ALUMINUM

Window Mulling Instructions (1/2” - 1” Steel Anchor System)

These instructions will cover the field mulling of windows that are reinforced with steel. See separate instructions for non-reinforced or 1/2” aluminum and steel reinforced mullions.

NOTES FOR INSTALLER

These instructions are a supplement to the window installation instructions. Prior to prepping the windows for field mulling, the wall rough opening must be properly prepared for the window to be installed.

Please read entire instruction completely before beginning.

Safety Alert Symbol Reference: These symbols are intended to alert you to potential injury hazards and information. Obey all safety messages.

COULD Result in: ⚠ WARNING — Major Injury/Death

COULD Result in: ⚠ CAUTION — Minor Injury

COULD Result in: NOTICE — Product or Property Damage

COULD Result in: IMPORTANT — Procedure and Product Info.

⚠ WARNING	⚠ CAUTION
Windows and doors can be extremely heavy. To avoid injury, use appropriate lifting techniques and an adequate number of people to carry and install the product. Mechanical lifting assistance may be needed for larger panels and glass. Failure to do so can result in injury or damage to product or property.	Always wear appropriate gloves and eye protection for all procedures. Follow manufacturers’ instructions for hand and power tools.

TOOLS AND MATERIALS NEEDED

Tools:

- Measuring tape
- Level (4’ minimum recommended)
- Hammer
- Phillips screwdriver
- Power driver
- 90 Degree Driver attachment
- 1/4” drill bit
- Caulk gun
- Pry bar
- Rubber Mallet
- Multiple Squeeze Clamps (medium to large)
- Utility Knife
- Metal Grinder or File
- Glass Cups
- Diluted denatured alcohol (60% alcohol/40% water)
- Paper towel and/or rags

Installation Materials (not included)

- Flashing tape (4” Minimum)
- Formable self-adhering sill flashing (or rigid pan)
- #8 x 2” flat head screws (or 2” Galvanized Roofing Nails)
- High-quality sealant
- Shims (moisture-proof)
- Low-expanding foam

Materials Included in the Job Box



- Through Frame Connectors
- 1/8” Hex Drive Bit for Connectors
- Drip Cap (vertical mulled units only)
- Mull covers
- Head & sill anchors with screws
- Loose exterior glazing beads
- 3” x 3” Self-adhering Flashing Tape Squares
- Tube(s) of Silicone Sealant (for mull connection not install)

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ALUMINUM

Window Mulling Instructions (1/2” - 1” Steel Anchor System)

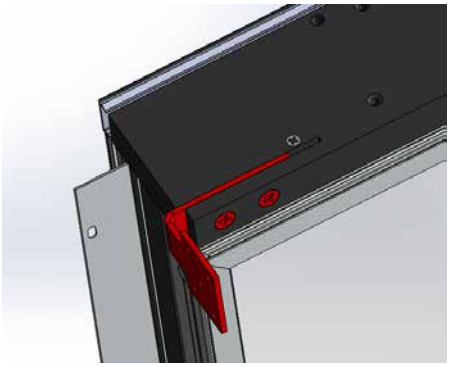
1 PREPARE FRAMES FOR MULLING



Windows prepared at the factory for field mulling will have the nail fins removed and structural reinforcements applied.

NOTE: If steel reinforcement is shipped separate and not pre-attached to one side of window or door, refer to the end of the instruction.

2 INSERT THE ANCHORS



The head and sill anchor legs are shipped loose. Insert each leg into the slot featured in the structural mullion bar. Once inserted, fasten the anchor strips with the provided screws but do not tighten completely. Allow room for the anchors to adjust as you install the frame into the opening.

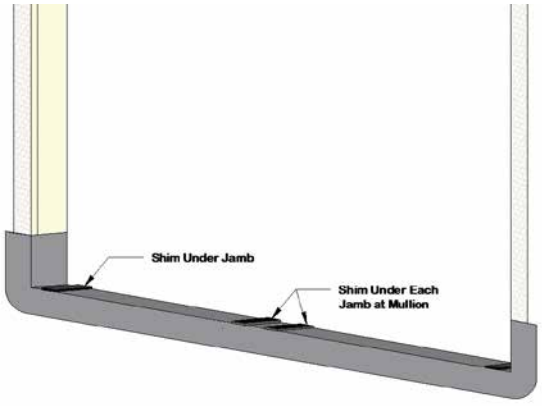
3 VERIFY ROUGH OPENING, DRY FIT THE UNIT



EXTERIOR

Verify the rough opening is correct, then dry fit the first frame to ensure your unit will fit into the opening properly. Start by tilting in the bottom of the unit first. If your unit fits, back the frame out of the opening.

4 SHIM THE SILL



EXTERIOR

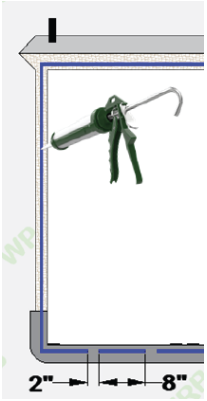
With the sill properly flashed, place shims at the sill. Shims should be located under each jamb corner opposite of the anchor jamb. It is critical that each window is shimmed to keep proper alignment.

