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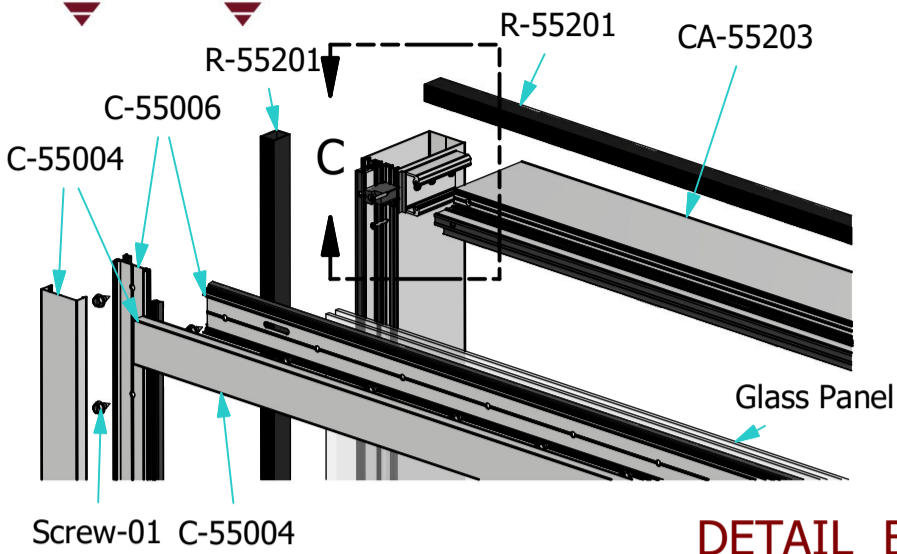
F a b r i c a t i o n

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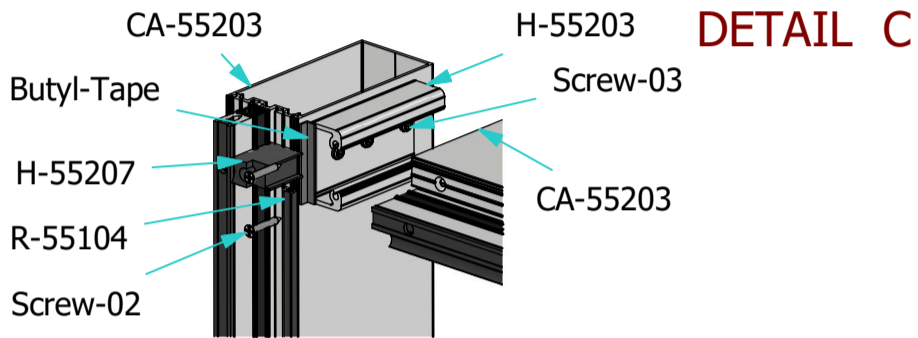
D r a w i n g s



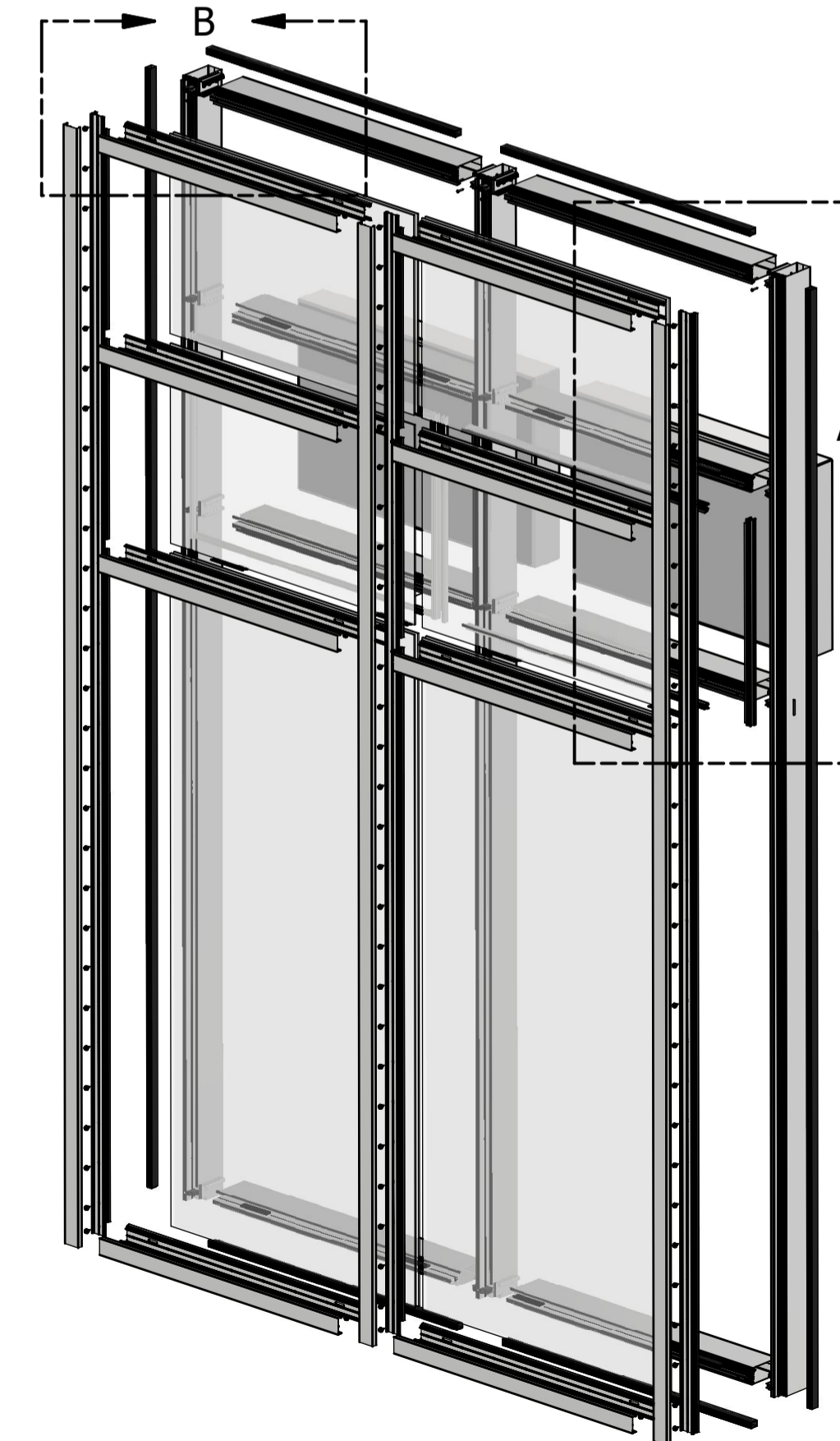
# 5500 HTP Series



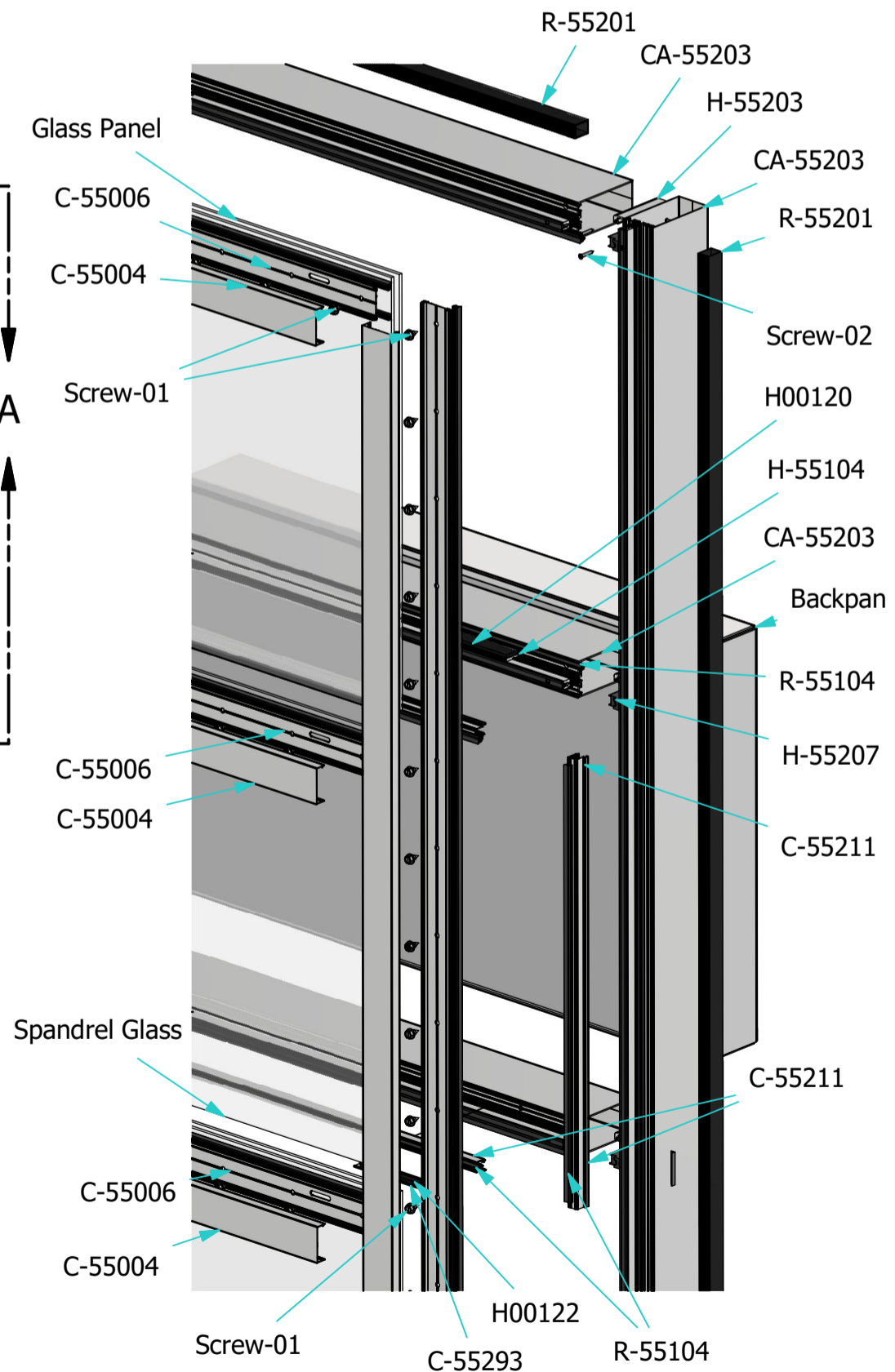
**DETAIL B**



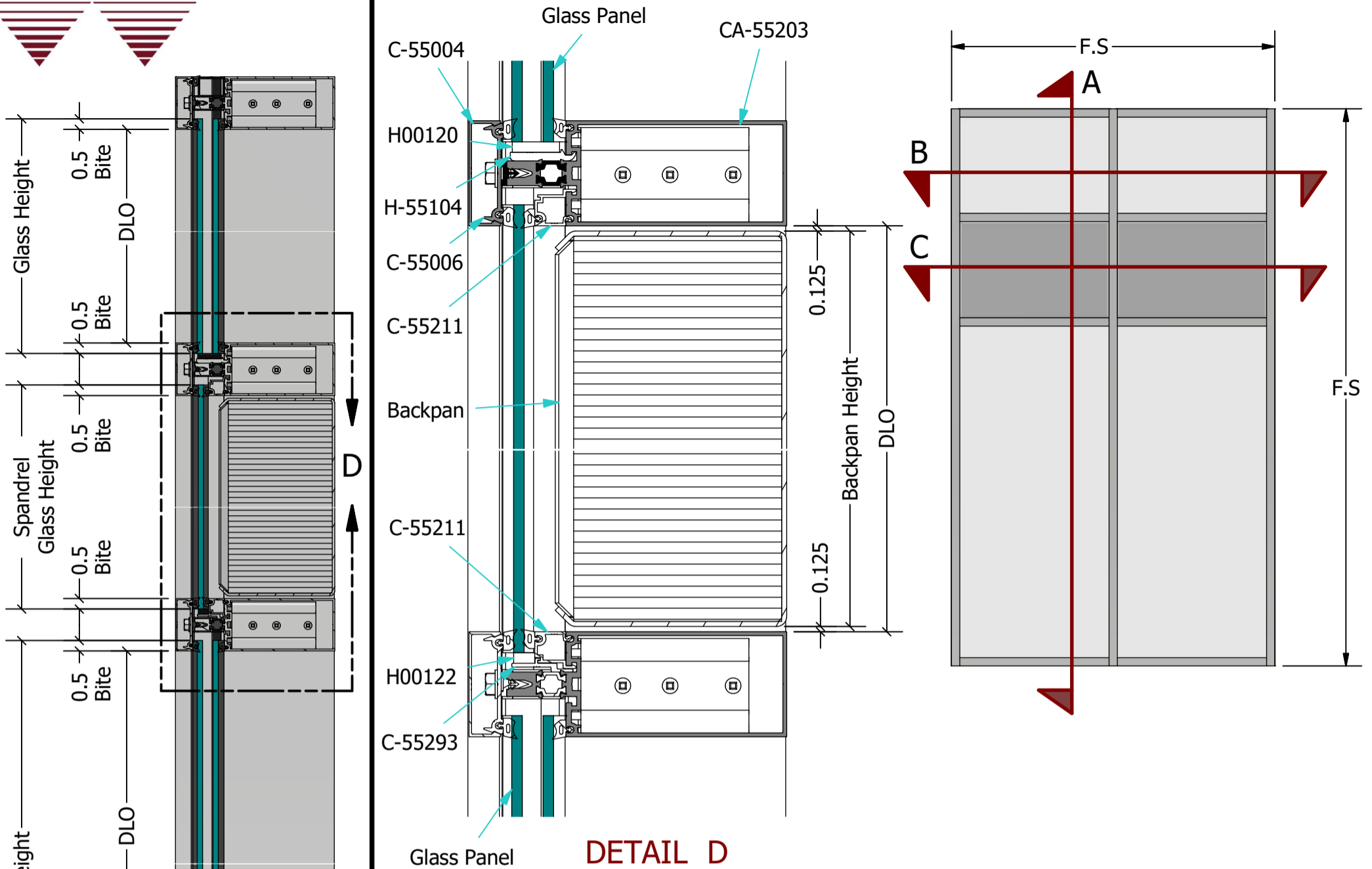
**DETAIL C**



PARTS LIST	
PART NUMBER	DESCRIPTION
Backpan	Galvanized Steel Backpan
Butyl-Tape	1/16" thick Butyl Tape
C-55004	2-1/2" x 3/4" Pressure Plate Cap – Compatible with C-55006
C-55006	2-1/2" Pressure Plate
C-55211	Single Glazing Adaptor for Double Glazed Capped Mullions
C-55293	HTP Single Glass Adaptor Support
CA-55203	2-1/2" x 5-1/4" Double Glazed Mullion
Glass Panel	Double Glazed Panel
H00120	(1/4 x 1 1/8 x 5" ) E.P.D.M Setting block
H00122	(1/4 x 1/2" x 5" ) E.P.D.M Setting block
H-55104	5" Support Tab for Double Glazed Capped Mullion
H-55203	4" Shear Block - Compatible with 2-1/2" x 5-1/4" Mullion
H-55207	Corner Plug for Double Glazed Capped (EPDM Foam) - Notched
R-55104	Interior Gasket for Capped Mullion Glazing
R-55105	Exterior Gasket for Capped Mullion Glazing
R-55201	1-1/4" x 15/16" Pocket Filler ( Rigid PVC )
Screw-01	#14 x 3/4" SS Hex Washer Head Screw
Screw-02	#10 x 1-1/4" Flat Head Socket Screw, Zinc
Screw-03	#10 x 3/4" Quadrex Pan Head Screw, Zinc
Spandrel Glass	Spandrel Glass (Single Glazing)



