly together.**

C. **Measure the frame dimension of the surface to be mulled when using lineal mullion covers.** Using a hacksaw, cut the Mullion covers 3/8" shorter than the frame dimension.

D. **Insert the end of the exterior mullion cover into the accessory groove of both products.** Drive the mullion cover into position with a rubber mallet or a rounded block of wood and a hammer.

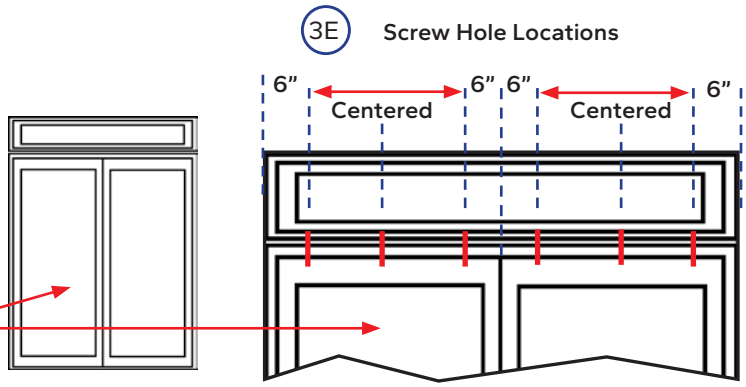


Note: Placing shims or wedges under the outer edges of the products will help bring the mullion grooves together.

E. **Attach the units together on the interior using #8 x 1-1/2" pan head screws**.

Drill 5/32" pilot holes above the vent panel at the frame groove line indicated for each screw hole location. Drill through the fiberglass and aluminum. DO NOT drill into the transom wood.

Note: Vent and Fixed panels will not be installed yet.



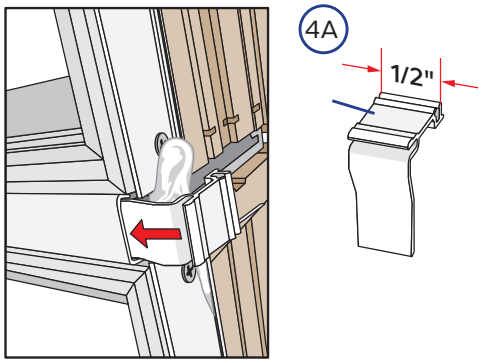
4 Completing the Combination Assembly:

A. **Cut a 1/2" piece of mullion end splice** for each horizontal and the bottom of each vertical mullion joint.

B. **Fill the end of the mullion joints with sealant and attach the mullion end splices,** lined up with the adjacent windows.

C. **Install continuous nailing fins around the combination** (if applicable).

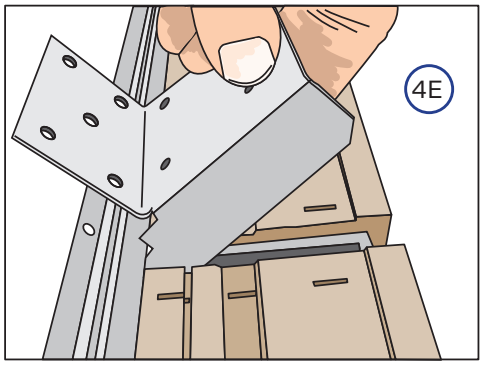
D. **Attach the fin corners** (if applicable).



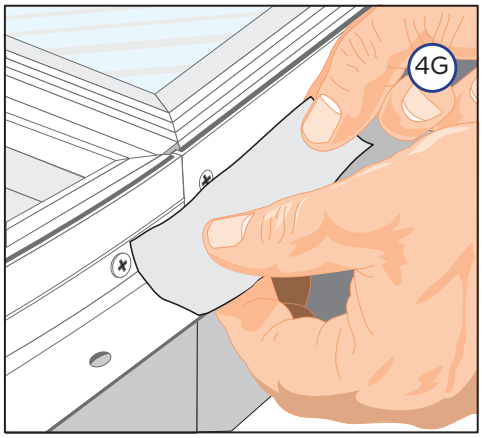
E. **Fold out the installation fins of the transom** and the sliding patio door to at least 90 degrees.

F. **Insert the mullion end anchor brackets**.

Note: Do not attach the mullion anchor bracket with screws at this time.



G. **Cut two 6" long pieces of flashing tape.** Remove the paper backing and apply the flashing tape over the gaps between the fins on both sides of the combination assembly.



5 Combination Installation:

A. **Install the combination** as described in the installation instructions.

B. **Trim and install interior mull covers** after applying mullion cover tape and any jamb extensions after application of other interior trim materials.

Field Mullion Assembly Within-the-Opening Option:

Note: This option may helpful when there is limited job site space available to assemble combinations out of the opening. This options requires sufficient rough opening head clearances to allow room for the transom window to be inserted above the door, after the door is set within the opening.

A. **Install the door frame including the fixed panel(s).** Refer to other applicable door installation instructions. Do not complete steps indicated for anchoring components in the head of the door that require longer screws. Complete steps necessary to anchor door jambs to each opening side.

B. **Cut the 1/2" mullion reinforcement 1/2" short of the door frame width** as indicated in 2A above.

C. **Place two 3/8" beads of sealant** on the door head as indicated in step 2D above.

D. **Insert the mull end anchor brackets into each end of the 1/2" mull reinforcement** (4F) and place the 1/2" reinforcement on the door head, aligning as shown in the Reference Points diagram in Step 2 or as indicate in the cross sections in Step 3.

Note: Center the 1/2" mull reinforcement by leaving a 1/4" space on each side to allow room for the end splices to be inserted.

E. **Place two 3/8" beads of sealant** on the top of the 1/2" mull reinforcement as indicated in steps 2B above.

F. **Insert transom window into the opening above the door** and set the transom on the 1/2" mull reinforcement and sealant. Align and squeeze or clamp the assembly together.

Note: If sealant was damaged during placement of the transom, add sealant after alignment is complete.

G. **Cut two 1/2" pieces of mullion end splice.** Inject sealant and insert as indicated in steps 4A and 4B above.

H. **Apply the 1/2" exterior mull cover** in accordance with steps 3C and 3D above.

I. **Drive the #8 x 1-1/2" screws as indicated** in step 3E above. Also complete the remaining anchor steps necessary in the door installation instructions.

J. **Finish installing and anchoring the combination** by driving anchors into the mull end anchor brackets, fastening the nail fins, and applying flashing tape to integrate with the wall systems weather resistive barrier.

