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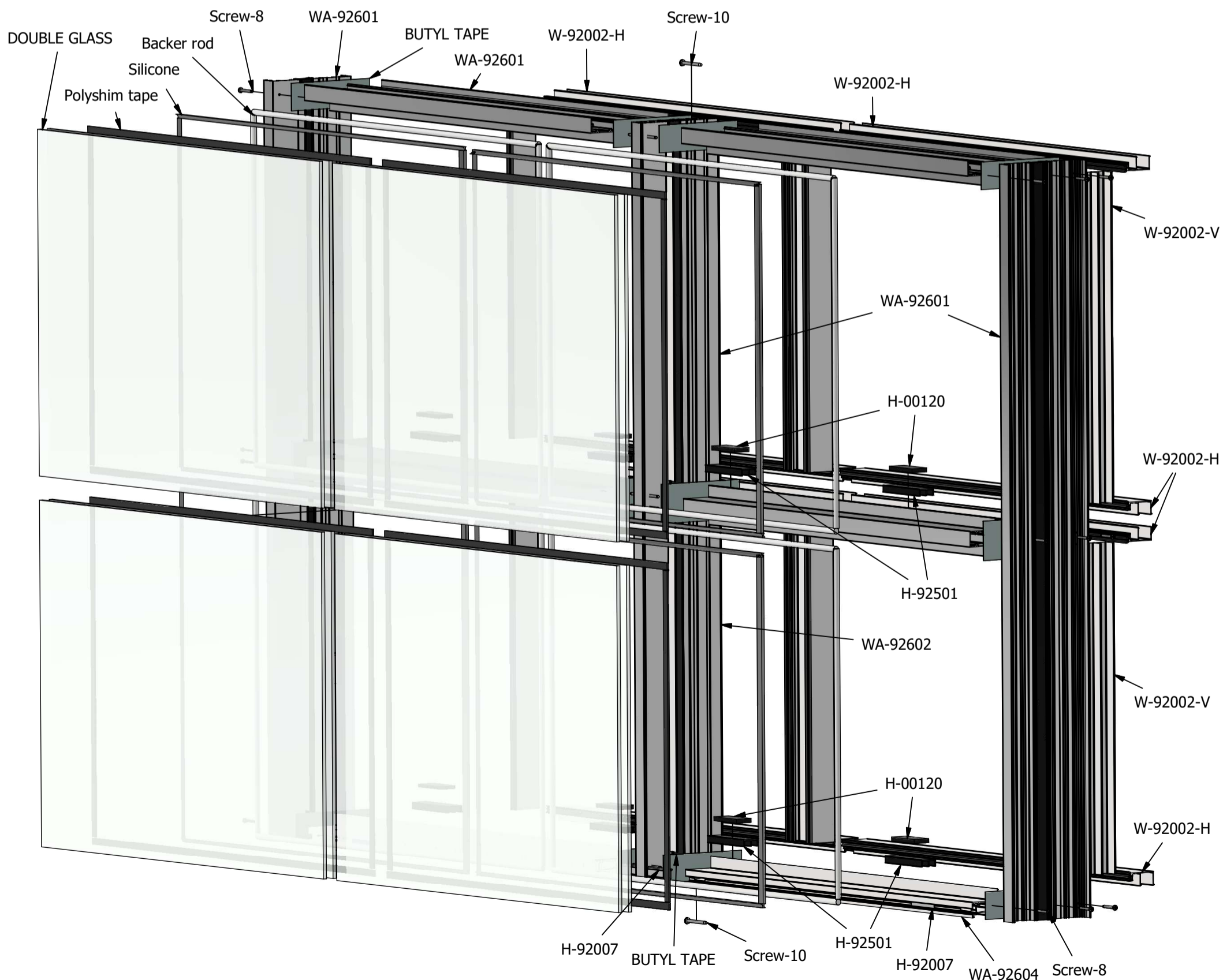
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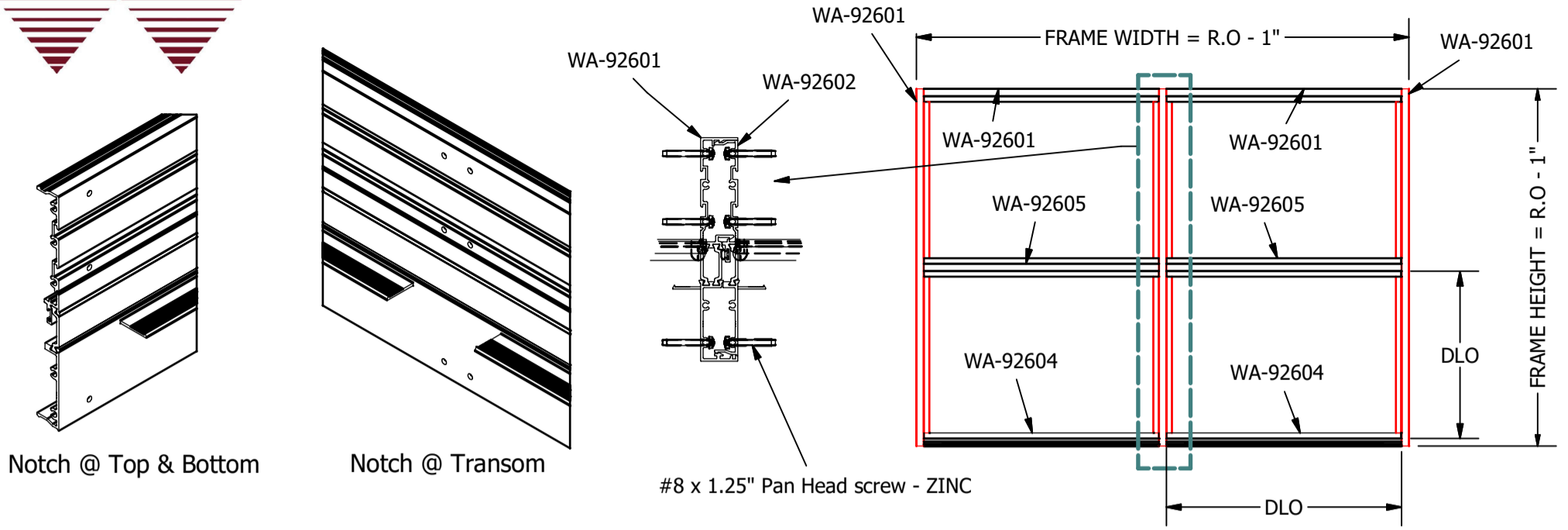
F a b r i c a t i o n



D r a w i n g s

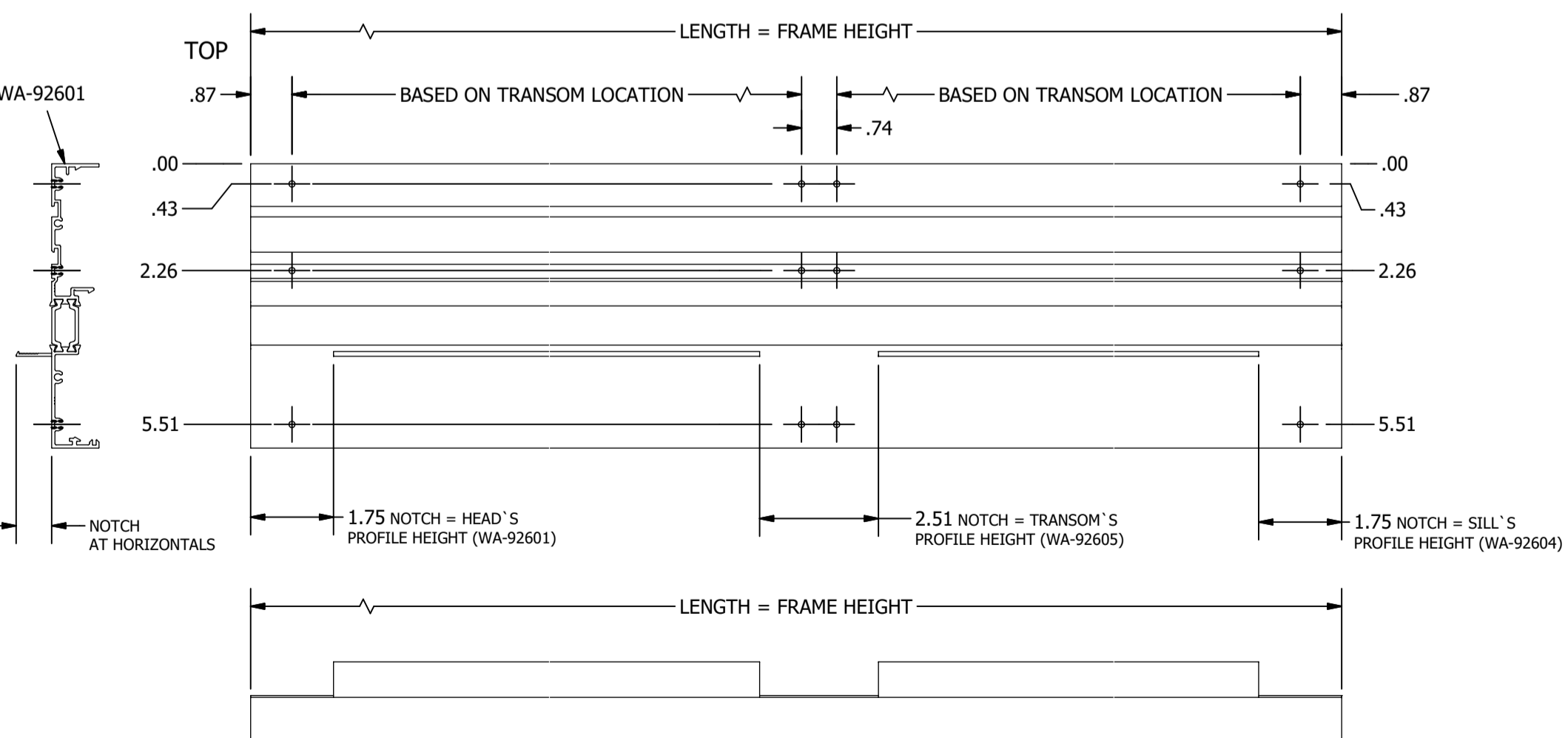
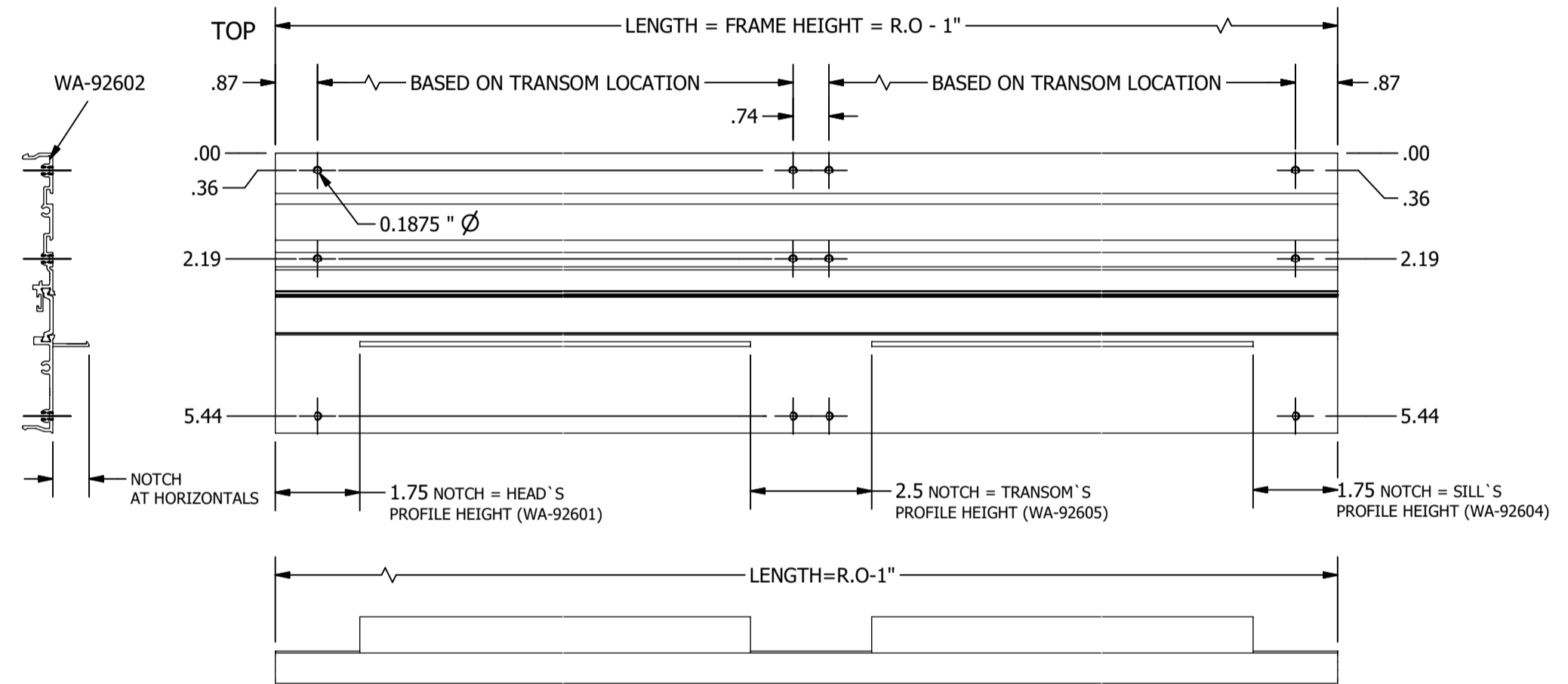
PARTS LIST	
PART NUMBER	DESCRIPTION
WA-92605	1 x 6" (25.4 x 152.4mm) 925 Transom
WA-92604	1 x 6" (25.4 x 152.4mm) 925 Sill
WA-92602	1 x 6" (25.4x 152.4mm) 925 Female Frame
WA-92601	1 x 6" (25.4x 152.4mm) 925 Perimeter
W-92002-V	Vertical Glass Stop (for 1" Double Glazing)
W-92002-H	Horizontal Glass Stop (for 1" Double Glazing)
Silicone	Silicone
Screw-10	#10 x 1.5" pan head screw - ZINC (Male to Female)
Screw-8	#8 x 1.25" pan head screw - ZINC (Horizontals to Verticals)
Polyshim tape	1/8" Polyshim Tape
H-92501	PVC Glazing support
H-92007	WATER GATE
H-00120	(1/4 x 1 1/8 x 2 1/2") E.P.D.M Setting block
Gasket	Bulb Gasket
DOUBLE GLASS	DOUBLE GLASS
BUTYL TAPE	(6" x 1", 1/16" thick) Butyl Tape
Backer rod	Backer rod

