

TABLE OF CONTENTS

Assembly

Fabrication

01	Table of Contents
02	Exploded view of the frame Exploded view , Parts List
03	Dimensional Details and Cross Sections Dimensional Formulas
04	Door Frame Mullions CA-65514
05	Door Stop Base , Door Stop Cap & Filler Adaptor C-45010 , C-65007 , R-65001
06	Corner Mullions (Male & Female) & End Mullions CA-65008, CA-65009, CA-65501
07	Head, Transom & Sill CA-65501, CA-65503, C-65004
08	Step 1 : Shear Block installation on mullions
09	Step 1 : Shear Block & Backup plates installation on Door Frame mullions
10	Step 2 : Filler Adaptor installation
11	Step 3 : Door Stop (Base & Cap) installation
12	Step 4 : Door Frame Assembly
13	Step 5 : Complete Frame assembly
14	Step 6 : Water Deflectors Step 7 : Setting Blocks
15	Step 8 : Glass Panels installation Step 9 : Glass Stop installation
16	Step 10 : Gaskets installation



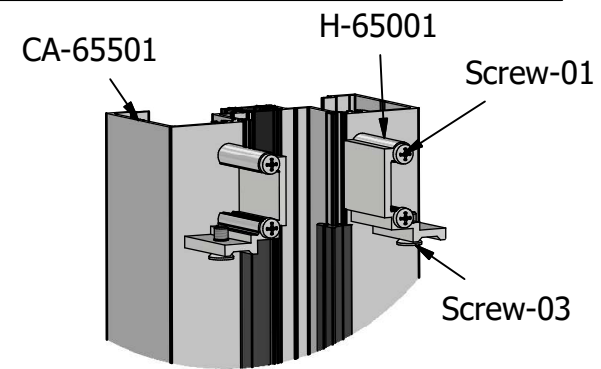
F a b r i c a t i o n

D r a w i n g s



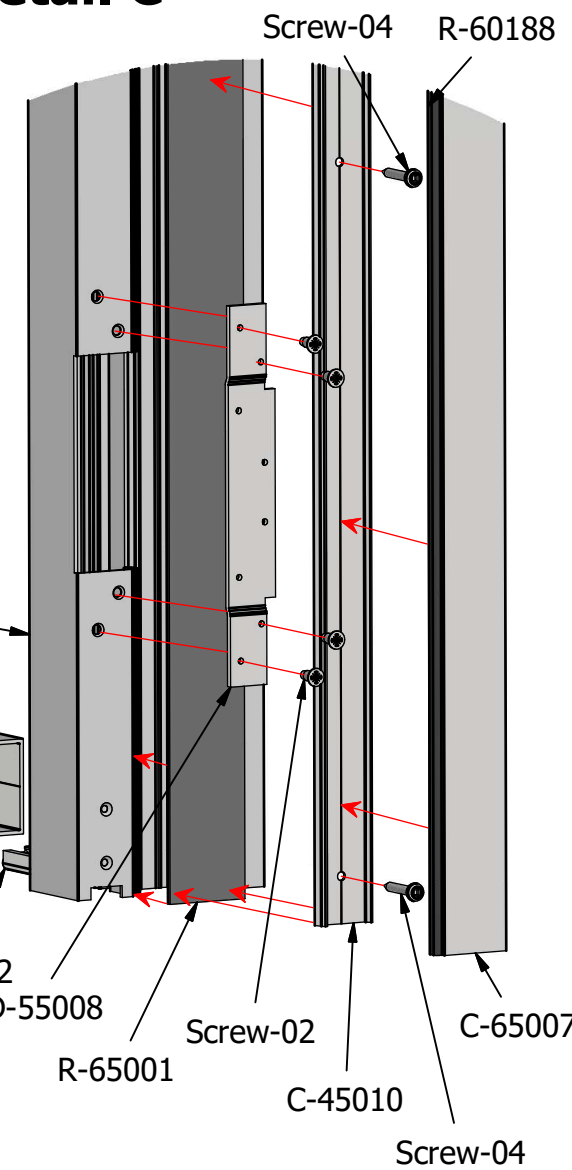
655 Series

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

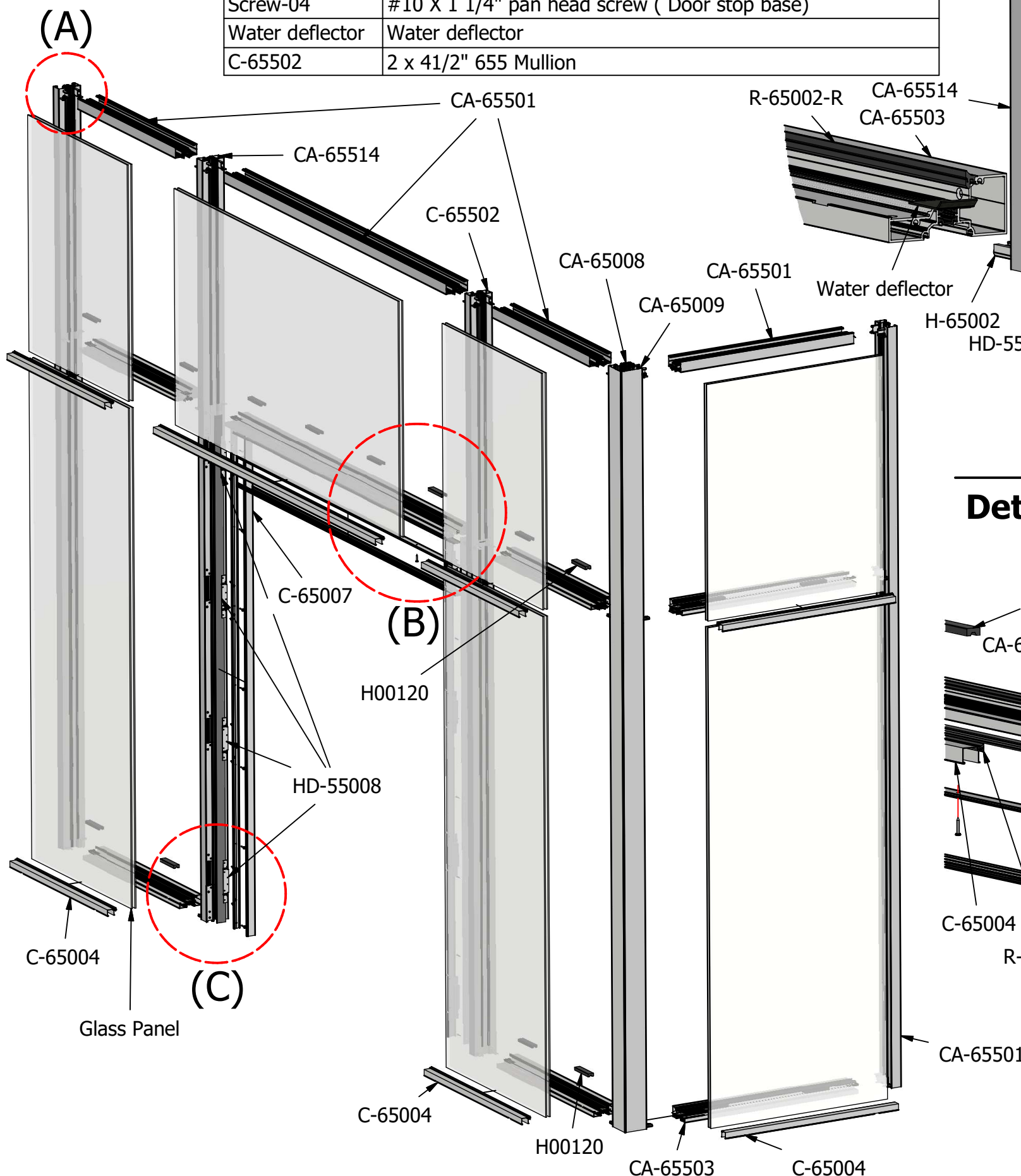
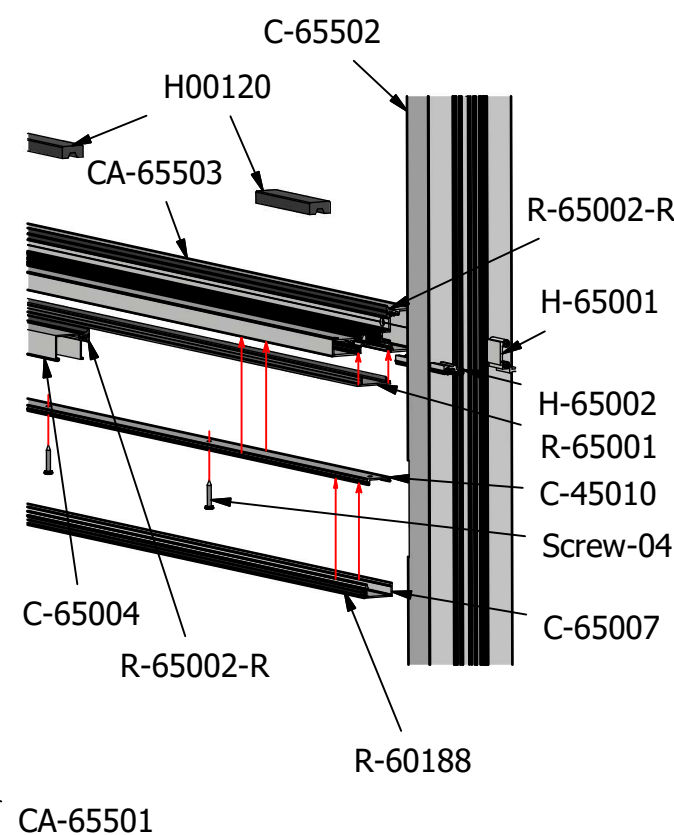


Detail A

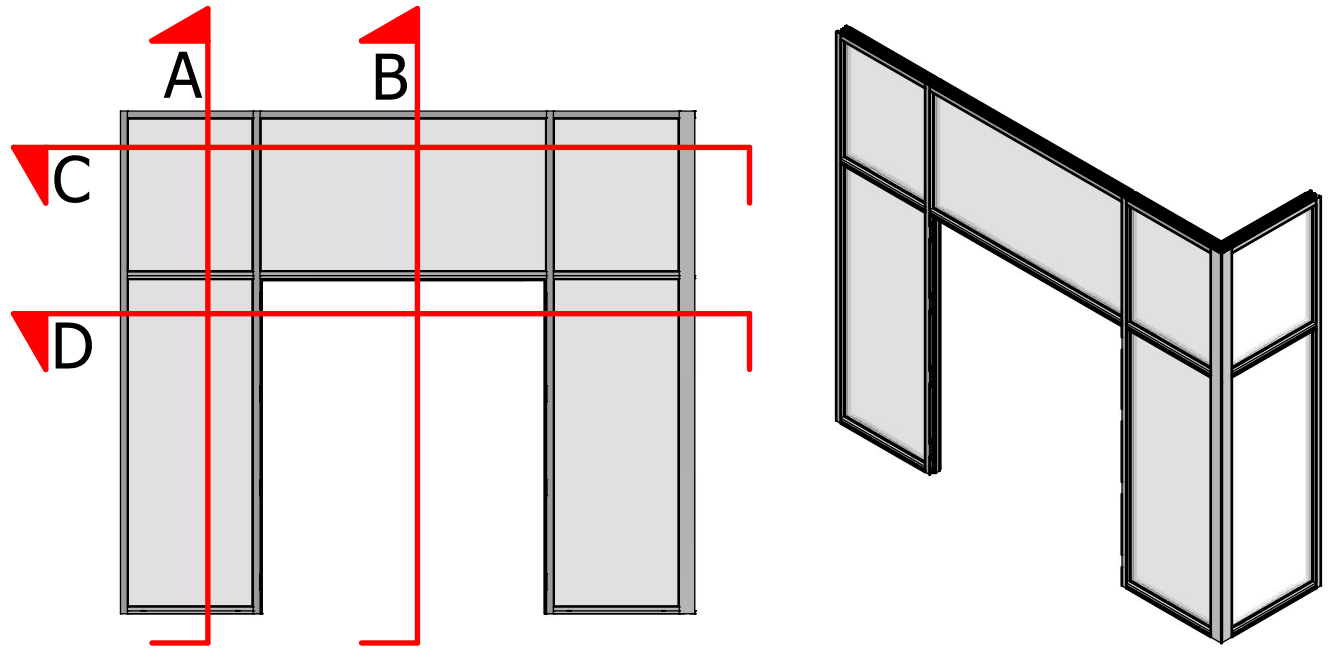
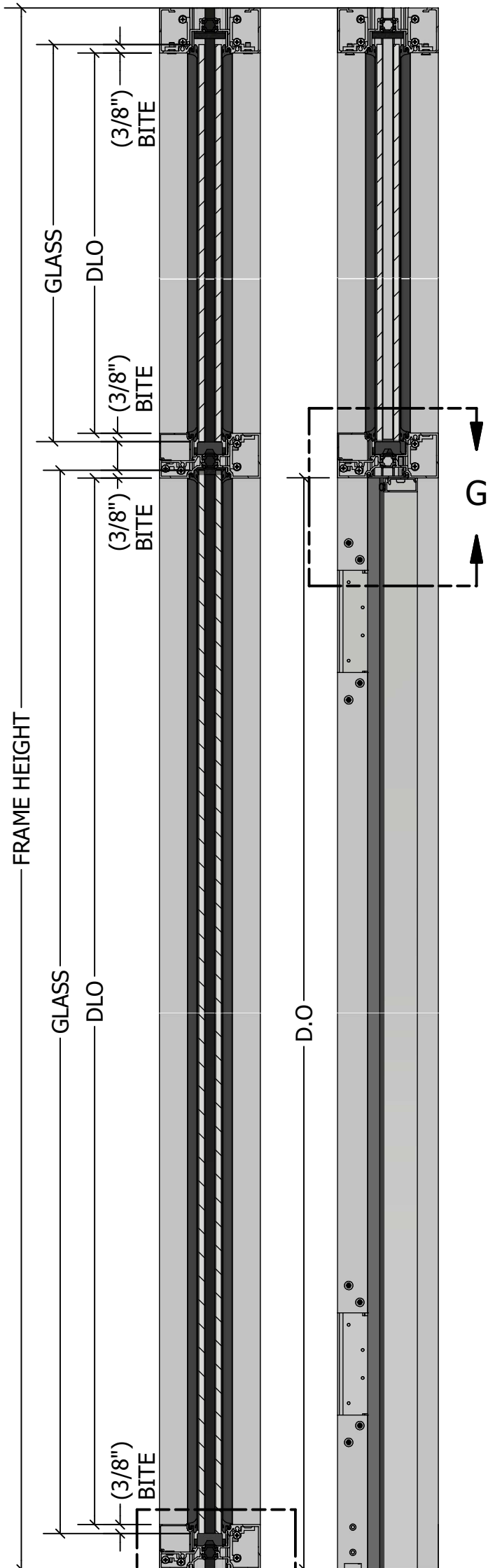
Detail C



