

# **400 THERMAL BARRIER**

## **FRAMING SYSTEM FOR 1" INSULATED GLASS SILICONE GLAZED MEMBERS**

### **SUPPLEMENTAL INSTALLATION INSTRUCTIONS :**

These instructions cover typical installation procedures for the 400 Series Curtain Wall Silicone Glazed framing system. Refer to Wausau standard 400 Series Installation Instructions (P1887-1 & 2) for procedures and instructions not given herein.

These instructions cover typical installations and are meant to provide a guide for competent glaziers. It is impossible to address every field condition with these instructions. The user should refer to the approved shop drawings for non-typical conditions.



**WAUSAU**

WINDOW AND WALL  
SYSTEMS

400 Series Curtainwall Installation Instructions  
1" Insulated Glass (Silicone Glazed) P-1889

## 400 Series (Butt-Glazed) Curtainwall

1. THESE DRAWINGS AND NOTES COVER TYPICAL CONDITIONS FOR THIS PRODUCT. DUE TO INDIVIDUAL PROJECT REQUIREMENTS, IT IS NECESSARY TO REFER TO THE FINAL APPROVED SHOP DRAWINGS FOR SUPPLEMENTAL INFORMATION NOT COVERED BY THESE INSTRUCTIONS. ANY CONFLICT OR DISCREPANCIES MUST BE CLARIFIED THROUGH WAUSAU'S ENGINEERING DEPARTMENT PRIOR TO EXECUTION.
2. MATERIALS STORED AT JOBSITE MUST BE STORED IN A SAFE PLACE WELL REMOVED FROM POSSIBLE DAMAGE BY OTHER TRADES. STACK WITH ADEQUATE SEPARATION SO MATERIAL 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 RECORDS OF WHERE VARIOUS MATERIALS ARE STORED.
3. ALL FIELD WELDING MUST BE ADEQUATELY SHIELDED TO AVOID SPATTER ON EITHER ALUMINUM OR GLASS. RESULTS WILL BE UNSIGHTLY AND/OR STRUCTURALLY UNSOUND. ADVISE GENERAL CONTRACTOR AND OTHER TRADES ACCORDINGLY.
4. COORDINATE PROTECTION OF INSTALLED WORK WITH GENERAL CONTRACTOR AND/OR OTHER TRADES. ALUMINUM FINISHES MUST BE PROTECTED FROM THE ACTION OF HARSH ALKALIES AND SAND IN STUCCO, MORTAR OR PLASTER. THE SETTING OF THIS ALUMINUM PRIOR TO THE SETTING OF OTHER MATERIALS REQUIRES THE CONTRACTOR TO CLOSELY SUPERVISE OTHER TRADES SO AS TO PREVENT MARRING OR DISCOLORATION FROM ANY CAUSE. TUBELITE WILL ASSUME NO RESPONSIBILITY FOR DAMAGE TO FINISHES CAUSED BY THE MATERIALS INDICATED ABOVE OR BY CLEANING AGENTS NOT SUITABLE FOR CONTACT WITH THE ALUMINUM FINISHES.
5. COORDINATE SEQUENCE OF OTHER TRADES WHICH AFFECT CURTAINWALL INSTALLATION WITH THE GENERAL CONTRACTOR (I.E. FIREPROOFING, BACK-UP WALLS, PARTITIONS, CEILINGS, MECHANICAL DUCTS, CONVECTORS, ETC.).
6. GENERAL CONTRACTOR SHOULD FURNISH AND GUARANTEE BENCH MARKS, OFFSET LINES, AND OPENING DIMENSIONS. THESE ITEMS SHOULD BE CHECKED FOR ACCURACY BEFORE PROCEEDING WITH ERECTION. MAKE CERTAIN CONSTRUCTION WHICH WILL RECEIVE YOUR MATERIALS IS ACCORDING TO CONTRACT DOCUMENTS. IF NOT, NOTIFY THE GENERAL CONTRACTOR IN WRITING BEFORE PROCEEDING WITH YOUR WORK SINCE THIS CONSTITUTES AN ACCEPTANCE OF WORK BY OTHER TRADES. IF PRESETTING OF ANCHORS IS REQUIRED, COORDINATE WITH THE GENERAL CONTRACTOR AND SUPERVISE LOCATIONS.
7. INSULATE ALL ALUMINUM TO BE PLACED IN DIRECT CONTACT WITH MASONRY OR OTHER INCOMPATIBLE MATERIALS WITH A HEAVY COAT OF ZINC CHROMATE OR BITUMINOUS PAINT.