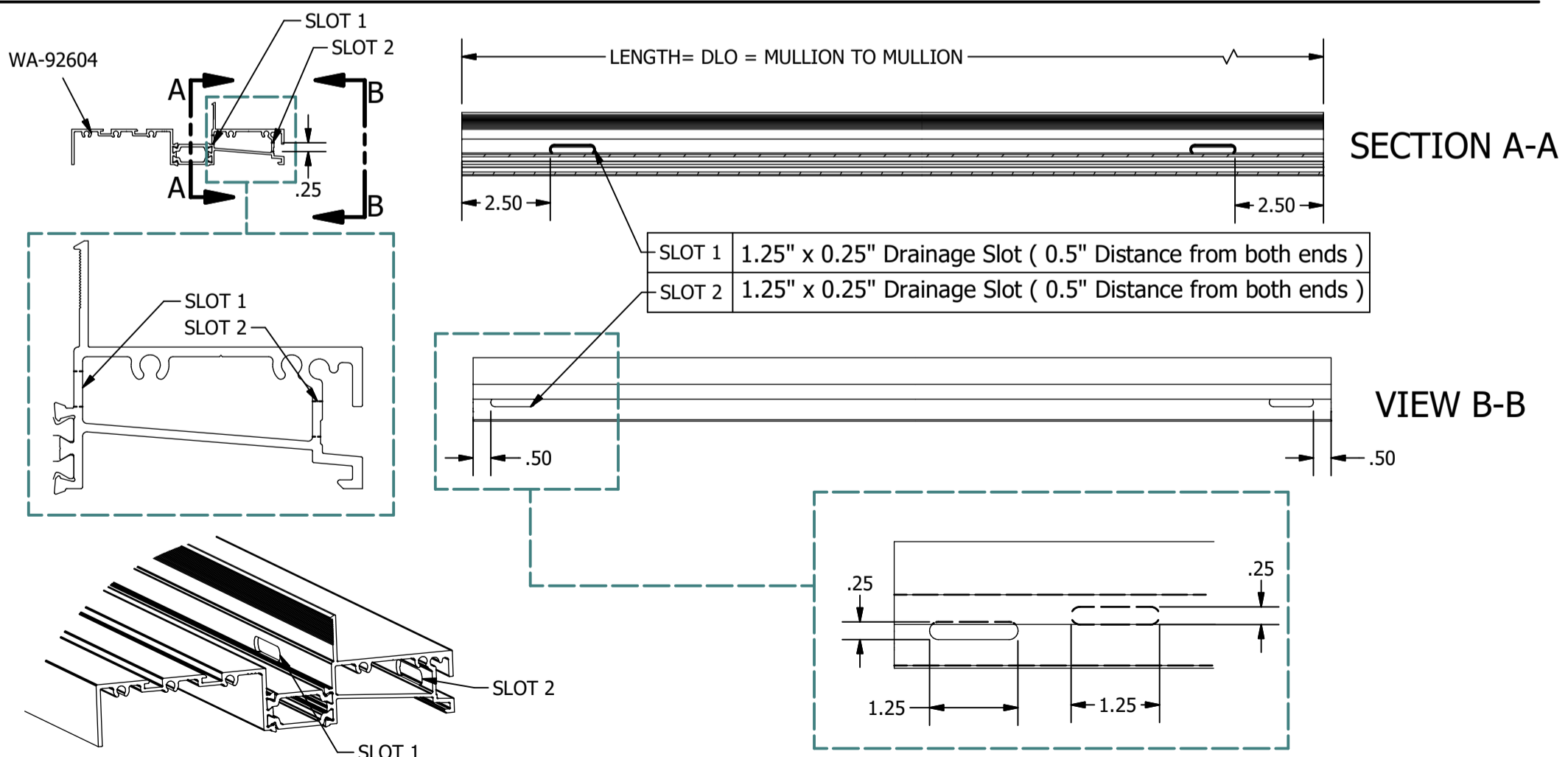
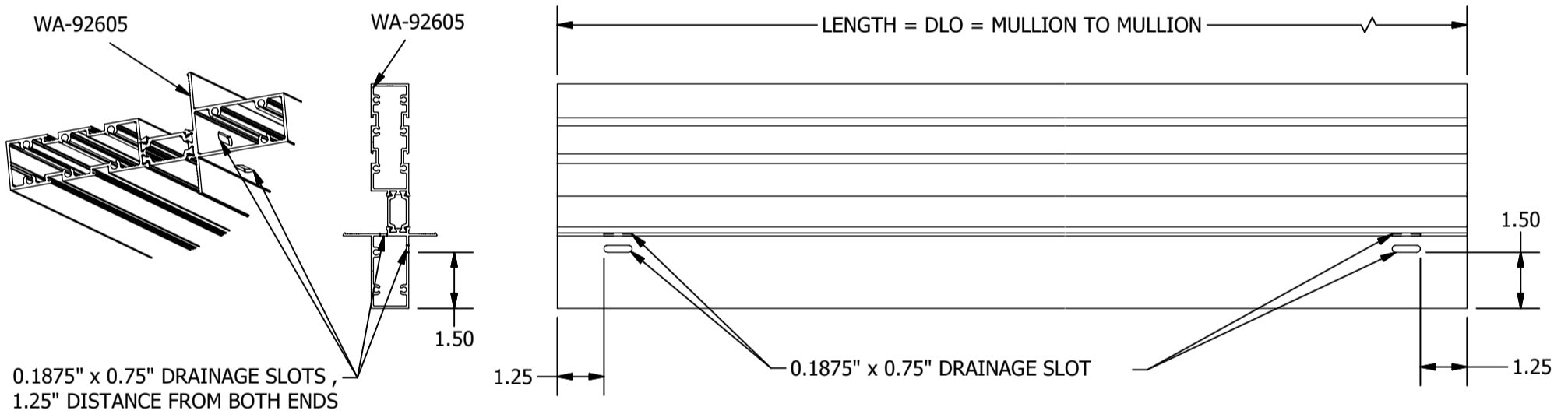
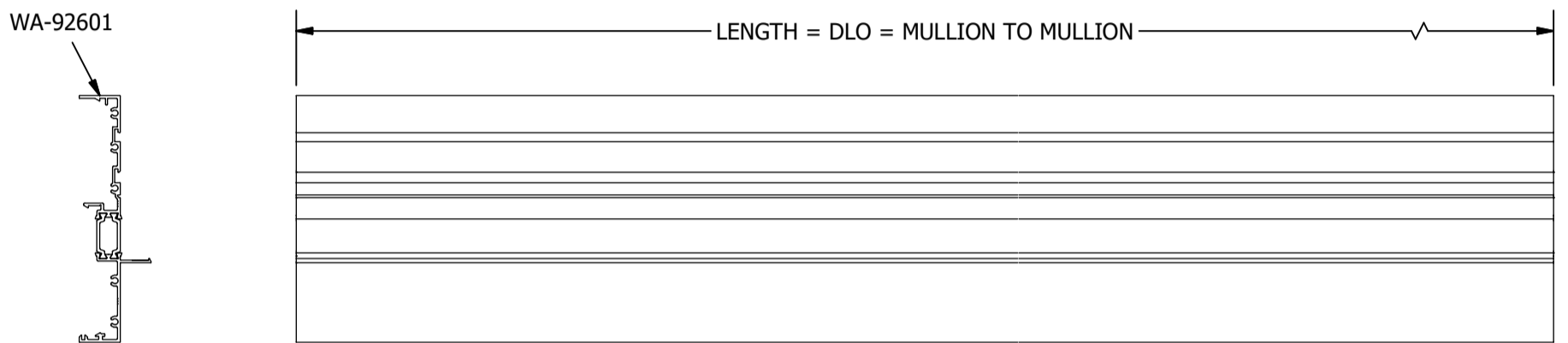
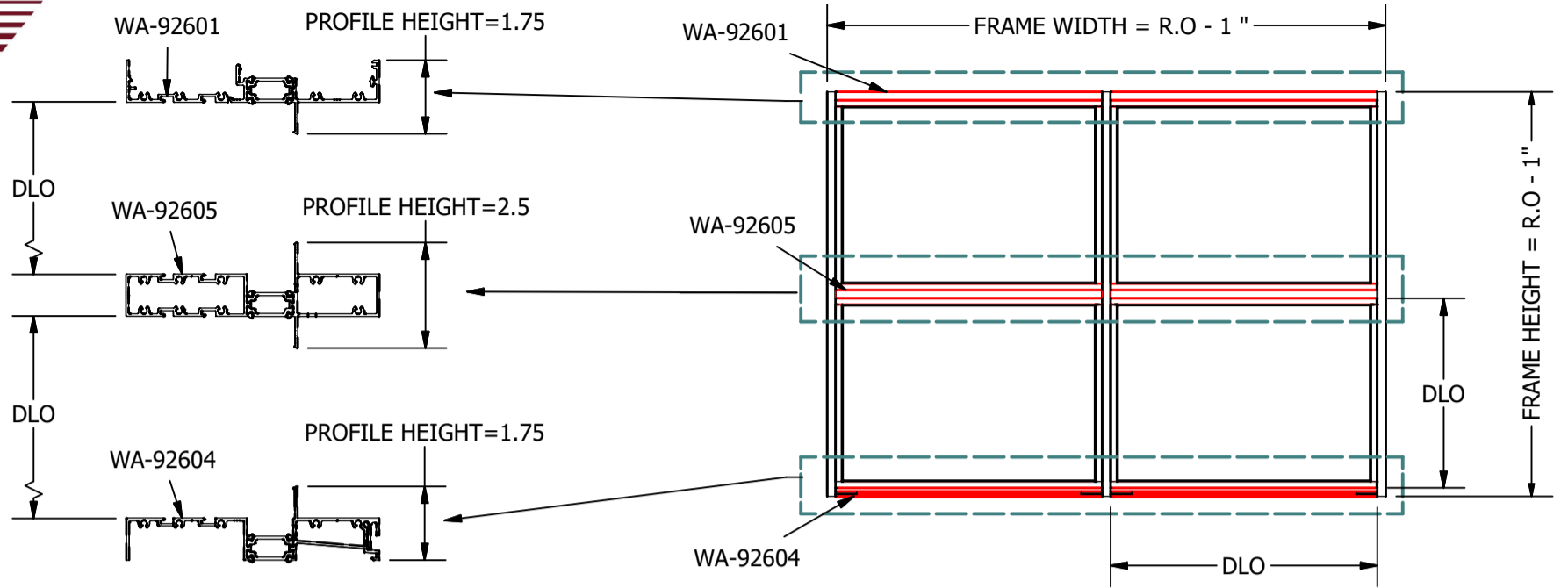


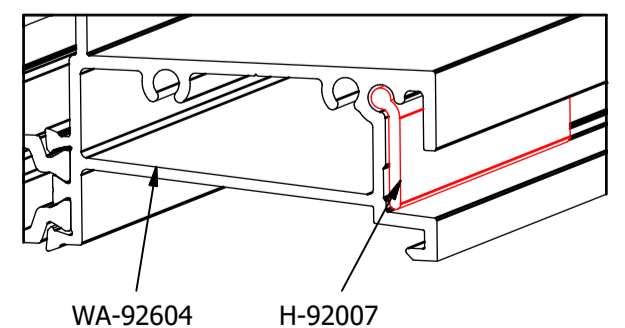
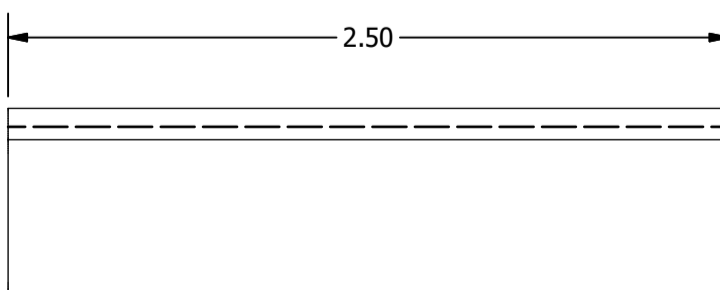
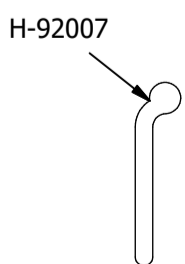
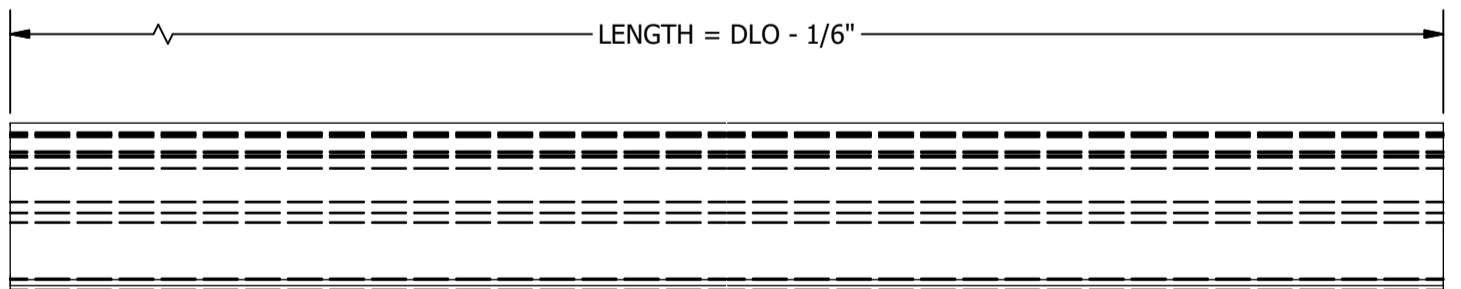
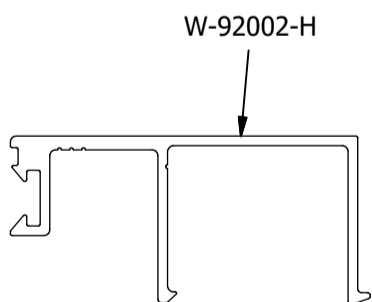
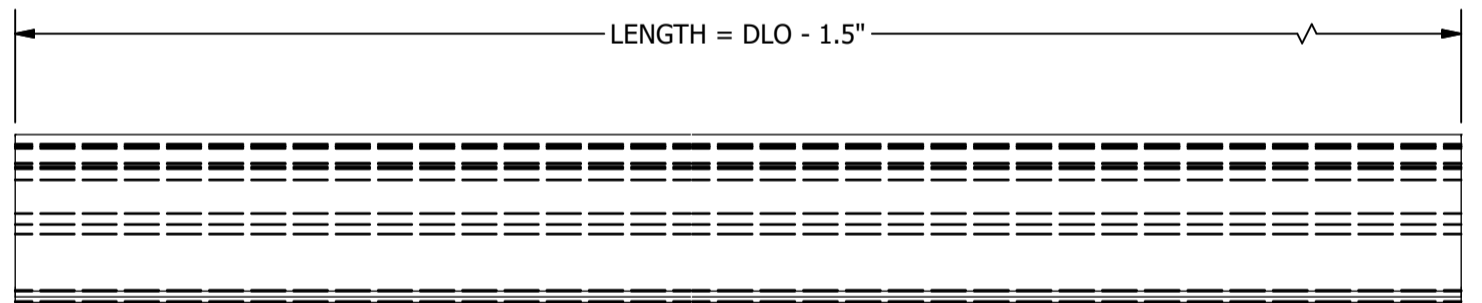
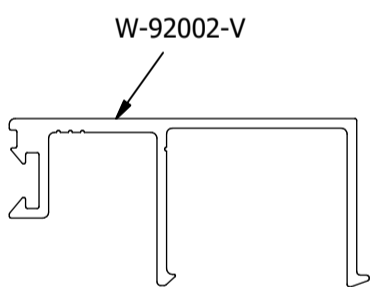
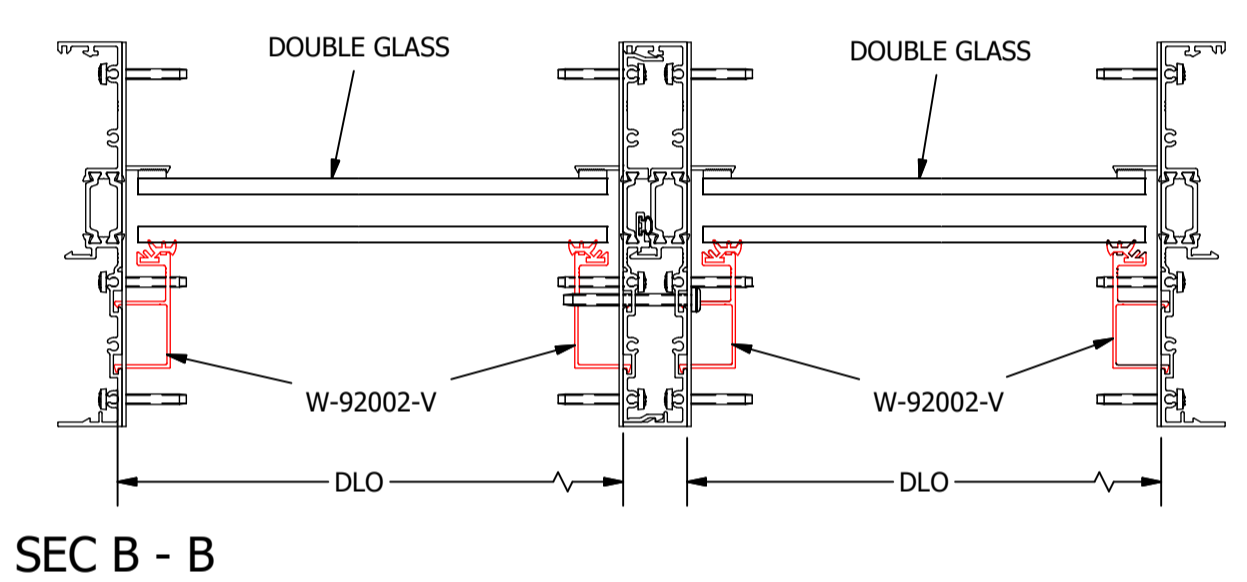
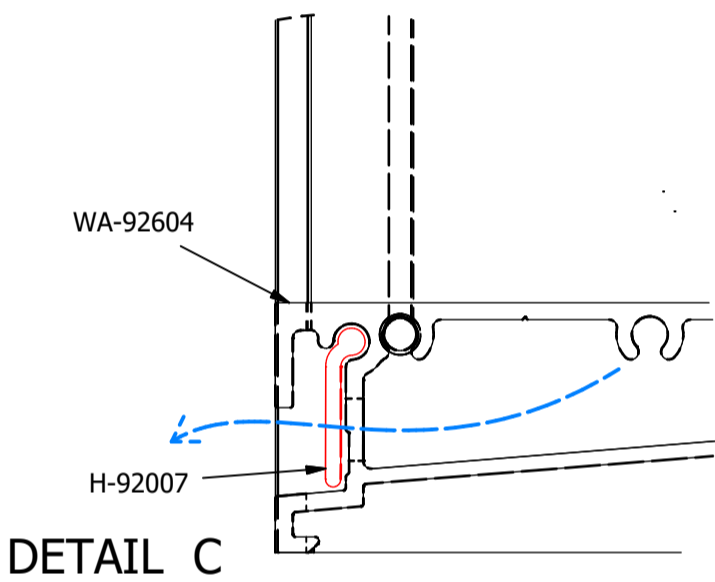
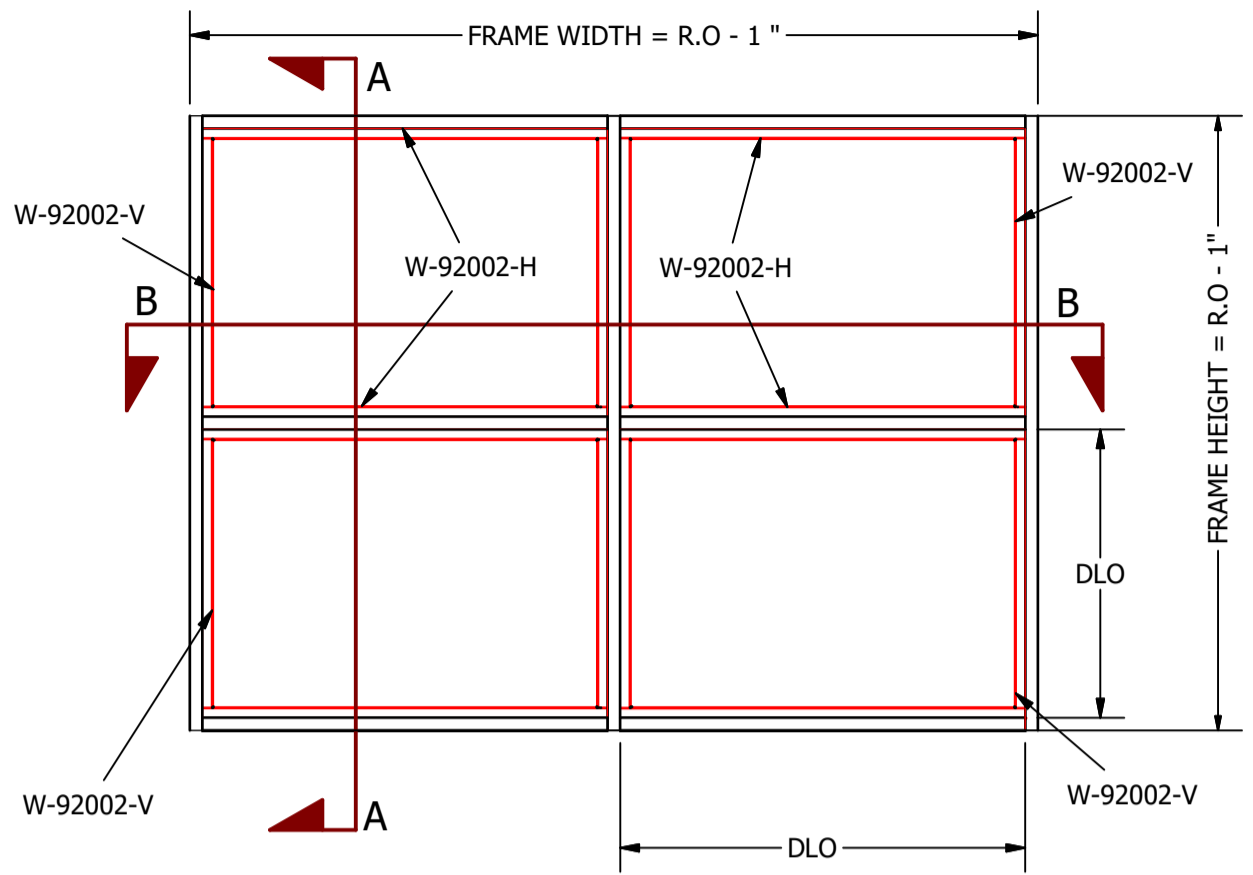
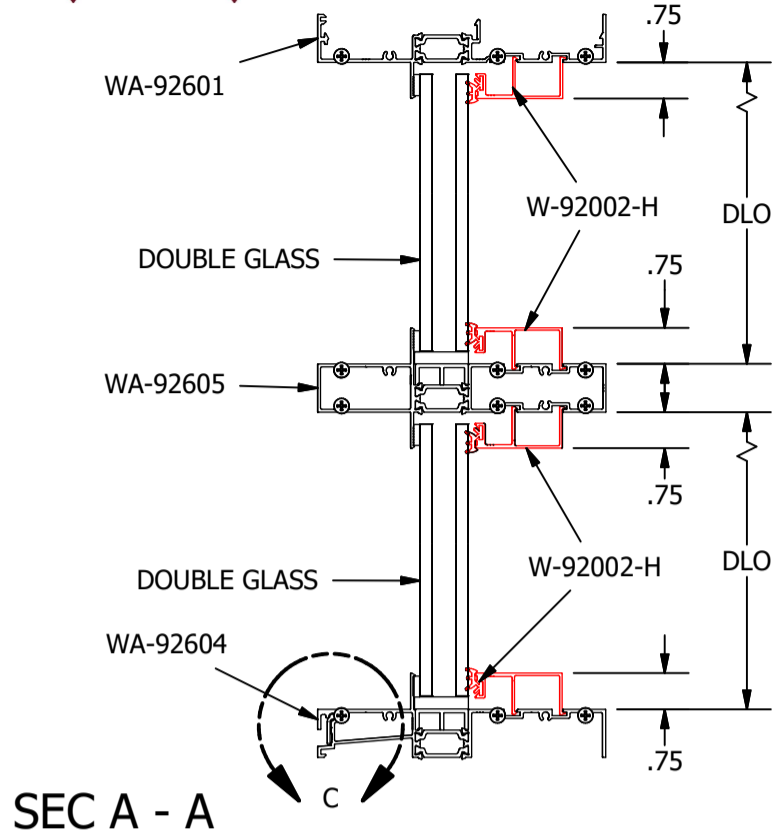