Detail B



Section-A Section-B



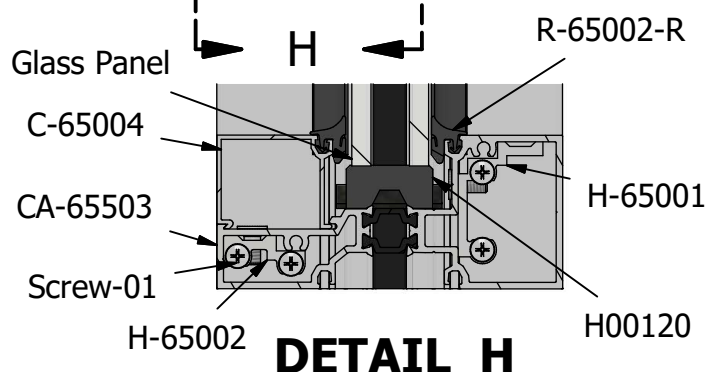
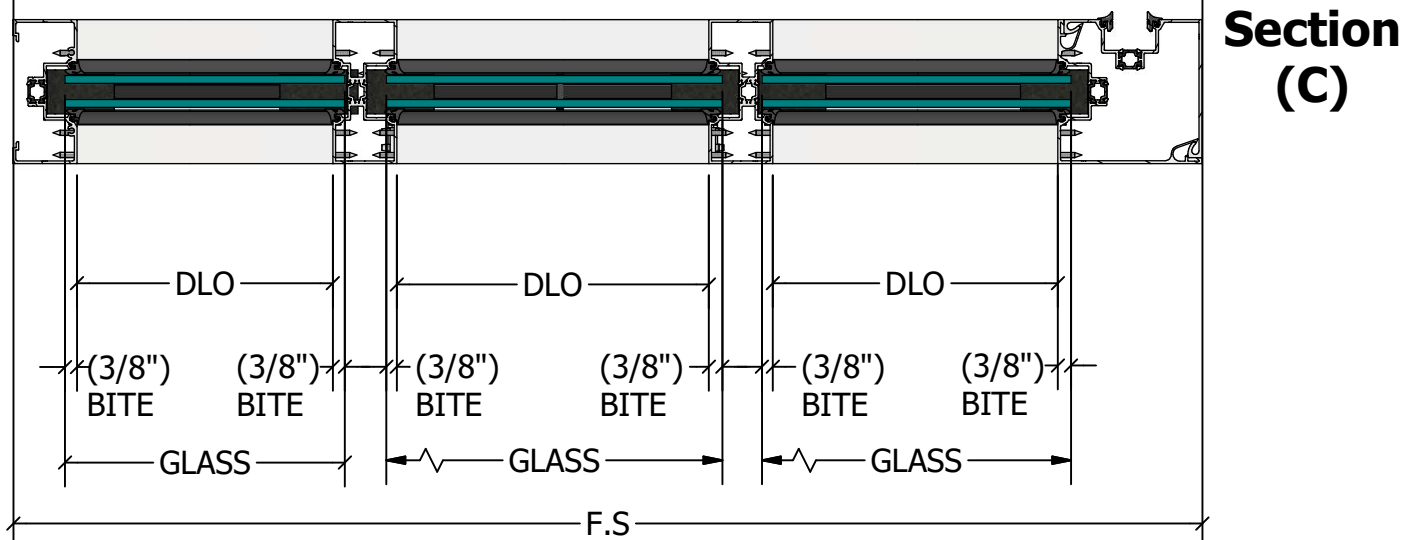
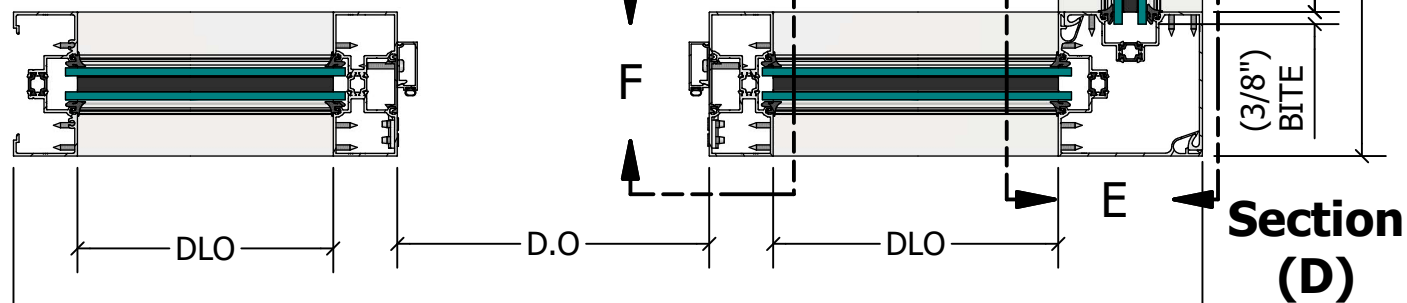
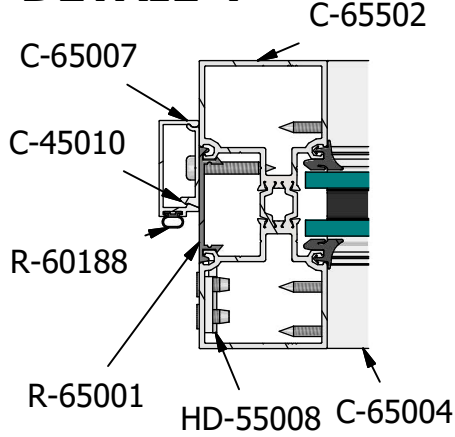
Notes:

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

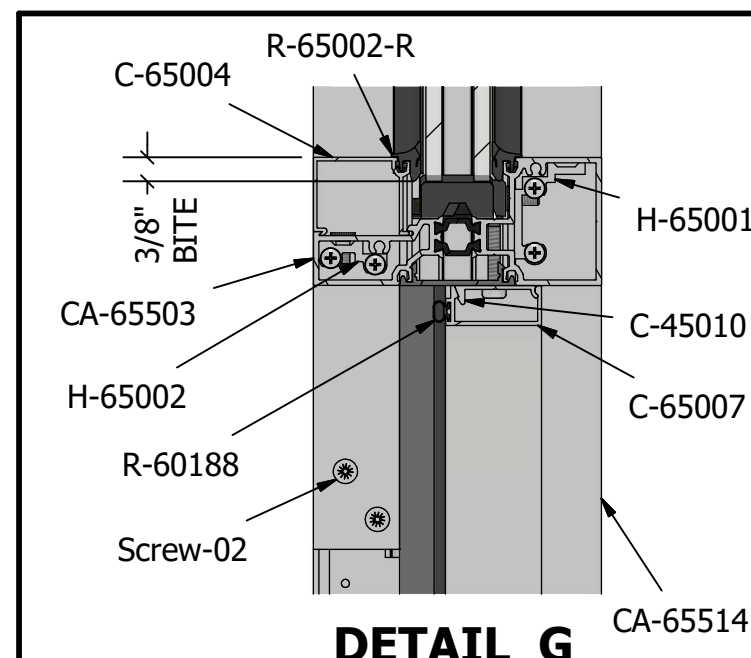
- Glass Width = DLO + 0.75"
- Glass Height = DLO + 0.75"

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

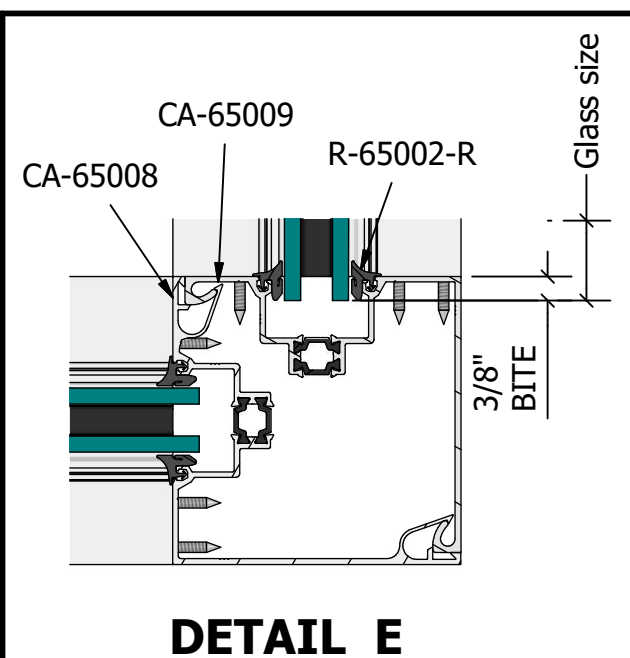
DETAIL F



DETAIL H

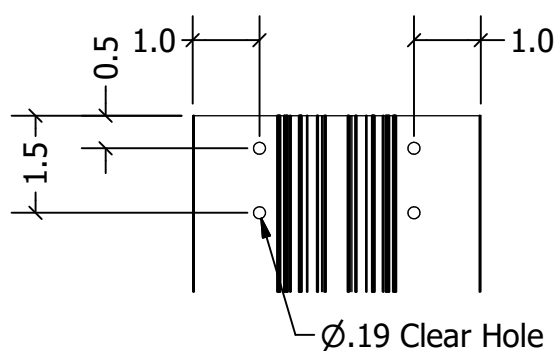


DETAIL G

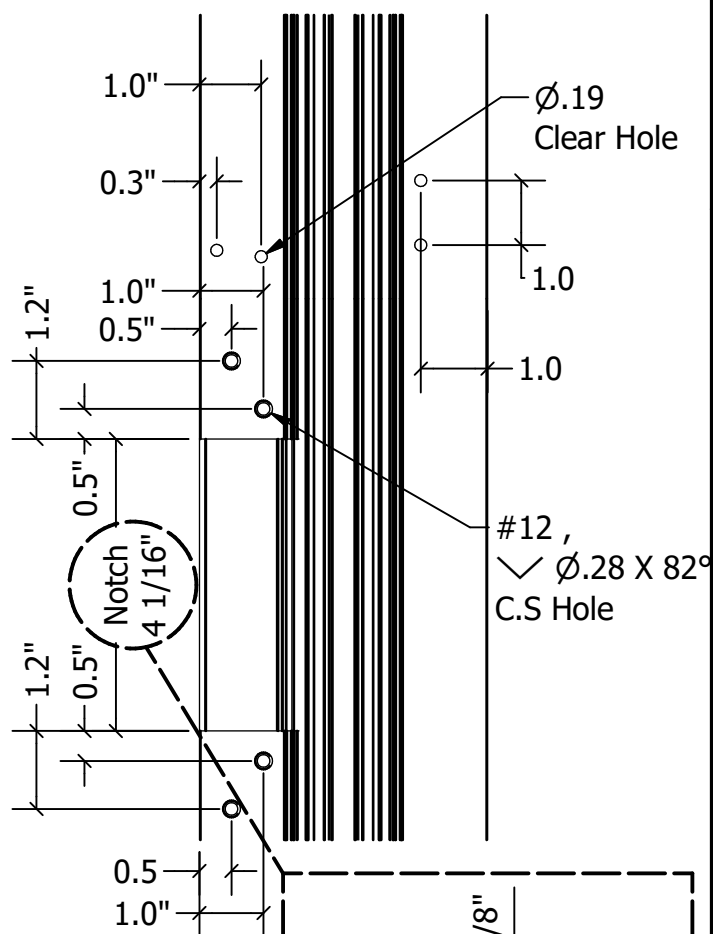


DETAIL E

DETAIL A

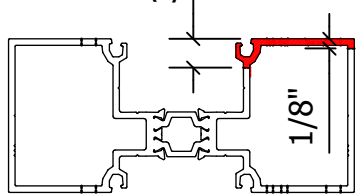


DETAIL B



Note:

Notch as shown:
Width extends to groove,
1/2" deep from inside,
1/4" deep from outside.



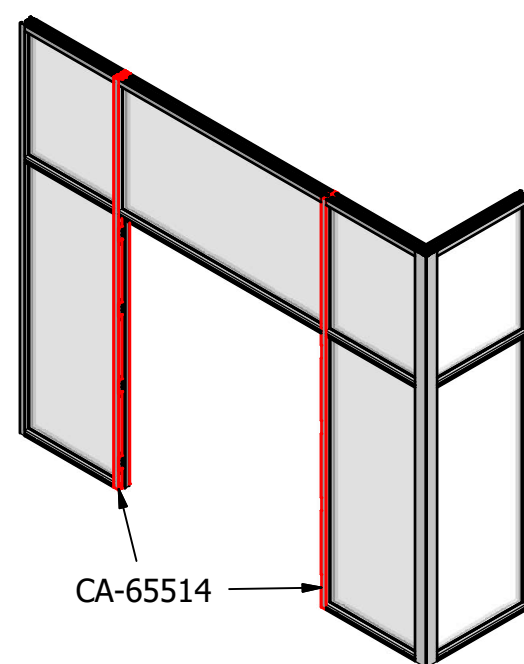
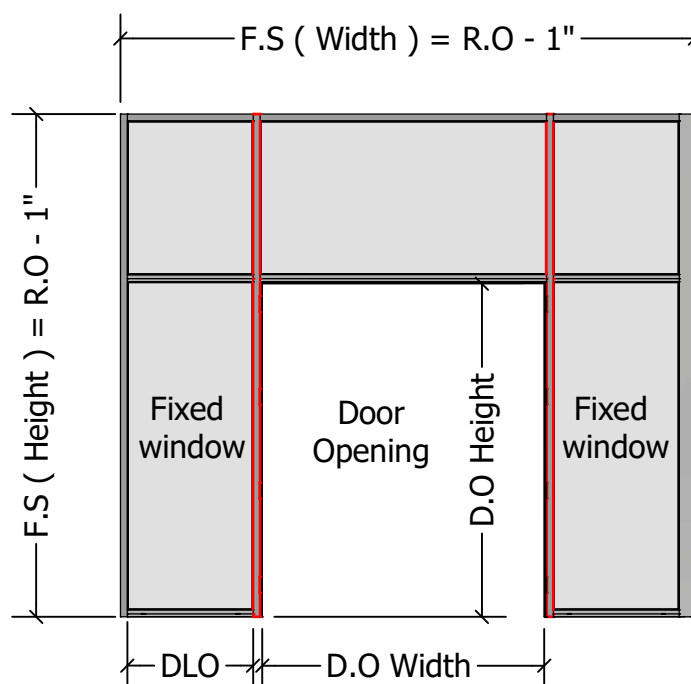
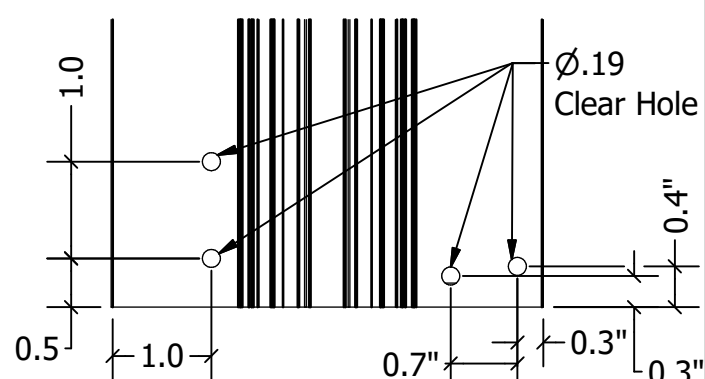
Note:

Refer to **page 09** of the HTP Door Fabrication Manual for sizes and locations of frame mullion (CA-65514) notches and holes for threshold bracket attachment.

