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## Assembly

## Fabrication

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F a b r i c a t i o n

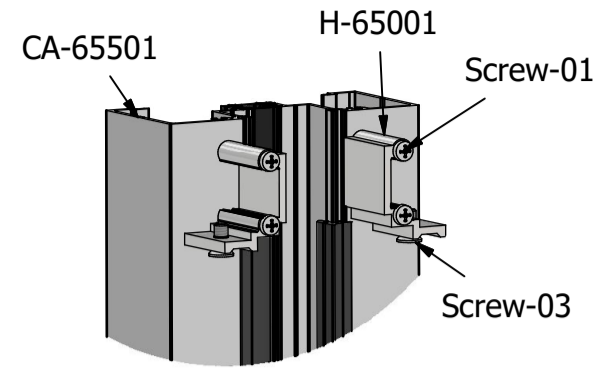
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D r a w i n g s



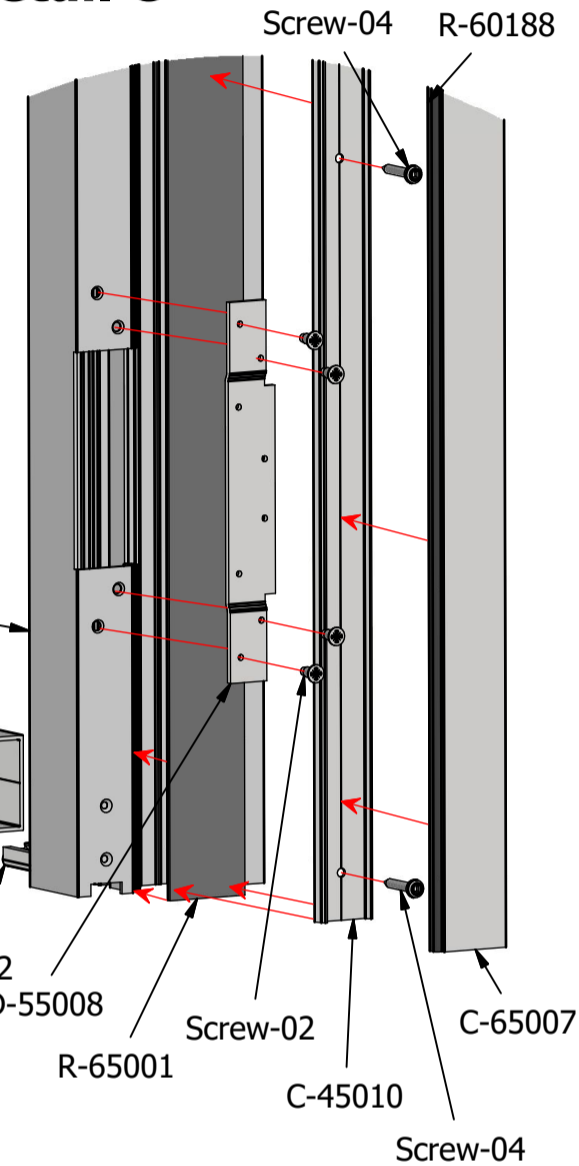
# 655 Series

PARTS LIST	
PART NUMBER	DESCRIPTION
C-45010	Door Stop Base
C-65004	1" Sealed Unit Glazing Stop
C-65007	Door Stop Cap
CA-65008	4 1/2" X 4 1/2" Male Half Corner Mullion
CA-65009	4 1/2" x 4 1/2" Female Half Corner Mullion
CA-65501	2 x 4 1/2" Open Back Perimeter
CA-65503	2 x 4 1/2" Horizontal Sill
CA-65514	2 x 4 1/2" 655 Mullion
Glass Panel	Glass Panel
H00120	(1/4 X 1 1/8 x 2 1/2" ) E.P.D.M Setting block
H-65001	Shear Block
H-65002	Shear Block Sill
HD-55008	Back up Plate for Butt Hinges
R-60188	Bulb Gasket
R-65001	PVC mullion Filler Adaptor
R-65002-R	Push-in Gasket
Screw-01	#8 X 2" pan head screw - ZINC (Shear blocks to Verticals)
Screw-02	12-24 x 1/2" Undercut Flat head screw ( Back up plates)
Screw-03	12-24 x 1/2" Flat head Screw ( Shear Blocks to Horizontals )
Screw-04	#10 X 1 1/4" pan head screw ( Door stop base)
Water deflector	Water deflector
C-65502	2 x 4 1/2" 655 Mullion

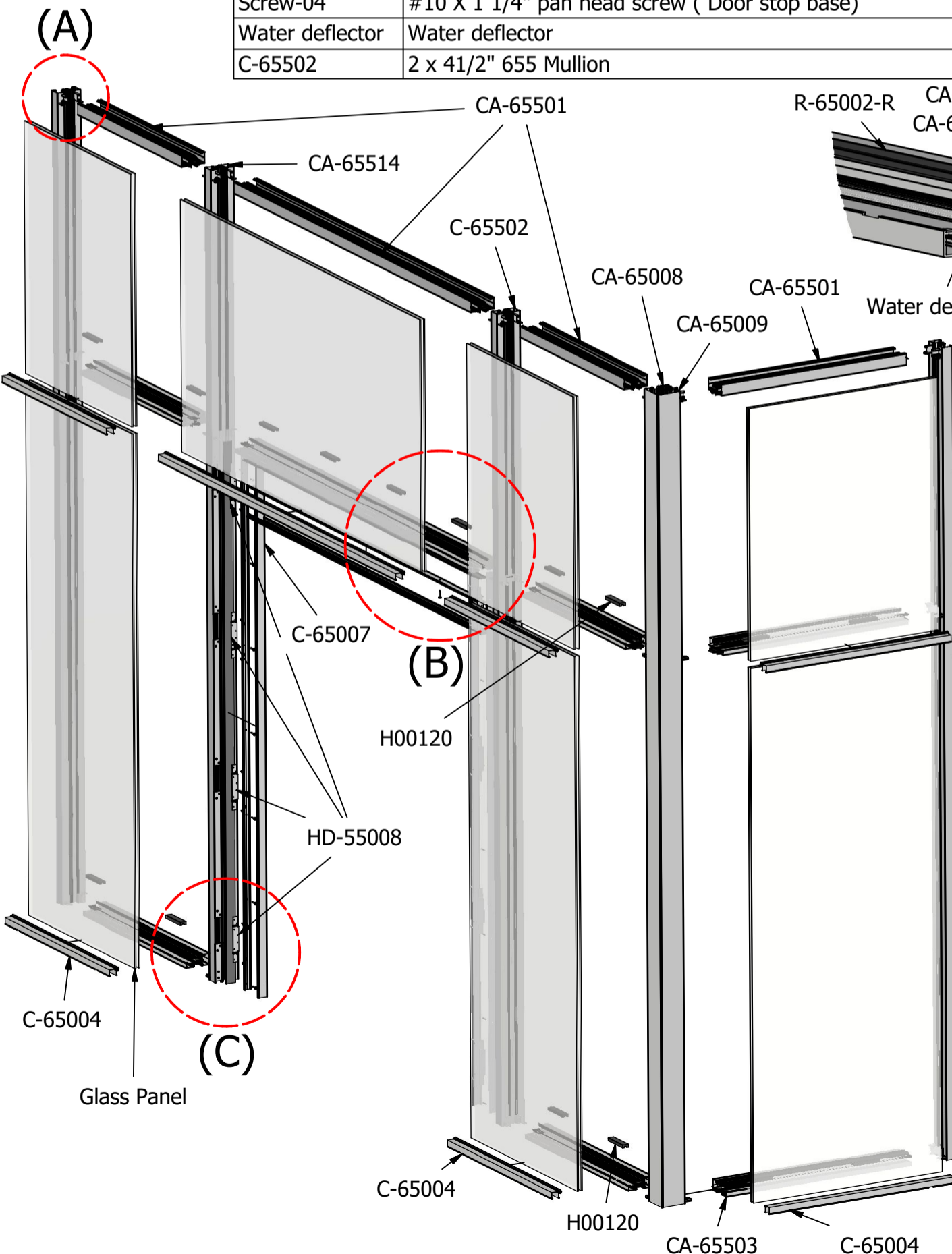
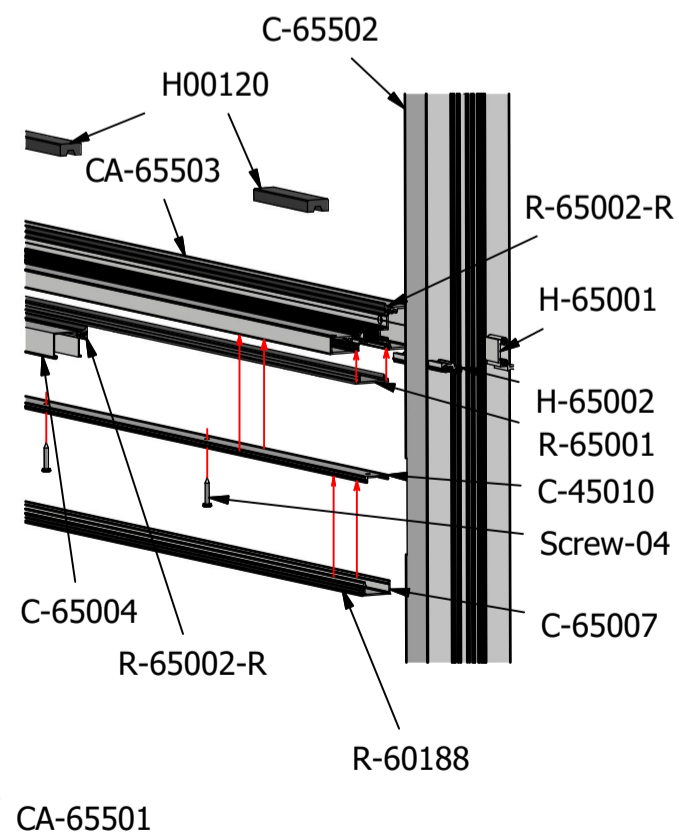


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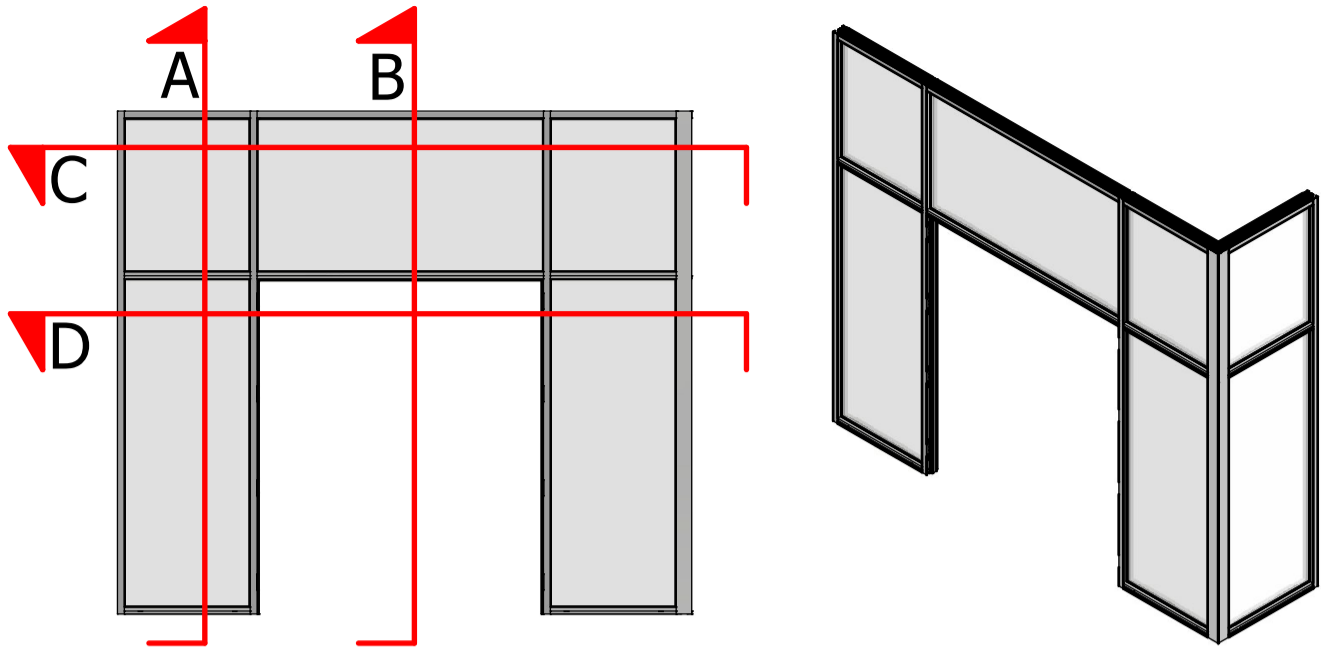
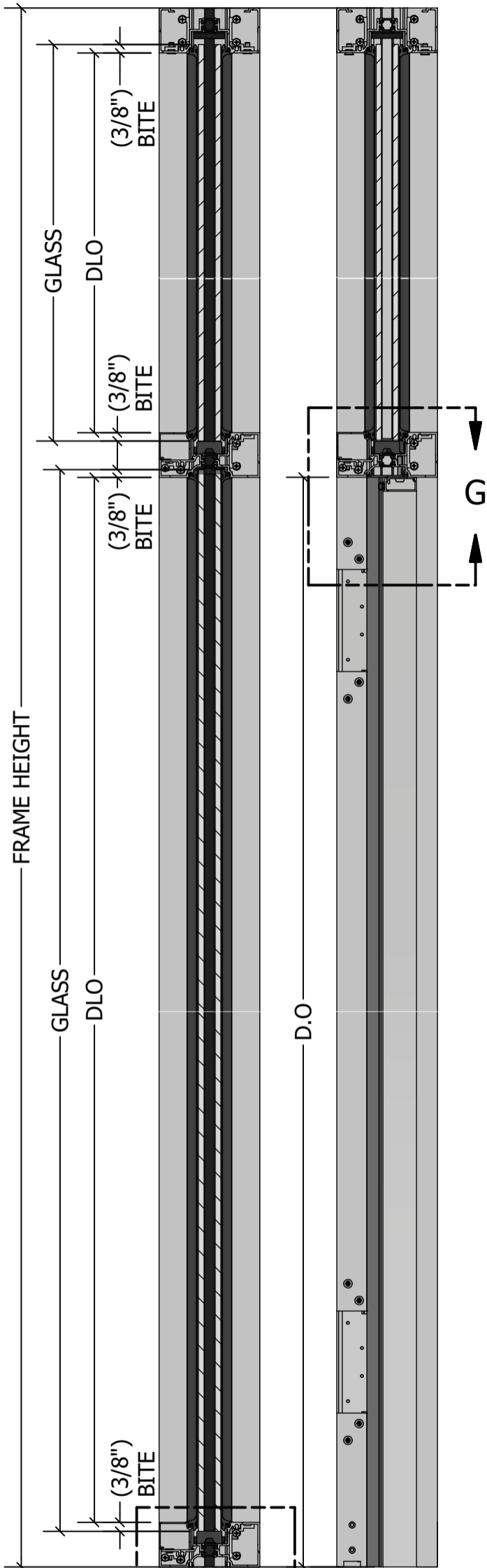
**Detail C**