Notch @ Top & Bottom

Notch @ Transom

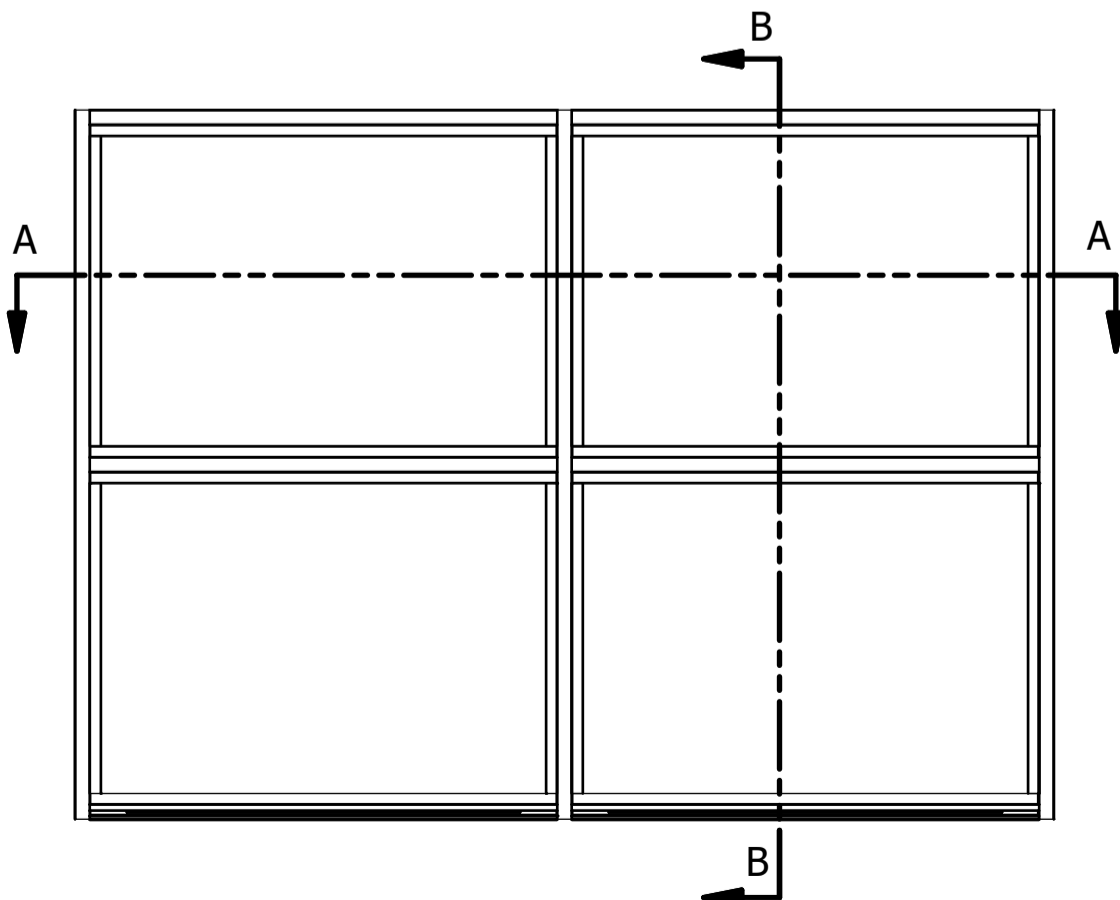
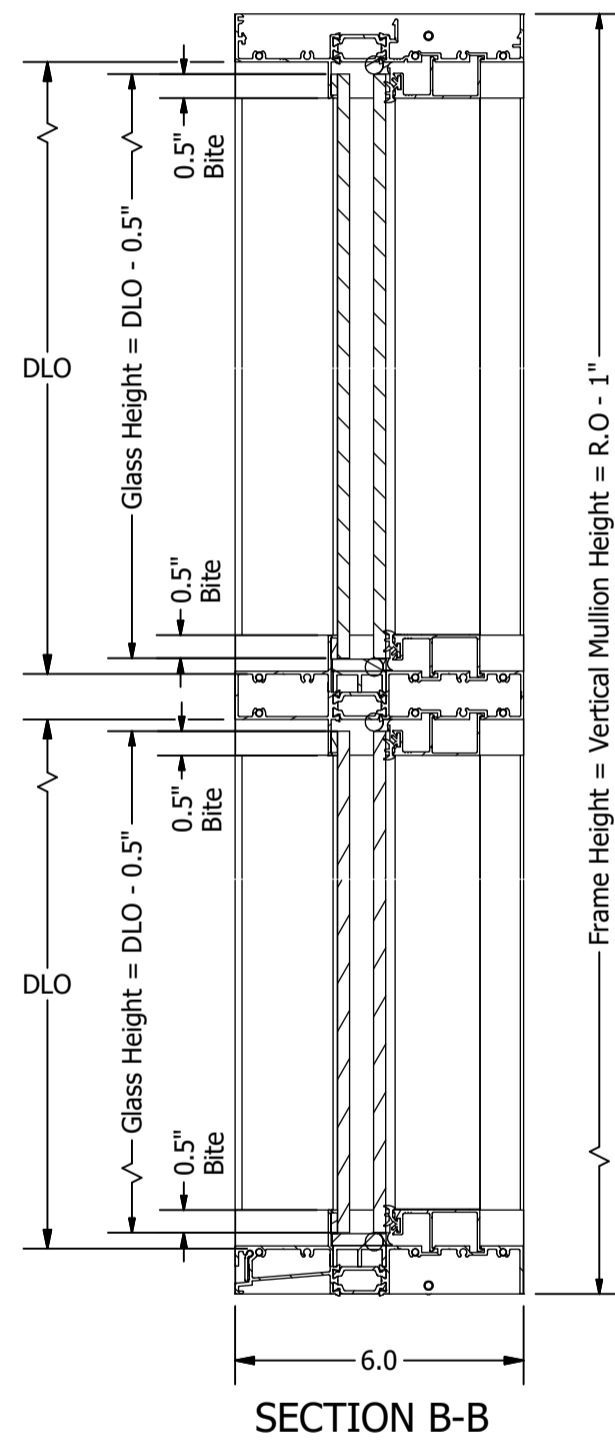
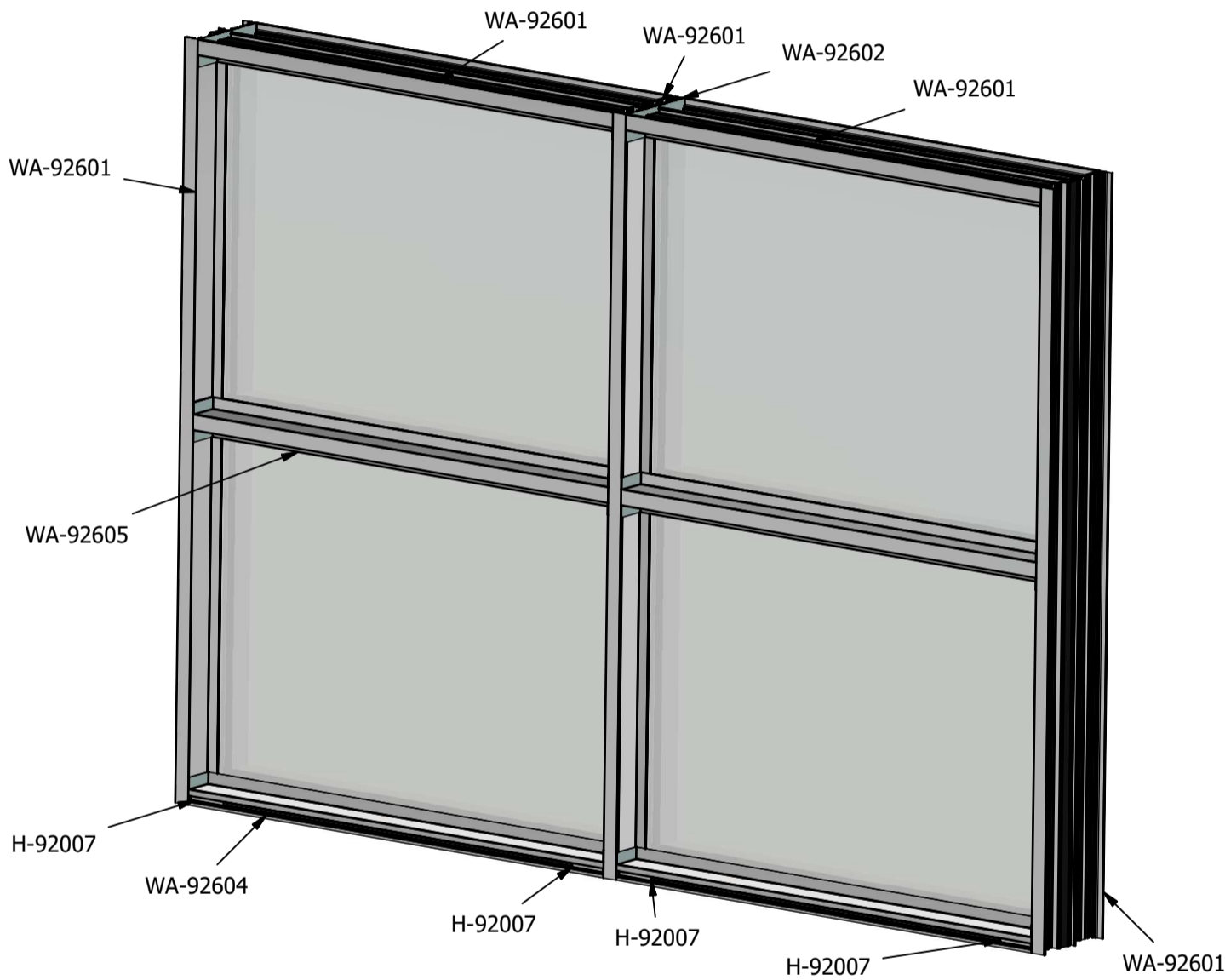
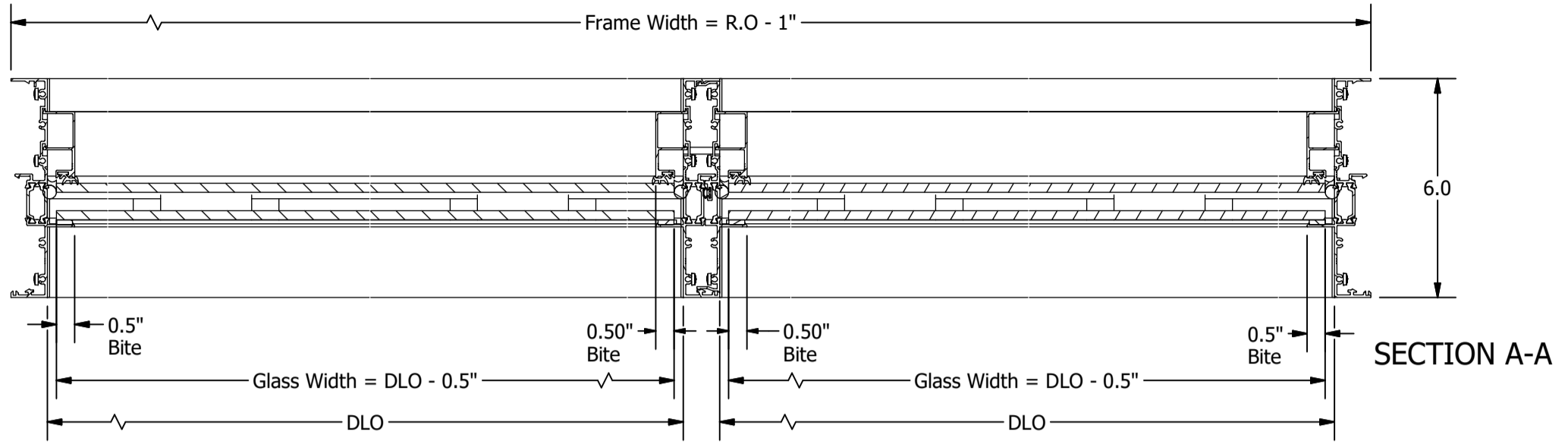