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8. SPECIFIC TYPES OF SEALANTS ARE CALLED FOR IN THESE INSTRUCTIONS DUE TO COMPATIBILITY WITH DIFFERENT MATERIALS. SEALANTS OTHER THAN THOSE SPECIFICALLY CALLED FOR ARE THE RESPONSIBILITY AND OPTION OF THE ERECTOR OR GLAZIER AND MUST BE APPROVED BY THE SEALANT MANUFACTURER IN REGARD TO QUALITY AND COMPATIBILITY FOR ITS INTENDED USE.

FOR THE PURPOSES OF THESE DOCUMENTS, "SEALANT" OR "SILICONE" SHALL INDICATE MEDIUM MODULUS ONE-PART SILICONE RUBBER SEALANT. "BUTYL" SHALL INDICATE A NON-SKINNING, ONE-PART BUTYL SEALANT.

ALL SEALANTS MUST BE USED IN STRICT ACCORDANCE WITH MANUFACTURERS INSTRUCTIONS, APPLIED ONLY BY TRAINED PERSONNEL TO SURFACES WHICH HAVE BEEN PROPERLY PREPARED.

9. DRAINAGE GUTTERS AND WEEP HOLES MUST BE KEPT CLEAN AT ALL TIMES. WAUSAU CANNOT ACCEPT RESPONSIBILITY FOR IMPROPER DRAINAGE DUE TO CLOGGED GUTTERS OR WEEP HOLES.
10. ALL MATERIALS TO BE INSTALLED PLUMB, LEVEL, AND TRUE WITH REGARD TO ESTABLISHED BENCH MARKS AND COLUMN CENTER LINES ESTABLISHED BY THE GENERAL CONTRACTOR AND CHECKED BY THE CURTAINWALL CONTRACTOR.

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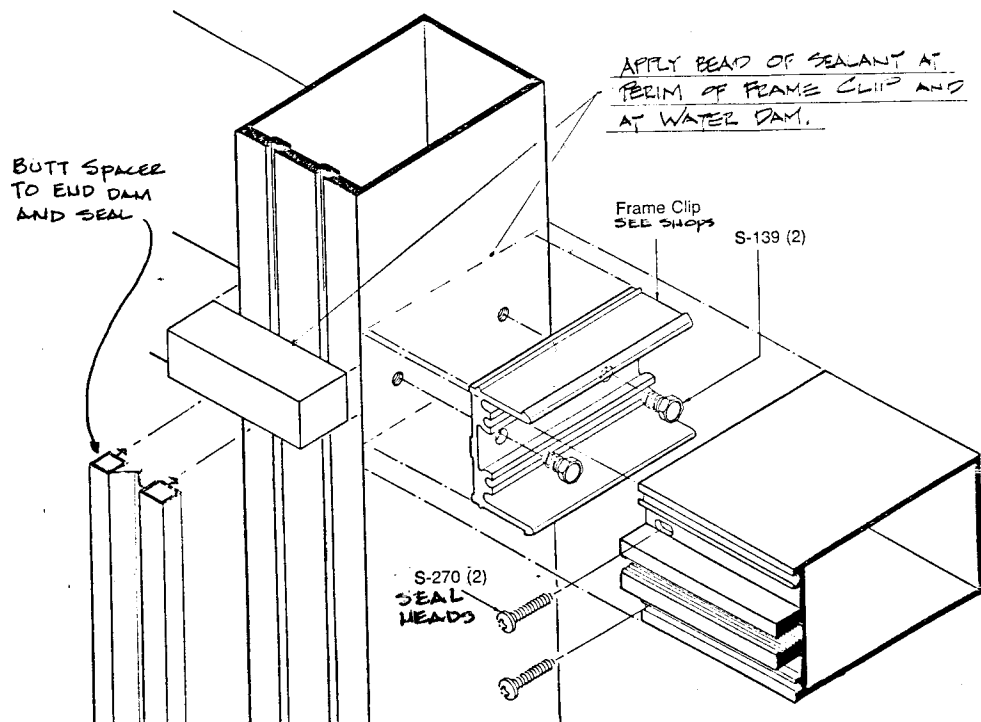
## 400 SERIES (BUTT GLAZED) CURTAINWALL