**Detail B**



## Section-A Section-B



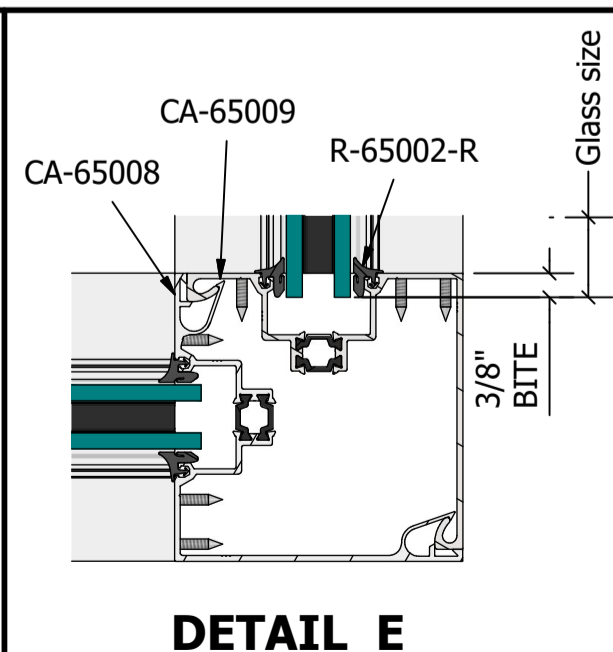
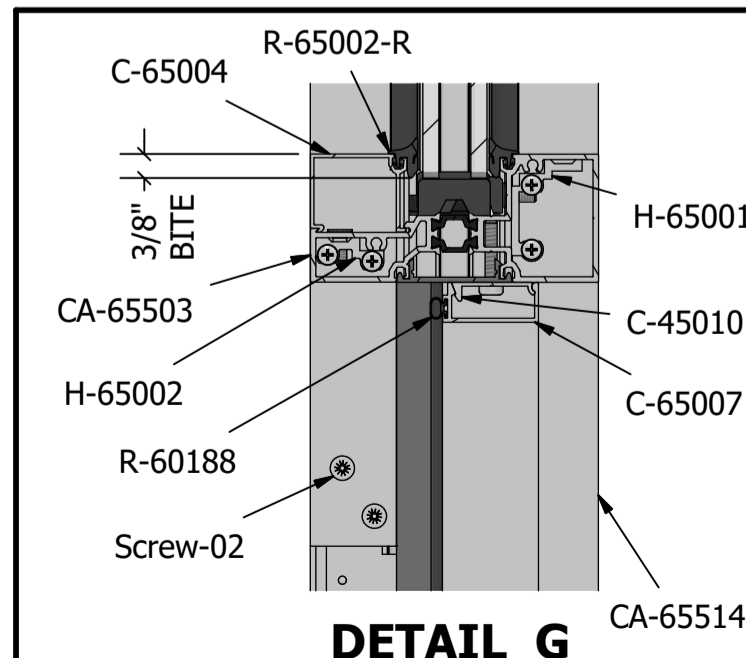
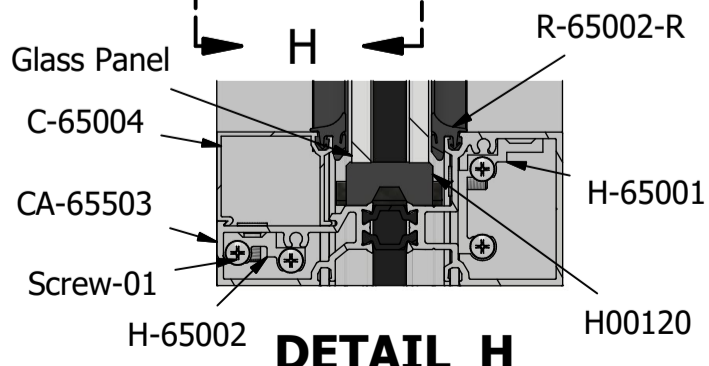
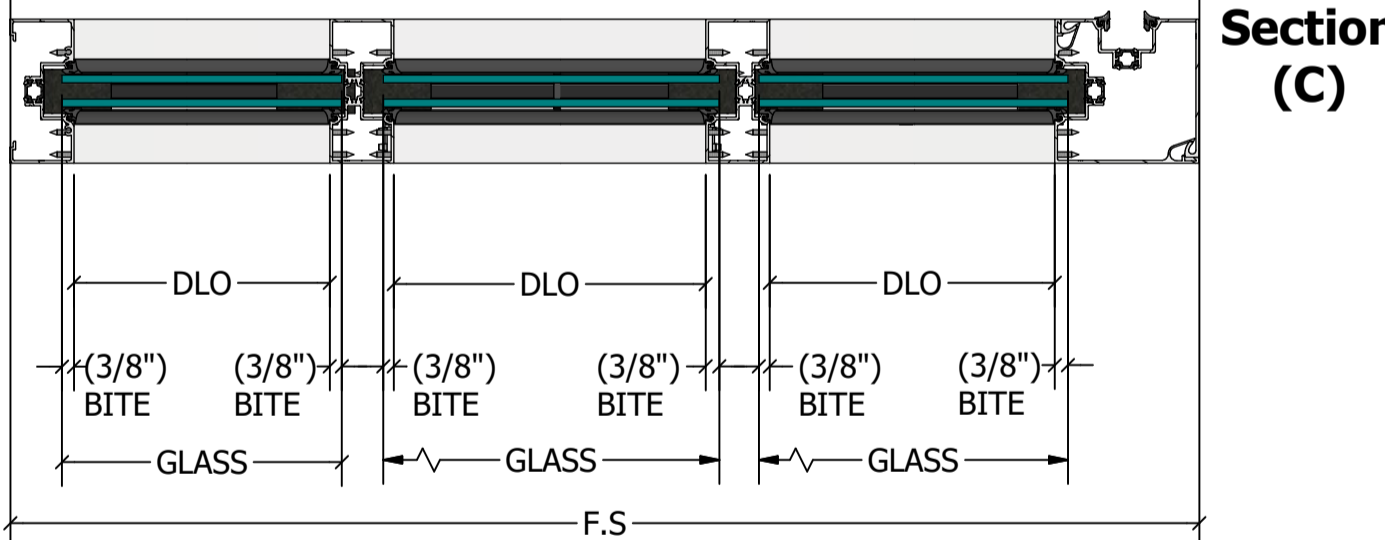
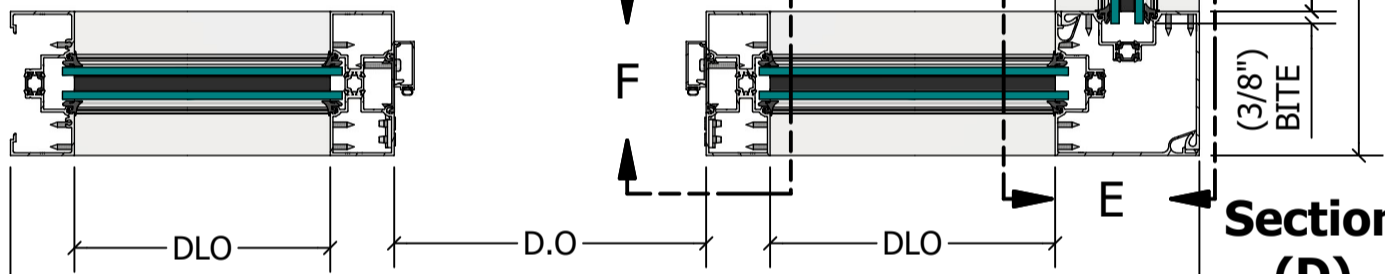
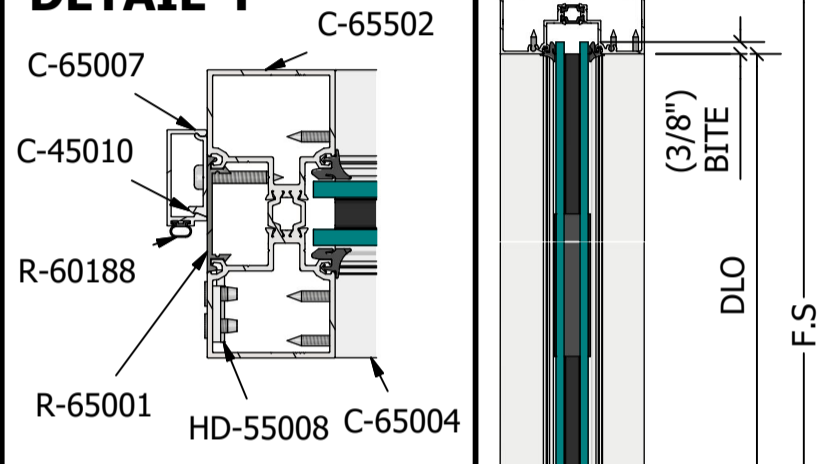
### Notes:

- D.O : Door opening
- R.O : Rough opening
- F.S : Frame size = R.O - 1"
- DLO : Daylight opening

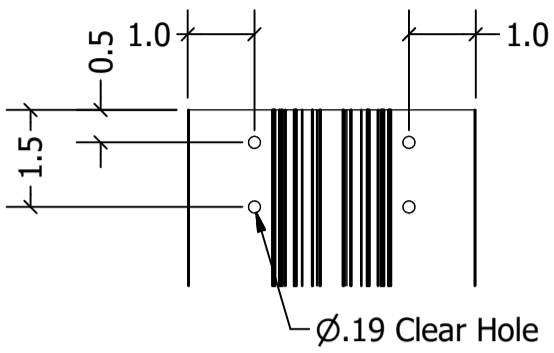
- Glass Width = DLO + 0.75"
- Glass Height = DLO + 0.75"

- Adjacent vertical mullions must have opposite glass pocket depths, one deep, one shallow. Avoid matching depths, especially shallow-shallow.

