INSTALLATION INSTRUCTIONS
2-1/2” x 7-5/16” for 1-5/16” Glass
-- Wet and Dry Glazed

Captured System
(Shown)
PRODUCT FEATURES: PW257 and PW257 B.G.

**Glazing Features:**
- Dry Glazed with Sentry Glass Interlayer by DuPont®

**Screw spline joinery allows:**
- Coral Punch die shop fabrication
- Die set punches spline and pressure bar weep holes
- Panelized frame assembly for easy transporting and installation

**Pressure Bars:**
- Factory installed EPDM thermal isolator with attachment holes pre-punched 9" O.C.
- Attached to back members with #12 x 1-1/4" HWH #3 self-drilling screws

**Removable snap-on interior trim covers at all horizontals allow:**
- Anchor inspection to substrate after glazing
- Inspection and/or repair of critical joint seal areas prior to and after glazing

**EVA foam end dams and bridges at horizontals provide:**
- Tight seals at intersection of vertical/horizontal joints for zone glazing

**Aluminum top and bottom vertical mullion caps:**
- Provides continuous perimeter seal

**Injection molded plastic temporary glazing retainer:**
- Reduces labor
- Distributes uniform pressure on glass reducing risk of breaking glass
- Reusable for next project
These instructions are for typical installations. Reference shop drawings for special notations on installations and glazing.

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INSTALLATION INSTRUCTIONS
- General Notes -

Recommended guidelines for all installations:

1. REVIEW CONTRACT DOCUMENTS. Check shop drawings, installation instructions, architectural drawings and shipping lists to become thoroughly familiar with the project. The shop drawings take precedence and include specific details for the project. Field verified notations shown within shop drawings must be resolved prior to installation. The installation instructions are of general nature and cover most conditions.

2. INSTALLATION. All materials shall be installed plumb, level and true.

3. BENCHMARKS. All work should start from established benchmarks and column center lines established by the architect and general contractor.

4. FIELD WELDING. All field welding must be adequately shielded to avoid any splatter on glass or aluminum. Advise general contractor and other trades accordingly. All field welds of steel anchors must receive touch-up paint (zinc chromate) to avoid rust.

5. SURROUNDING CONDITIONS. Make certain that construction which will receive your materials is in accordance with the contract documents. If not, notify the general contractor in writing and resolve differences before proceeding with work.

6. ISOLATION OF ALUMINUM. Aluminum to be placed in direct contact with uncured masonry or incompatible materials should be isolated with a heavy coat of zinc chromate or bituminous paint.

7. SEALANTS. Sealants must be compatible with all materials with which they have contact, including other sealant surfaces. Sealants depicted in this manual as critical seals and sealants shown as structural are Dow Products®. Consult with sealant manufacturer for recommendations relative to joint size, shelf life, compatibility, cleaning, priming, tooling, adhesion, etc. It is the responsibility of the Glazing Contractor to submit a statement from the sealant manufacturer indicating that glass and glazing materials have been tested for compatibility and adhesion with glazing sealants, and interpreting test results relative to material performance, including recommendations for primers and substrate preparation required to obtain adhesion. The chemical compatibility of all glazing materials and framing sealants with each other and with like materials used in glass fabrication must be established.

8. FASTENING. Only those fasteners used within the system are specified in these instructions. Due to the varying perimeter conditions and performance requirements perimeter fasteners are not specified in these instructions. Reference the shop drawings or anchor charts for perimeter fasteners.

9. BUILDING CODES. Due to the diversity in state, local and national codes that govern the design and application of architectural products, it is the responsibility of the architect, owner and installer to assure that products selected for use on each project comply with all applicable building codes and laws. CORAL ARCHITECTURAL PRODUCTS exercises no control over the use or application of its products, glazing materials and operating hardware and assumes no responsibility thereof.

10. EXPANSION JOINTS. Expansion joints and perimeter seals shown in these instructions and shop drawings are shown at normal size. Expansion mullion gaps should be based on temperature at time of installation.
11. WATER HOSE TEST. After a representative amount of the curtain wall system has been glazed (250 square feet) and the sealant has cured, a water hose test should be conducted in accordance with AAMA 501.2 specifications to check the installation. This test should be repeated every 500 square feet during the glazing operation. Note: This test procedure should not be used for entrance doors.

