

INSTALLATION GUIDE

4mm MULLION



CRYSTAL WINDOW & DOOR SYSTEMS
31-10 WHITESTONE EXPWY. FLUSHING NY 11354
TEL. 718.961.7300

VER 10.15.26

PAGE 1 OF 1

1. PREPARING THE JAMB PROFILE

The jamb profile will be prepared for mulling in the factory but, if required, the nailing fin and exterior leg can be removed as shown (See Figure 1).

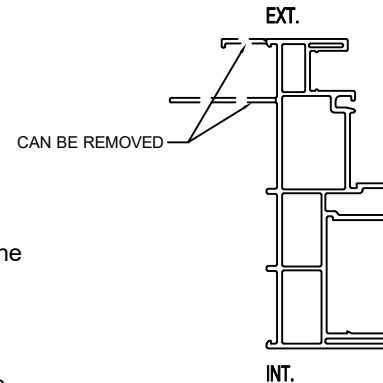


FIGURE 1

2. CLEARANCE HOLES / REINFORCEMENT

Drill 3/8" diameter screw head clearance holes on the interior and exterior of the jamb profiles that will be mulled. The holes should begin 4" - 6" from the head and sill at a frequency of 8" - 12" on center along the jambs. Alternate screw head clearance holes from jamb to jamb, offsetting to avoid screw interference (See Figure 2). NOTE: If reinforcement is required, attach it to one of the jambs as shown in Figure 3 before proceeding to the next step.

3. JOINING THE FRAMES

Lay 3/8" beads of low modulus silicone and caulk the entire length of the 4mm mullion (exterior mullion only, See Figure 2). Attach the 4mm mullion on both sides of the assembly and join the two jambs together, wiping off any excess caulk. Fasten the frames together using #8 x 7/8" self-drilling truss head screws through the pilot holes created in Step 2. If required use clamps to hold the assembly in place while fastening screws.

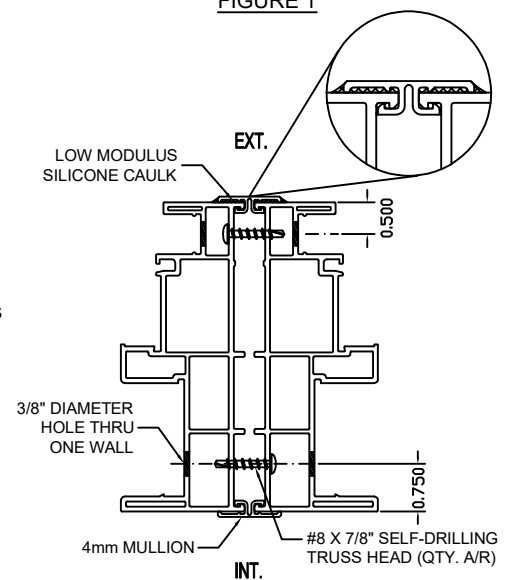


FIGURE 2

4. WATERPROOFING AT MULLION

NOTE: Units mulled in the factory will come with metal brackets connecting the two frames (See Figure 3). These brackets are used to secure the frames but can be removed if they are impeding installation. If removal is necessary please make sure to seal any gaps and ensure a watertight seal. Apply a generous amount of caulk at the head and sill of the mulled units to seal the gap between them. Proceed to waterproof the exterior of the mullion. Use Polyken 360-17 butyl sealant tape, Henry Blue skin or a similar product to seal over the mullion joint area. Seal a minimum of 1" over the nailing fin (See Figure 4).

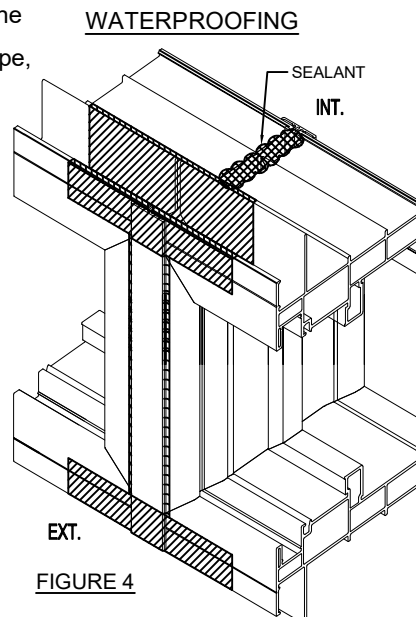


FIGURE 4

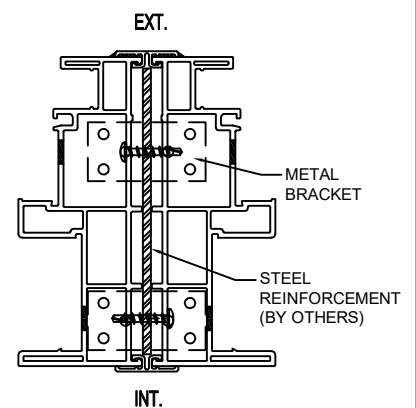


FIGURE 3