**DETAIL A**

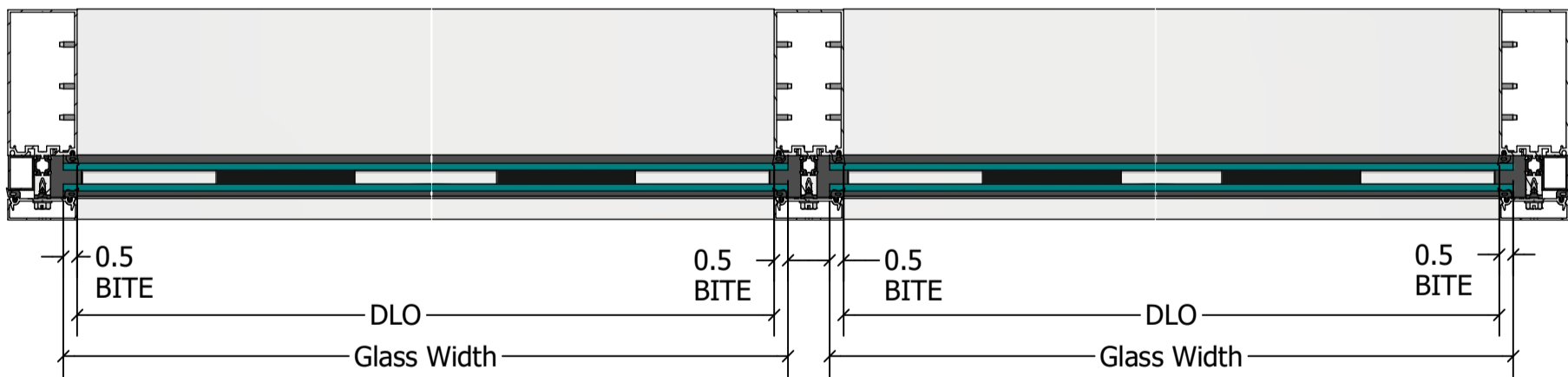


**SECTION A-A**

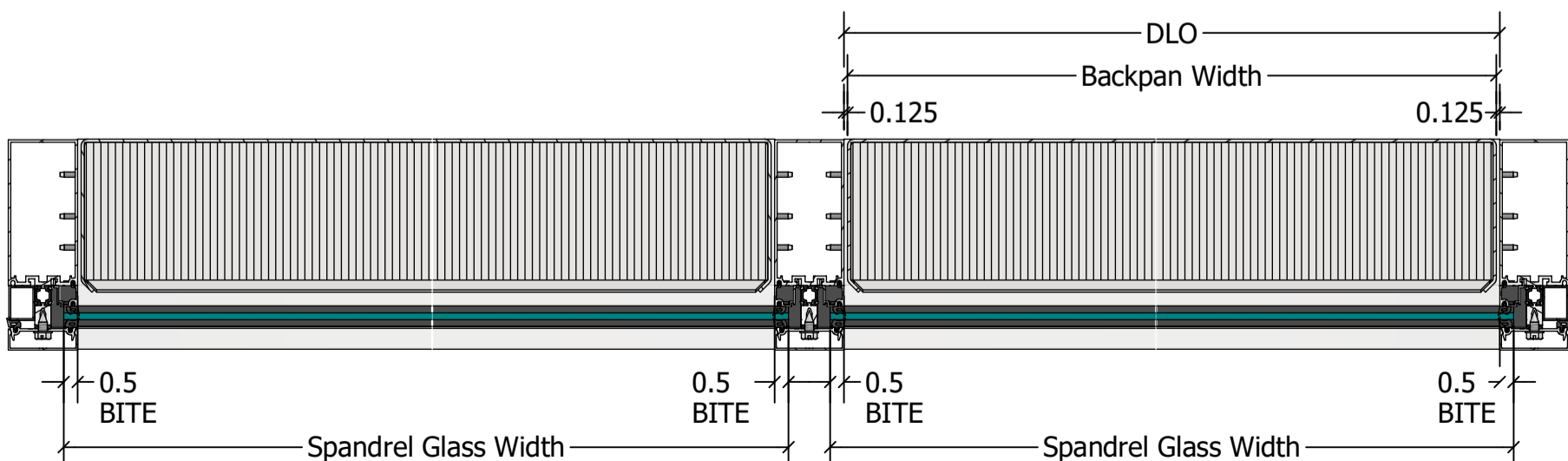
**DETAIL D**

**Notes:**

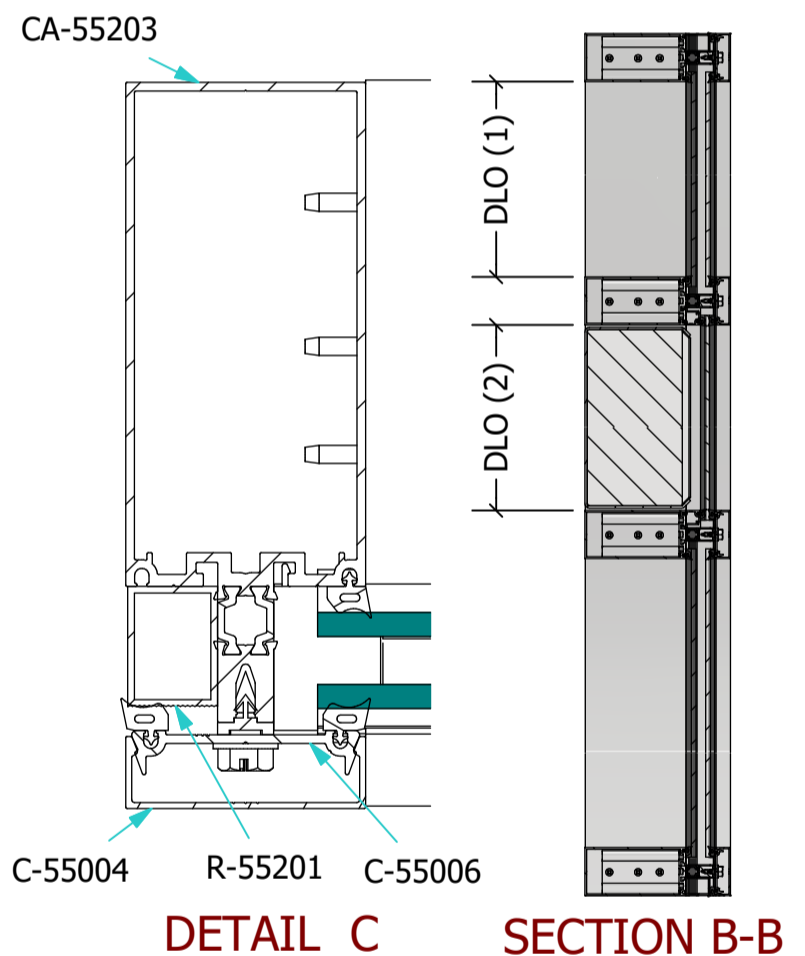
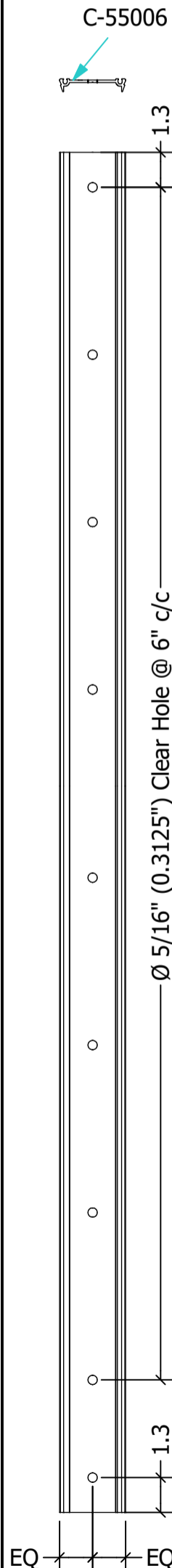
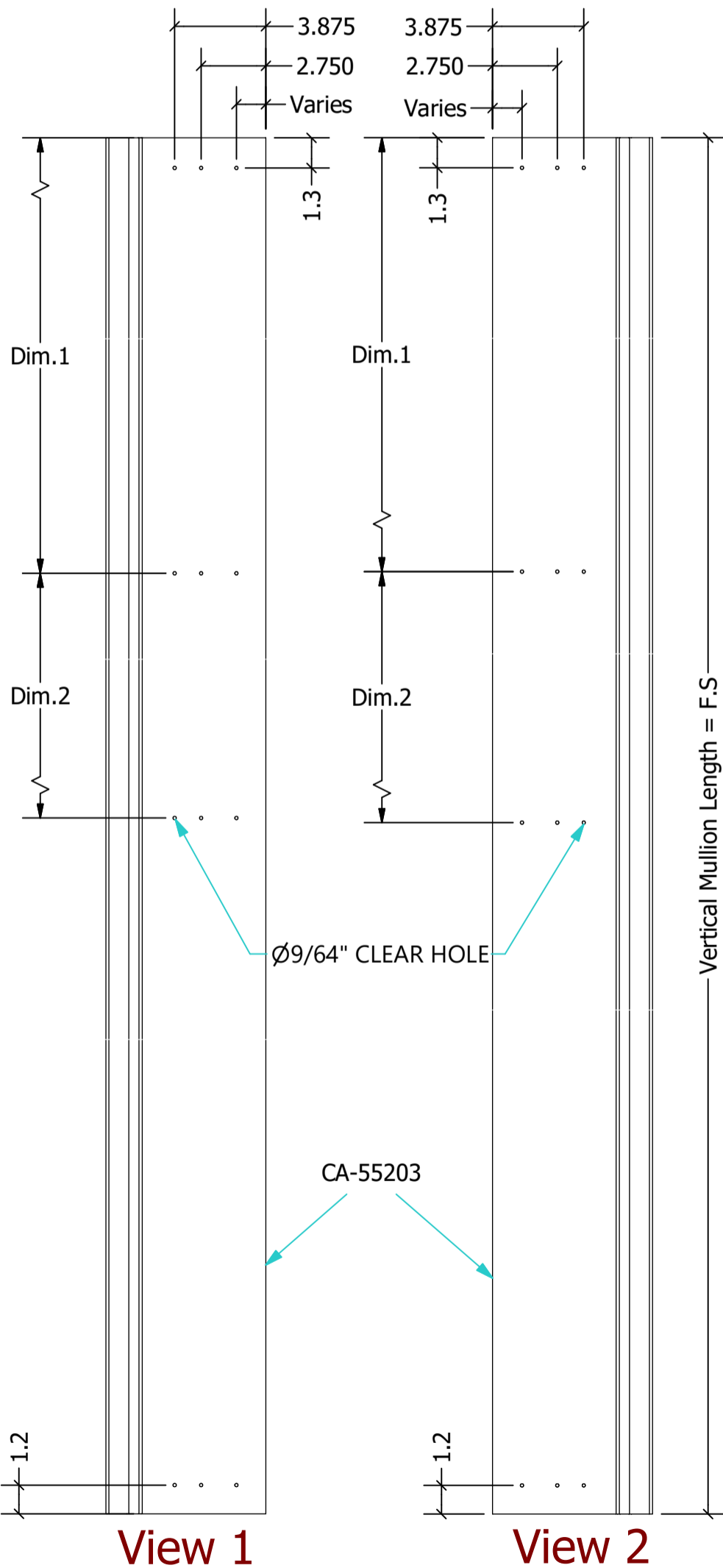
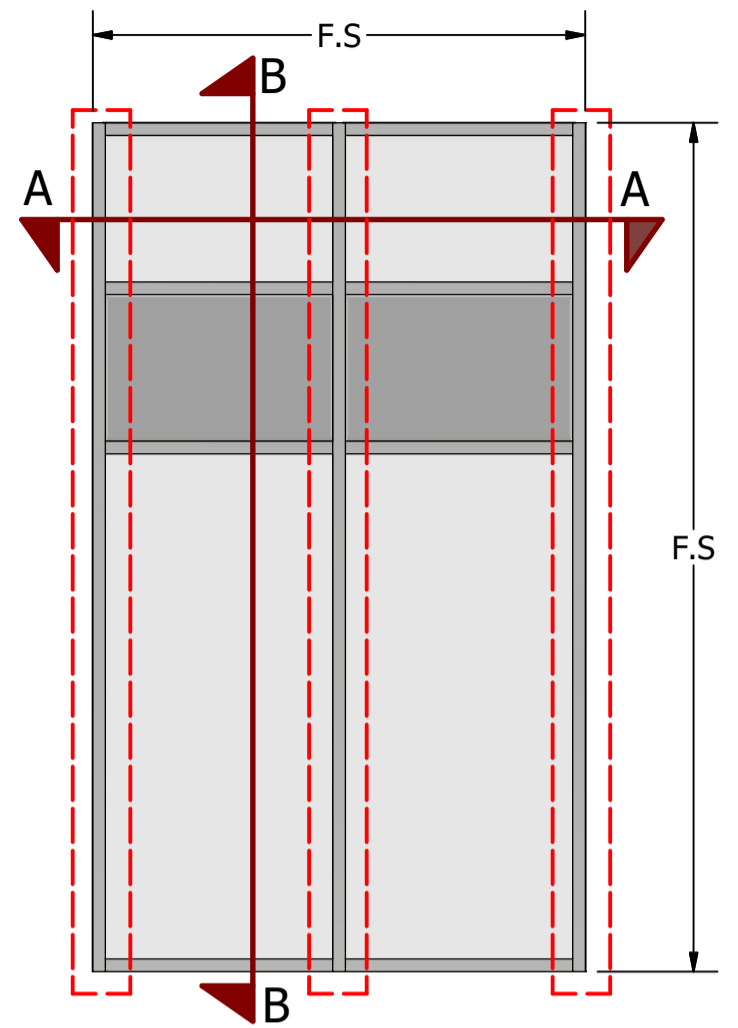
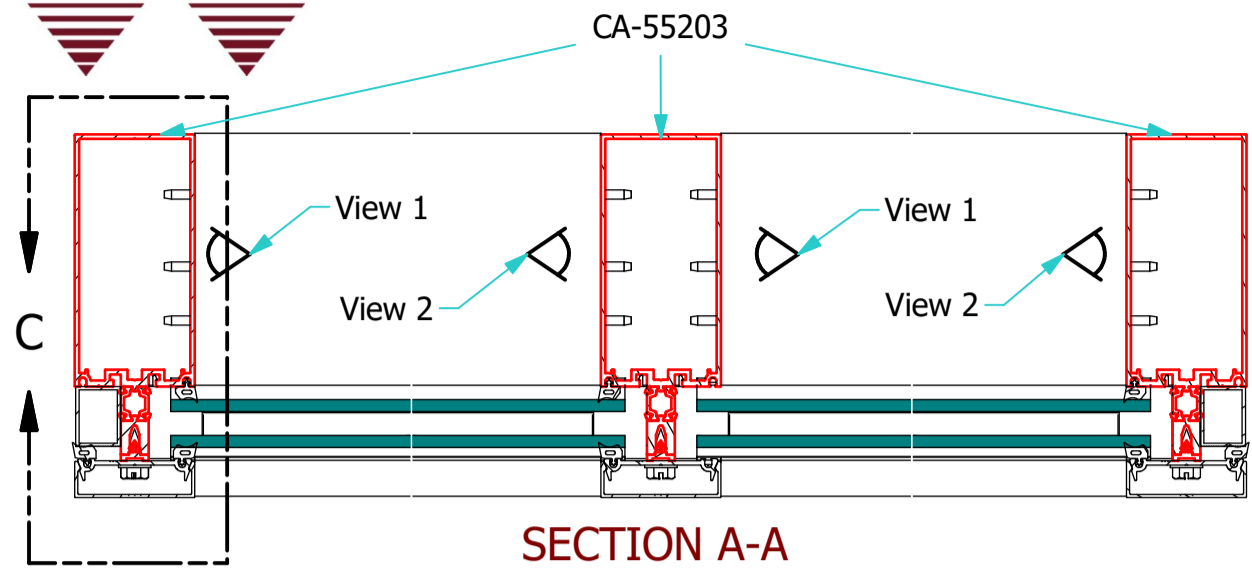
- R.O : Rough opening
- F.S : Frame size = R.O - 1"
- DLO : Daylight opening
- Glass Width =  $DLO + 1"$
- Glass Height =  $DLO + 1"$
- Backpan Height =  $DLO - 0.25"$
- Backpan Width =  $DLO - 0.25"$
- Spandrel Glass Height =  $DLO + 1"$
- Spandrel Glass Width =  $DLO + 1"$



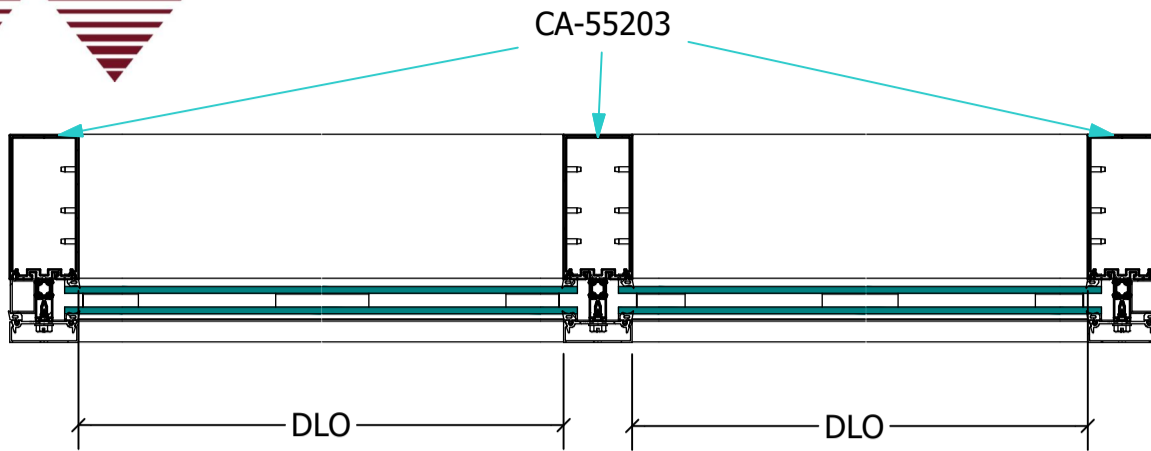
**SECTION B-B**



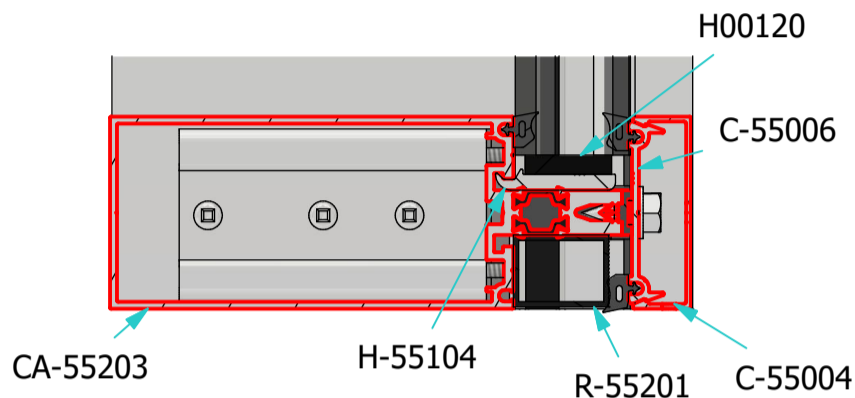
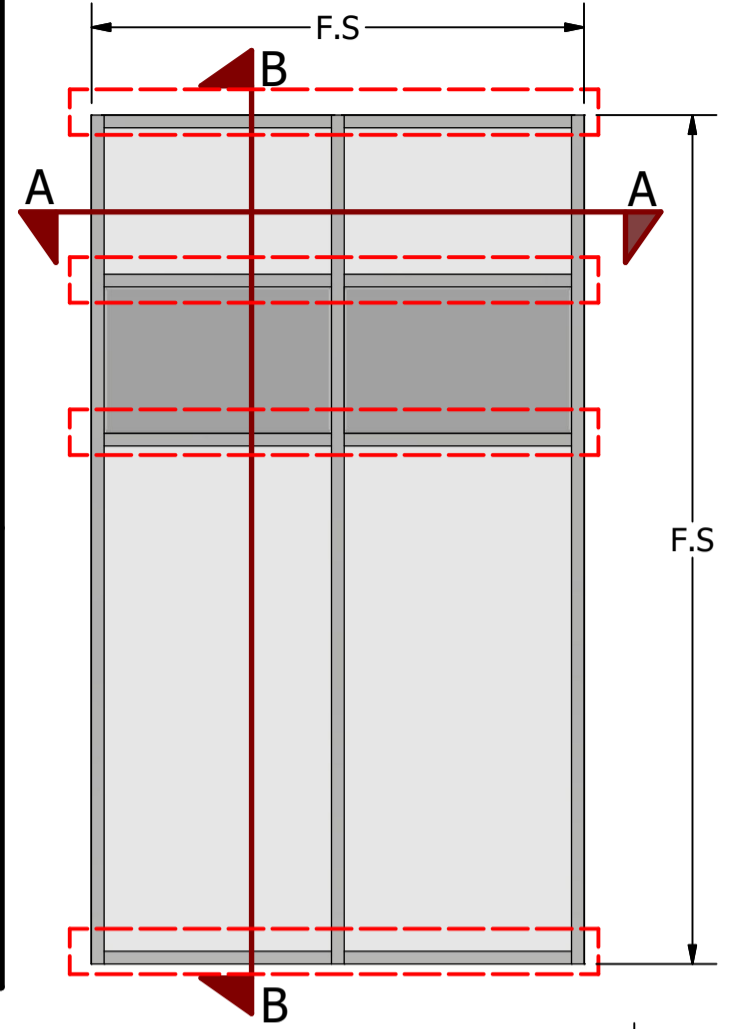
**SECTION C-C**



