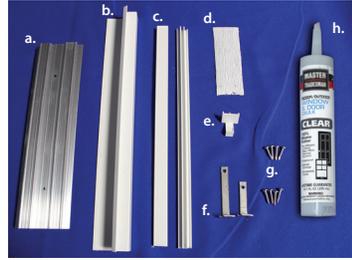


Field Mulling Instructions for Structural Mullion

Parts

- (a) Structural Aluminum Mull Piece (x2)
- (b) Drip Cap
- (c) PVC Mull Cover
- (d) Flexible Flashing Tape
- (e) L-Bracket Cover
- (f) Long L-Bracket and Short L-Bracket
- (g) #8 x 3/4" Pan-Head Screws
- (h) Caulk (Sealant - Not Included)



STEP 1

Prepare the Window

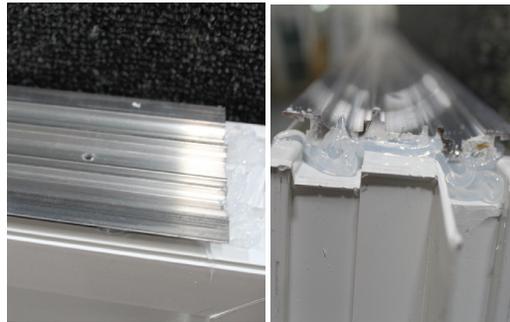
- Remove the nail fin from the jambs that will be attached
- Trim the excess welds at the corners and along the jambs to be attached
- Notch the exterior accessory grooves on the head and sill of the sides of the windows that will be joined



STEPS 2&3

Caulk the extrusions and set the mull pieces in the jambs

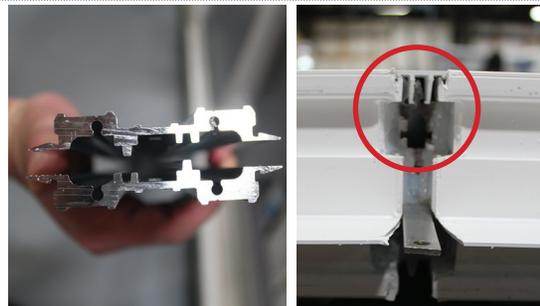
- Ensure that the aluminum reinforcements (**part a**) are cut 1" shorter than the frame on either end
- Apply caulk (**part h**) to each extrusion as follows:
 1. Run a bead in a zig-zag pattern along the center rib
 2. Dispense a liberal amount at either end, embedding it into the mulling channels
- Lay the structural mullion pieces onto the caulked jambs
- Fasten the pieces to the center rib of each jamb at approximately 12" o.c. spacing, at least 3" from either end



STEP 4

Join the windows

- Apply a bead of caulk down the center and along the edge of one of the mull pieces.
- Join the windows so that the male and female sides of the reinforcements meet. Set together



STEP 5

Install the mullion covers

- Run a bead of caulk down the center channel where the mull pieces have been set together
- Place one of the pvc mull covers (**part c**) on top of the caulked channel, and hammer into place with either a low-impact hammer or block of wood and steel hammer
- Flip unit over and follow the same instructions as above for the exterior
- Check alignment

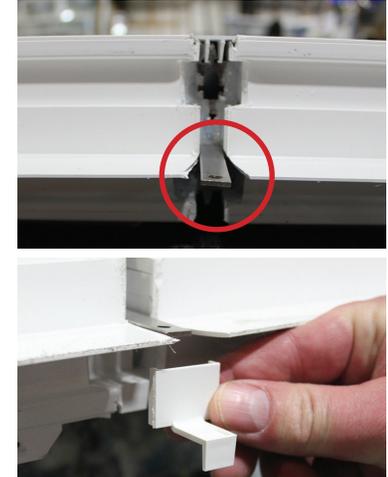


STEP 6

Install the L-Brackets

- Screw L-Brackets (**part f**) into the exposed ends of the aluminum reinforcements using two of the stainless steel #8 x 3/4" pan head screws (**part g**) provided. For vertical mulls, use the longer bracket at the head, and the shorter one for the sill. Horizontal mulls include two short brackets and two bracket covers
- The bottom L-Bracket includes a cover (**part e**). Add caulk to the bottom bracket and push/snap the cover into the center hole of the bracket. After the L-Brackets are secured, fill the cavities around them with caulk

Note: Bracket covers are not needed for frames that include J-Pocket Filler

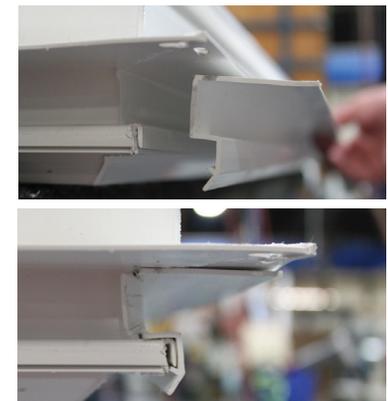


STEP 7

Install the drip cap

- Apply a bead of caulk to the accessory groove along the head jamb, in front of the nail fin
- Install the drip cap (**part b**) by snapping or sliding it into place
- Clip the overhang of the drip cap. Unless pocket filler is to be used, bend the tabs down along each side. Fill any gaps with caulk

Note: If sliding this piece in, make sure NOT to use a petroleum-based lubricant, as it will stain the vinyl.



STEP 8

Complete with flashing tape

- Apply flashing tape (**part d**) over the mull on both ends. Make sure the tape covers the mull channel and extends up along the nail fin