ASSEMBLY

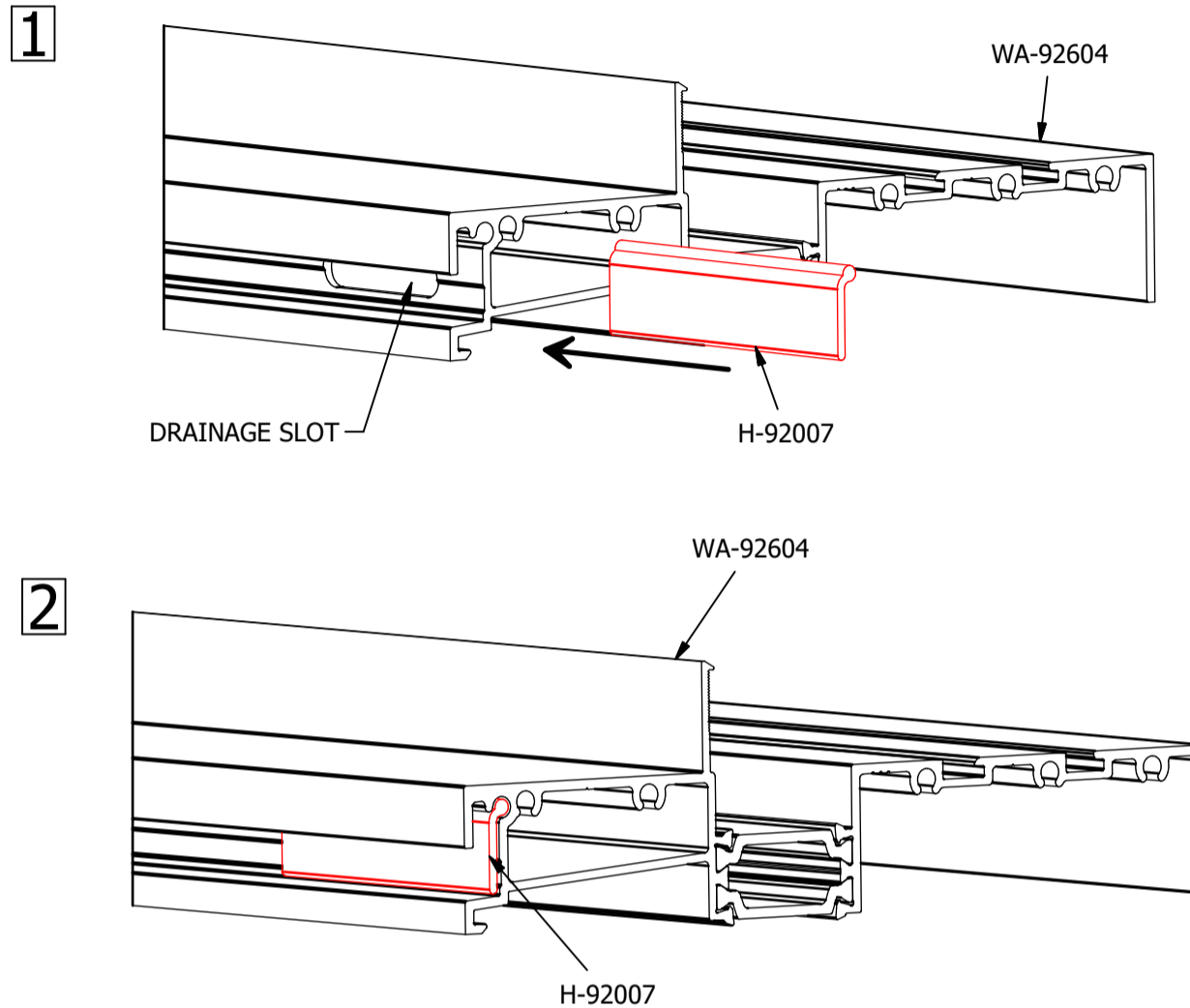
STEPS



- Notes:**
- DLO : Day light opening
 - R.O : Rough opening
 - Glass Height = DLO - 0.5"
 - Glass Width = DLO - 0.5"
 - Frame Height = R.O - 1"
 - Frame Width = R.O - 1"

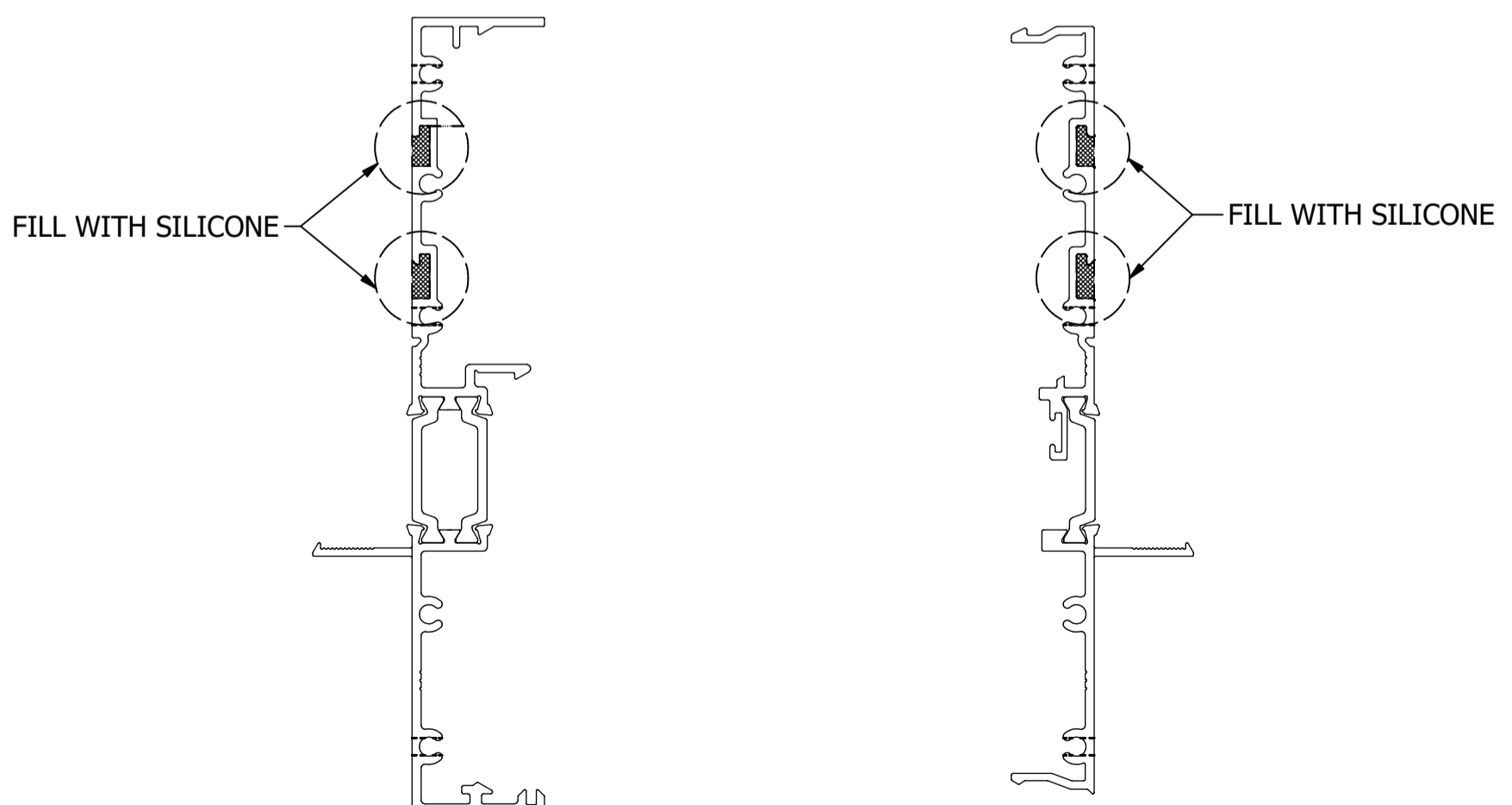
STEP 1 (Water Gate) :

Slide the Watergate, H-92007, into the outer sill groove and ensure it covers the drainage slot.



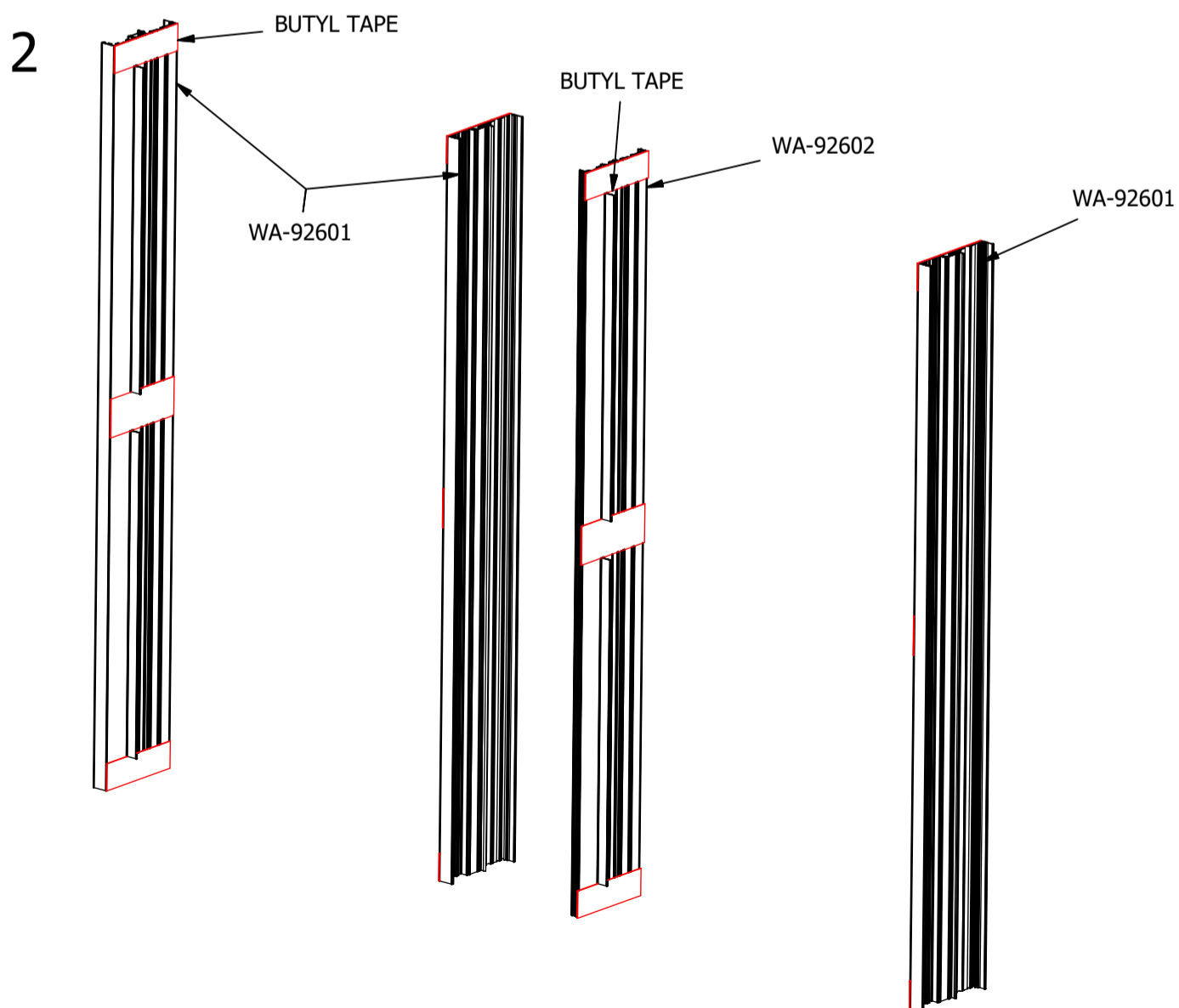
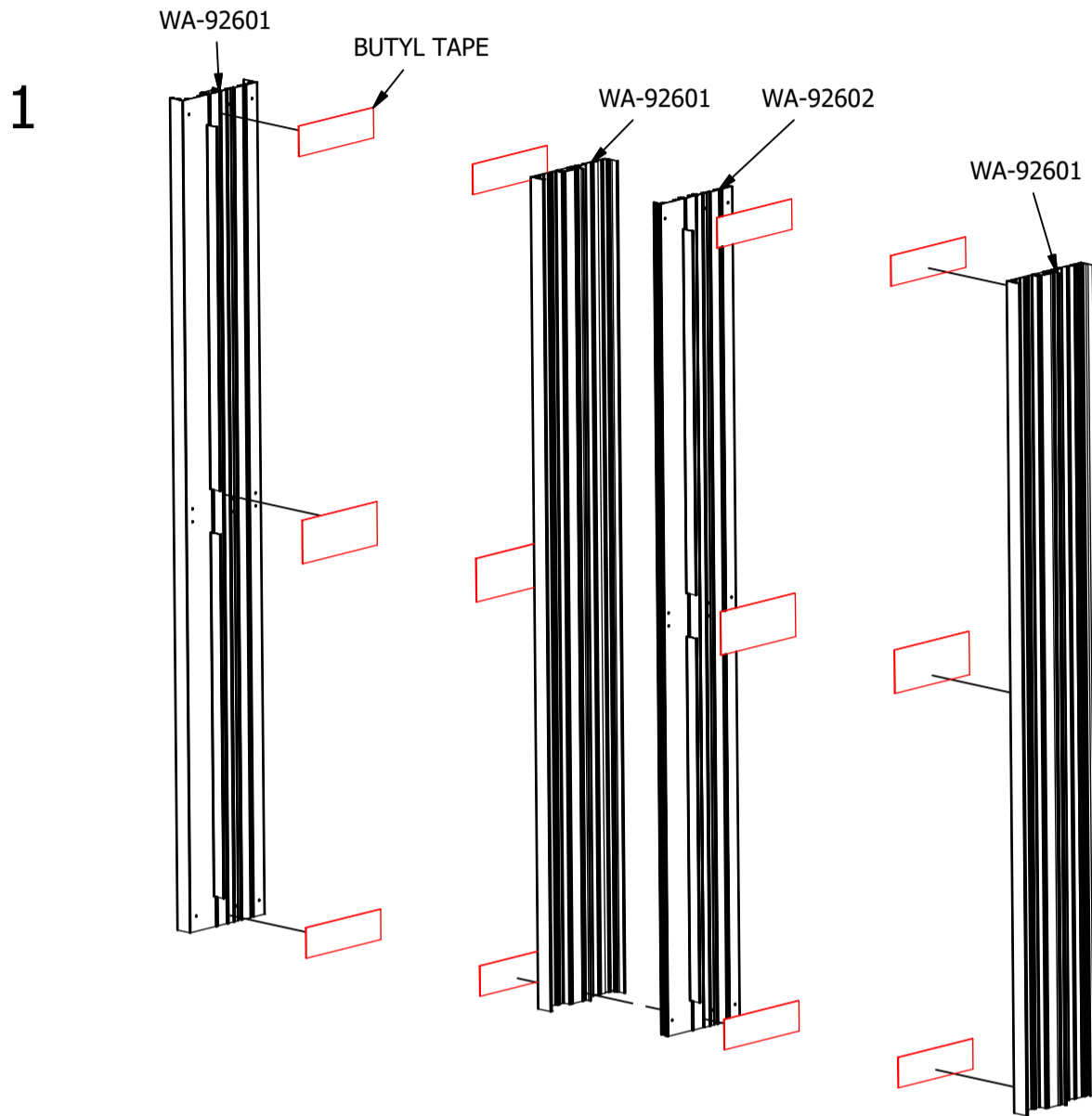
STEP 2 (Silicone) :

Fill the grooves in the vertical mullions at the joint location with silicone.