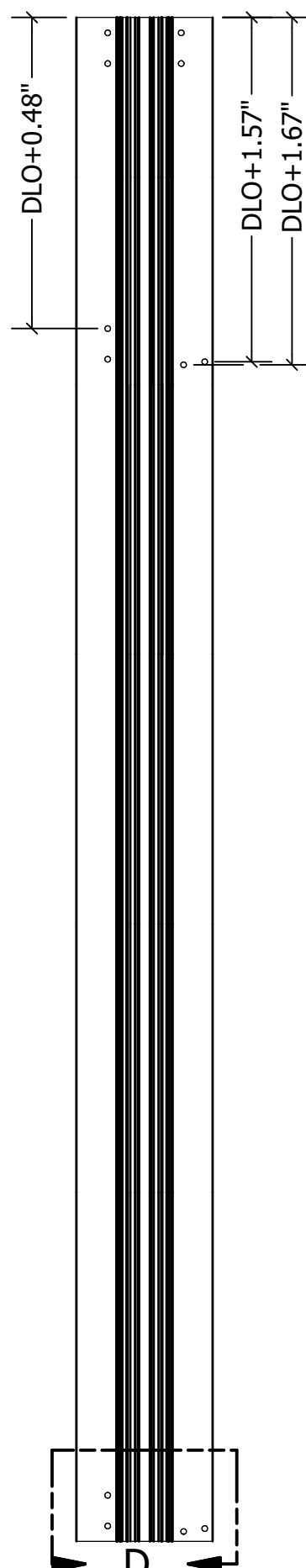
DETAIL C



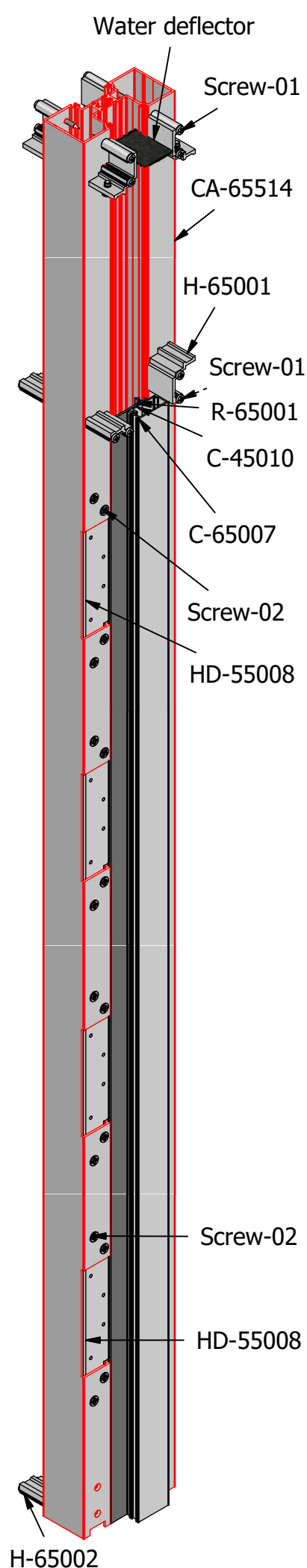
DETAIL D

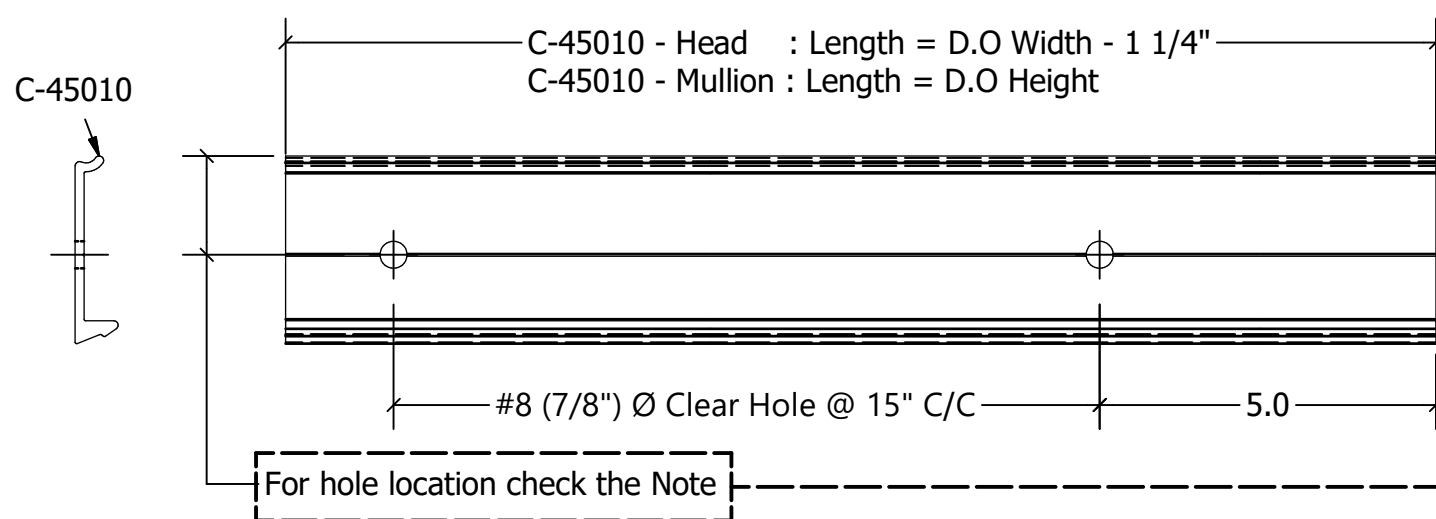
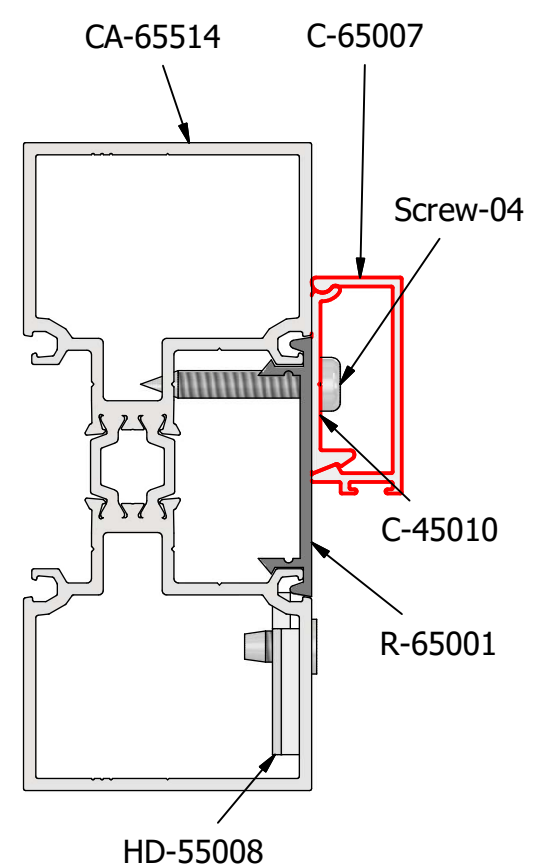
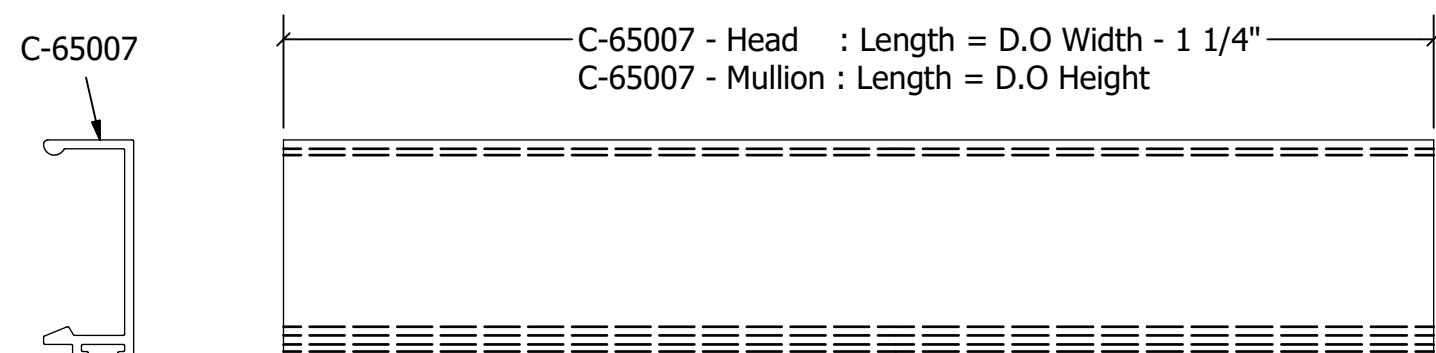
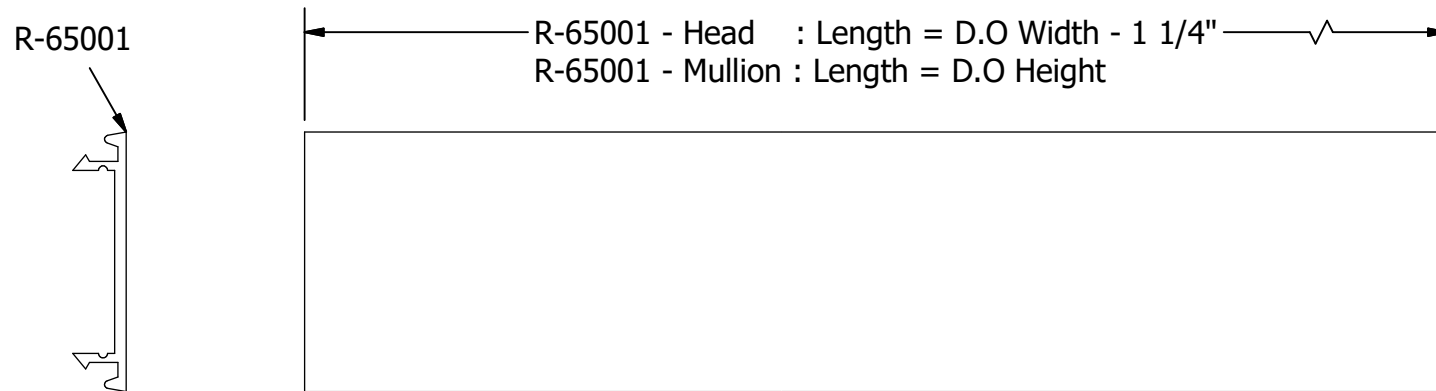
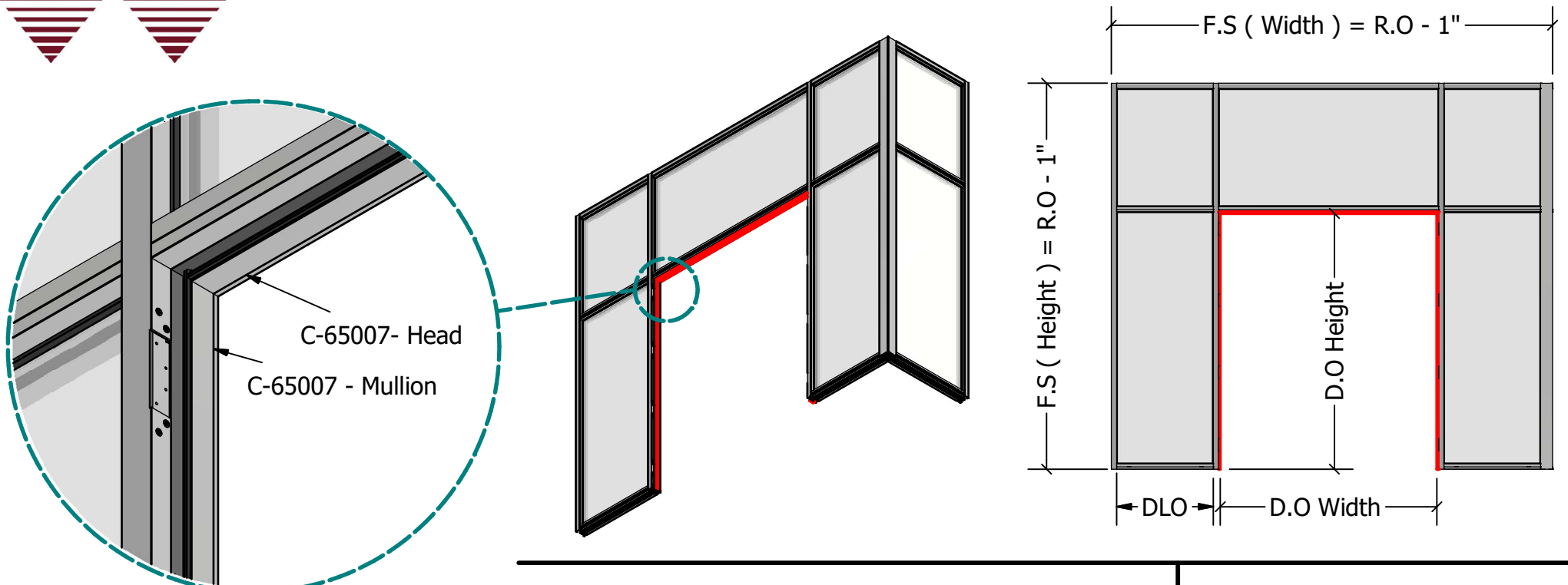


View From Fixed Window Side



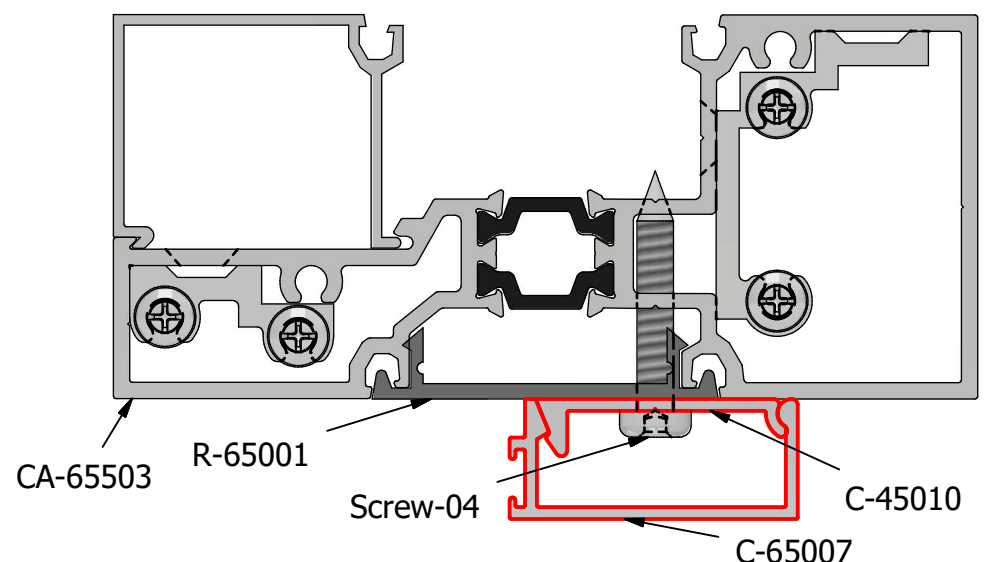
**View From
Door Opening
Side**

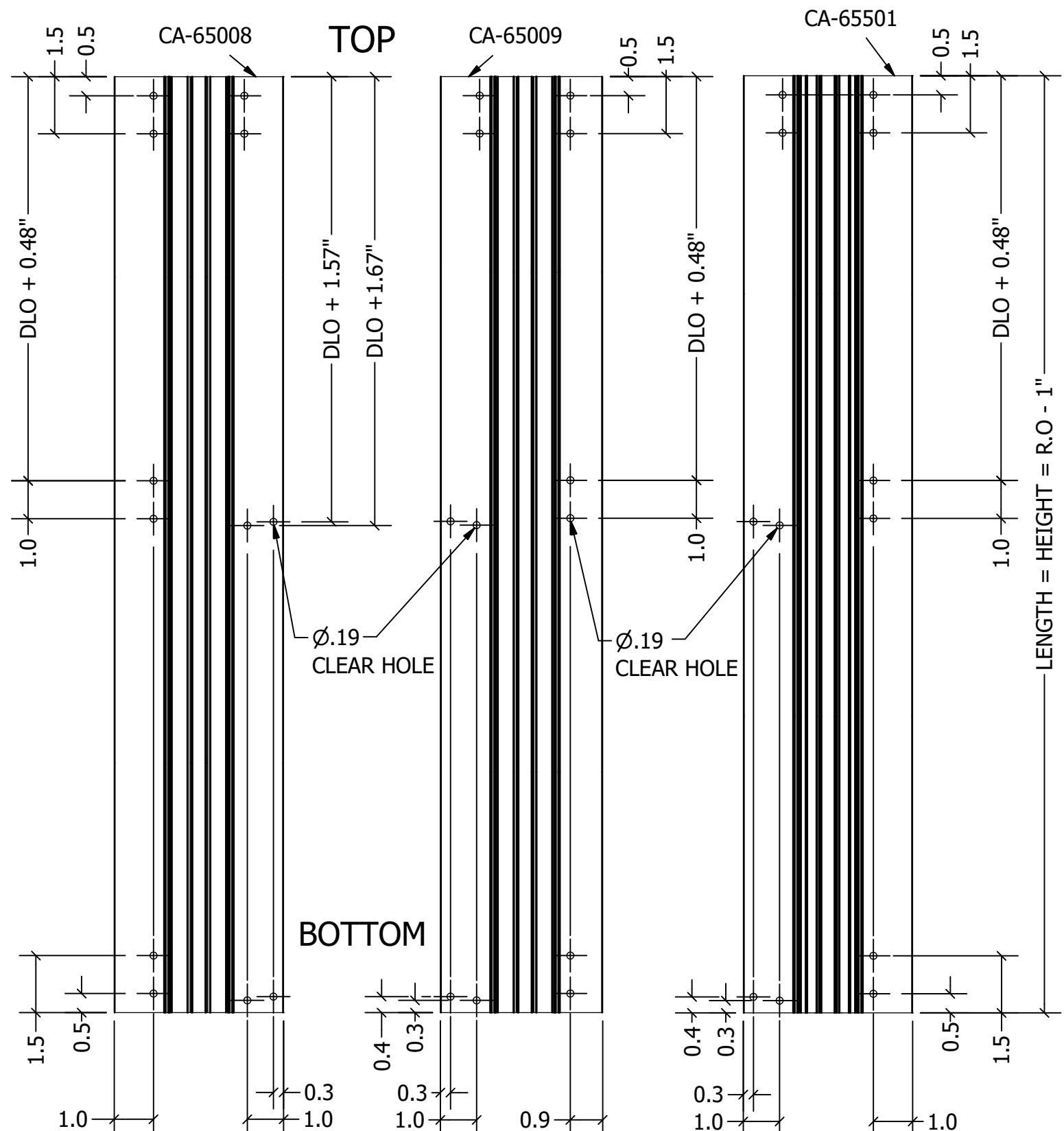
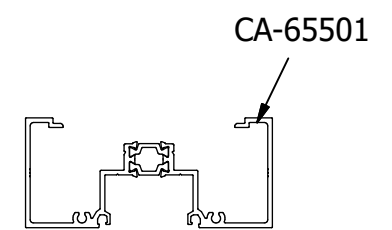
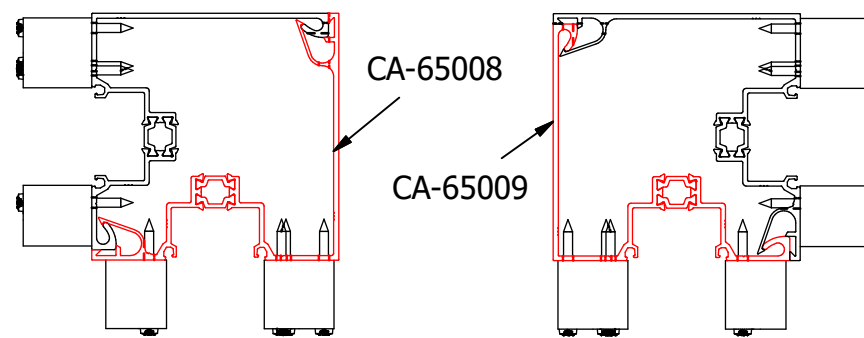
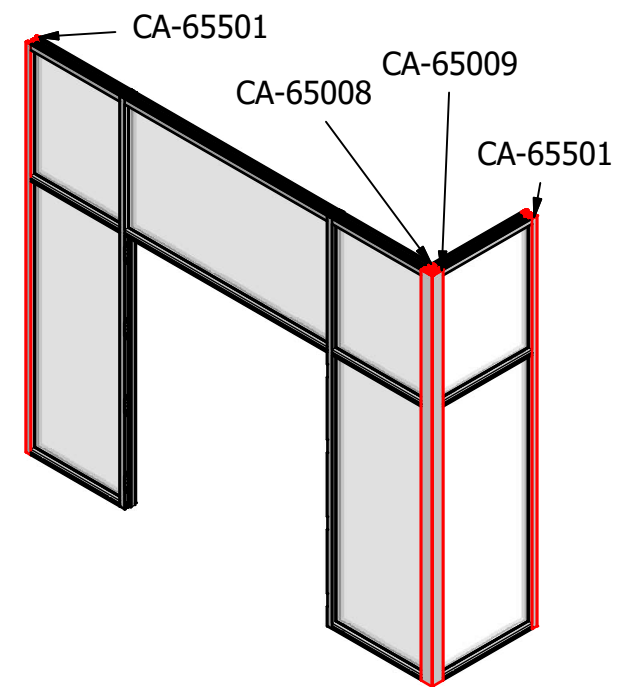
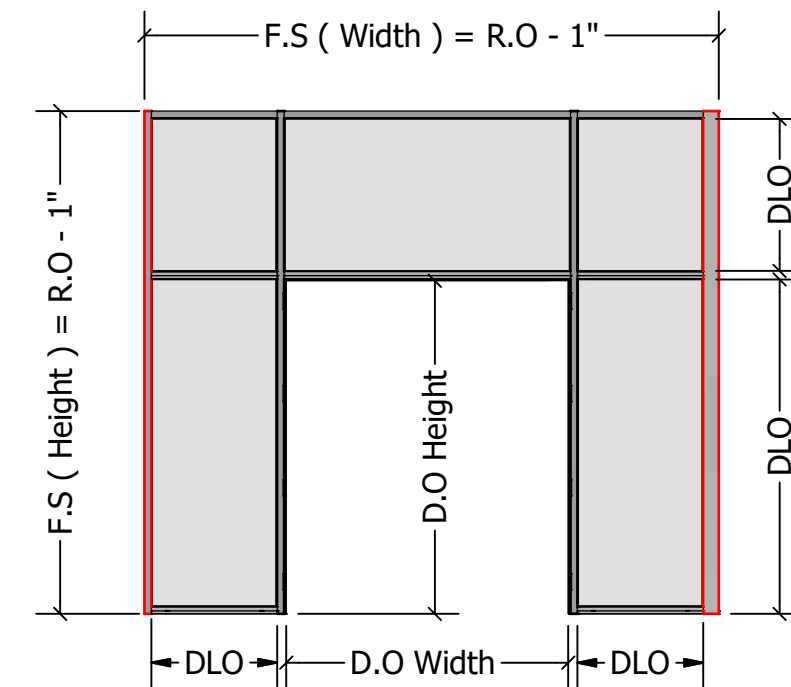


