# VINYL WINDOWS AND DOORS

Manufactured by Pella Corporation

# CLIP MULLION INSTALLATION INSTRUCTION FOR WINDOWS

**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 ThermaStar by Pella window or Pella® 150 Series window 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:**

- Do not mull more than 3 windows in one combination.
- It is not recommended to install mullions in temperatures less than 60° F.
- This kit is for vertical mullions only.
- The mulled product combination cannot exceed 50 square feet in rough opening area.
- The length of any mullion may not exceed 53.5".
- Single-Hung units can only be mulled to Single-Hung units, and Double-Hung units can only be mulled to double-Hung units.

**YOU WILL NEED THE FOLLOWING ITEMS:**

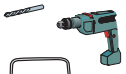
- High quality exterior grade polyurethane or silicone sealant 

- Mullion Kit

**Mullion Kit Contents:**

– 2" x 5/8" Backer Rod – Single Hung (Qty 2)
– 3" x 1" Backer Rod – Double Hung (Qty 2)
- 1/2" x 53.5" Mullion Cover (Qty 2)
– 1/8" x 53.5" Foam Weatherstrip (Qty 4)
– 7" Pella Flashing Tape (Qty 2)

**TOOLS REQUIRED:**

- Tape measure
- Sealant gun 
- Utility knife
- Rubber mallet 
- 1" wide wood chisel 
- 1/4" Drill bit
- Drill 
- Coping Saw 

## 1 PREPARING WINDOWS FOR MULLING

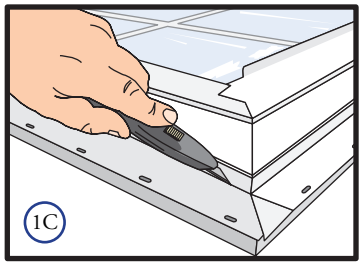
***NOTE: Before starting, verify the products when mulled together will fit the rough opening.***

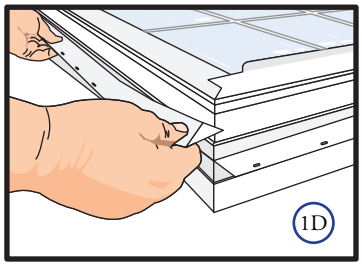
A. **Determine which surfaces of the products will be mulled together.**

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.




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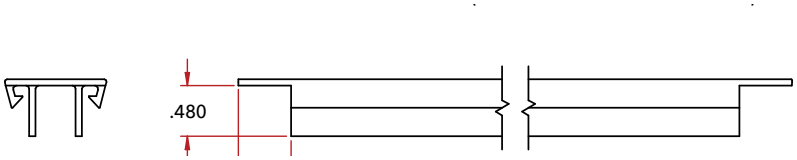
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# 2 PREPARING MULLION PARTS FOR MULLING (Cutting mull covers to Length)

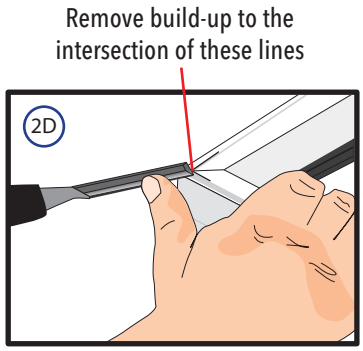
A **Measure frame height of windows to be mulled together.**

B. **Cut Mullion covers** to the length of the window Frame Height (measured in step 2A).

C. **Notch back the clip feature** on the back side of both Mull Covers on both ends. Notch should be 1/2" deep.




D. **Using a chisel, remove vinyl weld build-up** at the corners of the windows where the mullions will be applied.




# 3 INSTALL THE INTERIOR MULLION COVER

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

A. **Place the products exterior side down** on a smooth clean surface.

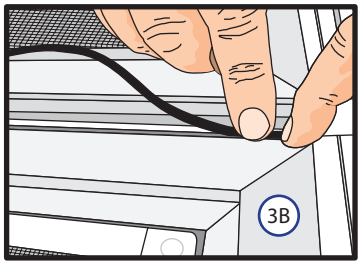
B. **Install the round foam weatherstrip** into the accessory groove of the surfaces to be mulled.

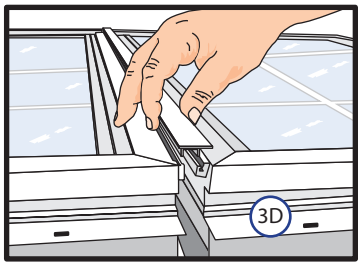
C. **Position the windows** approximately 1/2" apart and lay the mullion cover across the mullion joint.

D. **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.***

E. **Carefully flip the products over** while holding them approximately 1/2" apart.

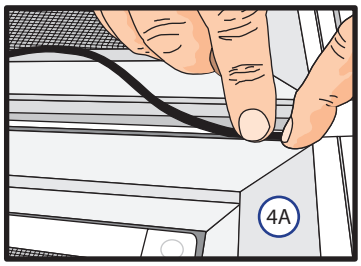


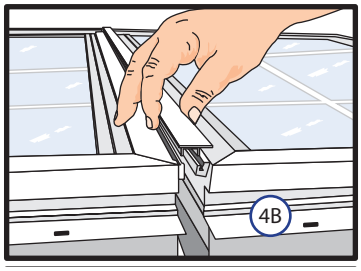




# 4 INSTALL THE EXTERIOR MULLION COVER

A. **Install the round foam weatherstrip** into the accessory groove of the surfaces to be mulled, with the products interior side down on a smooth clean surface.

B. **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.



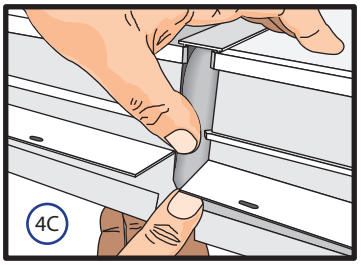

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# 4 INSTALL THE EXTERIOR MULLION COVER (continued)

C. **At each end of the mullion joint;** Apply high quality exterior grade polyurethane or silicone sealant and then, 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.

**For Single Hung units**, use the 5/8" diameter backer plug.

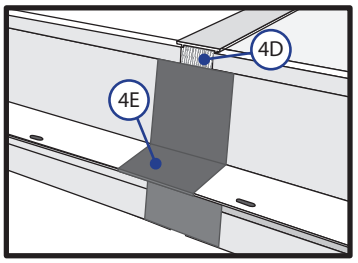
**For Double Hung units**, use the 1" diameter backer plug.

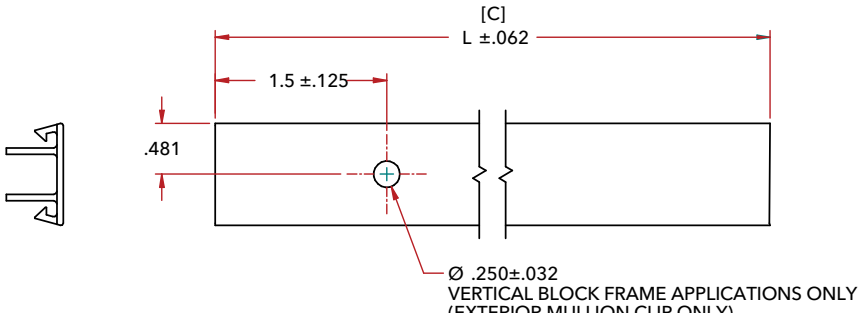



D. **Seal the ends of the mullion joint using high quality exterior grade polyurethane or silicone sealant.**

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.***




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

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.

**On 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.

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

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