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Fabrication

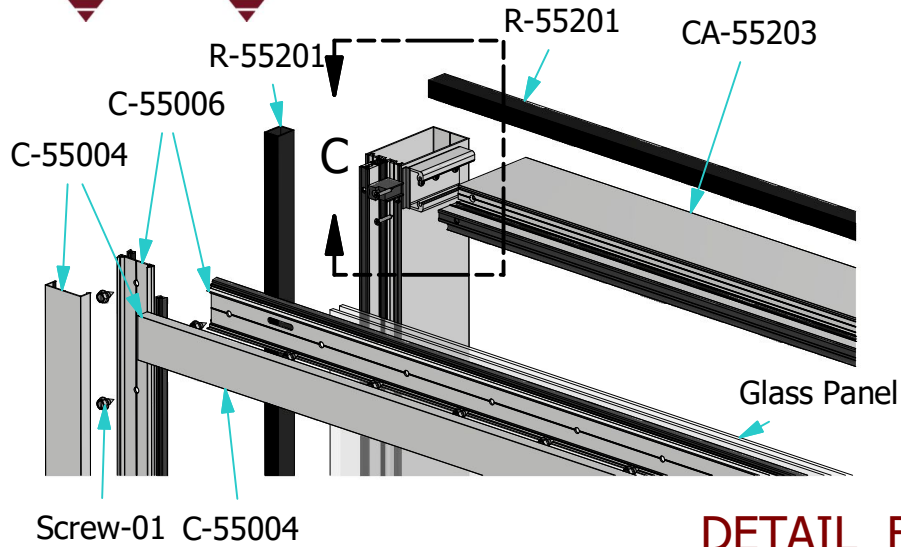
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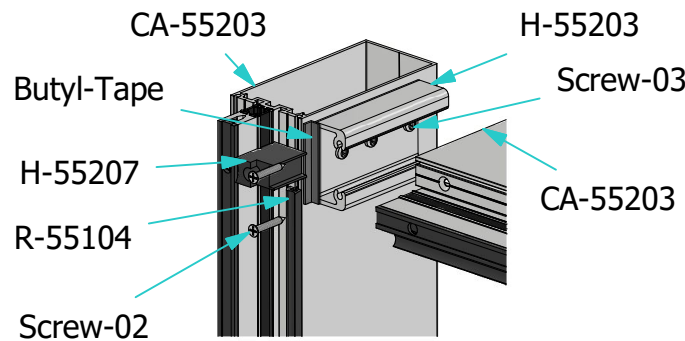


EXPLODED VIEW & PARTS LIST

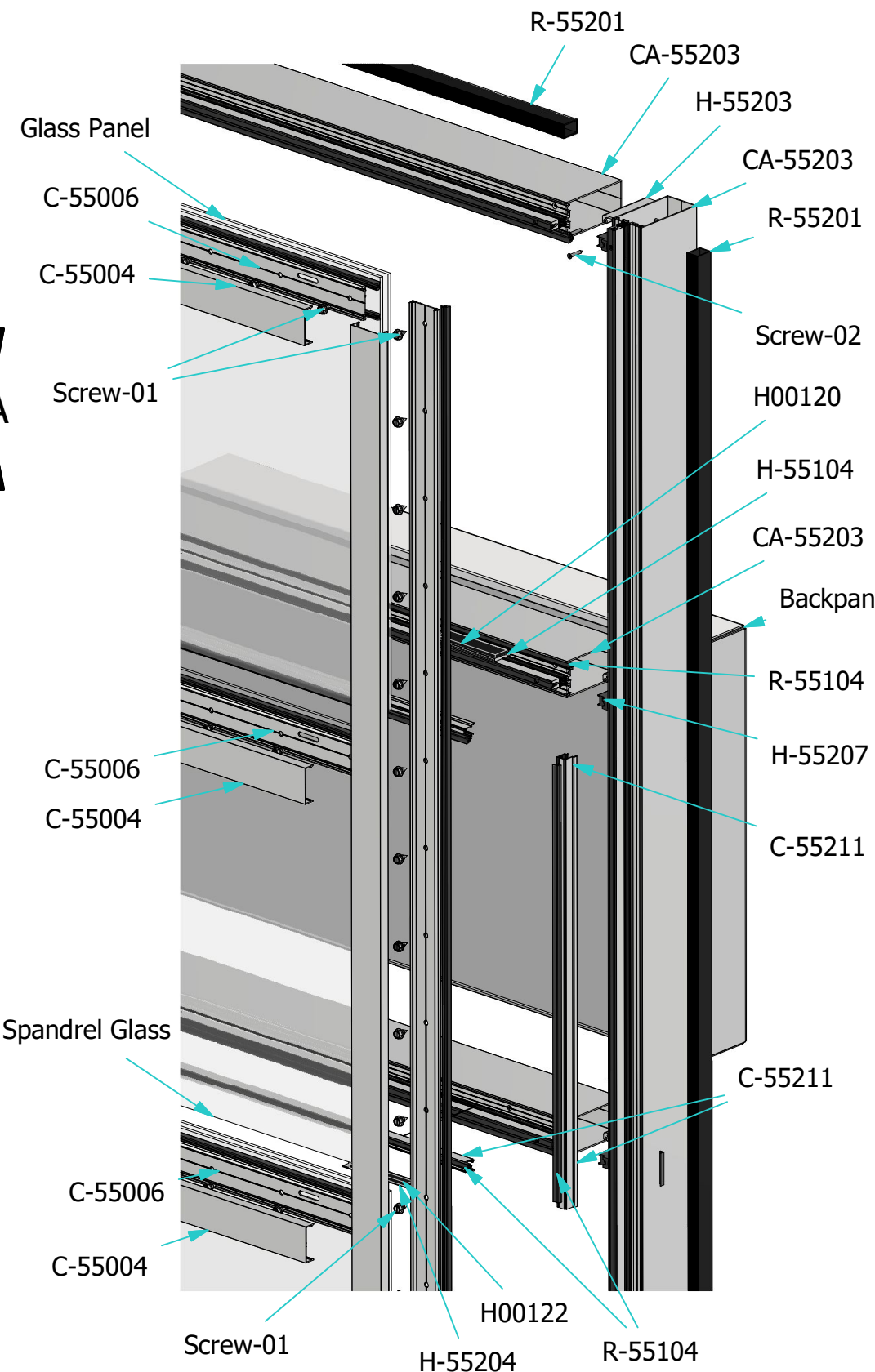
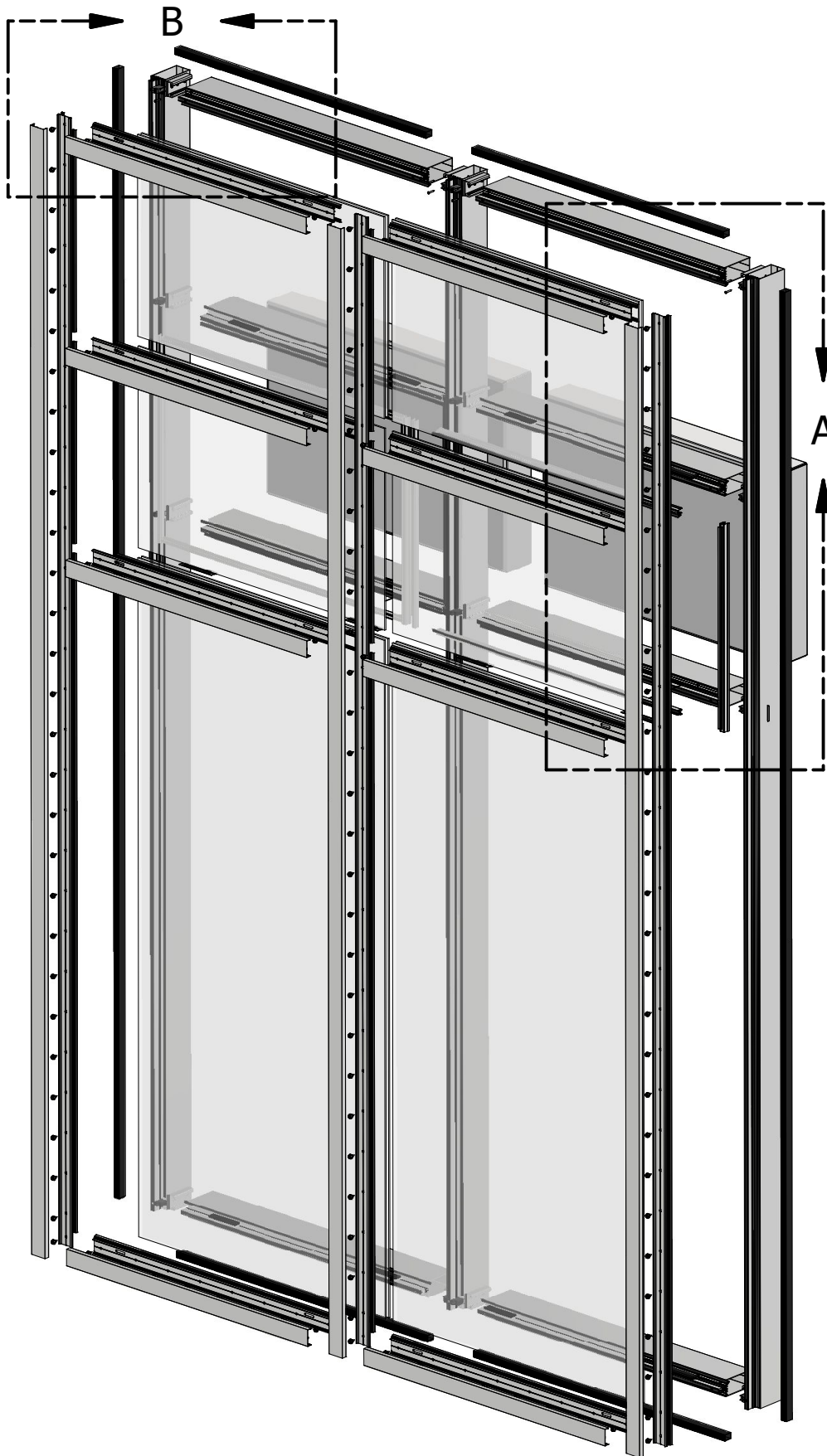
5500 HTP Series



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
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-55204	HTP Single Glass Adaptor Support
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)
R-55202	Thermal Break - Flexible 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

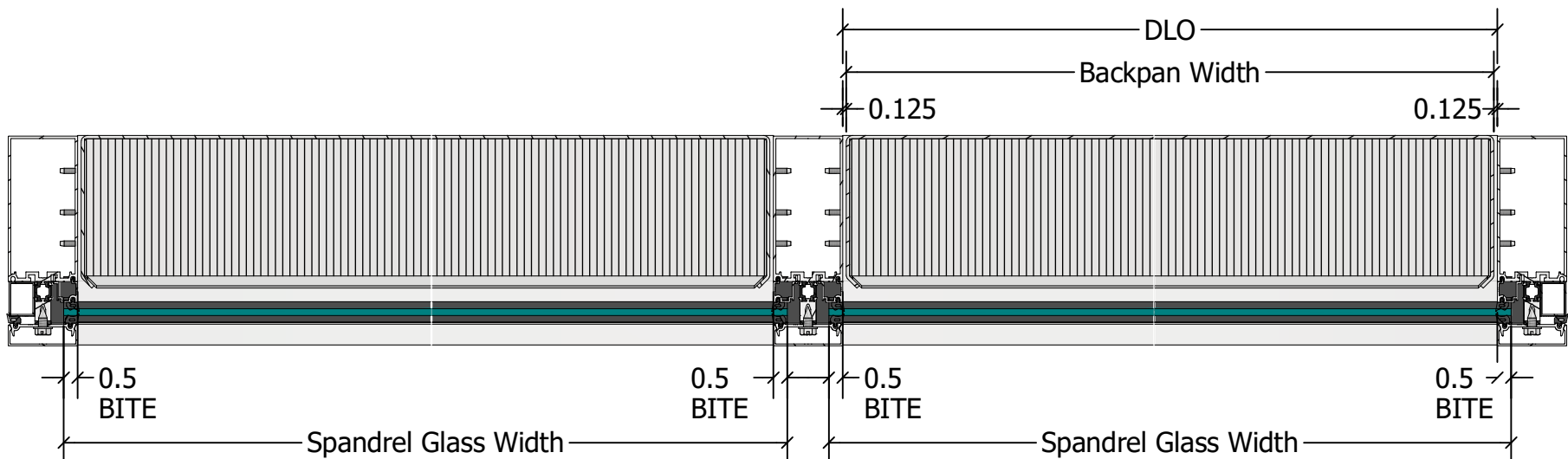
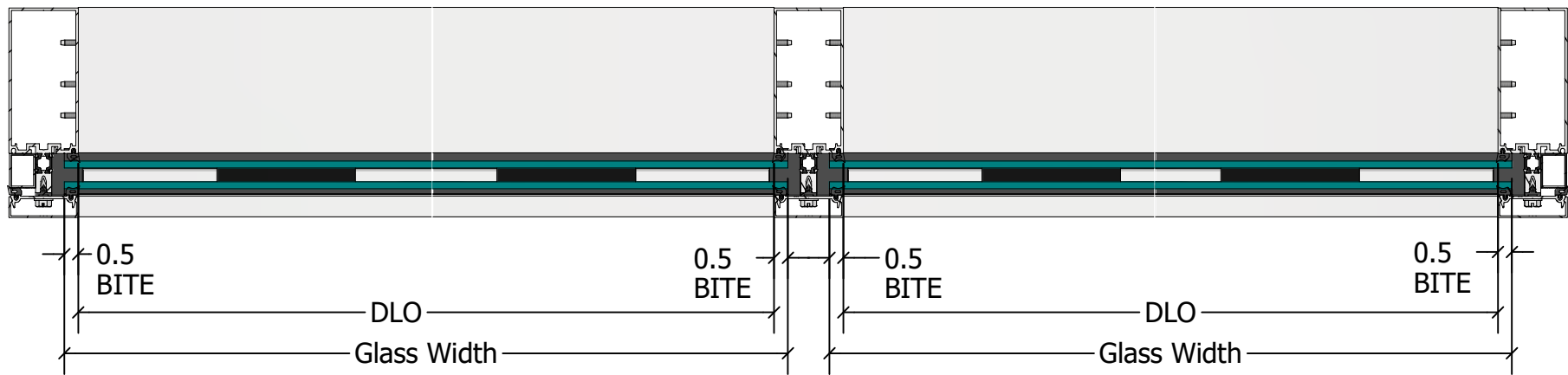
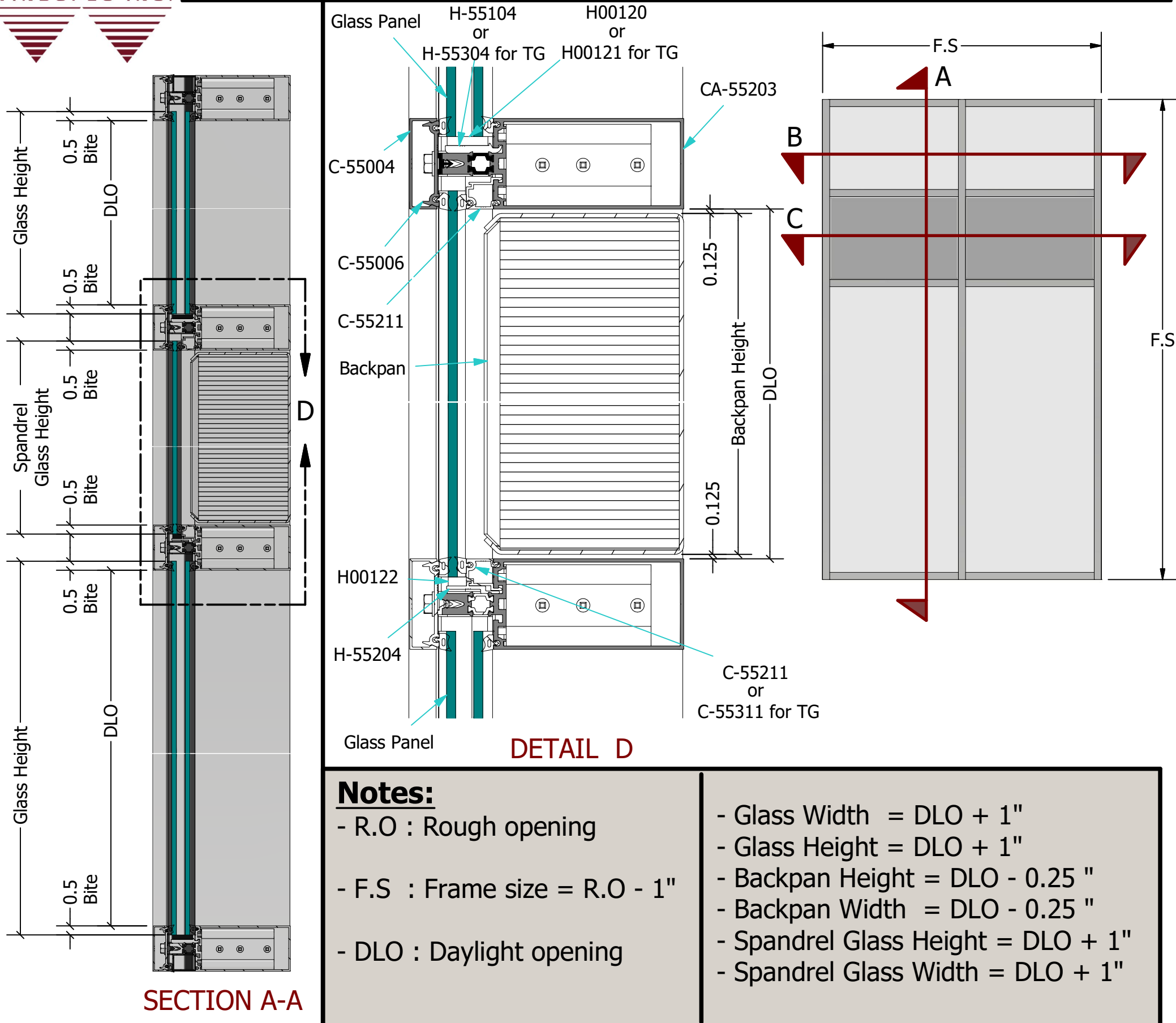
F a b r i c a t i o n