NOTE: As units are mulled, shims will sit next to mullion anchors.

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Window Mulling Instructions (1/2” - 1” Steel Anchor System)

5 APPLY SEALANT

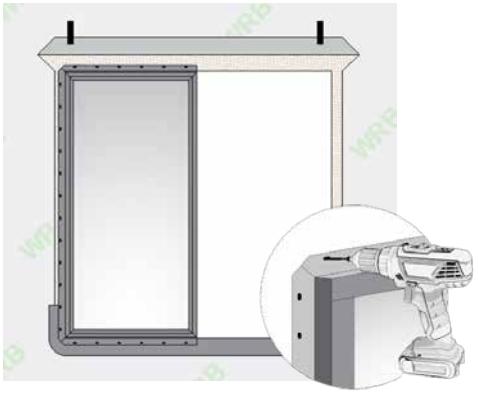


EXTERIOR

Apply a continuous 3/8” bead of sealant to the jamb and head sheathing. Keep sealant in line with where the nailing fin will be positioned.

Apply a 3/8” discontinuous bead of sealant to the sill to allow for incidental water drainage.

6 POSITION & FASTEN WINDOW

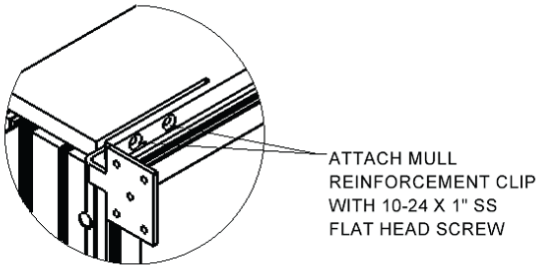


SIDE JAMB

Position unit tight to the opening and temporarily fasten the unit at 3-4 locations for stability. Check for plumb, level, and square, then fasten the unit entirely.

Place fasteners 4” from each corner and space every 4” - 8” on center.

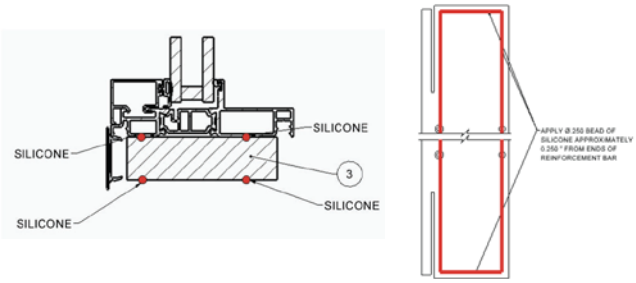
7 FASTENING ANCHORS



SIDE JAMB

Adjust the head and sill anchors so they are snug to the opening, then tighten the anchor screws so the anchors are tight to the frame. Use 3 installation screws to secure the anchors to the opening.

8 SEALANT APPLICATION



SIDE JAMB

Using the provided sealant, apply a continuous 3/8” bead along the perimeter of the mullion bar. Across the top and bottom, apply a generous amount of sealant approximately 1/4” from the top and bottom edge of the frame. Sealant should squeeze out when frames are joined.

NOTE: If the composition features any stacked units, add additional sealant on the mullion bar horizontally where the stack occurs.

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Window Mulling Instructions (1/2” - 1” Steel Anchor System)

9 CONNECTING THE WINDOW

When adding the second unit, repeat Steps 3-6:

Step 3 = Dry Fit Unit

Step 4 = Shim the Sill

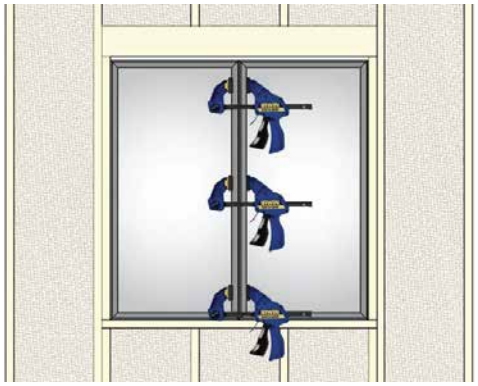
Step 5 = Apply Sealant

Step 6 = Position & Fasten Unit

EXTERIOR

When adding the second unit, repeat steps 3-6.

10 CONNECTING THE WINDOWS

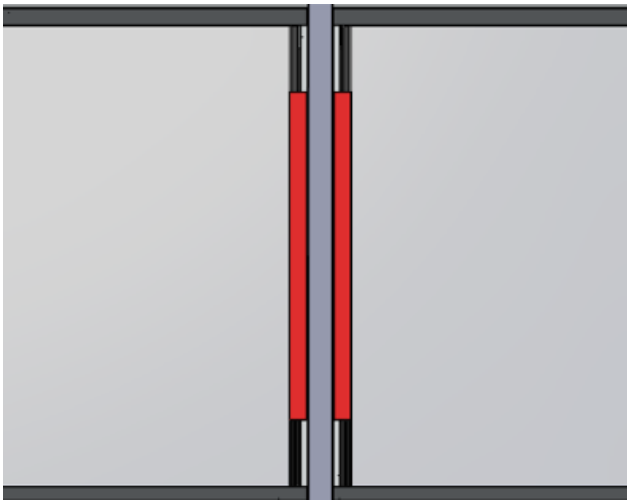


INTERIOR

From the interior, using squeeze type clamps, draw the frames together and let rest until you complete Step 13.