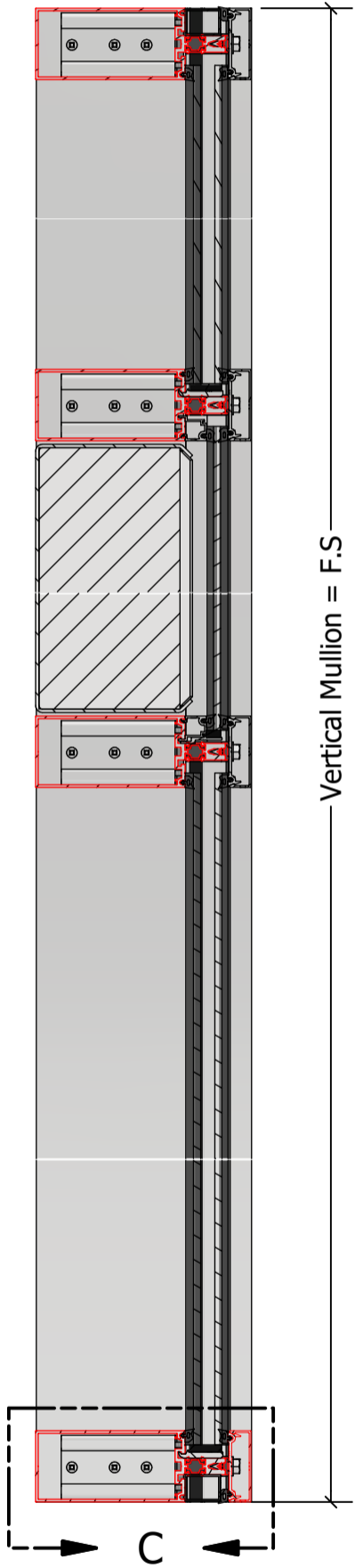
- Notes:**
- R.O : Rough opening
  - F.S : Frame size = R.O - 1"
  - DLO : Daylight opening
  - P.P : Pressure plate
  - Vertical P.P Length (C-55006) = F.S
  - Vertical Cap Length(C-55004) = F.S
  - Vertical Mullion Length = F.S (CA-55203)
  - Vertical Pocket Filler Length = F.S (R-55201)
  - Dim.1 = DLO (1) + 3.8125 "
  - Dim.2 = DLO (2) + 2.5"



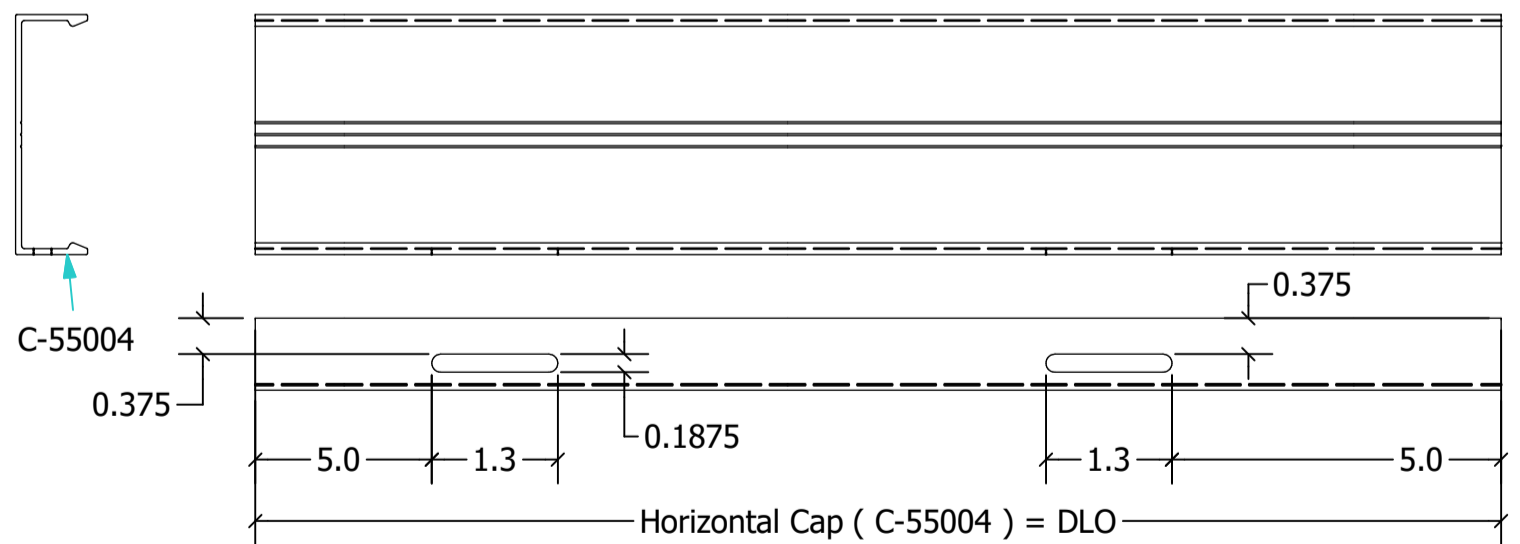
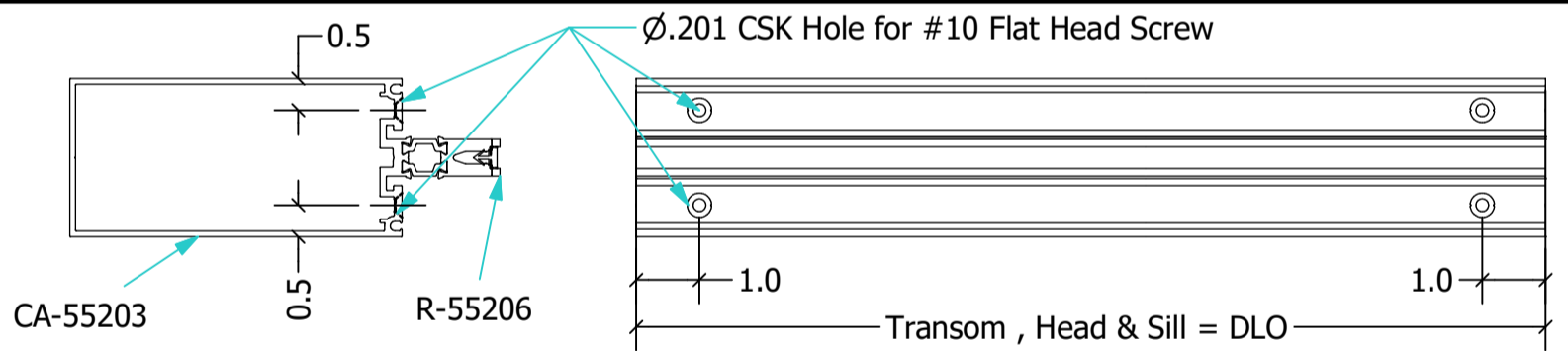
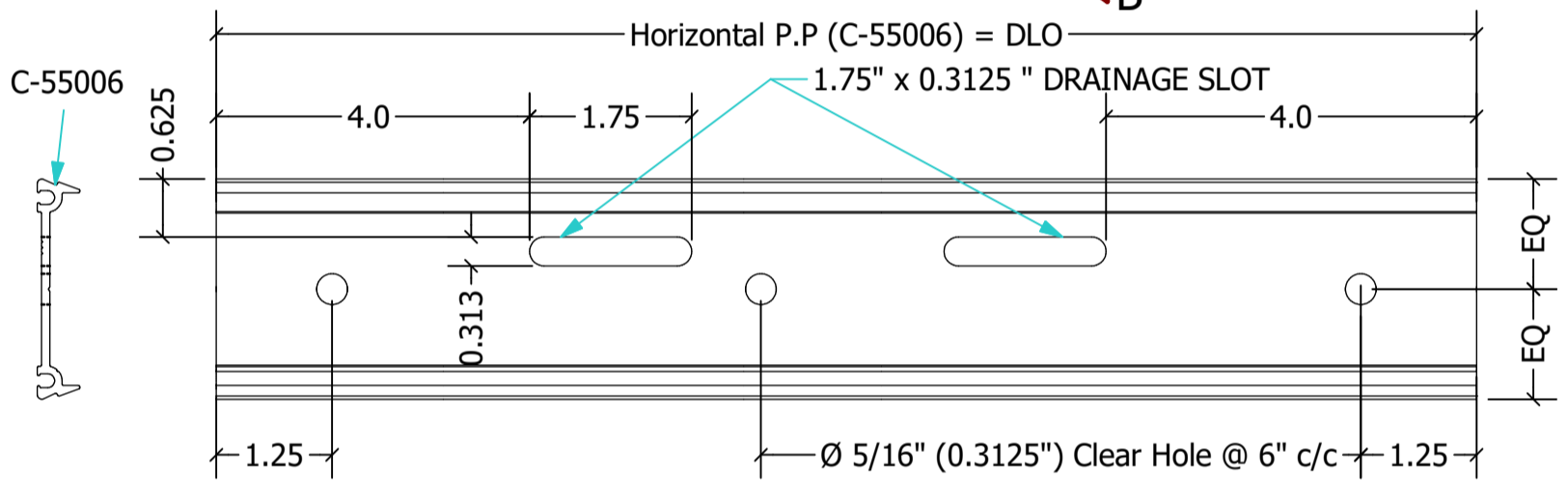
**SECTION A-A**



**DETAIL C**



**SECTION B-B**



**Notes:**

- R.O : Rough opening
- F.S : Frame size = R.O - 1"
- DLO : Daylight opening
- P.P : Pressure plate
- Horizontal P.P (C-55006) = DLO
- Horizontal Cap (C-55004) = DLO
- Transom , Head & Sill (CA-55203) = DLO
- Horizontal Pocket Filler (R-55201) = DLO + 1.9 "

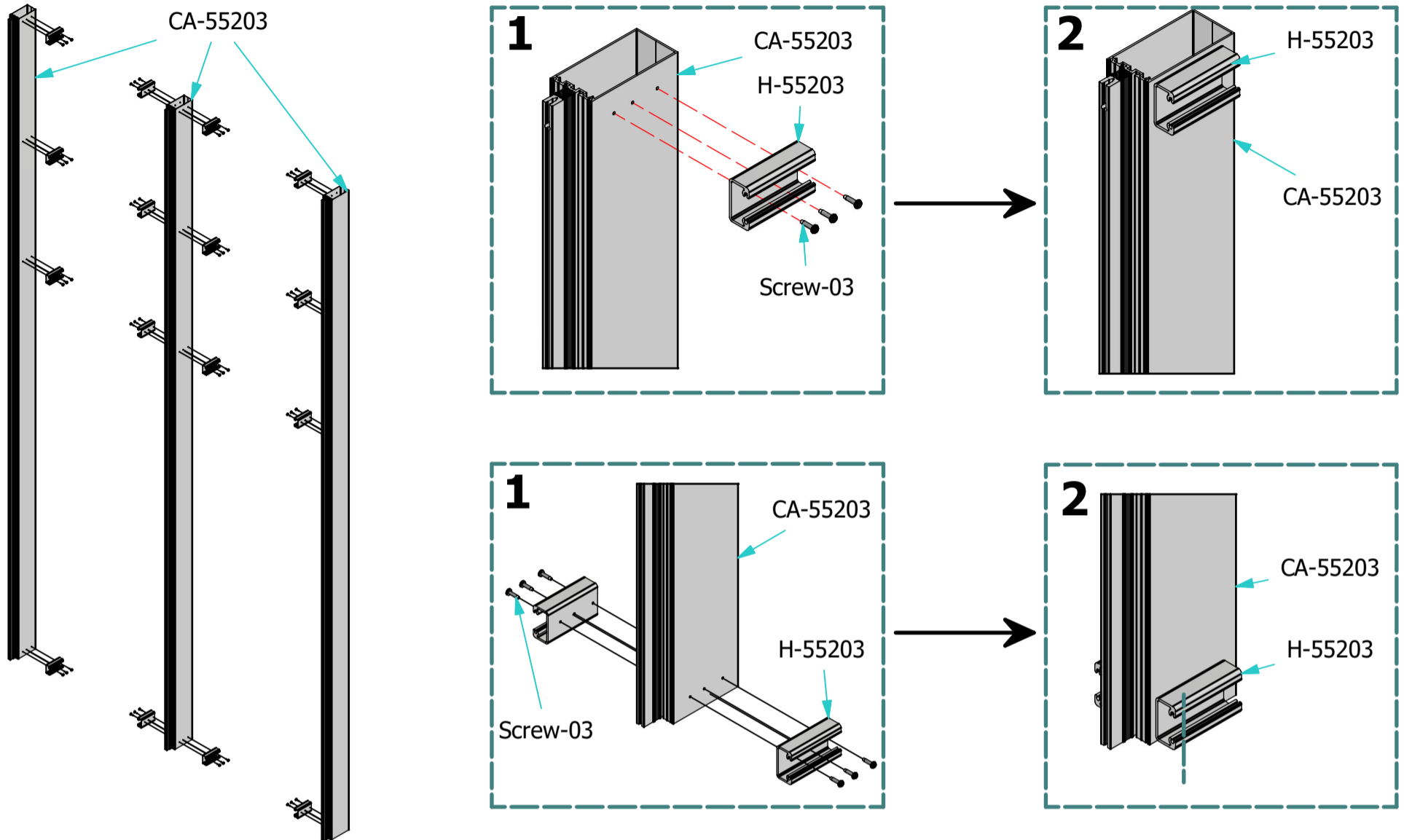
ASSEMBLY



STEPS

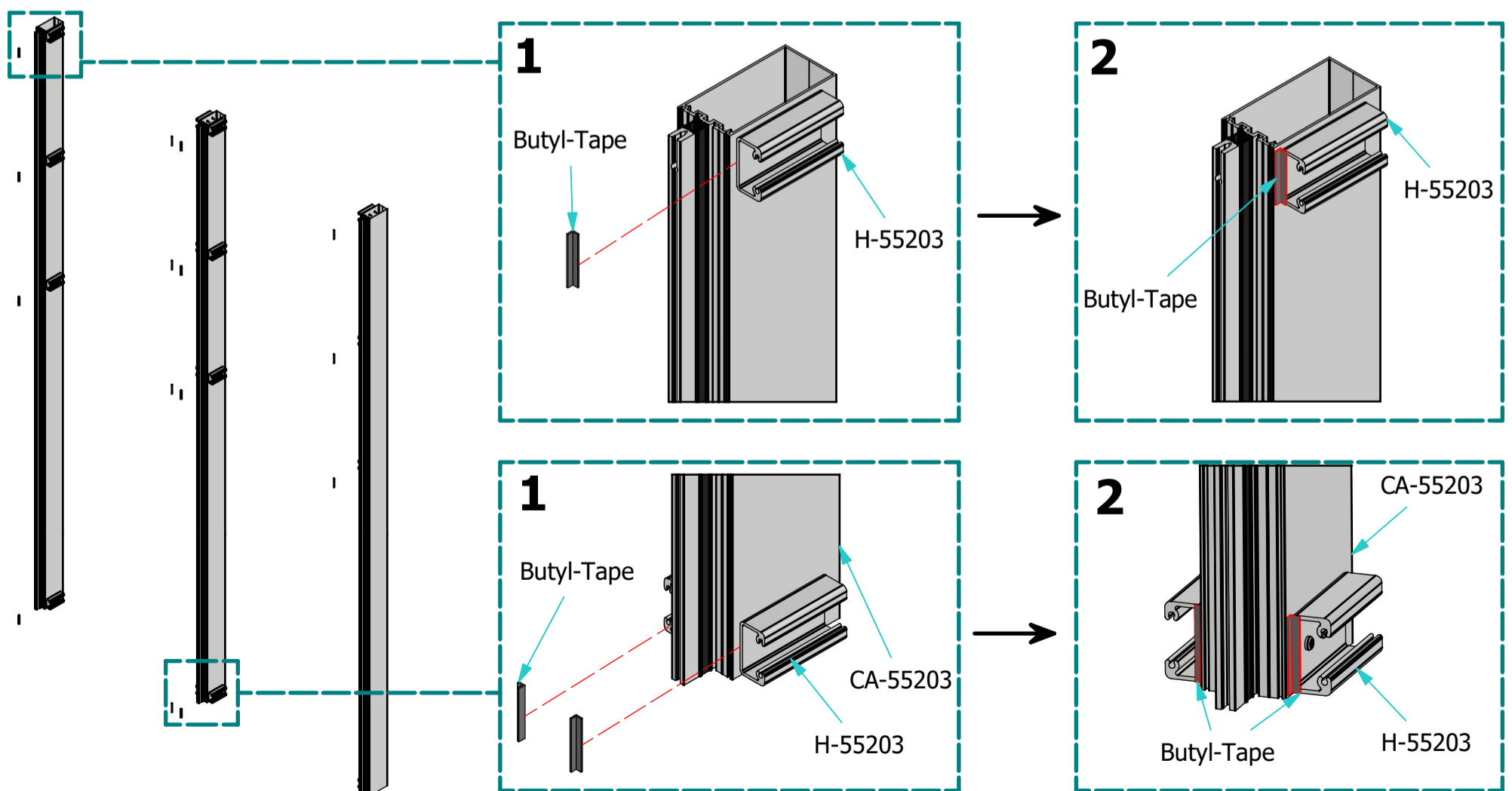
## STEP 1 (Shear Block Installation):

Attach shear blocks (H-55203) to the mullions (H-52203). Fasten using **#10 x 3/4" Quadrex Pan Head Screws (Screw-03)** through the  $\text{Ø}9/64$ " pre-drilled holes, as illustrated below.