D r a w i n g s



DIMENSIONAL DETAILS & SECTIONS

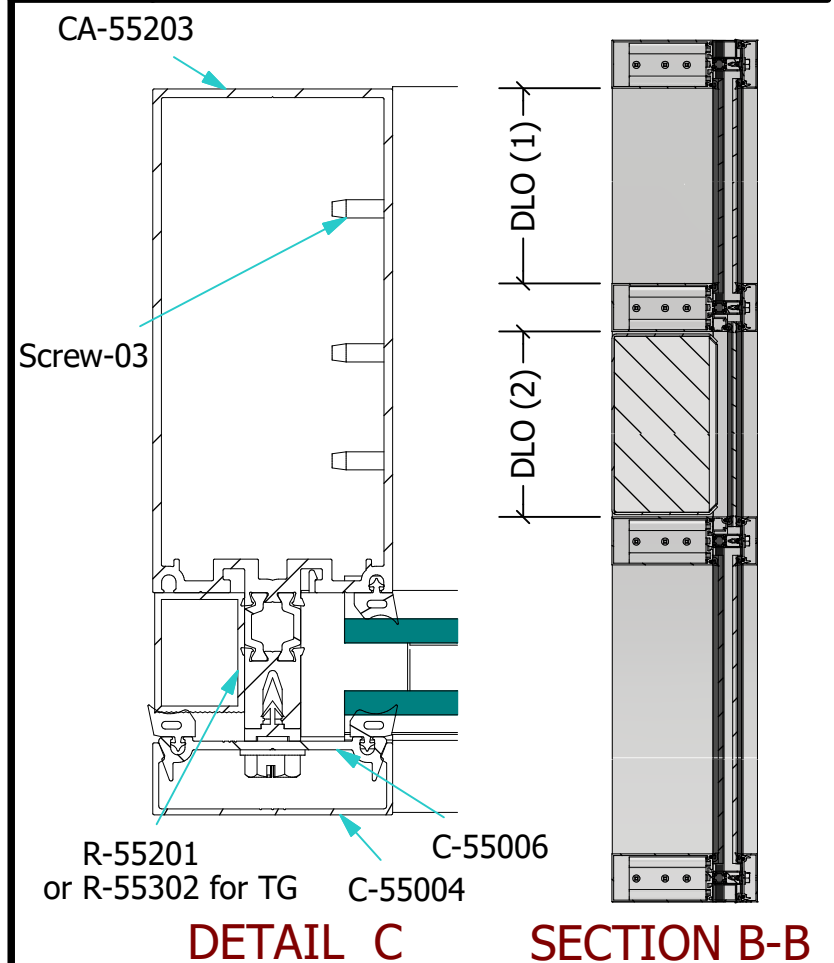
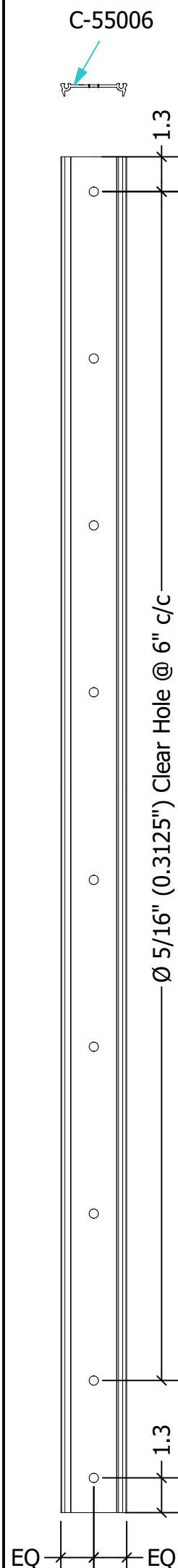
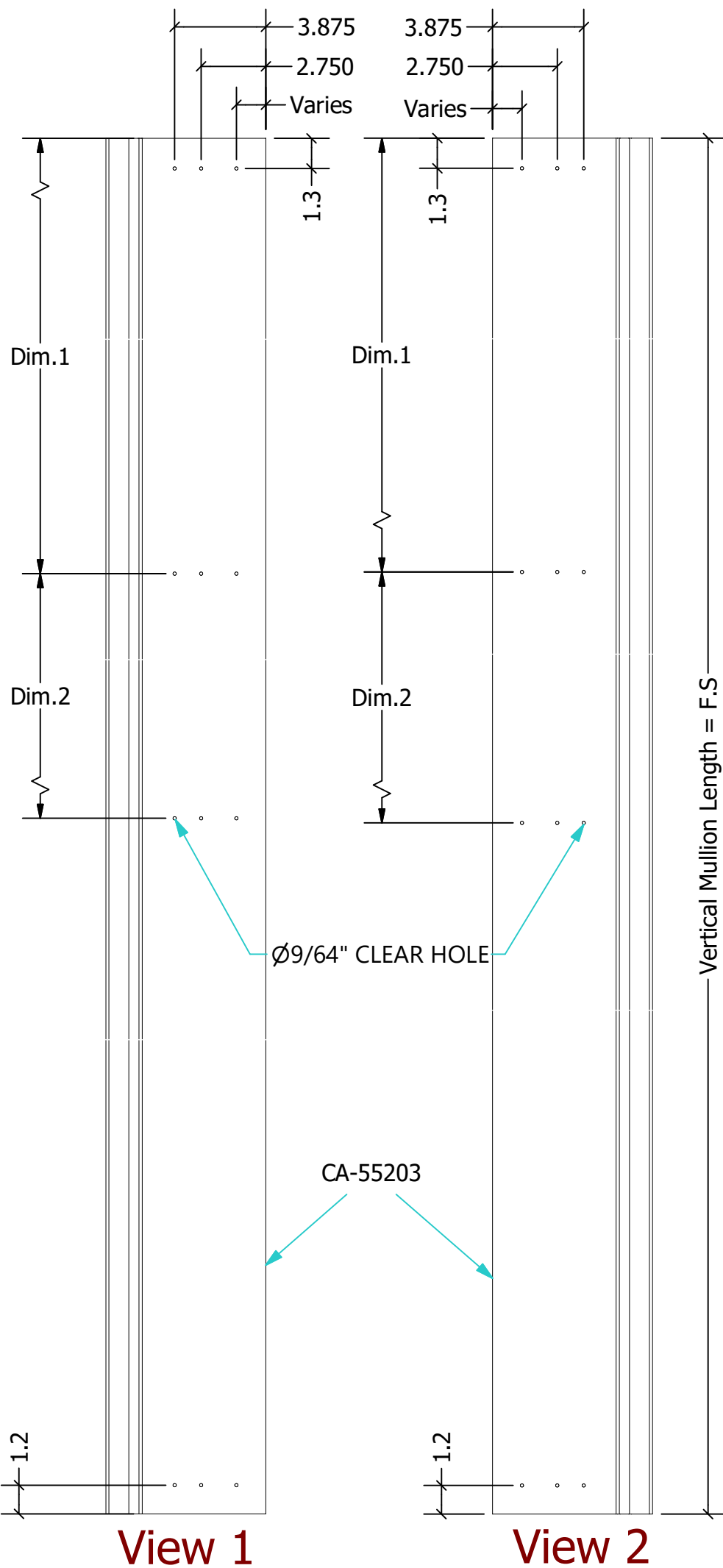
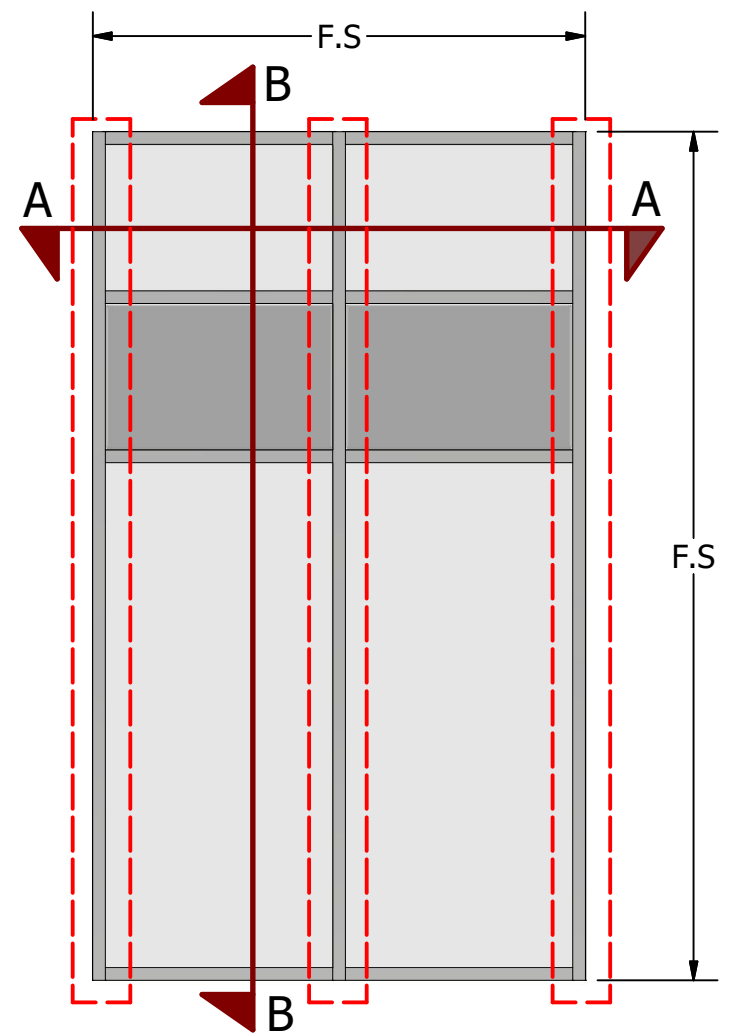
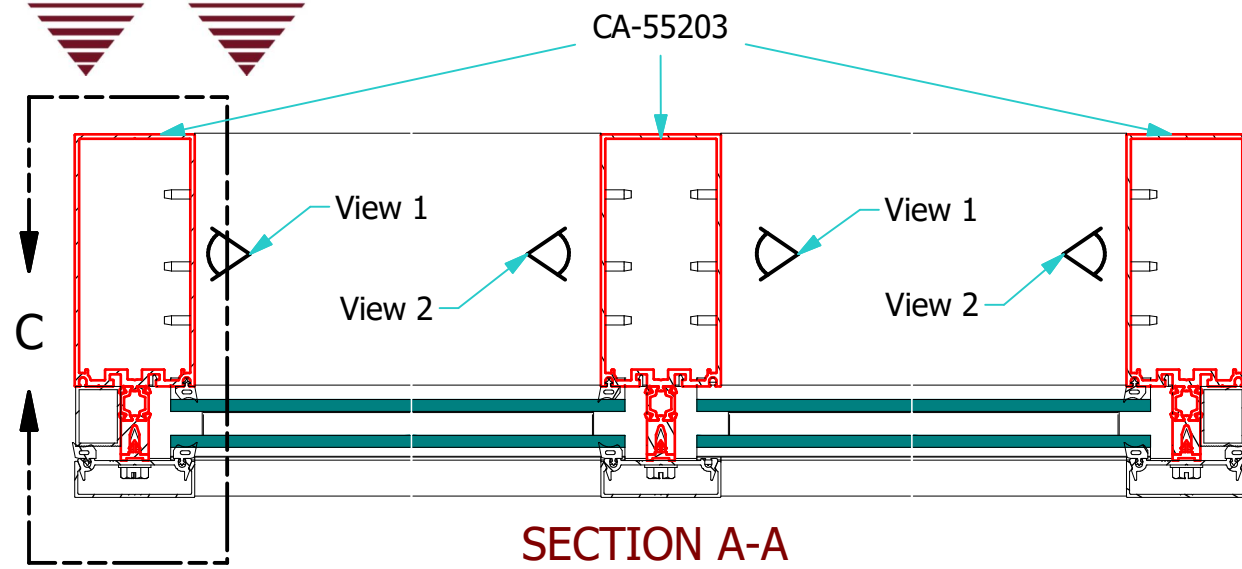
5500 HTP Series





