

INSTALLATION INSTRUCTION FOR MULLION

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 door 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.
- Horizontal and vertical mullions are not permitted in the same combination.
- The mullied product combination cannot exceed 50 square feet in rough opening area.
- The length of any mullion may not exceed 96".
- Mullions 54" or longer must be reinforced with a minimum 1/4" x 3" 6061-T6 aluminum flat bar reinforcement.
- All patio doors being mullied to sidelites or transoms must be reinforced with a minimum 1/4" x 3" 6061-T6 aluminum flat bar reinforcement.
- Any window greater than 25 square feet may not be mullied horizontally above another product.
- Patio door sidelites may not be mullied to the lock side jamb of a patio door.

YOU WILL NEED TO SUPPLY:











- High quality exterior grade polyurethane or silicone sealant.



Additional tools for reinforced application:

- 3/16" Drill bit 
- #2 Phillips screwdriver 

TOOLS REQUIRED:

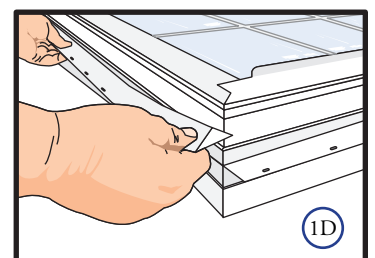
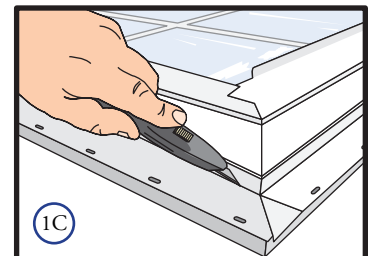
- Tape measure 
- Sealant gun 
- Utility knife 
- Rubber mallet 
- 1" wide wood chisel 
- Pliers 
- 3/8" Drill bit 
- Drill guide for 3/8" bit 
- Drill 
- Coping Saw 

1 PREPARING WINDOWS FOR MULLING:

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

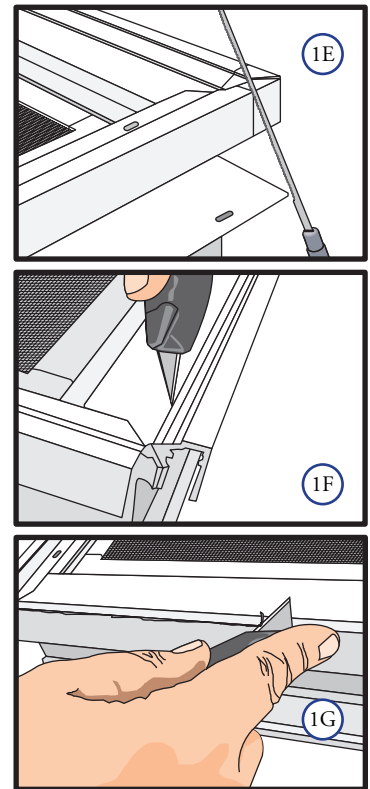
- Determine which surfaces of the products will be mullied together.**
- Remove the nail fin from the surfaces to be mullied.** Lay the products, exterior surface down on a firm, clean flat surface.
- Using a utility knife, score the fin 3 times** at the point where the fin meets the frame. Be careful not to gouge frame.
- Bend the fin back and forth 2 to 3 times**, and peel it off the unit.

If the product does not have J-mould proceed to Step 1H.



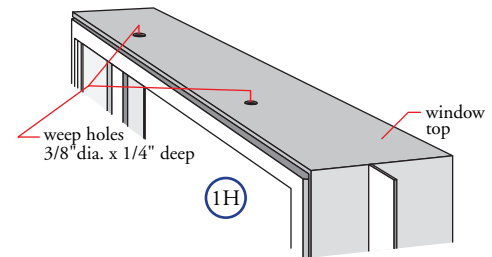
1 PREPARING WINDOWS FOR MULLING (continued):