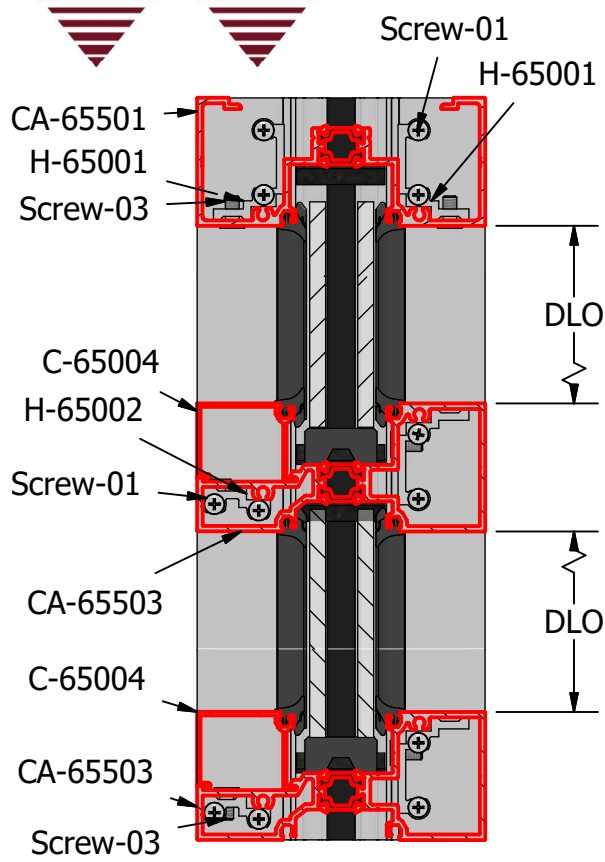


Note:
Position holes on Door Stop Base (C-45010) to prevent screw penetration into the mullion thermal break.

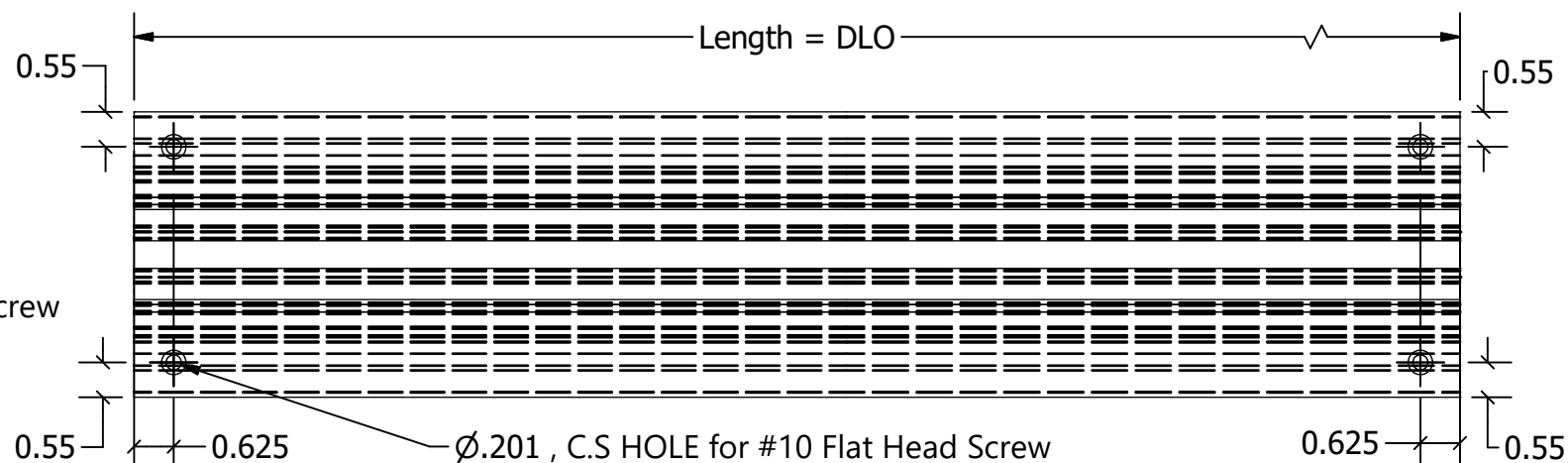
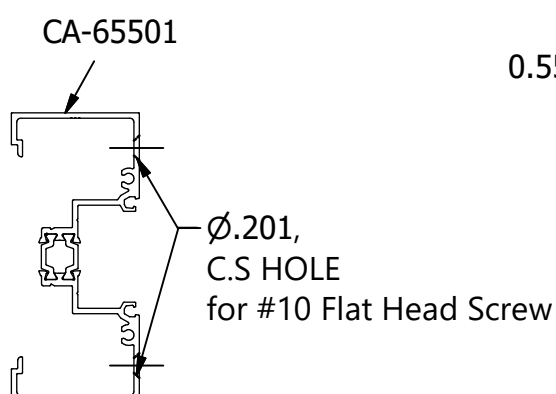
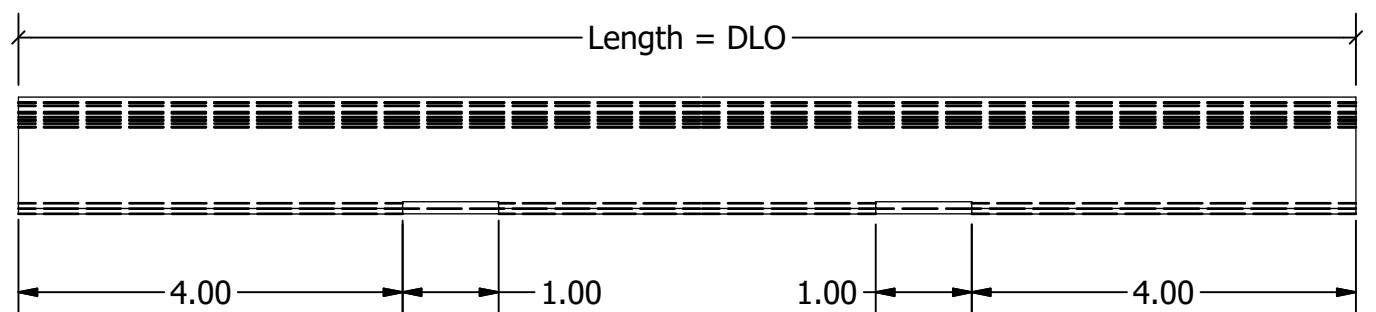
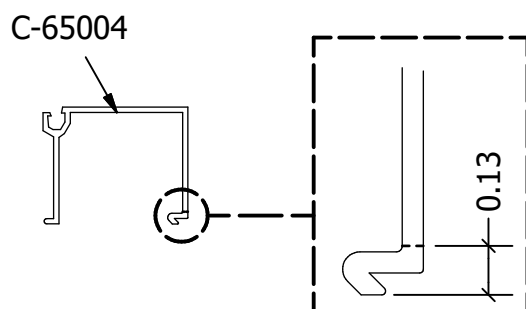
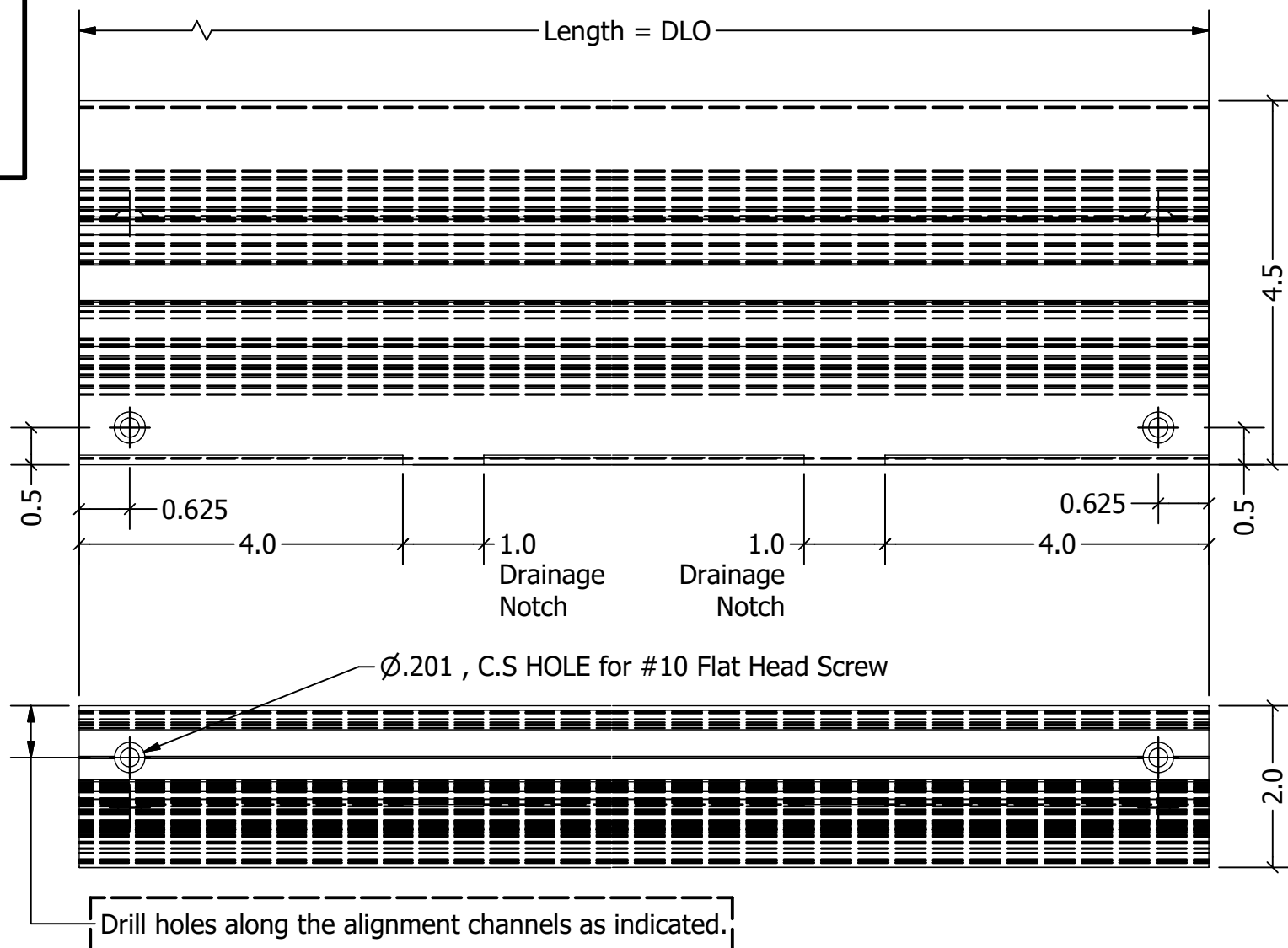
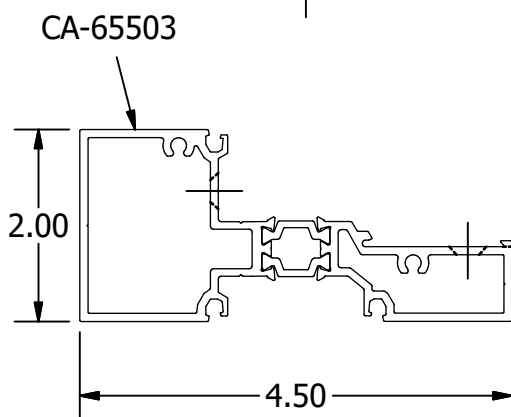
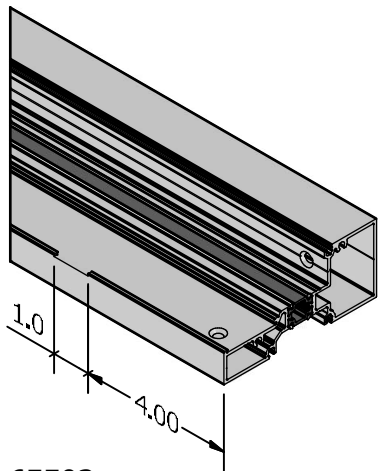
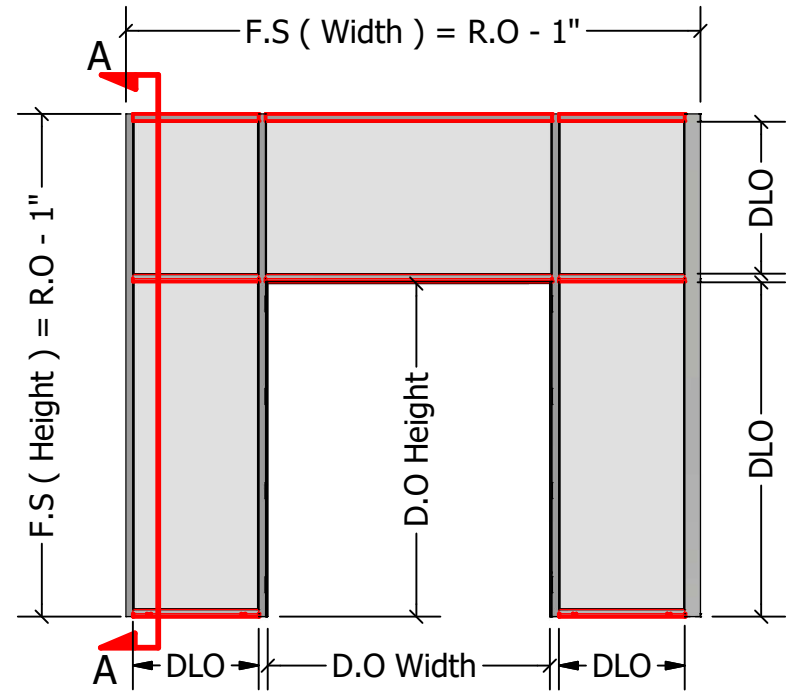
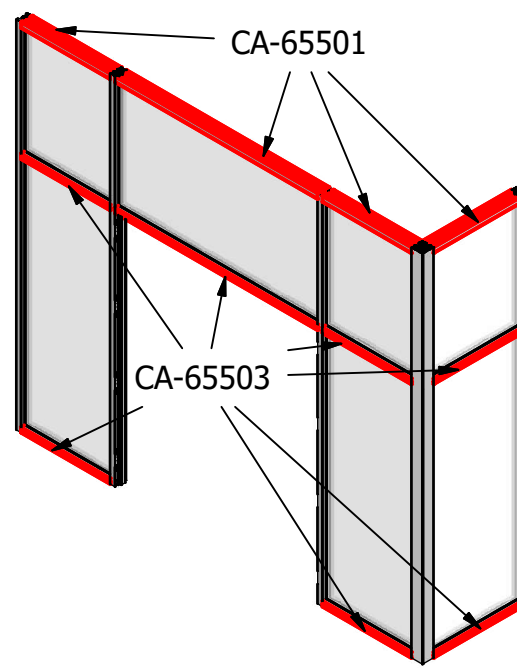
PARTS LIST	
PART NUMBER	DESCRIPTION
C-45010	Door Stop Base
C-65007	Door Stop Cap
CA-65503	2 x 4 1/2" Horizontal Sill
CA-65514	2 x 4 1/2" 655 Mullion
HD-55008	Back up Plate for Butt Hinges
R-65001	PVC mullion Filler Adaptor
Screw-04	#10 X 1 1/4" pan head screw (Door stop base)
C-65502	2 x 4 1/2" 655 Mullion