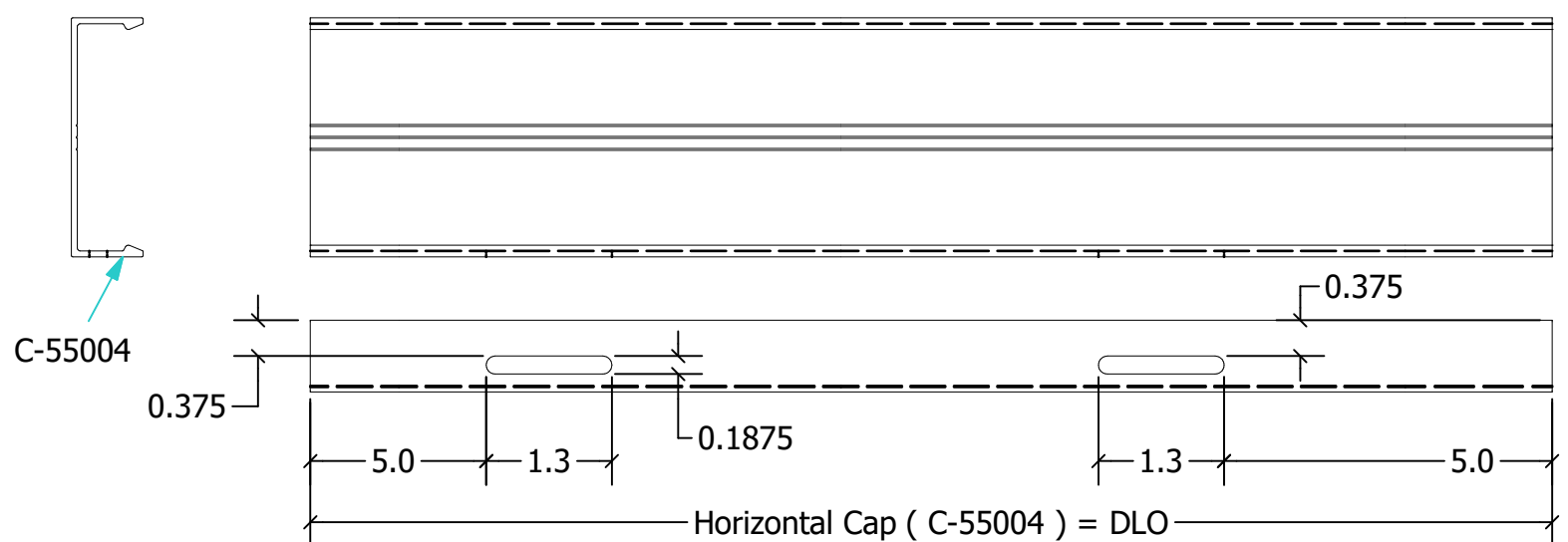
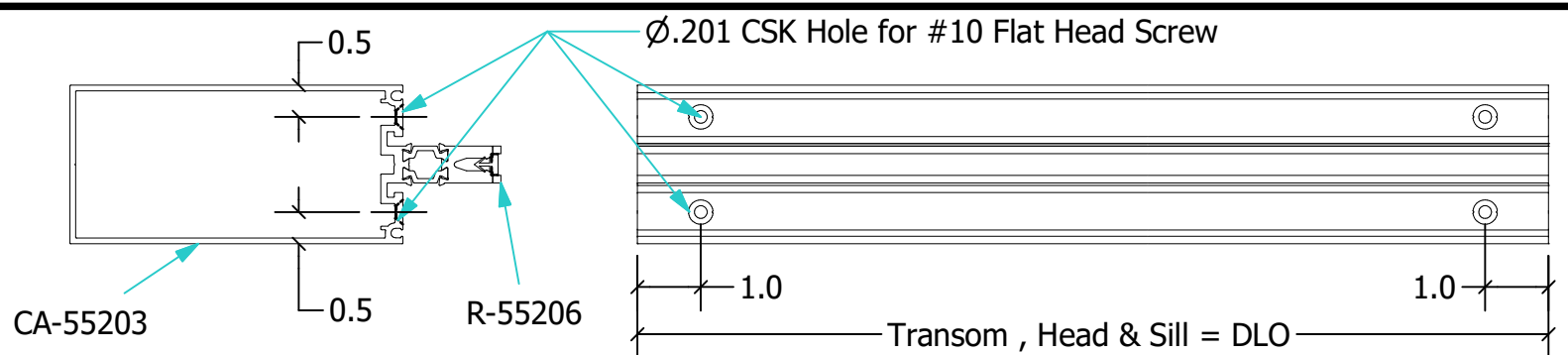
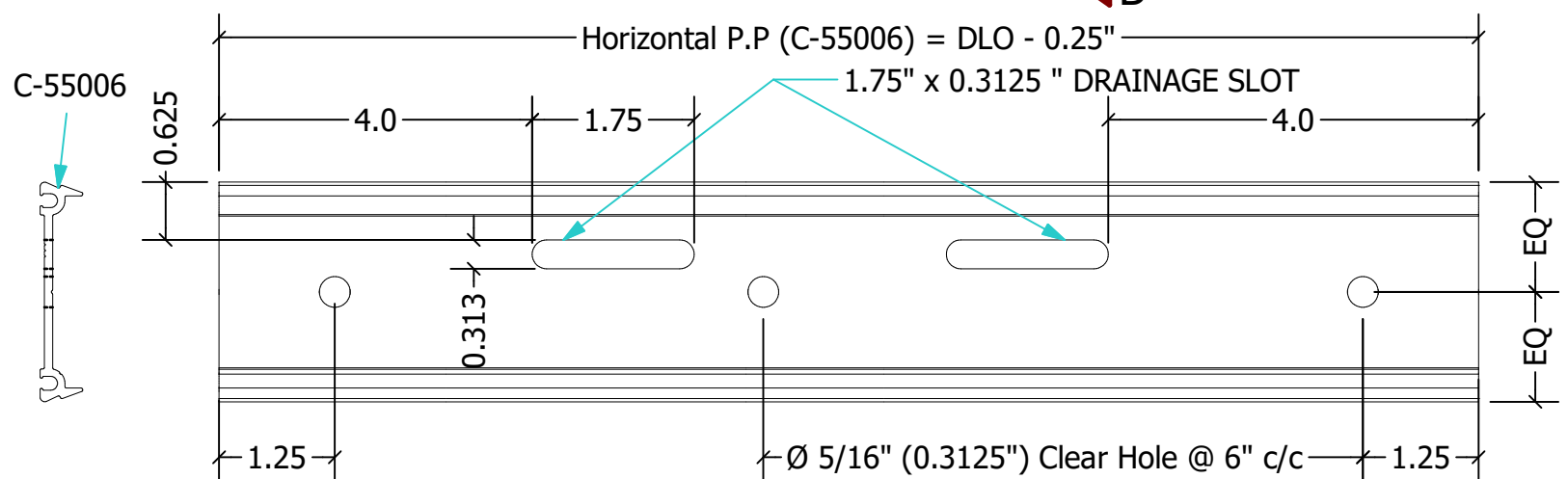
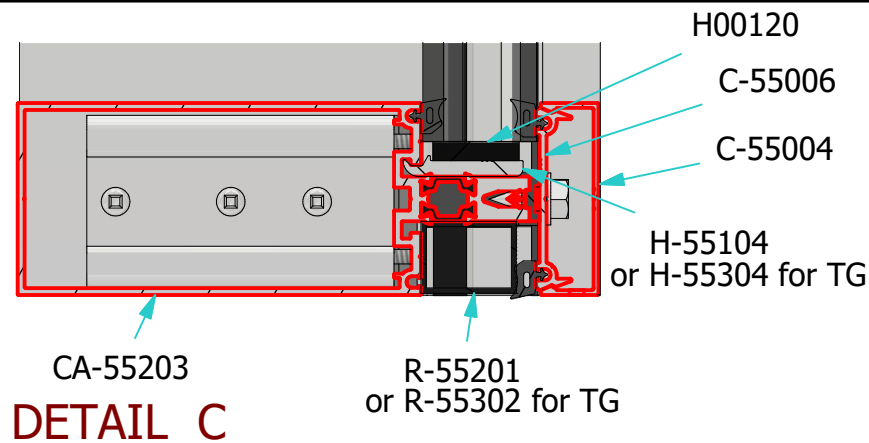
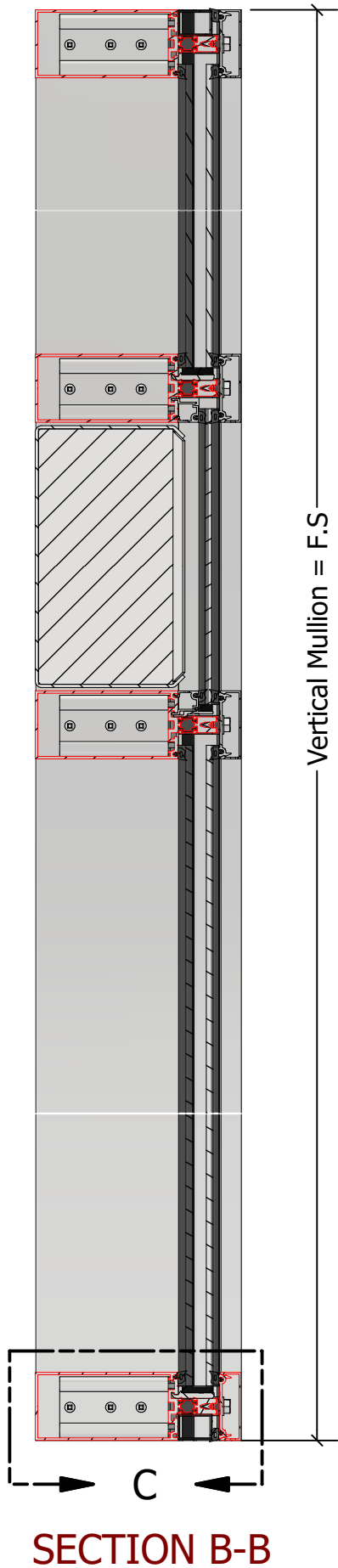
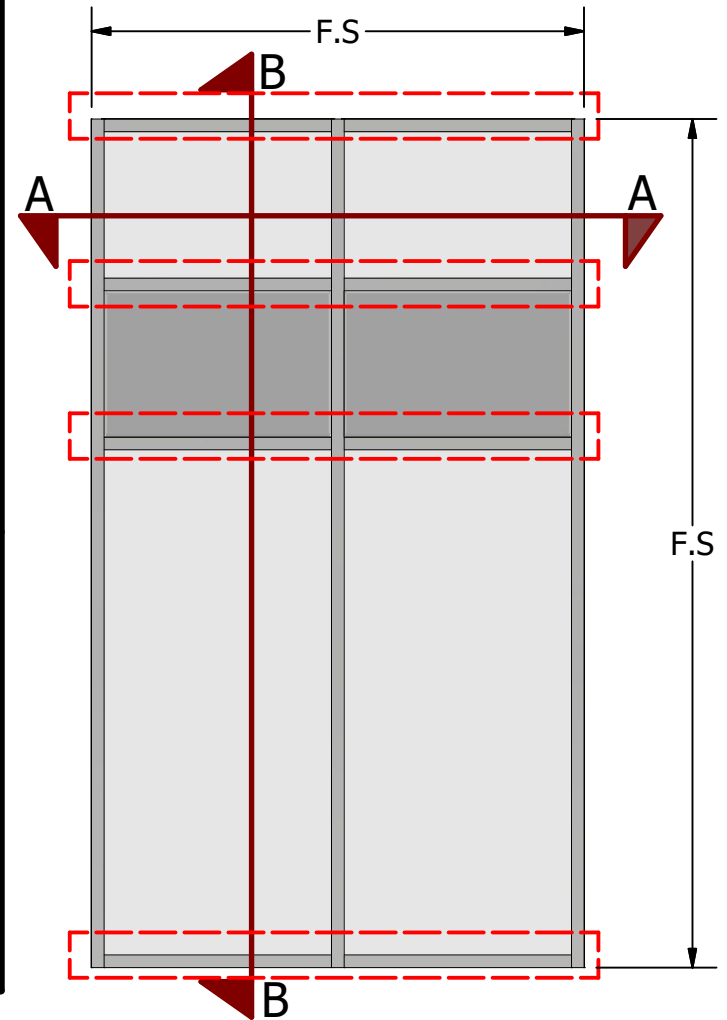
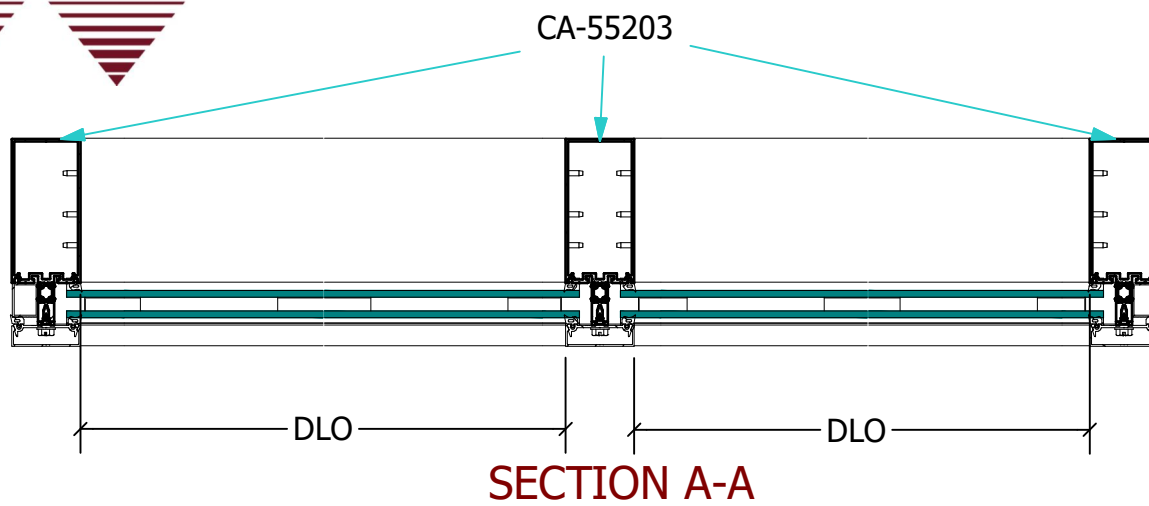
VERTICAL MULLIONS & PRESSURE PLATE

5500 HTP Series



Notes:

- R.O : Rough opening
- F.S : Frame size = R.O - 1"
- DLO : Daylight opening
- P.P : Pressure plate
- Vert. P.P Length = F.S - 0.25"
- Vert. Cap Length = F.S
- Vert. Mullion Length = F.S (CA-55203)
- Vert. Pocket Filler Length = F.S (R-55201)
- Dim.1 = DLO (1) + 3.75 "
- Dim.2 = DLO (2) + 2.5"

**Notes:**

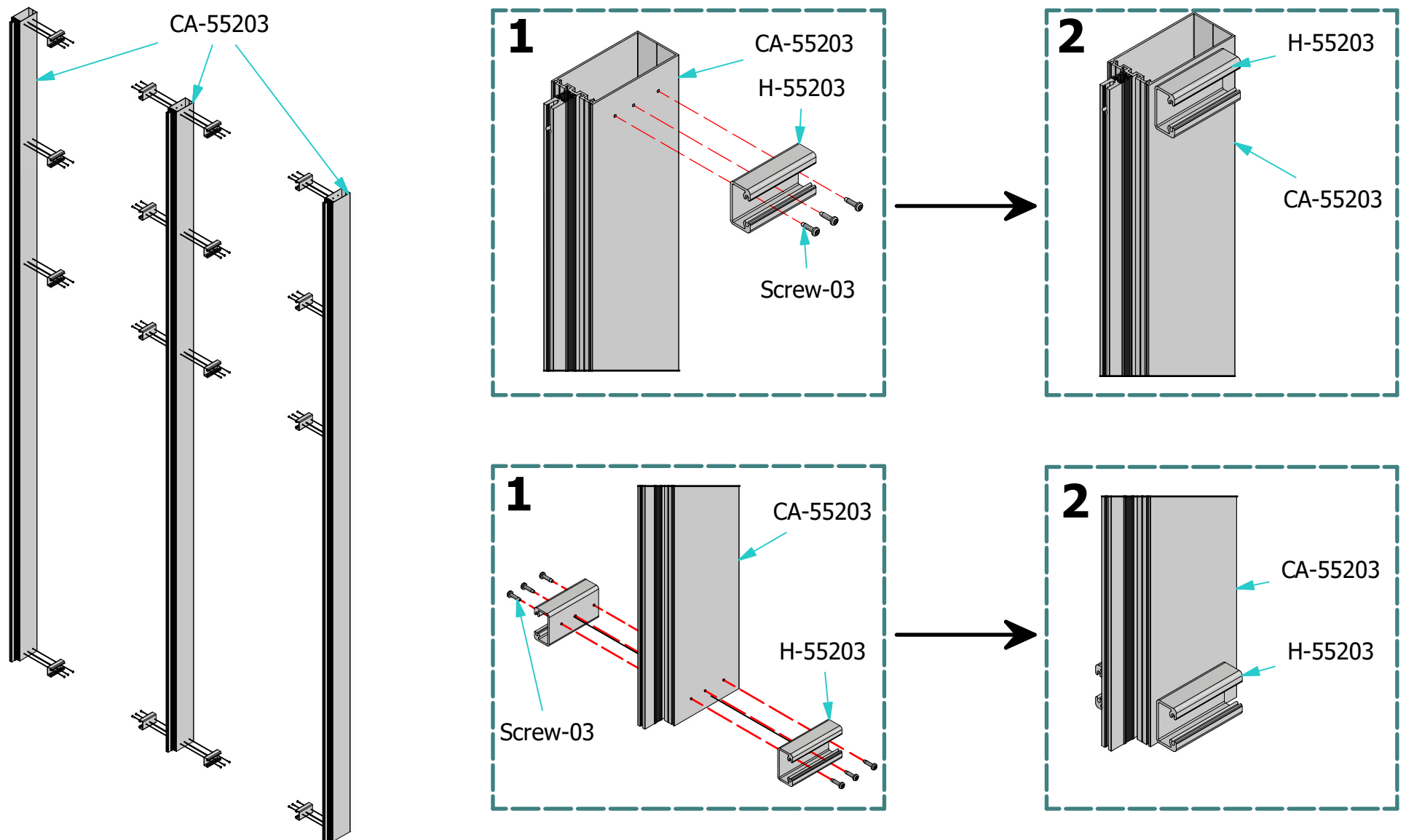
- R.O : Rough opening
- F.S : Frame size = R.O - 1"
- DLO : Daylight opening
- P.P : Pressure plate
- Horizontal P.P (C-55006) = DLO - 0.25"
- Horizontal Cap (C-55004) = DLO
- Transom , Head & Sill (CA-55203) = DLO
- Horizontal Pocket Filler (R-55201) = DLO + 1.9 "

A S S E M B L Y

S T E P S

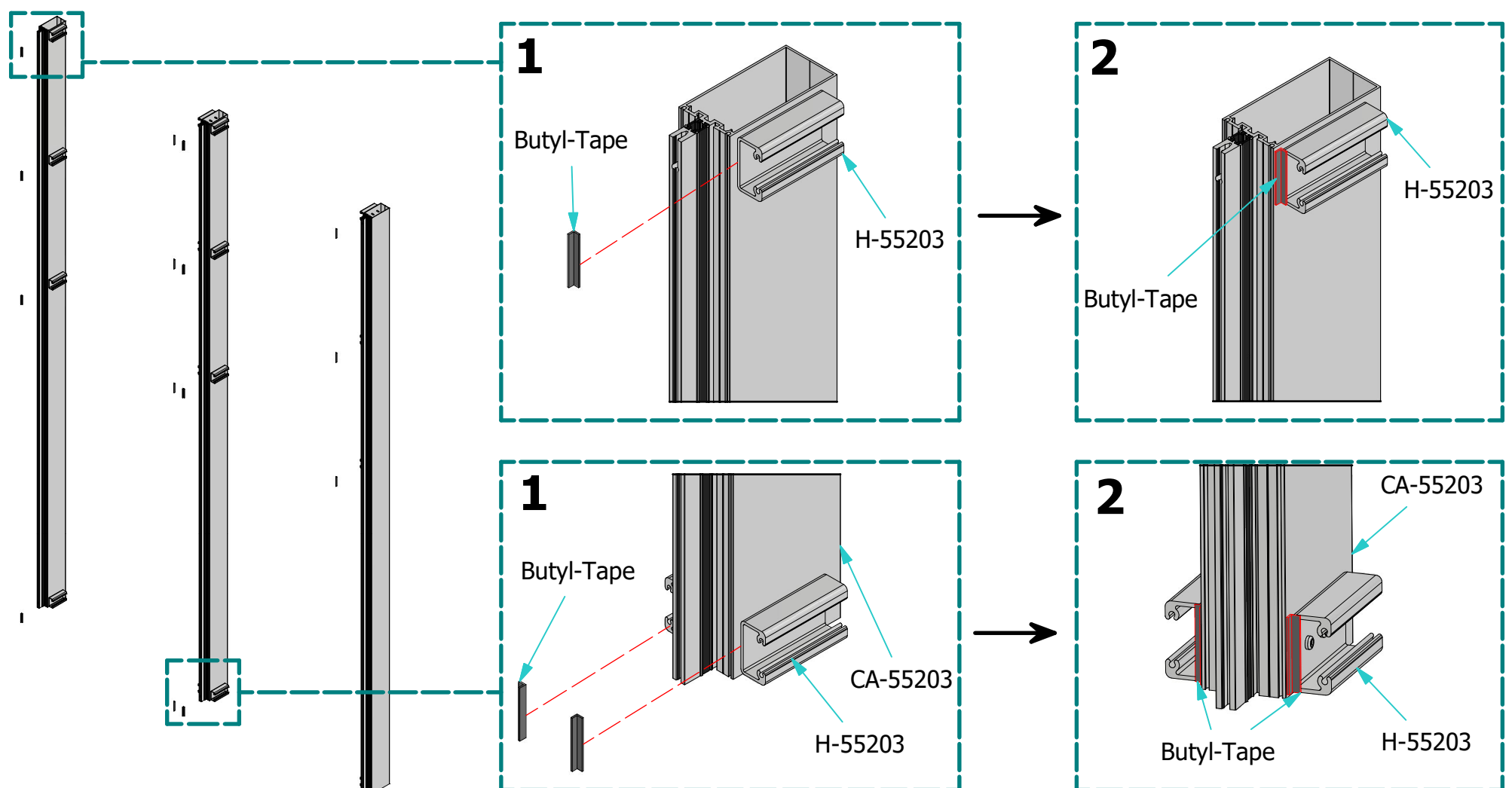
STEP 1 (Shear Block Installation):

Attach shear blocks (H-55203) to the mullions (CA-52203). Fasten using **#10 x 3/4" Quadrex Pan Head Screws (Screw-03)** through the Ø9/64" pre-drilled holes, as illustrated below.



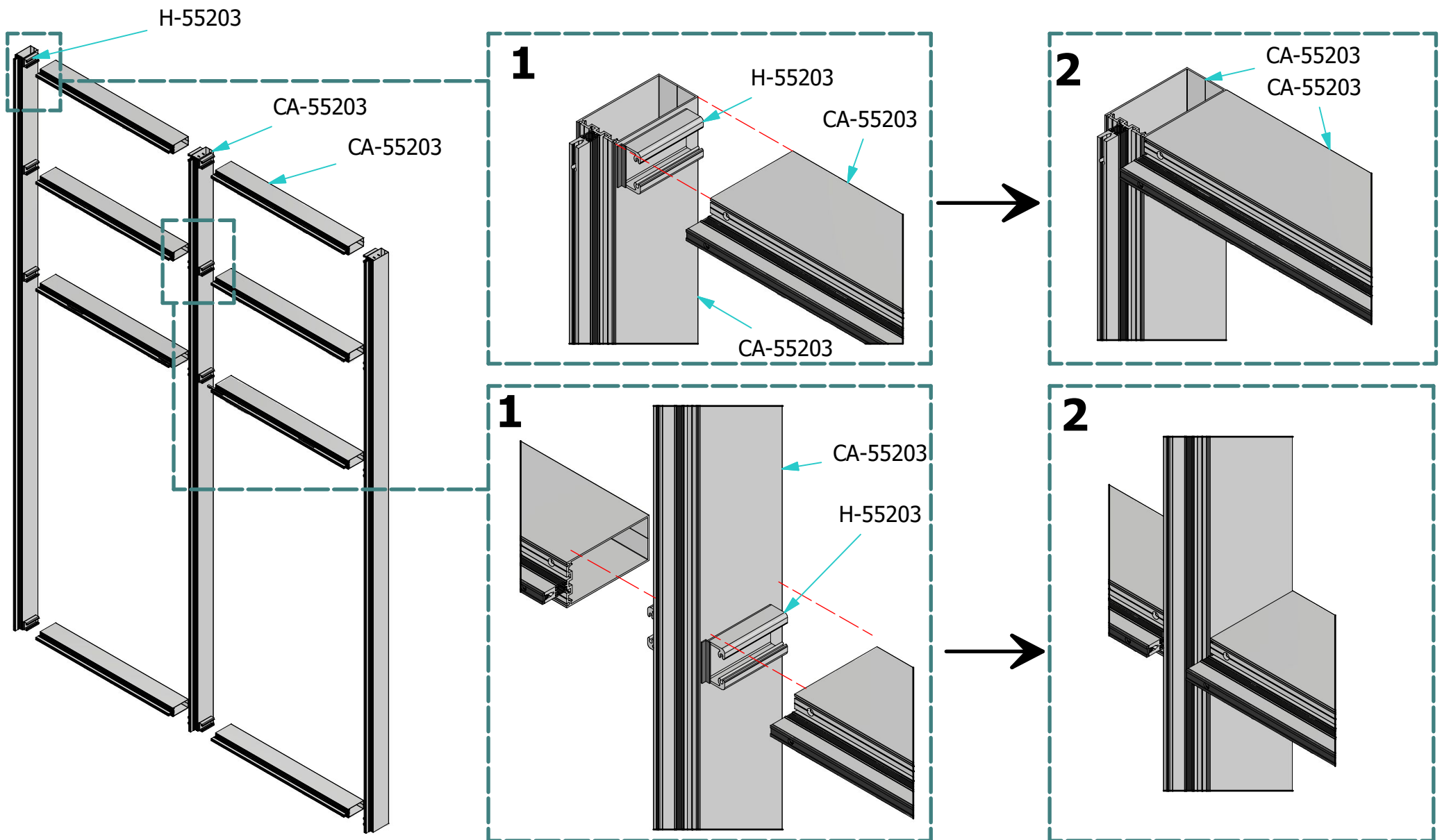
STEP 2 (Butyl Tape):

Apply a $\frac{1}{16}$ " thick butyl tape to each shear block (H-55203) on the exterior-facing side, as shown below.