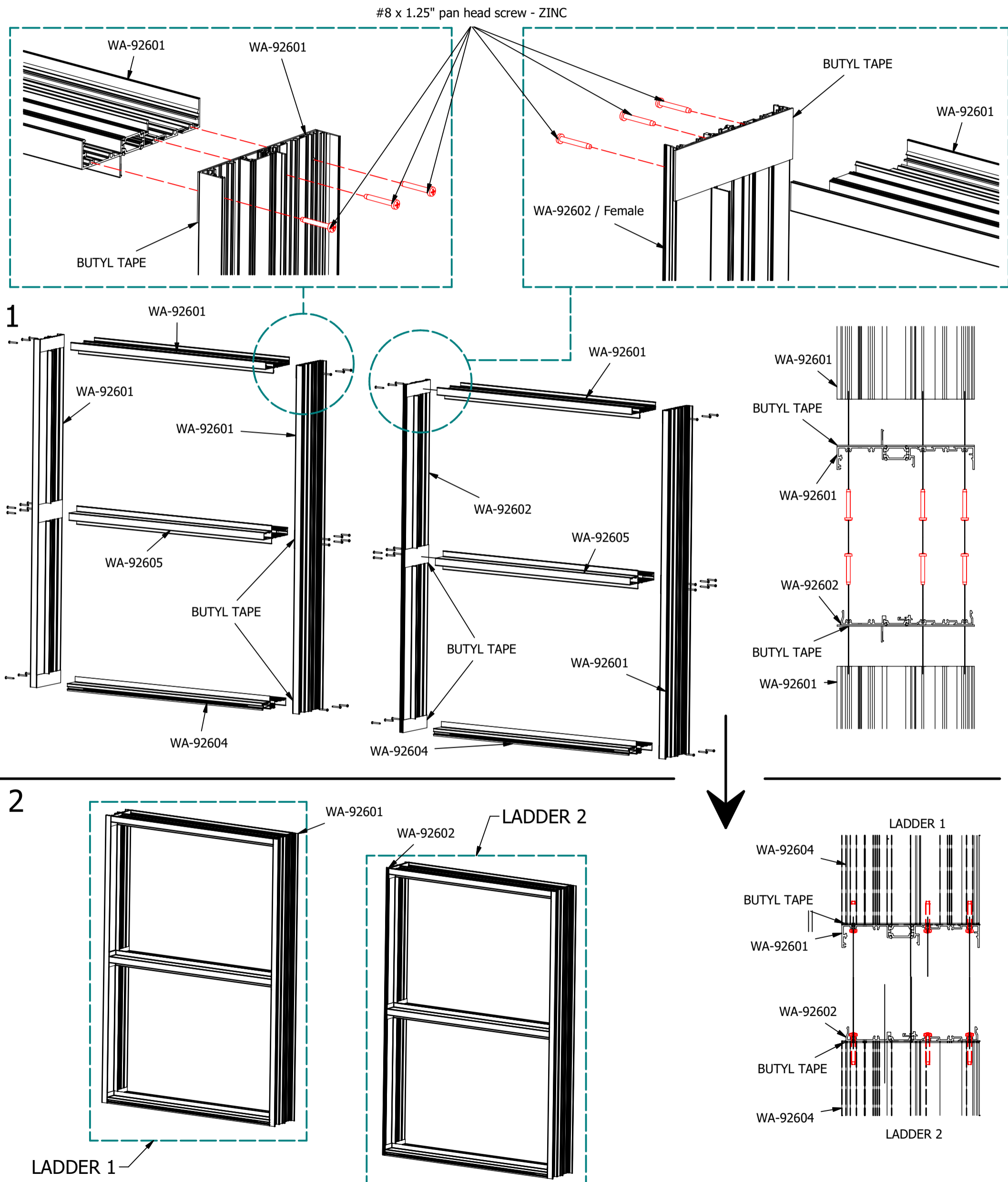
STEP 3 (Butyle Tape) :

Apply Butyl Tape (6" x 1", 1/16" thick) on the vertical mullions at the joint locations where the horizontals will be attached to the verticals.



STEP 4 (Ladder Frame Assembly) :

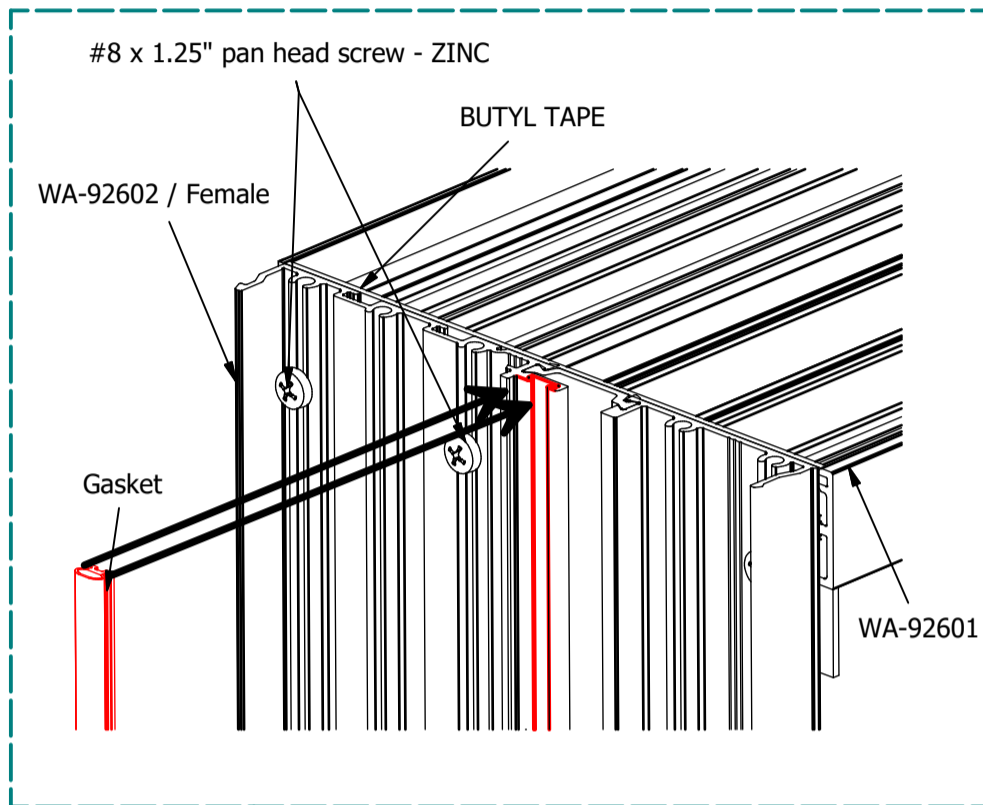
Screw the horizontals to the verticals through the Butyl tape using #8, 1.25" pan head zinc screws to form a ' Ladder ' frame assembly.



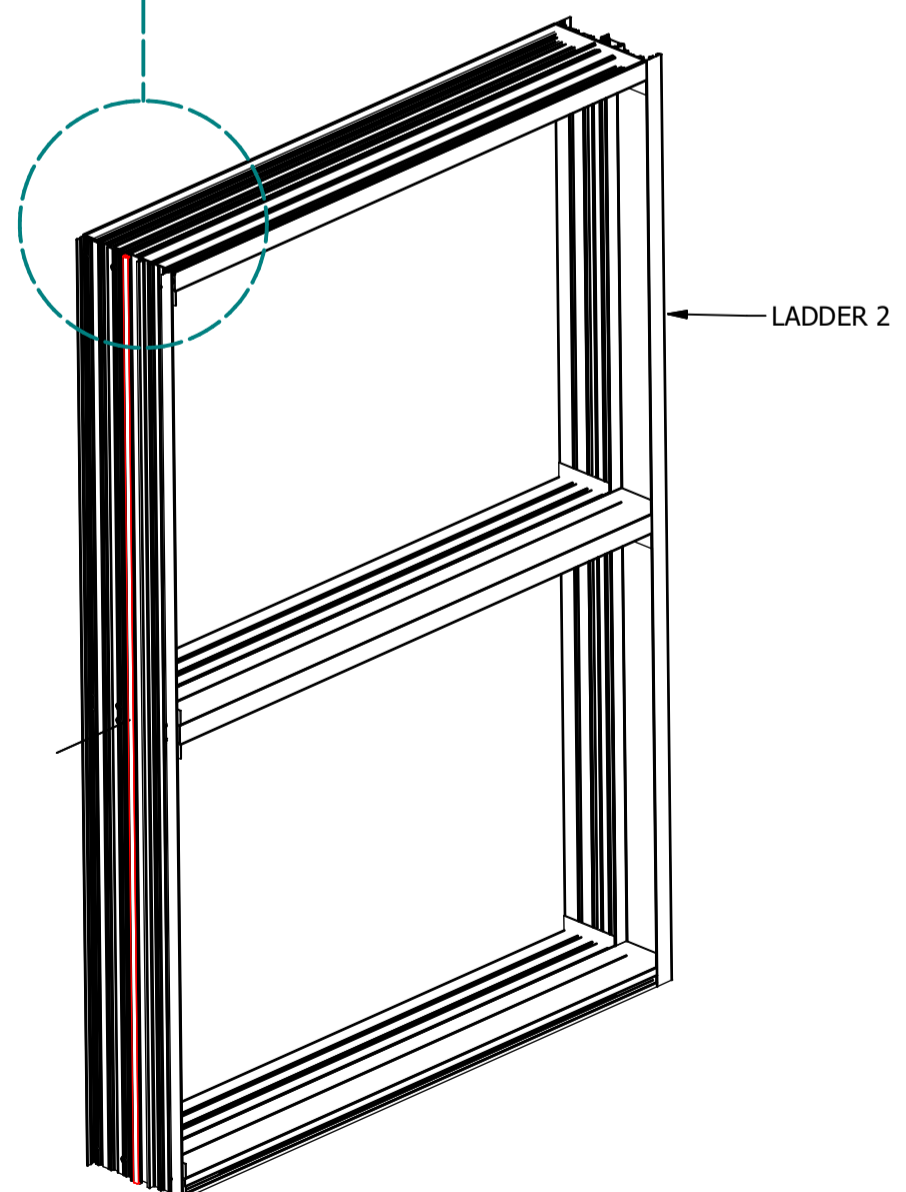
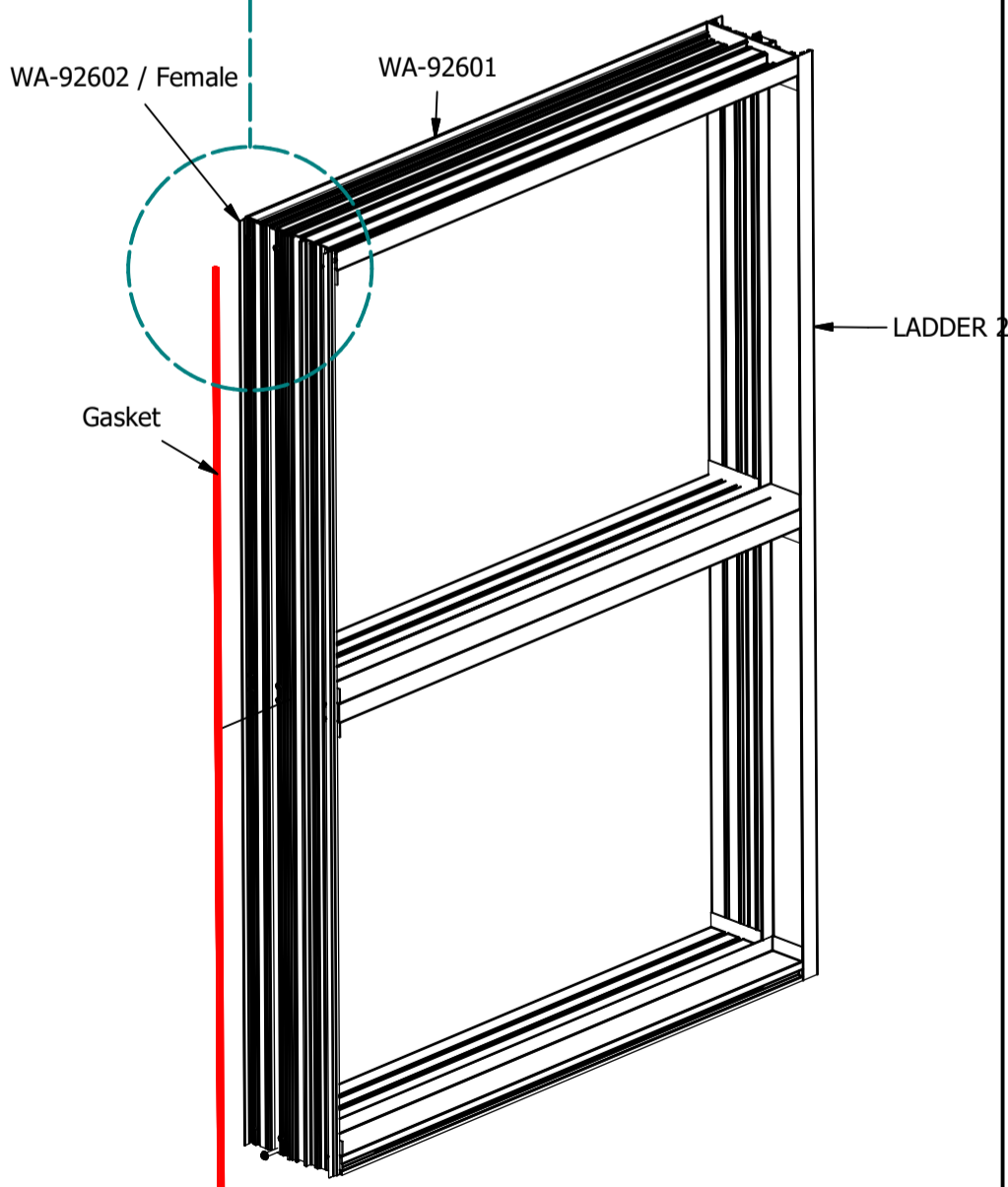
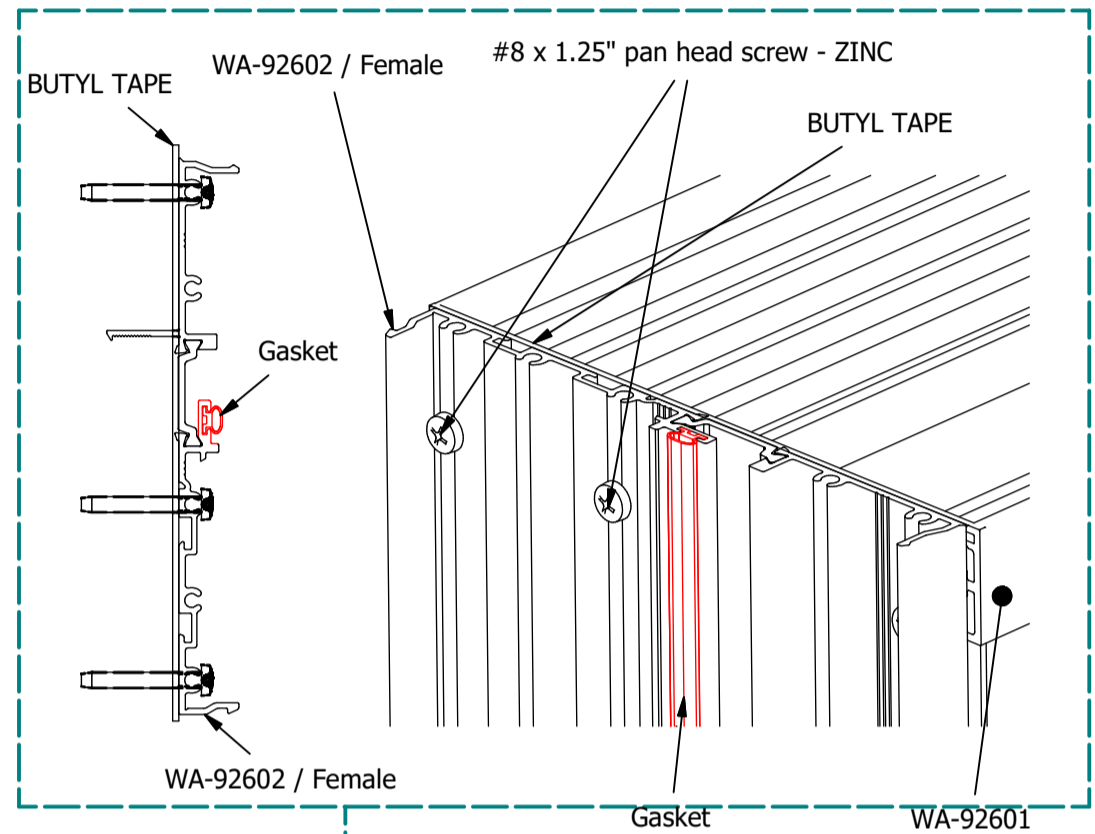
STEP 5 (Gasket Installation in Female Mullion) :

