



# UniVent 1375AW

## INSTALLATION INSTRUCTIONS

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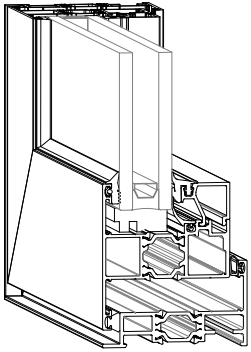
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1. These instructions cover typical product application, fabrication, installation and standard conditions and are general in nature. They provide useful guidelines, but the final shop drawings may include additional details specific to the project. Any conflict or discrepancies must be clarified prior to execution.
2. Materials stored at the job site must be kept in a safe place protected from possible damage by other trades. Stack with adequate separation so materials will not rub together and store off the ground. Cardboard or paper wrapped materials must be kept dry. Check arriving materials for quantity and keep a record of where various materials are stored.
3. All field welding must be done in accordance with AISC guidelines. All aluminum and glass should be shielded from field welding to avoid damage from weld splatter. Results will be unsightly and may be structurally unsound. Advise general contractor and other trades accordingly.
4. Coordinate protection of installed work with general contractor and/or other trades.
5. Coordinate sequence of other trades which affect framing installation with the general contractor (e.g. fire proofing , back up walls, partitions, ceilings, mechanical ducts, HVAC, etc.).
6. General contractor should furnish and guarantee bench marks, off set lines and opening dimensions. These items should be checked for accuracy before proceeding with erection. Make certain that all adjacent substrate construction is in accordance with the contract documents and/or approved shop drawings. If not, notify the general contractor in writing before proceeding with installation because this could constitute acceptance of adjacent substrate construction by others.
7. Isolate all aluminum to be placed directly in contact with masonry or other incompatible materials with a heavy coat of zinc chromate or bituminous paint. Fasteners attaching framing to building structure are typically not provided by Tubelite, nor specified in these instructions due to varying perimeter conditions and job performance requirements. Consult approved shop drawings.
8. Sealant selection is the responsibility of the erector, installer and/or glazing contractor and must be approved by the sealant manufacturer with regard to application and compatibility for its intended use. All sealants must be used in strict accordance with the manufacturer's instructions and applied only by trained personnel to surfaces that have been properly prepared.
9. Sealant must be compatible with all materials with which they have contact, including other sealant surfaces. Consult the sealant manufacturer for recommendations relative to shelf life, compatibility, cleaning of substrate, priming, tooling adhesion, etc. Recommend sealant manufacturer perform adhesion "pull test" at "wet" glazing for quality assurance.
10. Drainage gutters and weep holes must be kept clean at all times. Tubelite will not accept responsibility for improper drainage as a result of clogged gutters and weep holes.
11. All framing members, entrances and other materials are to be installed plumb, level and true with regard to established bench marks, column center lines or other working points established by the general contractor and checked by the erector, installer and/or glazing contractor.
12. Cleaning of exposed aluminum surfaces should be done per AAMA recommendations.
13. Due to varying perimeter conditions and job performance requirements, anchor fasteners are not specified in these instructions. For anchor fastening, refer to the shop drawings or consult the fastener supplier.
14. Codes governing the design and use of products vary widely. Tubelite does not control the selection of products configurations, operating hardware, or glazing materials, and assumes no responsibility for these considerations. It is the responsibility of the owner, specifier, architect, general contractor and the installer to make these selections in strict conformance with all applicable codes.
15. Check weblink below for any installation instruction updates



### 1375 PO AWNING INFORMATION DUAL GLAZED

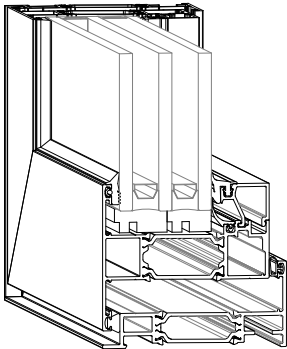
	ROTO-MPL	CAM HANDLES
*MIN DIMENSIONS	19 5/8" x 21"	16" x 16"
*MAX DIMENSIONS	72" x 36", 42" x 78"	60" x 36", 36" x 54"
SCREEN	OPTION	OPT. (wicket)
MAX OPENING	2 1/4" < *30 5/8" W 7 1/2" > *30 5/8" W	VARIES VARIES
LIMITED OPENING	OPTION @ 4"	OPTION @ 4"
CUSTODIAL LOCK	OPTION	N/A

\*Based on rough opening (RO) dimensions

### 1375 PO CASEMENT INFORMATION DUAL GLAZED

	ROTO-MPL	CAM HANDLES
*MIN DIMENSIONS	16 5/8" x 21" **	16" x 24" **
*MAX DIMENSIONS	36" x 62", 27" x 84" **	36" x 54" **
SCREEN	OPTION	OPT. (wicket)
MAX OPENING	VARIES	VARIES
EGRESS	OPTION	OPTION
LIMITED OPENING	OPTION @ 4"	OPTION @ 4"
CUSTODIAL LOCK	OPTION	N/A

\*Based on rough opening (RO) dimensions  
\*\*Width/Height ratio exceeding 65% is not recommended



### 1375 PO AWNING INFORMATION TRIPLE GLAZED

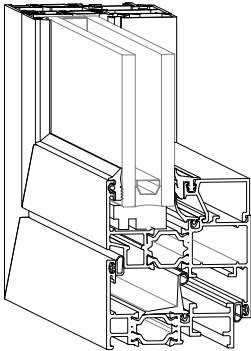
	ROTO-MPL	CAM HANDLES
*MIN DIMENSIONS	19 5/8" x 21"	16" x 16"
*MAX DIMENSIONS	66" x 36", 36" x 66"	60" x 36", 36" x 54"
SCREEN	OPTION	OPT. (wicket)
MAX OPENING	1 1/2" < *30 5/8" W 6 3/4" > *30 5/8" W	VARIES VARIES
LIMITED OPENING	OPTION @ 4"	OPTION @ 4"
CUSTODIAL LOCK	OPTION	N/A

\*Based on rough opening (RO) dimensions

### 1375 PO CASEMENT INFORMATION TRIPLE GLAZED

	ROTO-MPL	CAM HANDLES
*MIN DIMENSIONS	16 5/8" x 24" **	16" x 24" **
*MAX DIMENSIONS	36" x 60" **	36" x 54" **
SCREEN	OPTION	OPT. (wicket)
MAX OPENING	VARIES	VARIES
EGRESS	OPTION	OPTION
LIMITED OPENING	OPTION @ 4"	OPTION @ 4"
CUSTODIAL LOCK	OPTION	N/A

\*Based on rough opening (RO) dimensions  
\*\*Width/Height ratio exceeding 65% is not recommended



### 1375 PI HOPPER INFORMATION DUAL GLAZED

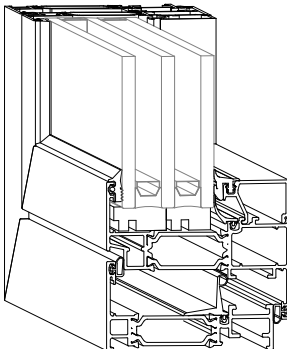
	MPL
*MIN DIMENSIONS	16" x 16"
*MAX DIMENSIONS	72" x 38" or 36" x 60"
SCREEN	OPTION
MAX OPENING	VARIES
LIMITED OPENING	OPTION @ 4"
CUSTODIAL LOCK	OPTION

\*Based on rough opening (RO) dimensions

### 1375 PI CASEMENT INFORMATION DUAL GLAZED

	MPL
*MIN DIMENSIONS	16" x 16"
*MAX DIMENSIONS	36" x 76"
SCREEN	OPTION
MAX OPENING	VARIES
EGRESS	OPTION
LIMITED OPENING	OPTION @ 4"
CUSTODIAL LOCK	OPTION

\*Based on rough opening (RO) dimensions  
\*\*Width/Height ratio exceeding 65% is not recommended



### 1375 PI HOPPER INFORMATION TRIPLE GLAZED

	MPL
*MIN DIMENSIONS	16" x 16"
*MAX DIMENSIONS	60" x 36", 36" x 60"
SCREEN	OPTION
MAX OPENING	VARIES
EGRESS	N/A
LIMITED OPENING	OPTION @ 4"
CUSTODIAL LOCK	OPTION

\*Based on rough opening (RO) dimensions

### 1375 PI CASEMENT INFORMATION TRIPLE GLAZED

	ROTO-MPL
*MIN DIMENSIONS	16" x 16"
*MAX DIMENSIONS	36" x 72"
SCREEN	OPTION
MAX OPENING	VARIES
EGRESS	OPTION
LIMITED OPENING	OPTION @ 4"
CUSTODIAL LOCK	OPTION