### END DAM INSTALLATION

FOAM END DAMS (PTB76A FOR 1/4" GLASS OR PTB76B FOR 1" GLASS) ARE DESIGNED FOR COMPRESSION FIT BETWEEN THE SCREW SPLINES ON THE HORIZONTAL MEMBERS. DO NOT CUT THESE PIECES SMALLER THAN SUPPLIED.

SET THE FOAM BLOCK IN A BED OF BUTYL SEALANT SO THAT THE BLOCK IS SEALED TO BOTH THE HORIZONTAL AND VERTICAL MULLION.

REFER TO FIGURE 1.



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## 400 SERIES (BUTT GLAZED) CURTAINWALL

### HORIZONTAL SNAP COVER INSTALLATION

APPLY A BED OF BUTYL SEALANT TO THE FRONT OF THE END DAM WHICH WAS INSTALLED PER THE PREVIOUS STEP. THIS SEAL IS NECESSARY FOR SEALING THE HORIZONTAL PRESSURE PLATE TO THE END DAMS.

SET THE GLASS.

FASTEN THE HORIZONTAL PRESSURE PLATES AS INDICATED ON THE APPROVED SHOP DRAWINGS. SEAL THE SCREW HEADS WITH SILICONE.

BEFORE INSTALLING THE SNAP COVER, INSERT THE FORMED ALUMINUM SPLICE IN A BED OF BUTYL BASED SEALANT TO ONE END OF THE SNAP COVER. THEN INSTALL THIS COVER.

BEFORE INSTALLING THE ADJACENT COVER, APPLY A BED OF BUTYL SEALANT TO THE EXPOSED END OF THE SNAP COVER SPLICE. DO NOT COVER THE PRE-INSTALLED BOND BREAKER TAPE. INSTALL THIS COVER.

SEAL THE GAP BETWEEN THE SNAP COVERS WITH SILICONE. THIS SEAL SHOULD BE A "BAND-AID" TYPE SEAL AS INDICATED IN FIGURE 2. TOOL.