Make sure the connection is as tight as possible. Take care not to scratch the aluminum with the clamps.

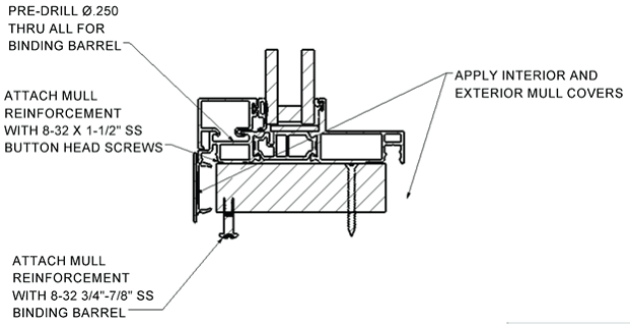
11 REMOVE THE TEMPORARY GLAZING BEADS



EXTERIOR

Moving back to the exterior, remove the temporary glazing beads from the side jambs where the mulling is occurring.

12 DRILL OUT THE PILOT HOLES



EXTERIOR

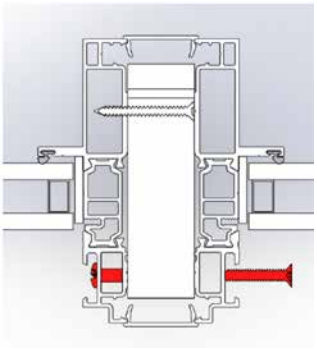
Locate the factory drilled pilot holes on the side jamb where the structural bar is mounted. Using your 1/4” drill bit, drill through the pilot holes creating uniform holes between the two frames.

NOTE: It is likely you will need the 90-degree adapter for this step. Also, operable units will require the sash to be open to expose the pilot holes.

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Window Mulling Instructions (1/2” - 1” Steel Anchor System)

13 APPLY THE THREADED BOLTS

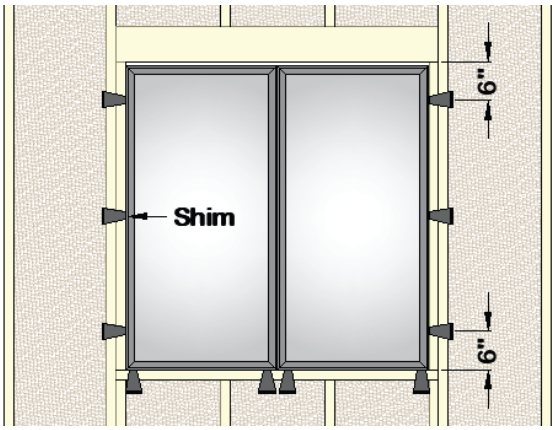


EXTERIOR

From the job box, locate the male and female thread bolt pieces. Insert the female pieces through the pilot holes on the side jamb where the structural bar is mounted and hold each one in place using a Phillips screwdriver. Fasten the male pieces as you hold the female pieces secure in the hole.

NOTE: You can remove the clamps from the interior after this process.

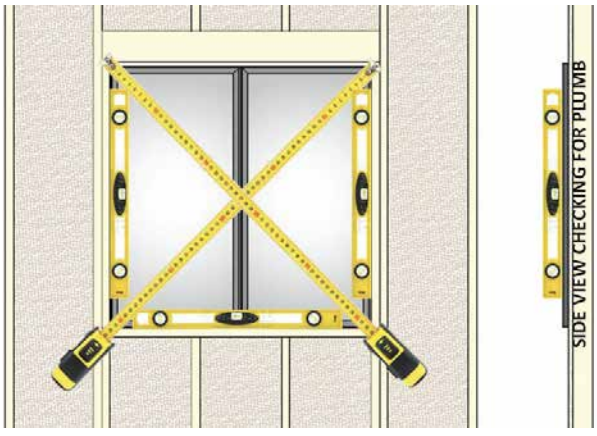
14 SHIM WINDOW



INTERIOR

Add shims 4”-6” in from the corners at the side jambs and at 16” intervals on center as needed to ensure the window is positioned in the opening plumb, level, and square.

15 VERIFY PLUMB, LEVEL, AND SQUARE



INTERIOR

Check the unit is plumb, level, and square. Diagonal measurements must be within 1/8”. Adjust shims as needed.

16 SECURE WINDOW



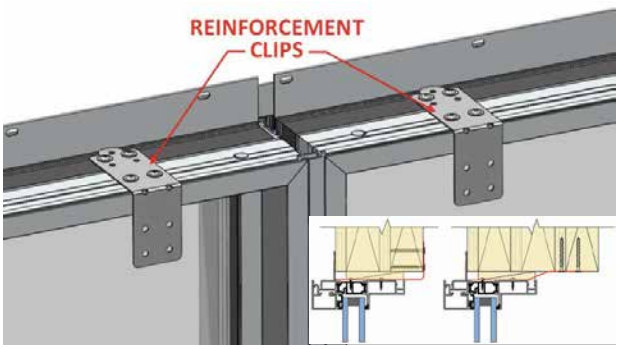
EXTERIOR

When the window is plumb, level, and square, continue fastening through the nailing fin holes. Place fasteners 4” from each corner and spaced every 4” - 8” on center.

