

**ASSEMBLY INSTRUCTION - INSTRUCCIONES DE ENSAMBLADO
FOR FLANGE FRAME STRUCTURAL MULLION KIT
(FLORIDA APPROVAL CODE - FL11372)**

Lea las instrucciones en español en el reverso.

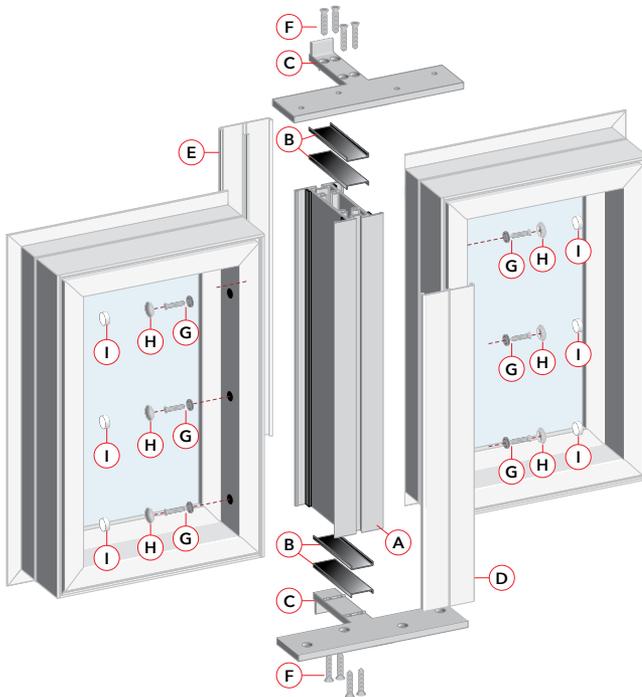
IMPORTANT: Read this entire instruction prior to attempting the process.

The processes described in this instruction were developed and tested for use with ThermaStar by Pella®, Pella® 150 Series and Encompass by Pella® window combinations using 1" mullion reinforcement based on the parameters listed below. 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.

There will be four standard length mullion kits offered to match the length of a window frame dimension. The components within the kit are cut to fit those four frame dimensions, which consist of 37-3/8", 62", 75" and 95-3/4". If the window frame is not one of these sizes, purchase the next longest kit.

If the mullion dimension is not one of the standard four offered, the end customer will need to cut and/or modify several components of the mullion kit to assemble correctly.

REMEMBER TO USE APPROPRIATE PERSONAL PROTECTIVE EQUIPMENT.



LEGEND:

- A. H-Bar with Butyl Tape
- B. Butyl Sealant Tape
- C. Mullion Cap
- D. Interior Mullion Cover
- E. Exterior Mullion Cover
- F. #8 x 1" Flat Head Screws
- G. #6 x 3/4" Self Tapping Screws with Washers
- H. Sliding Covers (Sliding and Fixed Windows)
- I. Foam Plugs (Single-hung Windows)

MULLION KIT CONTAINS:

- H-Bar with Butyl Tape (1)
- Interior and Exterior Mullion Covers (2) (1 each)
- Hardware Pack
 - #8 and #6 screws, washers, caps, or foam plugs
 - Single-hung require foam plugs
 - Sliding and Fixed require caps
- Mullion Caps (2) (1 for each end of mullion)
- Butyl Sealant Tape (4 pieces)
- Assembly Instructions

PARAMETERS/RESTRICTIONS:

- DO NOT mull more than three windows in one combination.
- Horizontal and vertical mullions are not permitted in the same combination.
- Combinations cannot exceed 40 square feet in frame dimension area.
- Vertical mullied composites may not exceed 108" in overall width.
- Fixed windows mullied above operable unit(s) cannot exceed 24 square feet.
- Mullion length cannot exceed 95-3/4".

YOU WILL NEED TO SUPPLY:

- High quality exterior grade polyurethane sealant

TOOLS REQUIRED:

- Tape measure 
- Utility knife 
- Miter saw
- Battery operated drill / screwdriver
- Sealant gun  

1 PREPARING WINDOWS FOR MULLING:

- A. **Determine which sides of the product will be mullied together.** Lay the windows (interior side up) on a smooth, clean surface.

- B. **Verify the mullion length.**

NOTE: To determine the mullion length needed, measure the window frame and subtract 5/8".

