

MULLION ASSEMBLY FOR 15 SERIES DOUBLE-HUNG

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 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
- Horizontal and vertical mullions are not permitted in the same combination
- The mulled product combination can not exceed 50 square feet in rough opening area
- 15 Series product cannot be mulled to other series product.
- DO NOT assemble mullion in temperatures below 55° F

YOU WILL NEED TO SUPPLY:

- High quality exterior grade polyurethane or silicone sealant 
- Pella SmartFlash foil backed butyl window and door flashing tape or equivalent 

TOOLS REQUIRED:

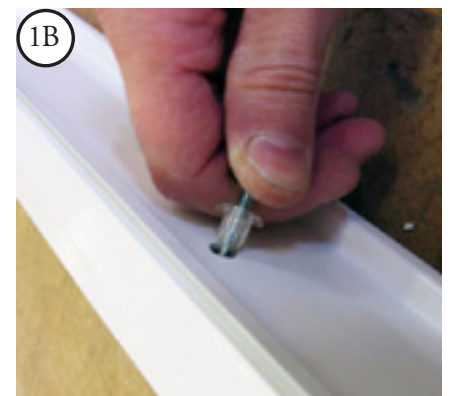
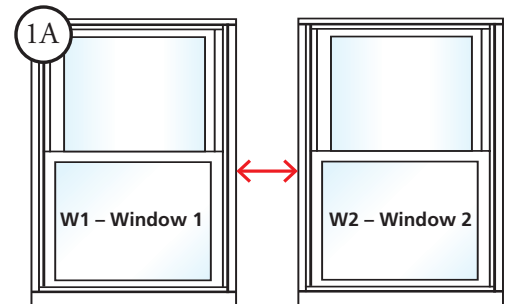
- Tape measure 
- Sealant gun 
- Rubber mallet 
- Drill 
- Side-cutters or shears 
- Phillips drive bit 
- Saw 
- Pliers 

Mullion Package Contents:

- Wood Composite Reinforcement
- Mullion Covers (Qty 2)
- #8 x 5/8" screws (Qty 6)
- Installation Clips (Qty 4)
- Installation Screw Package

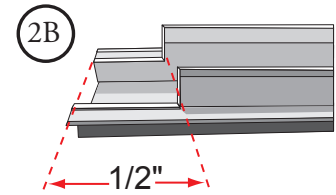
1 Prepare the Windows:

- A. **Remove both sash from each unit**, to allow for easier handling. Unlock the window and raise the lower sash a few inches. Slide the tilt release tabs located at the top of the sash inward. Pull the sash toward you until the sash is perpendicular to the frame. Grasp the sash near the frame and lift straight up until the locking pivot bars in each side of the sash are removed from the bottom of the balance. Lift the sash up and out of the window frame. Repeat on the upper sash. Label and store each sash in a clean area.
- B. **Remove the jamb adjusters from the jambs** that will be adjacent to the mullion by pulling them straight out of the frame. Pliers may be used for ease of removal.
- C. **Lay or lean the windows on a smooth clean flat surface** interior side up.



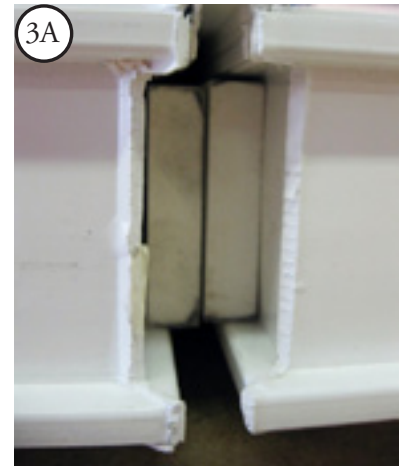
2 Prepare the Mullion Kit:

- A. **Cut the wooden reinforcement and mullion covers based on the frame height of the windows.** Cut the wooden reinforcement 1-1/2" shorter than the window height, and cut the mullion cover length equal to the window frame height.
- B. **Notch the ends of the mullion covers using hand cutters.** Cut the snap-legs back 1/2" on each end of the mullion cover.



3 Install the Mullion Reinforcement:

- A. **Place the wooden reinforcement between the 2 units.** Slide the units together so the wood stays in place.

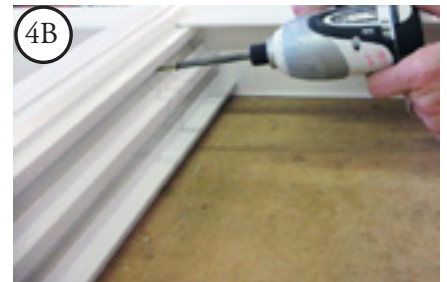


4 Install the Interior Mullion Cover:

- A. **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.

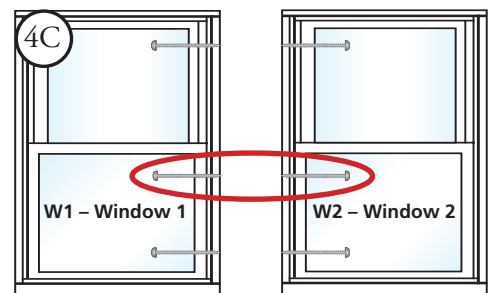


- B. **Center the wooden reinforcement** along the length of the mullion to achieve an equal set-back from the each end of the mullion.



- C. **Drive the provided screw through the pre-drilled hole in the middle of each jamb.** DO NOT use the previous jamb-adjuster hole. Drive one screw in each jamb.

- D. **Flip the frames over** in order to access the exterior side of the windows.

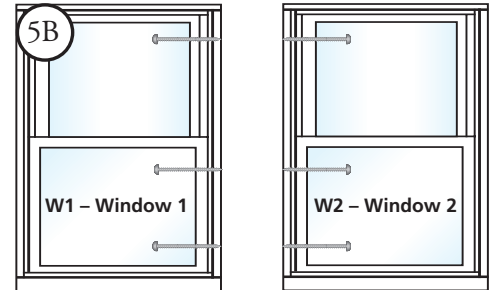


5 Install the Exterior Mullion Cover:

A. **Beginning 6" from one end**, use a rubber mallet to drive the legs of the mullion cover into the accessory grooves of the windows.



B. **Drive screws through** the top and bottom pre-drilled installation holes at the top and bottom of each jamb into the mullion reinforcement.



6 Seal the Ends of the Mullion:

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

Note: *It is critical to completely fill all voids of the mullion joint with sealant. Any void may result in water infiltration.*

B. **Cover the mullion joint with two 6" pieces of flashing tape.** 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.