12. COORDINATION WITH OTHER TRADES. Coordinate with the general contractor and sequence with other trades items which offset the storefront installation such as back-up walls, partitions, ceilings and mechanical ducts.

13. MATERIAL HANDLING:
   A. SHOP
      1. Cardboard wrapped or paper interleaved material must be kept dry.
      2. Should cardboard or paper interleave material get wet, remove immediately from aluminum to prevent staining or etching of aluminum finish.
      3. Check arriving materials for quantity and keep record of where various materials are stored.

   B. JOB SITE
      1. Material at job site must be stored in a safe place well removed from possible damage by other trades.
      2. Cardboard wrapped or paper interleaved material must be kept dry. (See 13.A.2)
      3. Keep record of where various materials are stored.
      4. Protect materials after erection. Cement, plaster, mortar and other alkaline solutions are very harmful to the finish.

14. CARE AND MAINTENANCE. Final cleaning of exposed aluminum surfaces should be done in accordance with AAMA 609 and 610.02 for anodized and painted aluminum.

15. CORAL ARCHITECTURAL PRODUCTS. It is the responsibility of CORAL ARCHITECTURAL PRODUCTS to supply a system to meet the architect's specifications.

16. GLASS. Glazing gaskets are designed for a compression fit against glass and can accommodate (+/- 1/32”). Be sure to check overall size of glass and thickness.
1. SEALANTS. All sealants referenced in these instructions must be one part elastomeric silicone and must be applied according to the silicone manufacturer’s recommendations.

2. APPLICATION. Structural silicone must be applied from the interior and weatherseal from the exterior.

3. MAXIMUM ALLOWABLE STRESS ON SILICONE. The maximum allowable size of the glass lite is controlled by the width and depth of the silicone joint combined with the specified design wind load. The stress on the structural silicone must not exceed 20 PSI for a 6:1 safety factor. Check Structural Silicone Chart in the Architectural Design Manual for this product series (ASTM 1401-09).

4. ARCHITECT. It is the responsibility of the architect to secure approval of the system and request from the Glazing Contractor the compatibility and adhesion test reports described below.

5. GLAZING CONTRACTOR. It is the responsibility of the glazing contractor to submit a statement from the sealant manufacturer indicating that glass and glazing materials have been tested for compatibility and adhesion with glazing sealants and interpreting test results relative to material performance, including recommendations for primers and substrate preparation required to obtain adhesion. The chemical compatibility of all glazing materials and framing sealants with each other and with like materials used in glass fabrication must be established. This is required on every project.

6. CORAL ARCHITECTURAL PRODUCTS. It is the responsibility of Coral Architectural Products to supply a system to meet the architect’s specification.

PRODUCT APPLICATION AND INSTALLATION

Series PW257 Panelized Curtain Wall was designed with screw spline joinery for simple fabrication and panelized installation. These features make the fabrication and installation very similar to storefront systems. PW257 Panelized Curtain Wall should only be installed by glazing contractors employing personnel with the necessary installation and project management experience to handle these type projects.

PW257 Panelized Curtain Wall requires the installer to pay close attention to the details shown within these Instructions and General Notes. All critical seal areas must be completed as shown.
FRAME FABRICATION
Captured or B.G. Installation

Establish frame size and cut metal to length.

STEP 1.

Measure width of rough opening.
A. Measure opening at bottom.
B. Measure opening at center.
C. Measure opening at top.
   The frame width will be the smallest dimension less 1” allowing for a 1/2” minimum for shimming and caulking joint at each jamb.

Repeat process to determine frame height.
A. Beginning on left side of opening, measure dimension from top to bottom.
B. Repeat at center.
C. Repeat at right side of opening.
   The frame height will be the smallest dimension less 1” allowing 1/2” minimum for shimming and caulking joint at the head and sill.

STEP 2. Vertical Members
Cut vertical members to size. (All vertical members run through)
Wall jambs, intermediate verticals, snap-in perimeter jamb filler and corner mullions are cut to frame height.
A. Pressure bars are cut frame height minus (-) 1/4”.
B. Face covers are cut frame height minus (-) 1/16”.
C. Reference Pages 28-31 for vertical mullions with a splice joint.