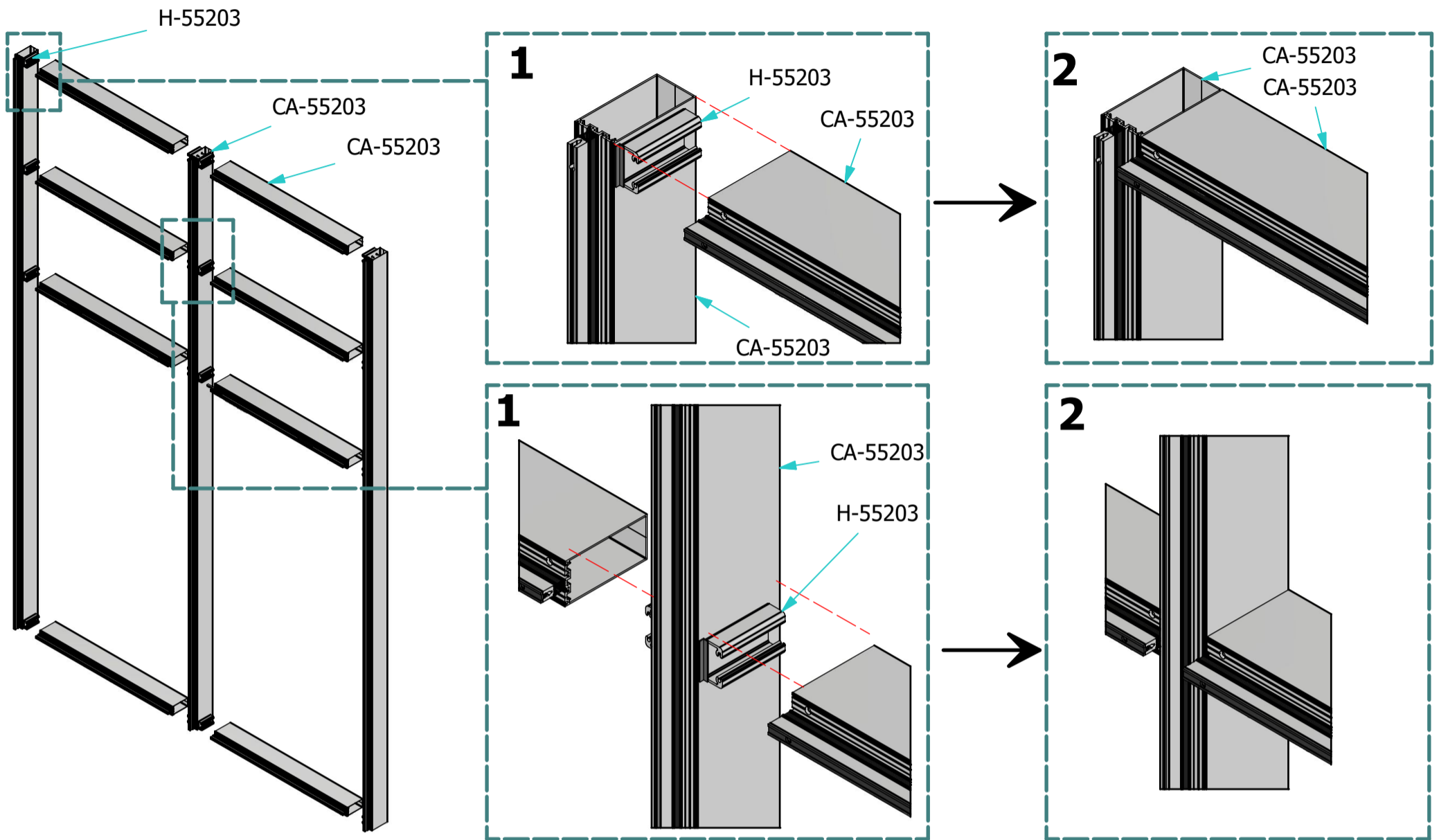
## STEP 2 (Butyl Tape):

Apply a  $\frac{1}{16}$ " thick butyl tape to each shear block (H-55293) on the exterior-facing side, as shown below.

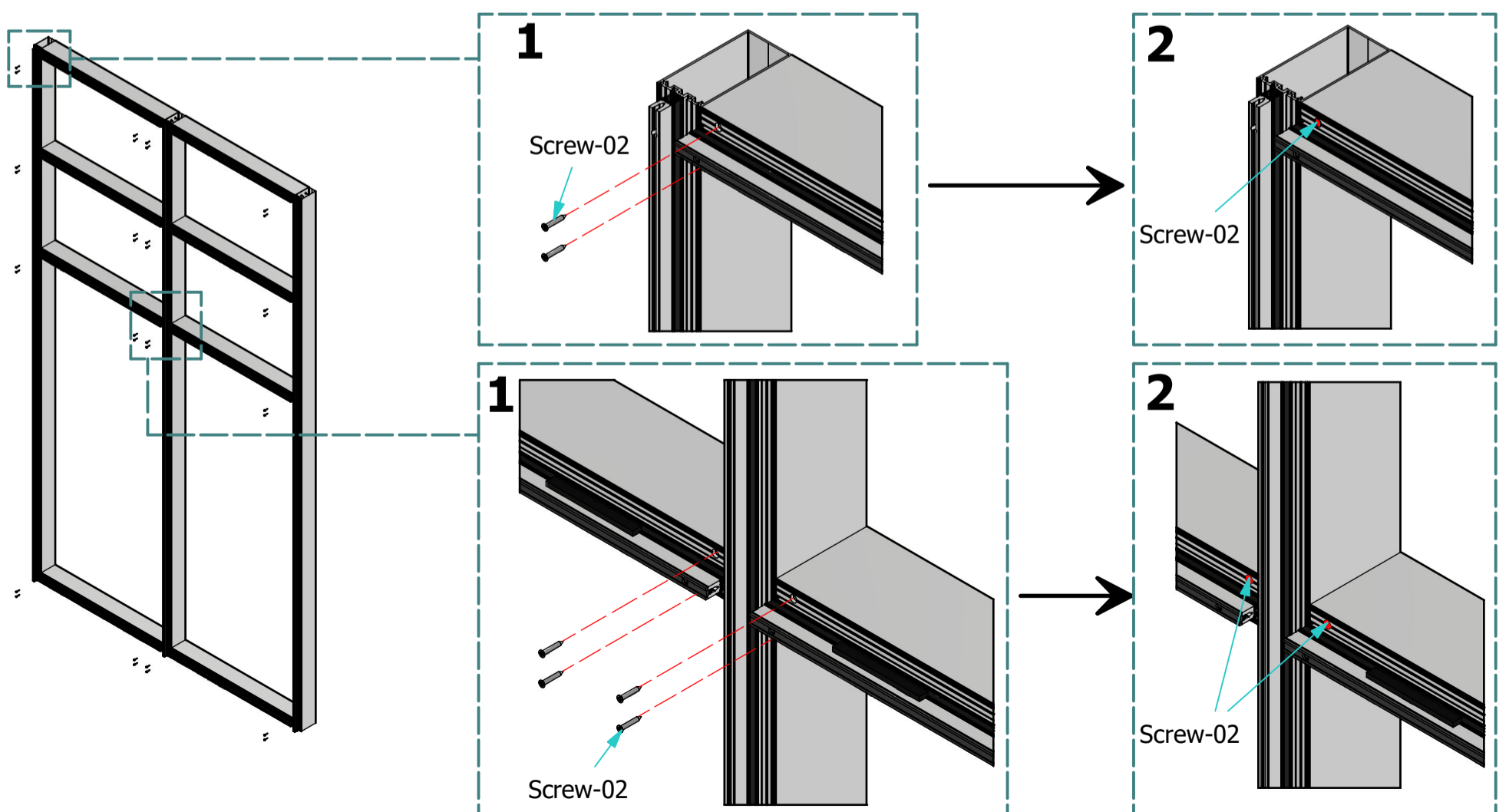


## STEP 3 (Horizontals Installation):

1) - Attach the horizontals (heads, transoms, and sills) **CA-55203** to the vertical mullion assembly **CA-55203** by sliding them onto the shear blocks (**H-55203**), as shown below.

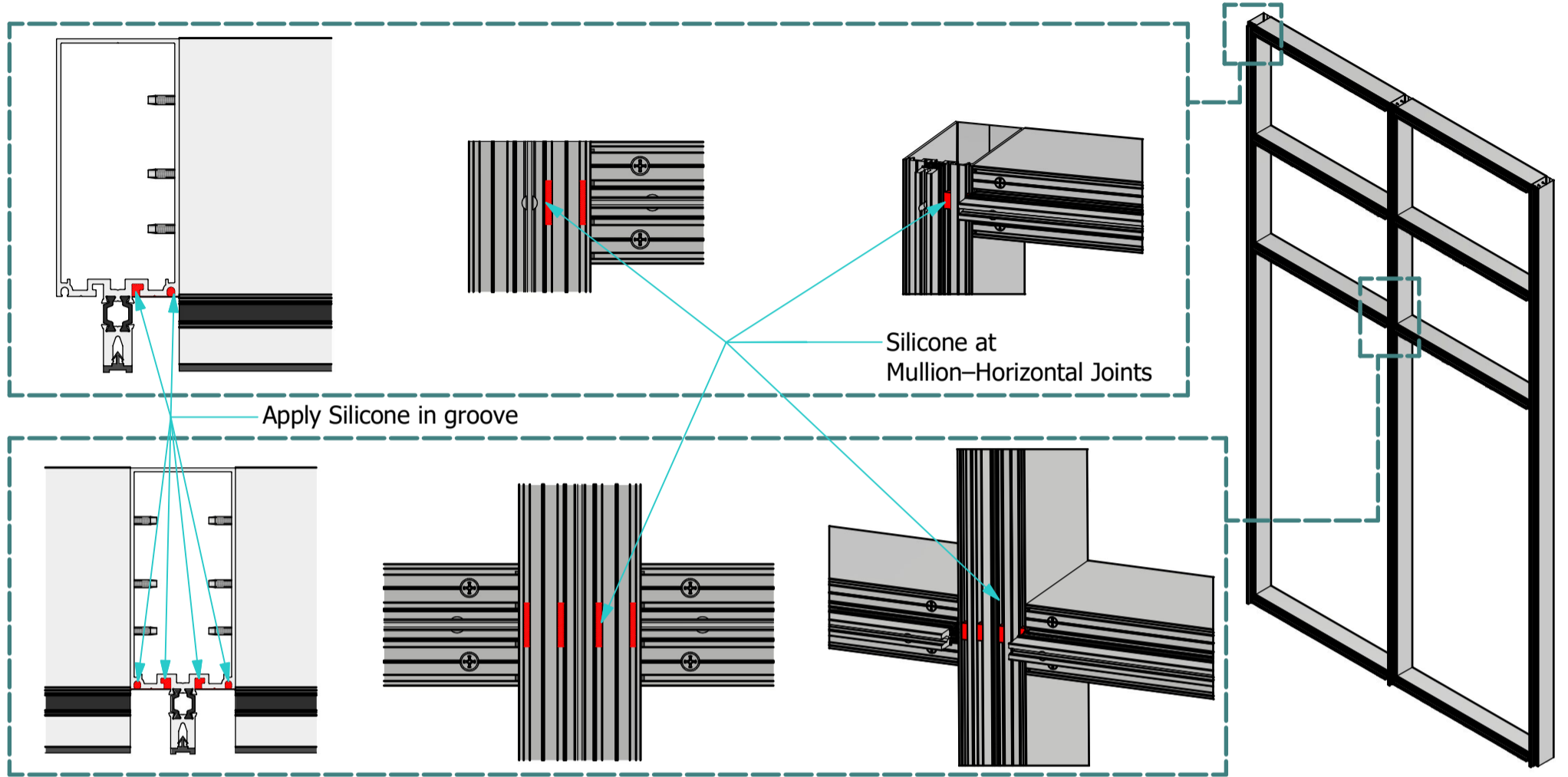


2) - Fasten the horizontals to the shear blocks using **#10 x 1-1/4" Flat Head Socket Screw (Screw-02)** through the  $\varnothing 0.201$ " CSK pre-drilled holes, as illustrated below



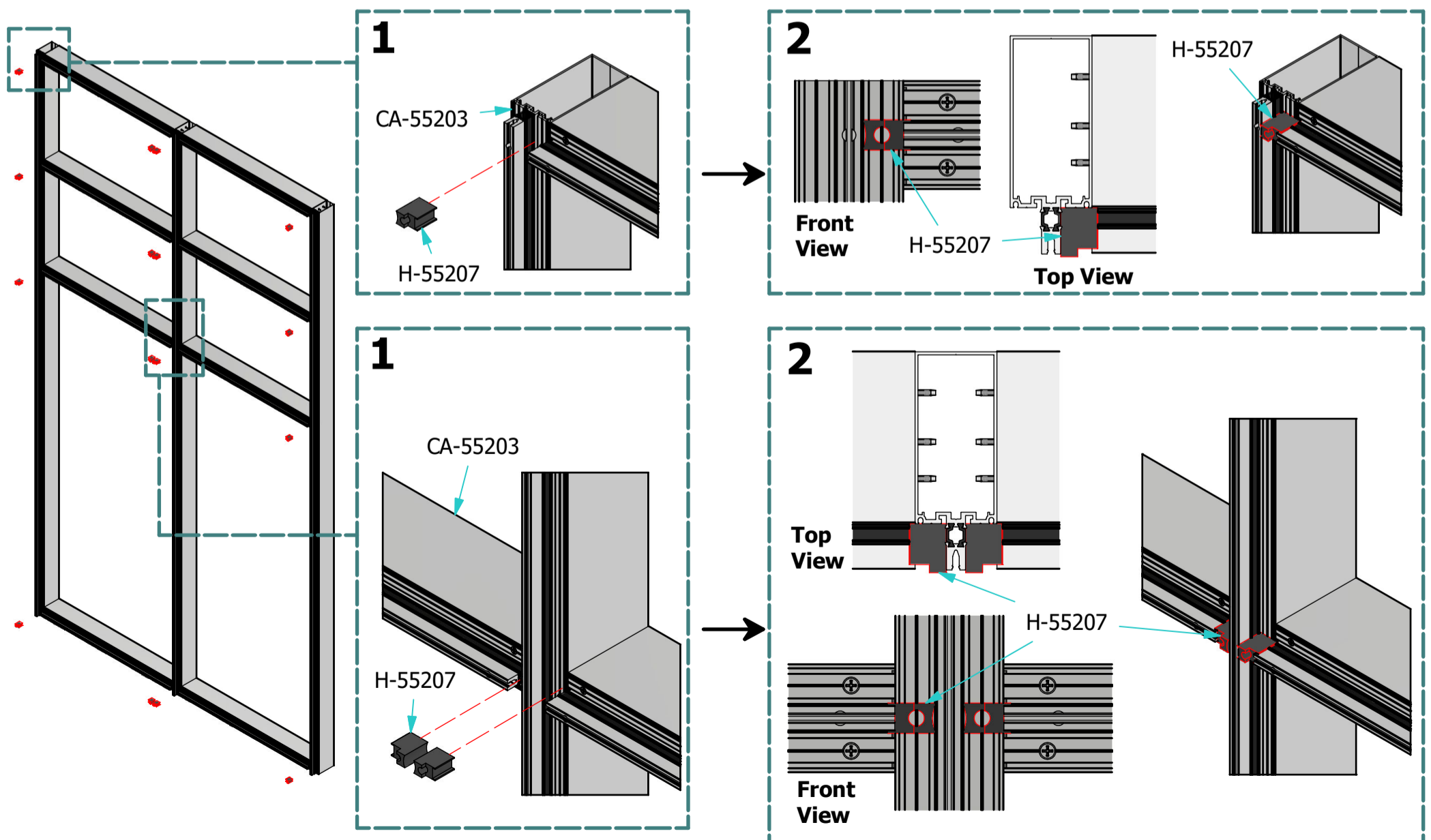
## STEP 4 (Corner Plug Area Sealing):