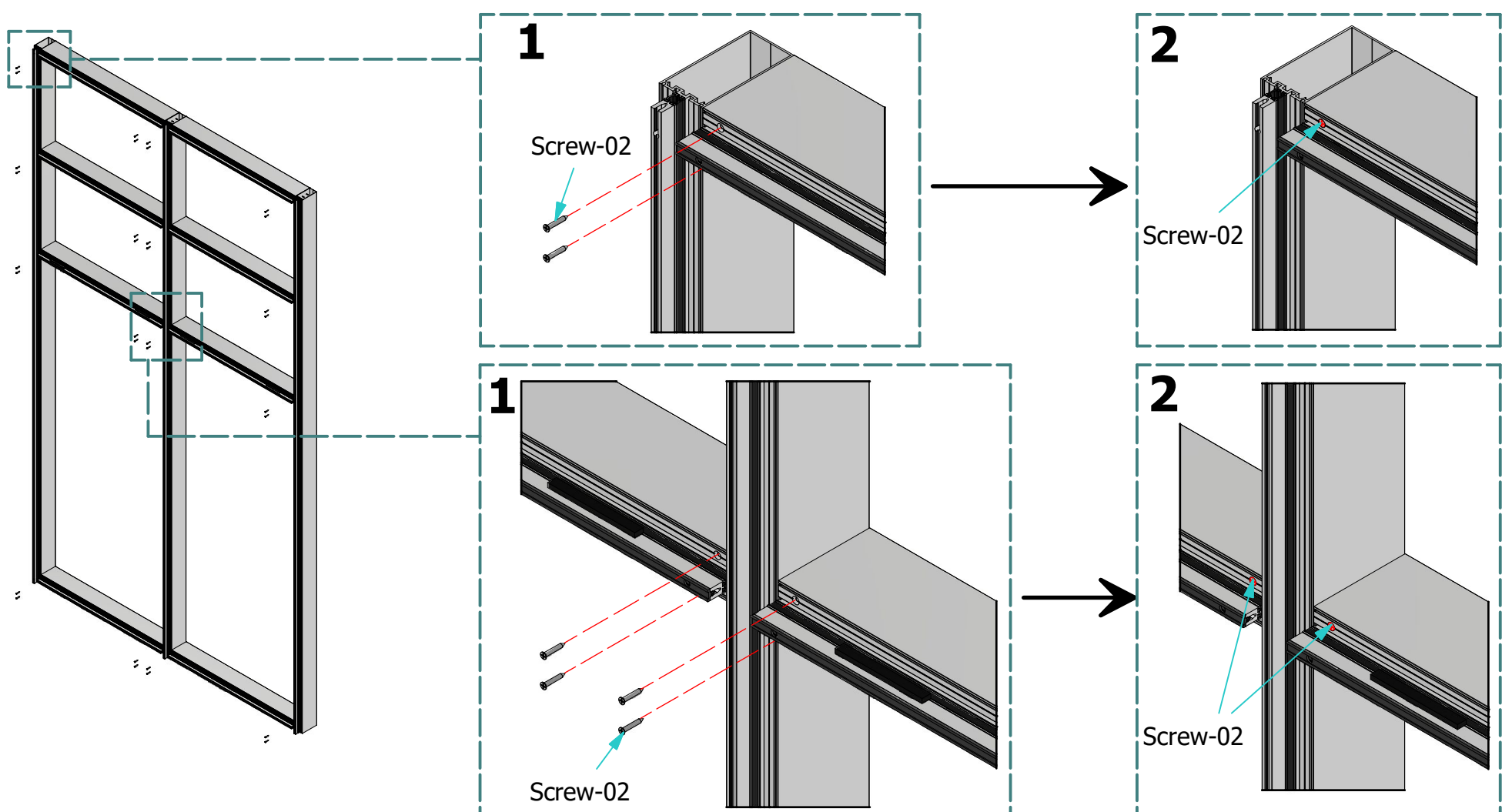


STEP 3 (Horizontal Installation):

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.

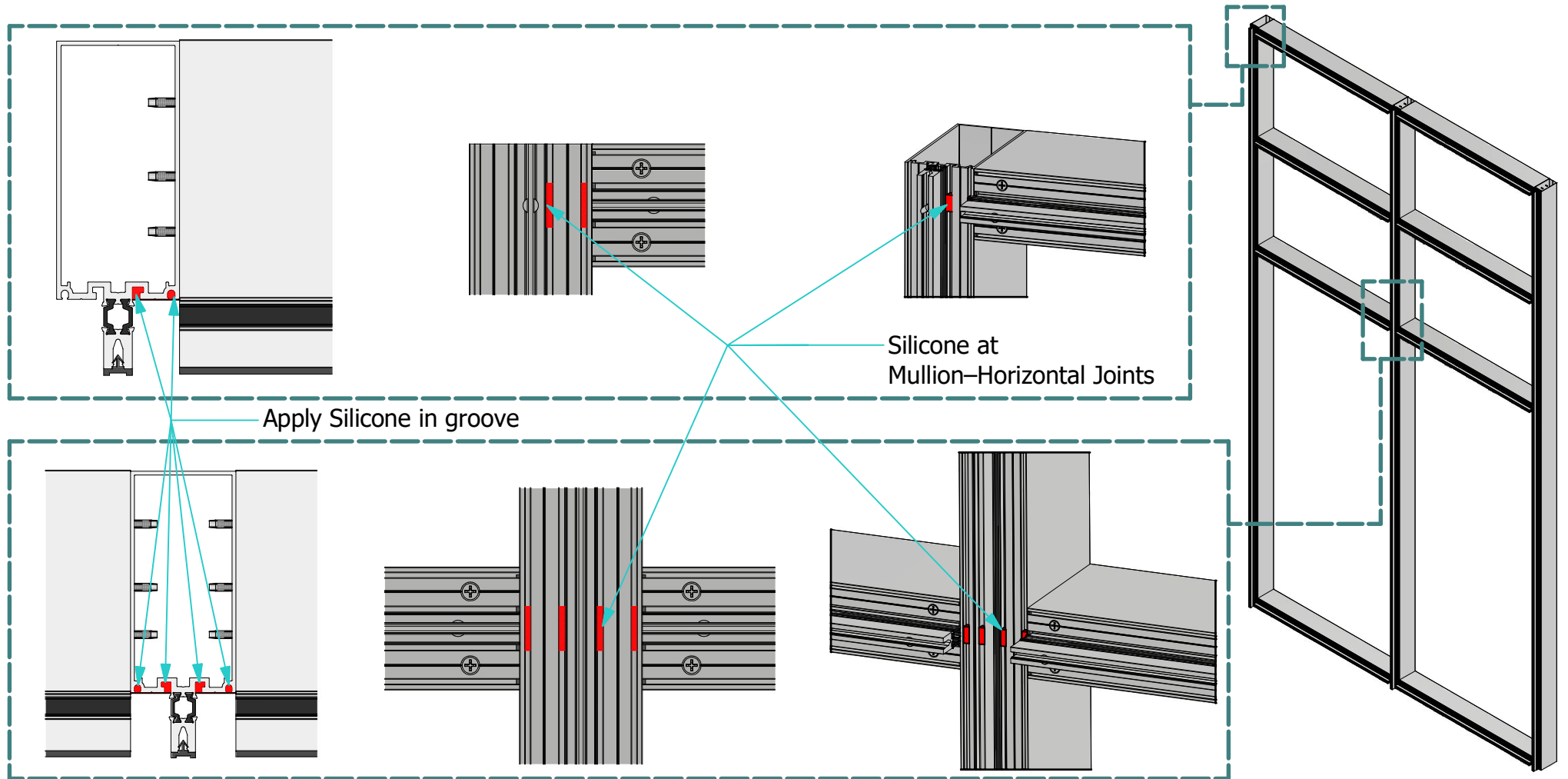


2) - Fasten the horizontals to the shear blocks using #10 x 1-1/4" Flat Head Socket Screw (Screw-02) through the Ø0.201" CSK pre-drilled holes, as illustrated below



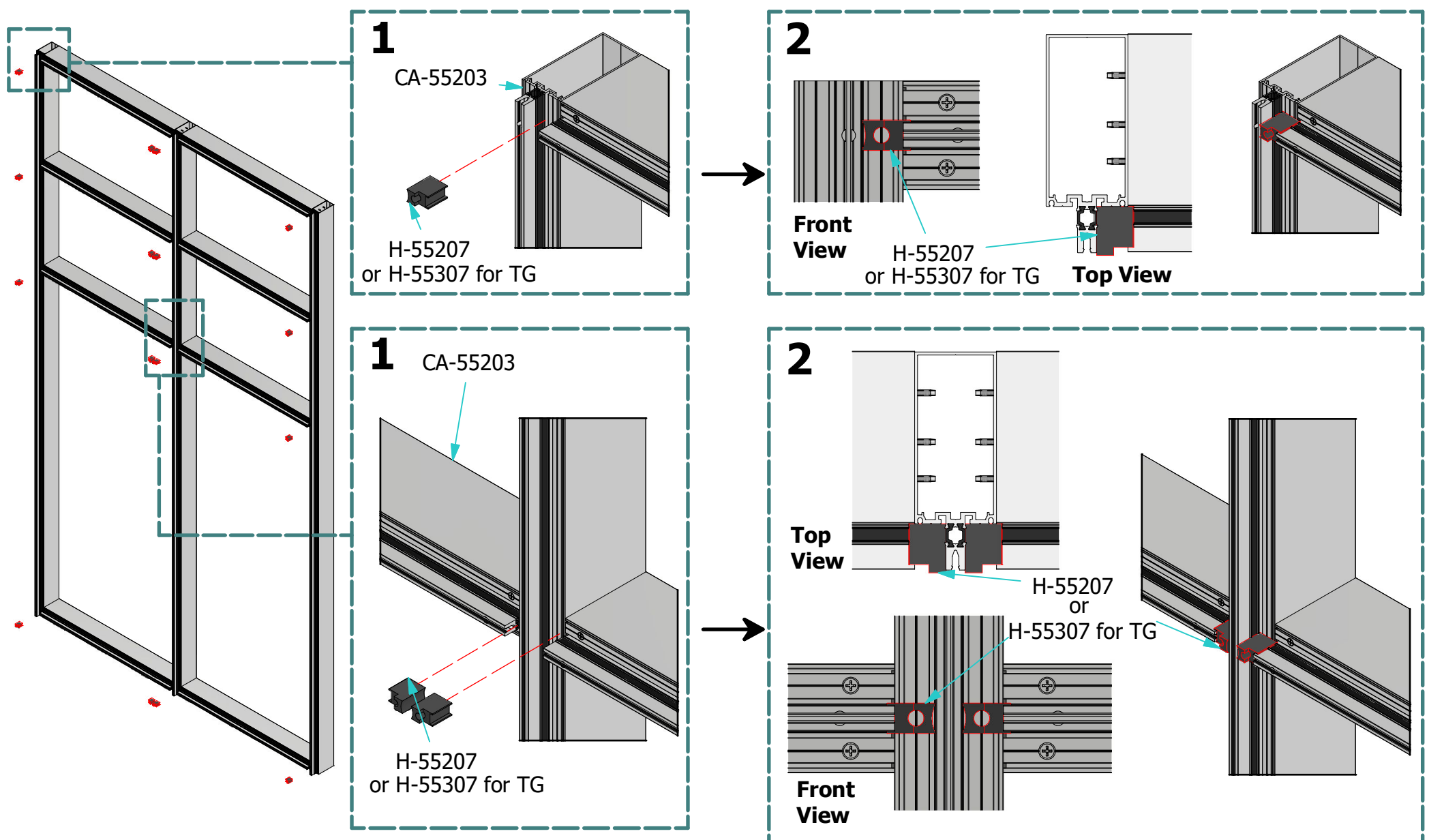
STEP 4 (Corner Plug Area Sealing):

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):

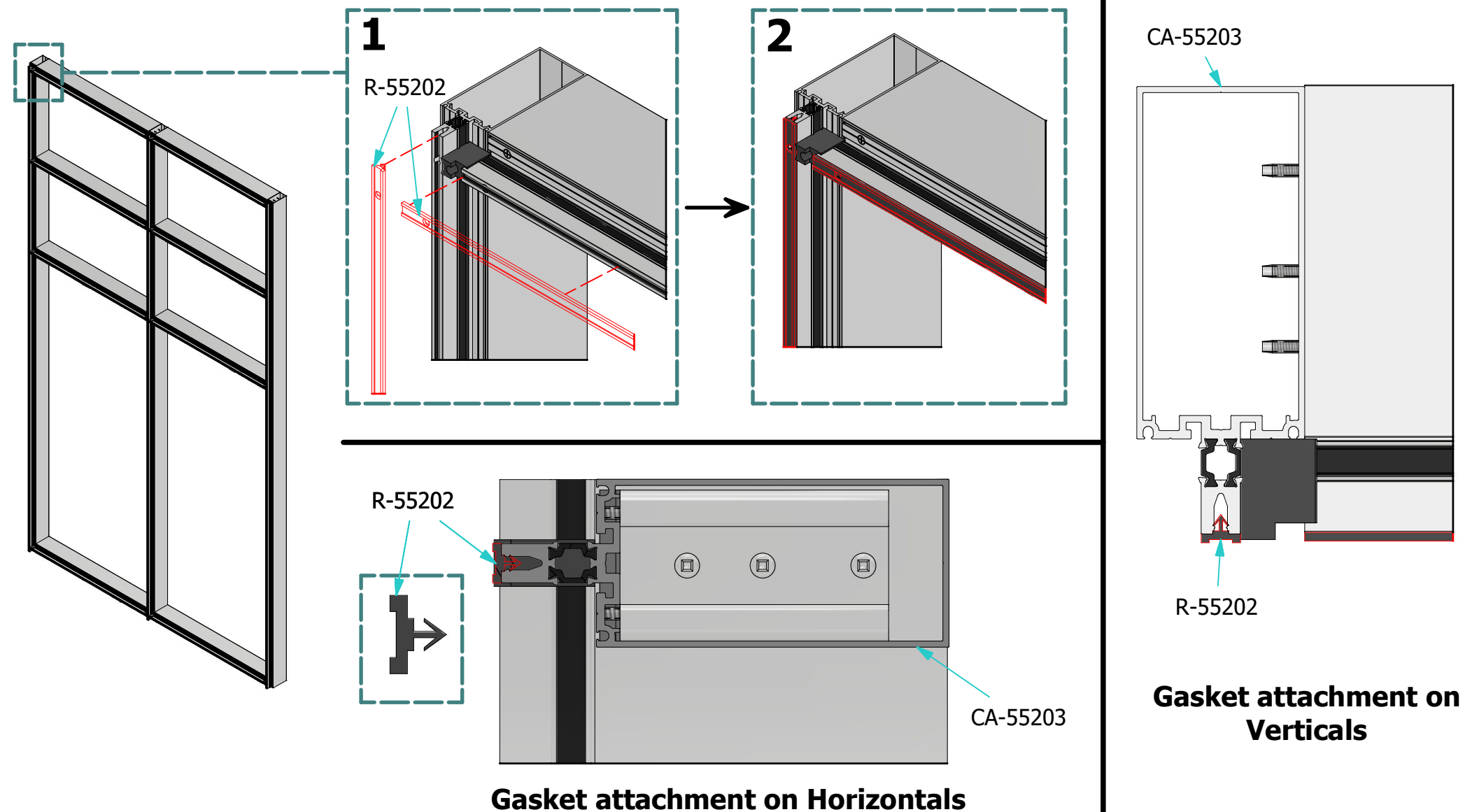
Insert the corner plugs (H-55207) or (H-55307 for TG) **at each frame connection**, ensuring the notched side faces inward toward the DLO and the back is fully seated against the exterior mullion face, as shown below.