STEP 3.

<table>
<thead>
<tr>
<th>Captured - Horizontals</th>
<th>B.G. - Horizontals</th>
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<tr>
<td>Cut horizontal members to size.</td>
<td>Cut horizontal members to size.</td>
</tr>
<tr>
<td>A. Head, sill and intermediate mullions are cut D.L.O.</td>
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</tr>
<tr>
<td>B. Pressure bars are cut D.L.O. minus (-) 1/4”.</td>
<td>B. Pressure bars run continuous between wall jambs.</td>
</tr>
<tr>
<td>C. Face covers are cut D.L.O. minus (-) 1/32”</td>
<td>C. Face covers run continuous between wall jambs.</td>
</tr>
<tr>
<td>D. Interior snap-on trim is cut D.L.O. minus (-) 1/32”</td>
<td>E. Horizontal glazing adaptors D.L.O. (-) 1/8”</td>
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</table>

Mullion spacing tolerance accumulation build up may become a problem on wide multi-bay elevations. Frequently check the cut lengths of head, sill and intermediate horizontal members prior to assembly to prevent tolerance build up. It is also good practice to check overall frame width every four or five bays during installation.
FRAME FABRICATION
Joinery Hole Locations

STEP 4.
Use DJ251 drill jig or PW251 Punch Die Set (same set used for PW251 System) for hole fabrication in verticals for attaching horizontals.

PW202
FILLER

PW650
VERTICAL MULLIONS

PW151

PW208

PW209

90º CORNER

Align drill with spline guide and drill 4 holes on angle

1-27/32"  41/64"

“F” (.257” Dia.)
Drill thru typ.

Top of Horizontal

5/16” Ø through bolt hole typ.
STEP 5.
Fabricate steel reinforcement where required. Cut steel the same length as vertical mullion (+0, -1/8”). Reference page 28 when mullions require splice joints.

Match drill holes in SR504 at center of each horizontal after inserting into corner mullion. See page 8, step 4.

Frame Fabrication
Steel Reinforcement

SR150
Steel for Vertical Mullions and Jambs

SR504
Steel for 90° Corner

Locate at center for each horizontal mullion or match drill after inserting into vertical mullion.

5/16” Ø hole typical

1 1/8”
FRAME FABRICATION
Head / Sill

STEP 6.
Fabricate head and sill anchor holes. Drill or punch one (1) ea. anchor hole located approximately 4” from each end of part. Hole should be centered on “V” groove located in extrusion. When two (2) or more fasteners are required, locate each additional fastener at minimum spacing as required for substrate.

**Note:** Hole Ø may vary depending on bolt size required for meeting job specific wind load conditions. Reference CAP anchor charts for typical conditions or shop drawings (if provided).

![Diagram of anchor bolt dimensions](image-url)

<table>
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<tr>
<th>ANCHOR BOLT Ø</th>
<th>DIMENSION “A”</th>
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<td>3/8”</td>
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<td>1/2”</td>
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STEP 7.
Fabricate for wall jamb using PW650, PW202 and PW613.

FRAME FABRICATION
Wall Jamb
(Left Hand Shown. Right Hand is opposite.)

Locate 8” long SR150-1 tapping plate at anchor location for multi-span conditions. Reference page 27, Detail “C”.

3/4” Access Hole as required at horizontal locations, determined by project conditions or shop drawings (if provided).
STEP 8.
Fabricate vertical and horizontal pressure bars.

Holes for attaching PW204-1 pressure bars are pre-punched at factory 9” on center. The 1/4” Ø holes located 1-1/2” from each end of pressure bar will need to be added as shown below. Drill hole on “V” groove line.

Note: Pressure Bars have 3 “V” grooves for locating weep holes. Center drill over middle groove to ensure hole is in correct location. Weep holes may be punched using PW251 Die Set in Coral Punch.

Note: Weep holes are always on top.

Note: Pressure Bars have 3 “V” grooves for locating weep holes. Center drill over middle groove to ensure hole is in correct location. Weep holes may be punched using PW251 Die Set in Coral Punch.