Section A-A

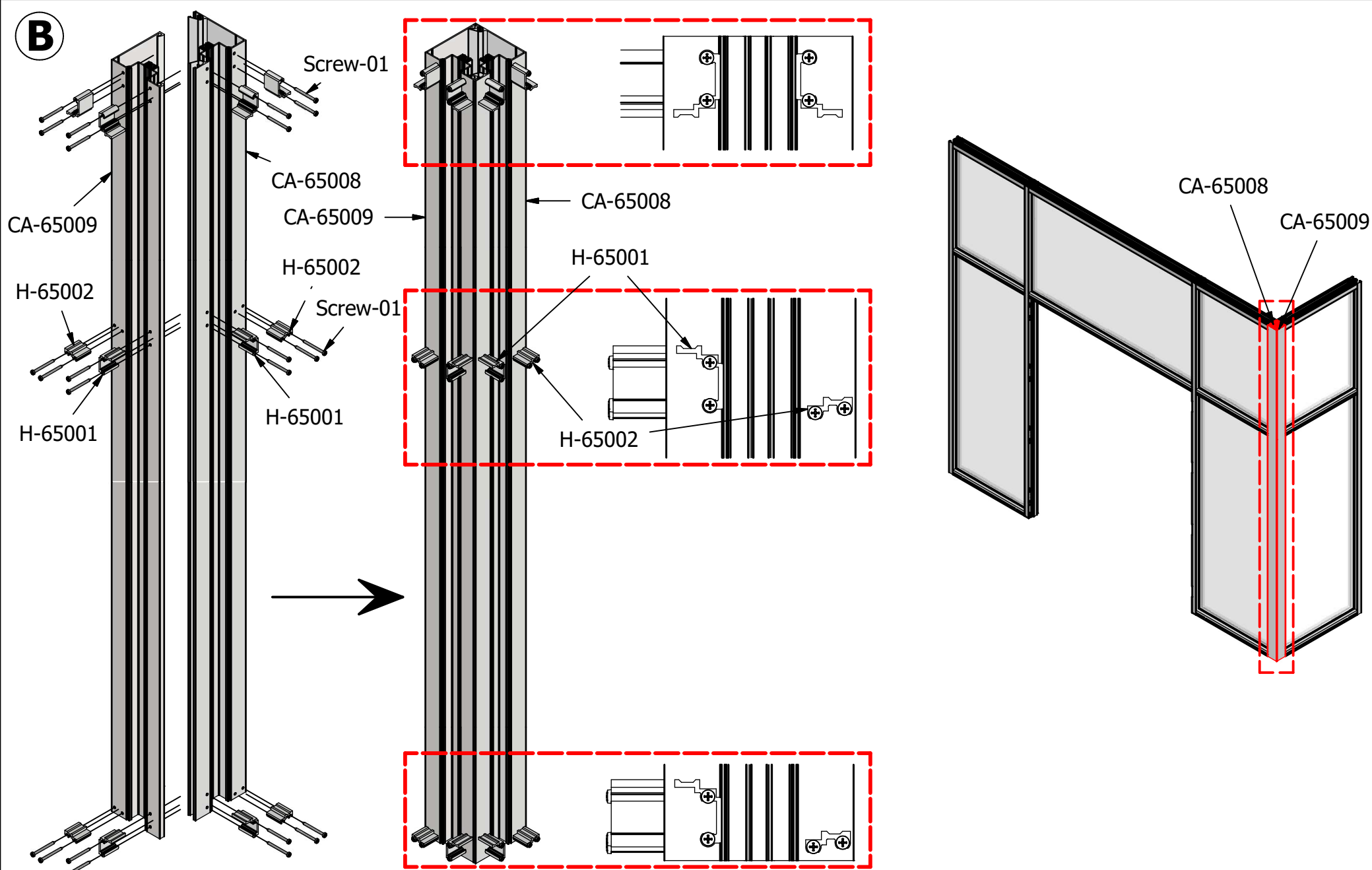
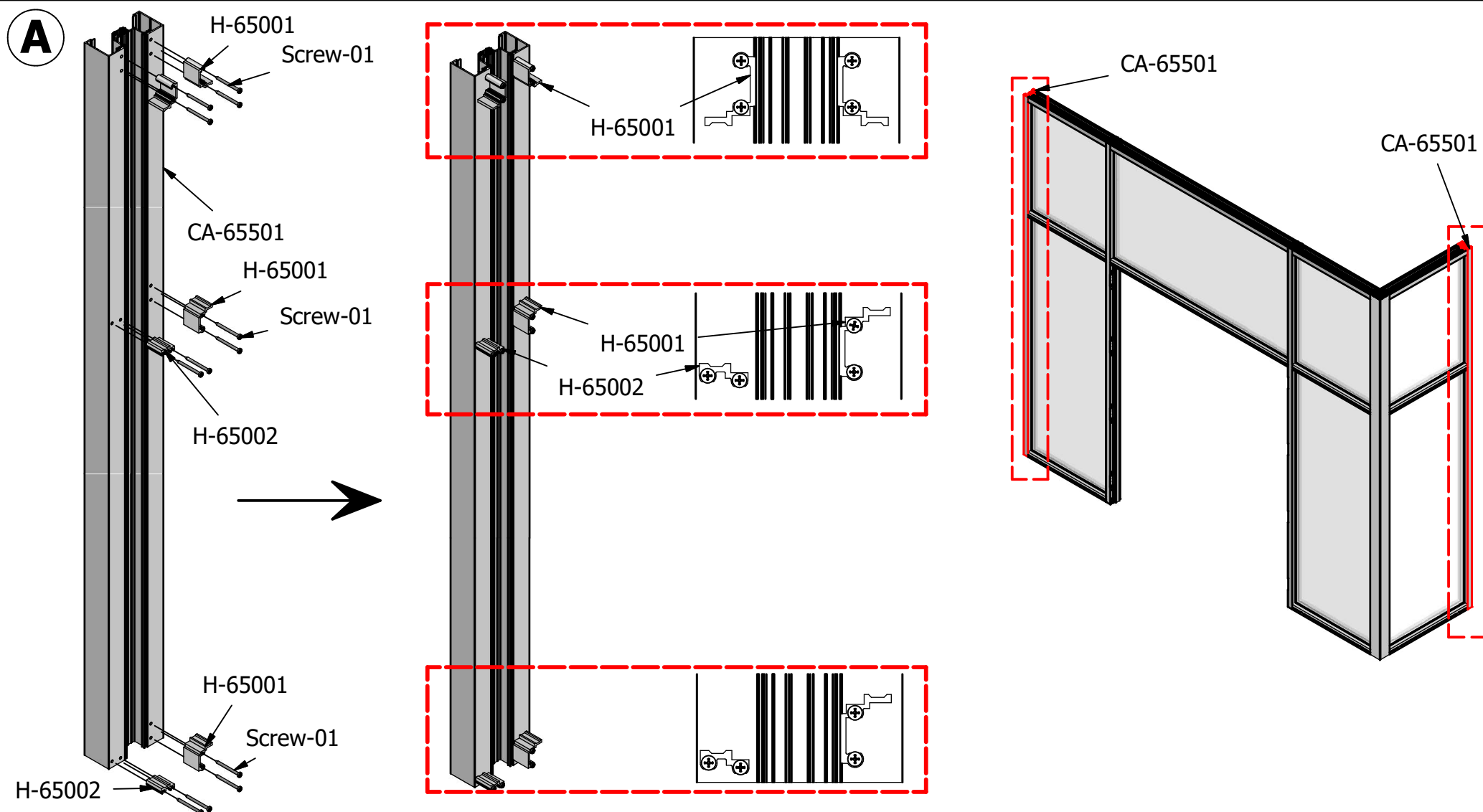


A S S E M B L Y

S T E P S

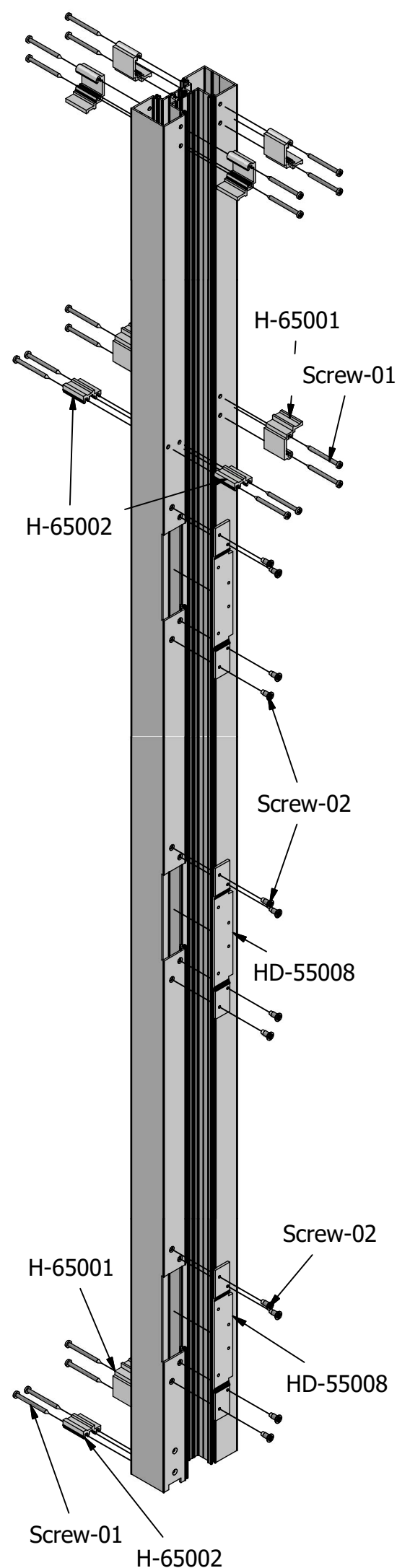
STEP 1 (Shear Block Installation on Mullions):

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.

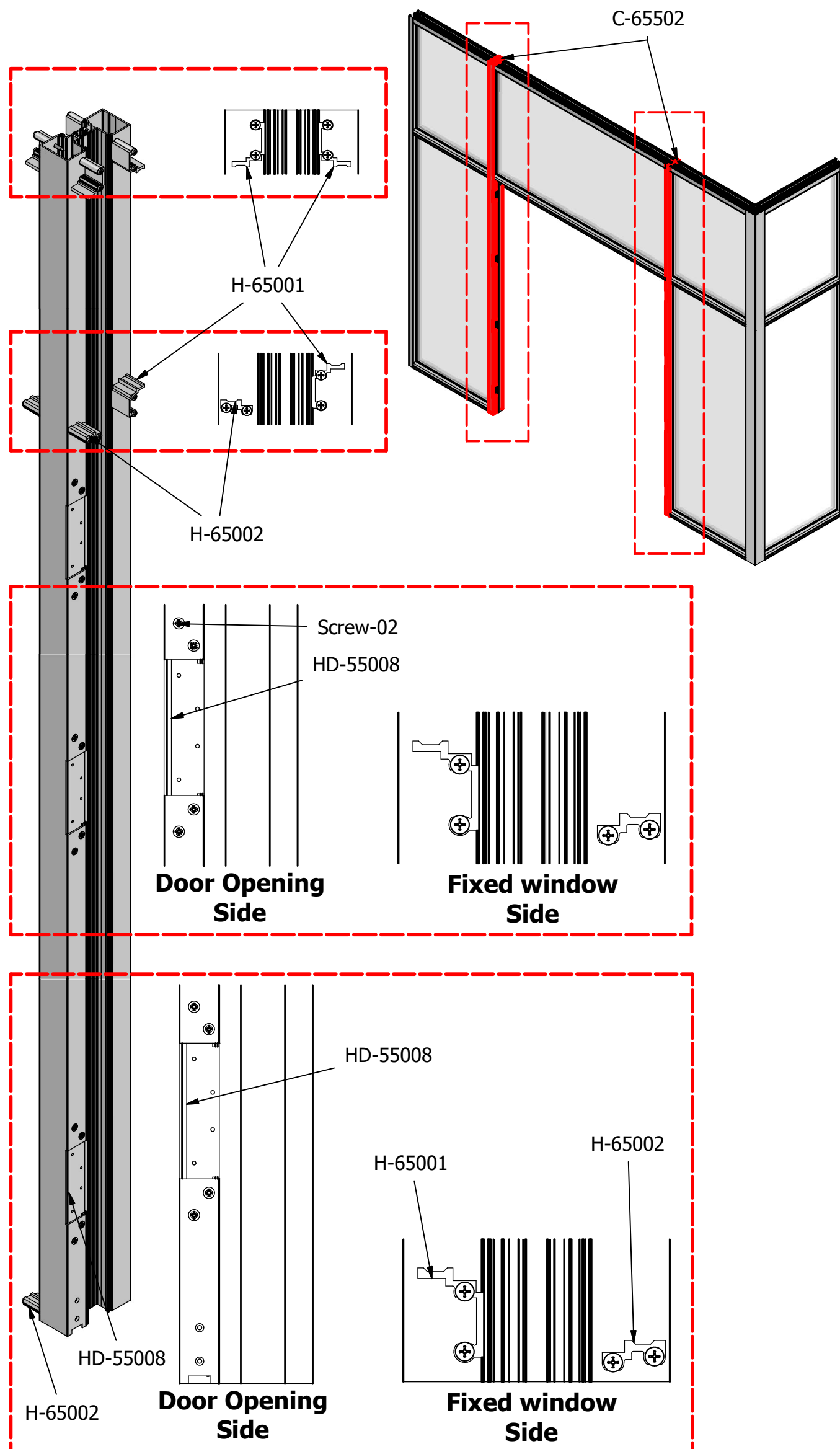


2) - For the mullion (CA-65514) in the door portion, attach the backup plates to the door opening side by securing them with #12 x 1/2" undercut flat head screws (Screw-02) through the holes around the hinge notches. On the fixed window side, install the shear blocks as per the previously provided instructions.