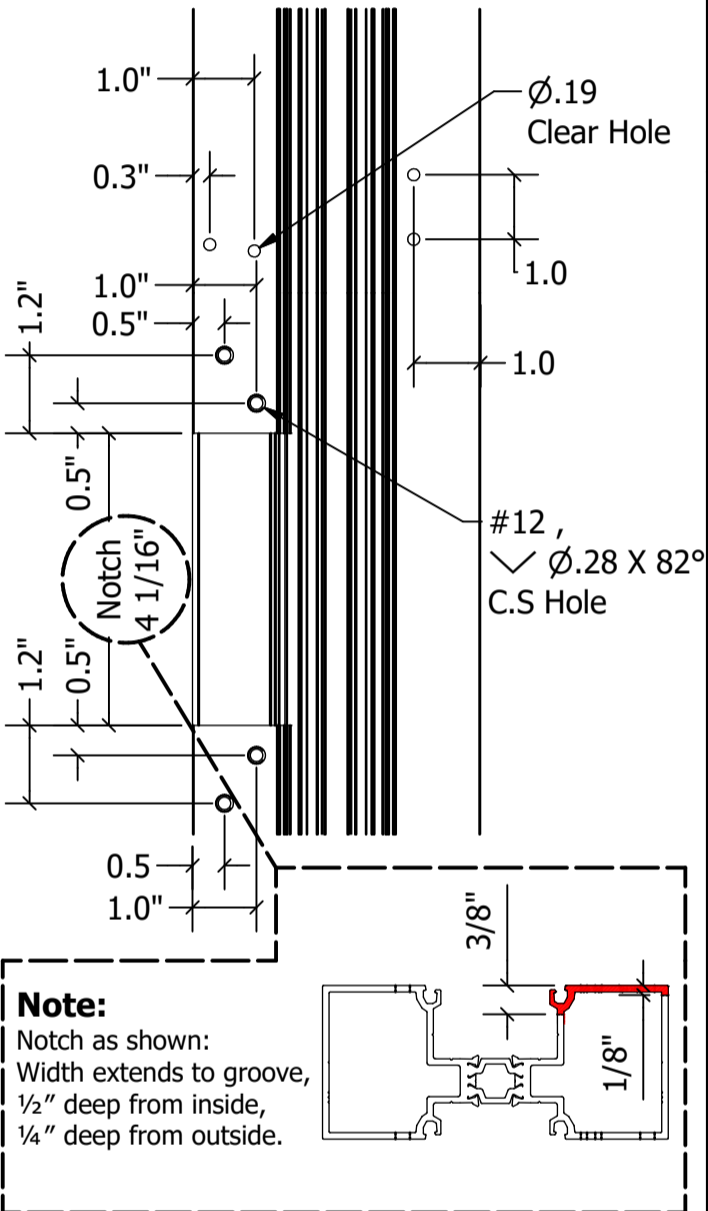
### DETAIL F



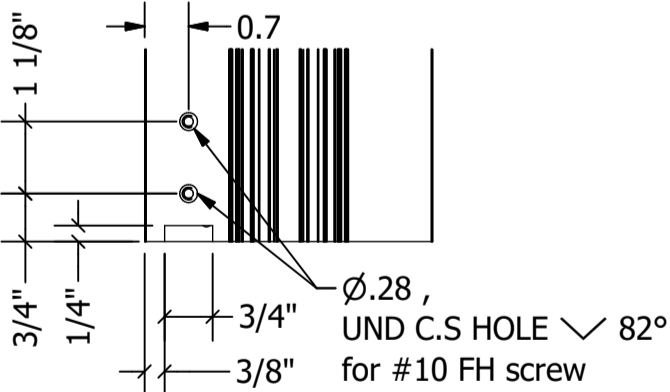
## DETAIL A



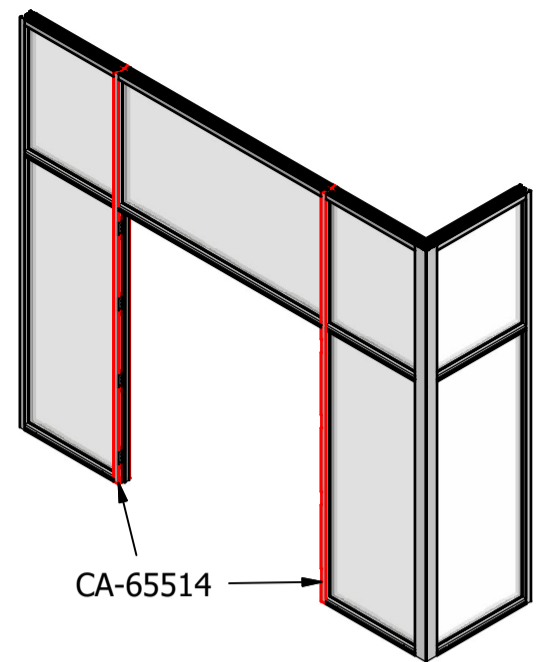
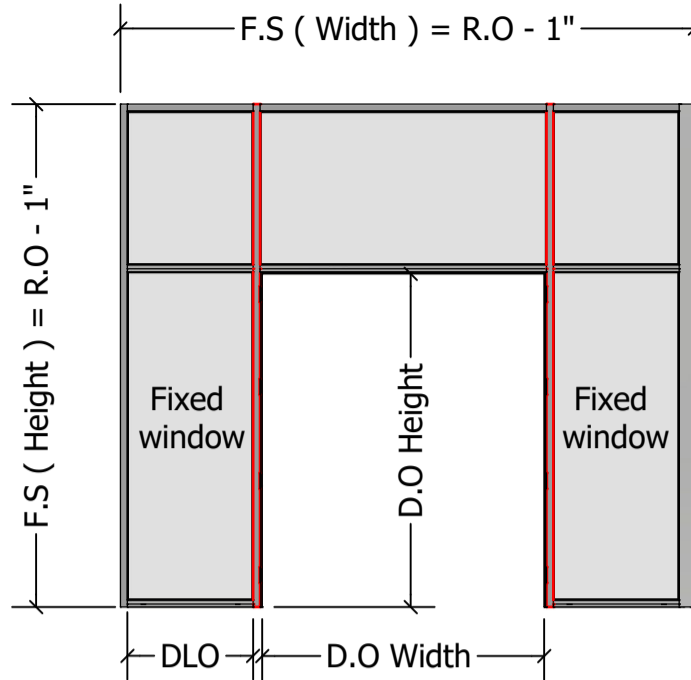
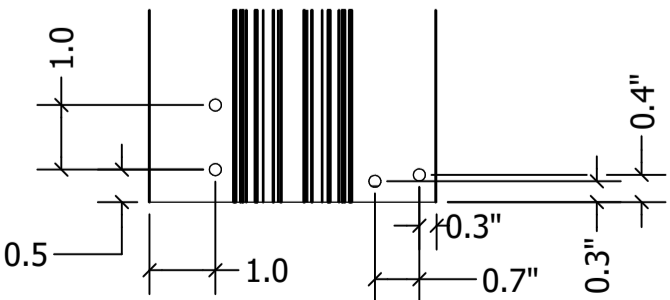
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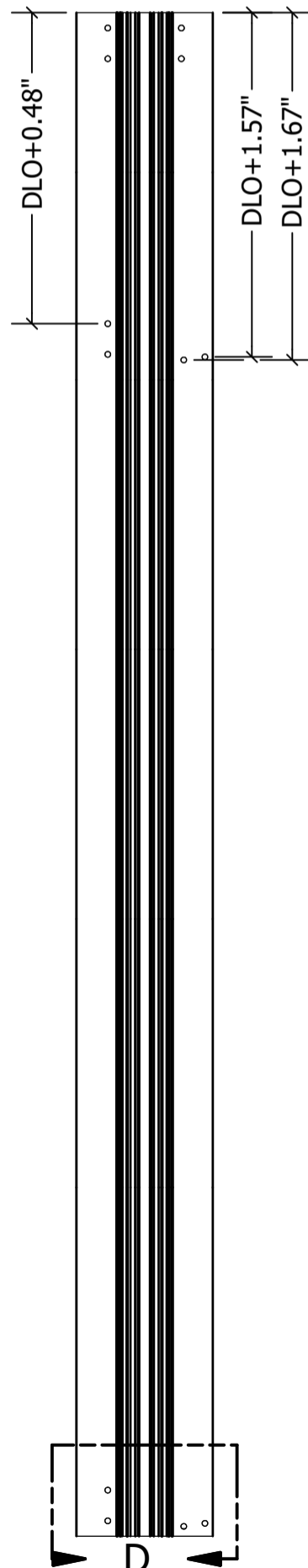
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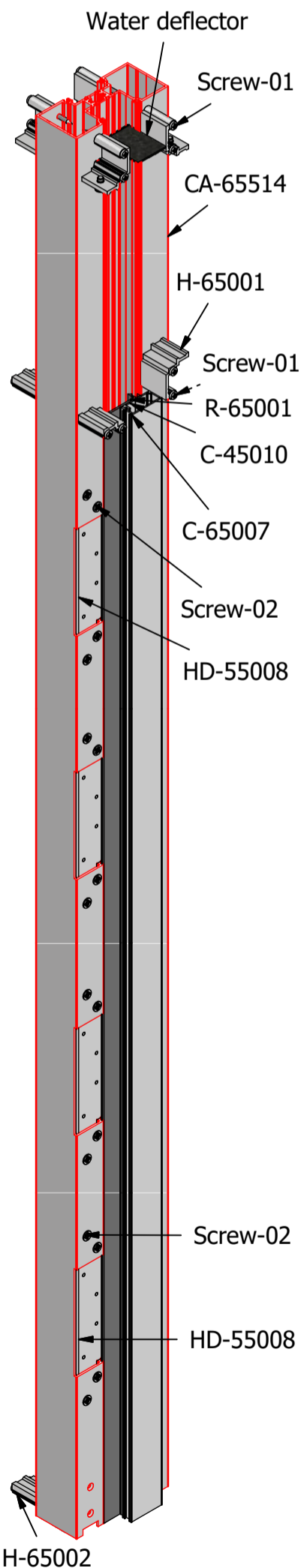
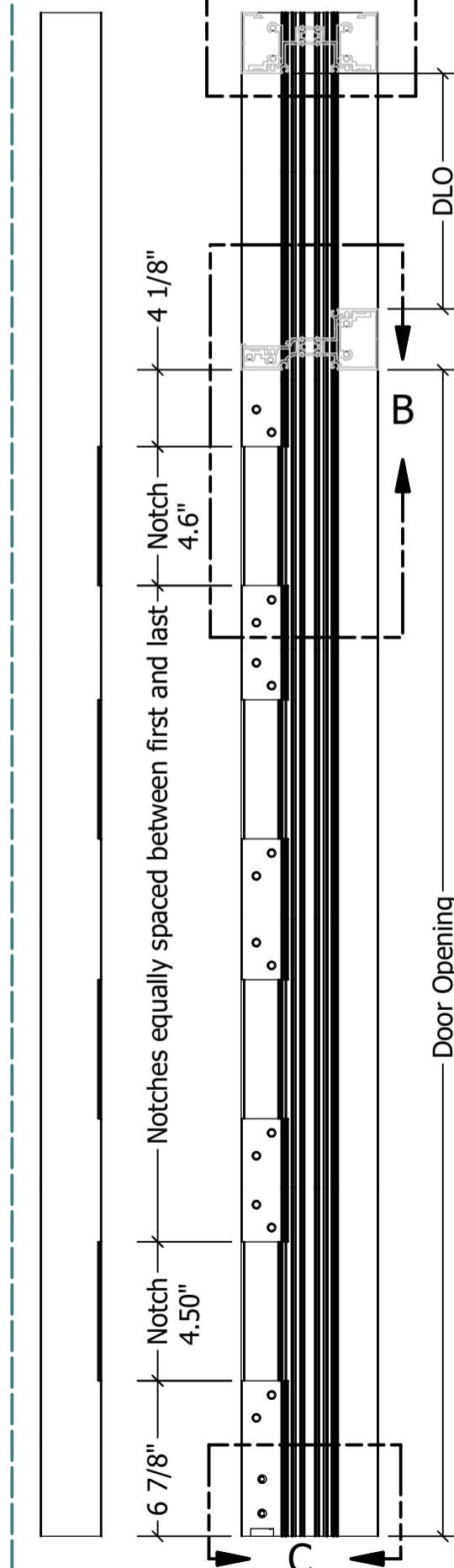
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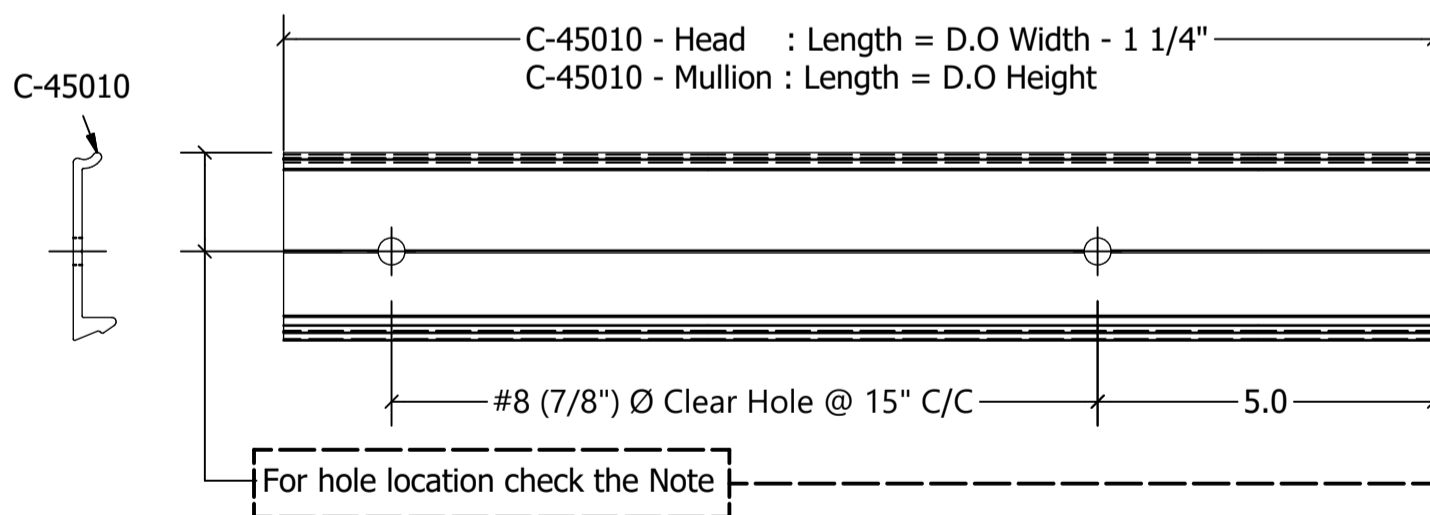
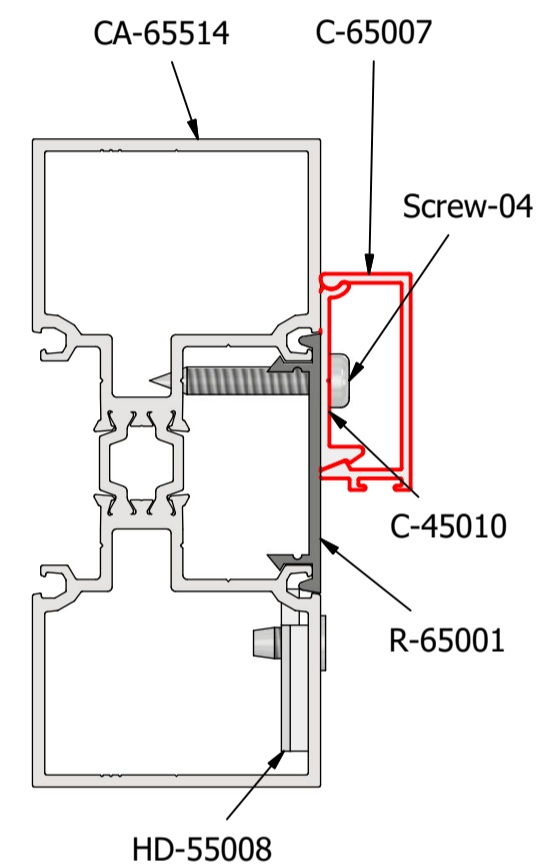
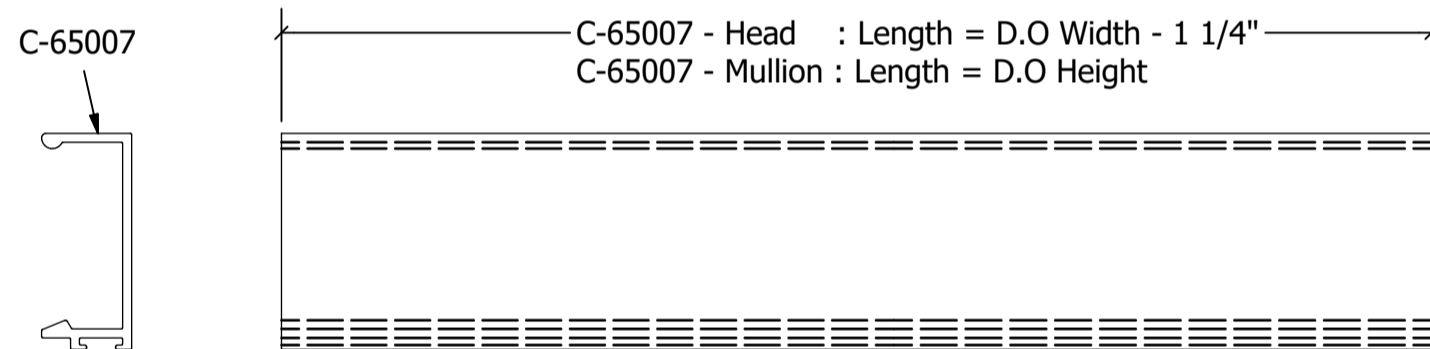
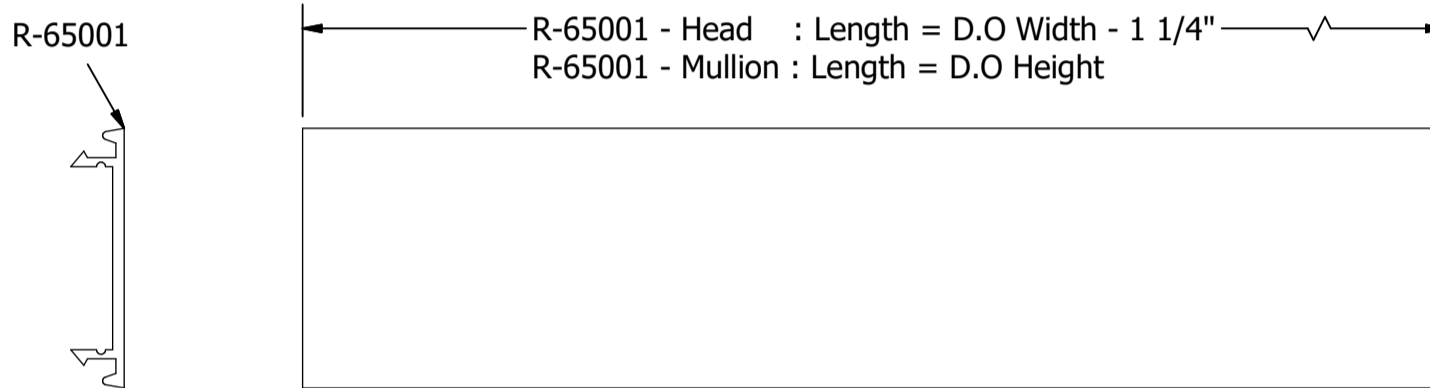
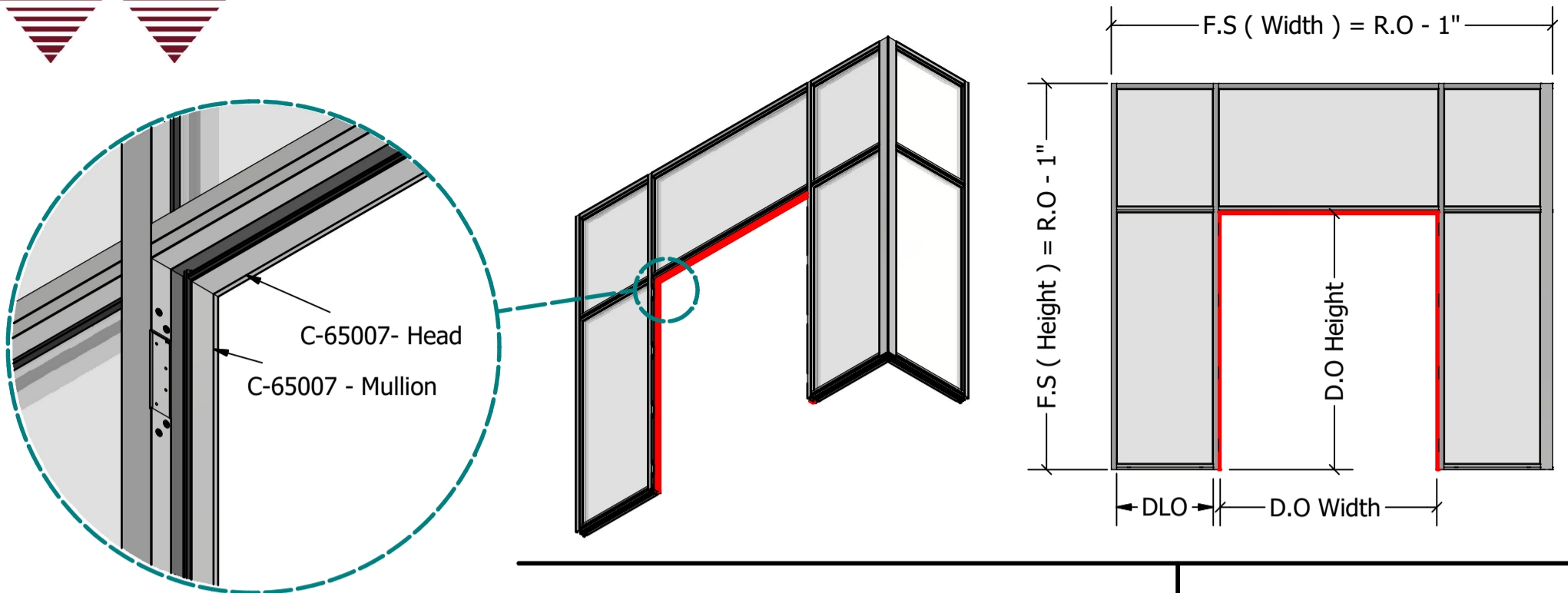


