Mullion Assembly of Clad and Wood Products

INSTALLATION INSTRUCTIONS

IMPORTANT **Read thoroughly before beginning. Failure to install as recommended will void any warranty, expressed or implied.**

You Will Need to Supply:

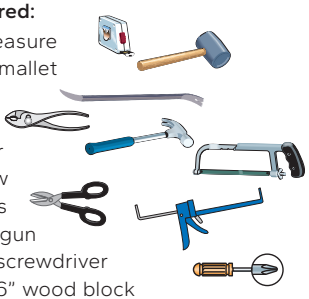
- Installation Fin
- Corrugated fasteners 
- Mullion plugs (2)
- Head sealant tape 
- SmartFlash™ foil backed butyl window and door flashing tape or equivalent 
- Window and Door Installation Sealant or equivalent high quality, multi-purpose sealant
- Fin corner (4)
- 6-1/2" x 1-5/8" Gusset plate (2)



Note: Quantities listed are for completing one mullion joint.

Tools Required:

- Tape measure
- Rubber mallet
- Pry bar
- Pliers
- Hammer
- Hacksaw
- Tin snips
- Sealant gun
- Phillips screwdriver
- 1-1/2" x 6" wood block with rounded edges



REMEMBER TO USE APPROPRIATE PERSONAL PROTECTIVE EQUIPMENT.

Note: If the products to be mulled have fins on the surfaces to be mulled, they must be removed prior to mulling products together.

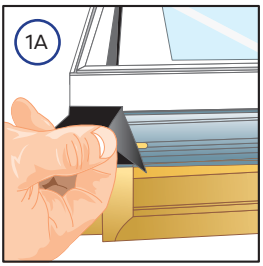
Note: For instructions on mulling Circleheads to rectangular units, proceed to Step 6.

Note: For mulling wood exterior frame units go to step 2C.

1 Removing the Installation Fin:

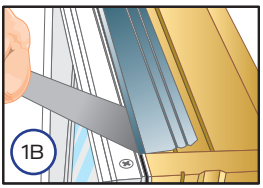
A. **Remove the flexible fin corners** from the joining sides of the products to be mulled together.

Note: You will remove two fin corners per product.

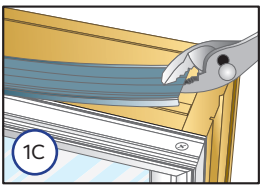


B. **Place the flat end of a pry bar against the front edge of the fin.** Strike the pry bar with a hammer and pry up.

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

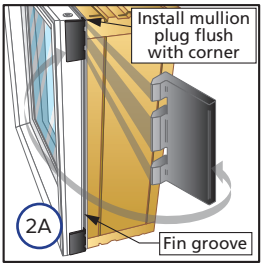


C. **Grasp the end of the fin with pliers or vise grips and pull up** on the end of the fin. Continue pulling up along the full length of the fin until it is completely removed from the product.



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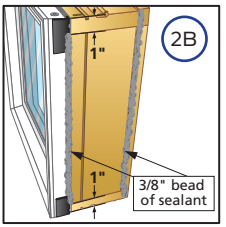
2 Installing the Mullion Plugs:



A. **Insert two mullion plugs** into one of the two products. Place the legs of the plugs into the fin groove, ensuring the plugs are flush with the corners of the frame at both ends.

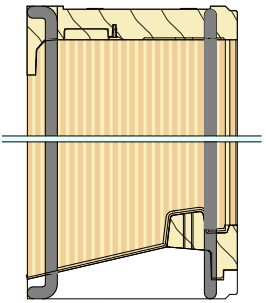
CLAD EXTERIOR UNITS:

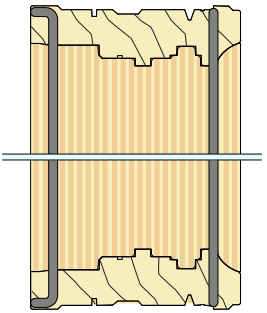
B. **Place a 3/8" bead of sealant** beginning on the mullion plug and 1" down from the corner of the frame. Continue along the fin groove to the plug on the opposite corner of the product, stopping 1" from the corner of the frame. Place a 2nd 3/8" bead of sealant 9/16" from the interior running bead from end to end.



WOOD EXTERIOR UNITS:

C. **Place a 3/8" bead of sealant from end to end as shown.** Place a 2nd 3/8" bead of sealant 9/16" from the interior running bead from end to end.