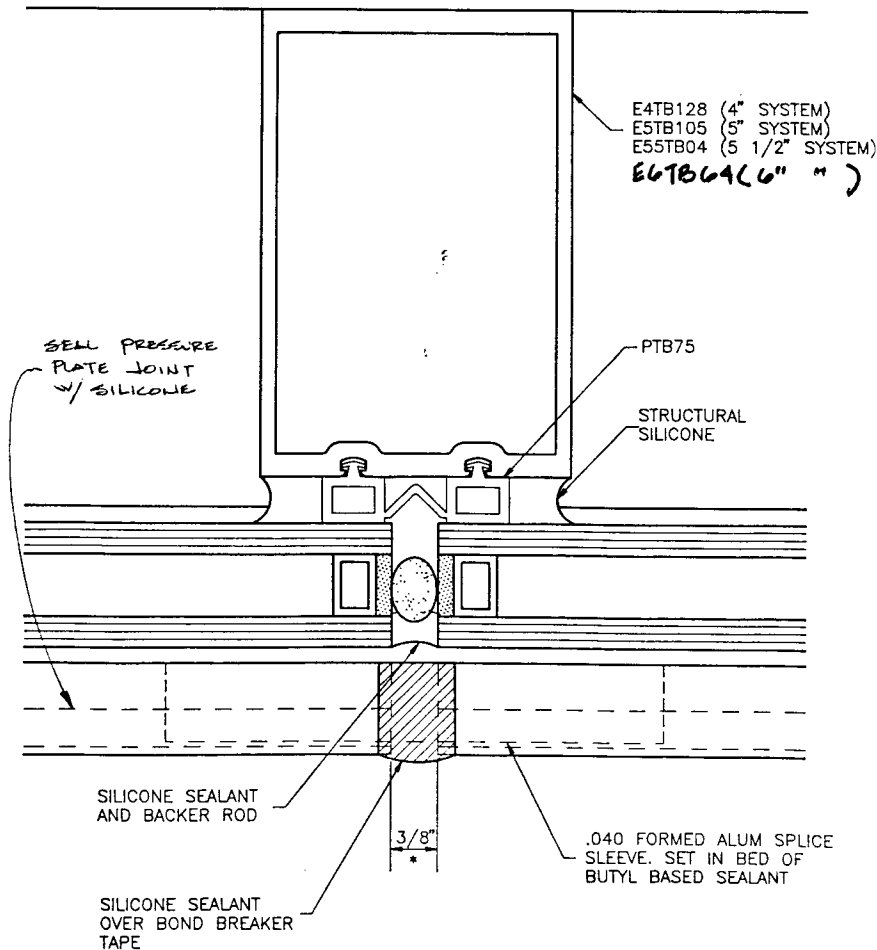


FIGURE 2

# 400 Series (Butt-Glazed) Curtainwall

## 400 SERIES (BUTT GLAZED) CURTAINWALL VERTICAL MULLION SPLICE

### FABRICATION

CUT TWO PIECES OF E1017 TO 10" LONG FOR EACH SPLICE REQUIRED.

ASSEMBLE THE PARTS TO THE PROPER DEPTH AS INDICATED IN FIGURE 3 AND TABLE 1 (BELOW).

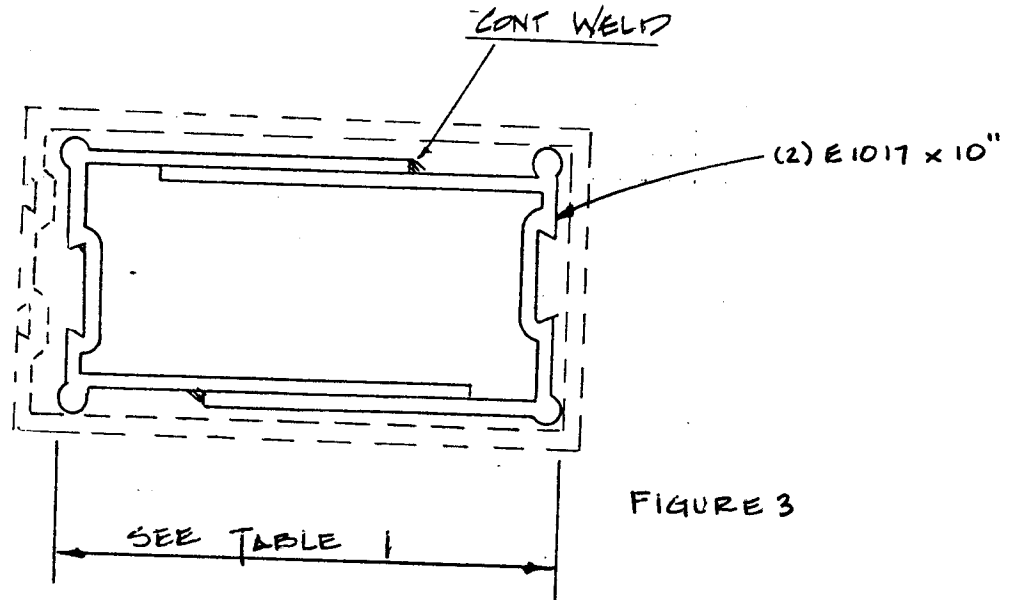


TABLE 1

MULLION	SPLICE DIMENSION
E-4TB-128	3 <sup>3</sup> / <sub>16</sub> "
E-5TB-105	4 <sup>3</sup> / <sub>16</sub> "
E-55TB-04	4 <sup>1</sup> / <sub>16</sub> "
E-6TB-64	5 <sup>3</sup> / <sub>16</sub> "

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FABRICATION OF MULLION SPLICE (continued)

WELD PARTS AS INDICATED, AND APPLY TWO STRIPS OF P1353 BOND BREAKER TAPE AS INDICATED IN FIGURE 4 (BELOW).