## View From Fixed Window Side



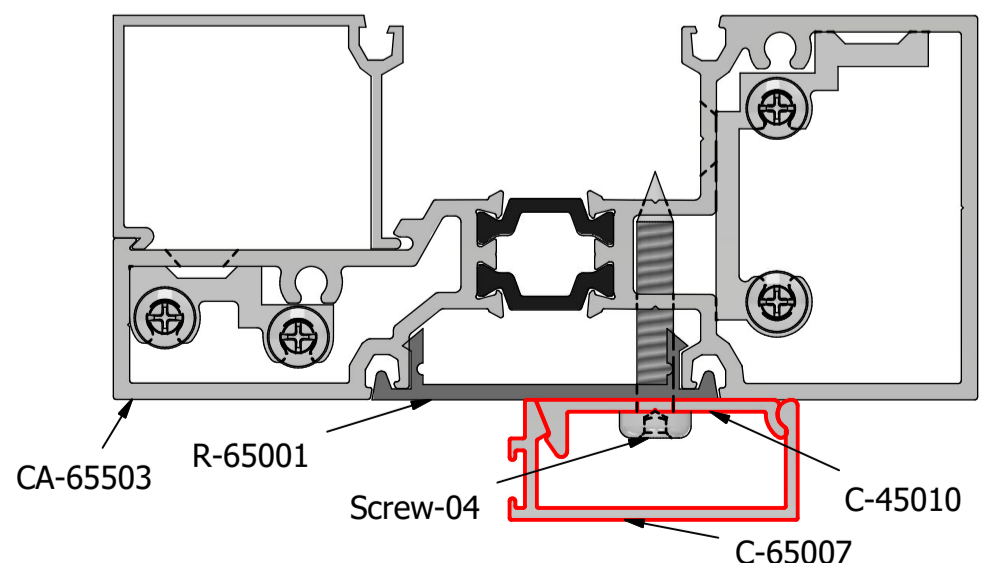
## View From Door Opening Side

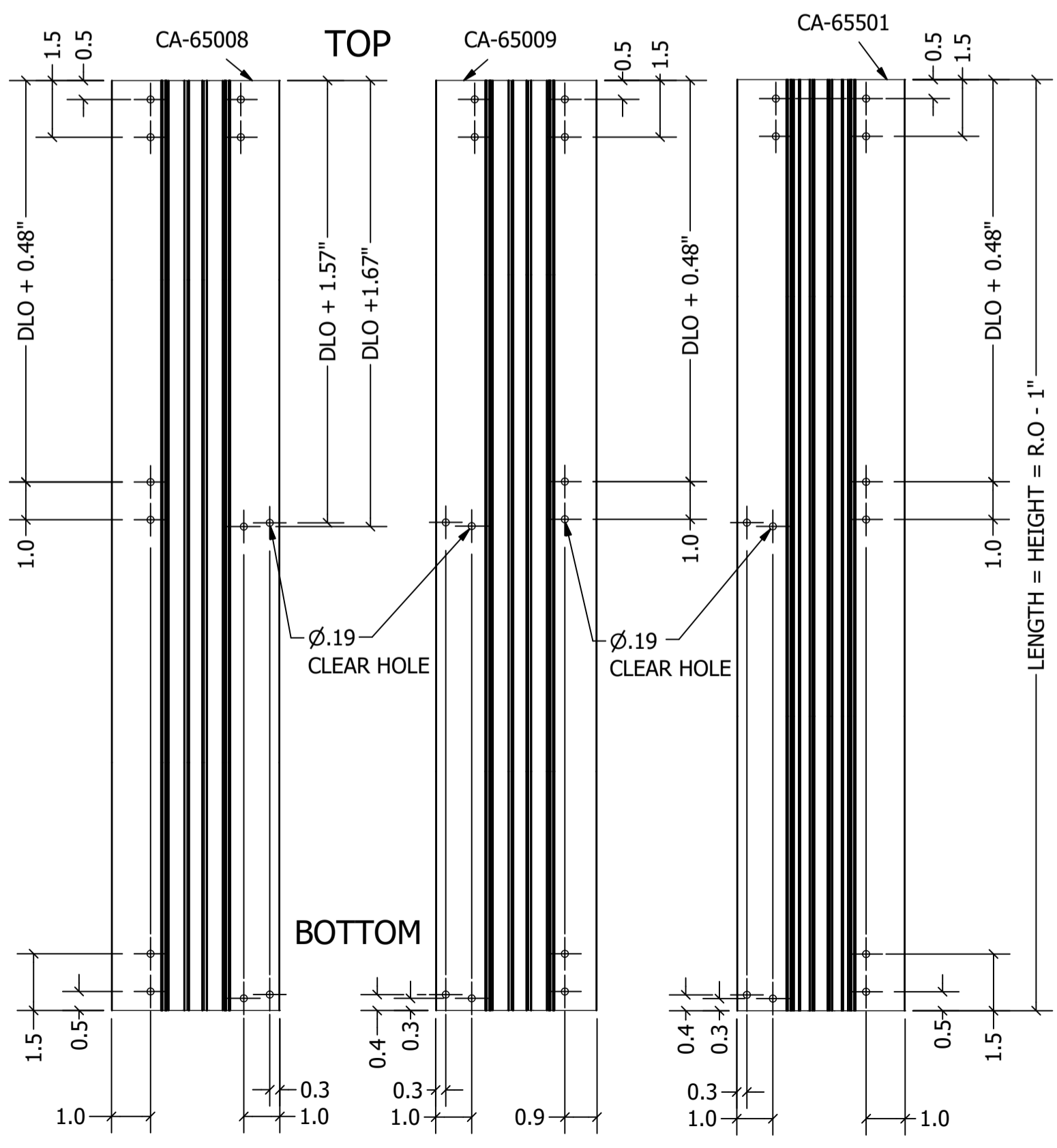
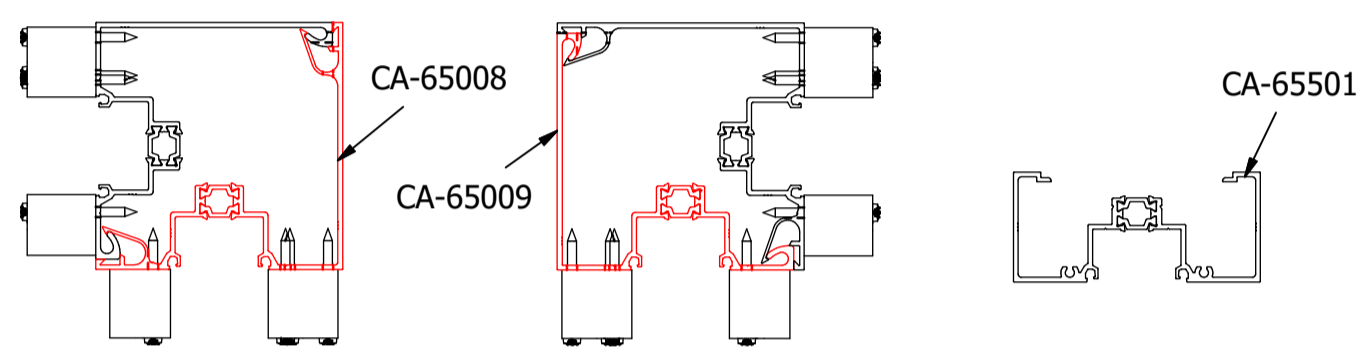
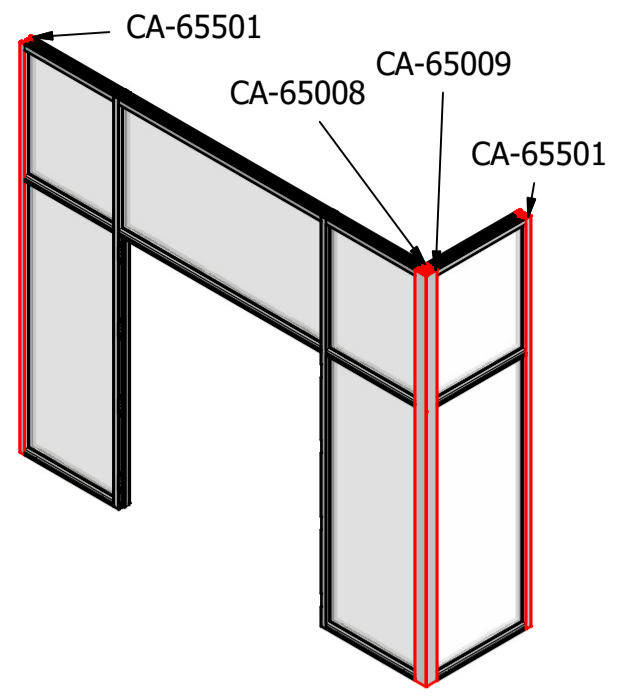
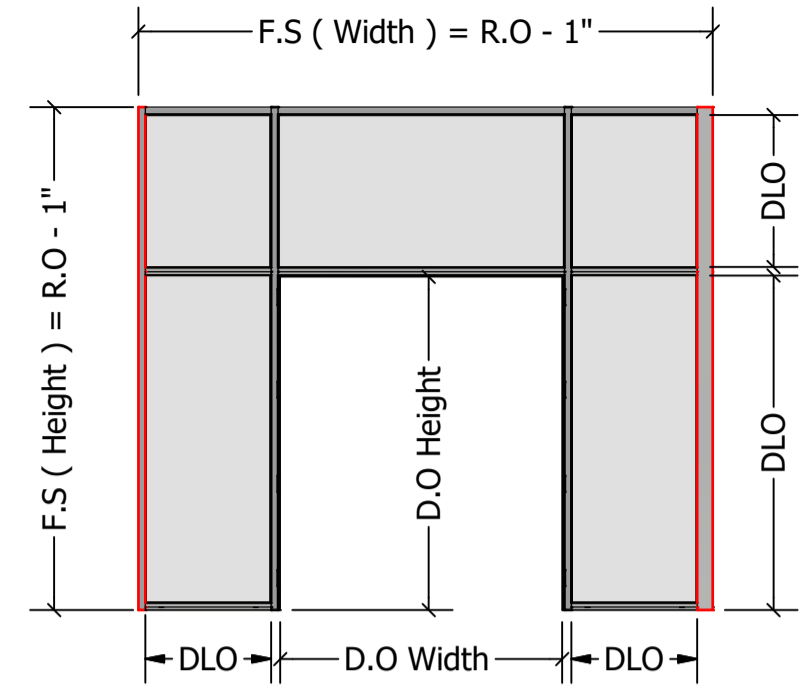
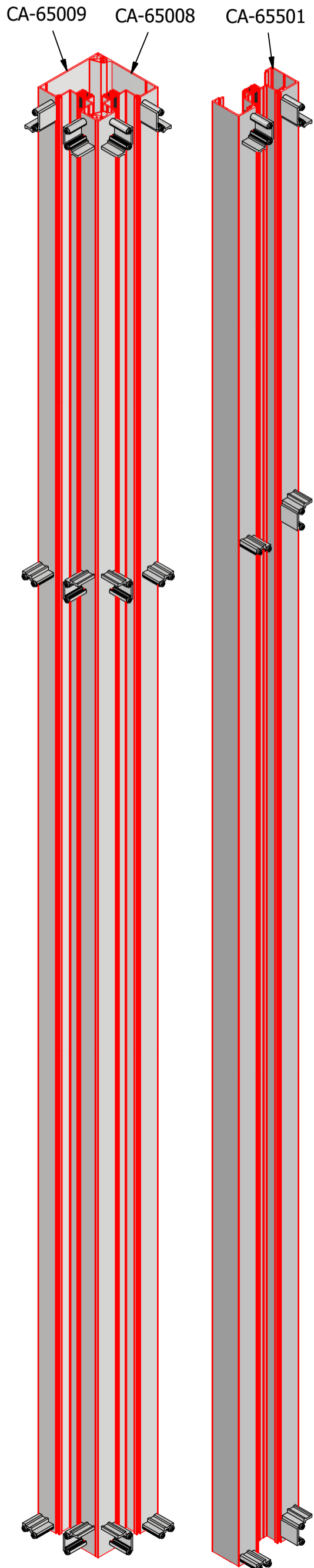


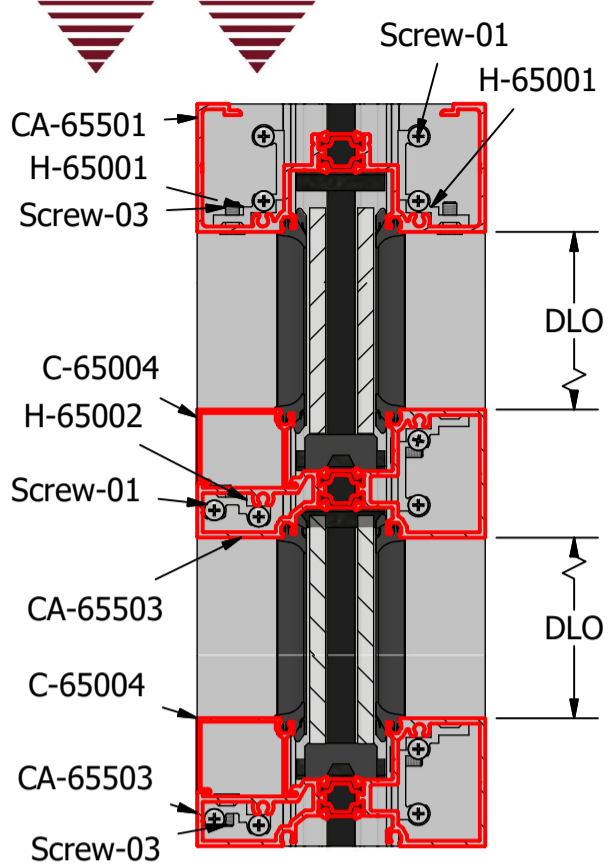


**Note:**  
Position holes on Door Stop Base (C-45010) to prevent screw penetration into the mullion thermal break.

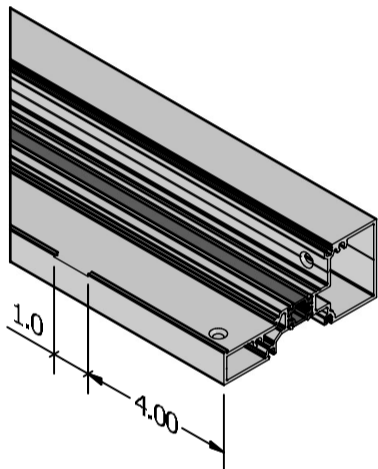
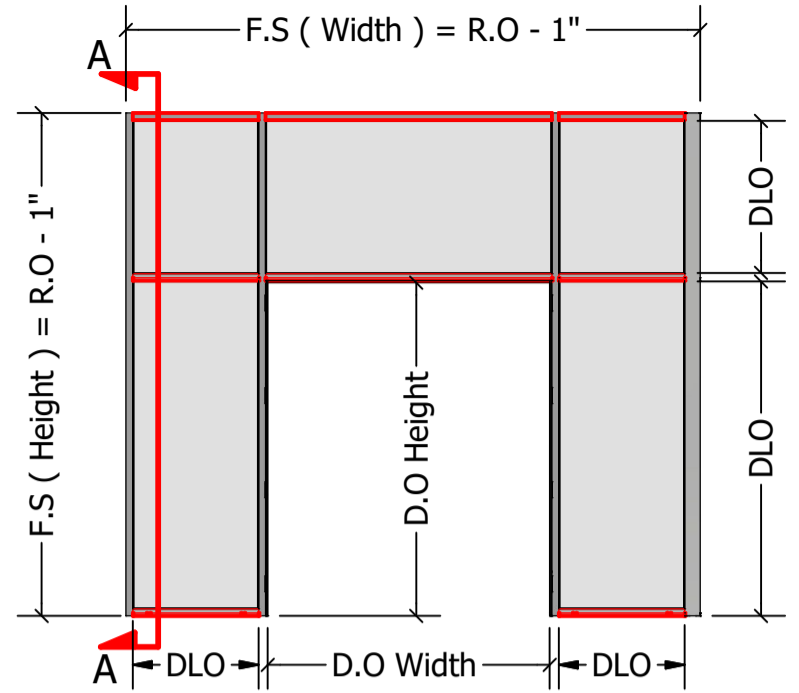
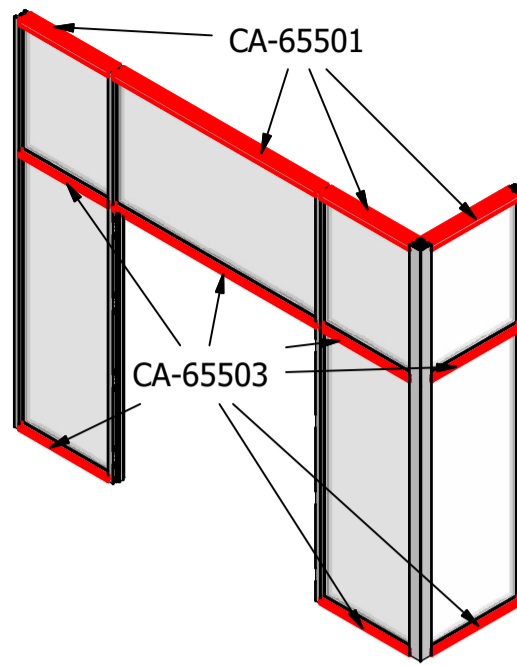
PARTS LIST	
PART NUMBER	DESCRIPTION
C-45010	Door Stop Base
C-65007	Door Stop Cap
CA-65503	2 x 4 1/2" Horizontal Sill
CA-65514	2 x 4 1/2" 655 Mullion
HD-55008	Back up Plate for Butt Hinges
R-65001	PVC mullion Filler Adaptor
Screw-04	#10 X 1 1/4" pan head screw ( Door stop base)
C-65502	2 x 4 1/2" 655 Mullion



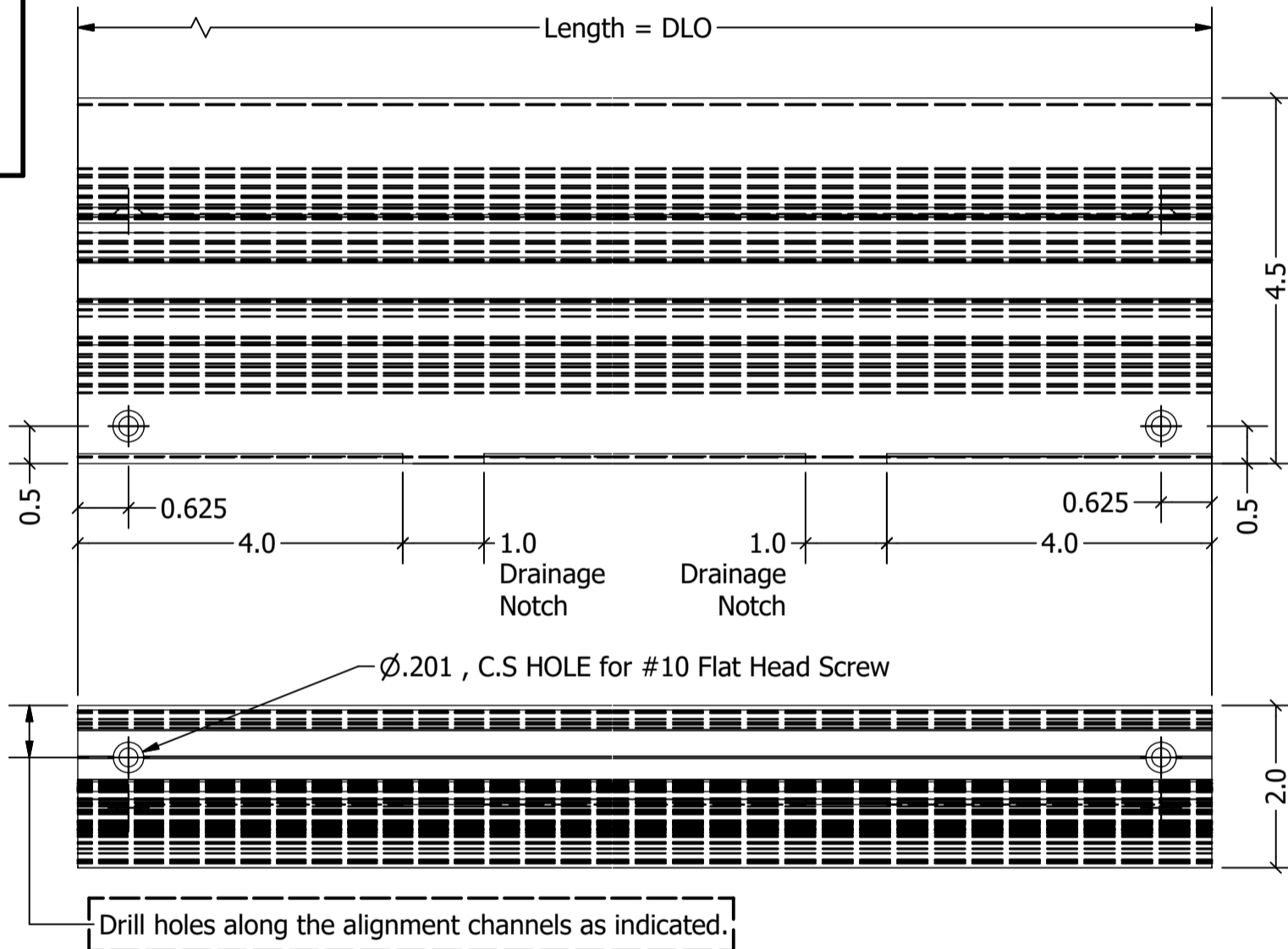
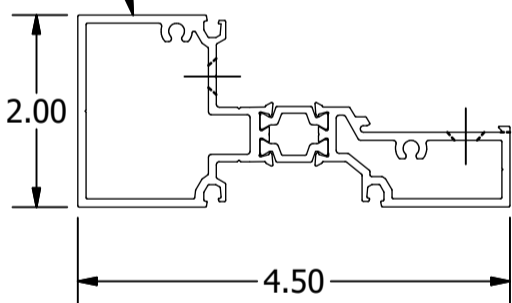




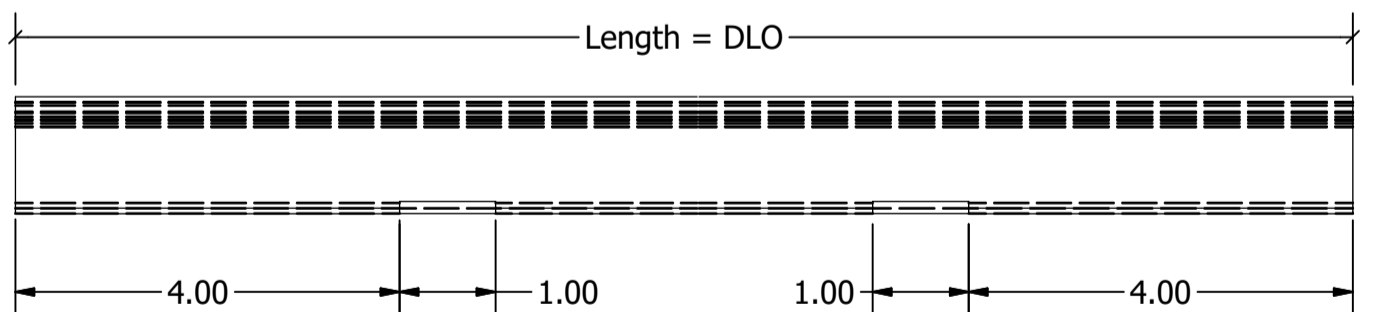
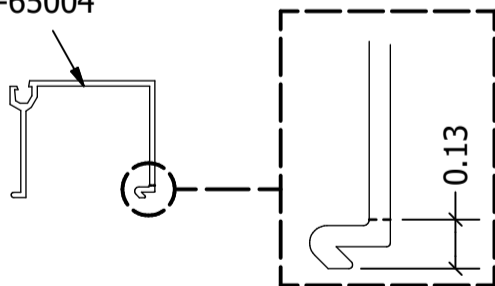
**Section A-A**