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Window Mulling Instructions (1/2” - 1” Steel Anchor System)

17 MULLION REINFORCEMENT CLIPS



INTERIOR

Units that are factory prepped for mulling will come with mullion reinforcement clips applied to the frame. Clips are bent down for shipping. Bend these clips so they can be secured to the opening. Utilize (2) #8 x 1-5/8” flat head, non-corrosive screws when mounting the clips to the opening.

18 SQUEEZE OUT CLEAN UP

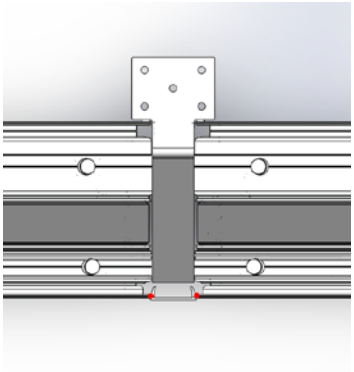


EXTERIOR & INTERIOR

Using the denatured alcohol/water combination, clean the sealant squeeze out from the exterior and interior frame surfaces.

NOTE: You do not need to clean the sealant where the mullion cover conceals the structural mullion.

19 MULLION COVER INSTALLATION

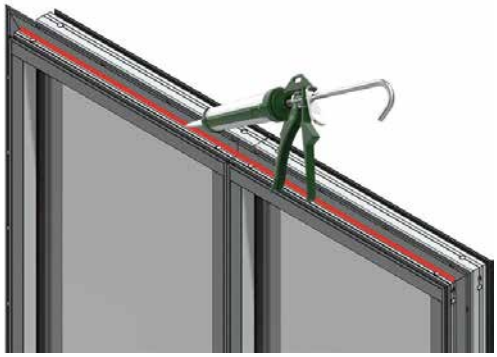


EXTERIOR & INTERIOR

Locate your loose mullion covers.Before installation, add a dab of silicone on the backside of the cover, spreading each dab every 10” - 12”. Utilize a rubber mallet to tap each mull cover into place.

NOTE: Slightly adjust male thread bolts if necessary for fit and install covers on same day.

20 DRIP CAP INSTALLATION



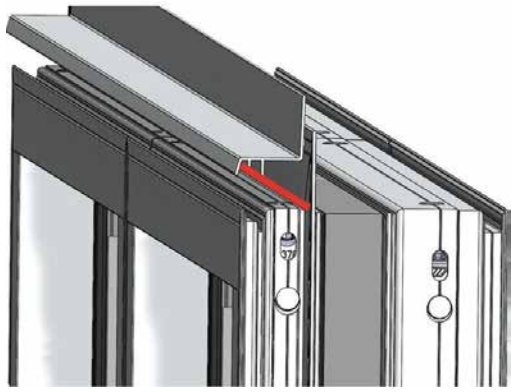
EXTERIOR

A continuous aluminum drip cap will be provided as part of the field mulling kit. This part should be the same width as the combined frame (minus nailing fins). To install, apply a continuous 3/8” bead of silicone using the corner of the nail fin to jamb as a guide.

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Window Mulling Instructions (1/2” - 1” Steel Anchor System)

21 DRIP CAP INSTALLATION



EXTERIOR

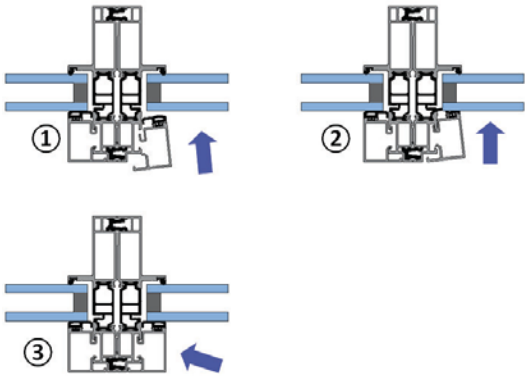
Center the drip cap at the head of the frames. Push the barb legs of the extrusion into the accessory channel of the frame. Using a wood block and a hammer, gently tap the drip cap into place.

22 FLASHING NAIL FIN JOINT



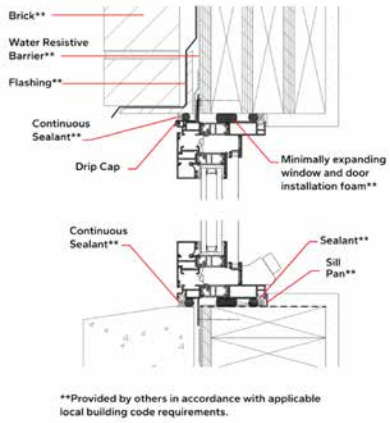
Using the provided 3” x 3” self-adhering flashing tape, evenly cover the joint between the nail fins, folding the tape 1/2” onto the frame of the window. Press the tape firmly against the exterior wall and remove any gaps or air pockets.