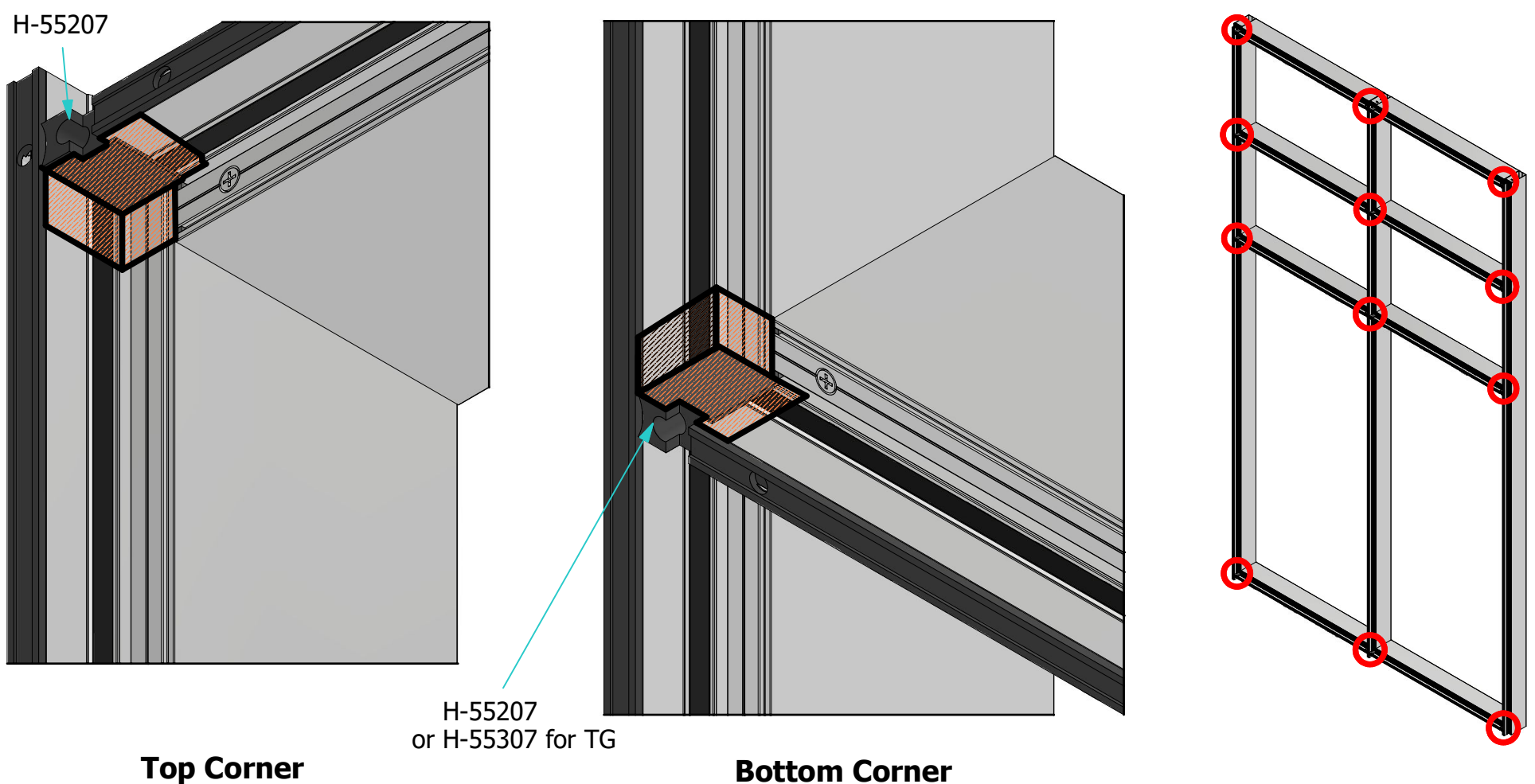
STEP 6 (Thermal Break Flexible PVC Installation):

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



STEP 7 (Corner Plug Caulking):

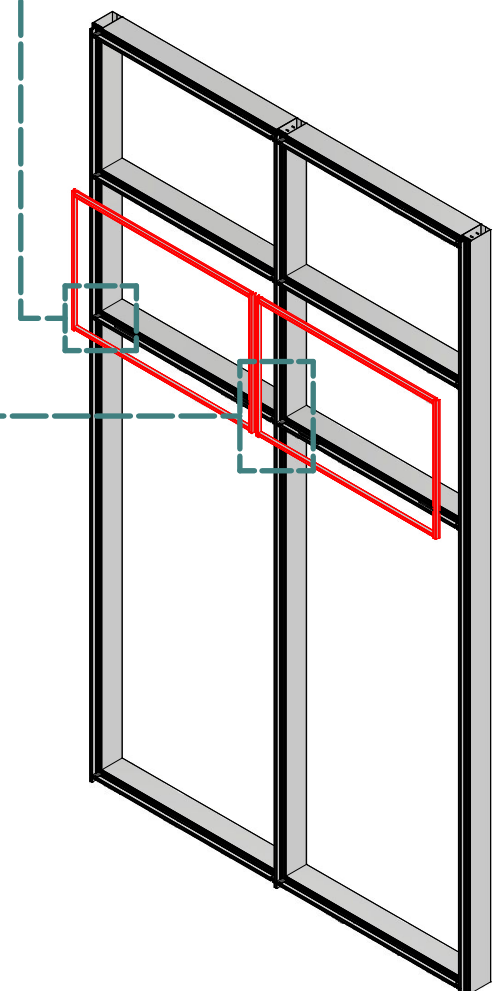
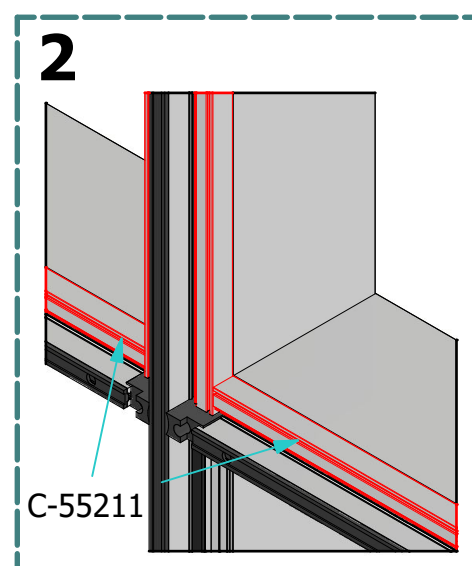
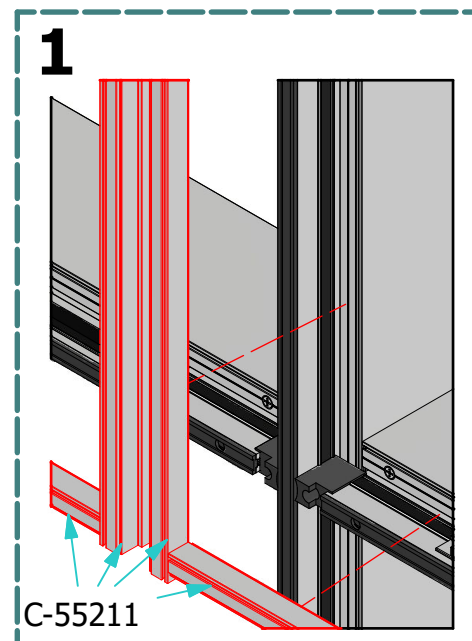
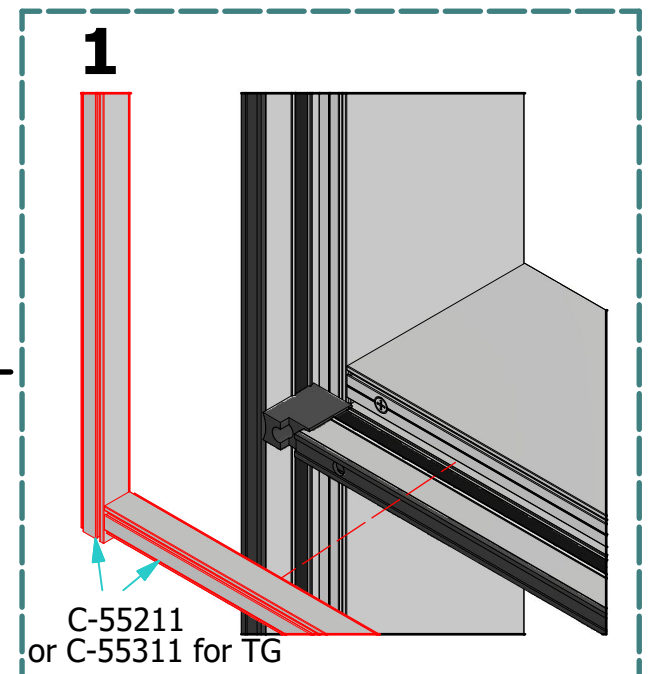
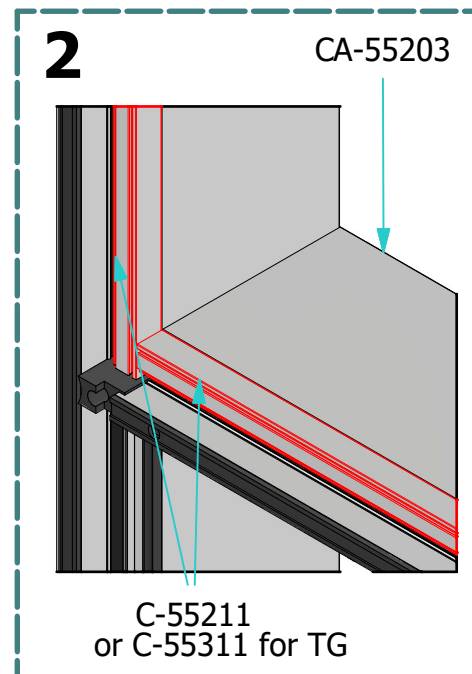
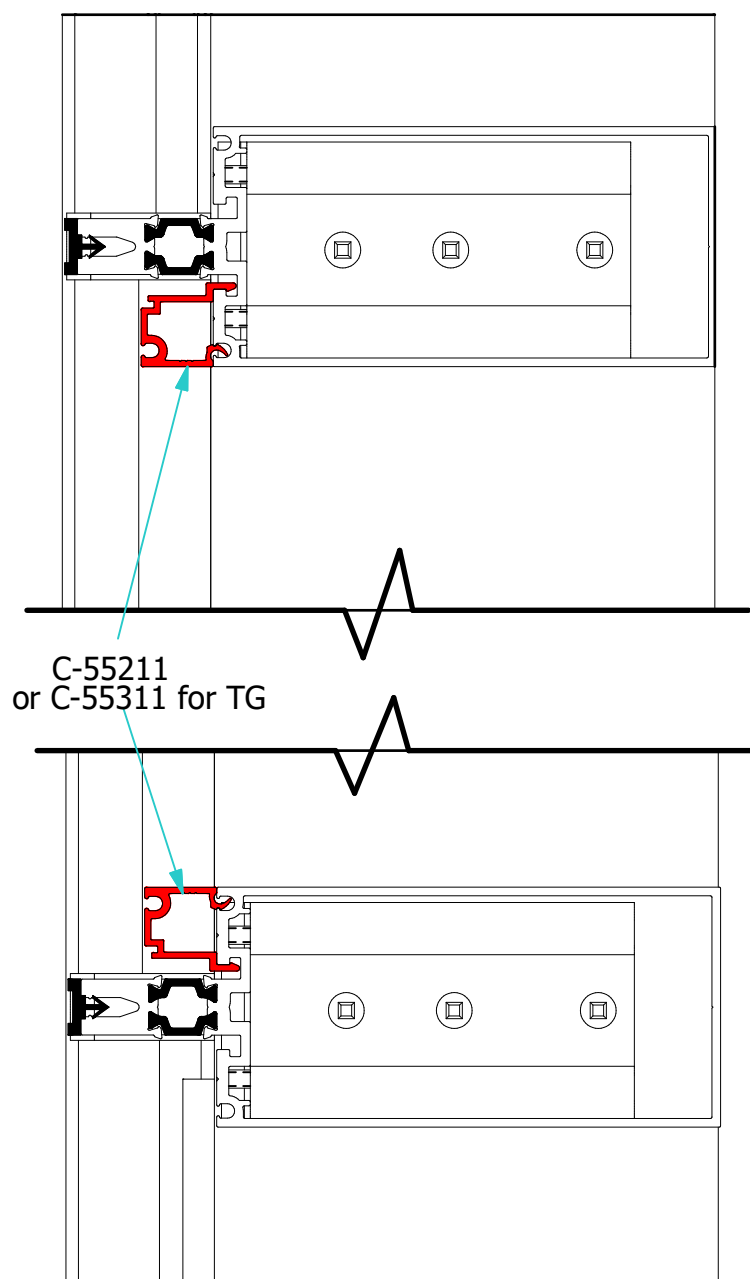
Caulk all corner plugs (**H-55207**) or (**H-55307**) with silicone, ensuring full coverage for a watertight seal, as shown below.



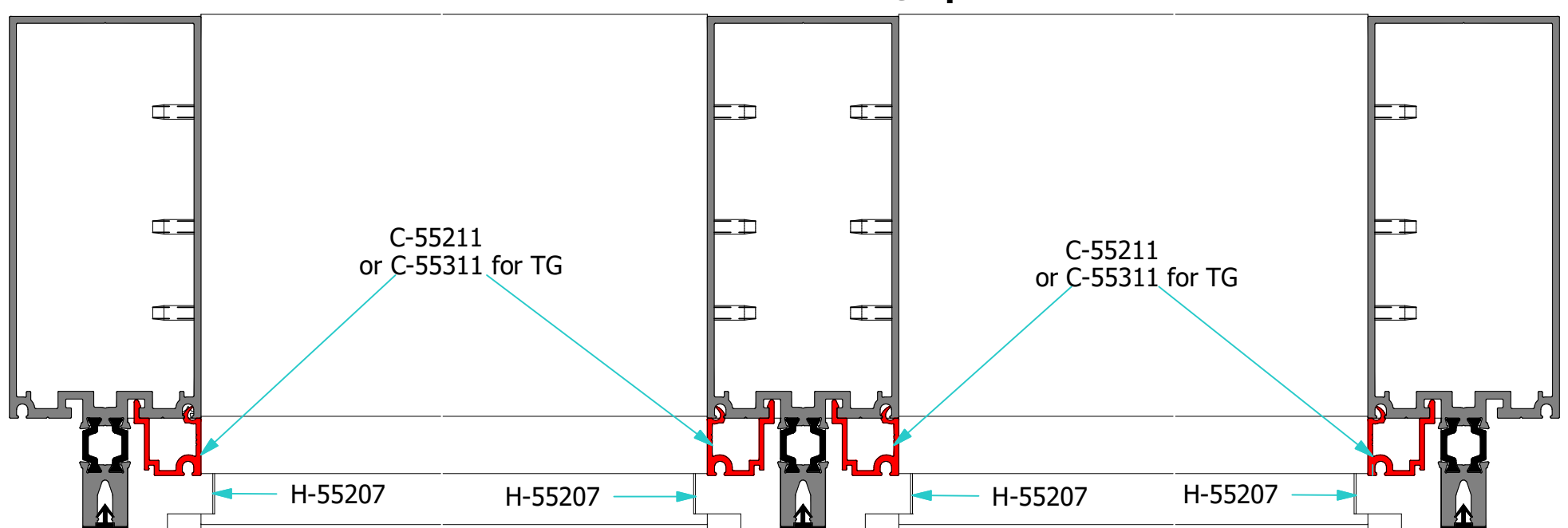
STEP 8: (If Applicable) (Spandrel Adapter Installation)

- Install the spandrel adapter (C-55211) or (C-55311 for TG) 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

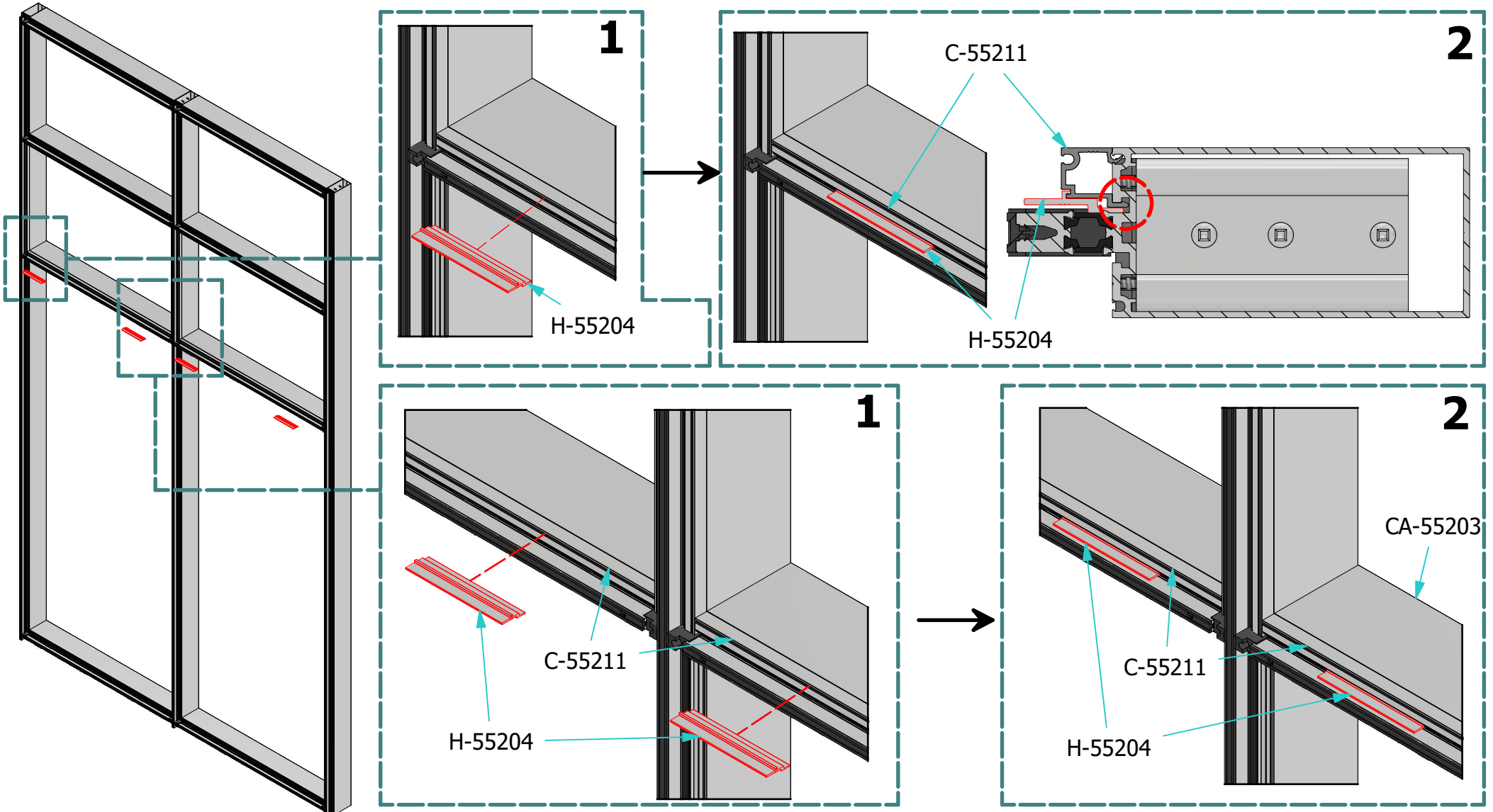


STEP 9 (If Applicable)

Support Tab Installation (Spandrel):

- Snap the support tab (**H-55204**) 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**