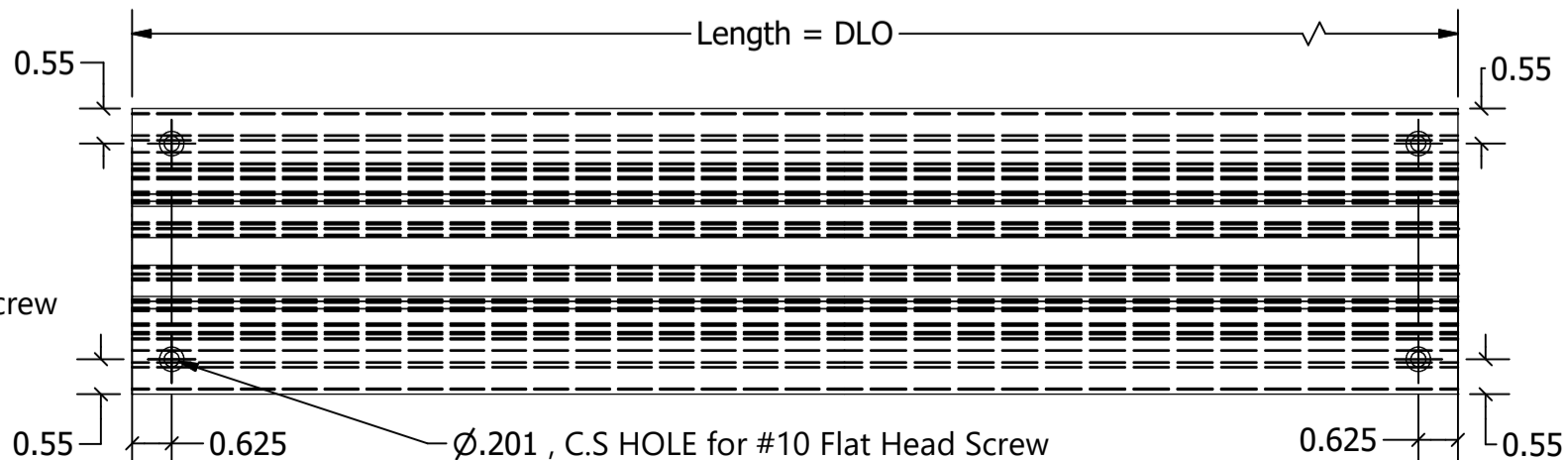
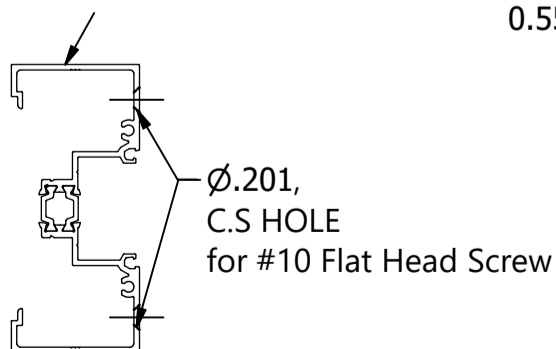
CA-65503



C-65004



CA-65501



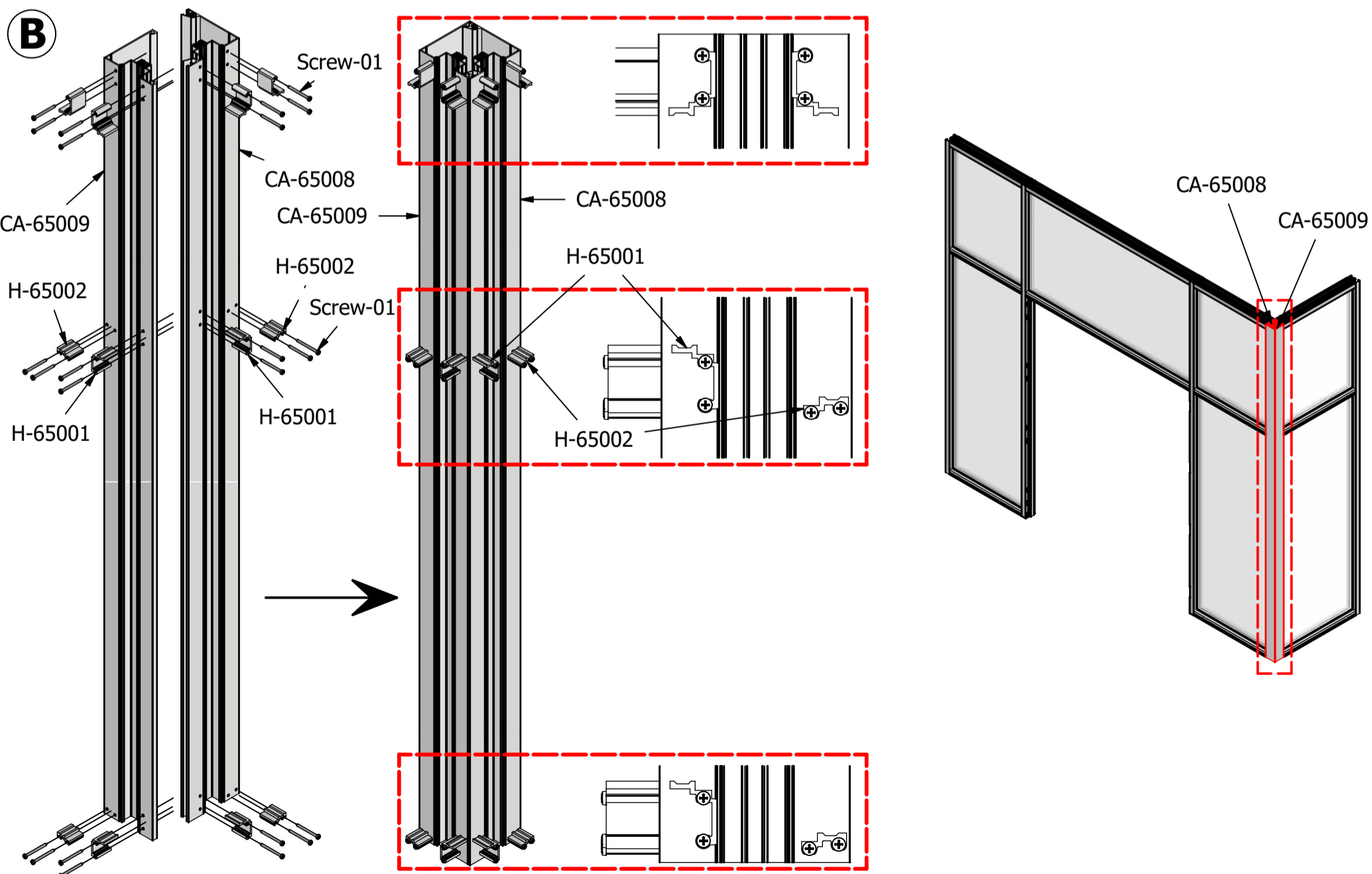
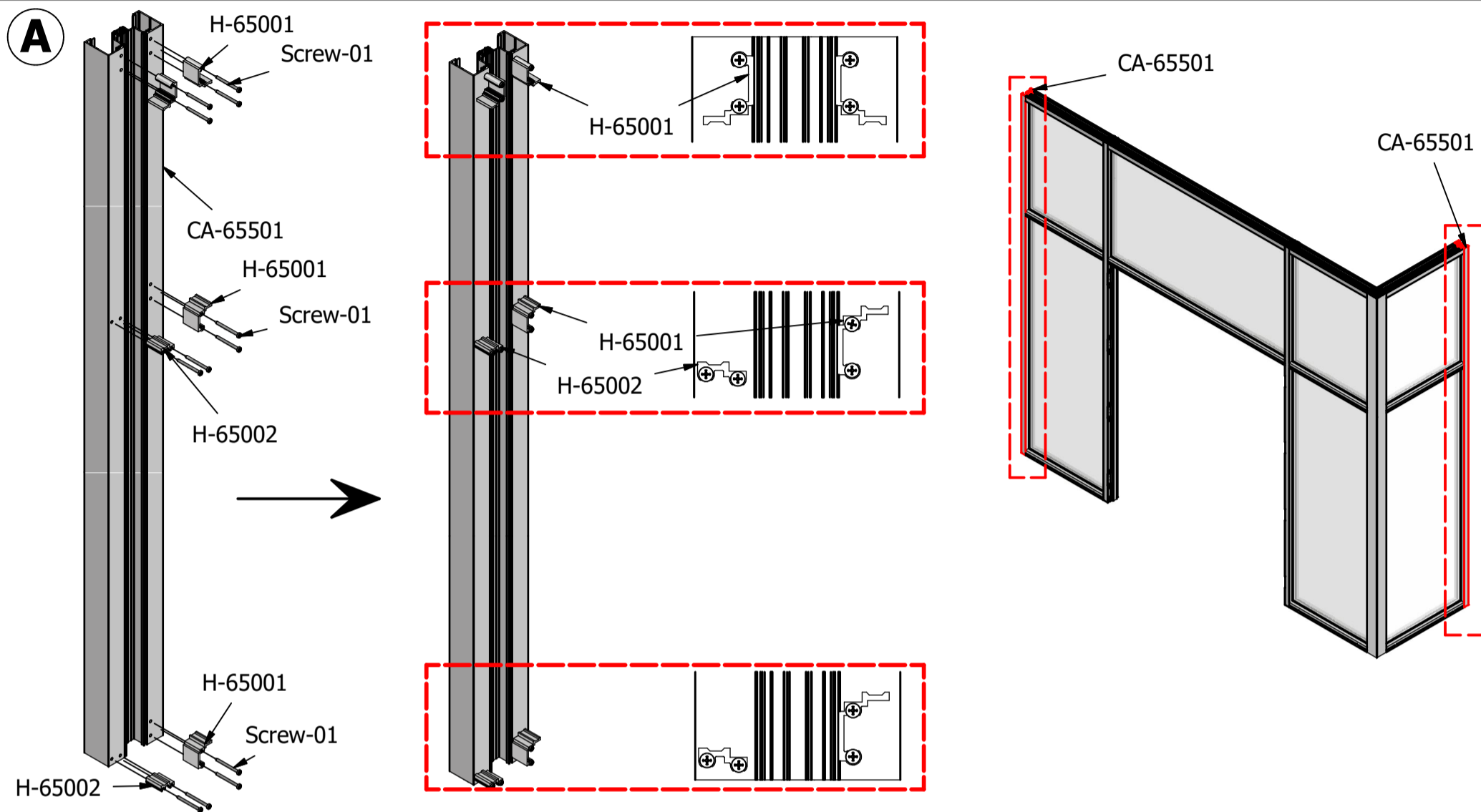
ASSEMBLY

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STEPS

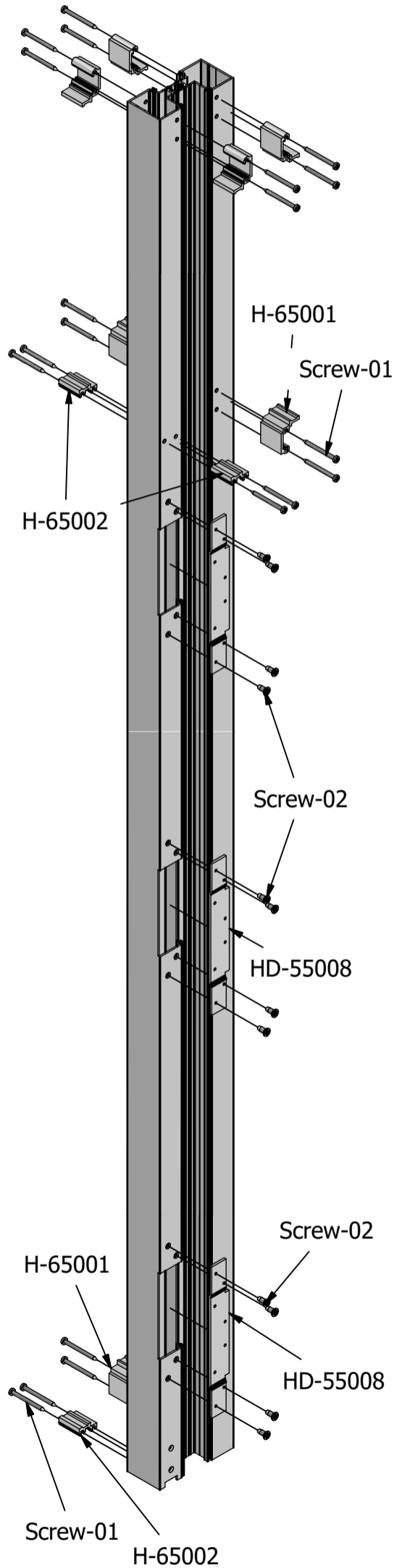
## STEP 1 (Shear Block Installation on Mullions):

**1)** - Attach shear blocks H-65001 and H-65002 to the mullions (CA-65501 , CA-65008 & CA-65009), ensuring proper placement: secure H-65002 on the exterior side where the glass stop is located and H-65001 on the interior side. Fasten both using #8 x 2" pan head screws (Screw-01), as illustrated below.

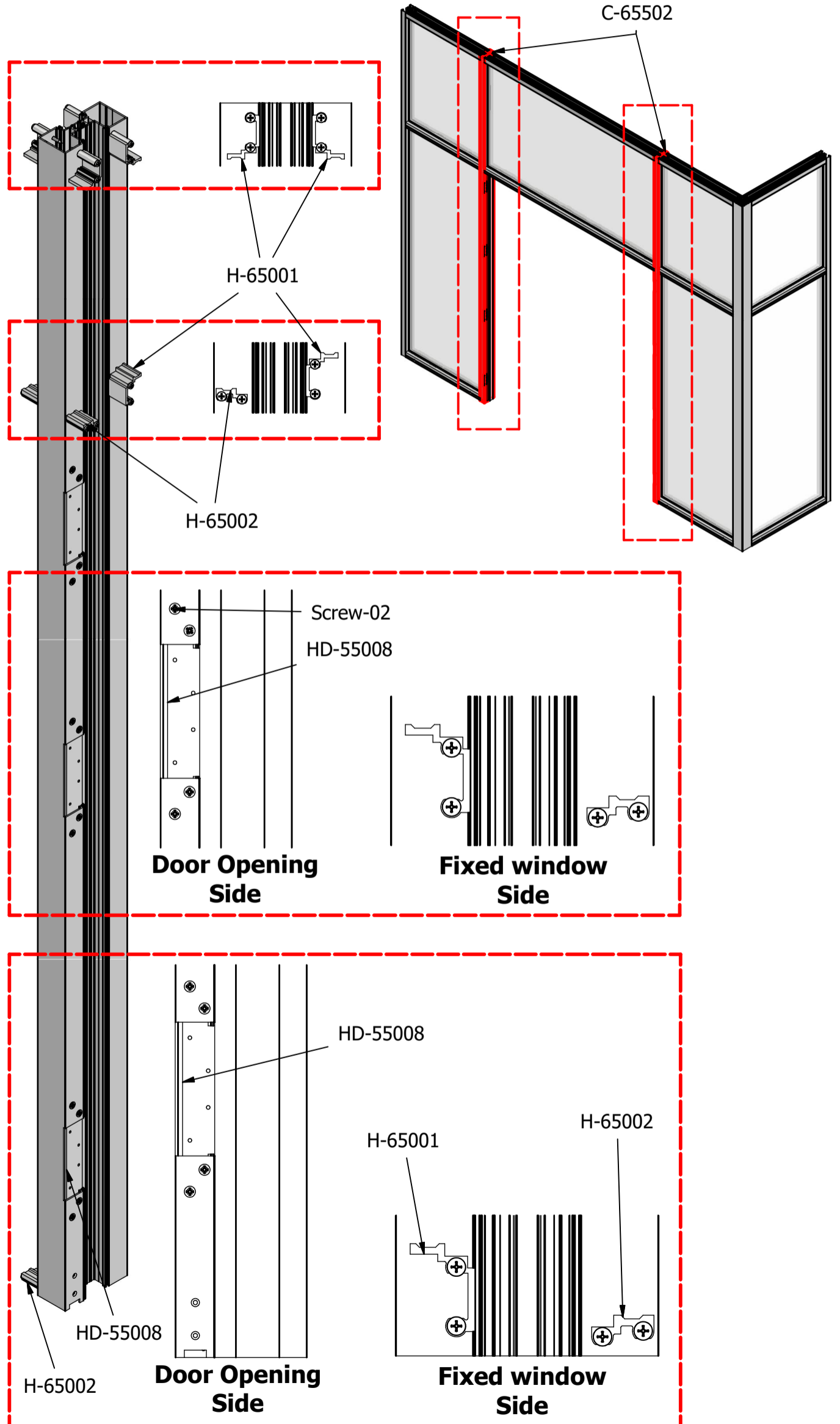


**2)** - For the mullion (CA-65514) in the door portion, attach the backup plates to the door opening side by securing them with #12 x 1/2" undercut flat head screws (Screw-02) through the holes around the hinge notches. On the fixed window side, install the shear blocks as per the previously provided instructions.