23 GLAZING BEAD INSTALLATION



Glazing beads left off during the mulling of the units will now need to be installed. Pushing the bead at an angle into the glass, engage the hook into the frame. Roll the bead into place, pushing inward to the glass and down to snap into place. A rubber mallet can be used carefully if needed.

24 FINAL FLASHING AND INSULATING



Finish off the installation by properly flashing and insulating the window combination using the methods outlined in the installation instructions available on the product website.

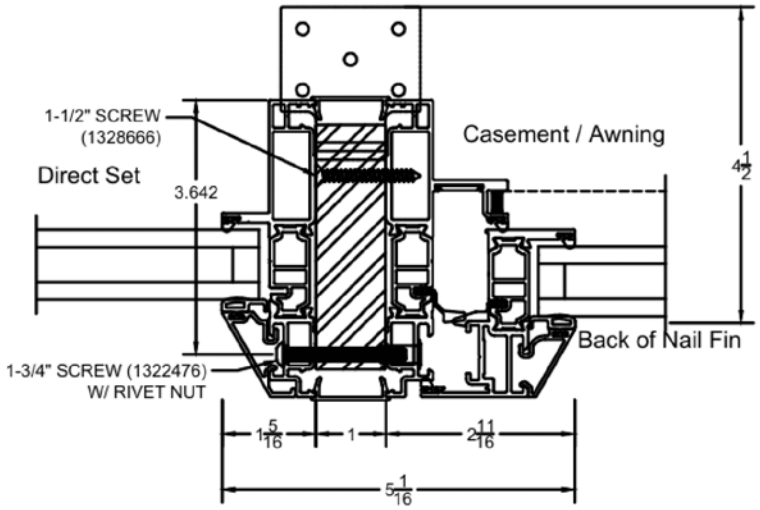
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Window Mulling Instructions (1/2” - 1” Steel Anchor System)

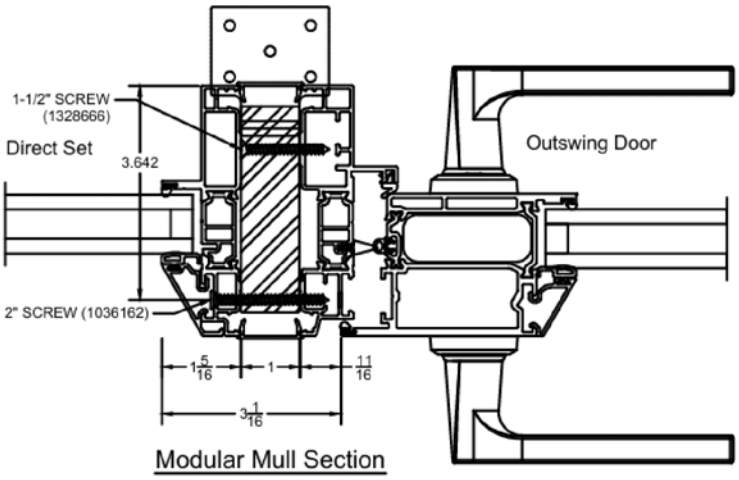
Supplemental Mullion Cross Sections

Note: Contact your product distributor for additional information as the product offering is highly modular.