\*Based on rough opening (RO) dimensions  
\*\*Width/Height ratio exceeding 65% is not recommended

## SYSTEM COMPATIBILITY

#### WINDOW WALL:

900RW T<sup>\*1</sup>  
900RW TU<sup>\*1</sup>

#### CURTAINWALL:

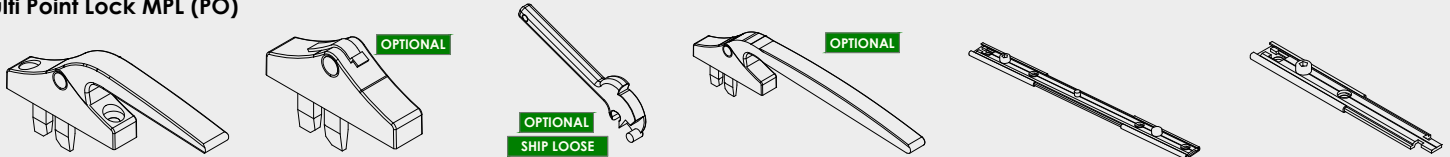
200<sup>\*3</sup>, 400CW, 400SS,  
400TU, 400IG<sup>\*2</sup>

#### STOREFRONT:

E1400<sup>\*3</sup>, T1400,  
E1400 I/O<sup>\*3</sup>, T1400 I/O, TU2400  
E24650<sup>\*1\*3</sup>, T24650<sup>\*1</sup>

<sup>\*1</sup> not compatible with SSG condition    <sup>\*2</sup> installed from exterior only    <sup>\*3</sup> non thermal application only

### Multi Point Lock MPL (PO)



4" LINEAR HANDLE		
PART #	FINISH	USED WITH
1162001	SILVER	1162304 Backer Plate
1162105	WHITE	1162203 Gasket
1162103	BLACK	7200201 Machine Screw

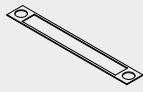
CUSTODIAL LOCK		
PART #	FINISH	USED WITH
PA1335001	SILVER	PA1337001 Handle
PA1335005	WHITE	1162203 Gasket
PA1335003	BLACK	7240101 Machine Screw

**PA1337001  
REMOVABLE  
CUSTODIAL HANDLE**  
*SHIP LOOSE*

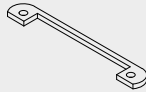
EXTENDED LINEAR HANDLE		
PART #	FINISH	USED WITH
PA1336001	SILVER	1162203 Gasket
PA1336005	WHITE	7240101 Machine Screw
PA1336003	BLACK	

MPL LOCK BAR		
PART #	FINISH	USED WITH
1168001	12"	116200x 4" Linear Handle
1168101	24"	PA133500x Custodial Lock
1168201	36"	PA133600x ADA Extended
1168301	48"	7238101 Machine Screw

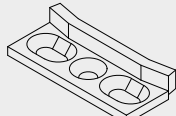
MPL EXTENSION BAR		
PART #	FINISH	USED WITH
1163001	6"	
1162901	10"	1168x01 Lock Bar
1162801	14"	7238101 Machine Screw
1162701	18"	
1162601	22"	



**1162203 MPL GASKET**



**1162304 MPL BACKER PLATE**



**1162404 MPL KEEPER**  
*used with 7238101*



**7200201 10-32 x 3/4 PHS, SS**

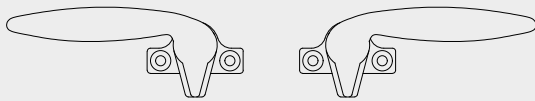


**7240101 10-32 x 1/2 PHS, SS**



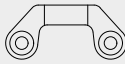
**7238101 10-24 x 3/8 FHS, SS**

### CAM Handle Locking Hardware (PO)

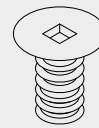


CAM HANDLE LH		
PART #	FINISH	USED WITH
1147101	WHITE BRONZE	1147301 Surface Strike 7238101 Machine Screw

CAM HANDLE RH		
PART #	FINISH	USED WITH
1147201	WHITE BRONZE	1147301 Surface Strike 7238101 Machine Screw



**1147301 SURFACE STRIKE**



**7238101 10-24 x 3/8 FHS, SOS**

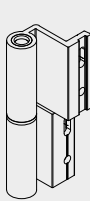
### Hinges (PO)

4-BAR HINGE, AWNING	
PART #	SIZE
1171001	10"
1171601	16"
1172401	24"
1142701	28"

*Used with 7237301*

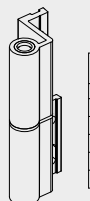
4-BAR HINGE LOOSE RIVET AWNING	
PART #	SIZE
PA1325001	10"
PA1325101	16"
PA1325201	24"

*Used with 7237301*



BUTT HINGE RH, CASEMENT	
PART #	FINISH
1452741	SILVER
1452772	BRONZE
1452773	BLACK
1452709	PAINTED

*Used with 7237001*



BUTT HINGE LH, CASEMENT	
PART #	FINISH
1453741	SILVER
1453772	BRONZE
1453773	BLACK
1453709	PAINTED

*Used with 7237001*

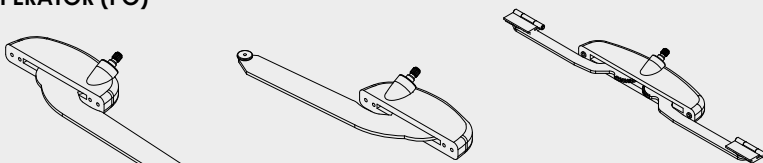


**7237001 10 x 1/2 PHS, SS**



**7237301 10 x 3/8 PHS, SS**

### ROTO OPERATOR (PO)



9 1/2" ROTO RH, CASEMENT		
PART #	FINISH	USED WITH
1451501	SILVER	1450402 Gasket
1451503	BLACK	7200104 Socket H.Screw
1451505	WHITE	1452101 13 1/2 TRACK

9 1/2" ROTO LH, CASEMENT		
PART #	FINISH	USED WITH
1451601	SILVER	1450402 Gasket
1451603	BLACK	7200104 Socket H.Screw
1451605	WHITE	1452101 13 1/2 TRACK

27 3/4" ROTO, AWNING		
PART #	FINISH	USED WITH
1450001	SILVER	1150402 Gasket
1450003	BLACK	7280104 Socket H.Screw
1450005	WHITE	1149801 13 7/8 TRACK

13 1/2" ROTO RH, CASEMENT		
PART #	FINISH	USED WITH
1451701	SILVER	1450402 Gasket
1451703	BLACK	7200104 Socket H.Screw
1451705	WHITE	1452101 13 1/2 Track

13 1/2" ROTO LH, CASEMENT		
PART #	FINISH	USED WITH
1451801	SILVER	1450402 Gasket
1451803	BLACK	7200104 Socket H.Screw
1451805	WHITE	1452101 13 1/2 Track

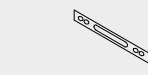
16 3/4" ROTO, AWNING		
PART #	FINISH	USED WITH
1450501	SILVER	1150402 Gasket
1450503	BLACK	7280104 Socket H.Screw
1450505	WHITE	1450601 8 3/8 Track



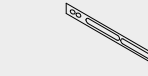
**7200104 10-24 x 3/8 SHS, SS**



**7280104 8-32 x 3/8 SHS, SS**



**1450401 GASKET, CSMT**



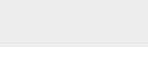
**1150402 GASKET, AWNING**



**1450601 8 3/8 TRACK, AWNING**



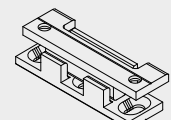
**1149801 13 7/8 TRACK, AWNING**



**1452101 13 1/2 TRACK, CASEMENT**

ROTO HANDLE		
PART #	FINISH	USED WITH
1449901	SILVER	
1449903	BLACK	ROTO OPERATORS
1449905	WHITE	

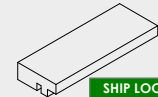
### MISC.