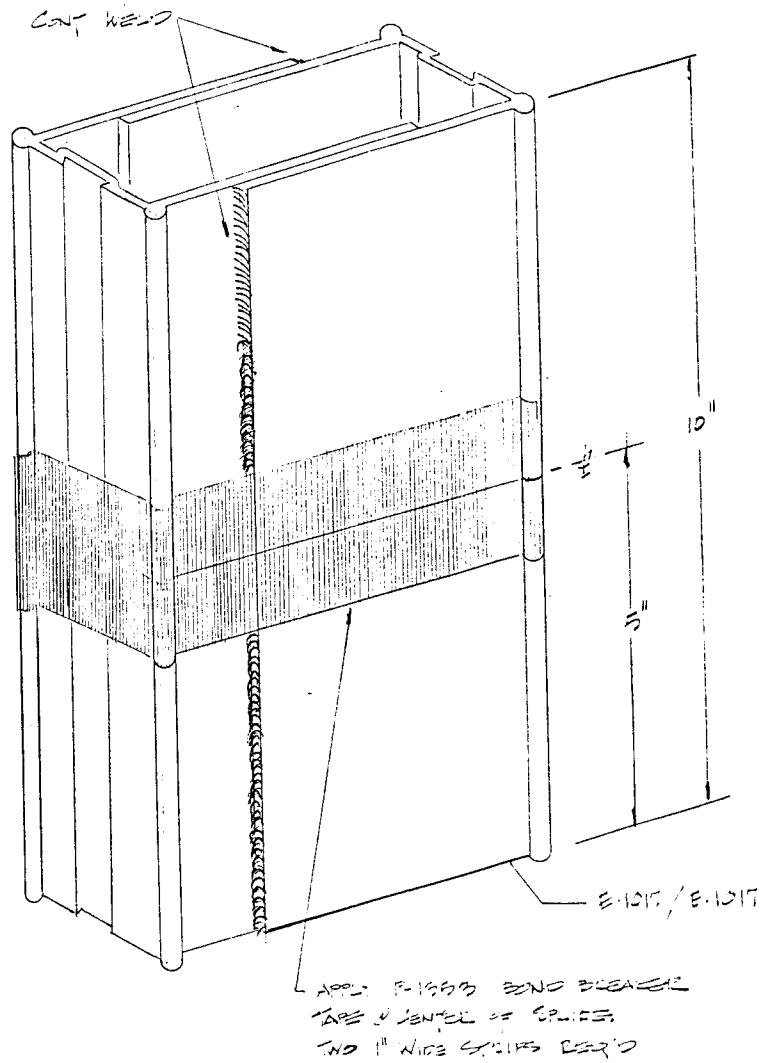


FIGURE 4

# 400 Series (Butt-Glazed) Curtainwall

## INSTALLATION OF SPLICE

SLIDE SPLICE ASSEMBLY INTO LOWER MULLION AND FASTEN AS INDICATED ON THE APPROVED SHOP DRAWINGS / CALCULATIONS.

SEE FIGURE 5.