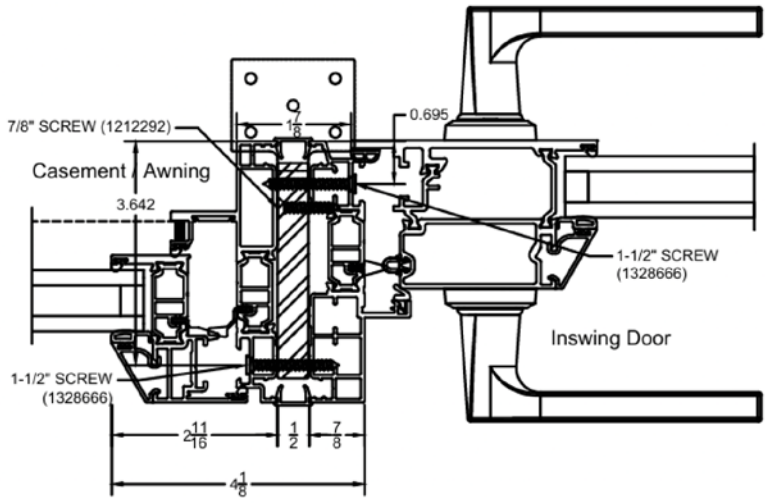
1” Steel Anchored Direct Set/Casement



1” Steel Anchored Direct Set/Outswing



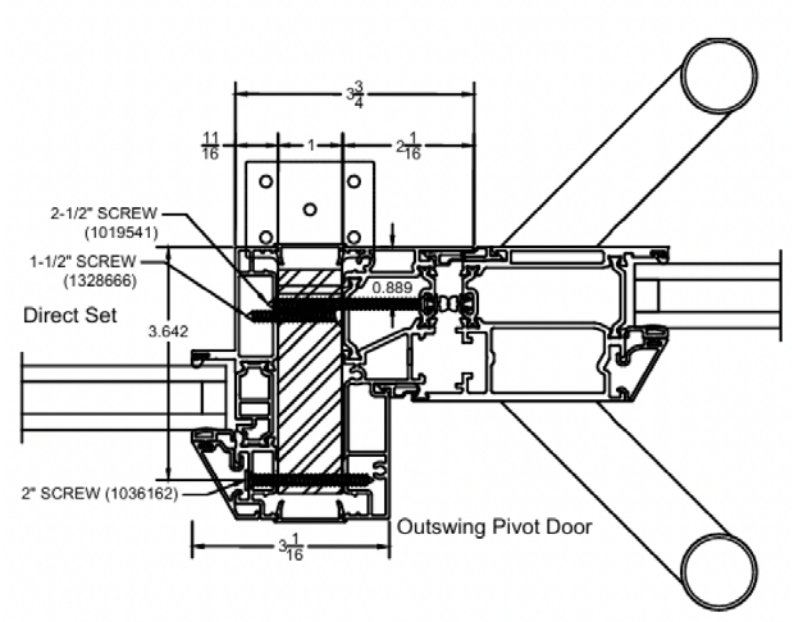
1/2” Steel Anchored Direct Set/Inswing



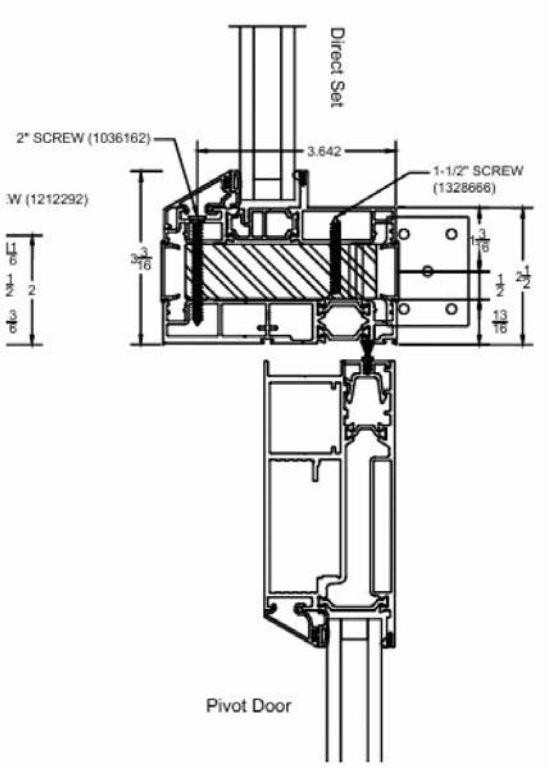
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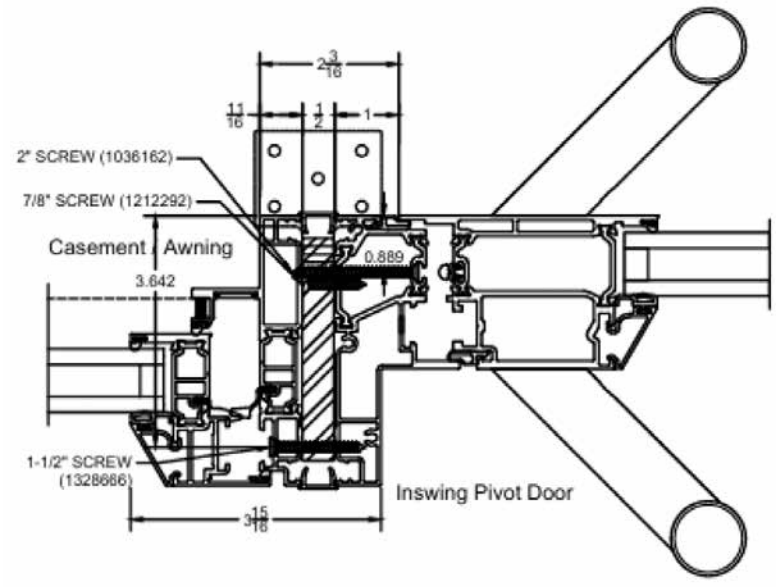
Window Mulling Instructions (1/2” - 1” Steel Anchor System)