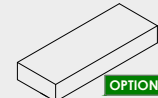
**1167003 SNUBBER SET**  
*used with 7238101*



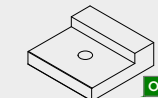
**1140501 FRICTION ADJUSTOR/LIMITER**  
*used with 7237001*



**1476203 EPDM SETTING BLOCK**



**PA1341003 SILICONE SETTING BLOCK**



**1141603 AWNING LIMIT BLOCK, 1 1/4"**  
*used with 7237001*

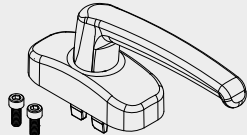


**PA1338401 FRICTION ARM LIMIT DEVICE**



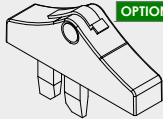
**1141501 ADJUSTING SCREW PVC SHIM**  
*used on casement only*

## Multi Point Lock MPL (PI)

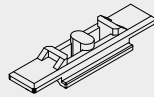


EURO HANDLE		
PART #	FINISH	USED WITH
PA1338001	SILVER	10-32 x 1/2 SHS
PA1338005	WHITE	
PA1338003	BLACK	

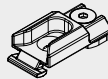
OPTIONAL



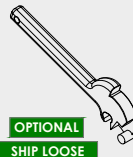
CUSTODIAL LOCK		
PART #	FINISH	USED WITH
PA1335001	SILVER	PA1337001 Handle
PA1335005	WHITE	1162203 Gasket
PA1335003	BLACK	7240101 Machine Screw



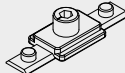
PA1338101  
HANDLE CONNECTOR



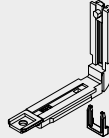
6218203  
KEEPER WITH CLAMP



OPTIONAL  
SHIP LOOSE  
PA1337001  
REMOVABLE  
CUSTODIAL HANDLE



PA1338201  
LOCK PLATE



PA1338301  
CORNER DRIVE

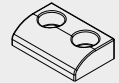


1162203 MPL GASKET

## MISC.



6220301  
SNUBBER



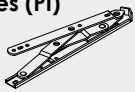
PA134003  
POSITIONING BLOCK



OPTIONAL

1174601  
FRICTION LIMIT DEVICE

## Hinges (PI)



4-BAR HINGE, HOPPER, CSMT	
PART #	SIZE
PA1326001	10"
PA1326101	16"
PA1326201	24"

Used with 7237001, 6209903



6220101  
CASEMENT HINGE, RH



6220201  
CASEMENT HINGE, LH



7237001  
10 x 1/2 PHS, SS



6209903  
GROOVE SHIM



OPTIONAL

PA1338401  
FRICTION ARM LIMIT DEVICE

## Extrusions



1342003  
EXTERIOR GLAZING GASKET



SHIP LOOSE

1342003  
AIRSEAL GASKET



SHIP LOOSE

1841003  
GLAZING GASKET, 1" GLASS



SHIP LOOSE

1840903  
GLAZING GASKET  
1 1/6", 1 3/4" GLASS



1461003  
CENTRAL SEAL GASKET, PI



1462003  
PERIMETER BULB GASKET



EA137505  
PO GLASS STOP



EA137511  
PI GLASS STOP



1174041  
PI CONNECTING BAR



13756003  
PI CW ADAPTOR, PVC



13756103  
PI CW ADAPTOR, 1 3/4", PVC



SHIP LOOSE

13756203  
SF ADAPTOR, PVC



SHIP LOOSE  
ORDERED SEPR.

T9404  
POCKET FILLER WITH LEG FOR  
FLAT BACK INSTALLATION



SHIP LOOSE  
ORDERED SEPR.

P4563  
JAMB POCKET FILLER FOR SF  
INSTALLATION

### AVAILABLE FINISHES

(C2) Clear (C1) Clear (DB) Dark Bronze (MB) Medium Bronze (BL) Black (LB) Light Bronze (CH) Champagne \*\*Painted-See Chart

## Insect Screen Components



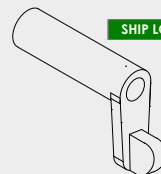
SHIP LOOSE

1159101  
5/16" SCREEN TURN CLIP  
(used on PO with ROTO hardware)



SHIP LOOSE

7248101  
#8 x 5/8" PHS, SS



SHIP LOOSE

1159301  
1" SCREEN TURN CLIP  
(used on PI and PO with wickets)

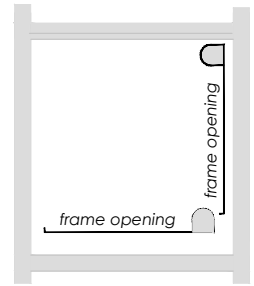


SHIP LOOSE

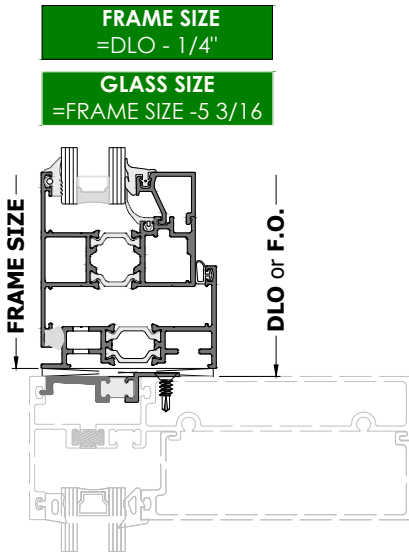
7243101  
#8 x 1 3/8" PHS, SS

**STEP 1**

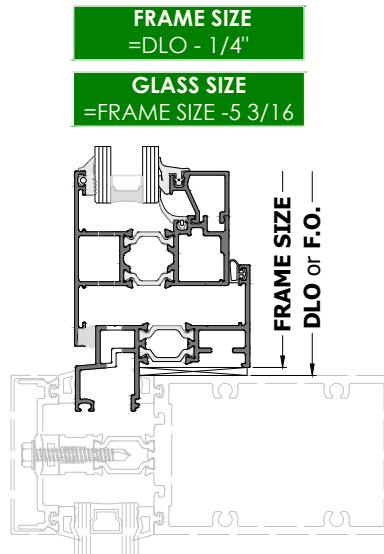
- Make sure frame opening (F.O) is plumb and level. Measuring corner-to-corner is easiest way to make sure it is square. See **FIG. 1**
- Make sure frame size is smaller than F.O. See **FIG. 2**
- See **Fig. 2** to measure and verify GLASS SIZE.



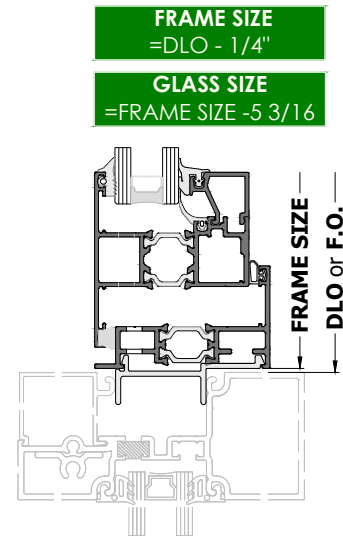
**FIG. 1**



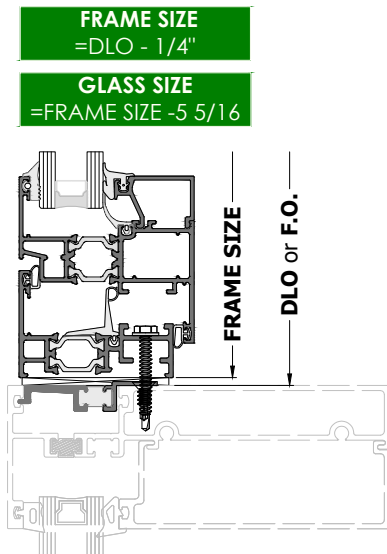
**1375 PO**  
FLAT BACK INSTALLATION



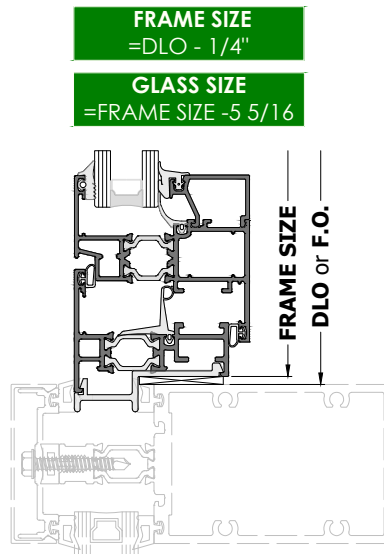
**1375 PO**  
CURTAIN WALL INSTALLATION



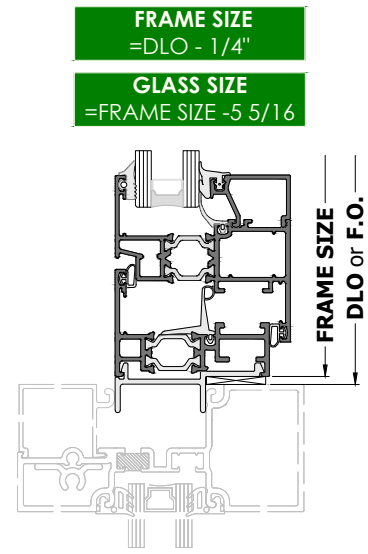
**1375 PO**  
STOREFRONT INSTALLATION  
with optional PVC adaptor