1



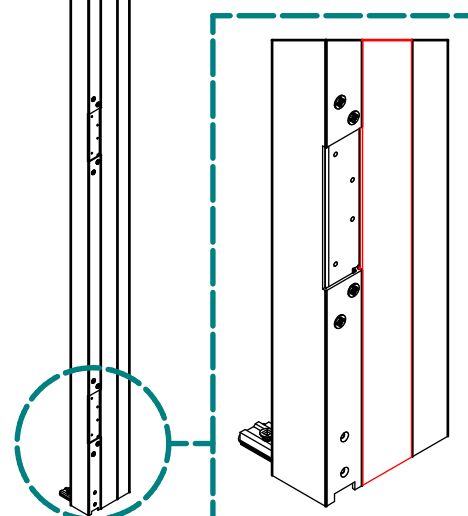
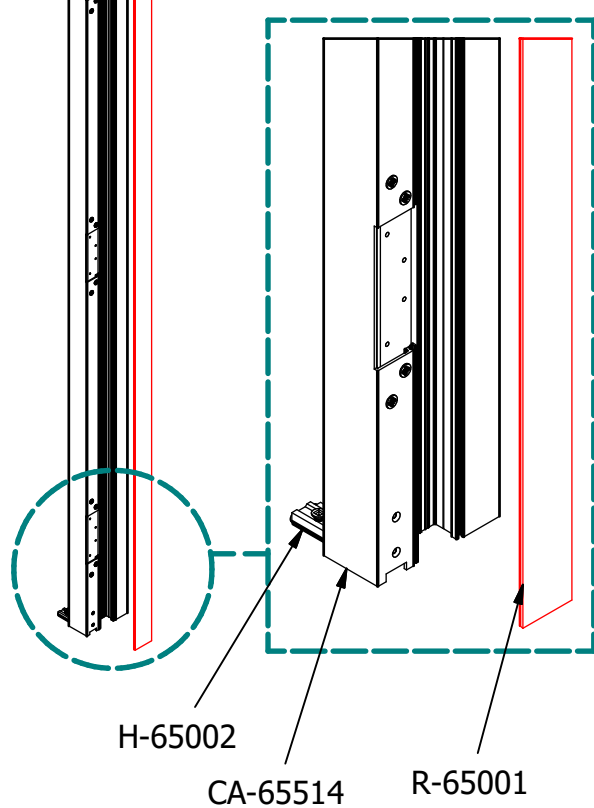
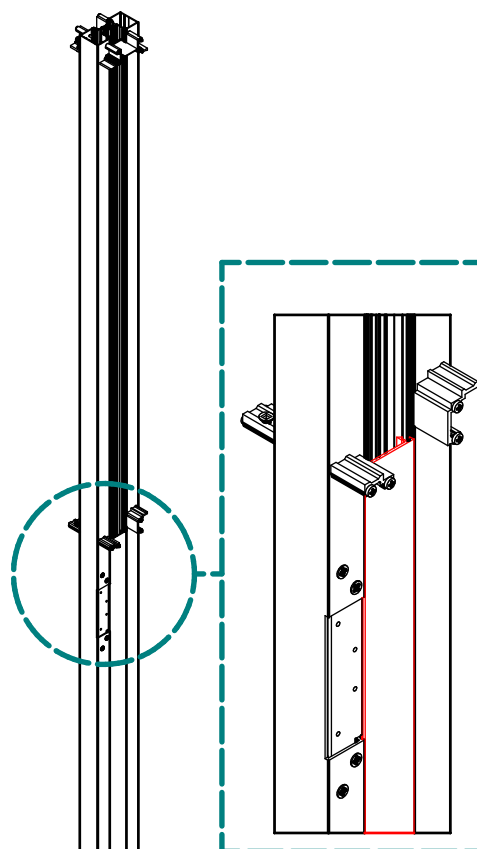
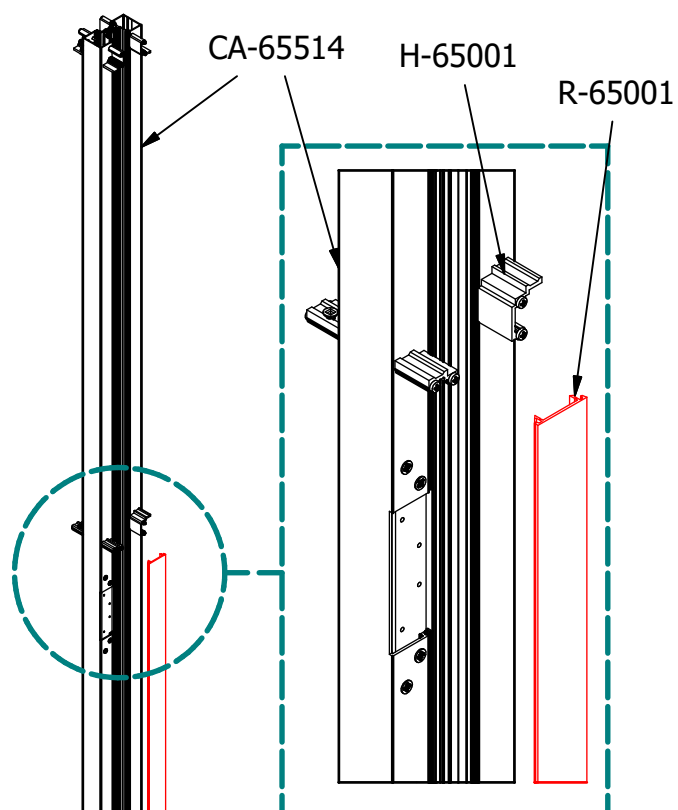
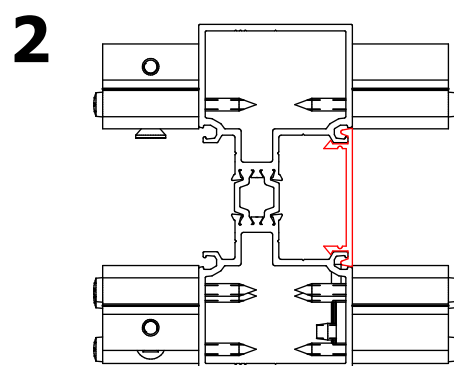
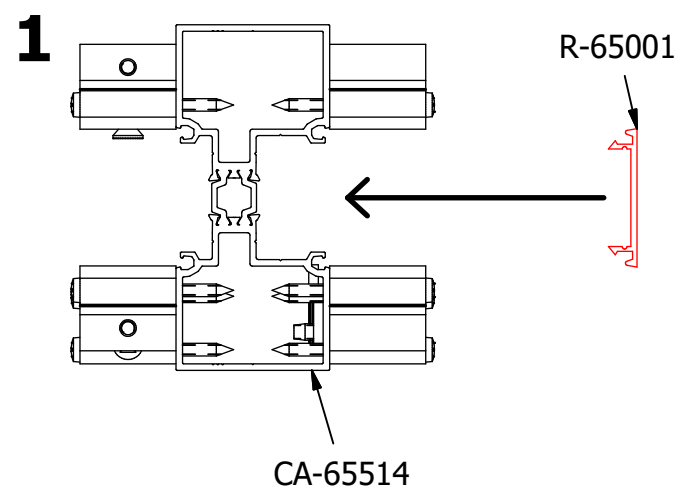
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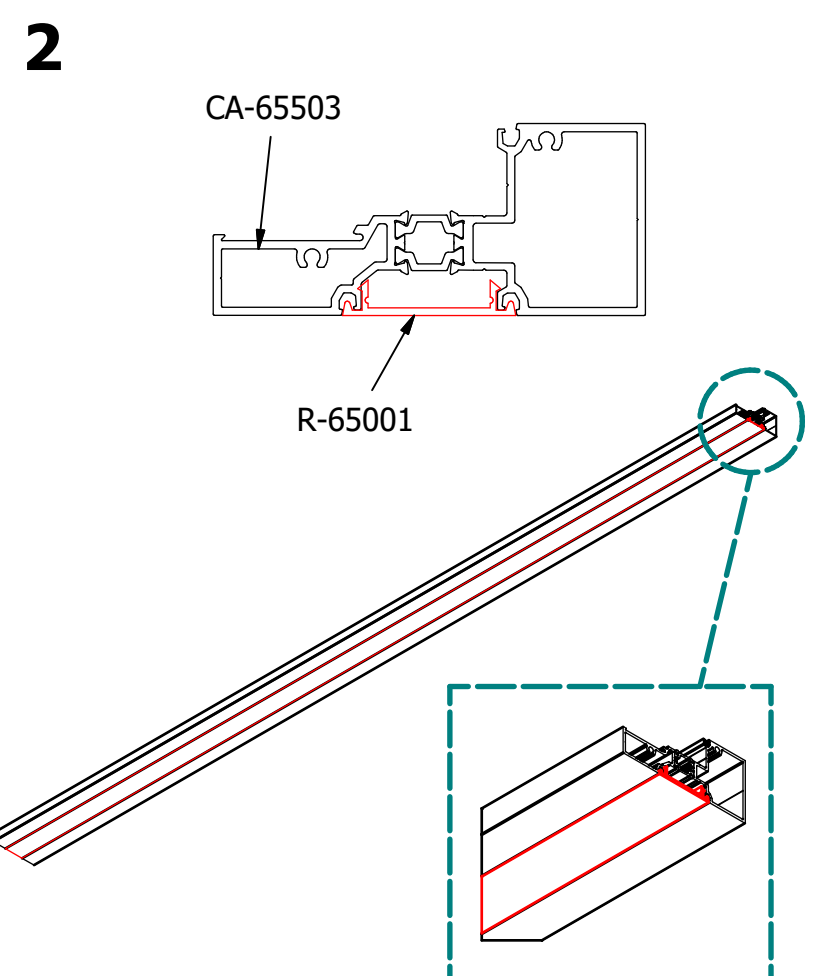
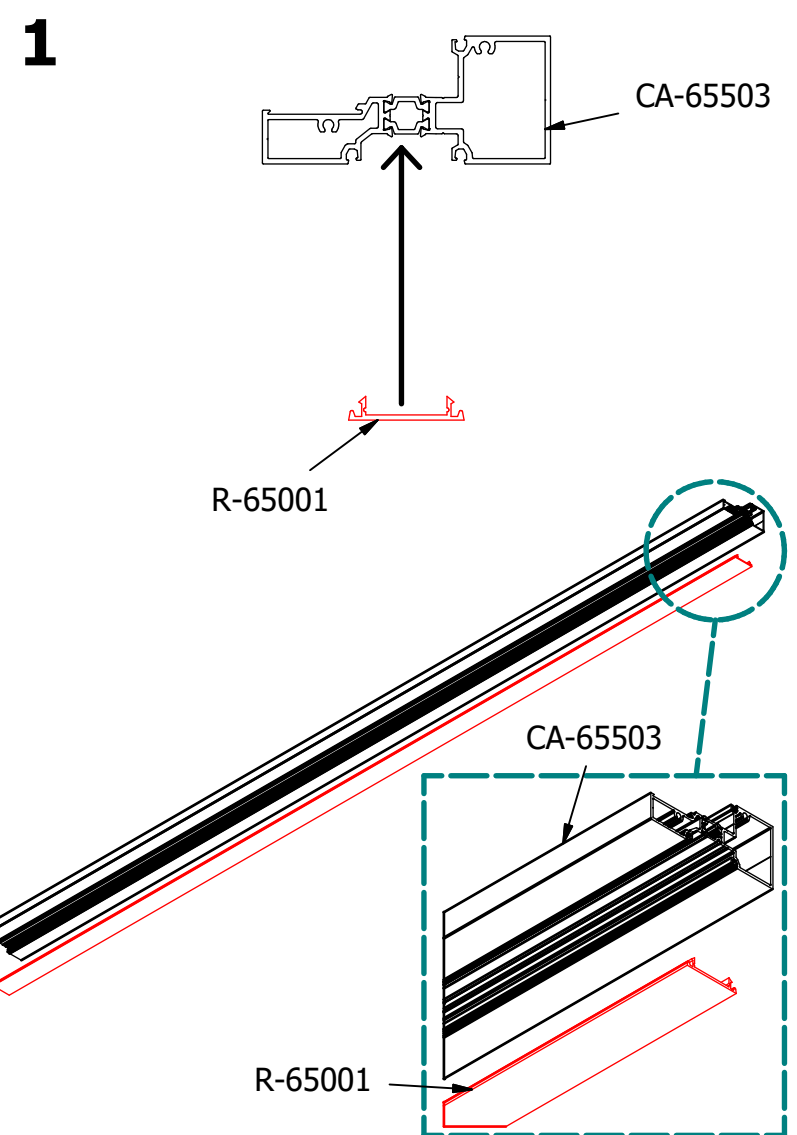
STEP 2 (Filler Adaptor Installation):

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):

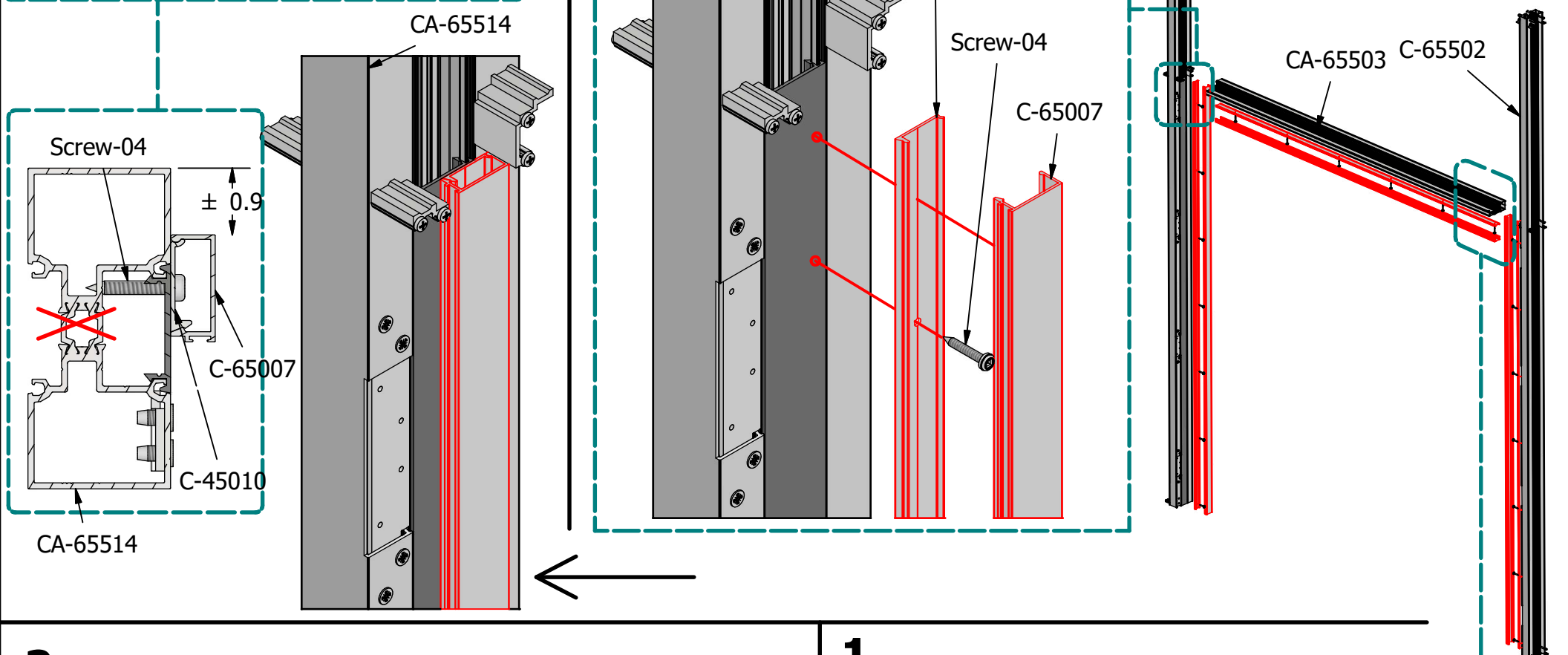
After ensuring proper alignment, secure the door stop base (C-45010) to the vertical mullion (CA-65514) in the door portion using #10 x 1 1/4" pan head screws (Screw-04) through the pre-drilled holes in the base. Then, snap the door stop cap (C-65007) firmly onto the base.