Apply silicone into the grooves of the vertical mullions at each mullion - horizontal joint, specifically in the gap between the end of the horizontal neck and the vertical mullion, which is where the corner plug will be installed in the following step. Ensure full coverage for a watertight seal, as shown below



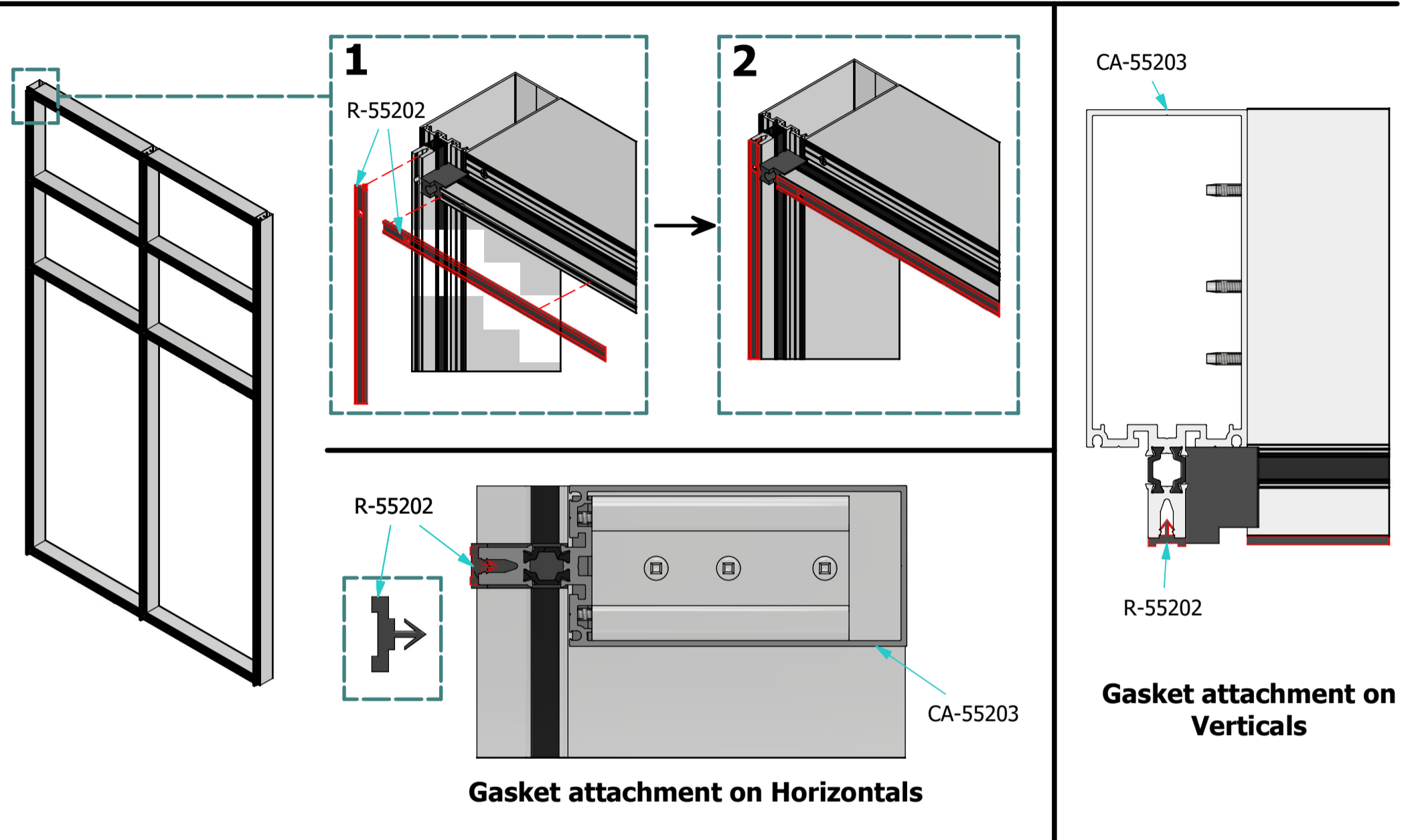
## STEP 5 (Corner Plug Installation):

Insert the corner plugs (H-55207) **at each frame connection**, ensuring the notched side faces inward toward the DLO and the back is fully seated against the exterior mullion face, as shown below.



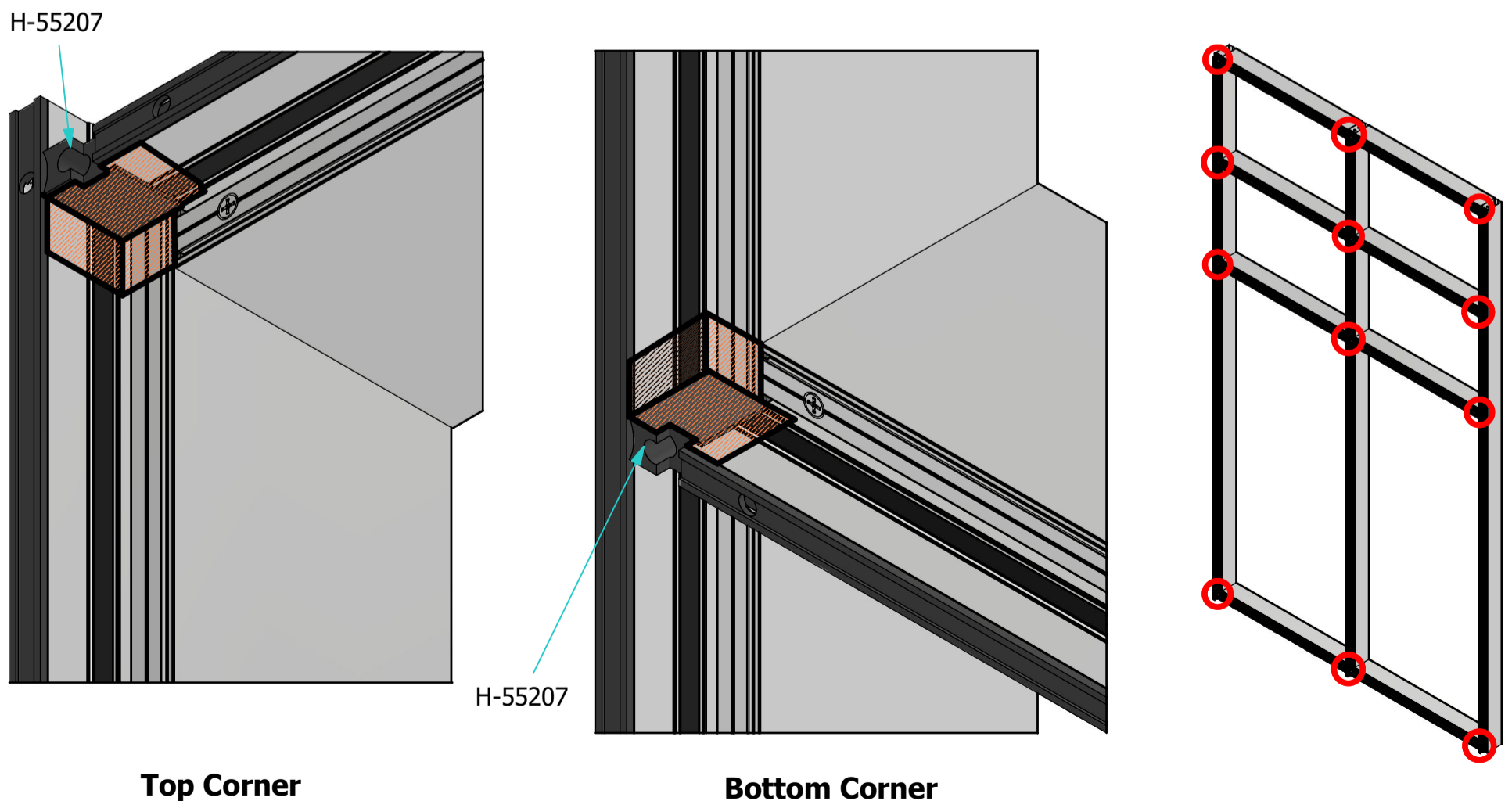
## STEP 6 (Installation of Neck Flexible PVC):

Install the neck flexible PVC (**R-55202**) onto the mullions and horizontals, ensuring full engagement within the neck profile, as illustrated below.



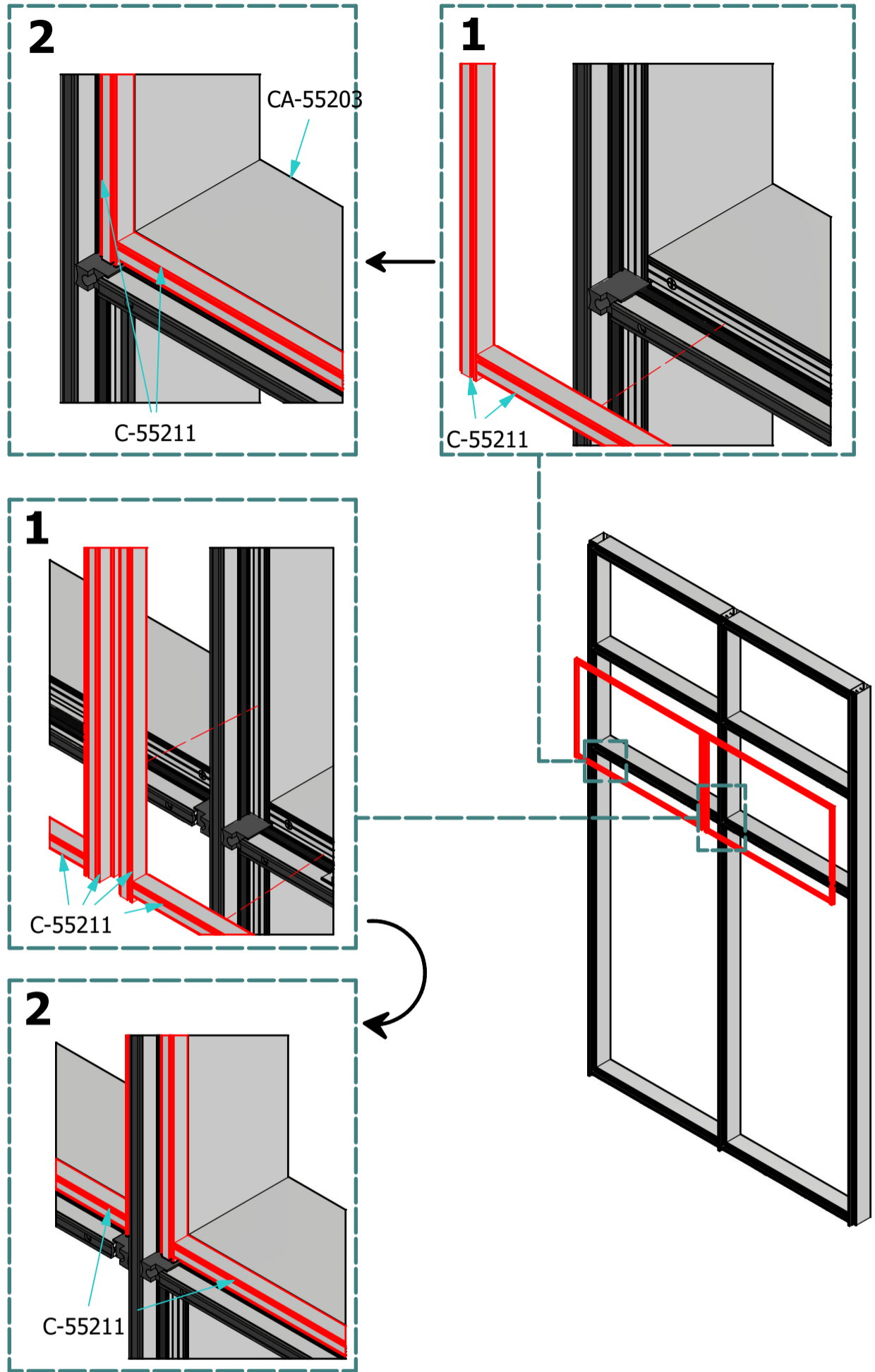
## STEP 7 (Corner Plug Caulking):

Caulk all corner plugs (**H-55207**) with silicone, ensuring full coverage for a watertight seal, as shown below.

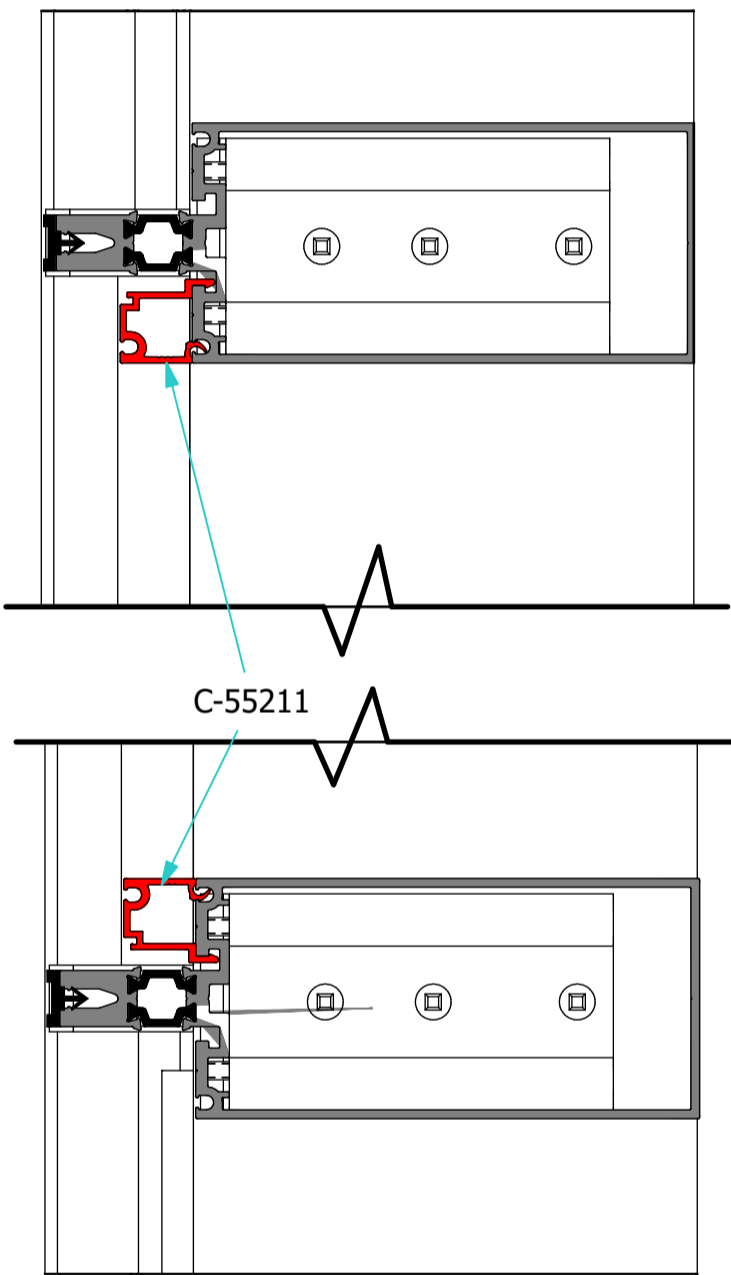


## STEP 8: ( If Applicable ) (Spandrel Adapter Installation)

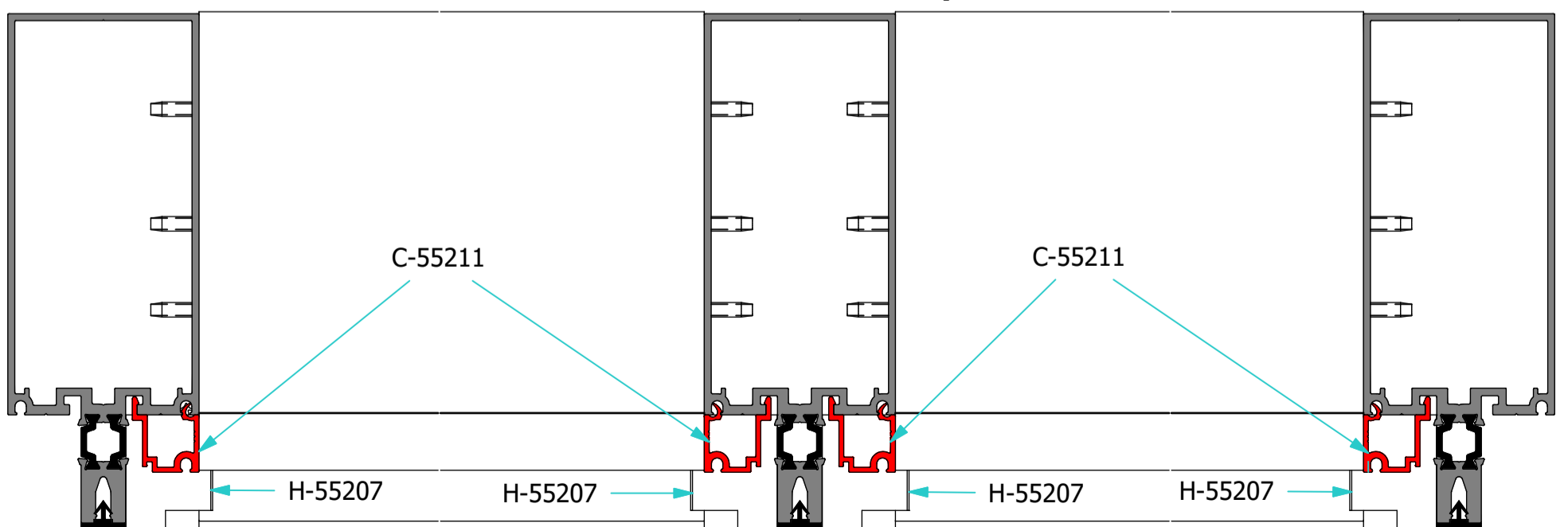
- Install the spandrel adapter (CA-55203) into the mullion grooves, ensuring it is properly seated, as shown below.
- **NOTE :This step applies only when spandrel glass is included in the system. Skip if not applicable**