3 Mulling the Products Together:

CLAD EXTERIOR UNITS:

A. **Place the products,** exterior (clad) side up on a clean flat surface.

WOOD EXTERIOR UNITS:

Place units interior side up on a clean flat surface.

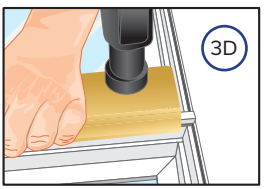
B. **Align the two products** and squeeze or clamp tightly together.

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

WOOD EXTERIOR UNITS: Go to step 3E.

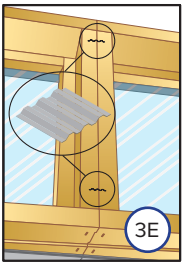
C. **Measure the frame dimension** of the surface to be mulled when using lineal mullion covers. Using a hacksaw, cut the mullion covers 3/8" shorter than the frame dimension.

D. **Insert the end of the exterior mullion cover** into the accessory groove of both products. Tap the end into the groove with a rubber mallet. Drive the mullion cover into position with a rubber mallet or a rounded wood block and hammer. Turn the products over carefully, making sure they stay together.



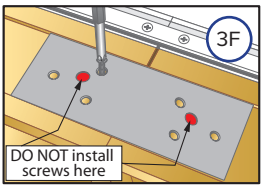
3 Mulling the Products Together (continued):

E. **Install the corrugated fasteners** on the interior beginning 2" from each end. Install additional corrugated fasteners not more than 12" on center.



F. **Attach a gusset plate at the end of each mullion joint.** Secure in place using six #8 x 1/2" flat head wood screws for each gusset plate.

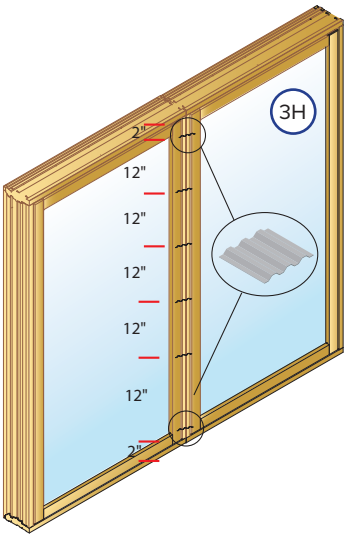
Note: DO NOT install screws in the holes indicated on the illustration.

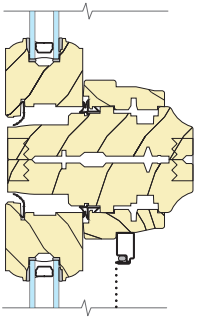


WOOD EXTERIOR UNITS:

G. **Carefully turn the units over** so the exterior side is up, making sure they stay together. Use clamps as needed to bring the units together.

H. **Install the corrugated fasteners on the exterior** beginning 2" from each end. Install additional corrugated fasteners not more than 12" on center making sure they stay together.





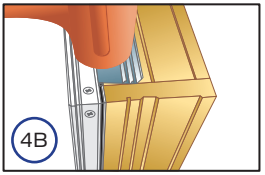
Note: After exterior brickmould or casing is applied to the combination, attach the exterior mullion cover(s). Apply sealant at each end of the mullion covers prior to painting.

STEPS 4 & 5 APPLY TO CLAD EXTERIOR UNITS ONLY.

4 Attaching New Installation Fins:

A. **Measure the frame dimension** of the surface accepting the new installation fin. Cut the fin 1-1/4" shorter than the frame dimension.

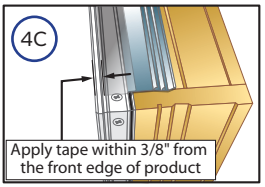
B. **Beginning 5/8" from one end,** insert the fin into the fin groove and tap into place using a rubber mallet.



C. **Using 1-1/2" head sealant tape,** apply within 3/8" from the front edge of the product, over the fin groove and lapping the tape onto the fin.

Note: The tape should cover the entire length of the fin.

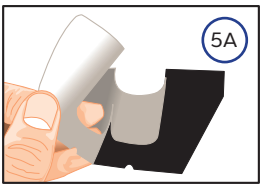
D. **Press the tape down firmly** over the entire surface to activate the adhesive and ensure a good seal.