Note: It is very important to ensure that vertical pressure bars are cut short to prevent dislodging SP211 top & bottom mullion caps. Reference page 23, step 1.
FRAME FABRICATION
Pressure Bar - B.G.

STEP 9.
Fabricate vertical and horizontal pressure bars.

Holes for attaching PW204 pressure bars are pre-punched at factory 9” on center. The 1/4” Ø holes located 1-1/2” from each end of pressure bar will need to be added as shown below. Drill hole on “V” groove line.

Note: Weep holes are always on top.

Note: Pressure Bars have 3 “V” grooves for locating weep holes. Center drill over middle groove to ensure hole is in correct location. Weep holes may be punched using PW251 Die Set in Coral Punch.

Note: It is very important to ensure that vertical pressure bars are cut short to prevent dislodging SP211 top & bottom mullion caps. Reference page 23, step 1.
STEP 10. Captured Installation
Fabricate horizontal face covers for 1/4" Ø weep holes. Install covers with weep holes located on the underneath side.

STEP 11. B.G. Installation
Fabricate horizontal face covers for 1/4" Ø weep holes. Install covers with weep holes located on the underneath side when snapping on covers. See page 43 for splice joints.
FRAME ASSEMBLY
Gasket Installation
- - Wet Glaze - -

STEP 1.

Prior to assembly of frames, install the following gaskets into the fabricated framing members:

Back Members: **NG14**
Intermediate Pressure Bars: **NG10**
Perimeter Pressure Bars: **NG10** (against glass) and **NG11** (against aluminum)
(Reference Detail “A” on page 42).
Spacer gasket for B.G. Mullion: **NG14**

GASKET INSTALLATION PROCEDURES *(Do not stretch gaskets)*

1. Cut gaskets allowing for 1/8” extra length per foot of framing members to accommodate shrinkage.
2. **NG10** gaskets for vertical back members are cut D.L.O. plus 1-1/4”.
   (Reference Detail “A” on page 38).
3. **NG14** Vertical spacer gasket runs full length on PW151 B.G. mullion.
   Note: Section of gasket will be removed for bridge installation. (Reference Detail “B” on page 38).
4. Horizontal spacer gasket is cut to D.L.O. length.
5. Horizontal pressure bar: glazing gasket should extend 1/8” beyond end of pressure bar.
6. Vertical pressure bar: gasket runs full length.

---

**Fig. 1**
Head

**Fig. 2**
Horizontal Mullion

**Fig. 3**
Sill

**Fig. 4**
Wall Jamb

**Fig. 5**
Vertical Mullion - - Captured - -

**Fig. 6**
Vertical Mullion - - Butt Glazed - -
FRAME ASSEMBLY
Gasket Installation
- - Dry Glaze - -

STEP 1.

Prior to assembly of frames, install the following gaskets into the fabricated framing members:

Back Members: NG16
Intermediate Pressure Bars: NG10
Perimeter Pressure Bars: NG10 (against glass) and NG11 (against aluminum)
(Reference Detail “A” on page 42).
Spacer gasket for B.G. Mullion: NG16

GASKET INSTALLATION PROCEDURES (Do not stretch gaskets)

1. Cut gaskets allowing for 1/8” extra length per foot of framing members to accommodate shrinkage.
2. NG10 gaskets for vertical back members are cut D.L.O. plus 1-1/4”.
   (Reference Detail “A” on page 38).
3. NG16 Vertical spacer gasket runs full length on PW151 B.G. mullion.
   (Reference Detail “B” on page 38).
4. Horizontal spacer gasket is cut to D.L.O. length.
5. Horizontal pressure bar: glazing gasket should extend 1/8” beyond end of pressure bar.
6. Vertical pressure bar: gasket runs full length.
STEP 2.

GLAZING TAPE INSTALLATION PROCEDURES: Reference Step 3.

1. Cut SM5601 1/8" x 1/2" tack tape approximately 2-3/4" long.
2. Clean surfaces where tape is to be applied with isopropyl alcohol or solvent to remove all dirt and cutting oils. Allow surface to dry before applying tape.
3. Position tape on vertical mullions at horizontal joint intersections.
4. Just prior to frame assembly, remove protective cover and screw joints together.
5. Use a box knife to trim excess sealant tape where exposed. Do not pull tape to trim.
CAPTURED FRAME ASSEMBLY
Vertical to Horizontal Joinery

STEP 3.