**1375 PI**  
FLAT BACK INSTALLATION



**1375 PI**  
CURTAIN WALL INSTALLATION



**1375 PI**  
STOREFRONT INSTALLATION  
with optional PVC adaptor

**FIG. 2**

## SYSTEM COMPATIBILITY

**WINDOW WALL:**  
900RW T<sup>\*1</sup>  
900RW TU<sup>\*1</sup>

**CURTAINWALL:**  
200<sup>\*3</sup>, 400CW, 400SS,  
400TU, 400IG<sup>\*2</sup>

**STOREFRONT:**  
E1400<sup>\*3</sup>, T1400,  
E1400 I/O<sup>\*3</sup>, T1400 I/O, TU2400  
E24650<sup>\*1\*3</sup>, T24650<sup>\*1</sup>

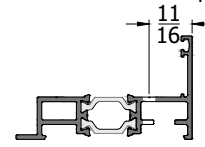
<sup>\*1</sup> not compatible with SSG condition

<sup>\*2</sup> installed from exterior only

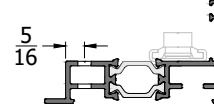
<sup>\*3</sup> non thermal application only

**STEP 1**

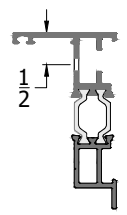
- Drill  $\varnothing.201$  clearance holes for #10 Screws using #7 Drill bit for anchoring holes, as per recommended location, see **FIG. 1**. Use interior V-groove for reference.
- For storefront application drill  $\frac{1}{2}$ " from the interior. See **FIG. 3**
- In case of hardware interference, stagger and drill clearance holes as per **FIG. 2**. Use exterior V-groove for reference.
- See **FIG. 4** for recommended spacing of clearance holes. Double check anchor size and location as per shop drawings.



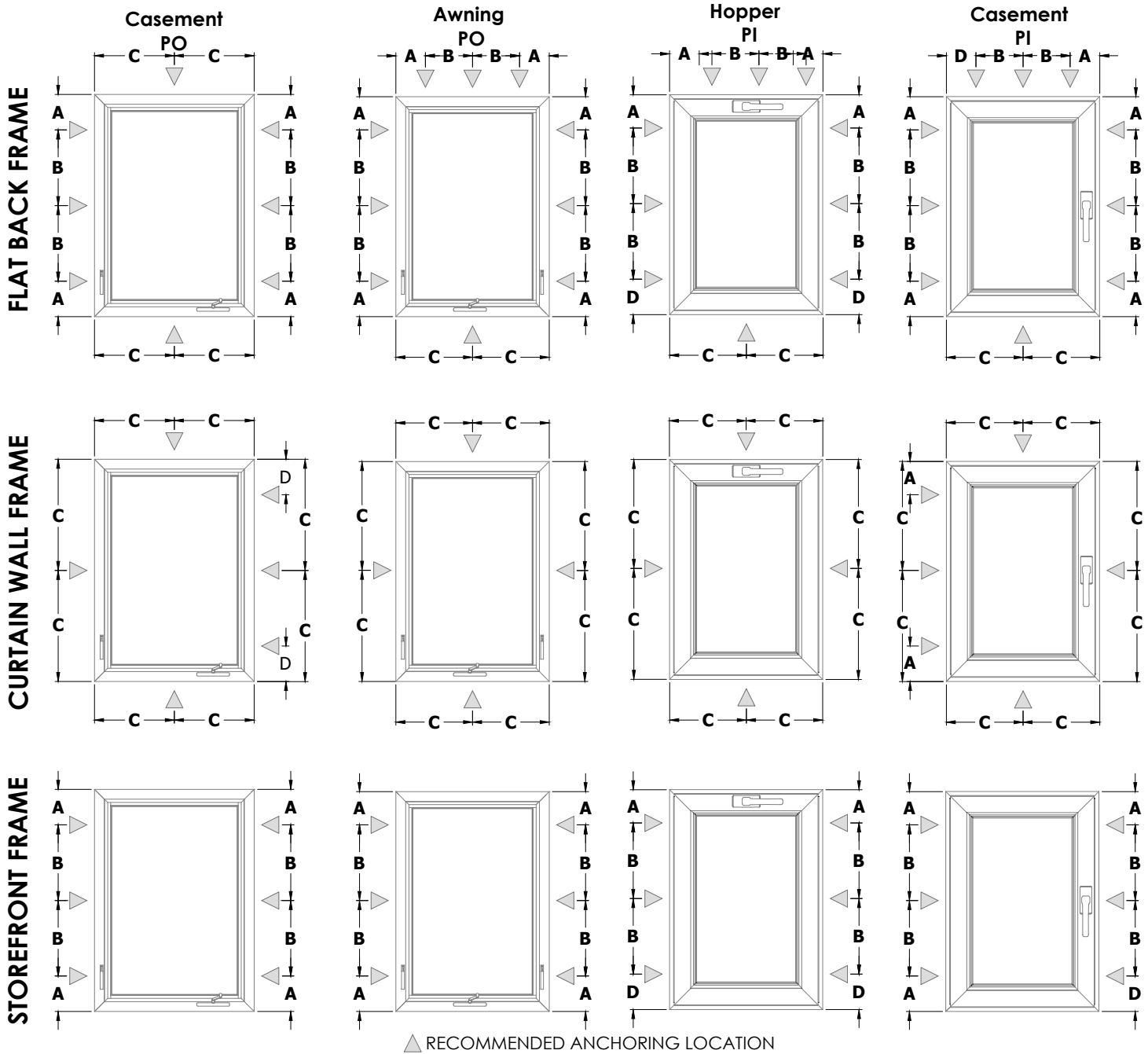
**FIG. 1**  
(Flatback)



**FIG. 2**



**FIG. 3**  
(Jamb with Flushglaze adpt. @ sill & head)



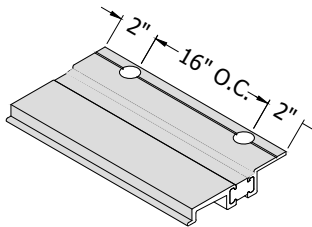
**FIG. 4**

**A=5" B= max 18" O.C C= Additional if Frame Width >36". D=beside hinge**

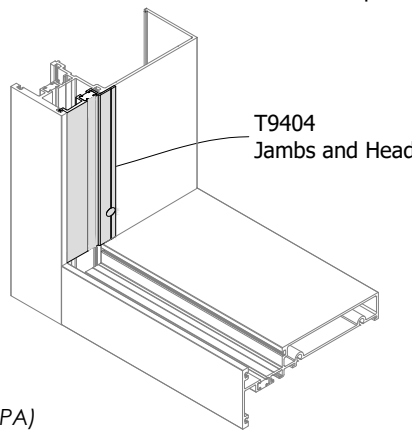


## STEP 1

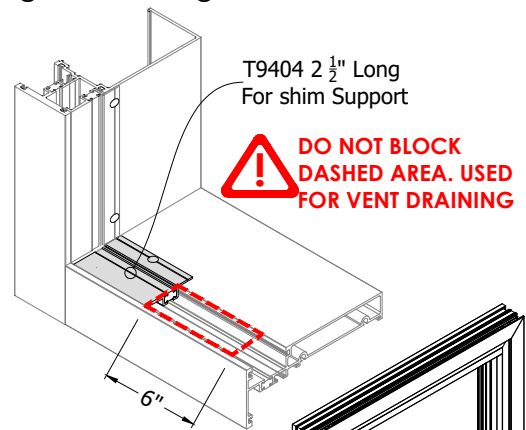
- Pre-drill and countersink T9404 pocket filler for #10 FHS, 2" from each end and 16" O.C. using V-groove as reference. **See FIG. 1**
- Install continuous T9404 Pocket Filler at both jambs and head using S444 fastener (#10 x 1/2" FHS Self Drilling). **See FIG. 2**
- Install 2 1/2" long T9404 at sill from both sides tight against adjacent pocket filler. Fasten using one S444 screw in the center of the V-groove. Seal fasteners with sealant. **See FIG. 3**
- Add additional 2 1/2" long T9404 at the sill if the frame opening width is larger then 36".