**1**



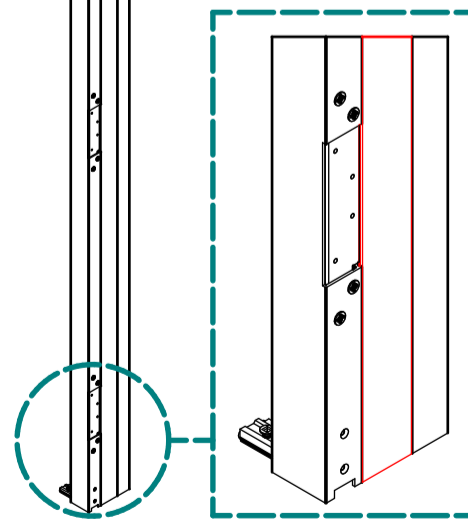
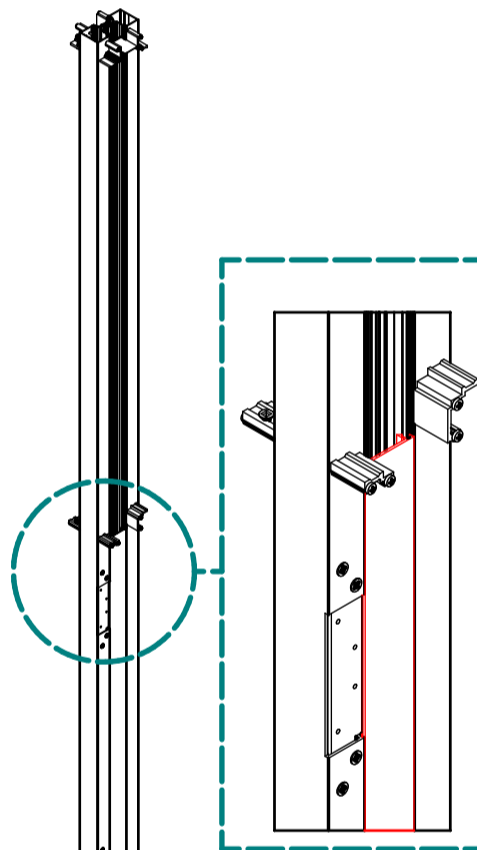
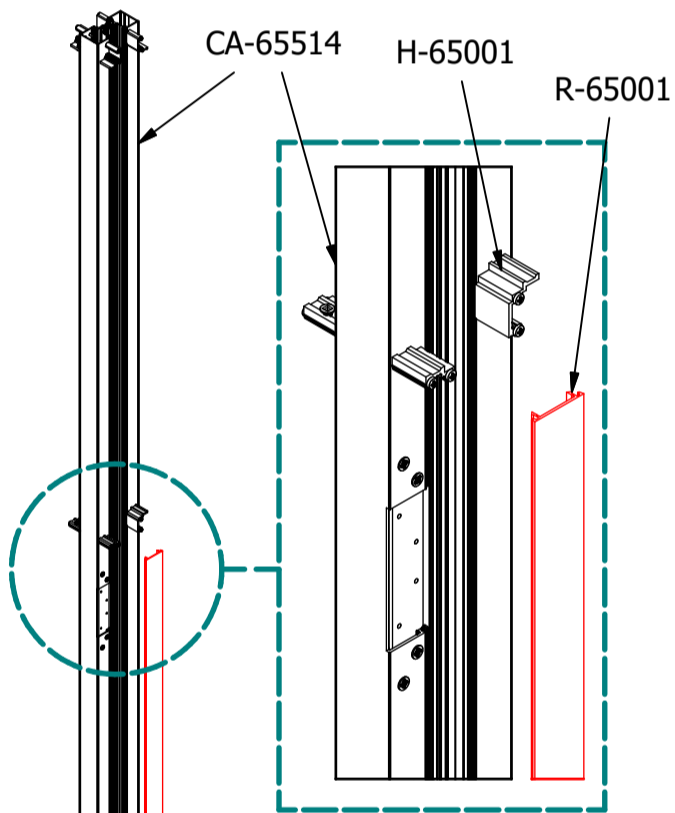
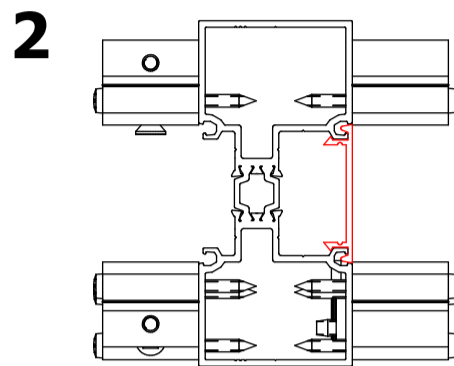
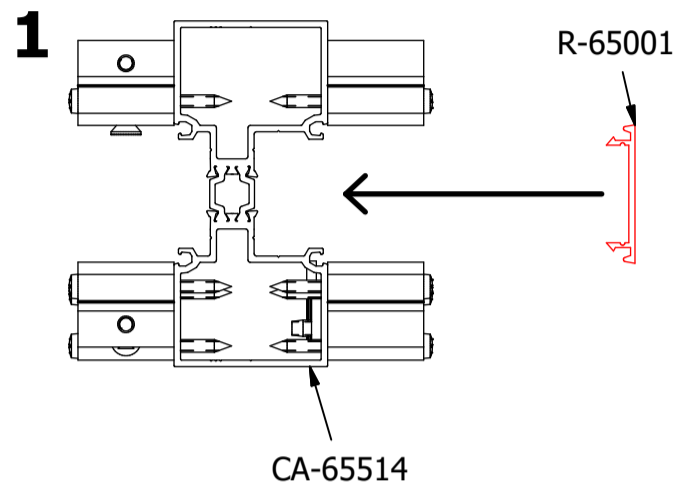
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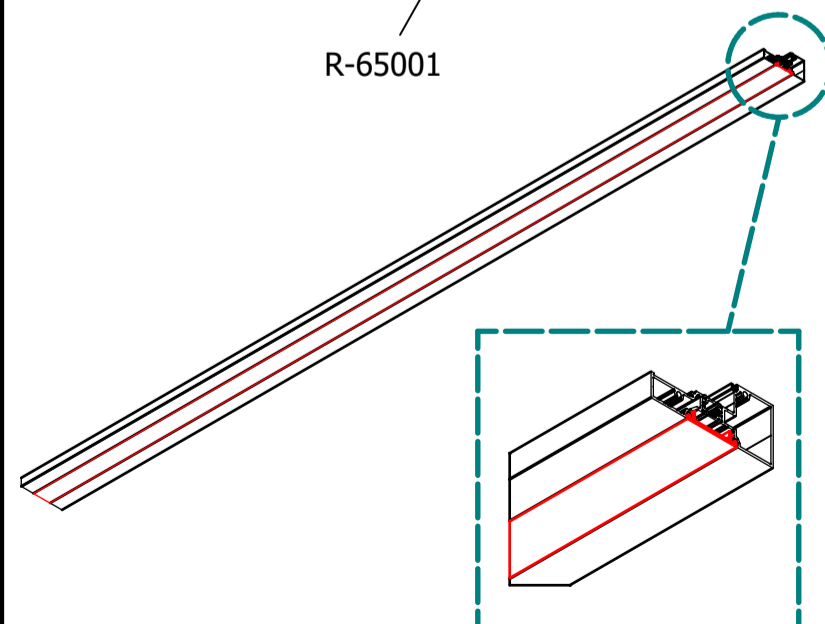
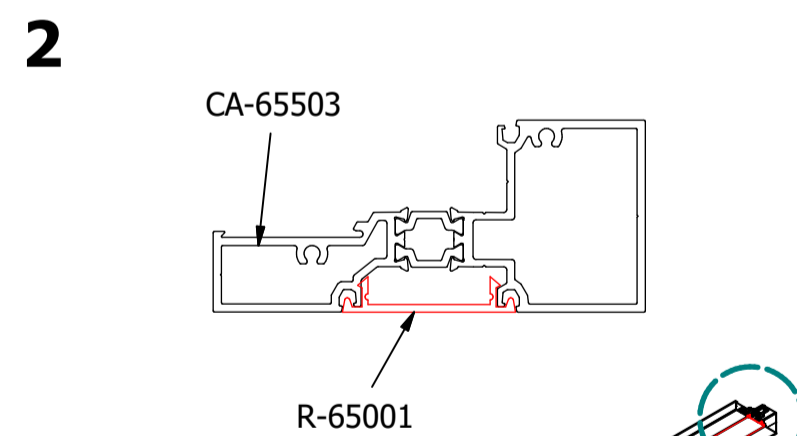
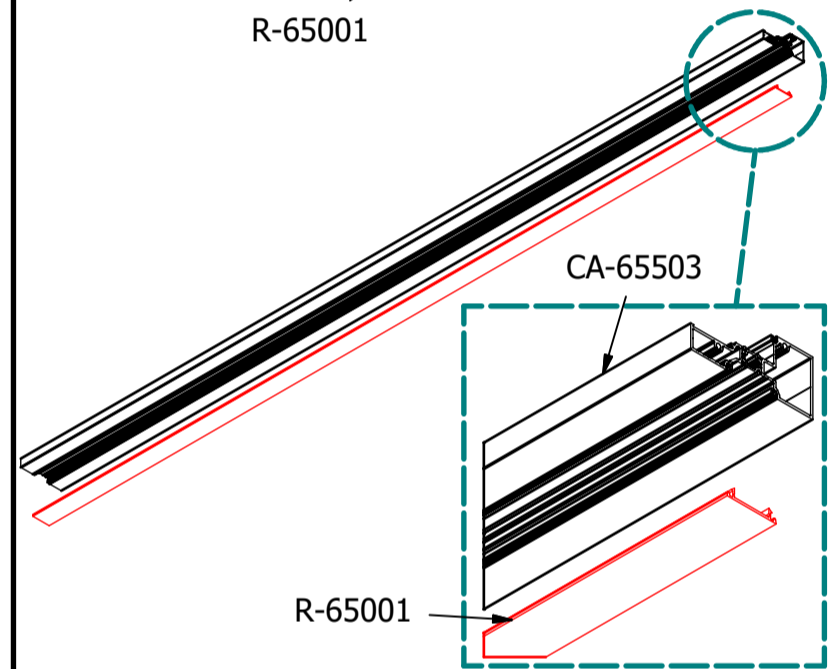
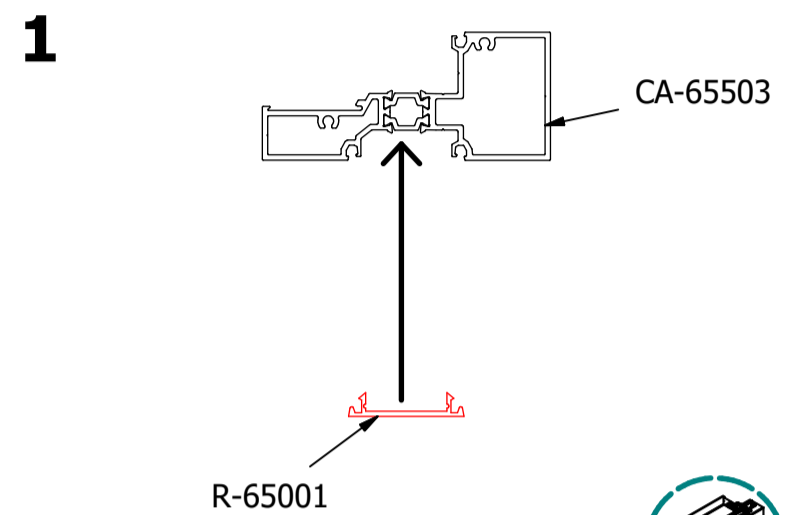
**STEP 2 (Filler Adaptor Installation):**

Attach the filler adaptor to the vertical mullions on the door opening side in the door portion and to the transom on the door head side, as shown below.

**On Vertical Mullions**



**On Door head**



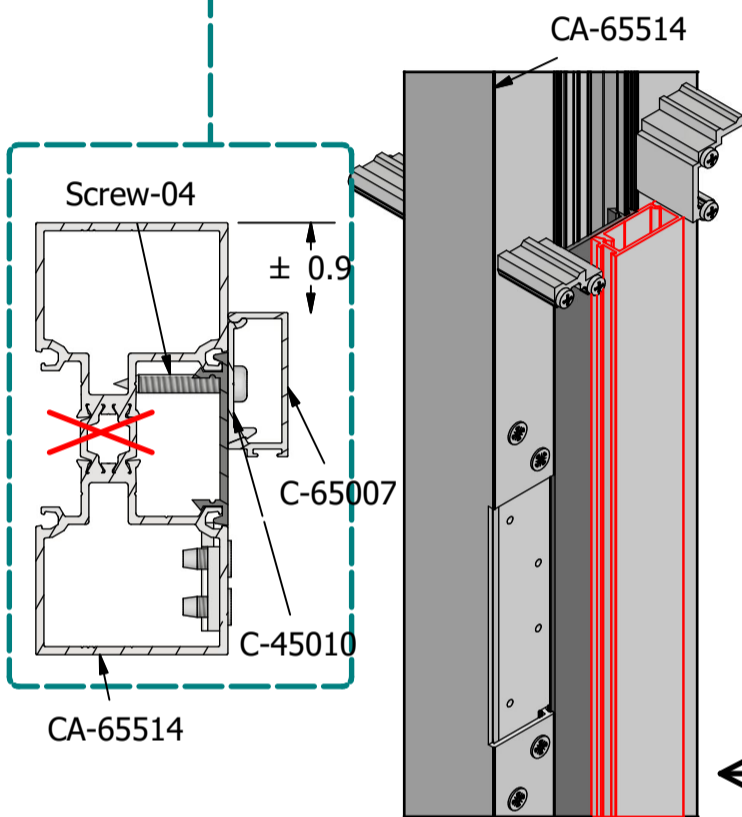
## STEP 3 (Door Stop Installation):

After ensuring proper alignment, secure the door stop base (C-45010) to the vertical mullion (CA-65514) in the door portion using #10 x 1 1/4" pan head screws (Screw-04) through the pre-drilled holes in the base. Then, snap the door stop cap (C-65007) firmly onto the base.