Attach the gasket into the female mullion, which is the vertical mullion in "Ladder 2", in the highlighted groove shown in the drawings below.

1

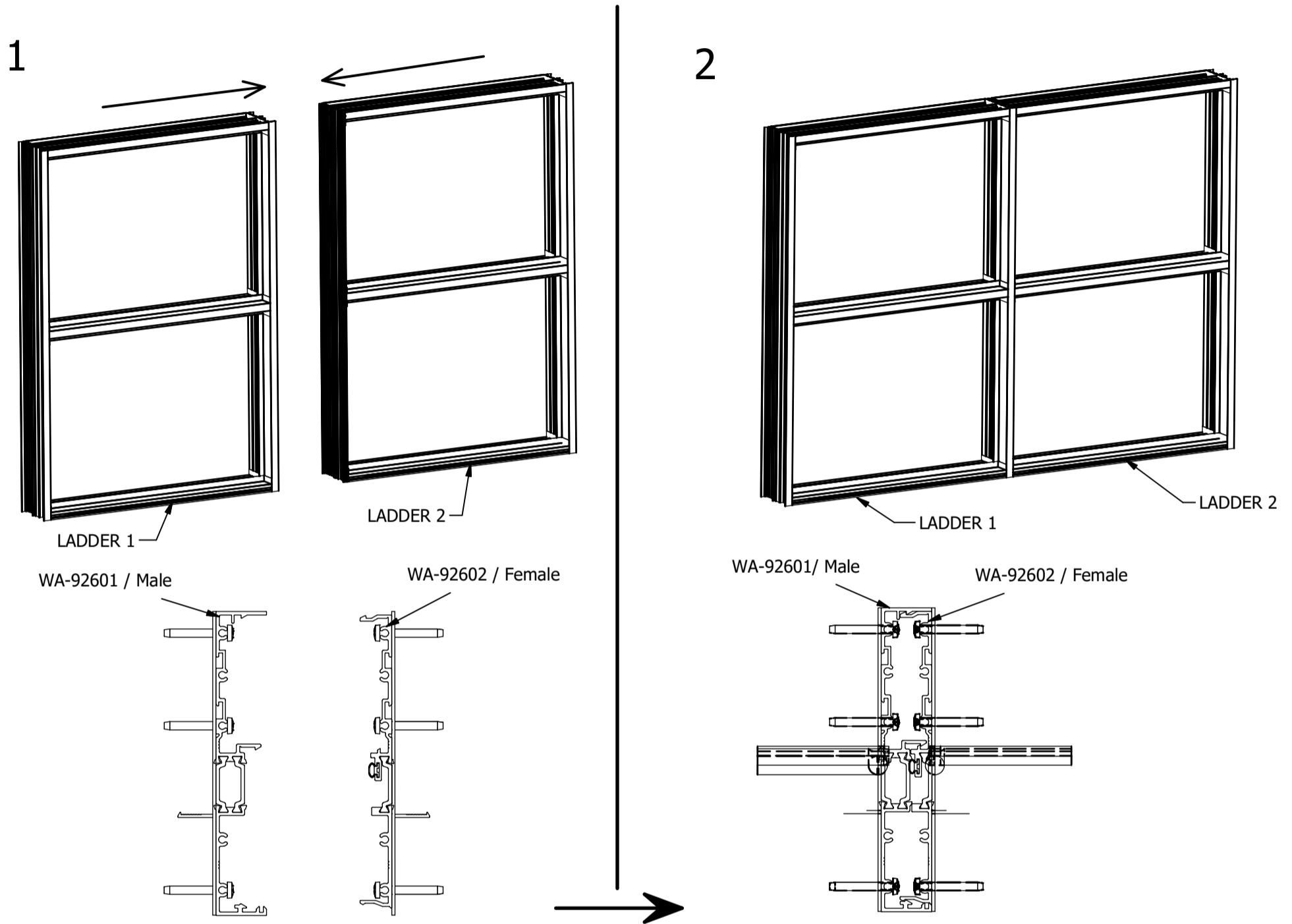


2



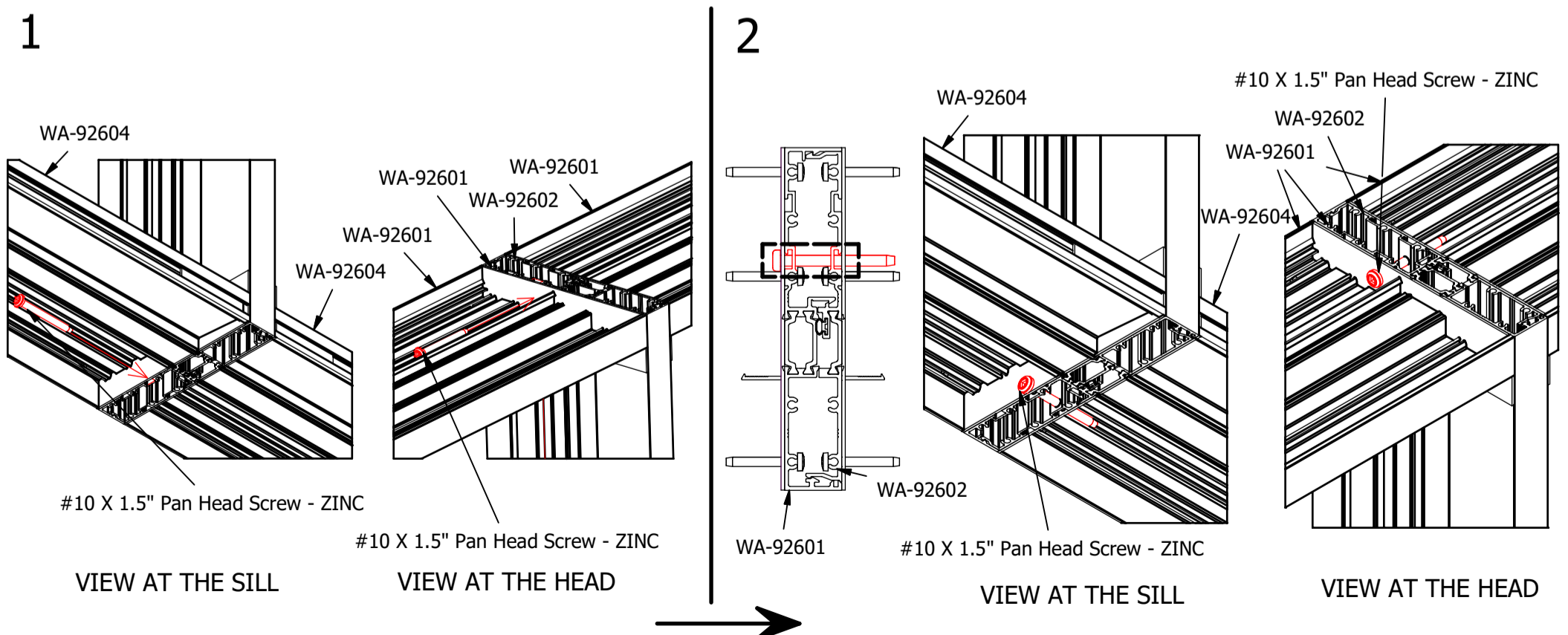
STEP 6: (Mullion Alignment and Fitting)

After ensuring that the male and female mullions of Ladder 1 and Ladder 2 are properly aligned, carefully slide the male profile into the female profile precisely to ensure that the profiles fit together snugly without forcing them.



STEP 7 (Securing the Ladder Assemblies) :

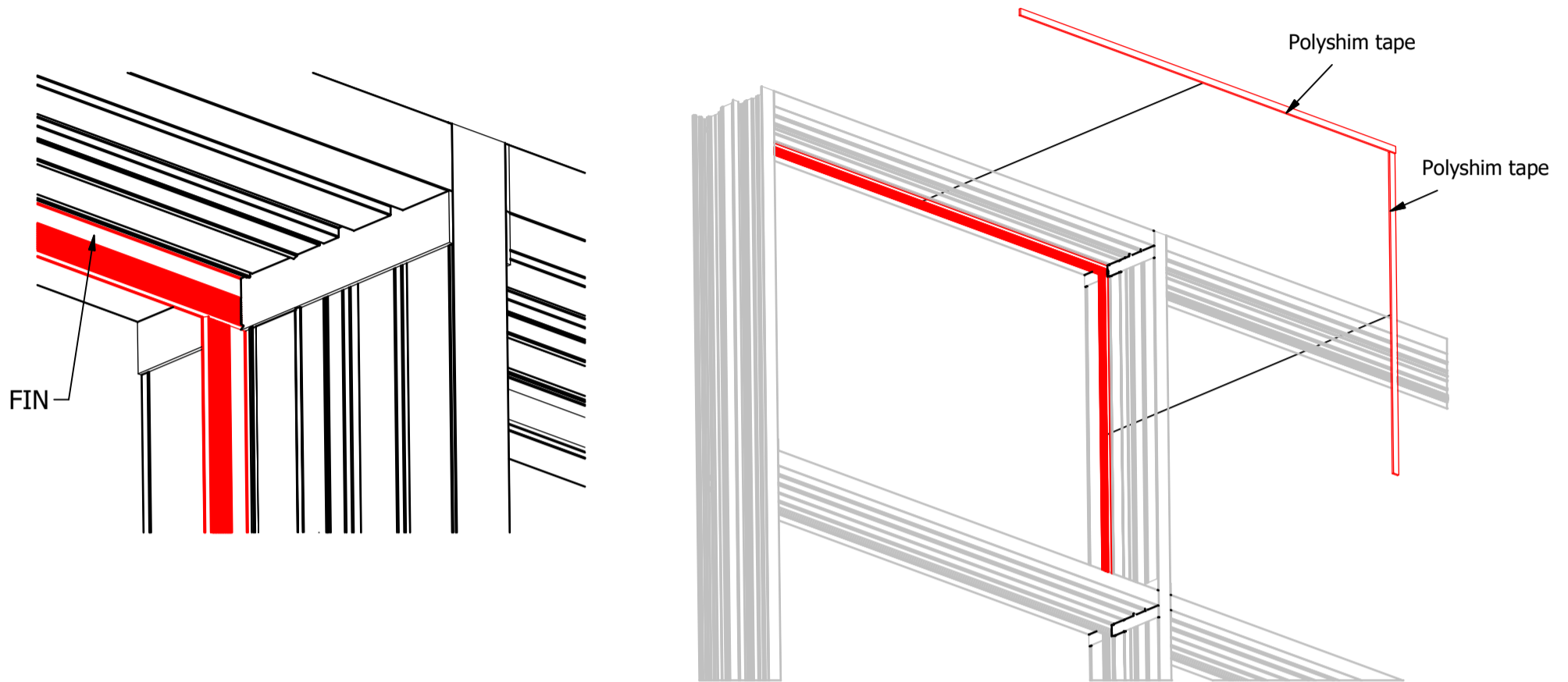
After completing the attachment, screw a #10, 1.5" pan head zinc screw into the vertical mullions through the highlighted groove in the drawings below, at both the head and sill, to ensure a proper snap fit.



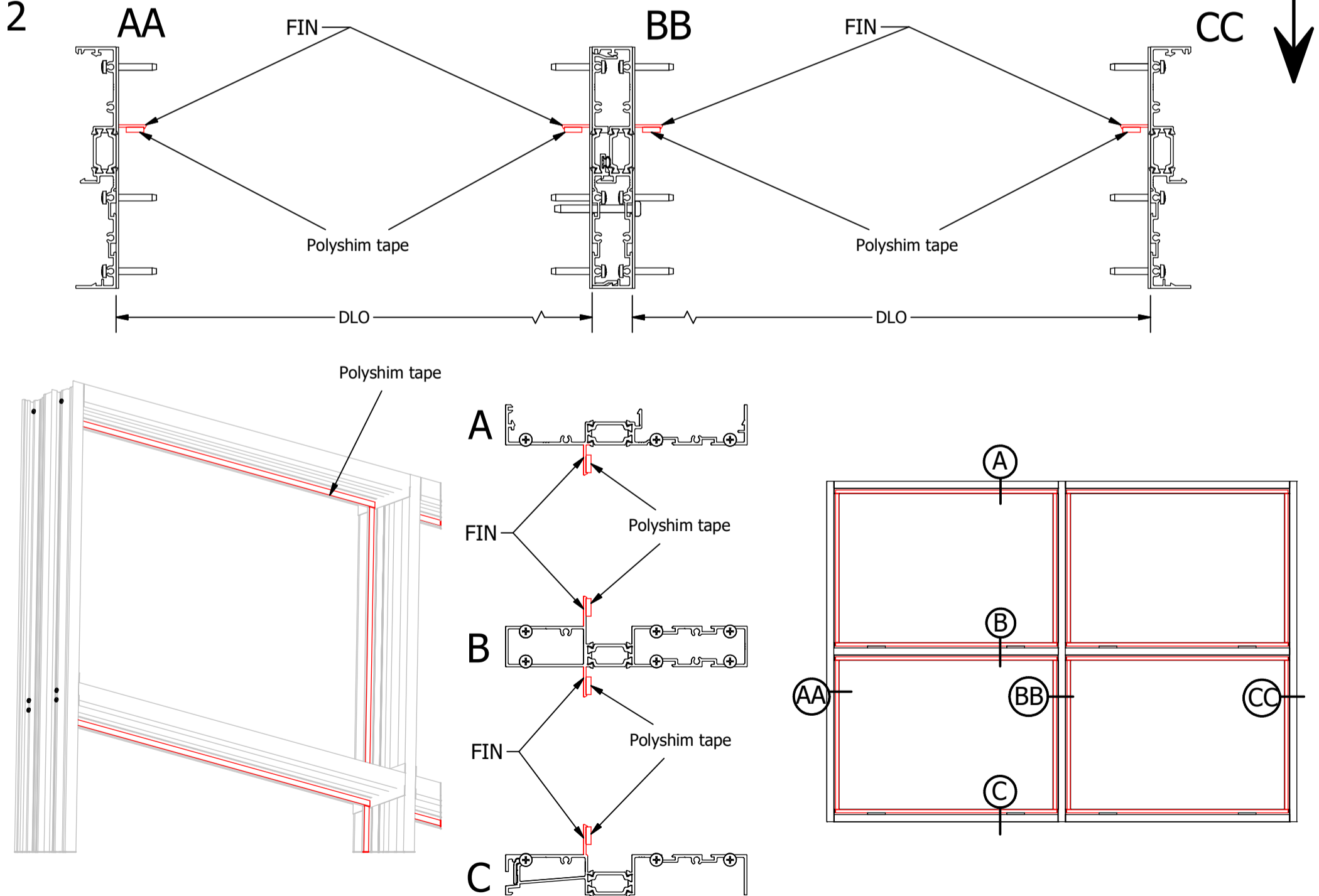
STEP 8 (Polyshim Tape Application):

Apply 1/8" thick Polyshim tape to the fins of the frame assembly after properly cleaning the frame.