**FIG. 1**



**FIG. 2**

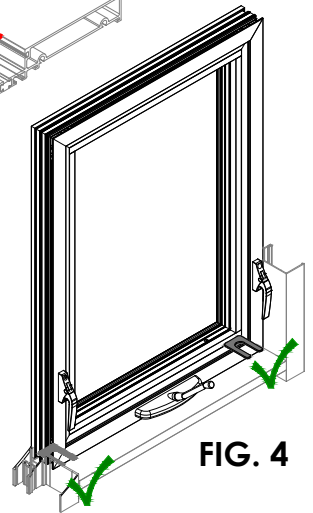


**FIG. 3**



**REFER TO FRAMING SYSTEMS FAB/INSTALLATION MANUAL FOR COMPLETE FABRICATION INSTRUCTIONS**

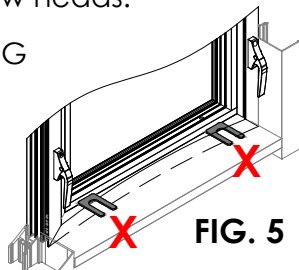
**NOTE:** IPA 2 method—dispense Iso-Propanol Alcohol (IPA) on a cloth, gently wipe the area. Immediately use another lint-free clean cloth to wipe the area dry.



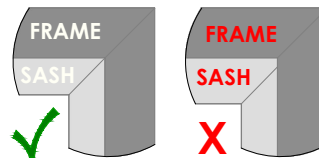
**FIG. 4**

## STEP 2

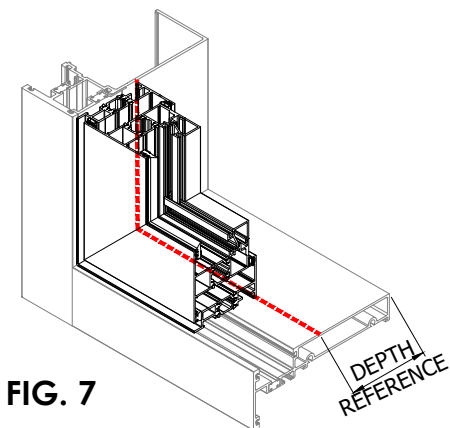
- Set Horseshoe shims onto the sill opening at each corner. Carefully set the vent onto the shims. **See FIG. 4 & FIG. 5**
- Position window frame in the opening, use **FIG. 7** as guide.
- Ensure weep holes are not blocked. Refer to **FIG. 3**
- Once vent is positioned, carefully open the sash and place a temporary fastener near the top hinge through the clearance hole.
- Place appropriate horseshoe shims around the perimeter, ensure window is square and plumb. Fasten in all remaining areas. Use #10 x 1 1/2" SELF DRILLING Screw.
- Check corners of the frame/sash at the lock side to make sure they are aligned or slightly raised on the lock side, adjust shims if necessary. **See FIG. 6**
- Seal all the screw heads.



**FIG. 5**



**FIG. 6**



**FIG. 7**

## SEE GLAZING

- Refer to GLAZING INSTRUCTIONS before proceeding to STEP 3.

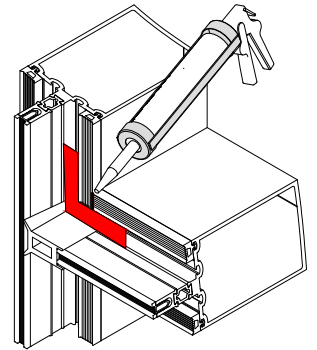
## STEP 3

- Check operation of the window by opening and closing multiple times.
- Cut horseshoe shims flush to interior/exterior frame surface.
- Clean perimeter of the frame where seal will be applied using IPA 2 METHOD.
- Apply Interior/Exterior seal around the frame and tool.

VENT TYPE	DEPTH REFERENCE	
	RECEIVING SYSTEM	
	900RW (4 1/2")	900RW (6")
1375 PO	1 9/16"	3 1/16"
1375 PI	1 7/8"	3 3/8"

## STEP 1

- Clean the around the corners of the frame using IPA2 METHOD.
- Apply a bed of sealant 2" around each corner of the frame ensuring it comes in contact with the gasket. Apply a dab of sealant on the the gasket joints. See **FIG. 1**



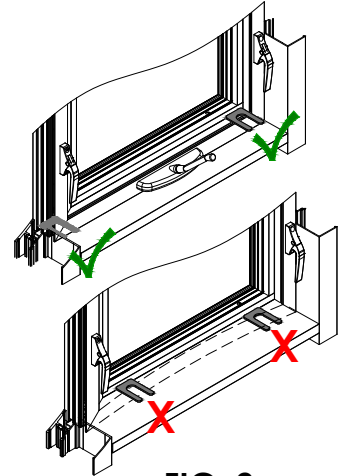
**FIG. 1**

**NOTE:** *IPA 2 method*-dispense Iso-Propanol Alcohol (IPA) on a cloth, gently wipe the area. Immediately use another lint-free clean cloth to wipe the area dry.

**REFER TO FRAMING SYSTEMS FAB/INSTALLATION MANUAL FOR COMPLETE FABRICATION INSTRUCTIONS**

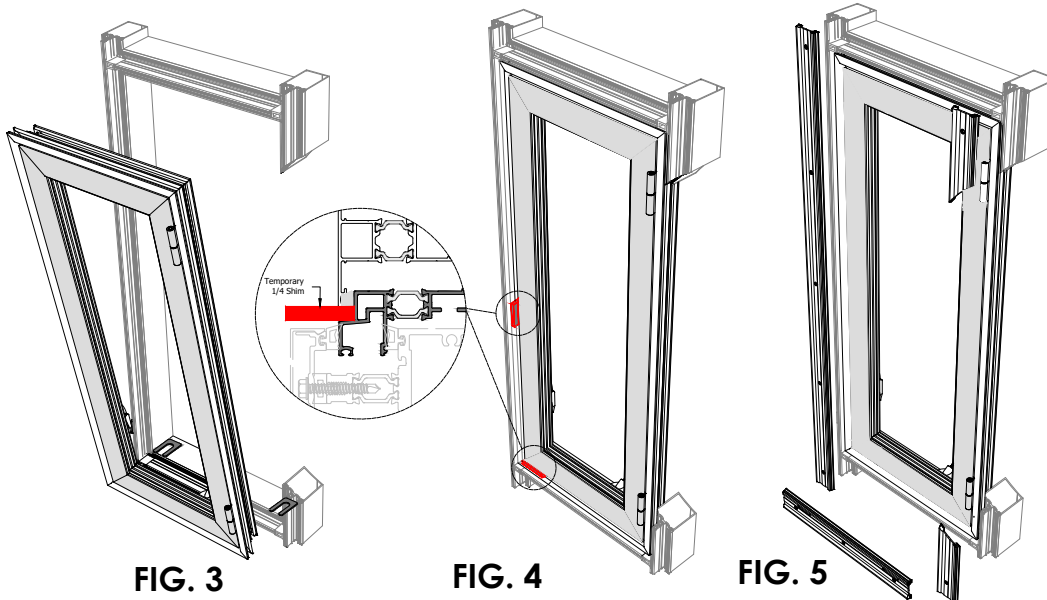
## STEP 2

- Clean exterior area of the vent where it will come in contact with the primary gasket using IPA 2 method
- Set Horseshoe shims onto the sill opening at each corner. Carefully set the vent onto the shims . See **FIG. 2**
- Push the vent in tight to the primary gasket seal. See **FIG. 3**
- Place temporary shims (1/4") between sash and frame maintaining consistent gap. This will prevent bowing and shifting of the vent during pressure plate installation. See **FIG. 4**
- Install exterior pressure plates ensuring drainage slots are facing up. **FIG. 5** , ensure window remains square.
- For windows exceeding 36" in height or width, place an anchoring screw. Refer to **FIG. 4 on Page 6**
- For casements windows, an additional fastener is needed beside the top hinge. Refer to **FIG. 4 on Page 8**
- Check sightline, adjust if necessary. See **FIG. 6**



**FIG. 2**

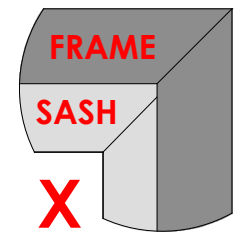
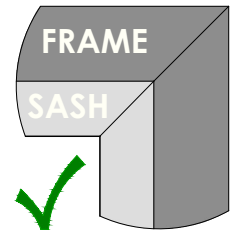
## SEE GLAZING



**FIG. 3**

**FIG. 4**

**FIG. 5**



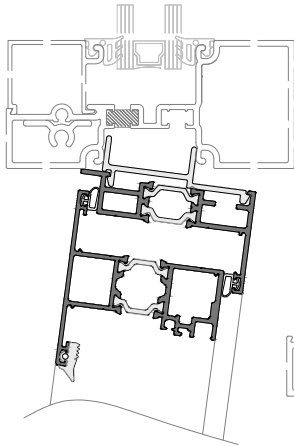
**FIG. 6**

## STEP 3

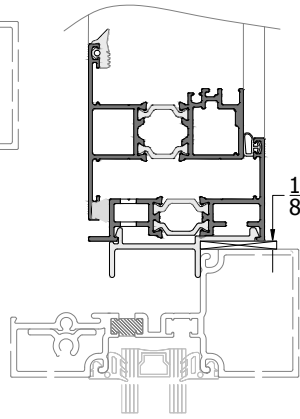
- Check operation of the window by opening and closing multiple times.
- Cut horseshoe shims flush to interior/exterior frame surface.
- Clean perimeter of the frame where seal will be applied using IPA 2 METHOD.
- Apply Interior/Exterior seal around the frame and tool.
- Seal all the screw heads.