2

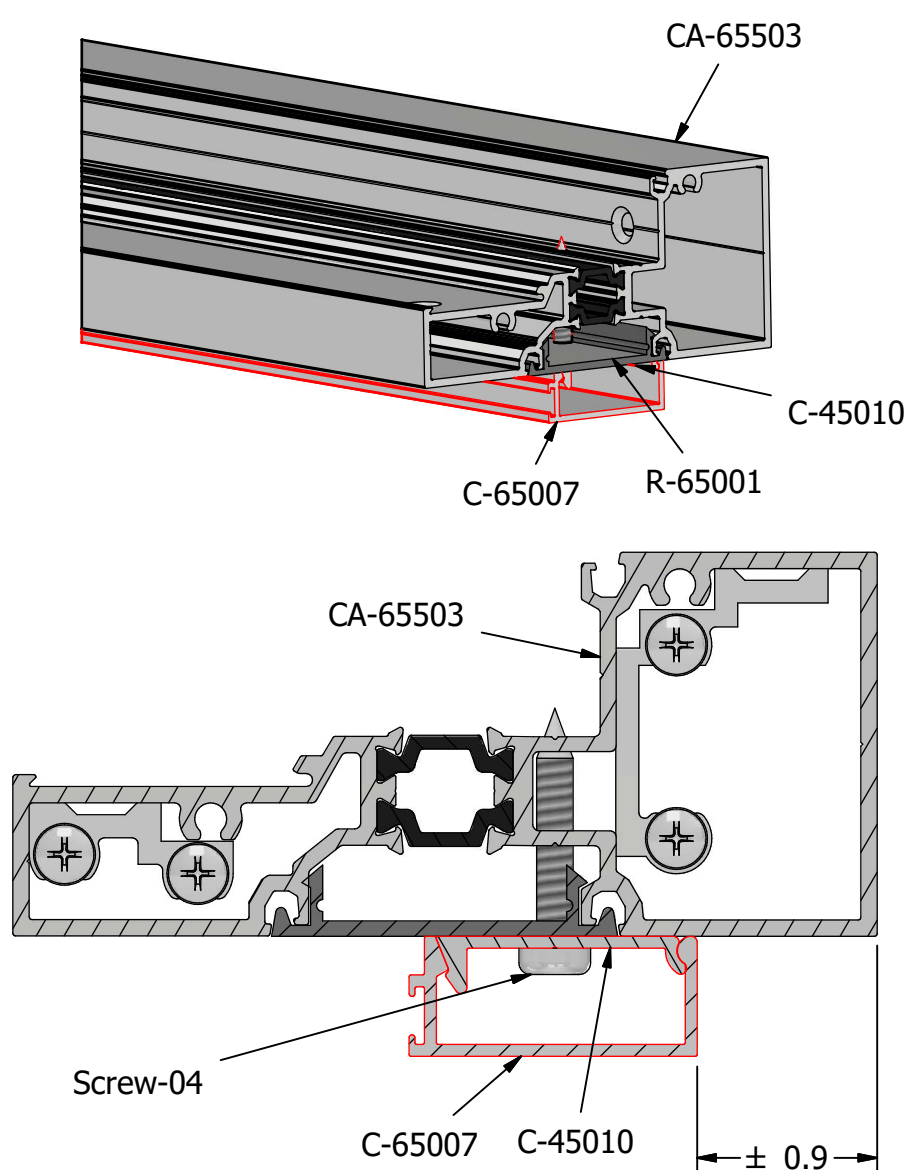
Note:

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

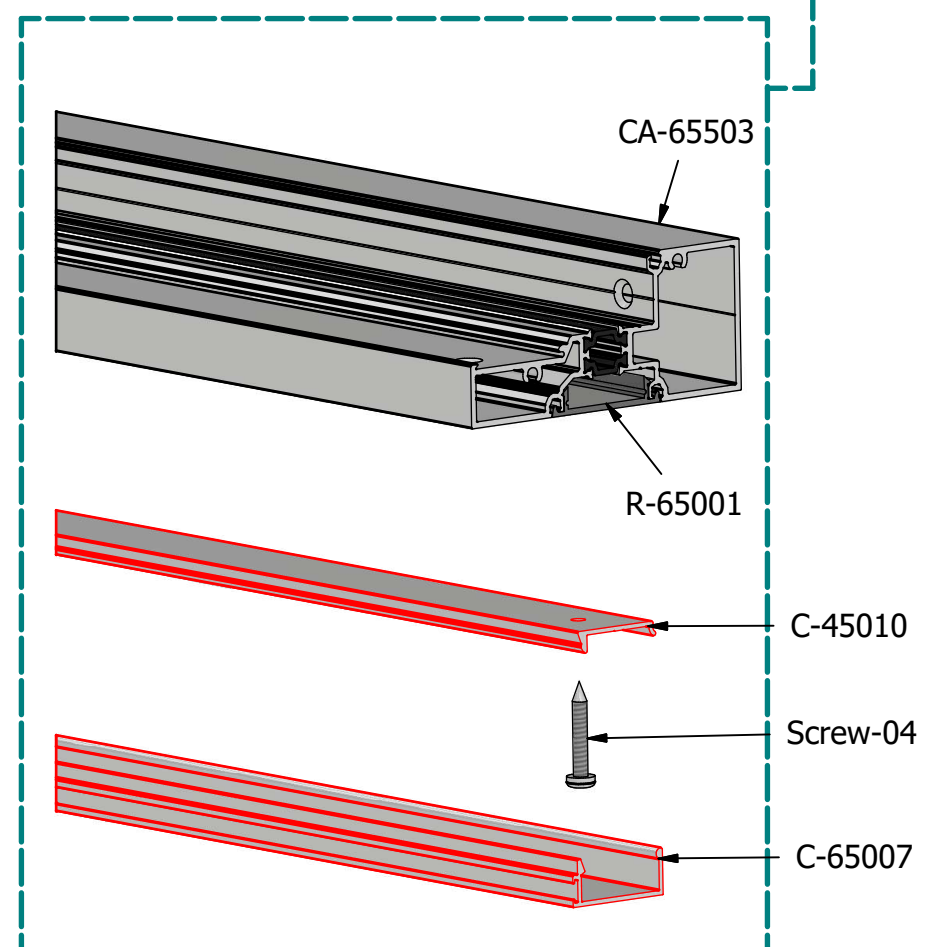
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2

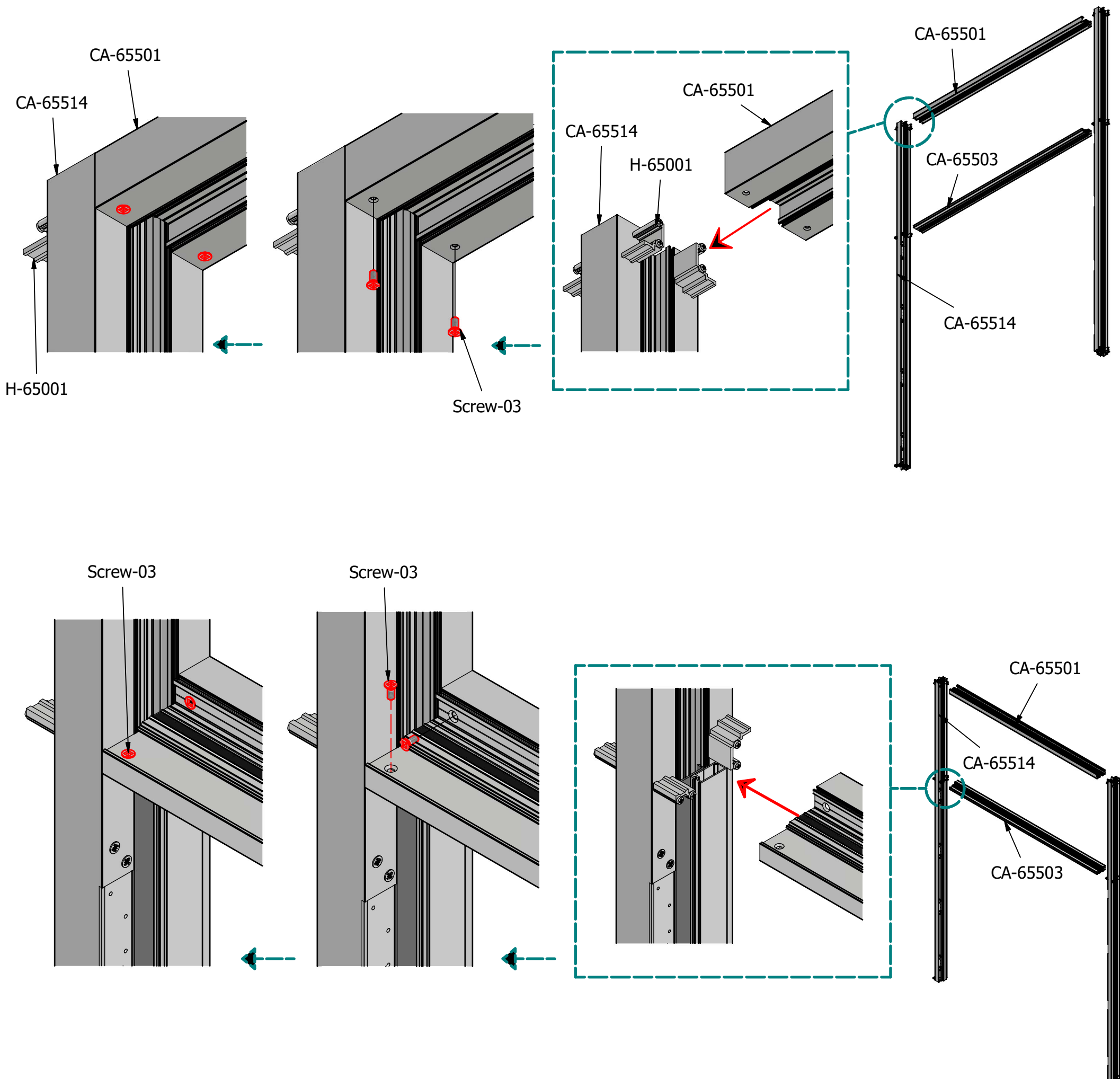


1



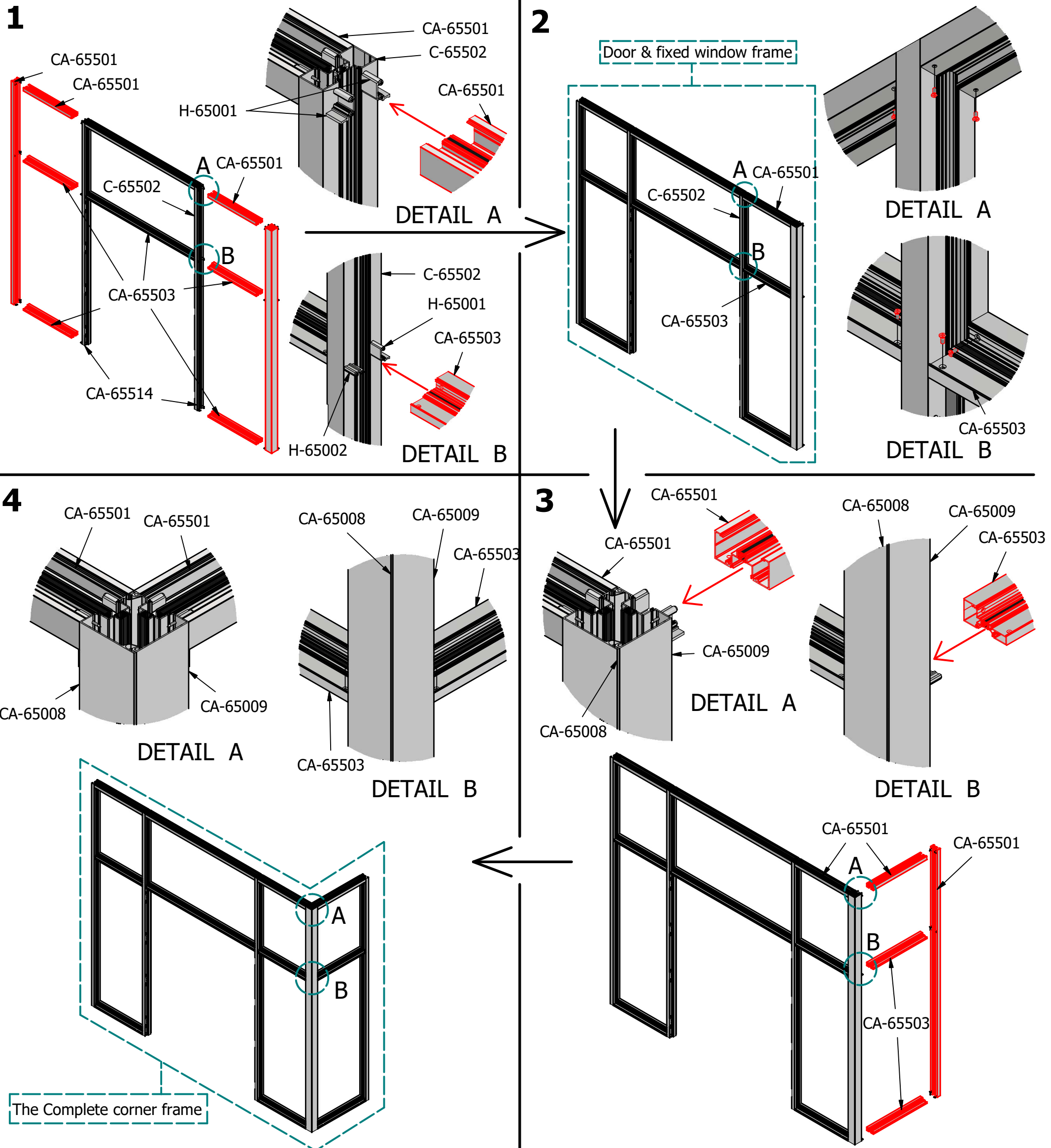
STEP 4 (Door Frame Assembly):

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):

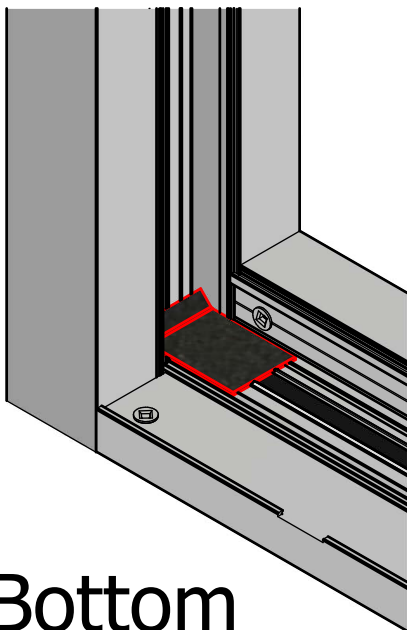
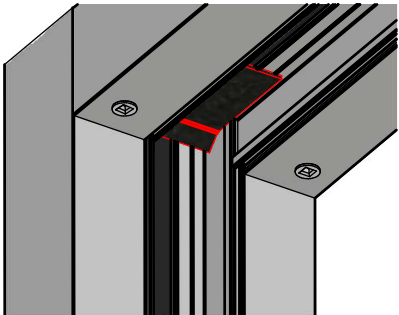
- Attach the remaining horizontals (CA-65501, CA-65503) to the mullion of the door frame (CA-65514) by securing them onto the shear blocks (H-65001, H-65002). Fasten them using #12 x 1½" flat head screws (screw-03) through the pre-drilled holes in the horizontals.
- Repeat this process to install the 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.