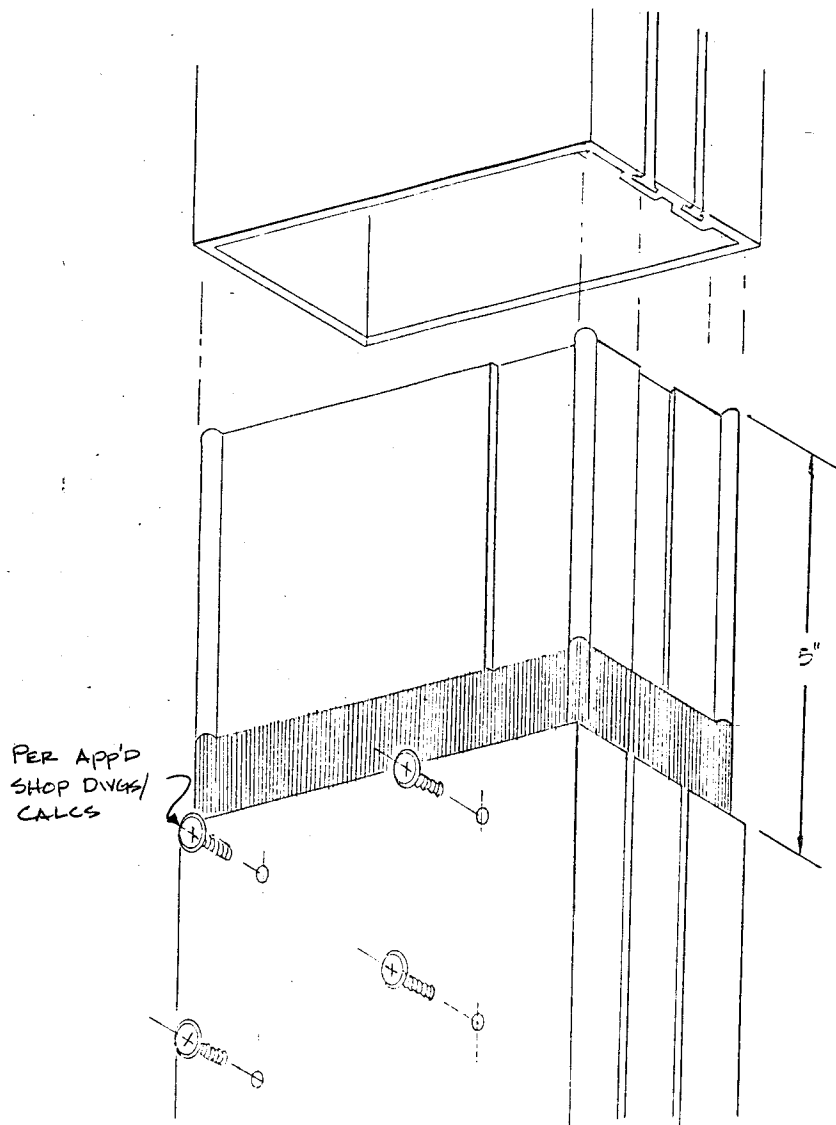


FIGURE 5.

# 400 Series (Butt-Glazed) Curtainwall

## INSTALLATION OF SPLICE (continued)

SLIDE UPPER MULLION ONTO LOWER MULLION AND ANCHOR AS INDICATED ON THE APPROVED SHOP DRAWINGS / CALCULATIONS. SET THE GAP BETWEEN MULLIONS AS PER THE DRAWINGS.

SEE FIGURE 6.