## STEP 1

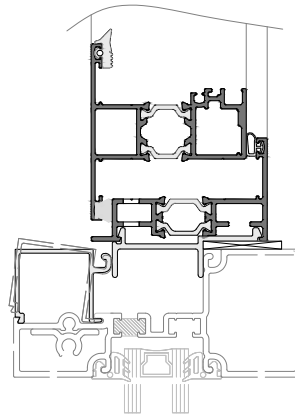
- Install **P4563 Pocket Filler** at jambs at each side. See **FIG. 1**
- Insert and slide top of the window into the glazing pocket. See **FIG. 2**
- Swing bottom of the window into place **FIG 3**. Set plastic horseshoe shims on the sill at each corner. See **FIG. 5**
- Snap glass stop into place. See **FIG. 4**



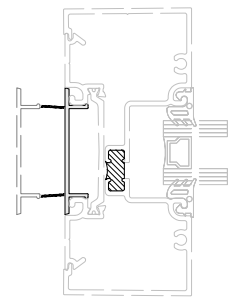
**FIG. 2**



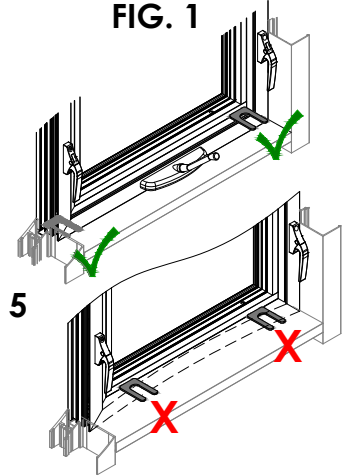
**FIG. 3**



**FIG. 4**



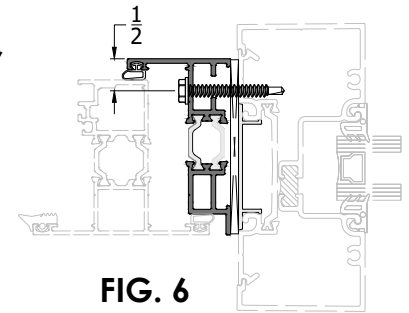
**FIG. 1**



**FIG. 5**

## STEP 2

- Place appropriate horseshoe shims around the perimeter, ensure window is square and plumb. Fasten the jambs of the frame **FIG 6**, refer to **FIG. 4 on Page 8** for spacing schedule .



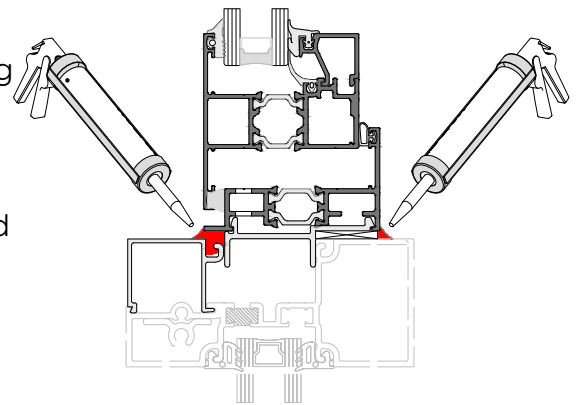
**FIG. 6**

## SEE GLAZING

- Refer to **GLAZING INSTRUCTIONS** before to proceeding to **STEP 3**.

## STEP 3

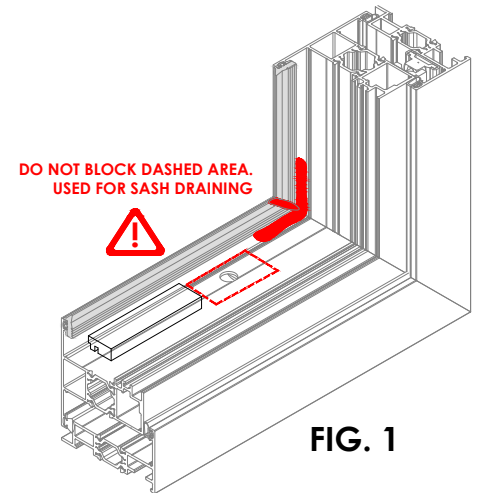
- Check operation of the window by opening and closing multiple times.
- Cut horseshoe shims flush to interior/exterior frame surface.
- Clean perimeter of the frame where seal will be applied using **IPA 2 METHOD**.
- Apply Interior/Exterior seal around the frame and tool. See **FIG. 7**
- Seal all the screw heads.



**FIG. 7**

STEP 1

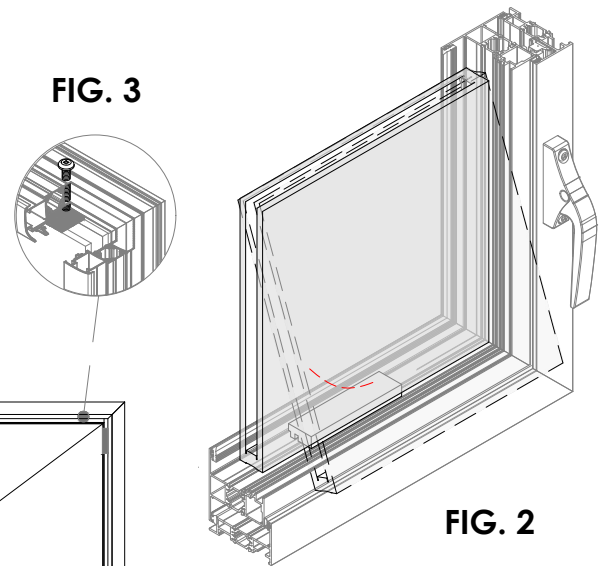
- Carefully remove glass stops around the interior perimeter of the sash.
- Ensure exterior gasket is not wavy.
- Clean 2" around each corner at glazing fin by using IPA2 METHOD.
- Apply a bed of sealant 2" around each corner of the sash ensuring it comes in contact with exterior glazing gasket.
- Apply a dab of sealant to the glazing gasket joint. See **FIG. 1**



**FIG. 1**

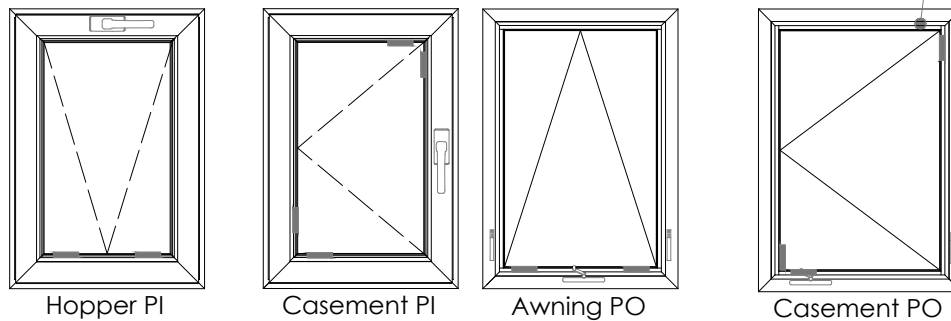
STEP 2

- Inspect glass unit for any sealant overlap, clean in necessary. Using IPA2 method clean 2 inches of interior/exterior glass surface all around the perimeter.
- Place setting blocks at each corner, approximately 4-6 inches from the corner. Dab of sealant can be used to hold it in place. **DO NOT BLOCK WEEP HOLES.** See **FIG. 1 & FIG. 4**
- Carefully slide the glass into glazing pocket at the top, set the glass onto the Setting Blocks and center the glass into the sash opening. See **FIG. 2**
- Ensure sight lines are even on all sides, sash must be square.
- Place PVC shim used for Adjusting Screw for Casement Out-swing only. Adjust screw to be snug. See **FIG. 3** (comes pre-installed)



**FIG. 3**

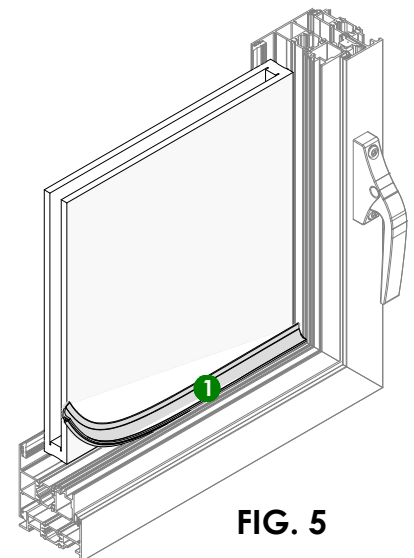
**FIG. 2**



**FIG. 4**

STEP 3

- Cut airseal gasket  $\frac{1}{4}$  longer per foot to avoid shrinkage at a later stage.
- Temporarily install glass stop at the head, to prevent glass from falling out.
- Starting at the sill, insert airseal gasket starting from one end, repeat this every 16 inches. Ensure opposite end of the gasket is inserted before rolling remaining gasket. Water with soap can be used to aid with gasket installation. See **FIG. 5**
- Ensure airseal gasket is fully inserted by checking for any bumps or waviness.