- E. **Remove the J-mould (if applicable)** from the surfaces that will be mulled together. Lay the product (with the interior surface down) on a smooth clean surface. Using a coping saw, make a horizontal and a vertical cut that align with the point where the J-mould meets the exterior face of the product. Cut until the blade reaches the point where the vertical and horizontal J-mould meet. Bend and remove the cut out section of the J-mould corner.
- F. **Using a utility knife, score (3 times) the point where the J-mould attaches to the exterior face of the product.** Beginning at one end of the J-mould, grasp the J-mould with pliers and bend the J-mould toward the interior of the product. Continue along the entire length of the product until the J-mould is removed from the product.
- G. **Using a utility knife, cut off any excess material** that does not break off the accessory groove.
- H. **Horizontal Mullions Only:** Drill $3/8"$ diameter, $1/4"$ deep weep holes into the top of the bottom window or door. Drill holes 6" from each end of the product, and 1" from the exterior edge of the product. If the mullion width of the unit is greater than 69", drill an additional weep hole at the mid point of the lower product, 1" from the exterior of the product.



Note: A drill guide set at $1/4"$ is recommended to prevent drilling through the second wall of vinyl.

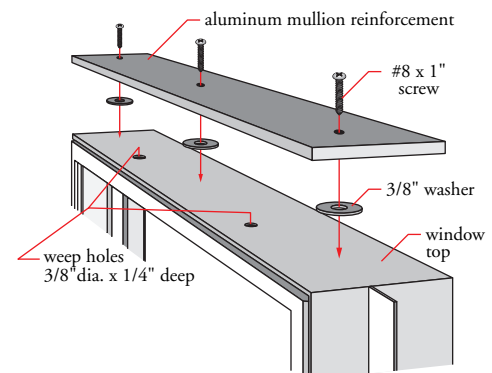
If mullion reinforcement is not required, proceed to Step 3A.



2 INSTALL MULLION REINFORCEMENT:

If mullion reinforcement is not required proceed to Step 3.

- A. **Pre-drill $3/16"$ holes in the mullion reinforcement** spaced 10" on center, the entire length of the reinforcement. The holes should be centered across the width of the reinforcement.
- B. **Attach the reinforcement** to one of the products to be mulled, for horizontal mullions, attach the reinforcement to the top of the bottom product.
- Double-hung:** Use #8 x 1" screws (provided) and place $3/8"$ washers (provided) between the product and the reinforcement.
- All Other Products:** Use #8 x 1" screws (provided) and place flat washers (provided) between the product and the reinforcement.



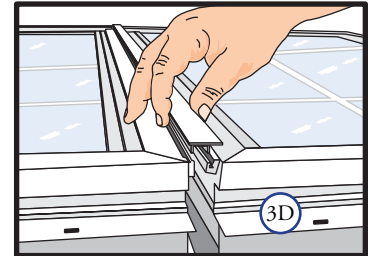
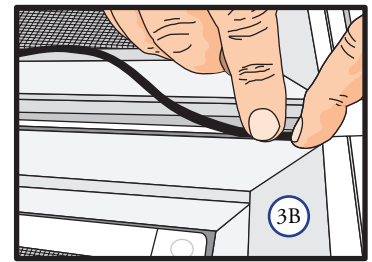
3 INSTALL THE INTERIOR MULLION COVER:

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

- Place the products exterior side down on a smooth clean surface.
- Install the round foam weather-strip into the accessory groove of the surfaces to be mulled.
- Apply a 4" long bead of sealant on top of the foam weather-strip at the top and bottom of each accessory groove.
- Position the windows approximately 1/2" apart and lay the mullion cover across the mullion joint.
- 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.

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



4 INSTALL THE EXTERIOR MULLION COVER:

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

Note: Door transoms, double-hung transoms, replacement fixed windows, casements and awnings have weep slots in the accessory groove. Cut the foam weather-strip to leave the weep slots open. If the top product has weep slots in the accessory groove, notch the mullion cover to match the weep slot location to allow the top product to weep.

- 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.
- At each end of the mullion joint, 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.
- Seal the ends of the mullion joint using high quality exterior grade polyurethane or silicone sealant.

Horizontal Mullions: Ensure both ends of the mullion joint are sealed, including the notched ends of the mullion.

Vertical Mullions: 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.

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

On vertical mullion joints: 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.

- J-mould products:** Install the J-mould joint cover (provided). Place a small bead of sealant on each cut edge of the J-mould. Snap the joint cover into position.

Note: When mulling radius shaped windows to rectangular windows or doors, a 2" piece J-mould joint cover is required. Use a coping saw to cut a 2" length from the 14" piece provided.

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