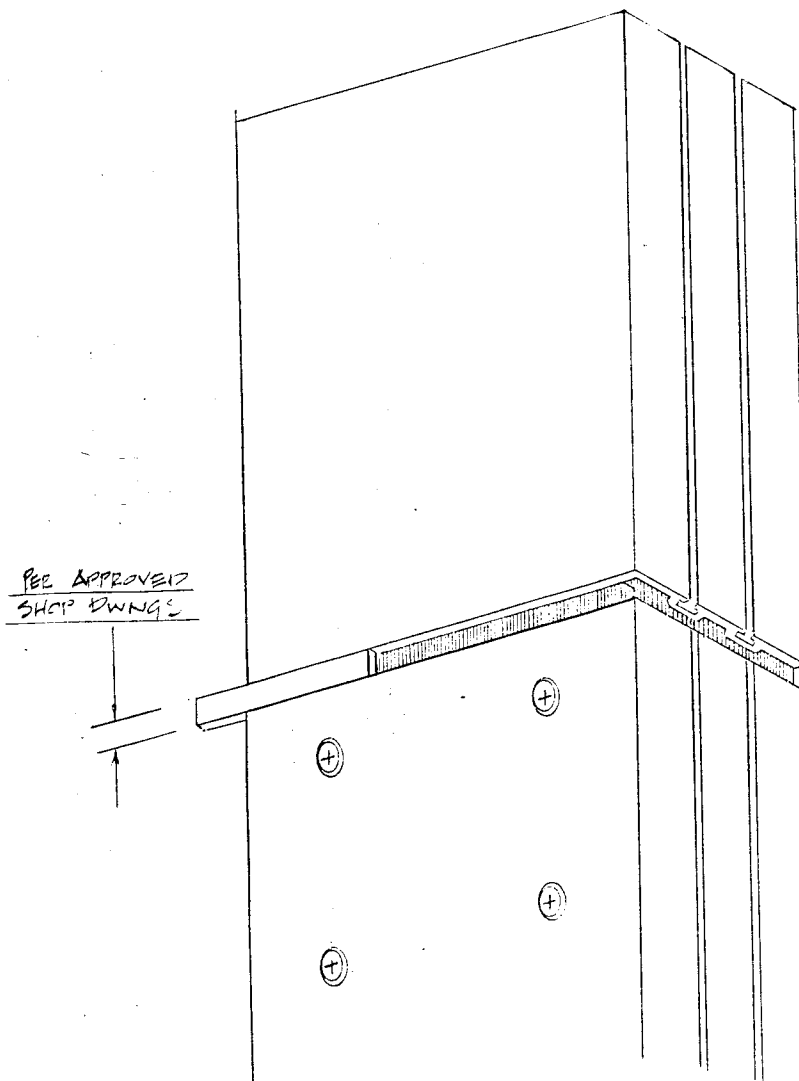


FIGURE 6

# 400 Series (Butt-Glazed) Curtainwall

INSTALLATION OF SPLICE (continued)

SEAL THE MULLIONS OVER THE BOND BREAKER TAPE WITH SILICONE. TOOL.

SEE FIGURE 7.