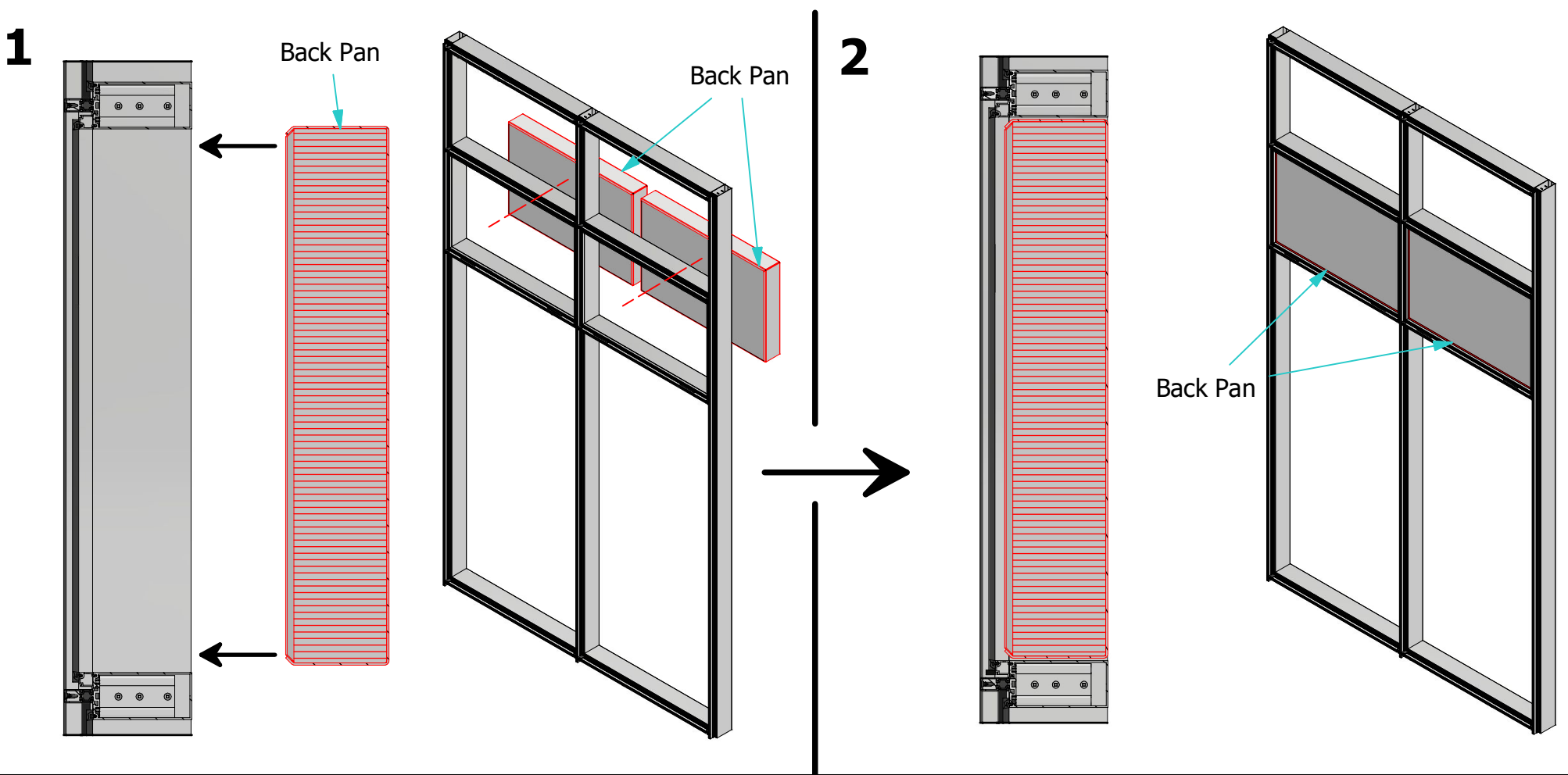


STEP 10 (If Applicable)

Back Pan Installation:

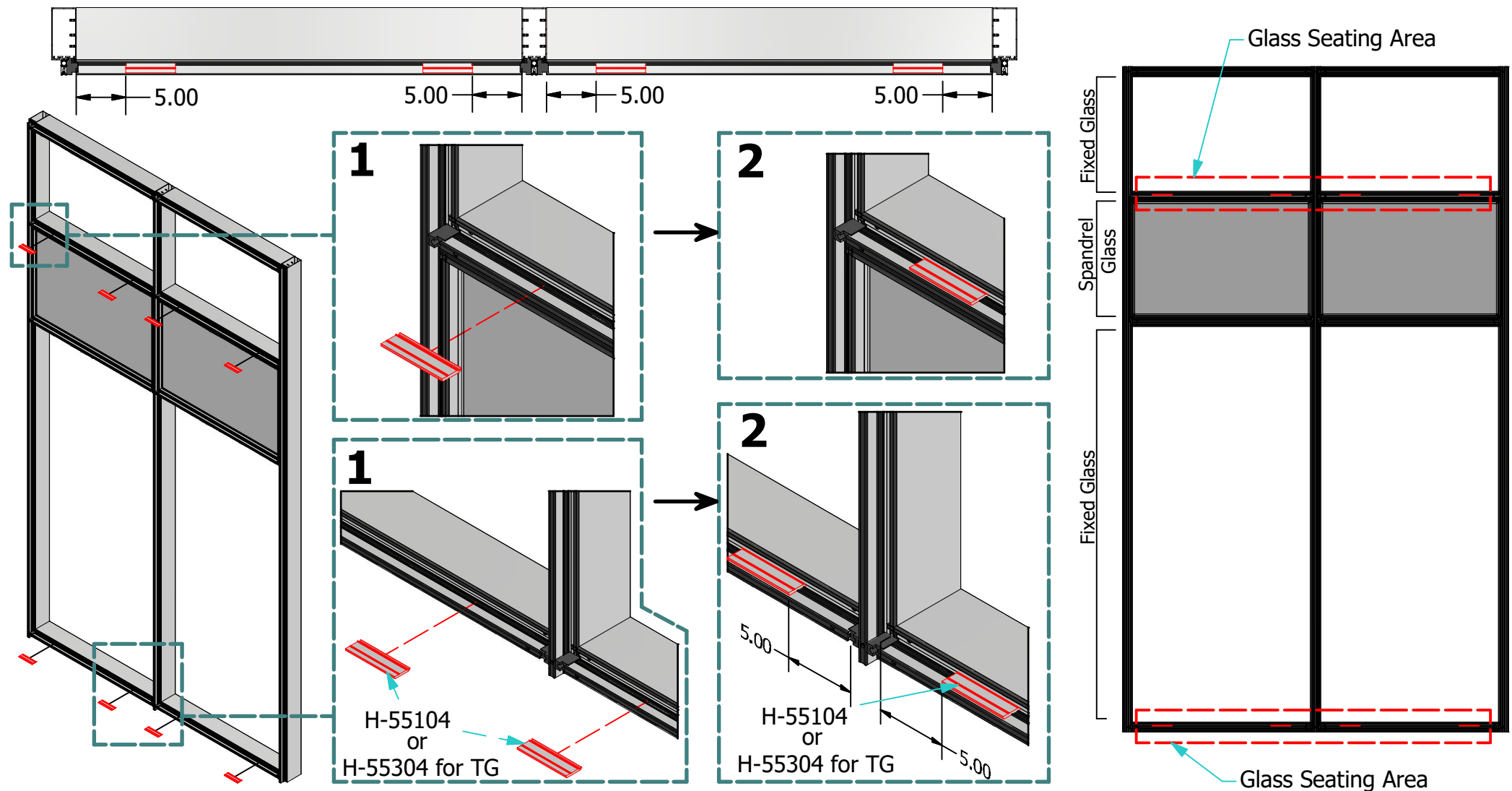
- Install the Back Pan into the spandrel opening, ensuring its back face is flush with the back faces of the mullions and transoms, as shown below.

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



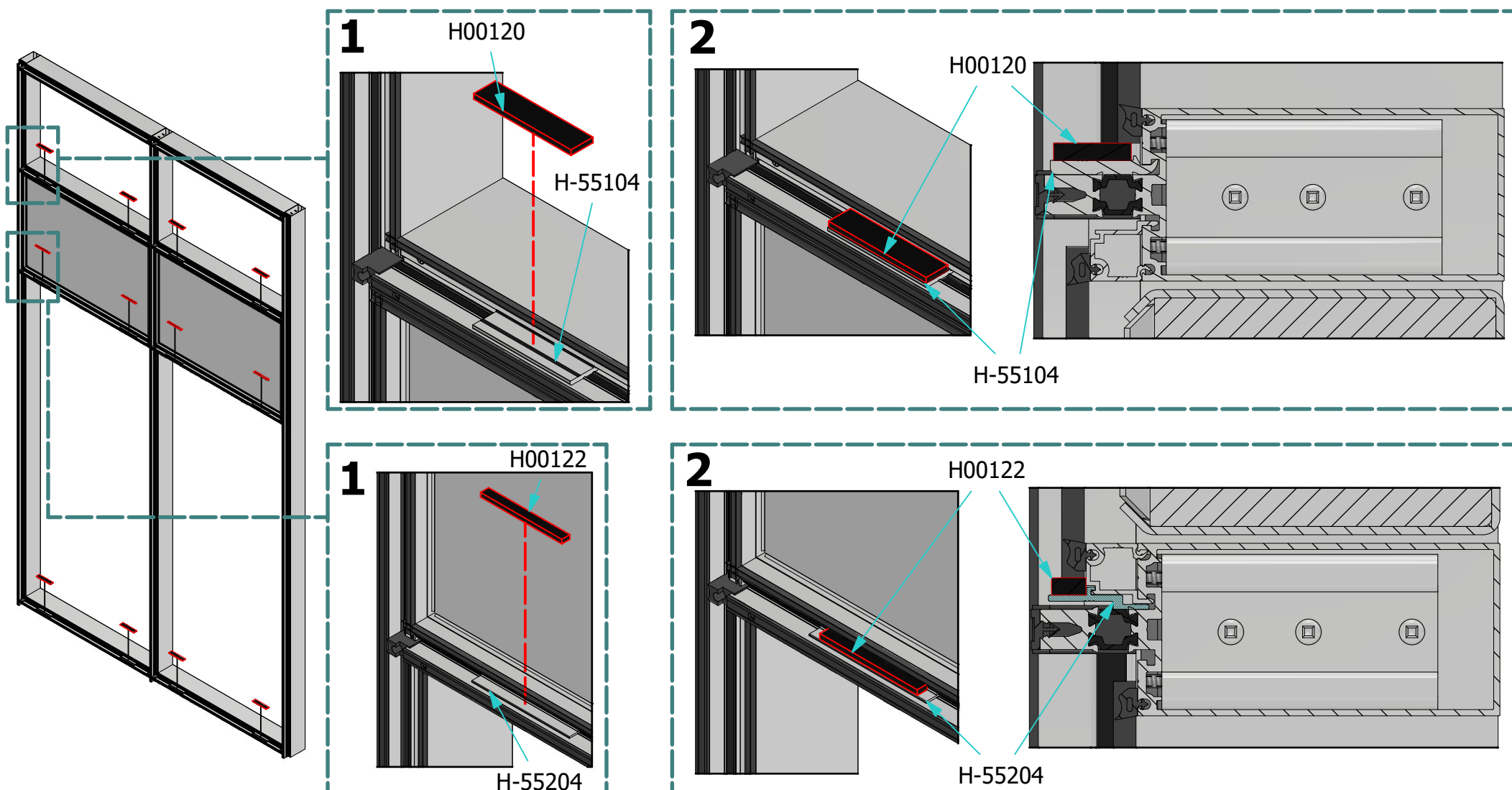
STEP 11 (Glazing Support Tab Insertion):

- Insert the glazing support tab (**H-55104**) or (**H-55304 for TG**) 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):

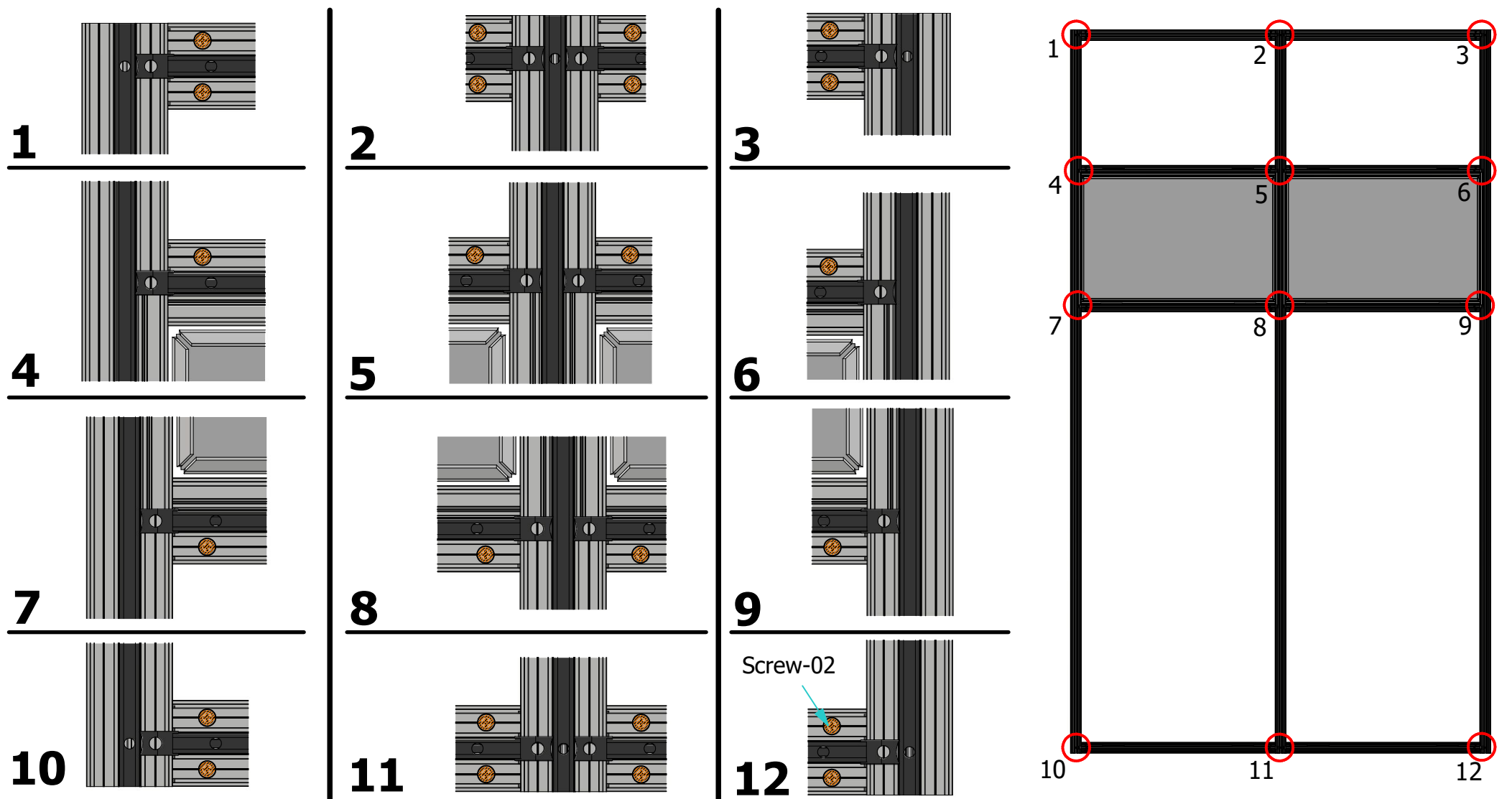
- Place the setting block (**H00120**) for **fixed glass** on top of the glazing support tabs (**H-55003**). For **spandrel glass**, place the setting block (**H00122**) on top of the glazing support tabs (**H-55293**), as shown below.
- **NOTE** :Perform the spandrel step only if spandrel glass is included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





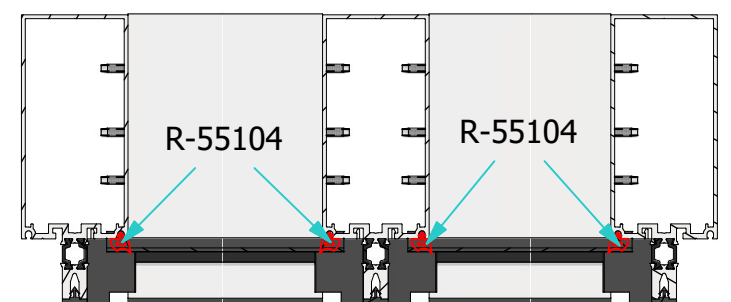
STEP 13 (Shear Block Screw Sealing):

- 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.

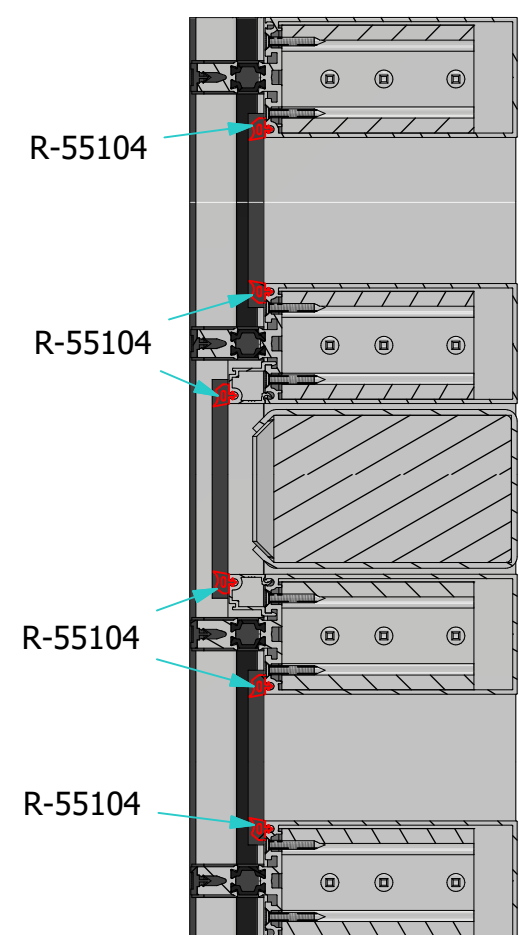
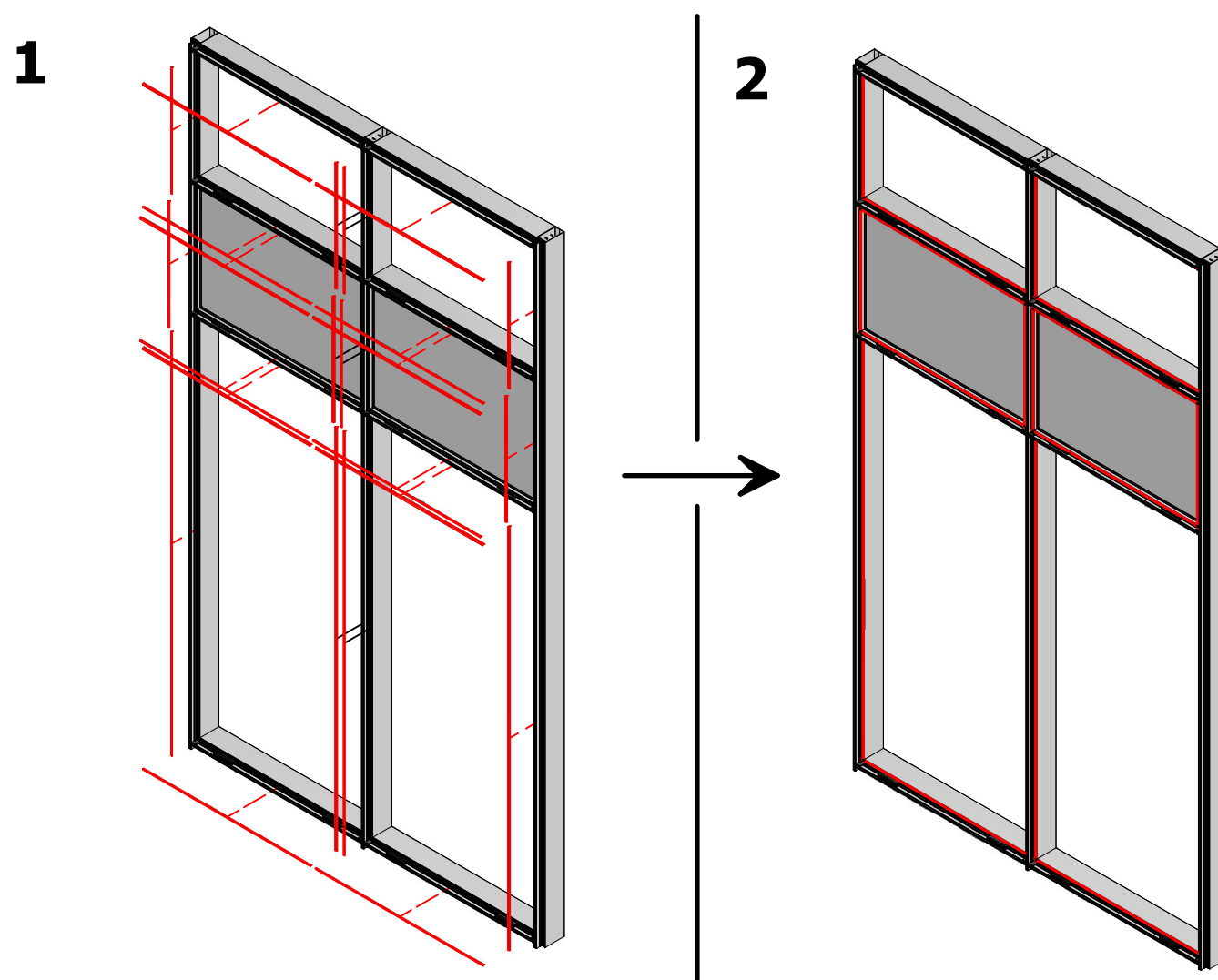