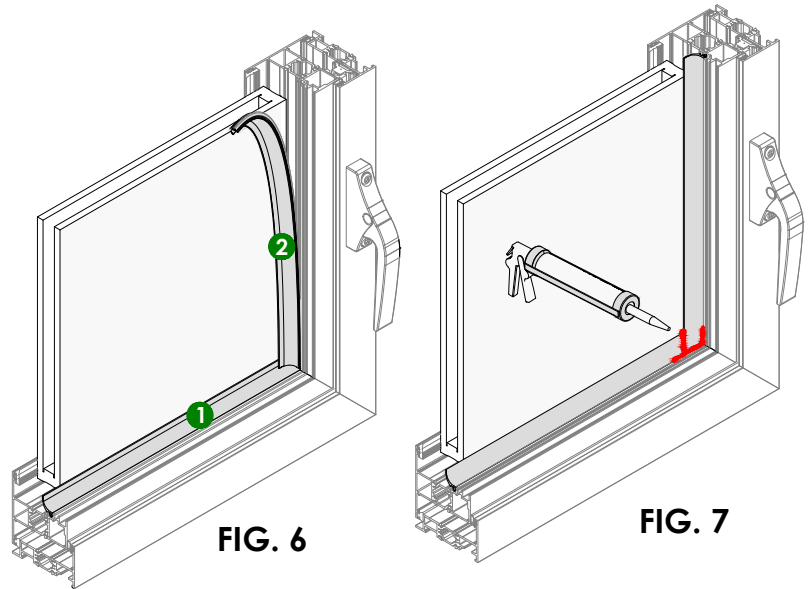


**FIG. 5**

**NEXT PAGE**

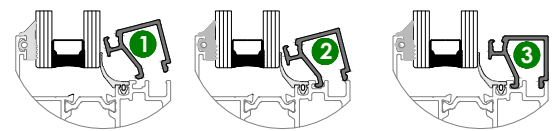
STEP 3 (continued)

- e. Repeat step "d" by inserting vertical airseal gasket ensuring it overlaps the gasket at the sill. Finally insert gasket at the head overlapping gaskets at both side. See **FIG. 6**
- f. Clean gasket corners with IPA2 method.
- g. Using a tooling stick peel back overlapping gasket and apply sealant in-between gaskets, and around the corner to prevent air leakage. See **FIG. 7**

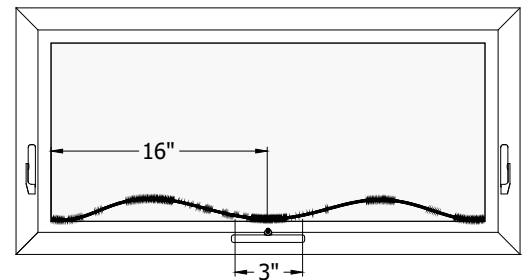


STEP 4

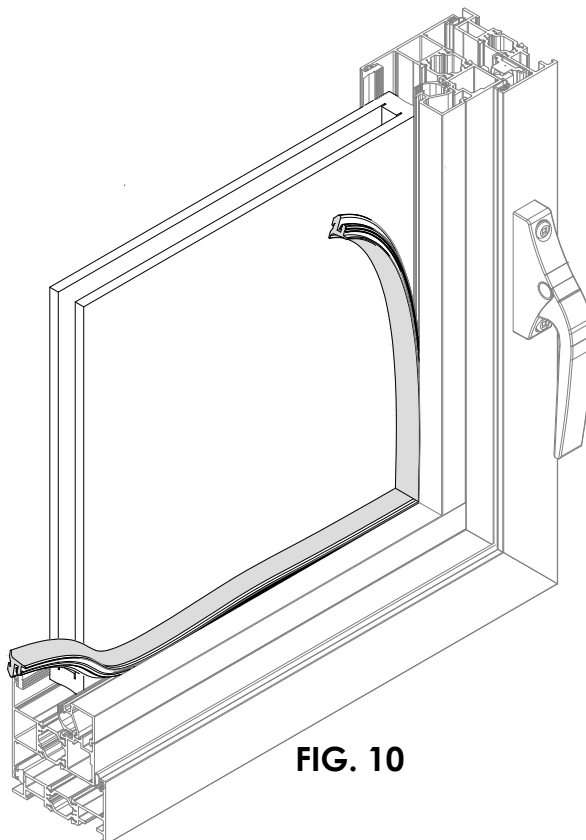
- a. Reinstall Glass Stops, starting with horizontals first. See **FIG. 8**
- b. Cut glazing gasket  $\frac{1}{4}$  inch longer per foot to avoid any shrinkage. See **FIG. 9**
- c. Insert glazing gasket starting from one end, repeat this every 16 inches. Ensure opposite end of the gasket is inserted before rolling remaining gasket. See **FIG. 10**. Ensure glazing gasket is pressing against airseal gasket. See **FIG. 11**