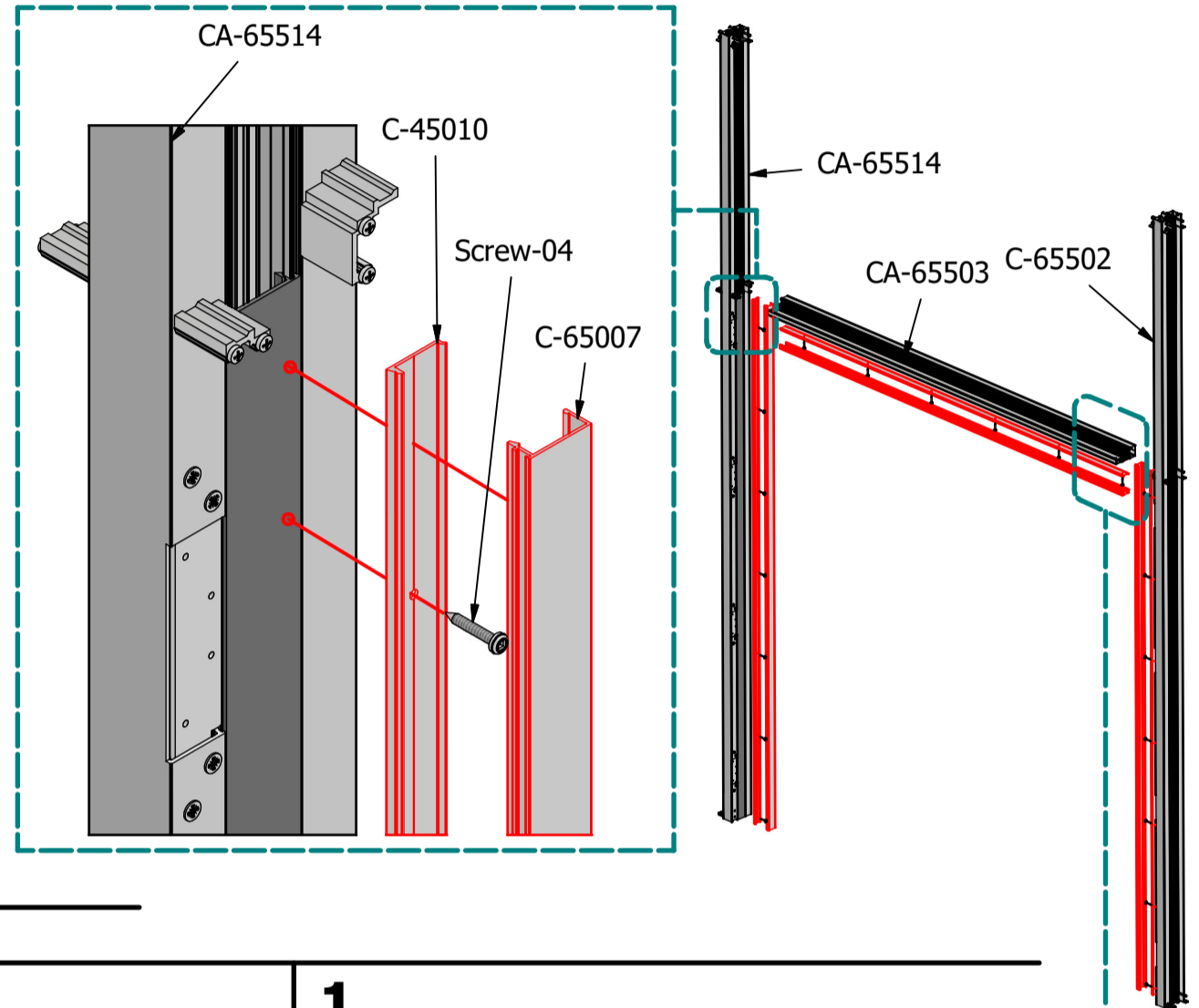
**2**

**Note:**

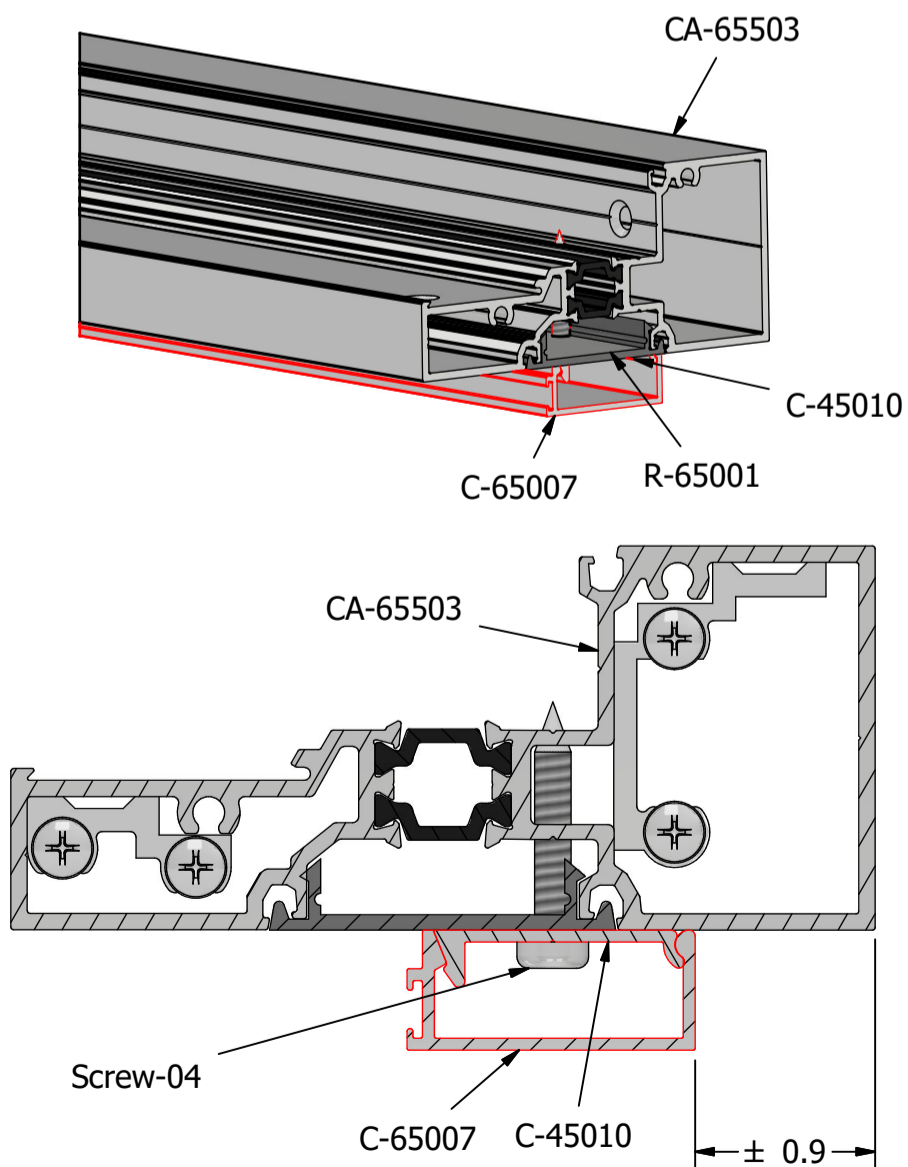
Ensure the door base is aligned to prevent screw penetration through the thermal break. Alignment may vary depending on the door stop size.



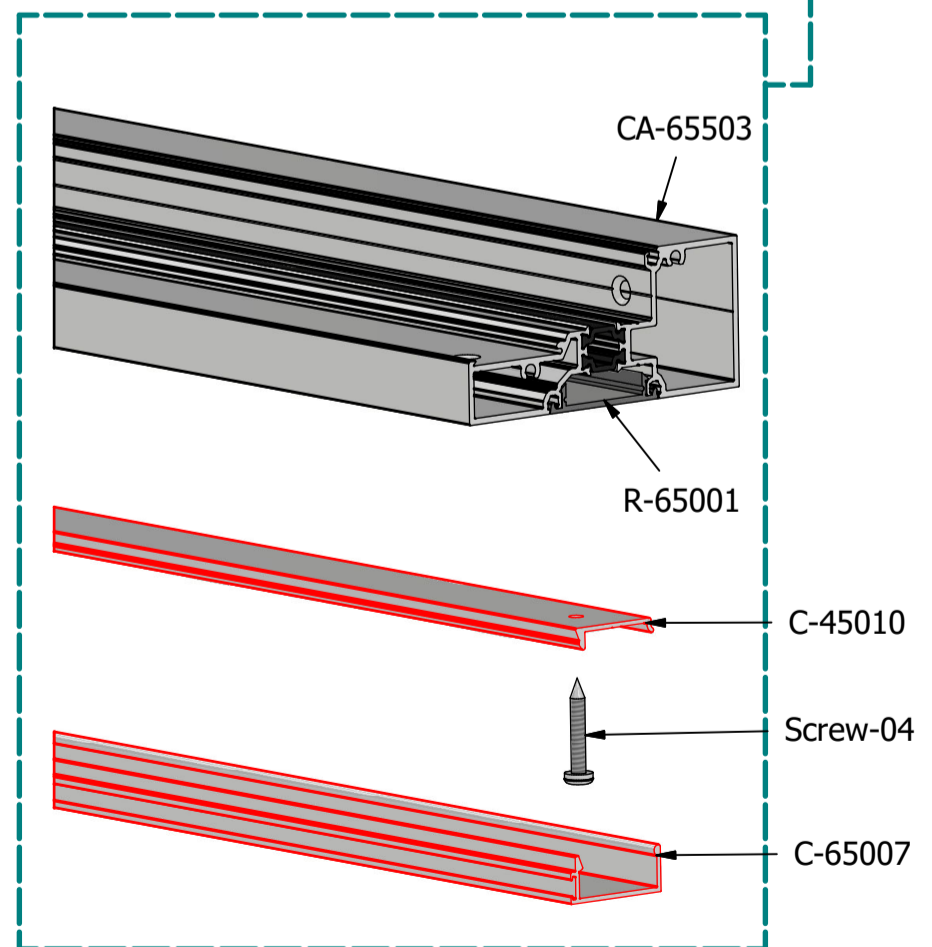
**1**



**2**

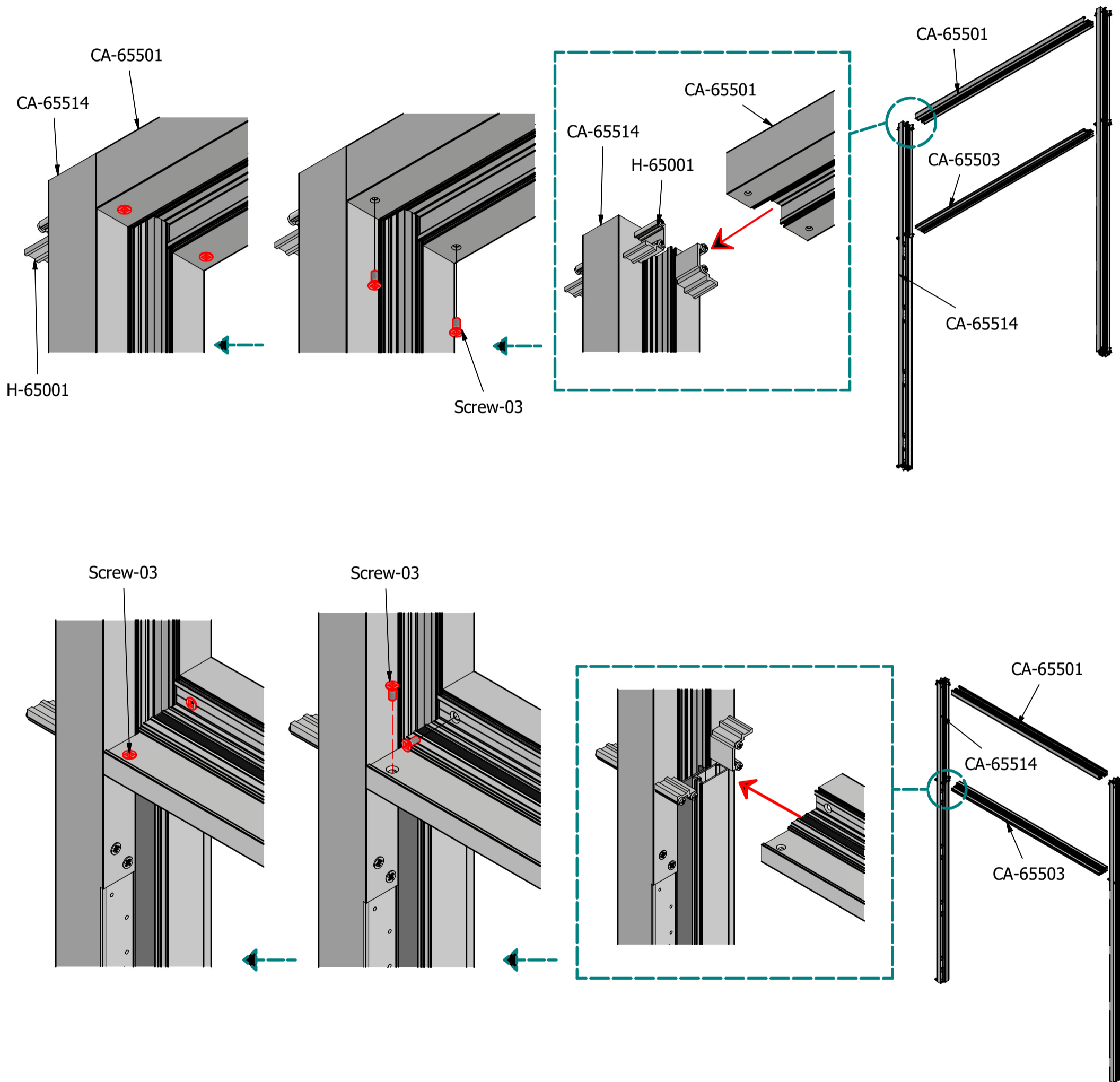


**1**



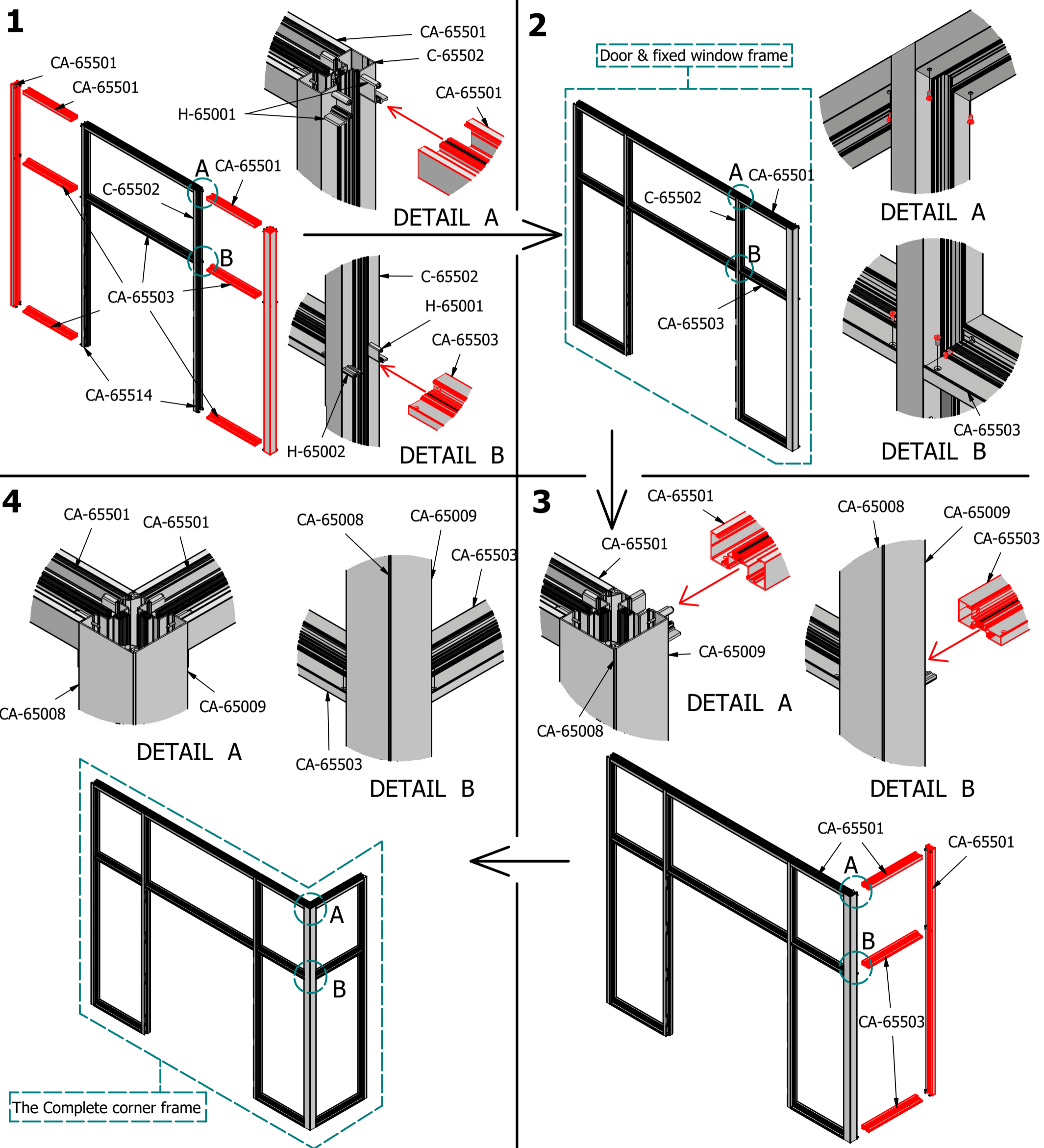
### STEP 4 (Door Frame Assembly):

Attach the head (CA-65501) and transom assembly (CA-65503) to the mullion assembly (CA-65514) by securing them onto the shear blocks (H-65001). Fasten them using #12 x 1/2" flat head screws (Screw-03) through the pre-drilled holes in the horizontals, as shown below.



## STEP 5 (Complete Frame Assembly):

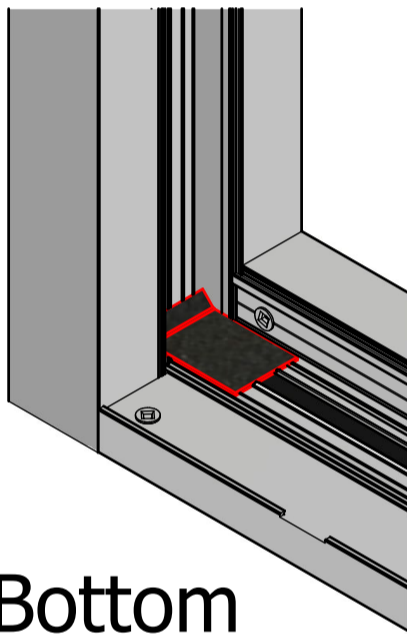
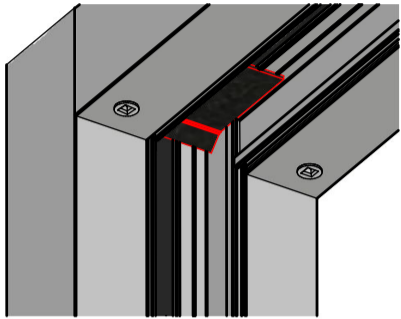
- Attach the remaining horizontals (CA-65501, CA-65503) to the mullion of the door frame (CA-65514) by securing them onto the shear blocks (H-65001, H-65002). Fasten them using #12 x 1½" flat head screws (screw-03) through the pre-drilled holes in the horizontals.
- Repeat this process to install the mullions (CA-65501) and the corner assembly (CA-65008, CA-65009) onto the horizontals installed in the previous step, forming the complete door and fixed window frame, as shown in Pictures 1 & 2.
- Then, repeat the same steps to assemble the entire corner frame, as shown in Pictures 3 & 4.