### Vertical Section @Spandrel



### Horizontal Section @ Spandrel

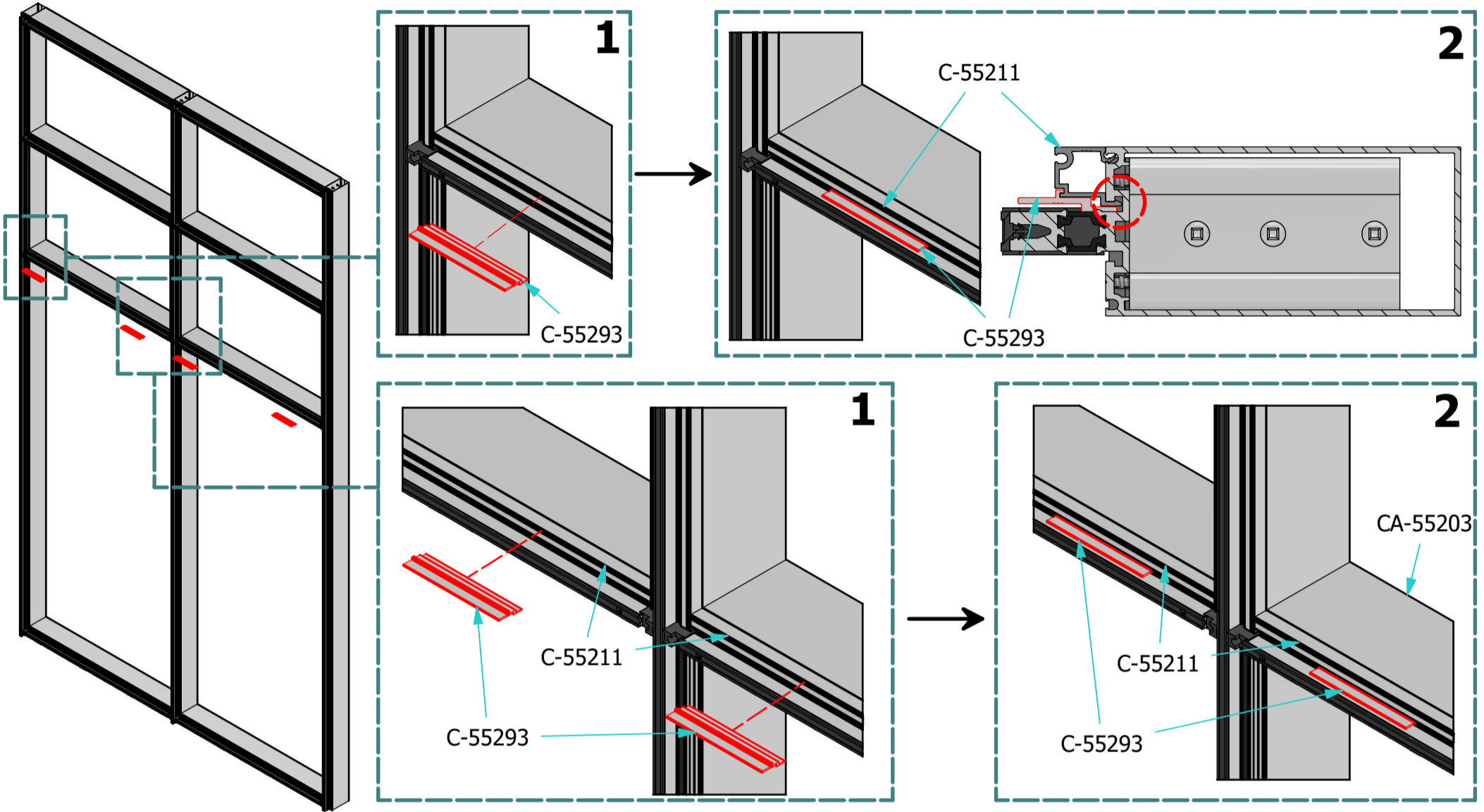


## STEP 9 ( If Applicable )

### Support Tab Installation ( Spandrel ) :

- Snap the support tab (C-55293) into the spandrel adaptor (C-55211) groove, positioning it 4" from the edge. Ensure it is fully engaged and rests securely underneath, as shown below

- **NOTE: This step applies only when spandrel glass is included in the system. Skip if not applicable**

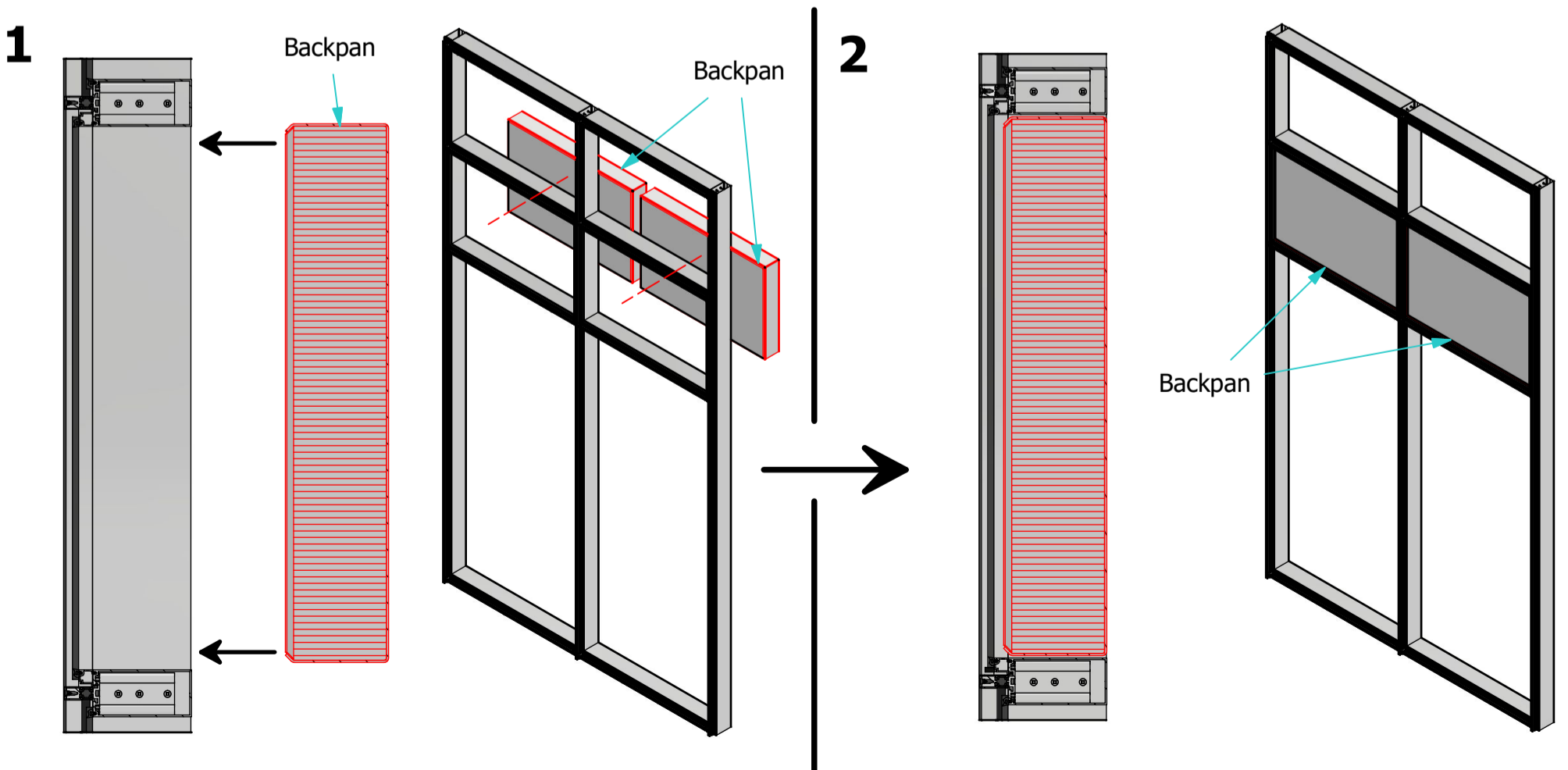


## STEP 10 ( If Applicable )

### Backpan Installation:

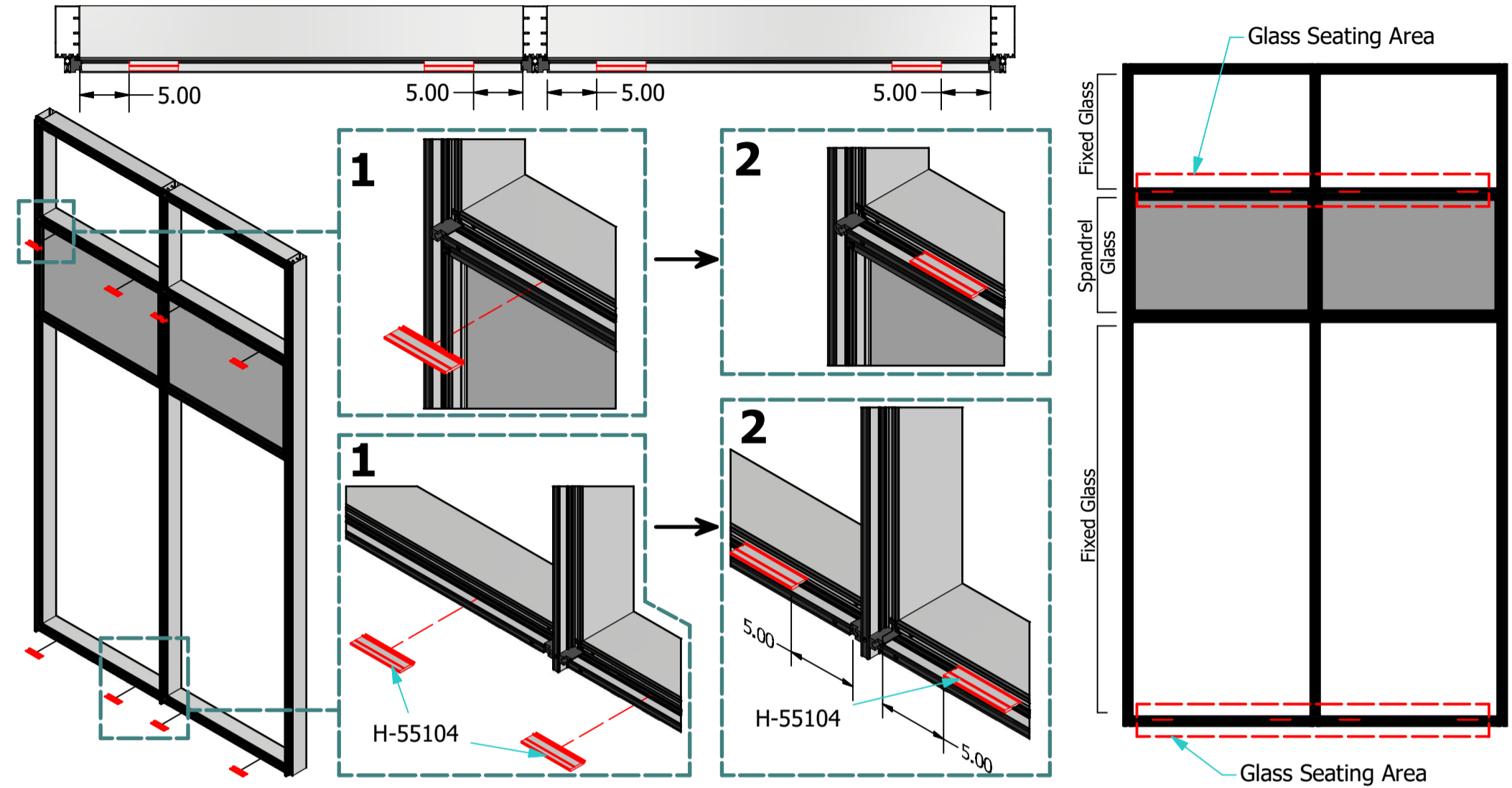
- Install the backpan into the spandrel opening, ensuring its back face is flush with the back faces of the mullions and transoms, as shown below.

- **NOTE :This step applies only when spandrel glass is included in the system. Skip if not applicable**



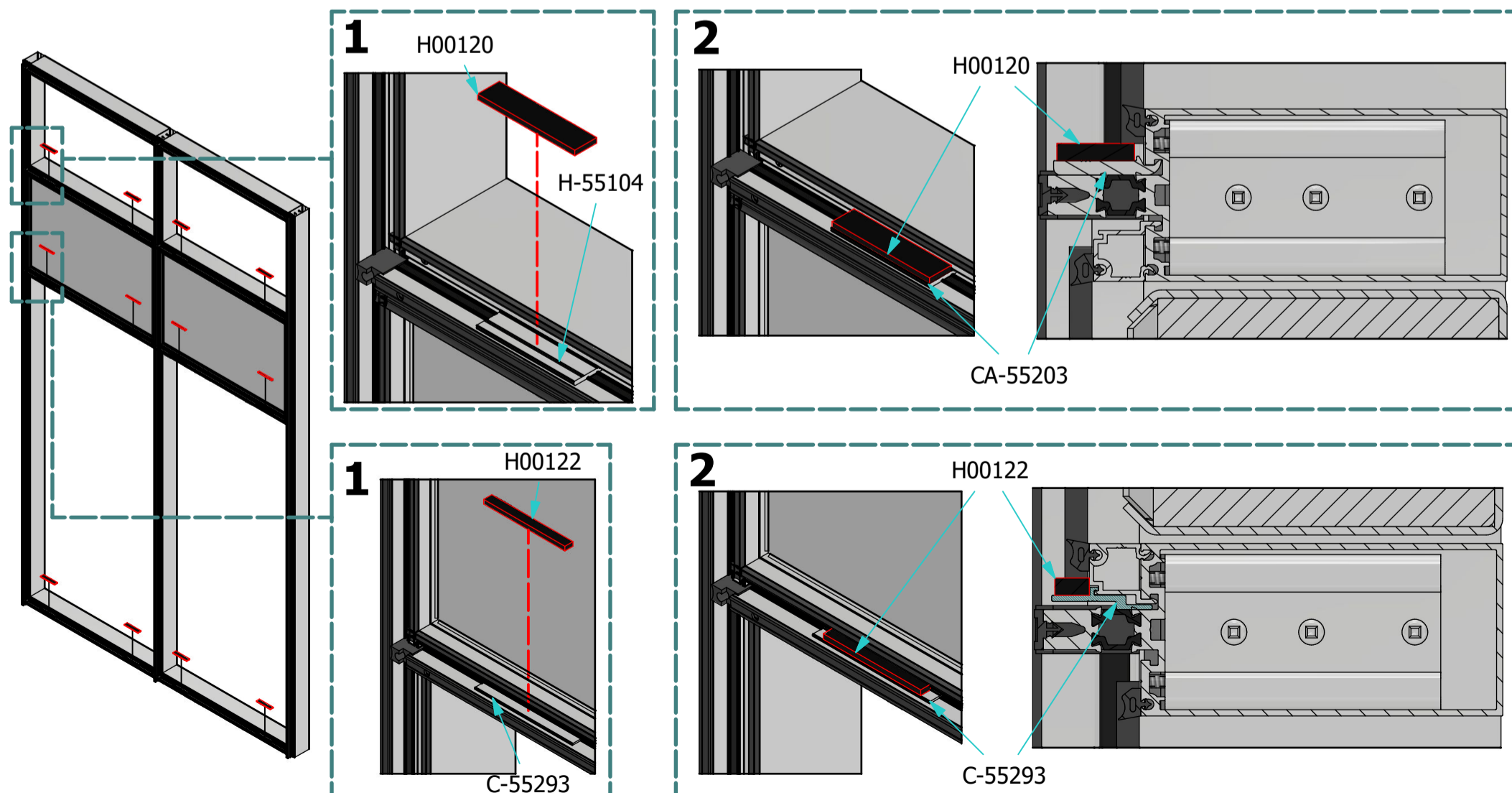
## STEP 11 (Glazing Support Tab Insertion):

- Insert the glazing support tab (**H-55104**) into the groove above the mullion neck in the **fixed glass areas**, where the glass panel will sit, **positioning it 5" away from the vertical mullion**, as shown below.