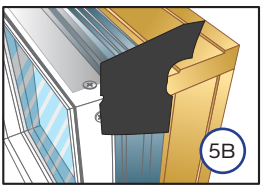


5 Installing the Fin Corners:

A. **Remove the outer portion of the backing** from a new fin corner by pulling on the tab at the corners.

B. **Line up the front edge of the fin corner** with the center of the corner lock screws and the front locating notch with the corner of the product frame.

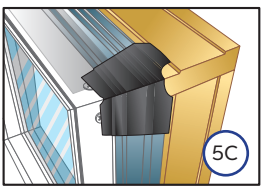




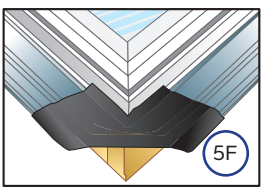
C. **Fold the fin corner over the corner of the product** and rub firmly over the entire surface to activate the adhesive and ensure a good seal.

D. **Lift the installation fin** just enough to fold under and adhere the tab of the fin corner to the back of the installation fin.

E. **Repeat Steps A thru D** for the opposite corner of the product.



F. **When ready to install,** fold out the fin, stretching the fin corner.

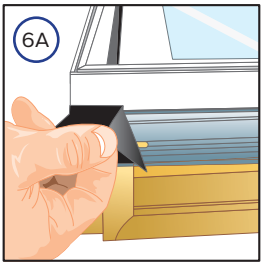


6 Mulling a Clad Exterior Circlehead Over Clad Exterior Window(s):

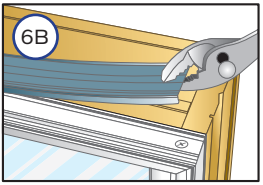
Note: For mulling wood exterior circlehead over wood exterior windows go to Step 7.

A. **Remove the flexible fin corners from the top** of the lower window to be mulled together.

Note: You will remove two fin corners per window.

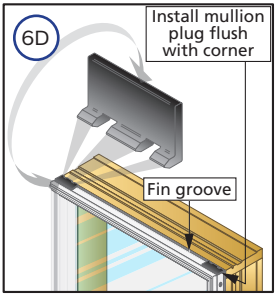


B. R**emove the fold out fin from the top** of the lower window.



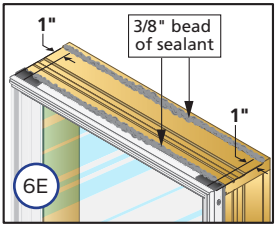
C. **Remove the fold out fin from the sill** of the Circlehead.

D. **Insert two mullion plugs** into one of the two products. Place the legs of the plugs into the fin groove, ensuring the plugs are flush with the corners of the frame at both ends.



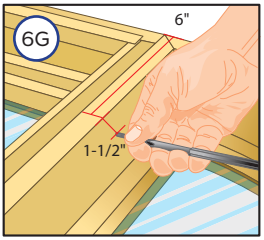
E. **Place a 3/8" bead of sealant** beginning on the mullion plug and 1" down from the corner of the frame. Continue along the fin groove to the plug on the opposite corner of the product, stopping 1" from the corner of the frame. Place a 2nd 3/8" bead of sealant 9/16" from the interior running bead from end to end.

F. **With the wood side up,** position the windows together on a clean flat surface. Align the two products and squeeze or clamp tightly together.



G. **Secure the interior of the windows** with #8 x 1-1/4" flat head corrosion resistant screws. Drill two 3/32" pilot holes, 1-1/2" from the interior edge and 6" from each side of the frame of the Circlehead.

Note: Take care not to drill into the window below the Circlehead.



H. **Install two of the five screws at the pilot locations.** Install the remaining screws evenly spaced between the two pilot locations. Turn the window over carefully, making sure the windows stay together.

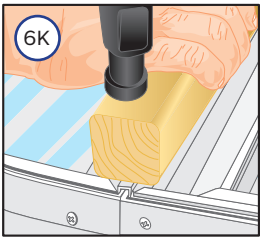
6 Mulling a Clad Exterior Circlehead Over Clad Exterior Window(s) (continued):

I. **Using a hacksaw,** cut the exterior mullion cover 3/8" less than the frame width of the combination assembly.

J. **Center the exterior mullion cover over the mullion joint,** making sure the legs of the mullion cover line up with the accessory grooves of the products.