1



2



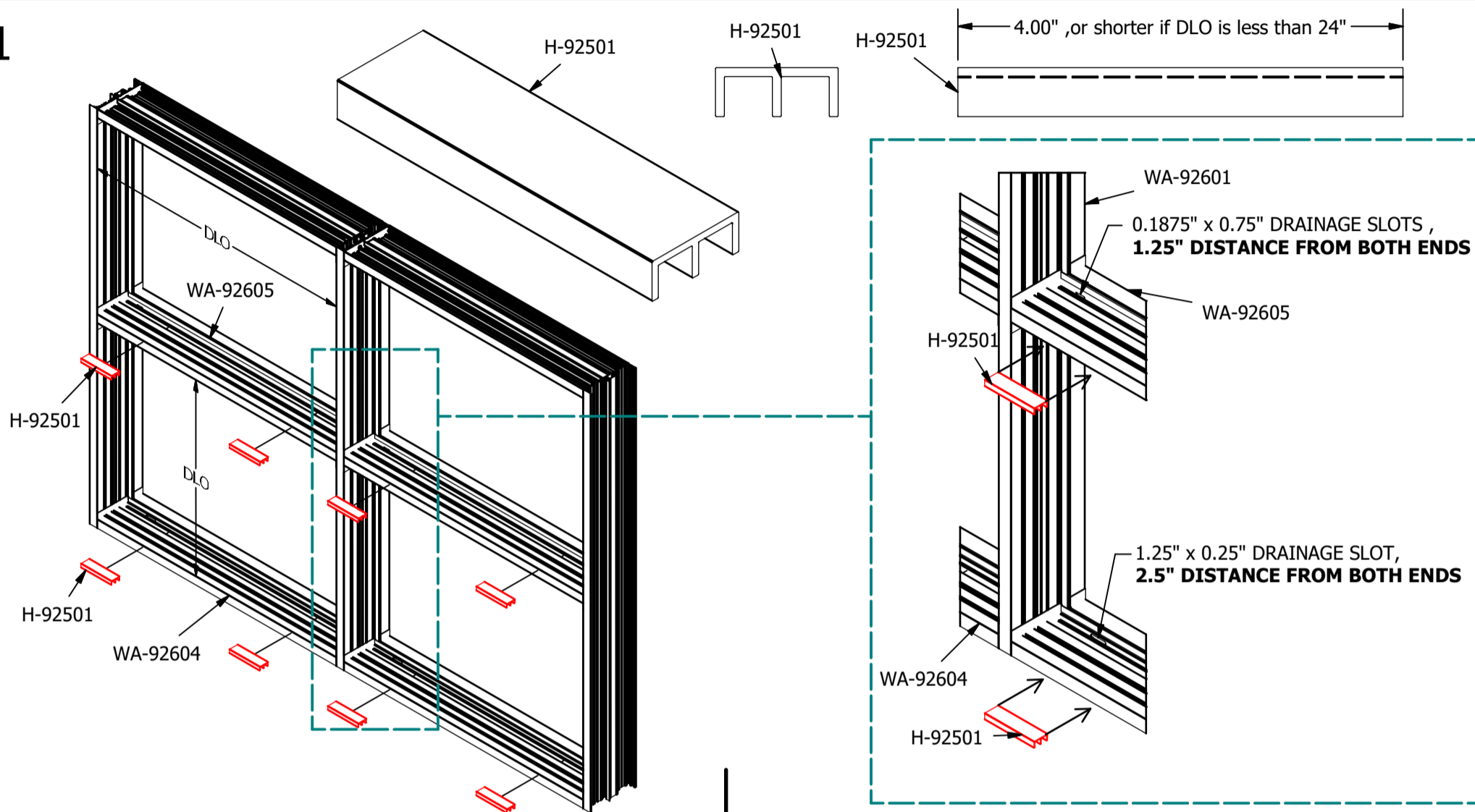
STEP 9 (PVC Glazing Support) :

Place a 4-inch PVC Glazing Support (**H-92501**) by gently pressing it into position, ensuring a 4-inch gap from both ends, using hand pressure to make sure it's properly seated.

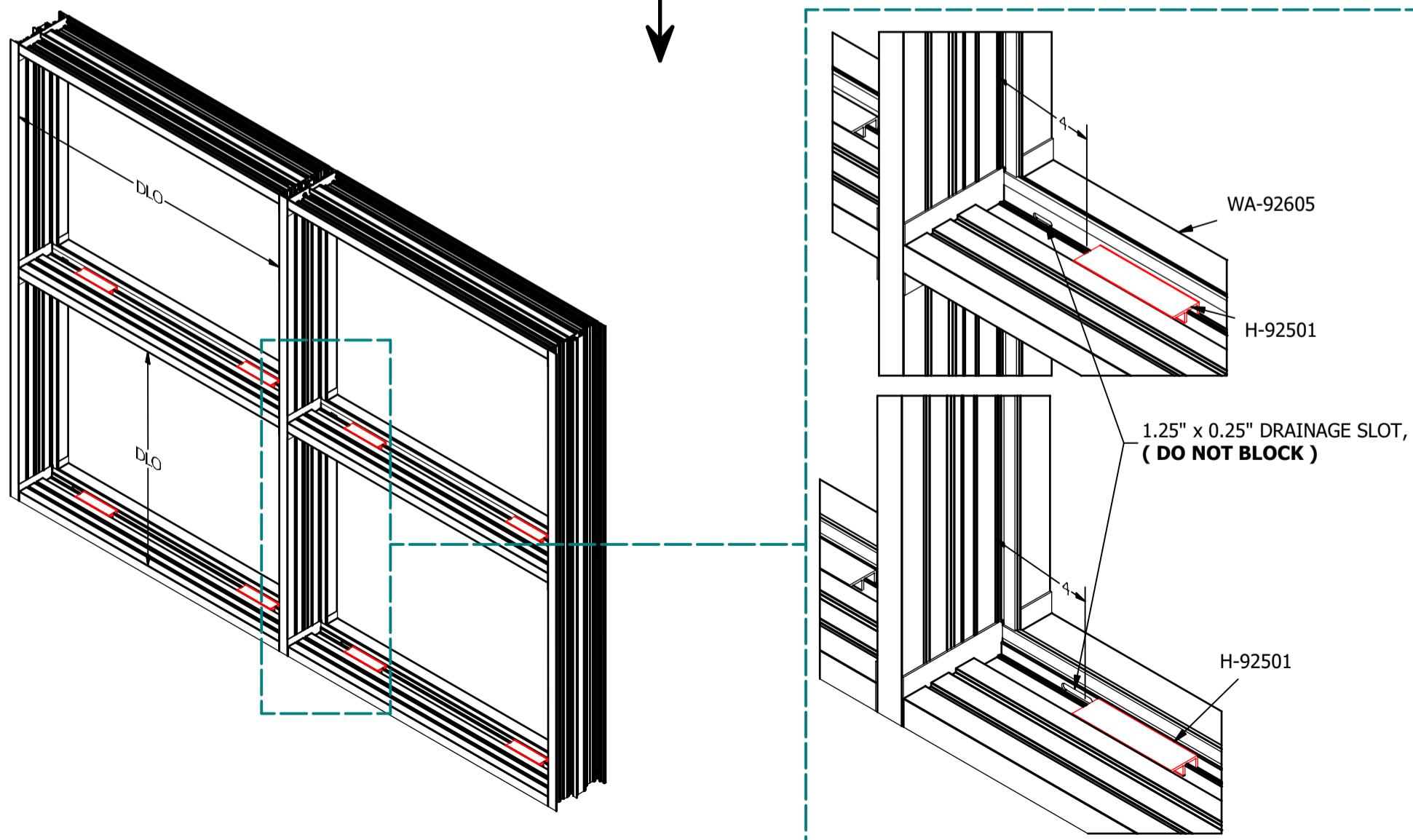
NOTE:

- If the DLO (Daylight Opening) is less than 24 inches, it is recommended to use a shorter PVC Glazing support and place it directly at both ends with no 4-inch gap.
- Ensure that the drainage holes in both the transom and sill remain unblocked.

1

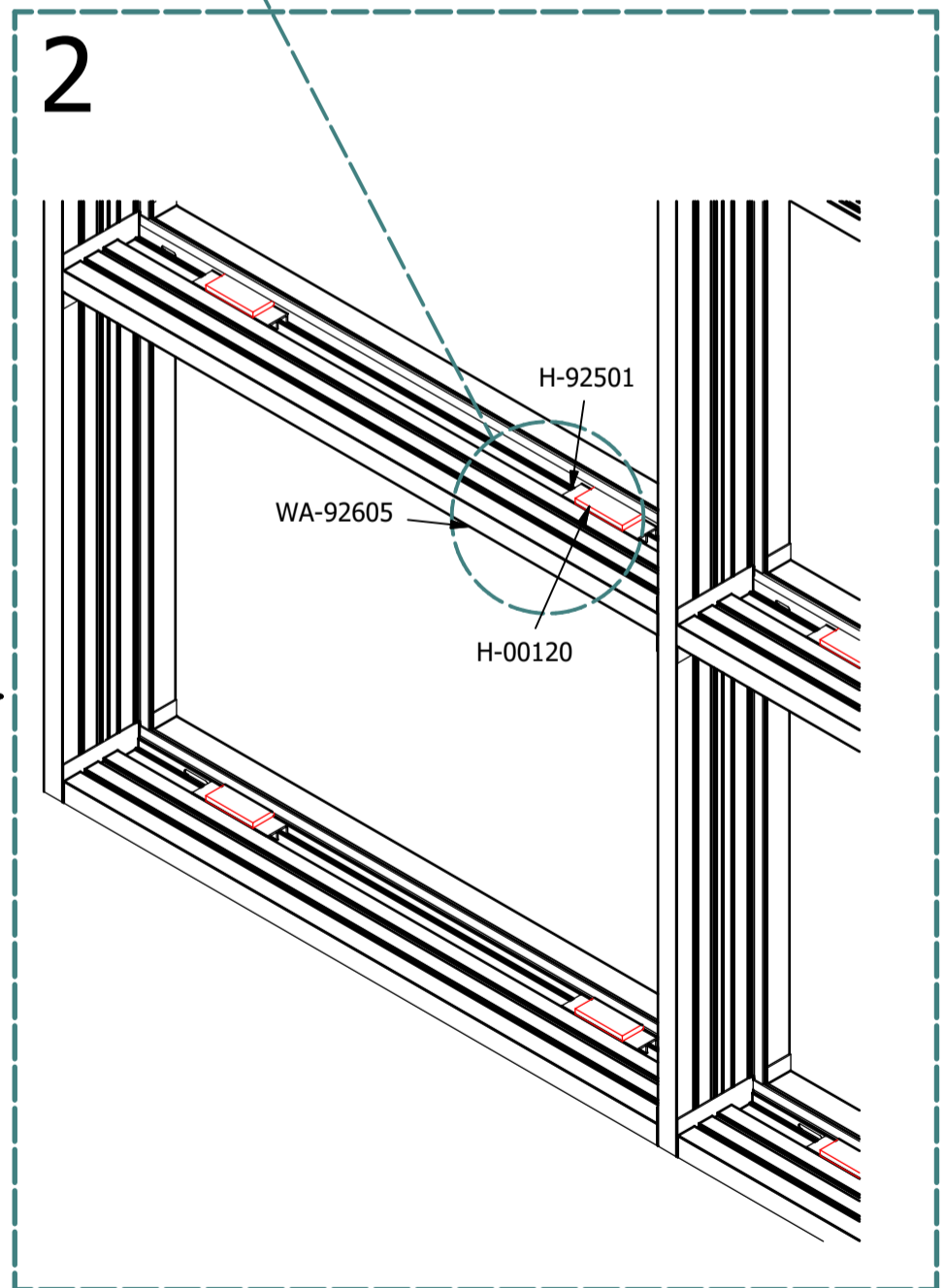
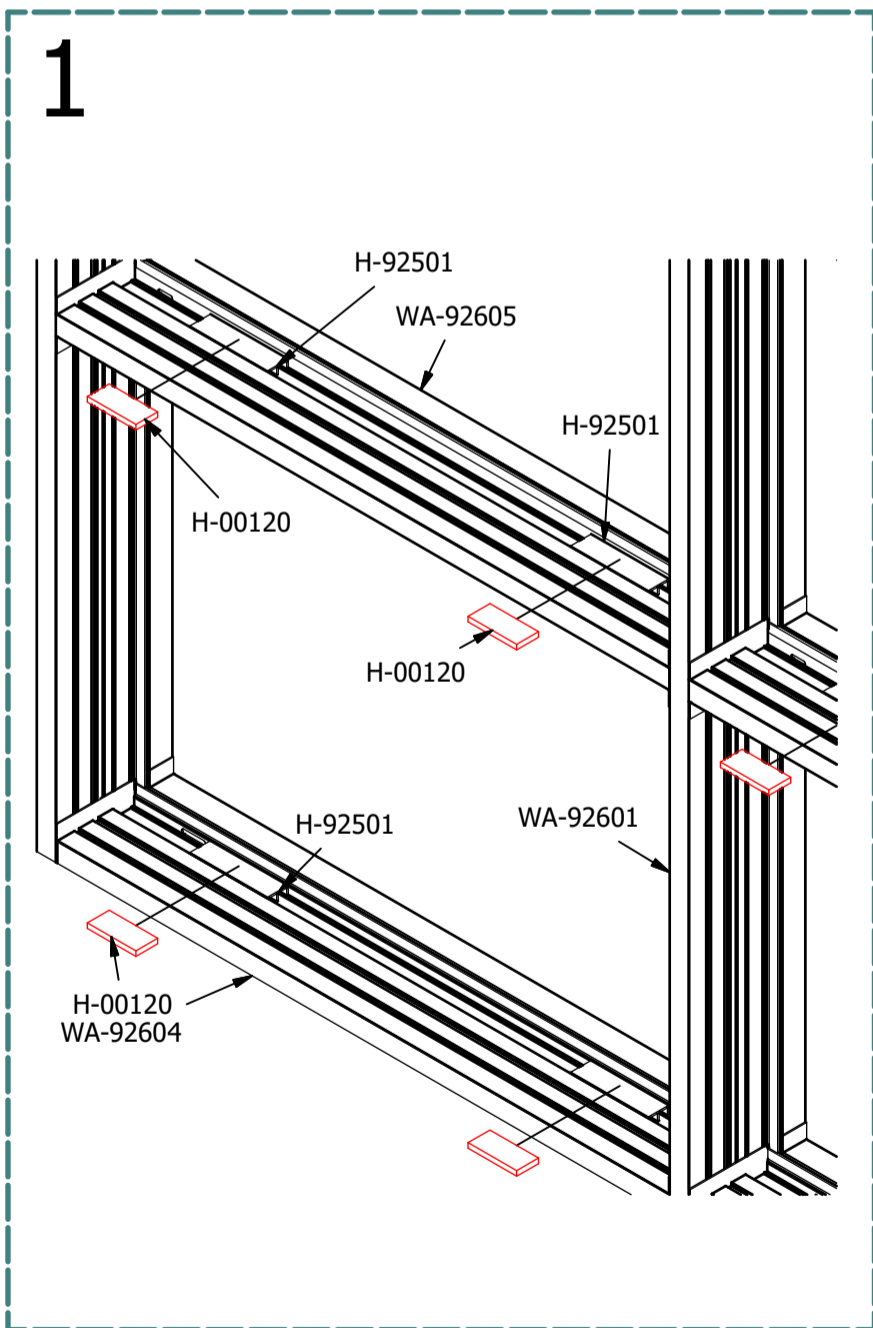
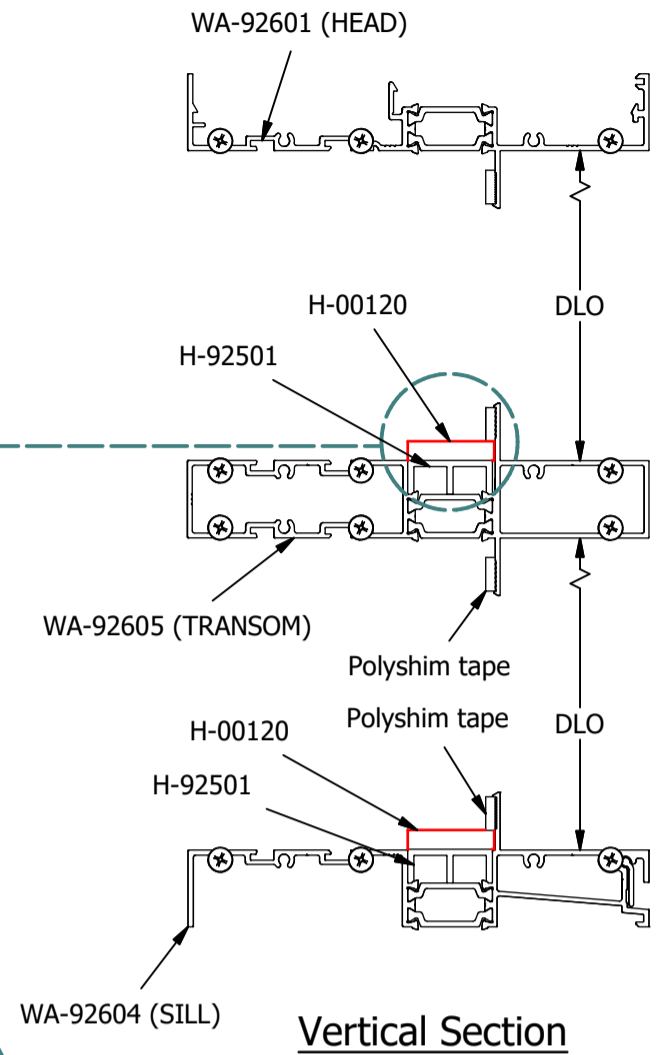
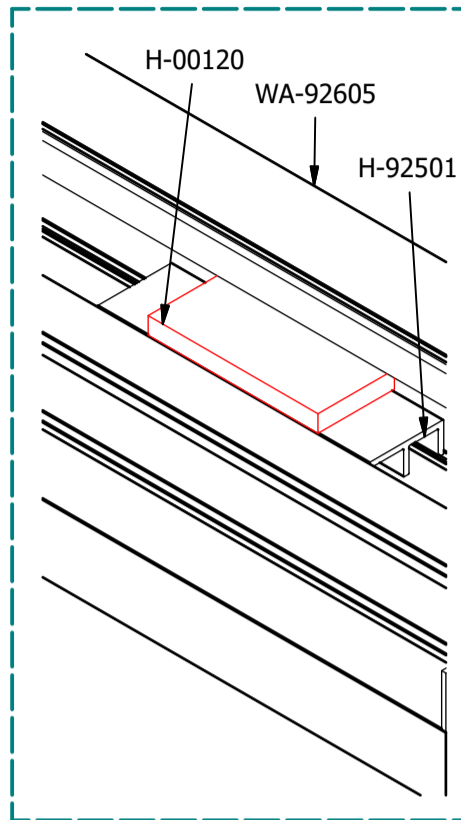