Supplemental Mullion Cross Sections Continued

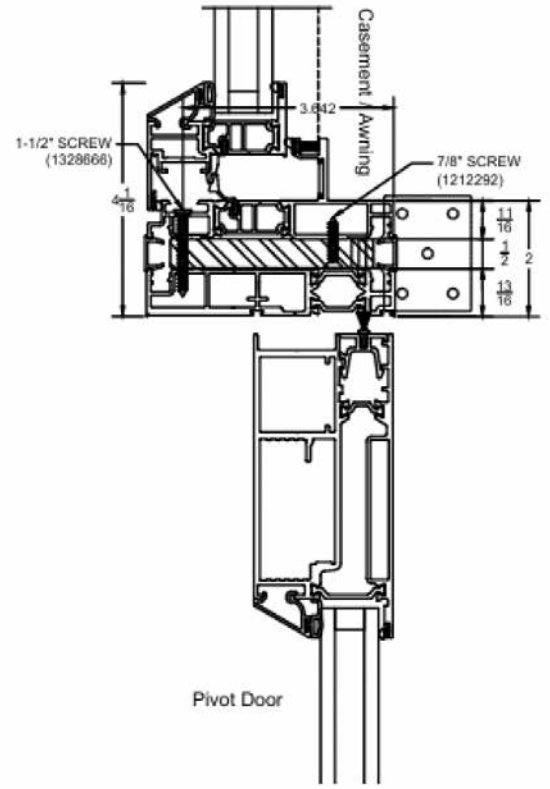


Modular Mull Section
1” Steel Anchored





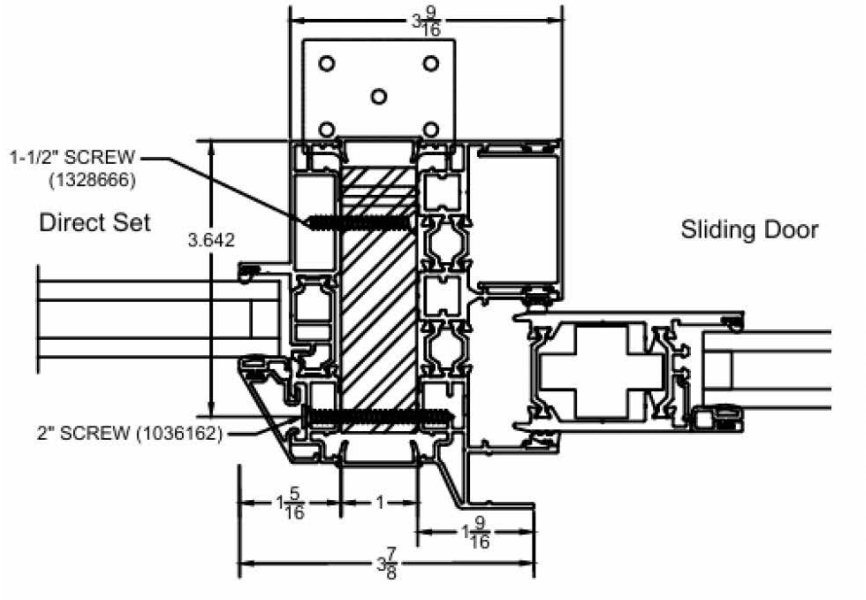
Modular Mull Section
1/2” Steel Anchored



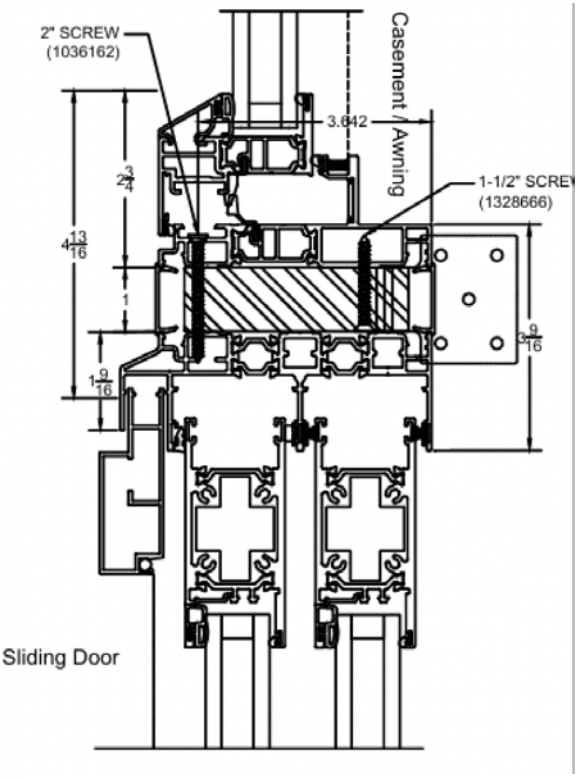
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Window Mulling Instructions (1/2” - 1” Steel Anchor System)

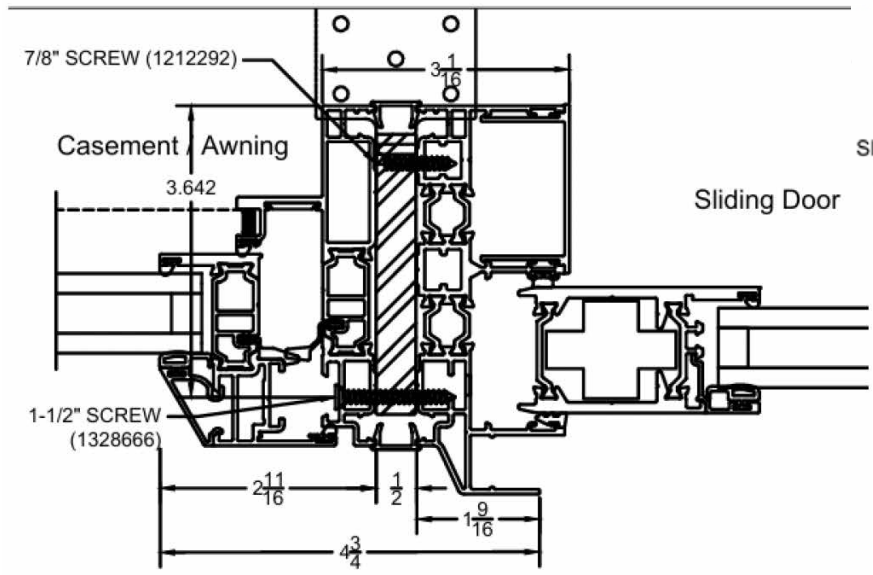
Supplemental Mullion Cross Sections Continued



