Work Instructions

Glazing Frames in Doors

Purpose

This document outlines the procedure for glazing a standard or impact rated lite frame into a door - slab or sidelite. Applicable to all injection molded frames except Silhouette frame.

Responsibility Statement

It is the operator's responsibility to follow the instructions on this document while performing the procedure. The operator must also adhere to any and all safety guidelines noted throughout the process. Care must be given to the procedure in order to ensure accuracy of results as well as operator safety.

Safety



This Symbol indicates certain tasks within this procedure that involve critical safety precautions.

Personal Protective Equipment (PPE)

Protective Eyewear	
Steel toe work boots	

Preparation

Equipment:

Glazing table

Caulk gun (powered variable speed or manual)

Screw driver (powered variable speed/torque or manual)

Caulk

- Standard Product:
  a. Forbo 2H791: Decorative IGU & all shapes other than rectangles
  b. QSo 18 for Interior frame & QSo 101 for Exterior frame: Standard rectangle IGUs
- Impact Rated Product:
  a. Dow Corning 995 (white) for all frames

Cleaning solvent (denatured alcohol)

Clean rags

Door slab or sidelite

Lite frame assembly (standard/decorative IGU or impact/laminated IGU)

Rubber Mallet (For MXP and Craftsman frames)

Screws:

a. 8-10 X 1-1/2" #7 Phillips Pan Head Lo-Root for all frames except Flush-Glazed Craftsman

b. 8-10 X 1-1/8" #7 Phillips Pan Head Lo-Root for Flush-Glazed Craftsman

Procedure

1. Standard/Decorative IGU:

1.1. Clean door surface around cutout that will come in contact with frame and sealant.

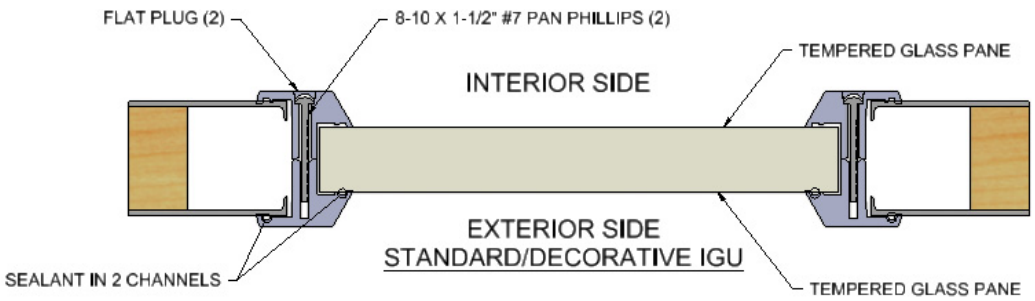
1.2. Place exterior frame with IGU on glazing table with show face against the table surface.

1.3. Place door over exterior frame so that exterior side is facing downward while aligning cutout so that the door surface fully seats on the frame lip for a tight seal.

1.4. Place interior frame in cutout while aligning screw bosses against the exterior frame.

1.5. Install and drive screws into mating screw boss to a torque of 13-15 in-lb for all frames except Heritage Craftsman frames. Install and drive screws into mating screw boss to a torque of 8-10 in-lb for Heritage Craftsman frames. DO NOT overtighten.

1.6. Install screw plugs on the interior frame in plug holes. Make sure to line up the texture on the plug with frame texture. For MXP, Flush-Glazed Craftsman, Lip Lite Craftsman and Heritage Craftsman Frames,



tapping screw plug inside plug hole on the frame with a rubber mallet is required to ensure proper fit.

2. Impact/Laminated IGU:

2.1. With a clean rag, clean exterior door surface with denatured alcohol around cutout that will come in contact with frame and sealant.

2.2. Place exterior frame on glazing table with show face against the table surface.

2.3. IGU will be sealed against exterior frame. With a clean rag, clean door side sealant channel of exterior frame with denatured alcohol prior to applying sealant.

2.4. After denatured alcohol dries, apply a continuous bead, about 3/16" diameter, of sealant required for that type of impact rated frame as specified in "Caulk" section above, on the door side frame lip using a caulking gun.

2.5. While sealant is still wet, place door over frame so that exterior side is facing downward while aligning cutout so that the door surface fully seats on the frame lip for a tight seal.

2.6. With a clean rag, clean both channels of interior frame with denatured alcohol prior to applying sealant.

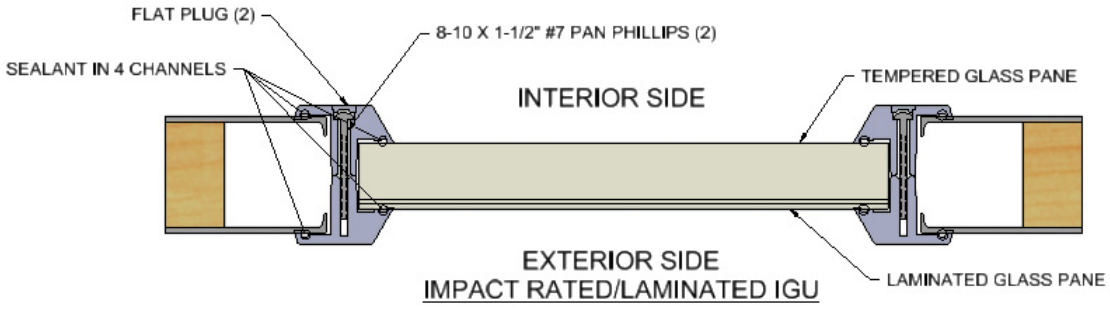
2.7. With a clean rag, clean interior door surface with denatured alcohol around cutout that will come in contact with frame and sealant. Also clean glass surface that will come in contact with frame and sealant.

2.8. Apply sealant required for that type of impact rated frame as specified in "Caulk" section above on IGU side frame lip and door side frame lip on interior frame using a caulking gun.

2.9. While sealant is still wet, place interior frame in cutout while aligning screw bosses against the exterior frame so that it fully seats on the frame lips for a tight seal.

2.10. Install and drive screws into mating screw boss to a torque of 13-15 in-lb for all impact rated frames except Heritage Craftsman frames. Install and drive screws into mating screw boss to a torque of 8-10 in-lb for impact rated Heritage Craftsman frames. DO NOT overtighten.

2.11. Install screw plugs on the interior frame in plug holes. Make sure to line up the texture on the plug with frame texture. For Heritage Craftsman Frames, tapping screw plug inside plug hole on the frame with a



rubber mallet is required to ensure proper fit.