2



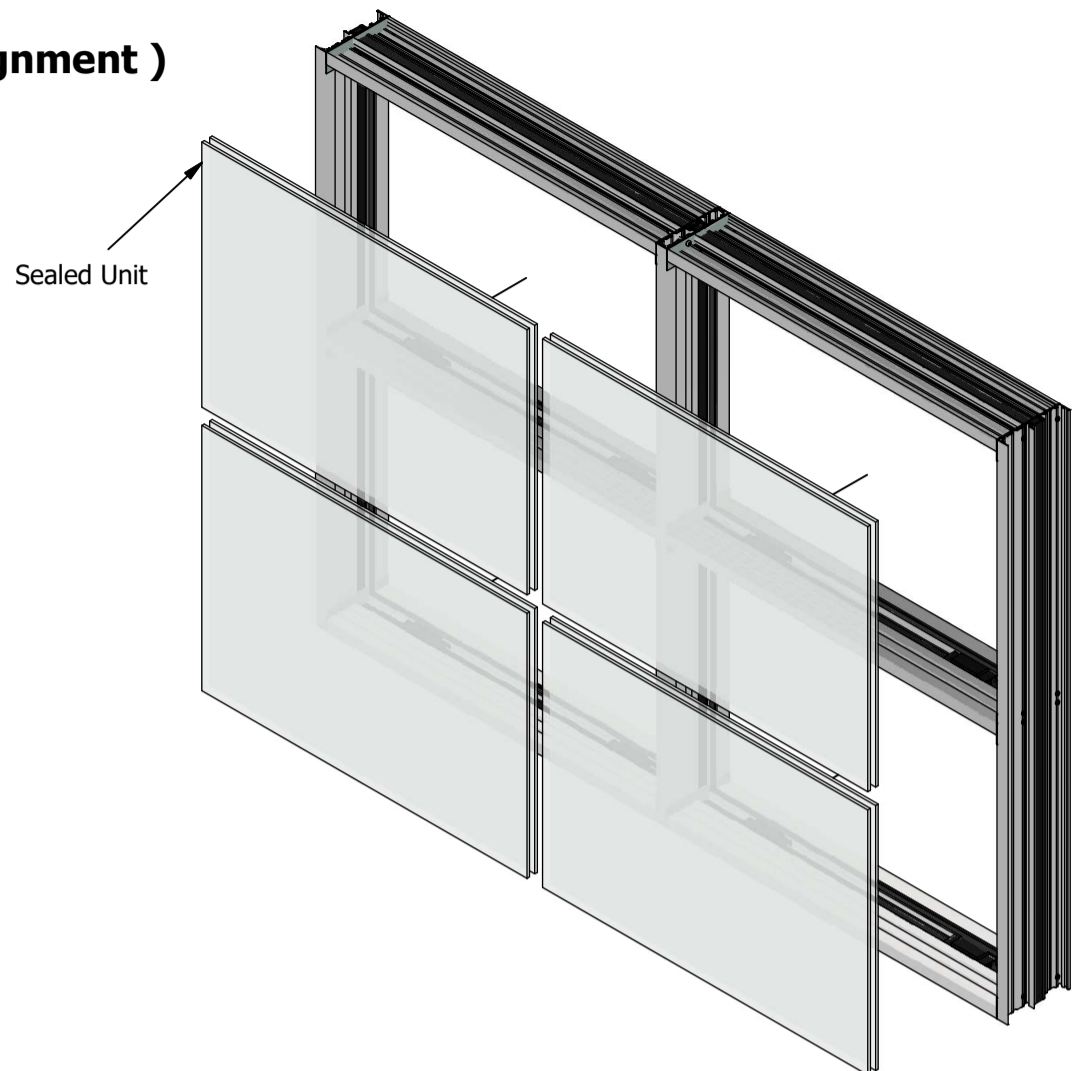
STEP 10 (Placing Setting Block on PVC Supports)

After placing the frame on-site and securing it as per the architect's instructions, and before installing the glass, place a ($\frac{1}{4}$ " x $1 \frac{1}{8}$ " x $2 \frac{1}{2}$ ") setting block (**H-00120**) on top of each PVC support (**H-92501**), ensuring it is centered & aligned.



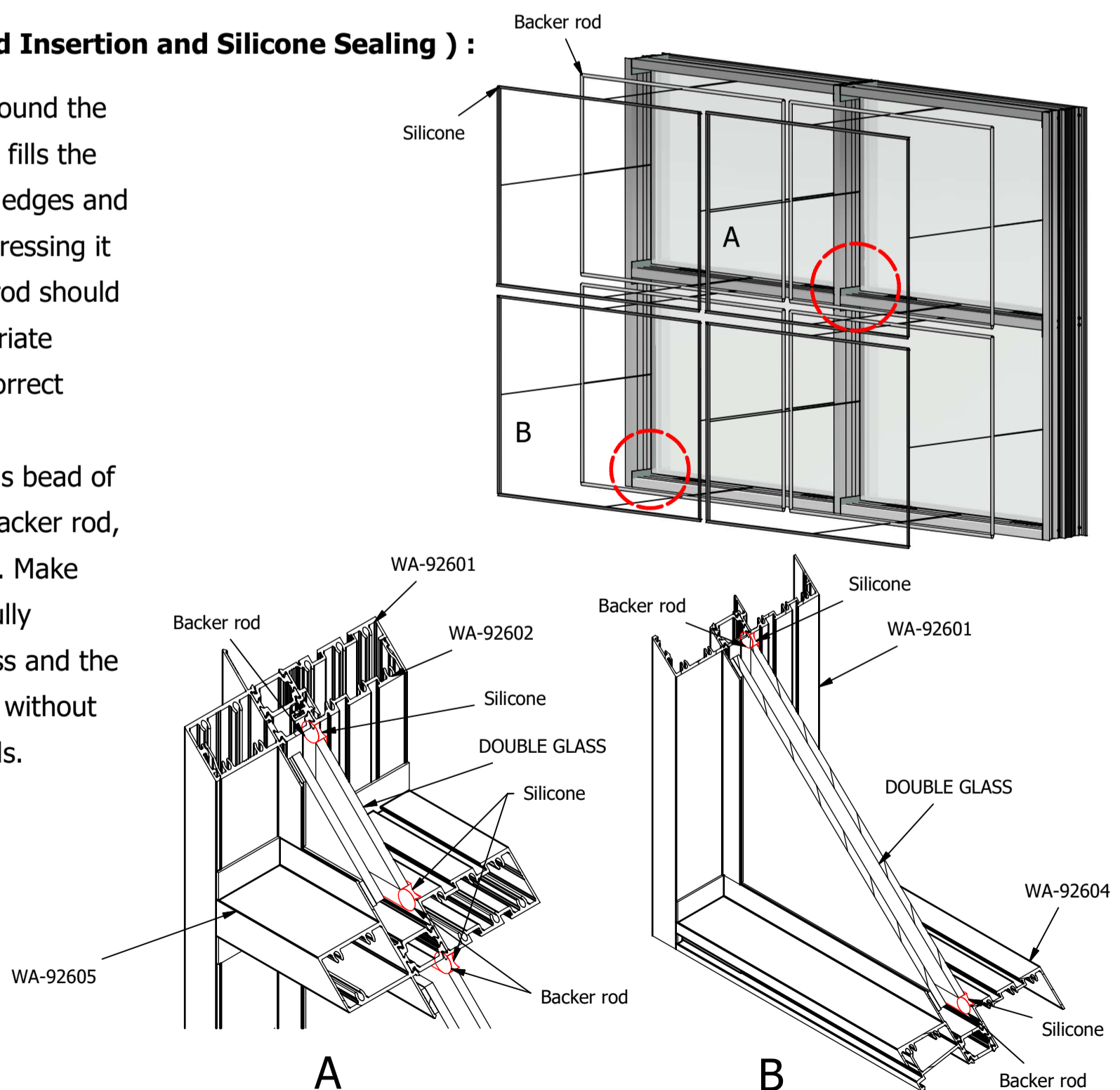
STEP 11: (Glass Panel Installation And Alignment)

- Carefully lift and place the glass panel into the frame, ensuring that the edges are aligned with the frame's glazing channels. Ensure that the glass is positioned evenly on the setting blocks, with no contact between the glass edges and the frame to avoid stress points.
- Once in place, verify that the glass is level and correctly seated within the frame before proceeding to secure it with Polyshim tape, Caulking and Glass stop.



STEP 12 (Backer Rod Insertion and Silicone Sealing) :

- Insert the backer rod around the glass panels, ensuring it fills the gaps between the glass edges and the frame without compressing it too tightly. The backer rod should be placed at the appropriate depth to allow for the correct amount of sealant.
- Then, apply a continuous bead of silicone in front of the backer rod, ensuring even coverage. Make sure the silicone bead fully adheres to both the glass and the frame for a proper seal, without leaving any gaps or voids.

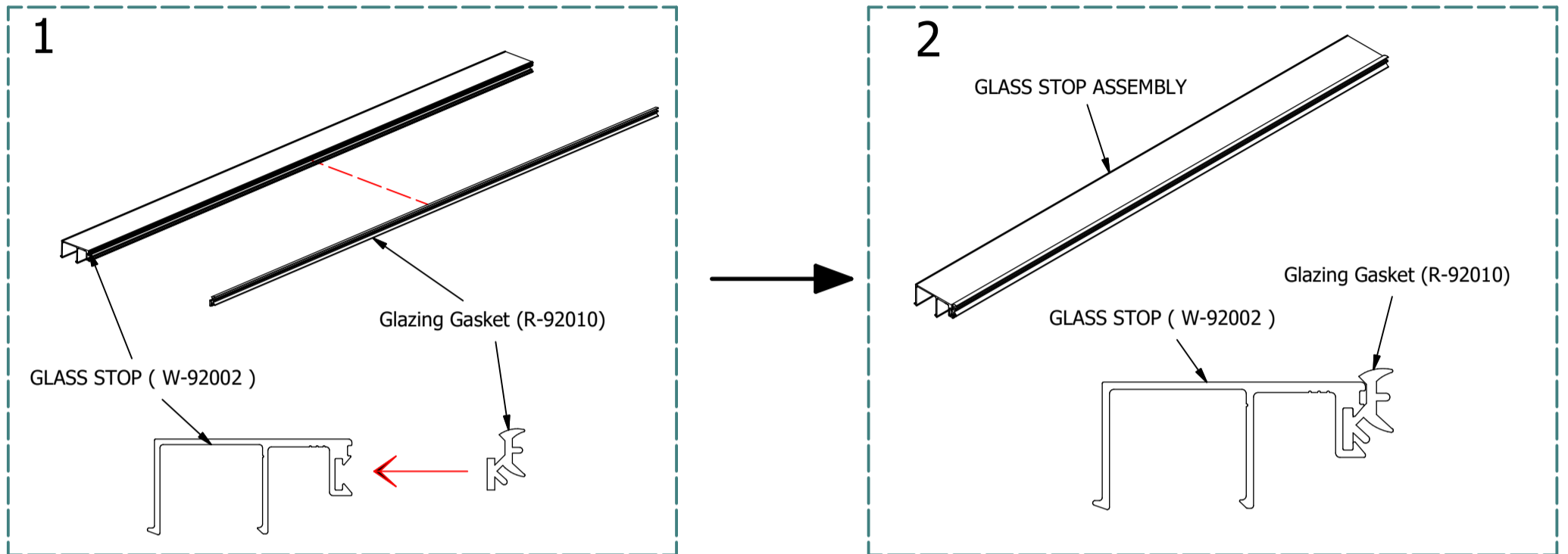


STEP 13 (Glass Stop Pre-Assembly and Installation) :

- Pre-assemble the glass stop with the gasket before securing it to the frame

NOTE:

Gasket Length = Glass Stop Length
(Refer to fabrication drawing - Page 05)



- Install the pre-assembled glass stop into the frame, using either hand pressure or a soft-faced hammer as needed. Ensure that the horizontal stops are installed before proceeding with the vertical stops to maintain proper alignment.