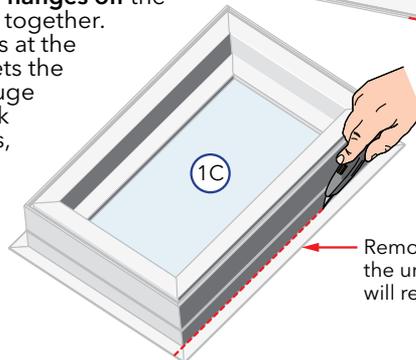
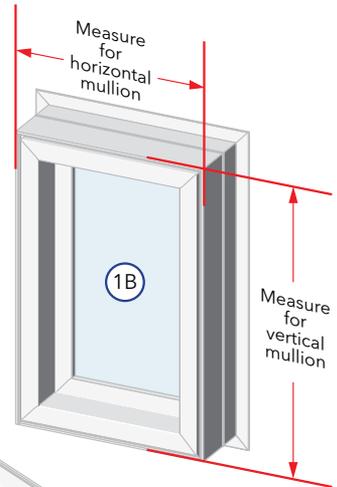
Example:

Frame dimension = 36"

H-bar length = 35-3/8"

(H-bar length = frame dimension minus 5/8").

- C. **Using a utility knife, cut the flanges off the surfaces that will be mullied together.** Score the flange three times at the point where the flange meets the frame. Be careful not to gouge frame. Bend the flange back and forth two to three times, and peel it off the unit. The result will be a flush surface to mull against.



Remove the flange from the unit on the side that will receive the mullion.

2 PREPARING THE H-MULLION:

NOTE: If the mullion kit length matches the window frame size proceed to Step B.

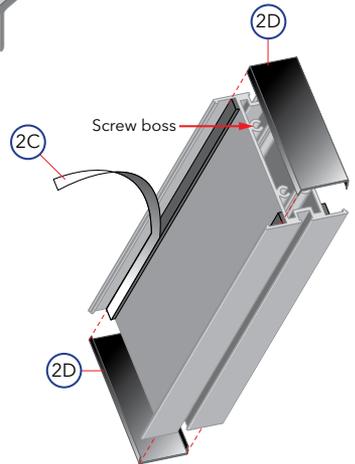
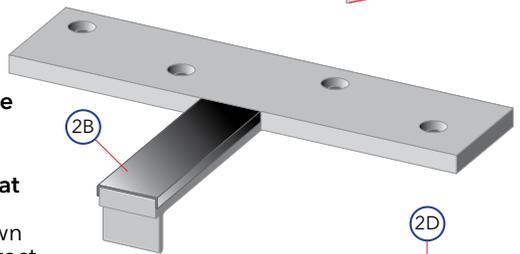
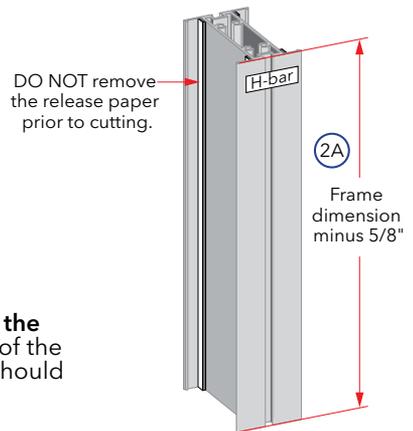
- A. Using a miter saw with construction grade blade, cut the H-bar to length. The H-bar should be cut $5/8$ " shorter than the frame dimension of the window.

NOTE: DO NOT remove the release paper from the butyl tape prior to cutting the H-bar.

- B. Apply flat butyl sealant tape (1-1/4" x 3") to the mullion cap. Center the butyl on the surface of the cap shown; approximately $1/8$ " of the butyl should overhang on each side of the mullion cap.

NOTE: Be sure to wrap the butyl over the sides of the cap.

- C. Remove the release paper from the butyl strips on the H-bar. Keep the butyl strips clean from debris.
- D. Apply the supplied (1-1/4" x 3") flat butyl sealant tape to both ends of the H-bar. Wrap the butyl tape down the sides of the H-bar, making contact with the long H-bar butyl strips.