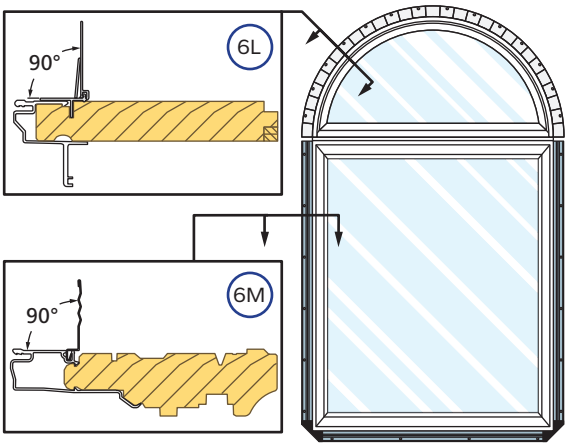
K. **Drive the legs of the mullion cover into the accessory grooves** of the products using a rubber mallet or hammer with a rounded edge wood block.

Note: Rounding the edge of the wood block will help prevent damage to the mullion cover.

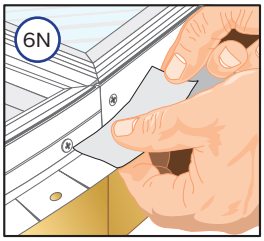


L. **Fold out the Circlehead flexible fin** until it snaps into position.

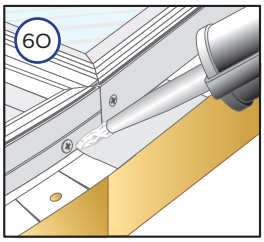
M. **Fold out the installation fins of the lower window** to at least 90 degrees, aligning with the Circlehead flexible fin.



N. **Cut two 1-3/8" long pieces of flashing tape.** Remove the paper backing and apply the flashing tape over the gaps between the Circlehead flexible fin and the rectangular window fins on both sides of the combination assembly.



O. **Apply a 3/8" diameter bead of sealant** between the flashing tape and the edge of the window as shown.

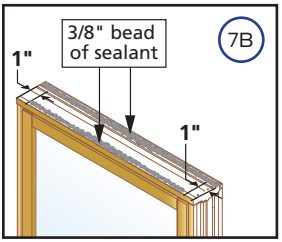


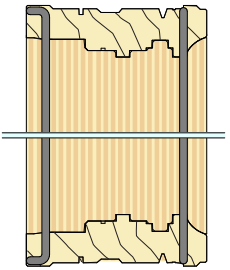
P. **Install the windows as described** in the installation instructions. Save the wood interior mullion cover for later use when trimming out the windows.

7 Mulling a Wood Exterior Circlehead Over Wood Exterior Window(s):

A. **With the interior side up,** position the windows together on a clean flat surface. Align the two products and squeeze or clamp tightly together.

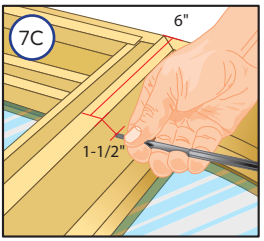
B. **Place a 3/8" bead of sealant from end to end as shown.** Place a 2nd 3/8" bead of sealant 9/16" from the interior running bead from end to end.





C. **Secure the interior of the windows** with #8 x 1-1/4" flat head corrosion resistant screws. Drill two 3/32" pilot holes, 1-1/2" from the interior edge and 6" from each side of the frame of the Circlehead.

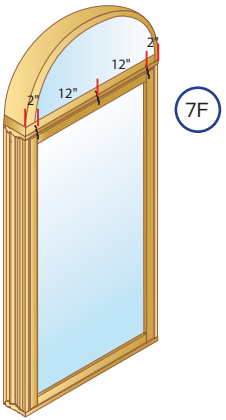
Note: Take care not to drill into the window below the Circlehead.

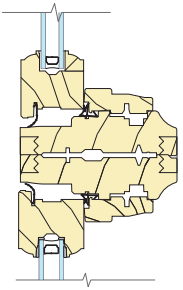


D. **Install two of the five screws at the pilot locations.** Install the remaining screws evenly spaced between the two pilot locations. Turn the window over carefully, making sure the windows stay together.

E. **Carefully turn the units over** so the exterior side is up, making sure they stay together. Use clamps as needed to bring the units together.

F. **Install the corrugated fasteners on the exterior** beginning 2" from each end. Install additional corrugated fasteners not more than 12" on center making sure they stay together.





Note: After exterior brickmould or casing is applied to the combination, attach the exterior mullion cover(s). Apply sealant at each end of the mullion covers prior to painting.