STEP 14 (Interior Gasket Installation):

- 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

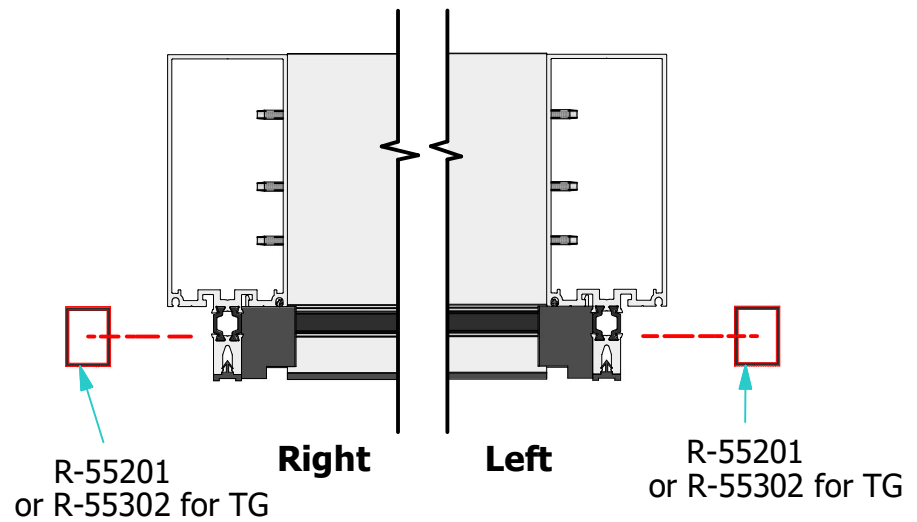
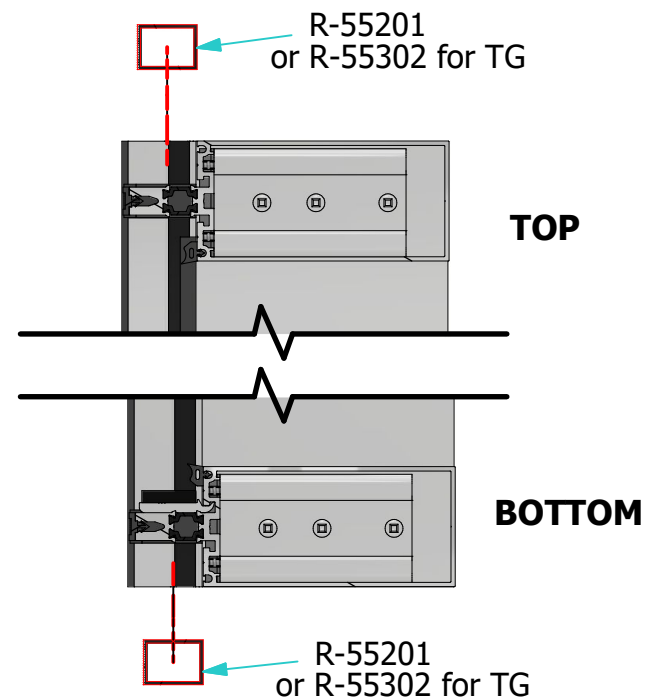
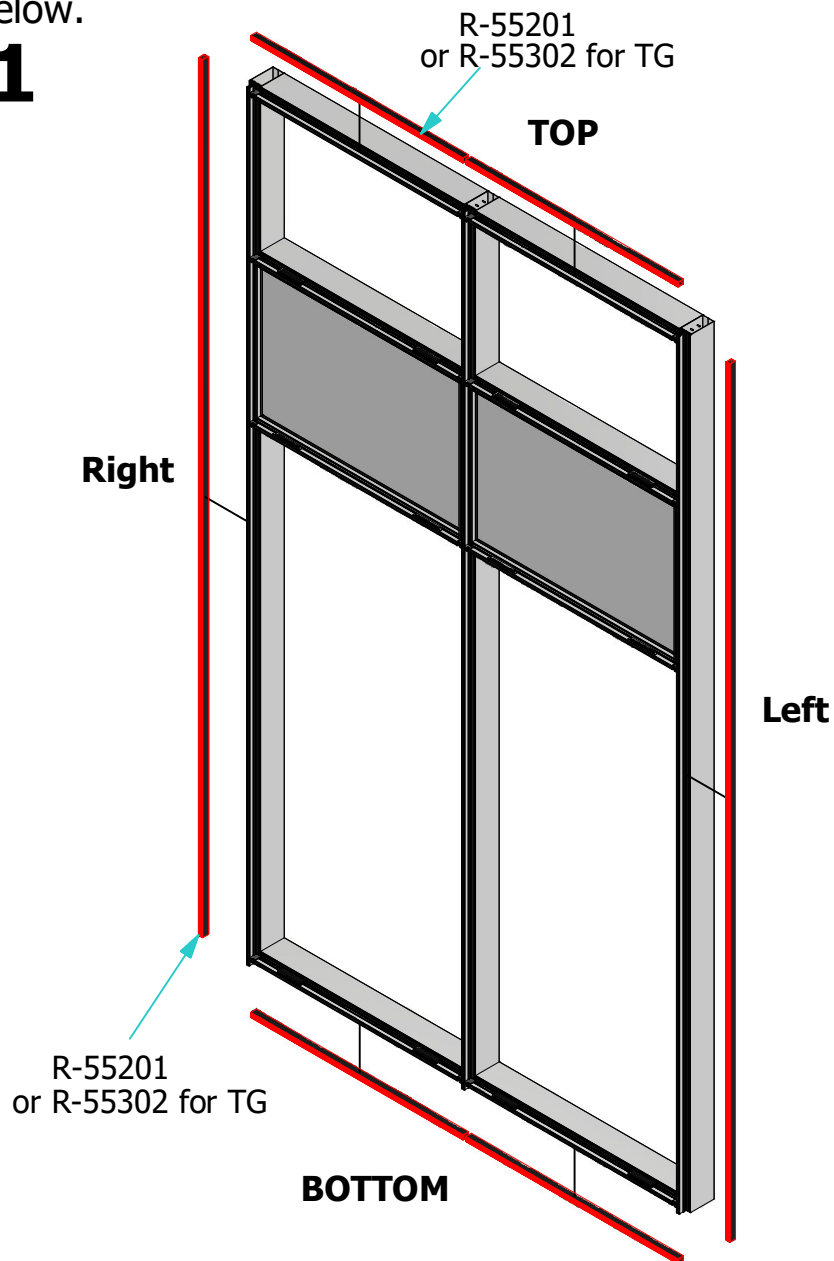


Vertical Section

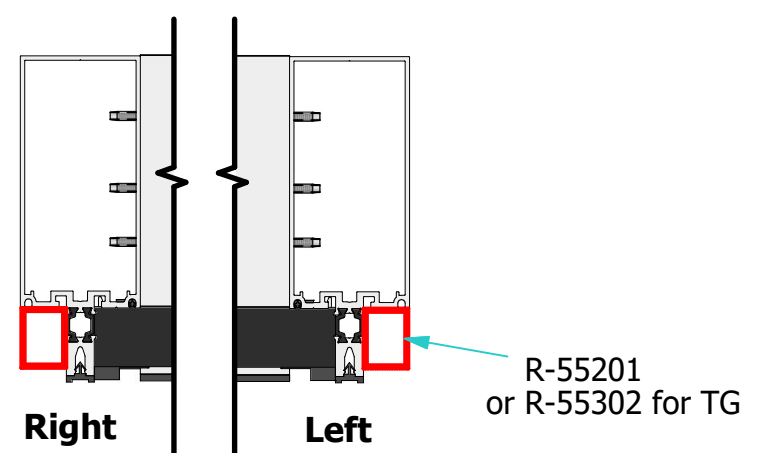
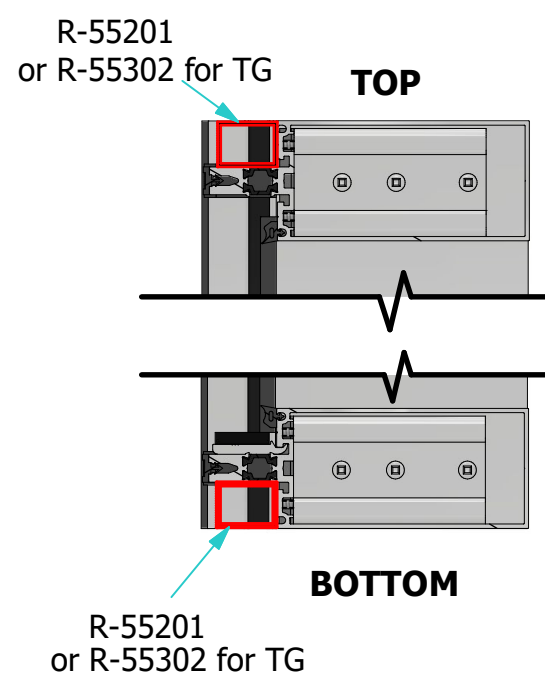
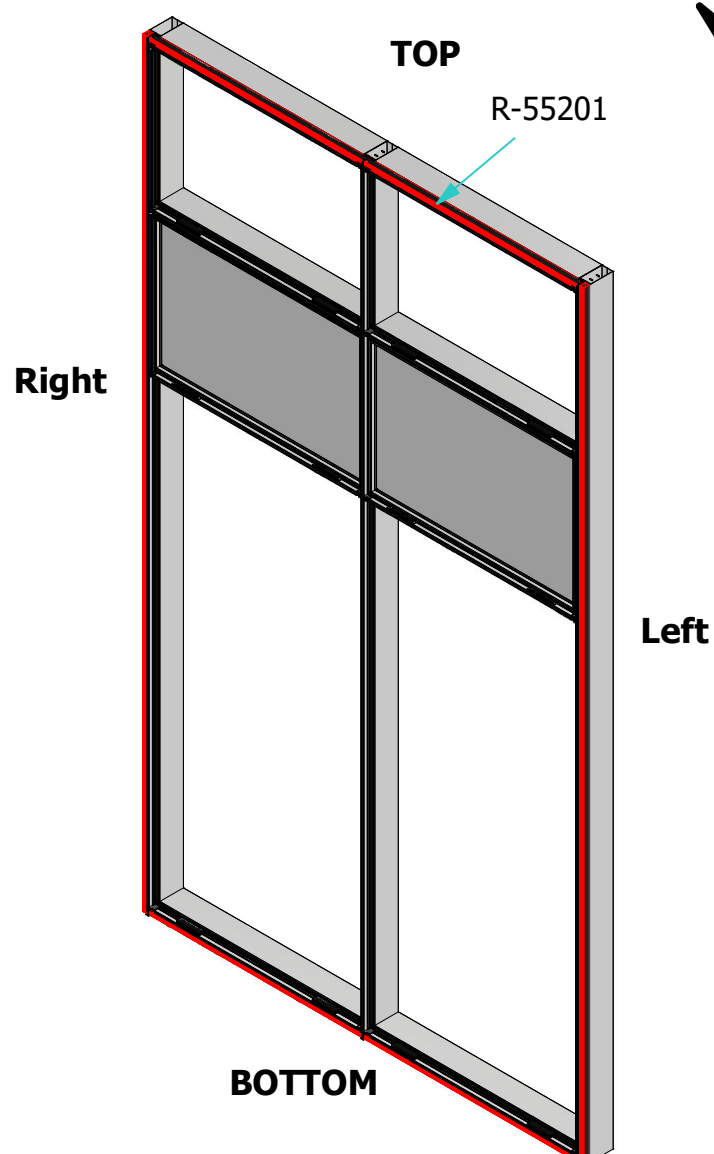
STEP 15 (Pocket filler installation):

Insert the pocket fillers (R-55201) or (R-55302 for TG) 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.

1



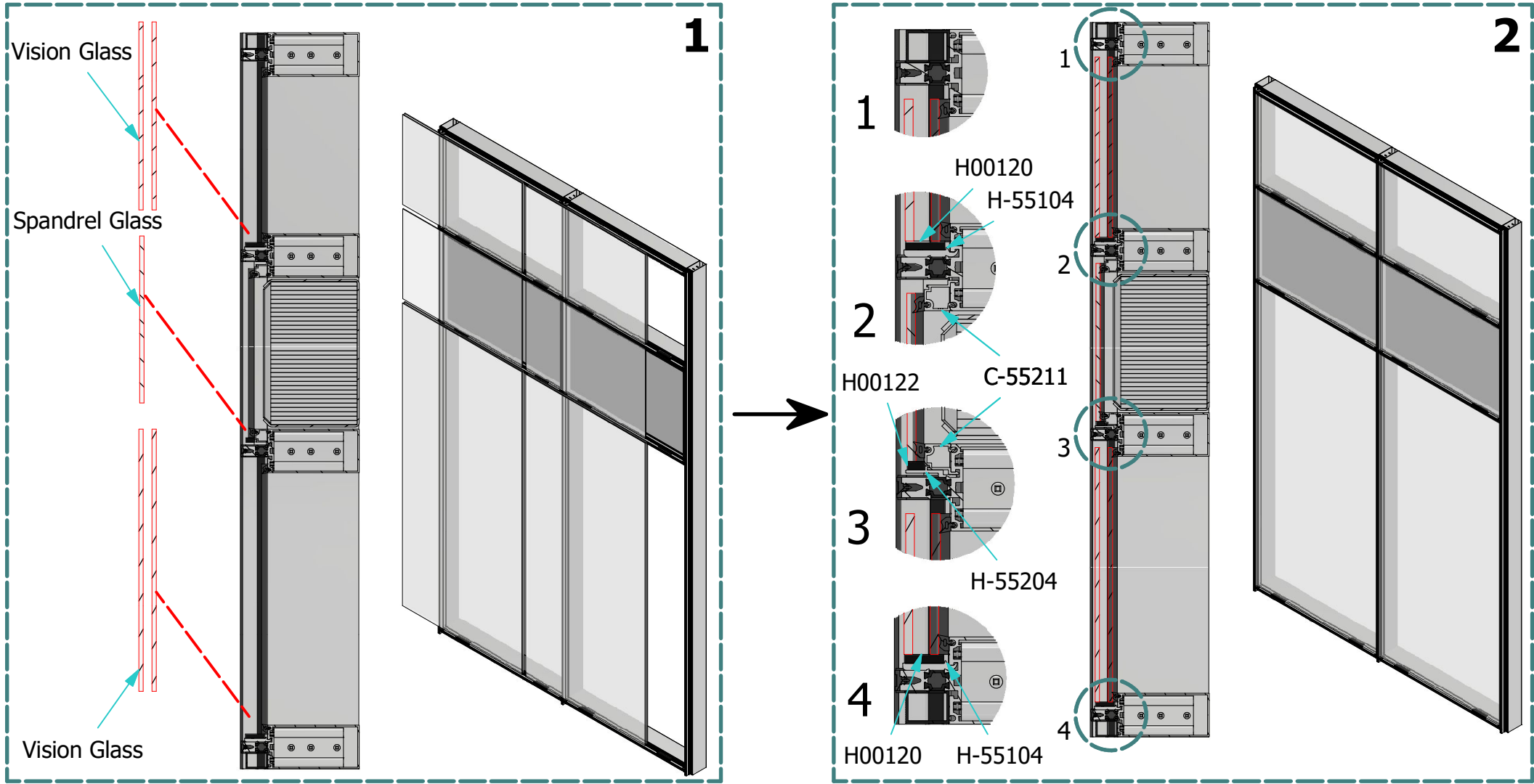
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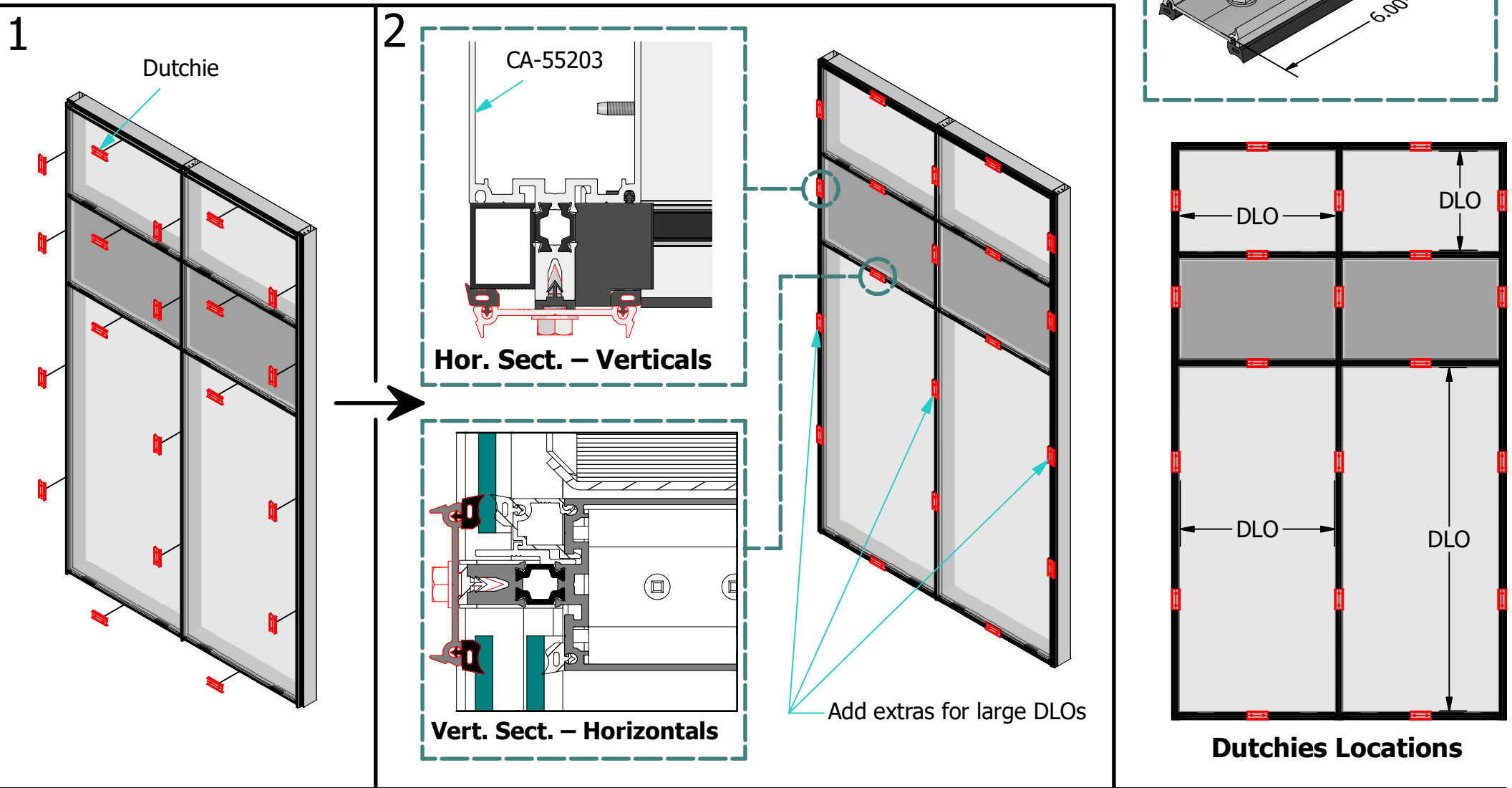
STEP 16 (Glass Panels Installation):