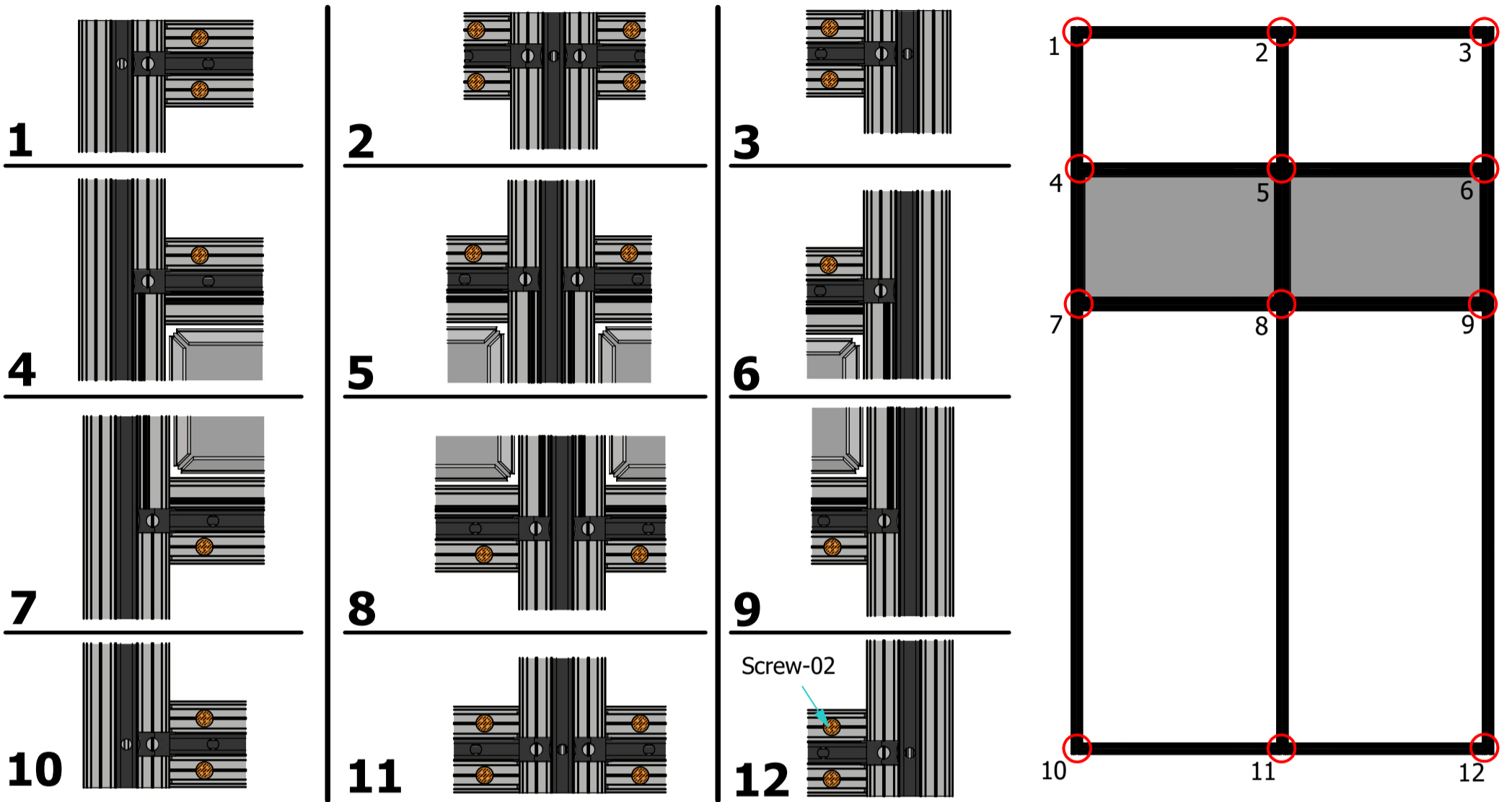
## STEP 12 (Setting Block Placement):

- Place the setting block (**H00120**) for **fixed glass** on top of the glazing support tabs (**H-55003**).
- For **spandrel glass**, place the setting block (**H00122**) on top of the glazing support tabs (**H-55293**), as shown below.
- **NOTE** :Perform the spandrel step only if spandrel glass is included in the system.



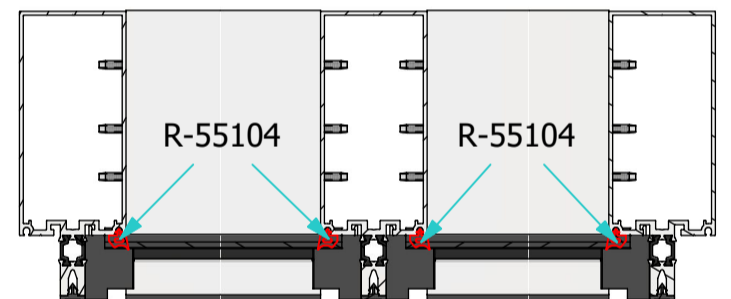
## STEP 13 (Silicone Application at Shear Block Fasteners):

- Apply silicone on the horizontals **at the screw locations where the #10 × 3/4" Quadrex Pan Head Screws (Screw-02)** pass through the shear block, ensuring full coverage to maintain a watertight seal, as shown below.

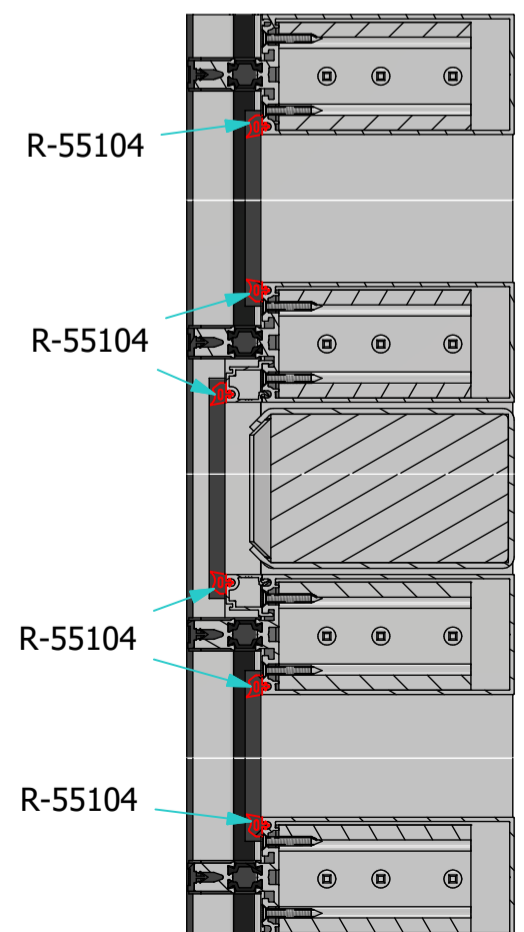
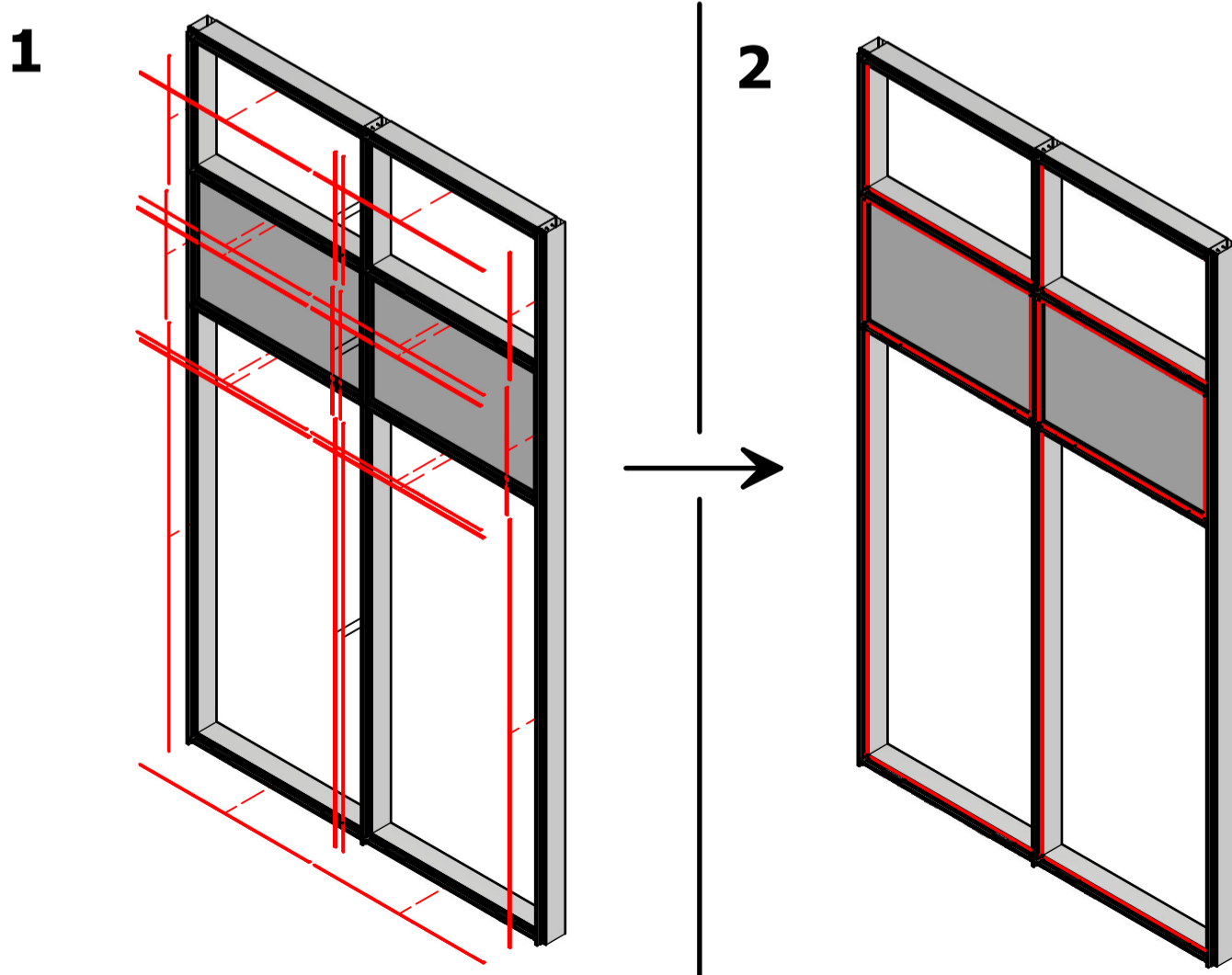


## STEP 14 (Interior Gasket Installation):

- Carefully insert the interior gaskets (**R-55104**) into the designated grooves. For vision glass areas, place them along the grooves of the vertical and horizontal members. **For spandrel areas, insert them into the groove of the spandrel adaptor.** Ensure each gasket is fully seated and continuous along the entire length, as shown below.



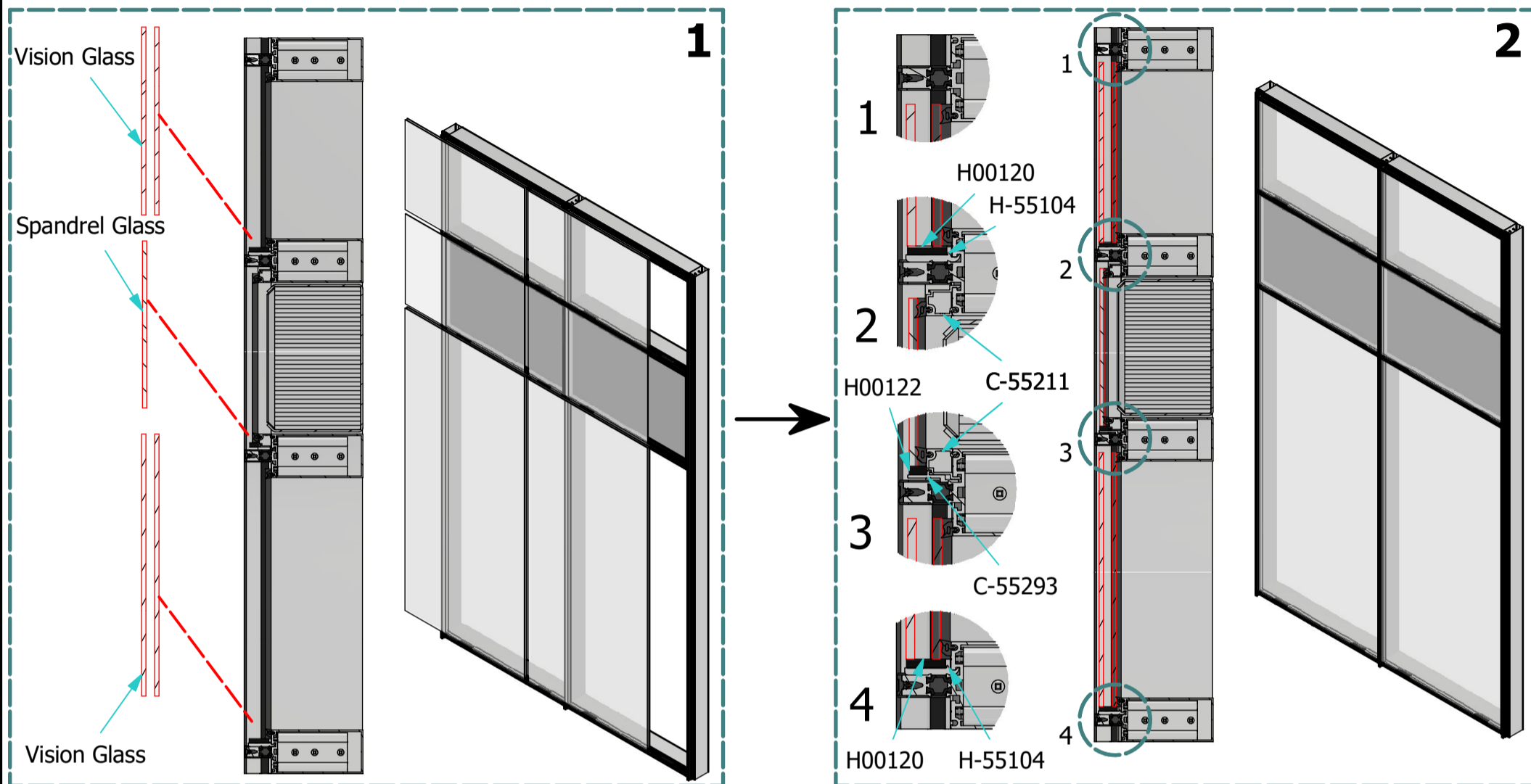
Horizontal Section



Vertical Section

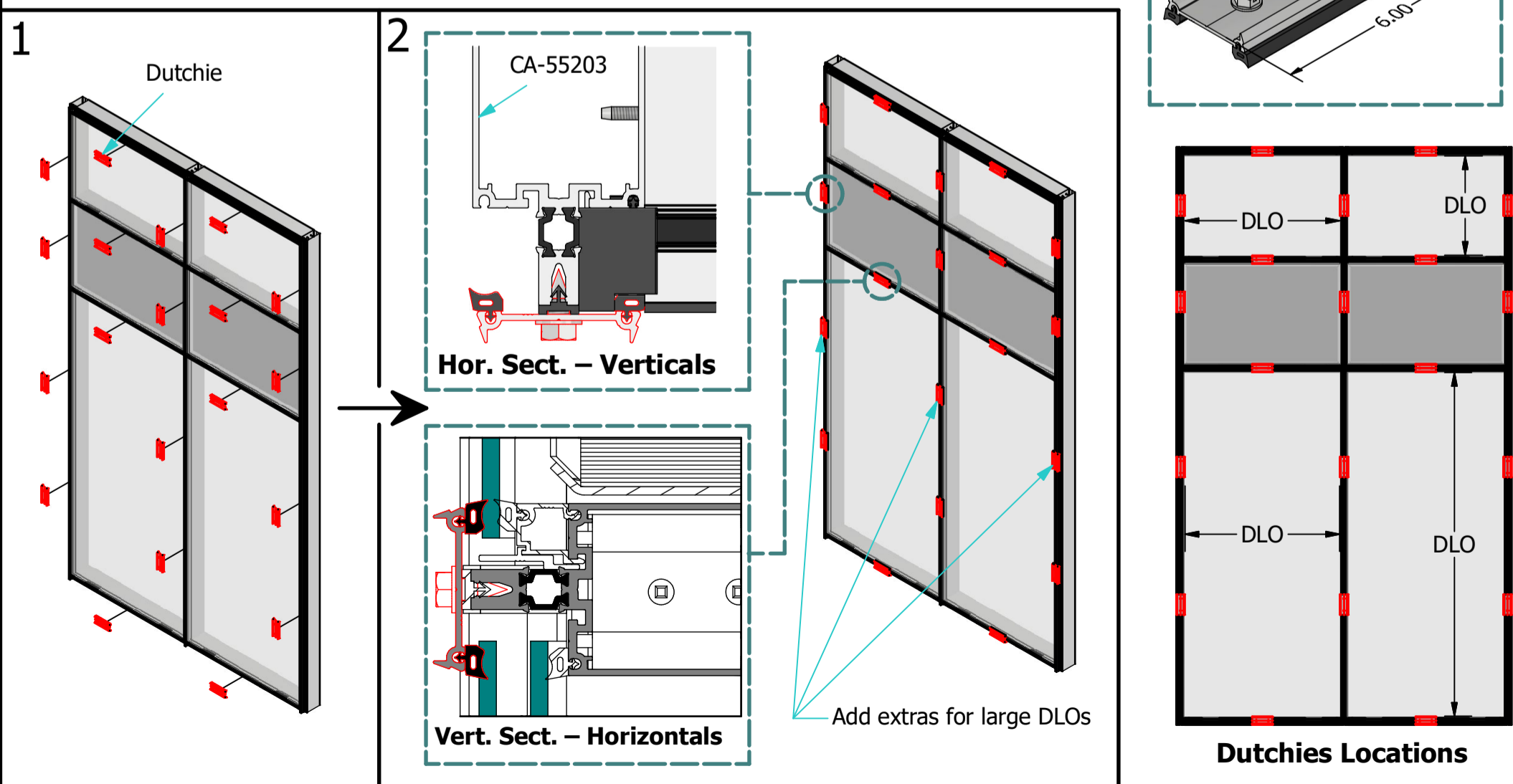
## STEP 15 (Glass Panels Installation):

- Insert the vision glass panels into each daylight opening, ensuring they are evenly supported and properly aligned on the setting blocks (H00120).
- Insert a single spandrel glass panel into the designated spandrel opening, if applicable, ensuring it is seated correctly on its setting blocks (H00122).