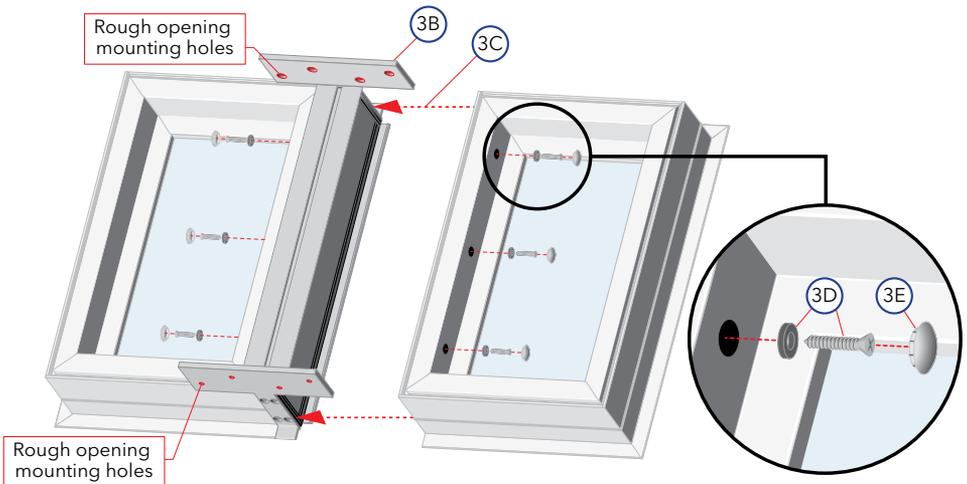
- E. Fasten the prepared mullion cap to the H-bar using four #8 x 1" flat head screws. Be sure to drive the screws into the H-bar screw bosses as shown. This can be assured by aligning the back of the cap to the outer surface of the H-bar. Repeat this step for the other end.

NOTE: Be sure to attach the mullion caps in the same direction.

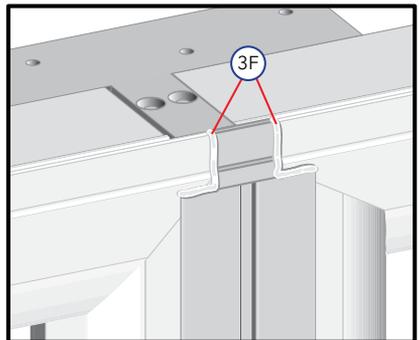
3 INSTALLING H-MULLION:

- A. Lay the windows (interior side up) on a smooth, clean surface, with the sides being mullied approximately 2" apart.
- B. With the rough opening mounting holes on the mullion cap facing up, position the H-mullion onto the first window frame, aligning the ends of the H-mullion to the ends of the window frame. Press the H-mullion firmly into position.
- C. Position the second window frame with the H-mullion, aligning the ends of the H-mullion to the ends of the window frame. Press the H-mullion into position. Verify the sides of the windows being mullied are aligned.
- D. Fasten both units to the H-bar by driving #6 x 3/4" self tapping screws with washers (provided) into the pre-drilled holes in the vinyl extrusion and into the H-bar.

NOTE: Tighten the screws so there is approximately 50% compression of the neoprene washer.



- E. Press in the screw covers or foam plugs after the screws are seated.
- F. Apply high quality exterior grade polyurethane or silicone sealant to both ends of the mull as shown.



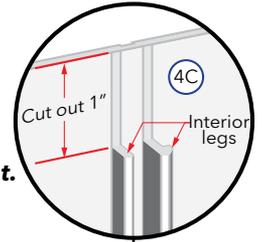
4 INSTALLING MULLION COVERS:

A. Cut a mullion cover for the interior.

New Construction Applications: The interior cover length equals frame dimension minus 1".

Replacement Applications: The interior cover length is equal to the frame dimension.

Note: Make sure the ends of the cover are cut straight.

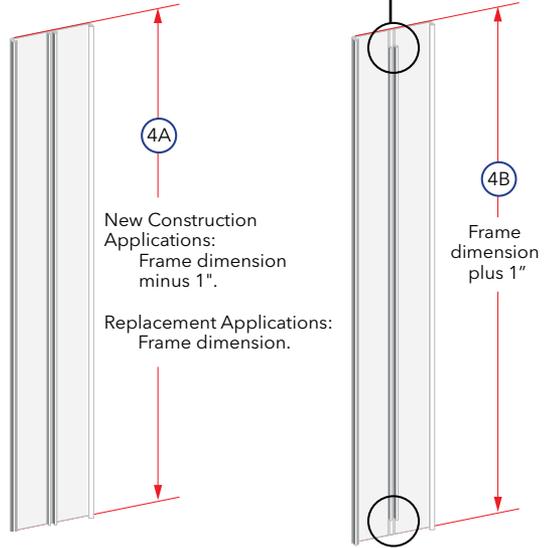


B. Cut a mullion cover for the exterior.

Exterior cover length equals frame dimension plus 1".

NOTE: Make sure the ends of the cover are cut straight.

C. Using a utility knife, cut out 1" of the interior legs as shown, on both ends of the exterior mullion cover.



D. Snap the mullion covers into the H-bar.

Starting on one end of the H-bar, firmly press the center of the cover and work to the other end.

NOTE: Shortest cover goes to the interior.