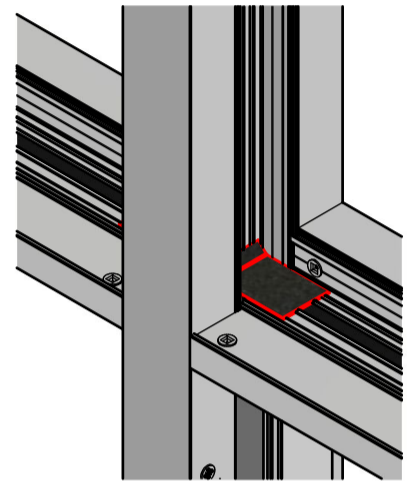
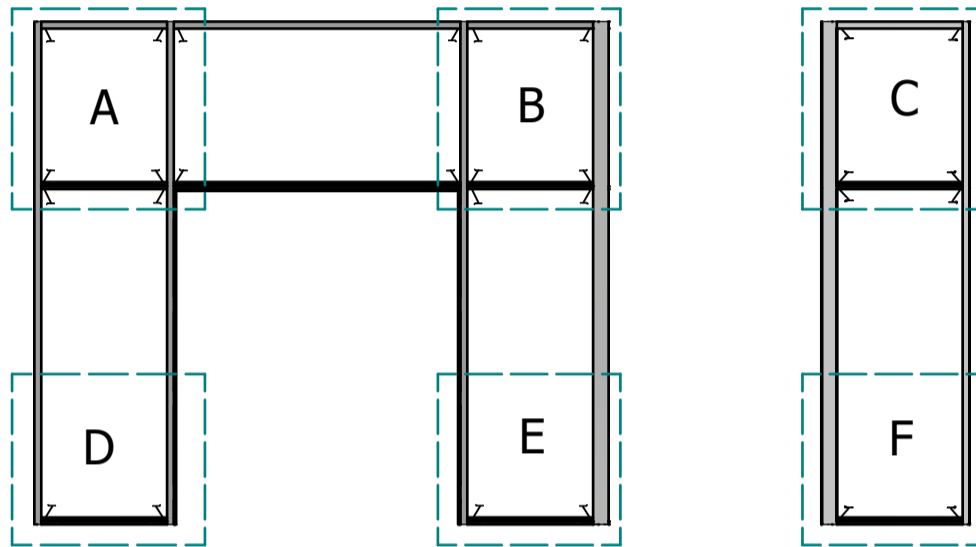
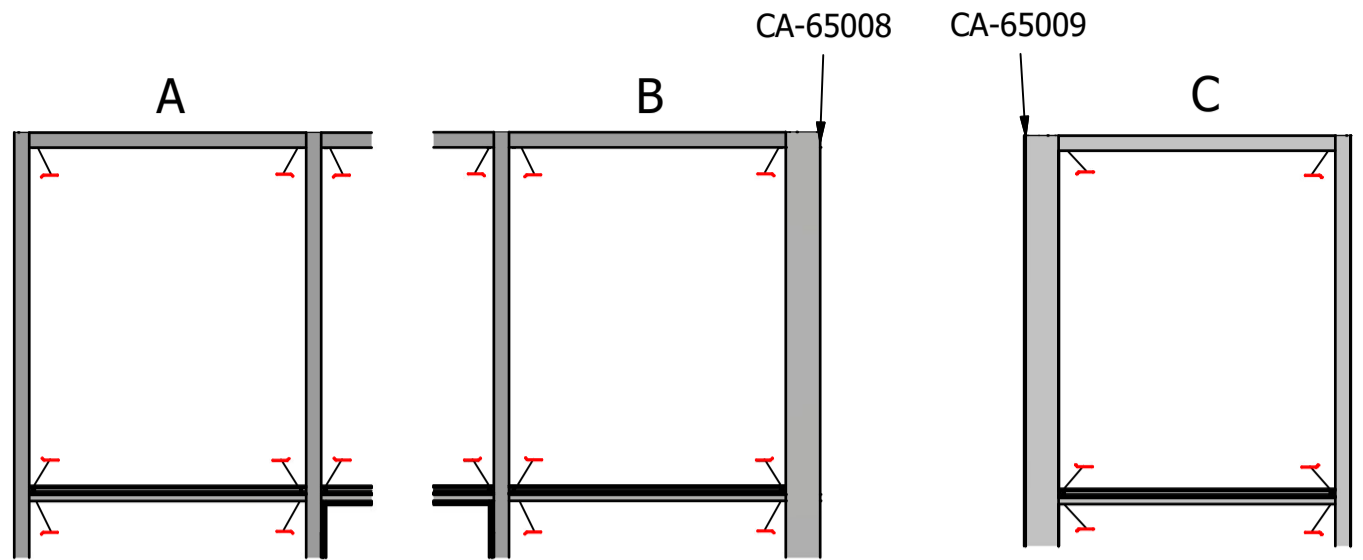
## STEP 6 (Water deflector):

Secure water deflectors at the corners of each opening, except for the door opening, by adhering them with silicone.

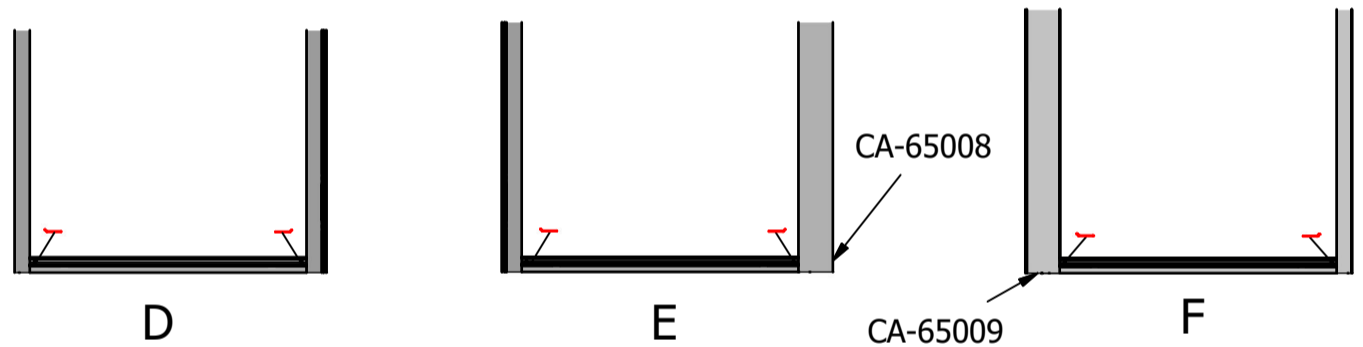
### Head



### Bottom

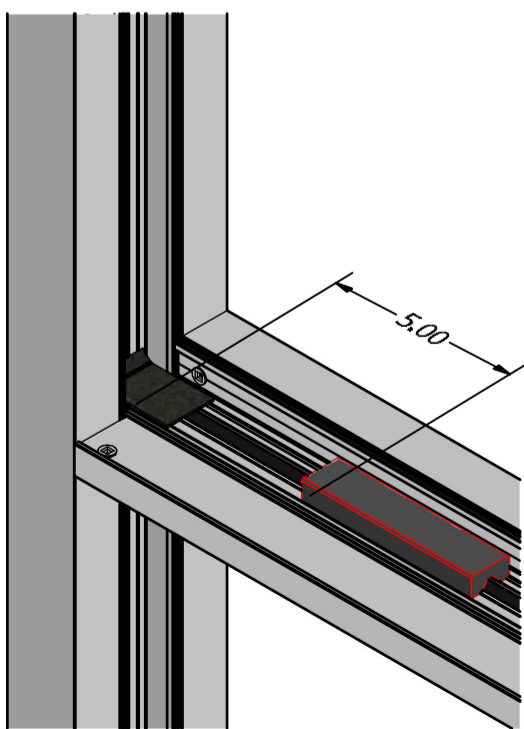


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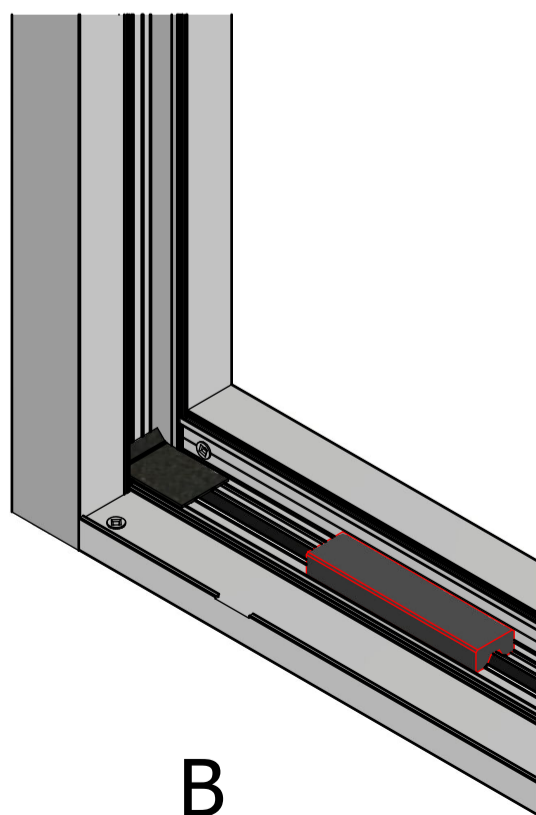


## STEP 7 (Sitting blocks):

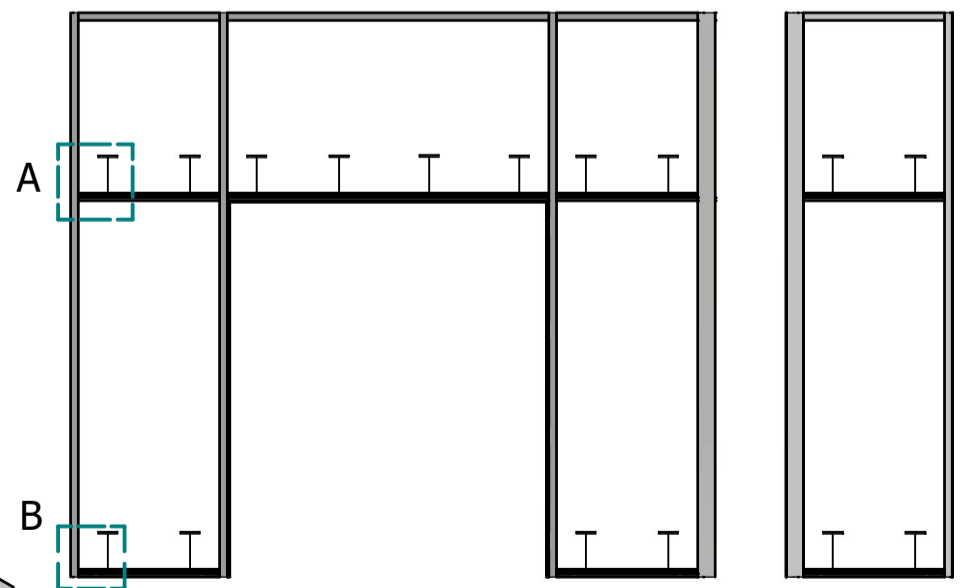
Position setting blocks on top of transoms and sills, placing them 5 inches from the edge on each side, as shown below.



### A

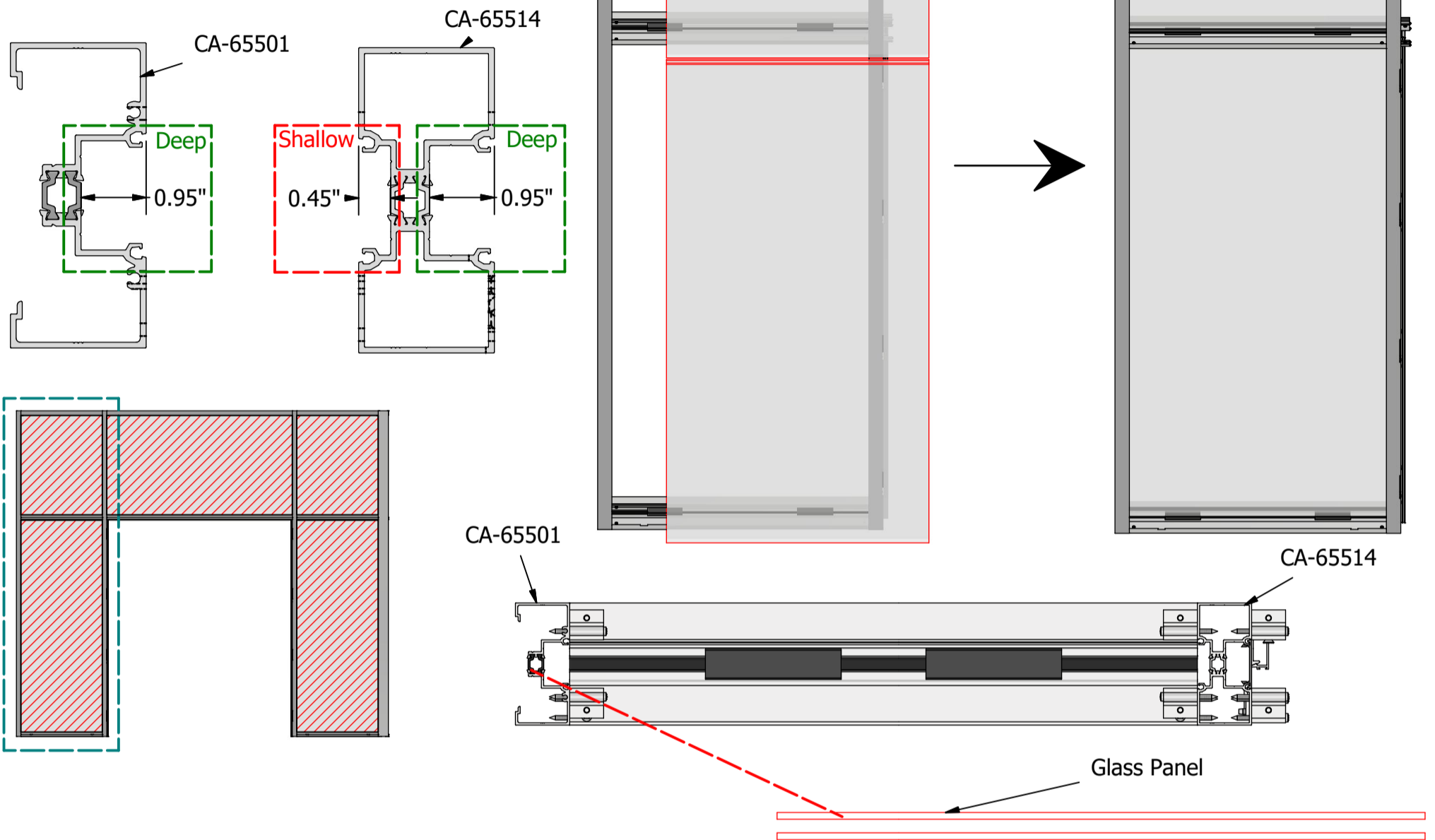


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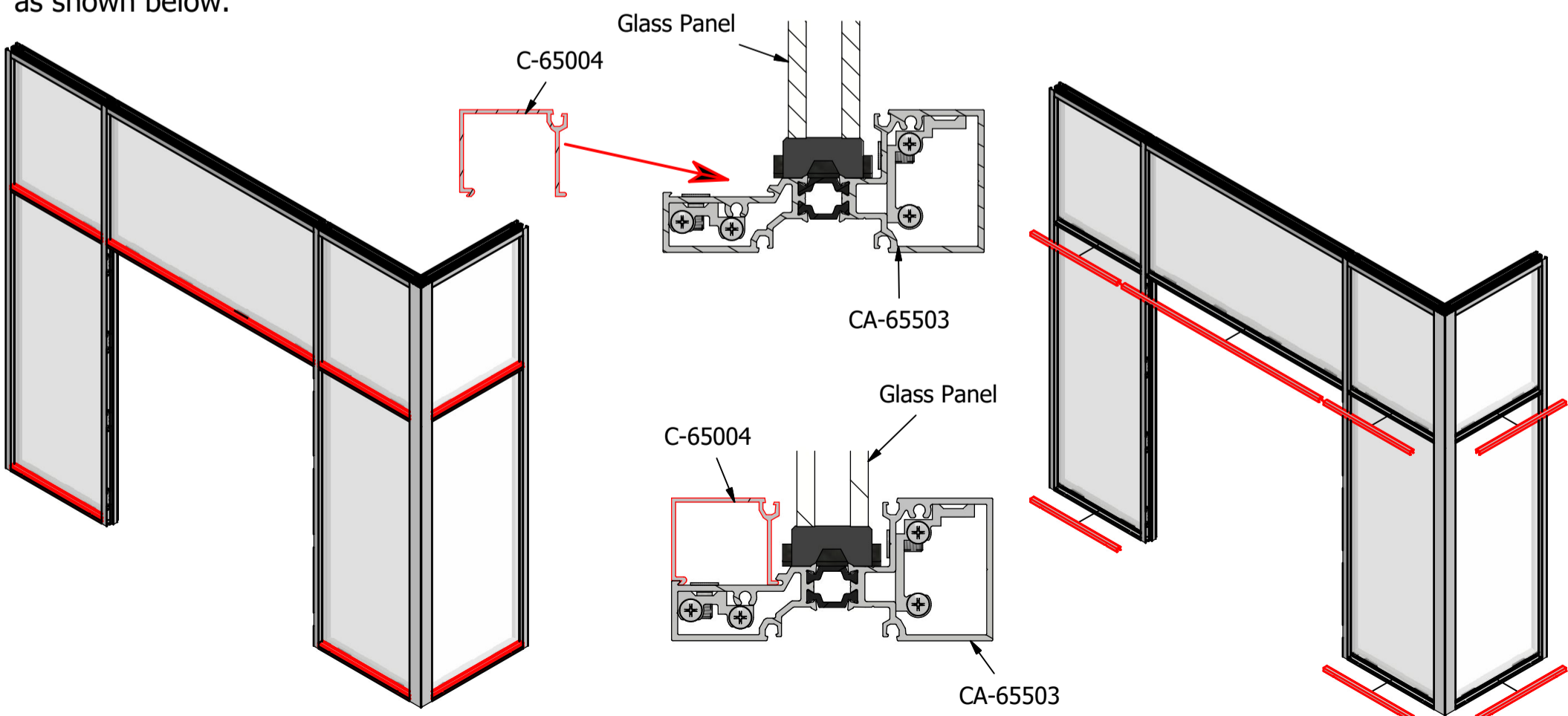
## STEP 8 (Glass Panels Installation):

Insert the glass panels into each day light opening by **first** sliding them into the **deep pocket**, then seating them into the **shallow pocket**, as shown below.



## STEP 9 (Glass Stop Installation):

Install the glass stops in front of and at the bottom of each glass panel using hand pressure or a soft-faced hammer, as shown below.



**STEP 10 (Gasket Installation):**

- Insert gaskets (**R-65002-R**) into the horizontal and vertical members of each daylight opening in the frame, ensuring they are fully seated in the grooves shown below.

- Additionally, insert gasket (**R-60188**) into the groove of the door stop cap at the sides and head of the door, as shown below.