## STEP 16 (Temporary Dutchies Installation):

- Temporarily attach 6" Dutchies to the horizontals and verticals by securing them through the neck, around the middle of each DLO. Use additional Dutchies for larger openings, as shown below

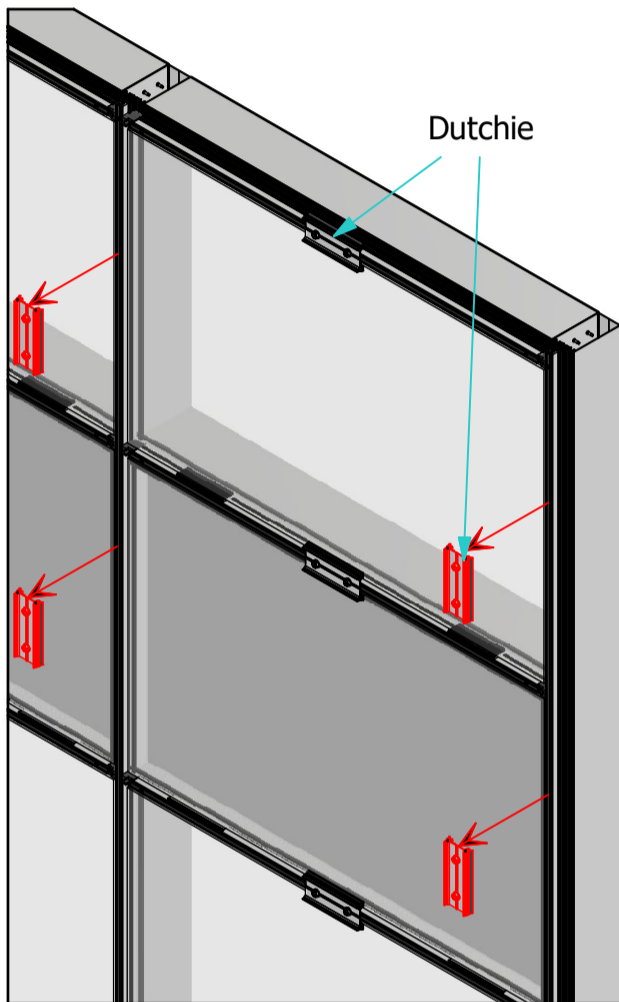


## STEP 17 (Pressure Plates Installation):

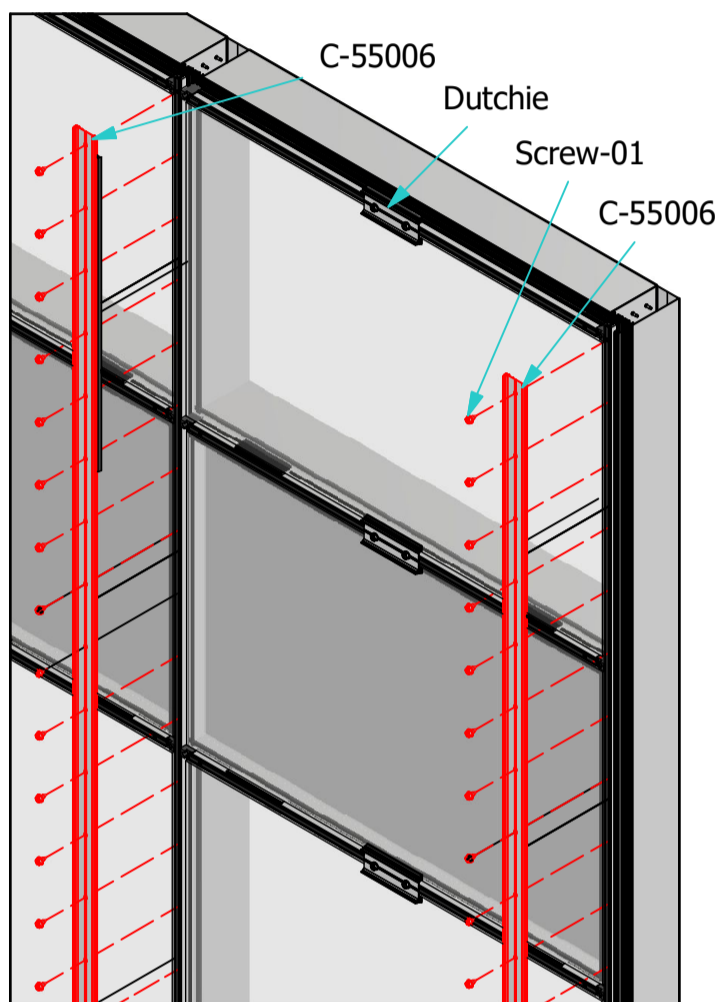
- Remove the Dutchies from the verticals, then install the vertical pressure plates (**C-55006**) by fastening them through the flexible PVC and into the neck using **#14 x 3/4" SS Hex Washer Head Screws (Screw-01)**.
- Repeat the same process for the horizontals.

### Pressure Plate Installation Sequence

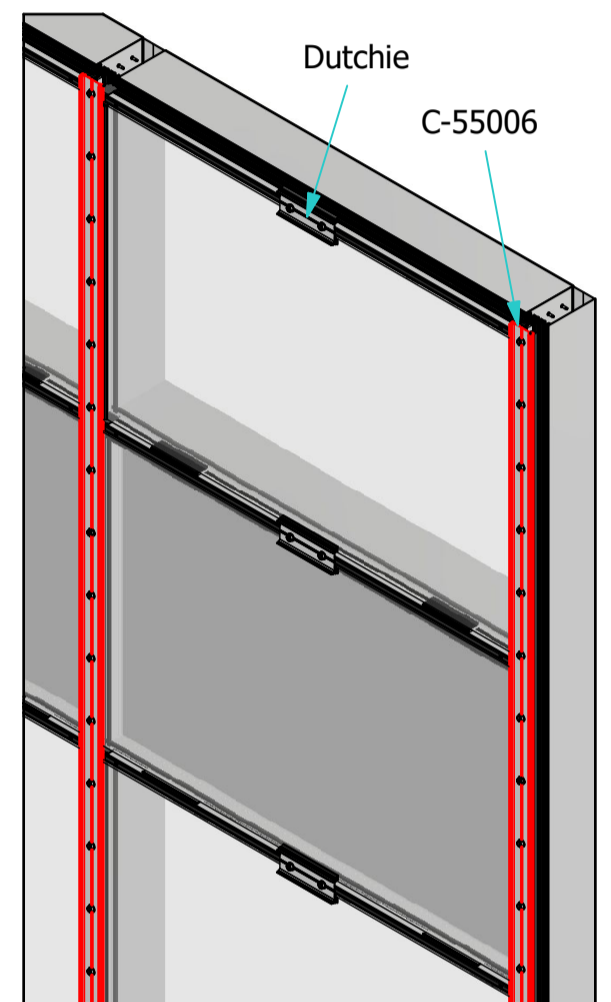
1) - Remove Dutchies - Verticals



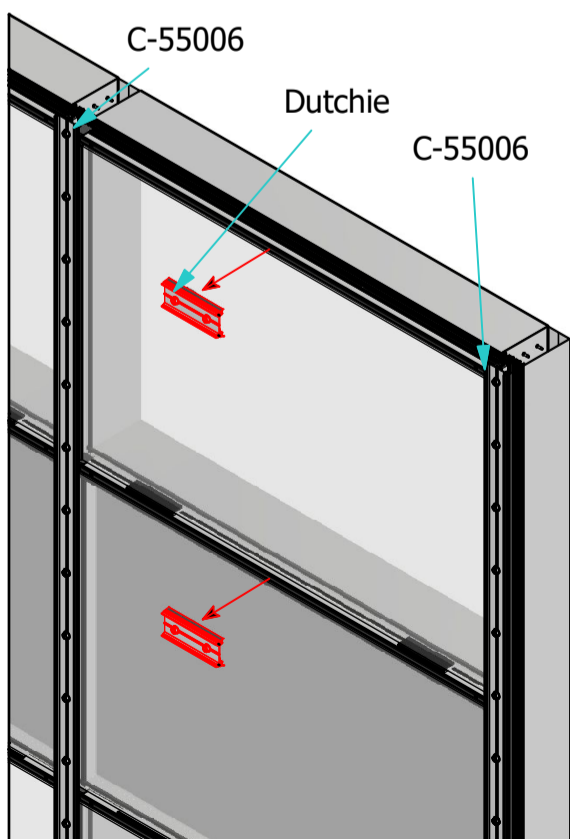
2) - Install Vertical Pressure Plates



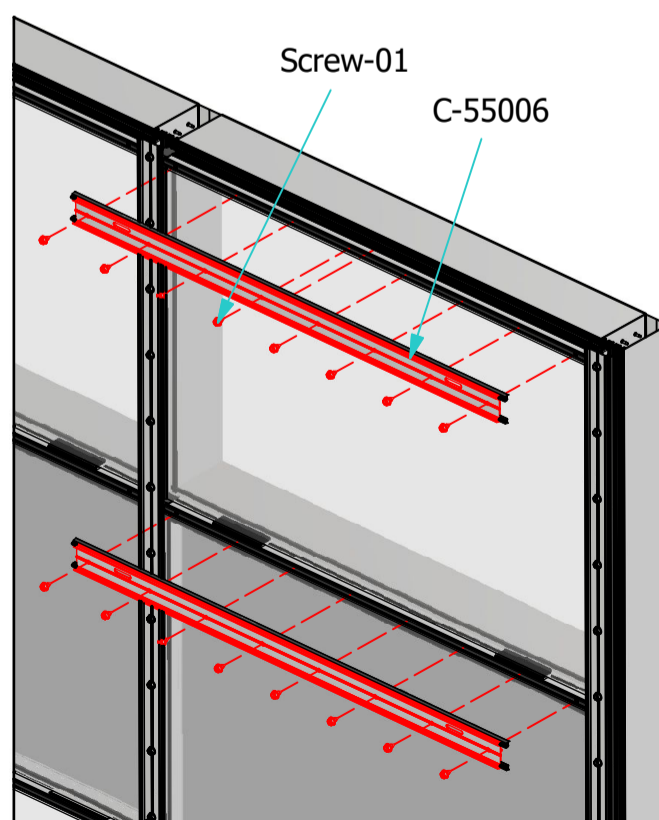
3) - Vertical Installation - Final Look



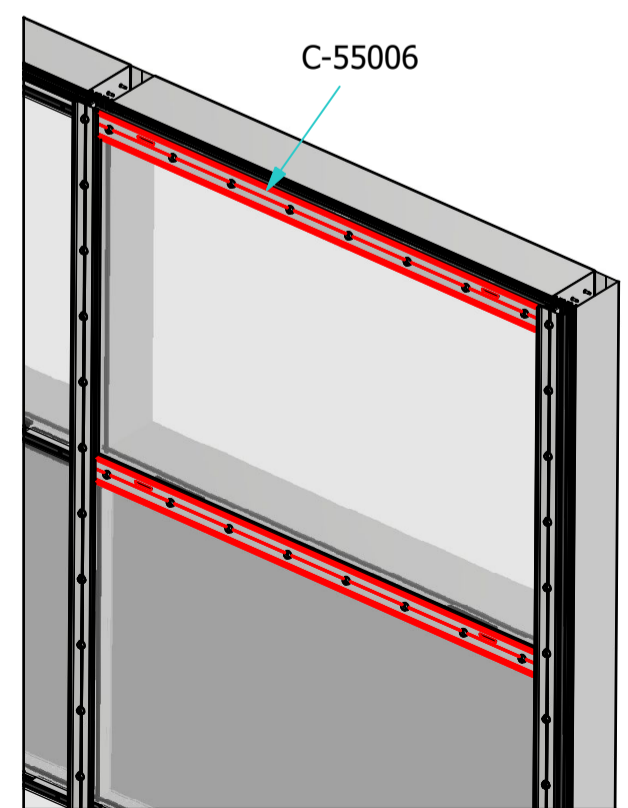
4) - Remove Dutchies - Horizontals



5) - Install Horizontal Pressure Plates

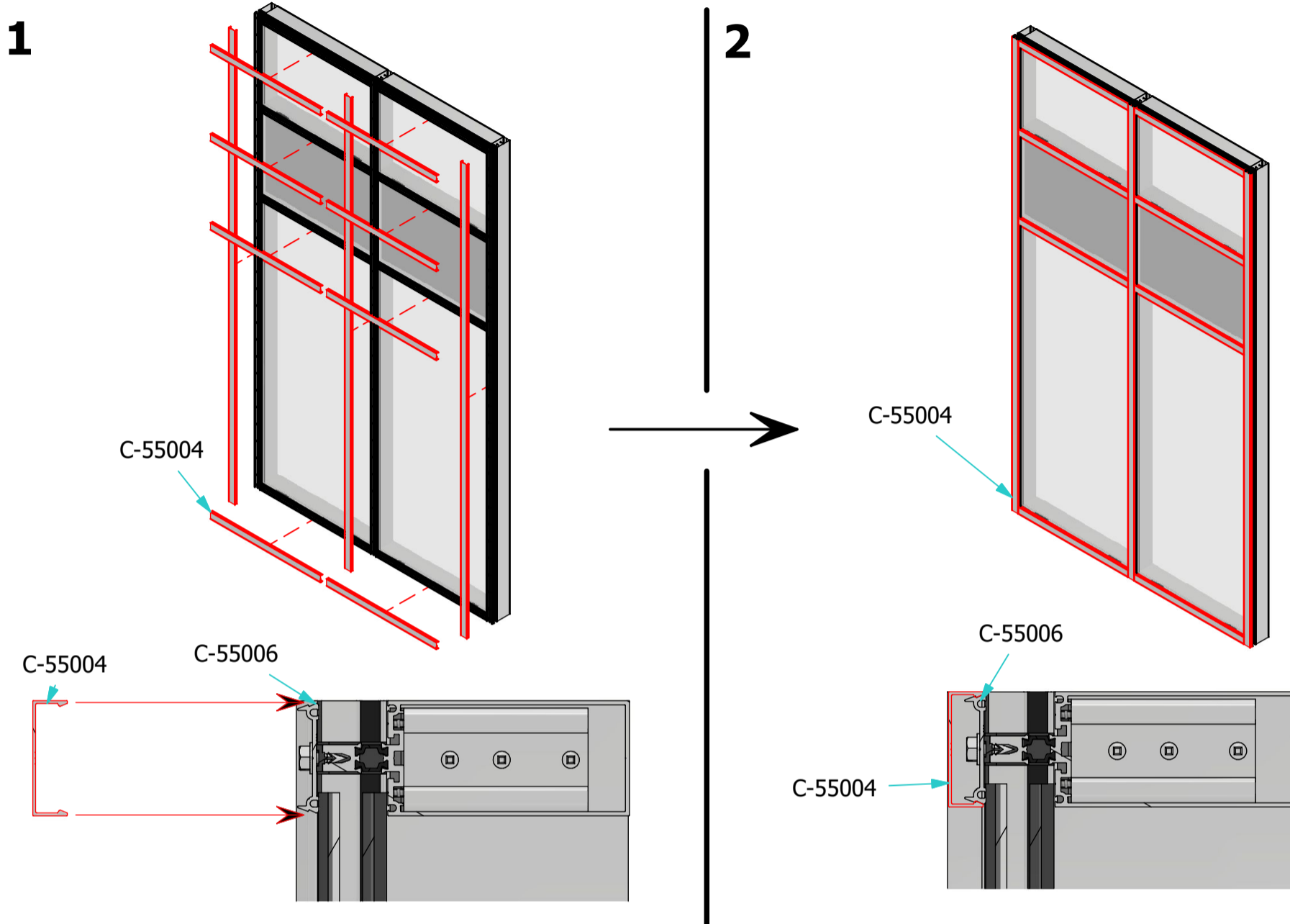


6) - Horizontal Installation - Final Look



## STEP 18 (Cap Installation):

Gently hammer the caps (C-55004) onto the pressure plates (C-55006), ensuring they are fully seated and securely engaged along the profile, as shown below.



## STEP 19 (Pocket filler installation):

Insert the pocket fillers (R-55201) into all external empty pockets around the frame, ensuring they are fully seated and flush with the mullion face to close off cavities and maintain system integrity, as shown below.