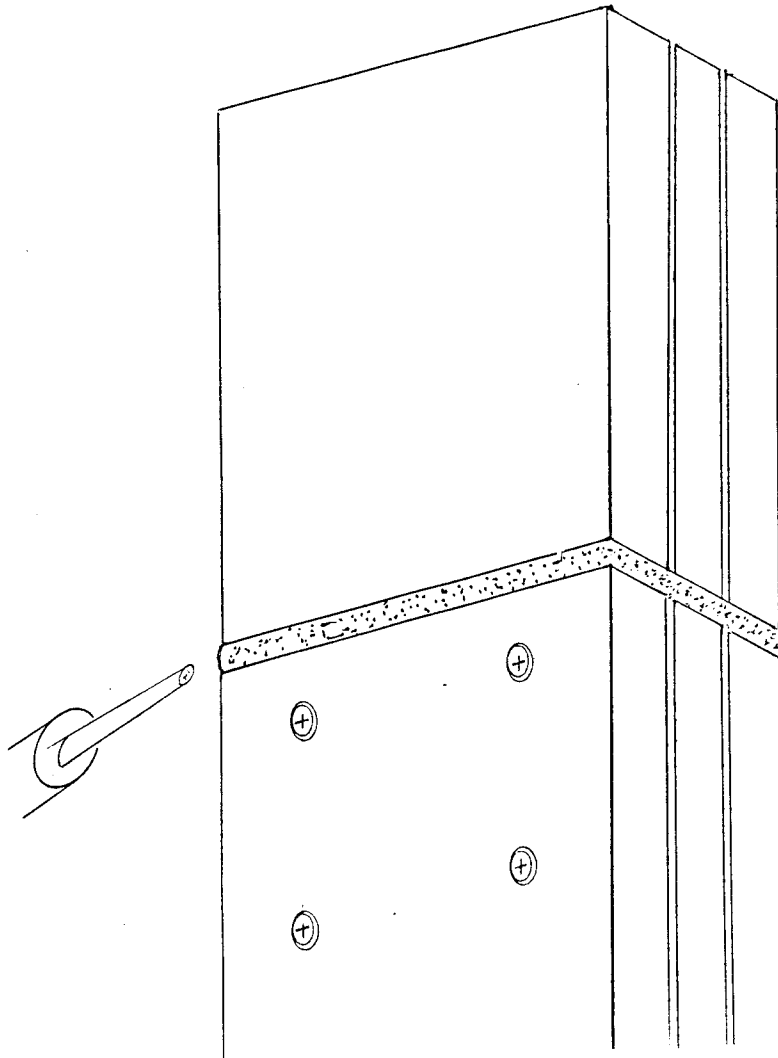
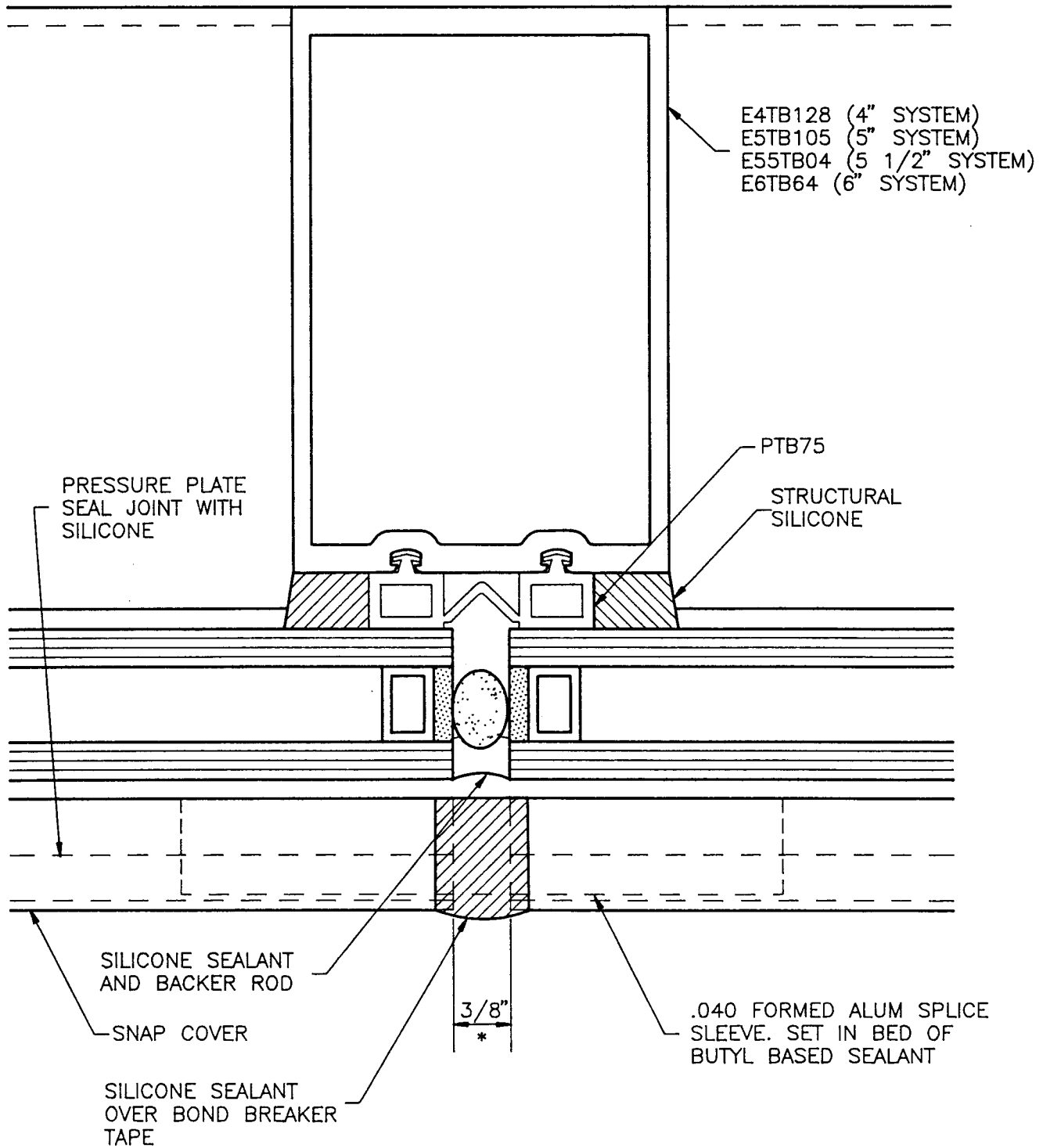


FIGURE 7

# 400 Series Curtainwall BUTT GLAZED MULLION



(\* ) OR PER APPROVED SHOP DRAWINGS

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## Silicone Glazed Horizontal

CAD DETAIL FILE NO.  
290HORZ1