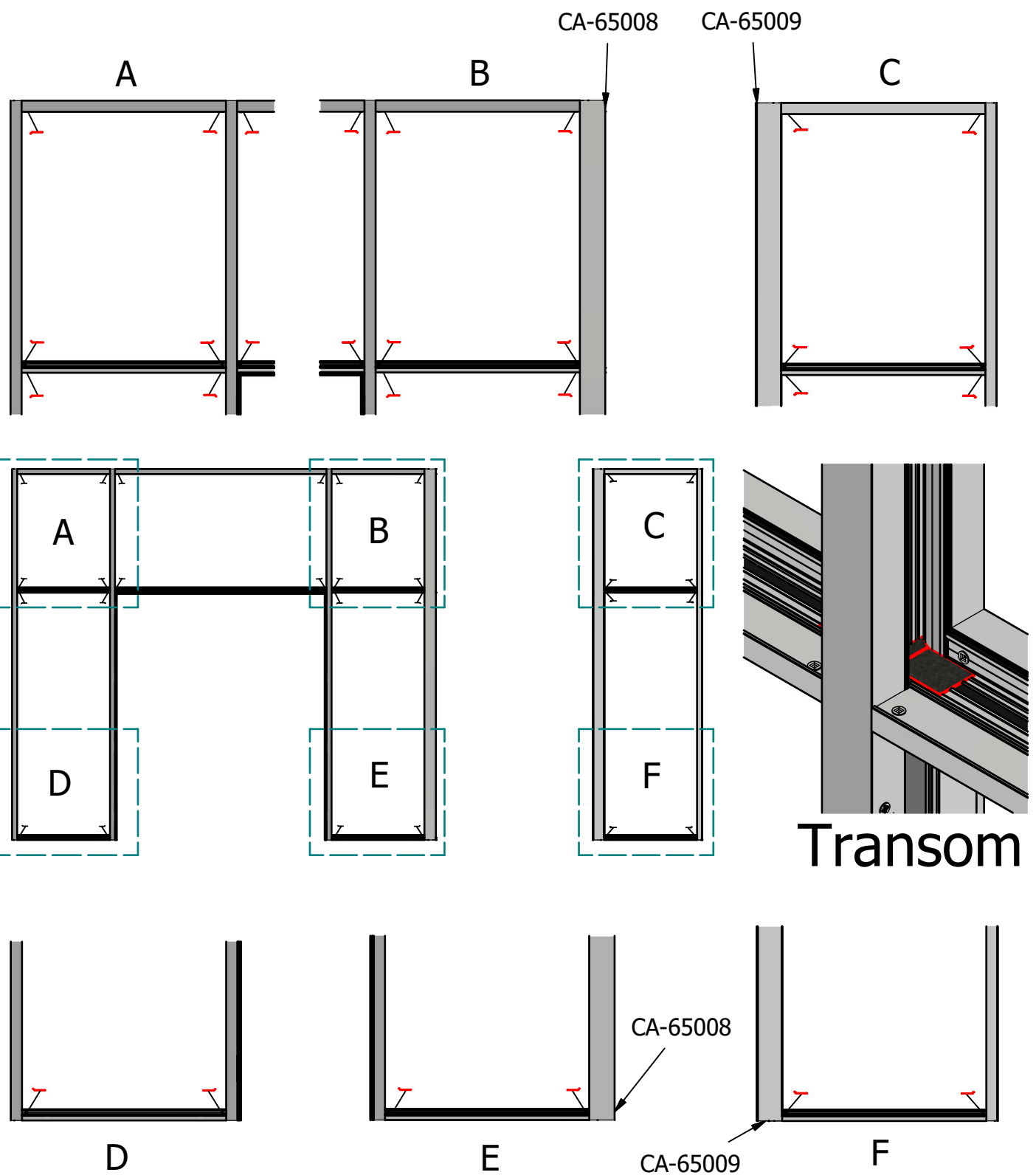
STEP 6 (Water deflector):

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

Head

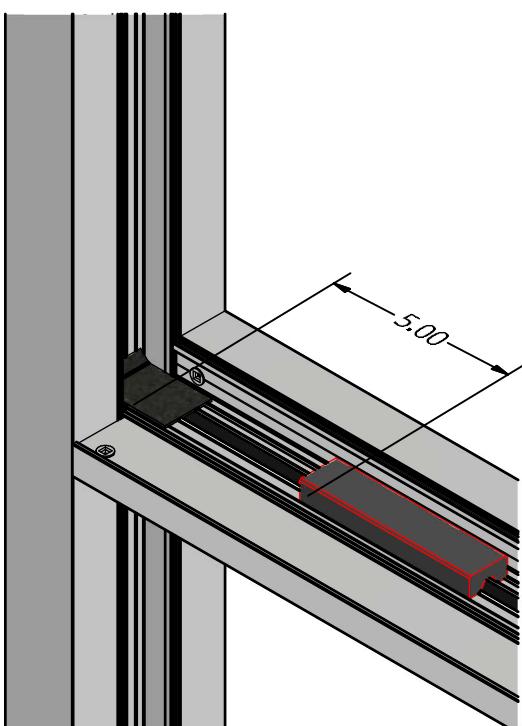


Bottom

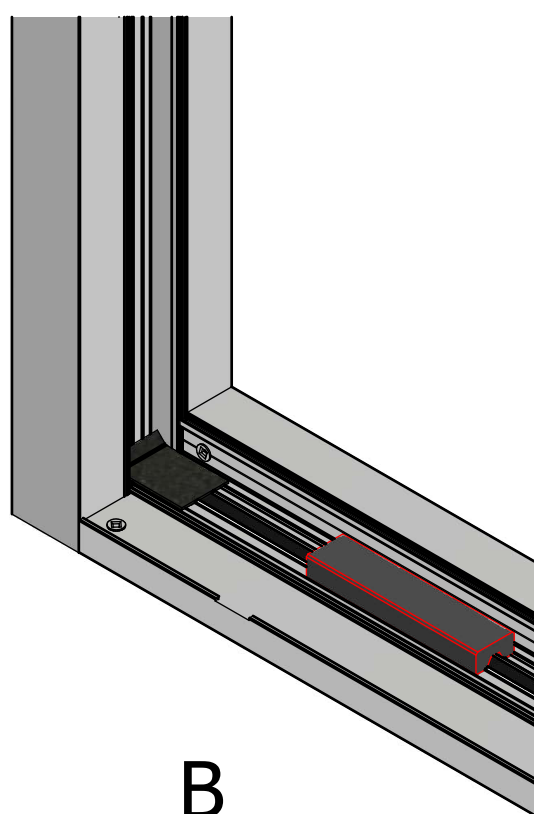


STEP 7 (Setting blocks):

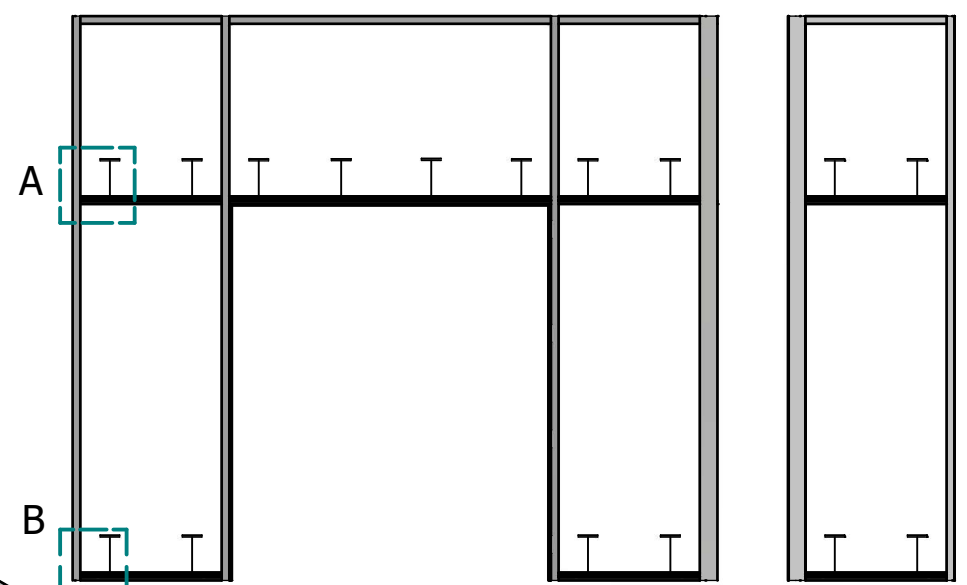
Position setting blocks on top of transoms and sills, placing them 5 inches from the edge on each side, as shown below.



A

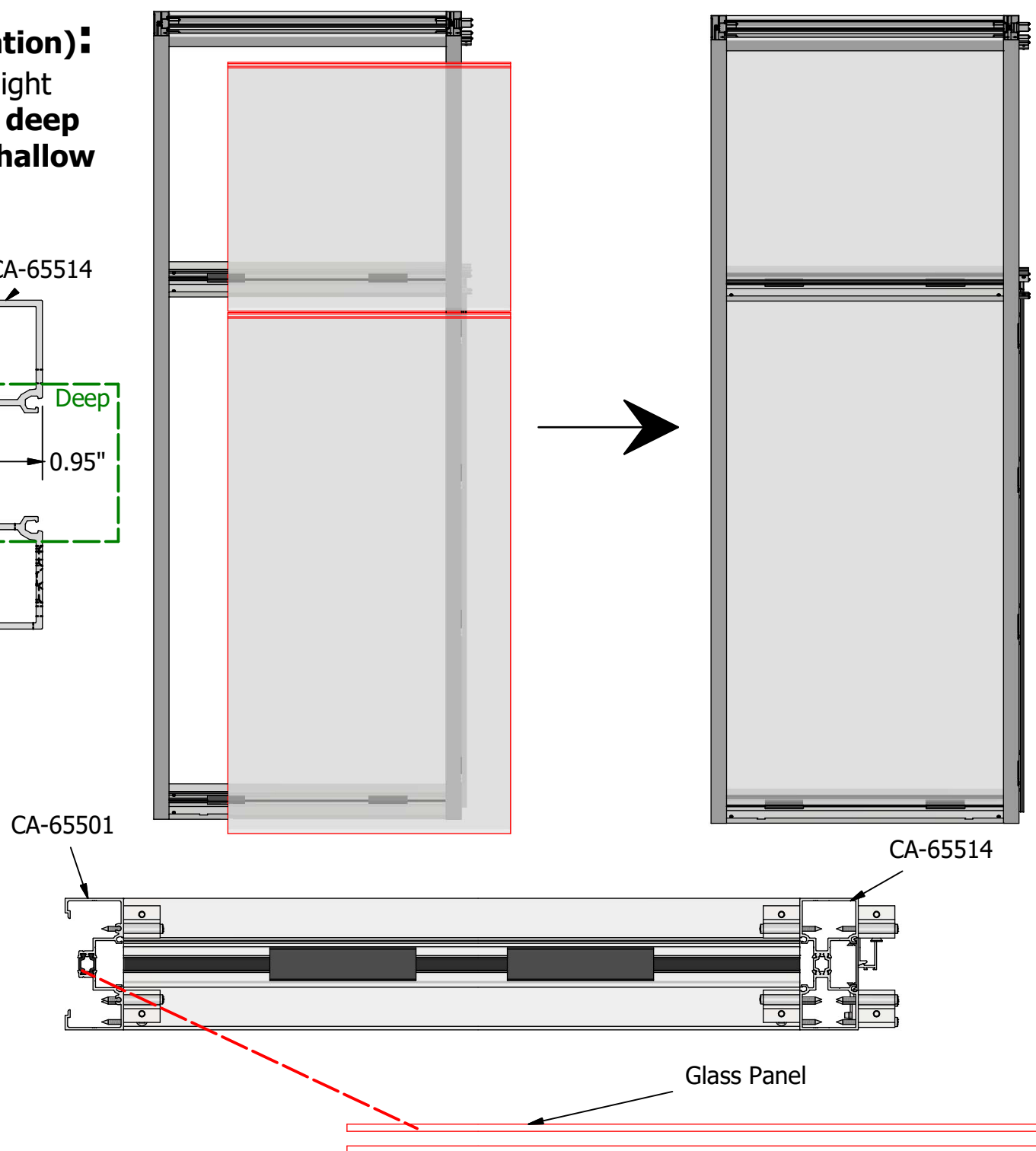
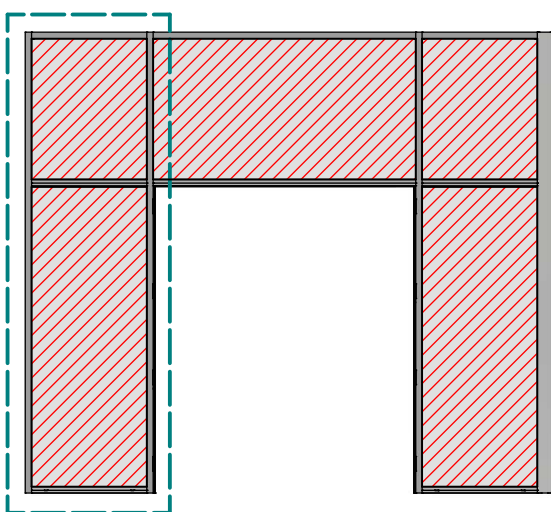
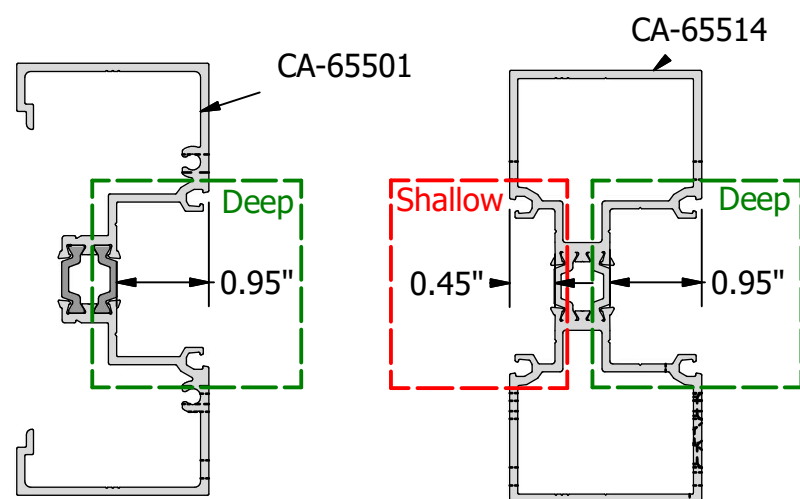


B



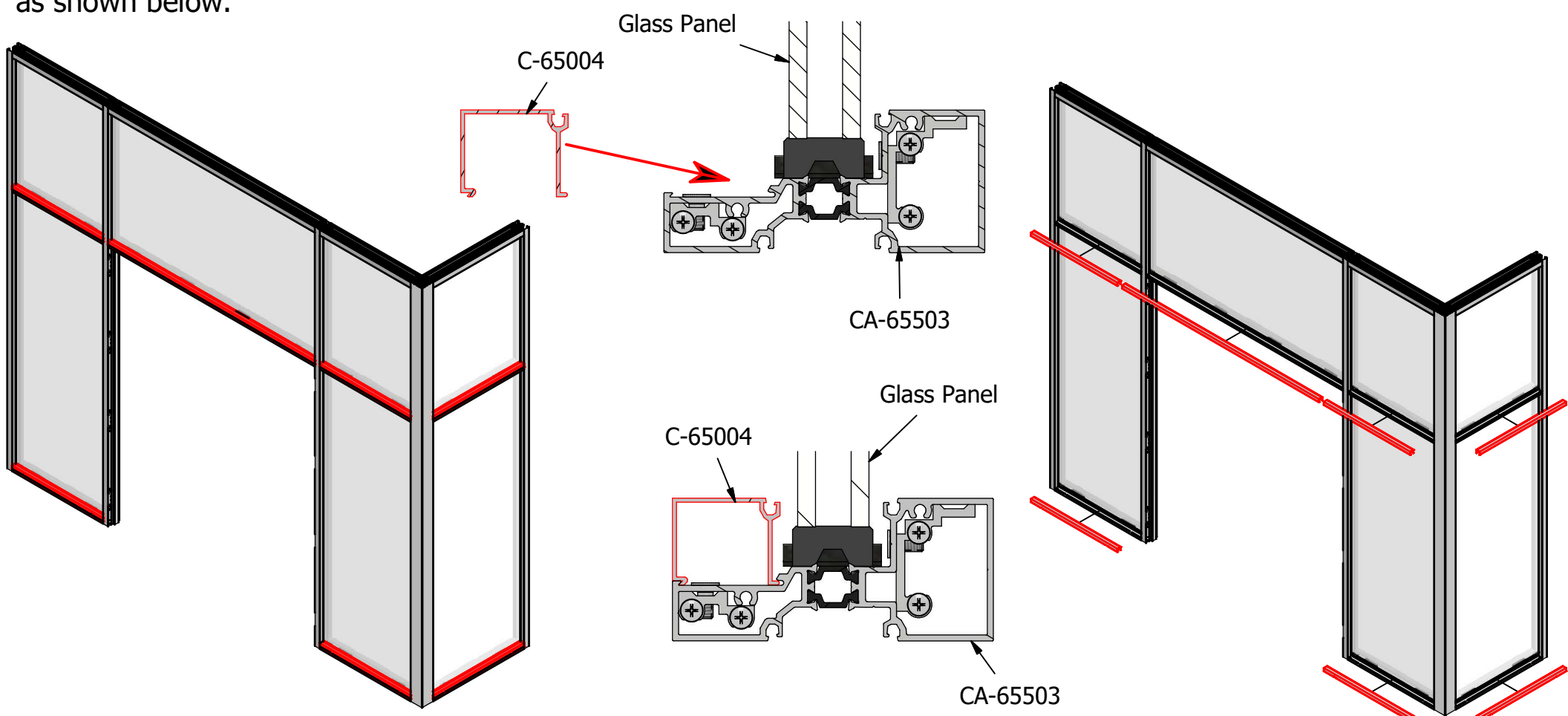
STEP 8 (Glass Panels Installation):

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.