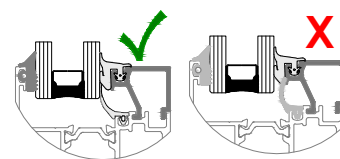
**FIG. 8**



**FIG. 9**



**FIG. 10**

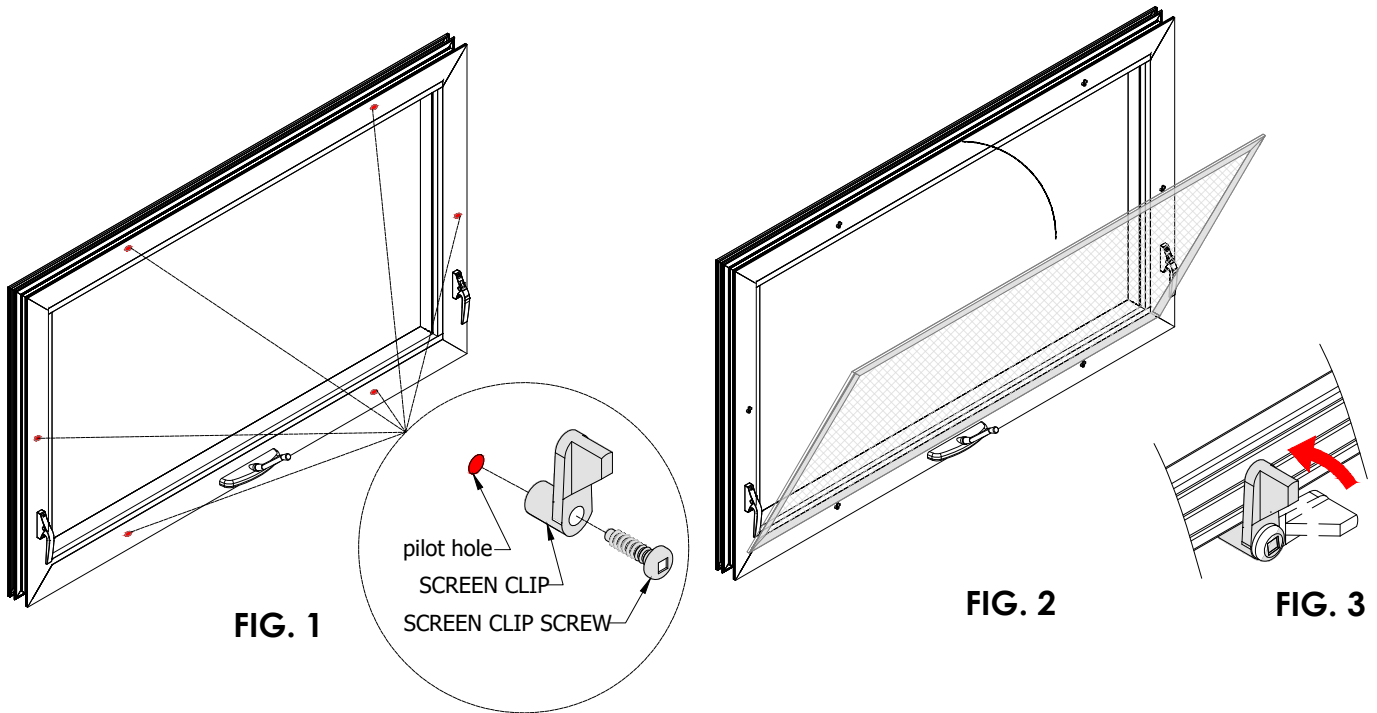


**FIG. 11**





**STEP 1**

- Install supplied screen clips & fasteners on all the pre-drilled pilot holes. See **FIG. 1**
- Ensure screen clip is snug and free to rotate.
- Insert supplied screen frame in between the screen clips. See **FIG. 2**
- Rotate screen clips to lock the screen frame in place. See **FIG. 3**

SCREEN CLIP SCHEDULE		
Screen HEIGHT	Screen WIDTH	
	W<48"	W>48"
H<48"	4x	6x
H>48"	6x	8x

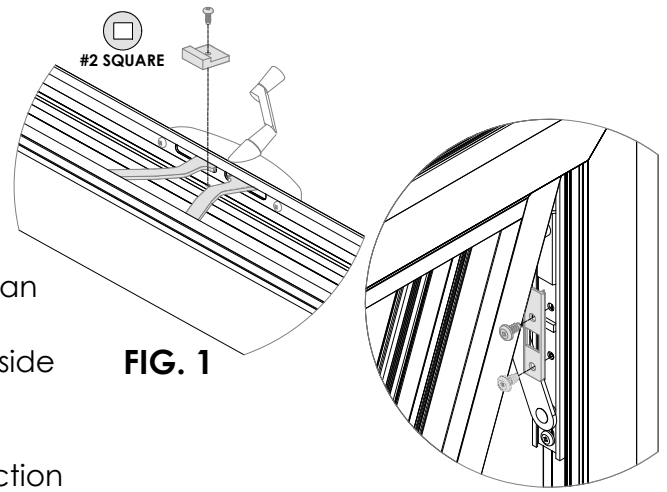


**Insect Screen Components**

 SHIP LOOSE	 SHIP LOOSE	 SHIP LOOSE	 SHIP LOOSE
<b>1159101</b> <b>5/16" SCREEN TURN CLIP</b> (used on PO with ROTO hardware)	<b>7248101</b> #8 x 1 1/2" PHS, SS	<b>1159301</b> <b>1" SCREEN TURN CLIP</b> (used on PI and PO with wickets)	<b>7243101</b> #8 x 1 3/8" PHS, SS

**LIMIT BLOCK  
REMOVAL/REINSTALL**

- Open sash using ROTO operator.
- Locate LIMIT BLOCK next to ROTO arms
- Remove fastener by using #2 SQUARE DRIVE
- Prior to reinstalling LIMIT BLOCK apply sealant into fastener hole
- Place LIMIT BLOCK back into its place, fasten using #2 SQUARE DRIVE. See **FIG. 1**

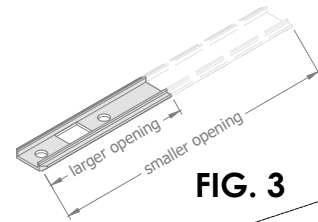


**FIG. 1**

**FIG. 2**

**FRICION ARM LIMIT DEVICE  
REMOVAL/REINSTALL**

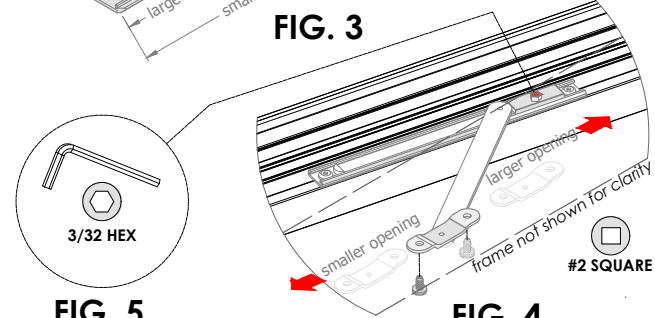
- Vents equipped with FRICTION ARM LIMIT DEVICE can be removed to aid with anchor screw installation.
- Open sash to the maximum, locate LIMIT DEVICE inside of the Friction Arm, if applicable. See **FIG. 2**
- Remove 2 #10 fasteners holding LIMIT DEVICE.
- Temporarily place same fasteners back into the Friction Arm securing the hinges.
- If larger opening is desired trim LIMIT DEVICE as needed. See **FIG. 3**. Once installation and any adjustments are complete, bring sash to the original opening and install LIMIT DEVICE into its place.



**FIG. 3**

**CASEMENT FRICTION  
ADJUSTOR/LIMITER**

- Open sash, locate Friction Adjustor bracket located on the frame.
- Remove 2 fasteners holding the bracket on the frame side. See **FIG. 4**
- Sash can be opened to the full extend for any maintenance or installation work.
- Over time friction must be adjusted, this can be done by using 3/32 HEX KEY, adjusting screw is located on top of sliding shoe within the track. See **FIG. 5**
- Reinstall the bracket to its place using original fasteners.

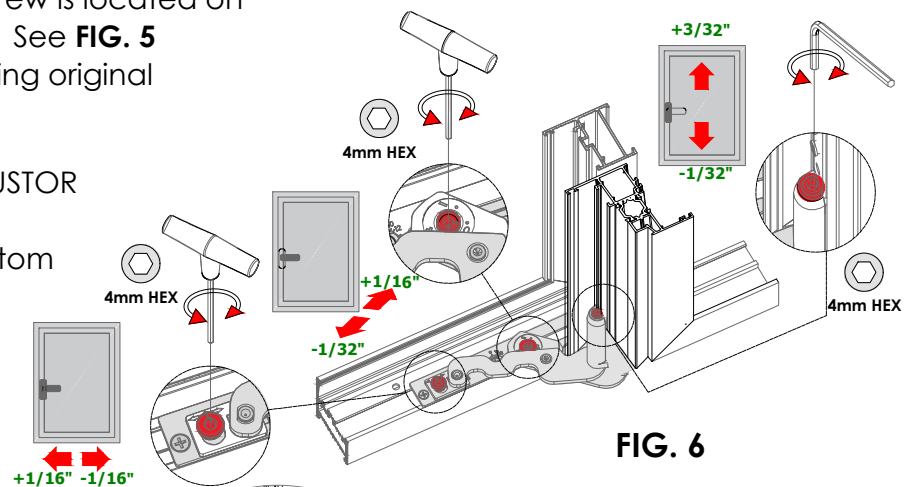


**FIG. 5**

**FIG. 4**

**PI CASEMENT HINGE  
ADJUSTMENT (EGRESS)**

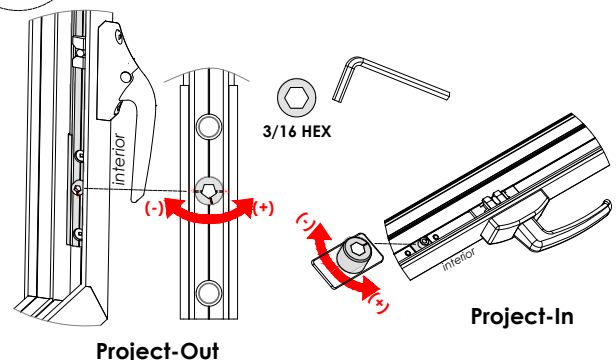
- Open sash, remove FRICTION ADJUSTOR if applicable
- Locate adjusting screws at the bottom and the top hinge.
- Using 4mm HEX KEY adjust hinge if needed as per **FIG. 6**
- Reinstall FRICTION ADJUSTOR.
- Close sash and check for any interferences.



**FIG. 6**

**MPL COMPRESSION  
ADJUSTMENTS**

- To adjust compression open the sash and locate MPL lock points.
- Using 3/16 HEX KEY adjust cam bolts. **FIG. 7**
- Lock the handle, sash must compress up to 1/8" from the initial surface contact with the bulb seal.



**FIG. 7**

**Project-Out**

**Project-In**