Modular Mull Section
1” Steel Anchored



Stacked Modular Mull Section
1” Steel Anchored



Modular Mull Section
1/2” Steel Anchored

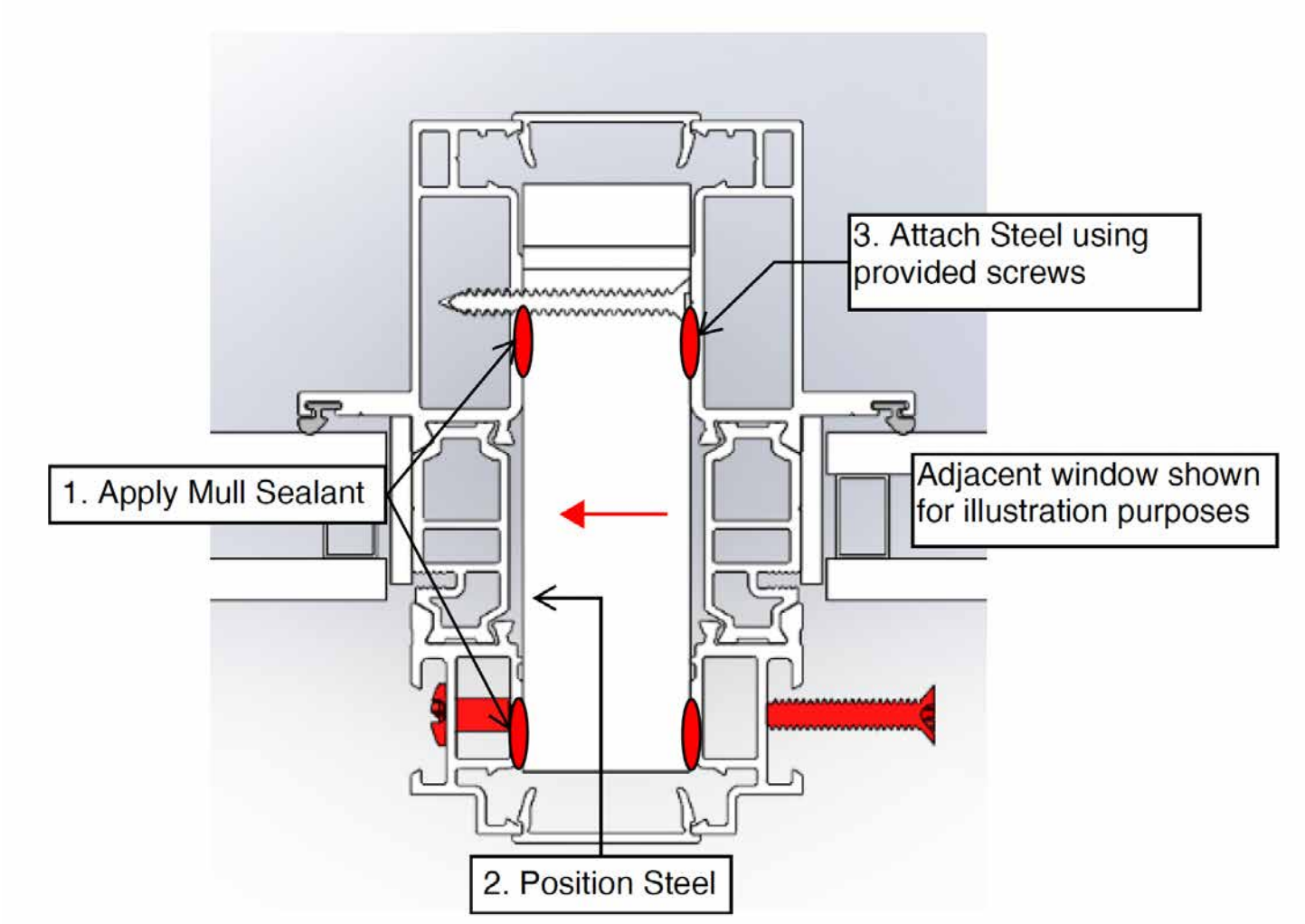
Window Mulling Instructions (1/2” - 1” Steel Anchor System)

Steel Reinforcement Shipped Separate

1. Apply mull sealant.
2. Position steel reinforcement against the side of the window with the notches for the end anchors oriented to the interior.

TIP: Temporarily insert the thread bolt parts into the pre-drilled holes on the window frame to use as alignment devices to assist with locating the steel.

3. Use the provided screws and attach the steel reinforcement to the window.



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