- 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 17 (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

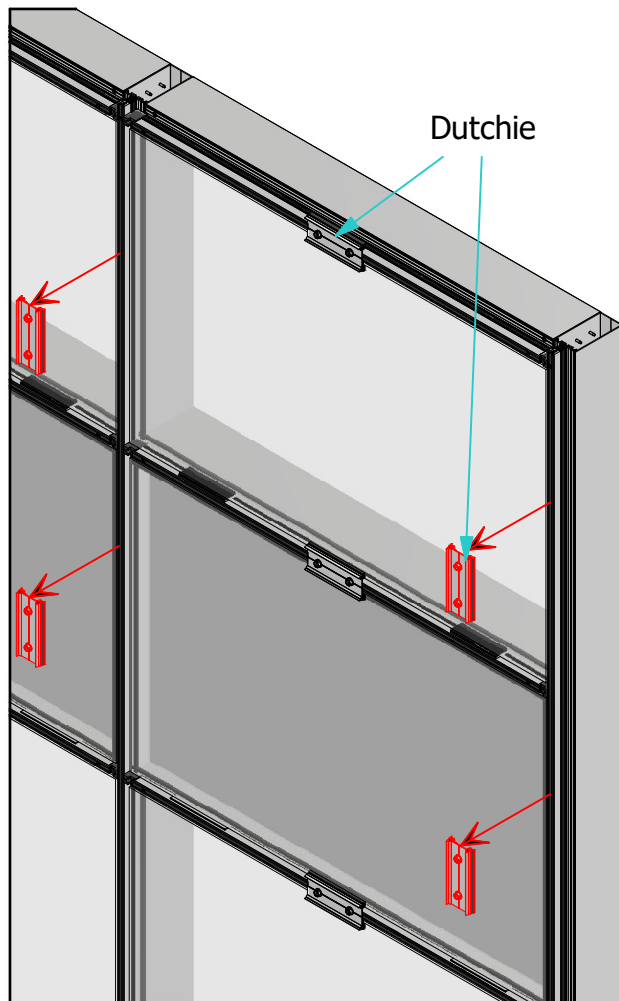


STEP 18 (Pressure Plates Installation):

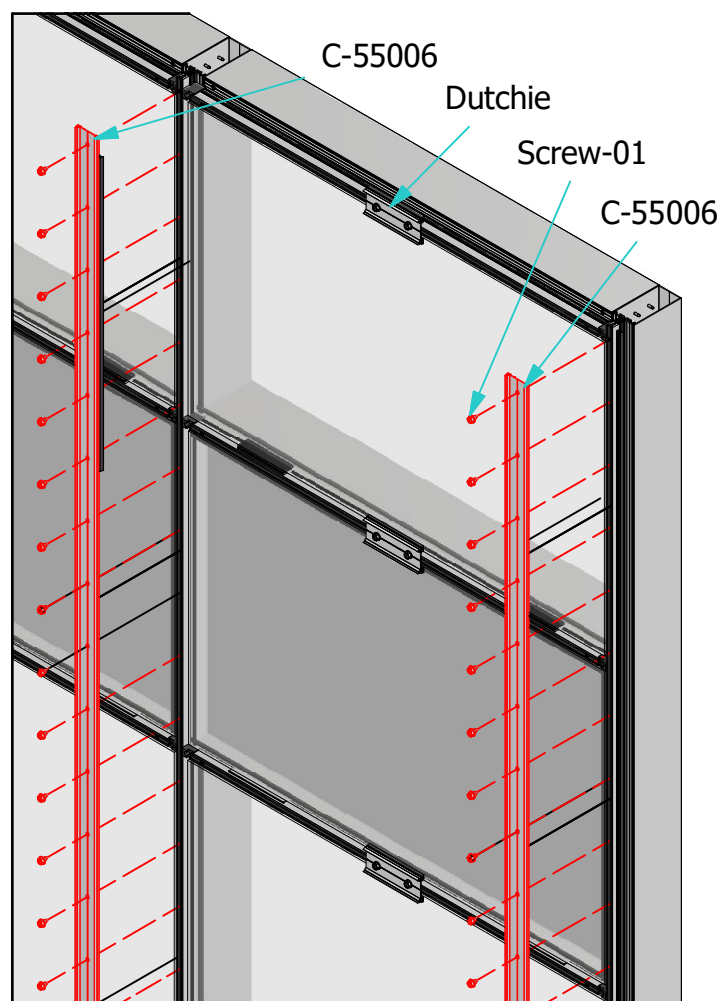
- Remove the Dutchies from the verticals, then install the vertical pressure plates (**C-55006**) by fastening them through the flexible PVC and into the neck using **#14 x 3/4" SS Hex Washer Head Screws (Screw-01)**.
- Repeat the same process for the horizontals.

Pressure Plate Installation Sequence

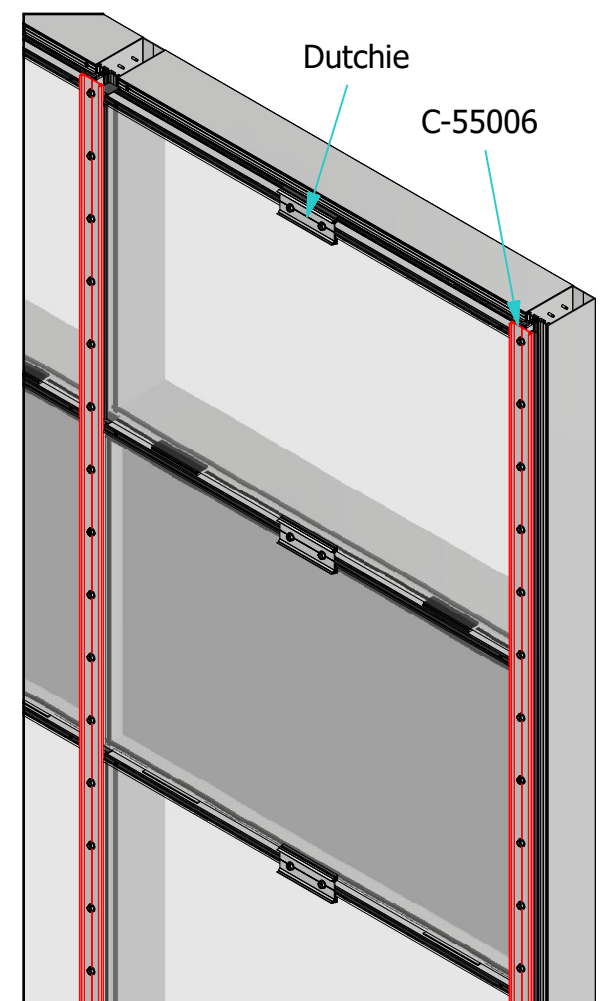
1) - Remove Dutchies - Verticals



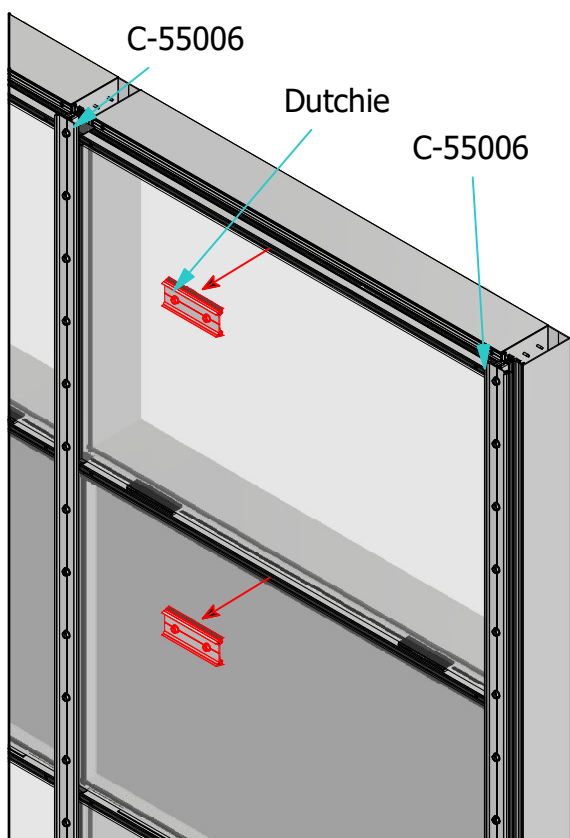
2) - Install Vertical Pressure Plates



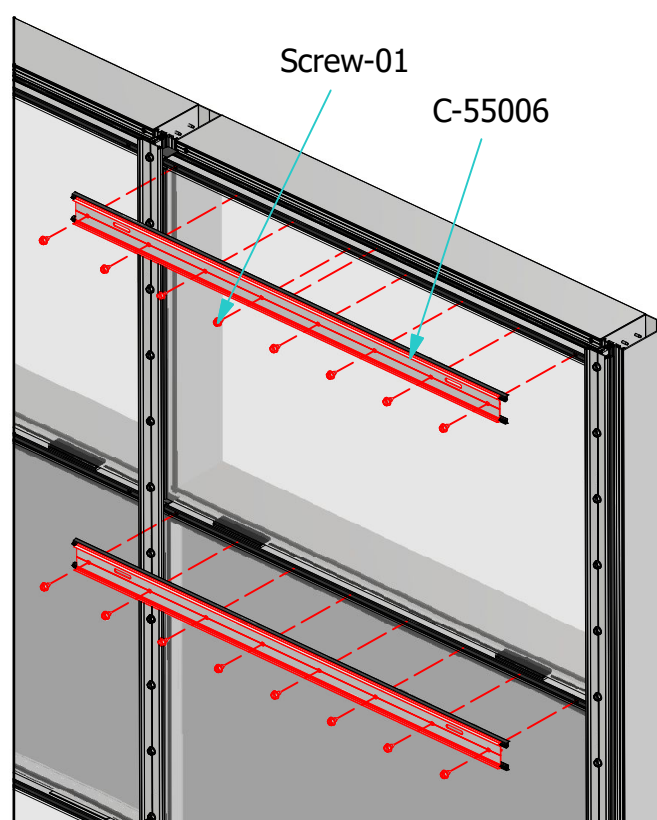
3) - Vertical Installation - Final Look



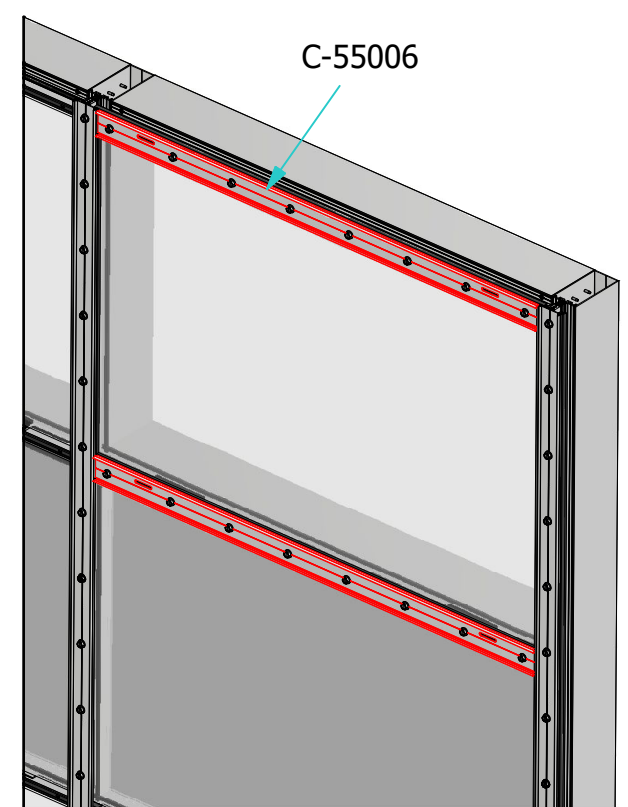
4) - Remove Dutchies - Horizontals



5) - Install Horizontal Pressure Plates



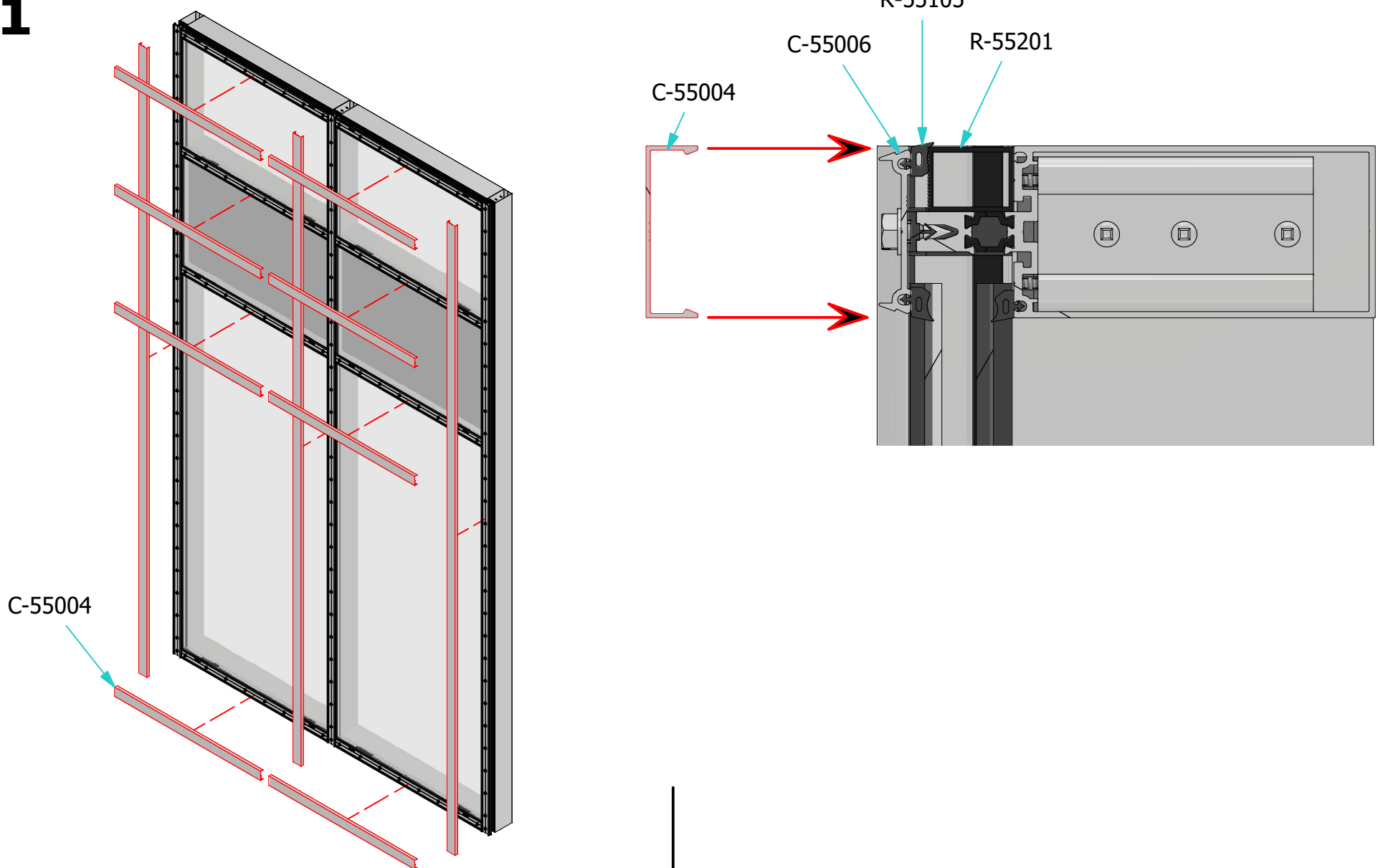
6) - Horizontal Installation - Final Look



STEP 19 (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.

1



2