Note: Reference page 38, Detail “A” for NG14 Gasket location in vertical.

PW202
Filler

AS16
Spline Screw (Typ.)

PW650
Vertical

PW652
Head

Anchor Hole
(Ref. page 10)

PW655
Horizontal

PW652
Sill

Critical Seal!
STEP 4.

B.G. MULLION FRAME ASSEMBLY
Vertical to Horizontal Joinery

PW202
Filler

AS16
Spline Screw (Typ.)

Critical Seal!

PW151
Vertical

Anchor Hole (Ref. page 10)

PW652
Head

PW655
Horizontal

PW652
Sill

Note: NG14
Spacer Gasket Runs through

Runs through Anchor Hole
(Ref. page 10)

Critical Seal!
STEP 5.

WALL JAMM ASSEMBLY
Vertical to Horizontal Joinery

Critical Seal!
Cap seal all anchors.

Note:
Apply bead of sealant under PW613 and attach to PW650 prior to installing into opening. Cap seal all anchors.
Critical seal areas!
OUTSIDE CORNER ASSEMBLY
Corner to Horizontal Joinery

STEP 6.

PW208
Female Half

AS16
Spline Screw (Typ.)

PW209
Male Half

PW652
Head

Anchor Hole
(Ref. page 10)

PW655
Horizontal

Critical Seal!

PW652
Sill
OUTSIDE CORNER ASSEMBLY
Corner Assembly Fasteners

STEP 7.

AS25
(#12 x 3/4" HWH #3 self drilling fastener) Locate 18" O.C. at front and back.

(1/4" Ø x 3" bolt with washer and nut)

PW656
90° Glazing “Tee”

(#12 x 1-1/4" HWH #3 self drilling fastener) Locate 18" O.C.

AS32

1/4” - 20 x 1-1/4” bolt with washer and nut

SR504
Steel inserted as required

Apply sealant full length prior to installing PW565 Glazing Tee.

Critical Seal!

Cap Seal.

Sealant

Sealant

Critical Seal!
MULLION CAP INSTALLATION
Captured and B.G.

STEP 1. Prior to installing frames into opening, install aluminum SP211 mullion caps at top and bottom of vertical members as shown below to ensure continuous perimeter seal.

**Note:**
Remove material on SP211 at raised line on wall jamb when required.

Seal reglets to 2” height. **Critical seal.**
Add sealant prior to installing

Completely remove vinyl seal after installing and seal glazing reglets on both sides of mullion to 2” height. **Critical seal!**
FRAME INSTALLATION
Panelized Assembly

STEP 2.
Install assembled frame panels into opening starting with jamb and continue working toward the last bay until the last panel is installed. Reference illustrations shown below for sequencing.

Note: Snap-in PW202 flat filler and PW613 pocket filler into jambs prior to installing. PW613 is difficult to install after jambs are installed due to limited work space.

Jamb

SP211 mullion cap omitted for clarity

Caution: Reference pages 17 and 20 for tape application.

Captured Mullions shown (Butt-Glazed Mullions similar)

Alternate Jamb

Note: 1/2” minimum caulk joint required for installation of last bay panel

Last Bay Jamb
STEP 3.

**Typical Jamb Installation**

- **Jamb Section**
  - Locate (1) 3/8" x 2" fastener at each intermediate horizontal when required for single span installation.
  - Drill 3/4" Ø access hole for installing fastener when required for single span installation to limit mullion deflection.

- **Head Section shown**

- **Anchor Hole** as required.
  - See **Anchor Charts** or shop drawings, if provided.

- **Note**: Location of caulk line. Perimeter sealant is done prior to glazing and installation of pressure bars and face caps.

- **Pocket Filler**
  - Install before positioning frame into opening.

- **Reference pages 11 and 20**

- **SP211**
  - Completely seal prior to installing.
  - AS2 #8 x 1/2" PPH

- **PW202**

- **PW650**

- **PW652**

- **PW613**

- **Note**: Reference **CAP Anchor Chart** or shop drawings (if provided) for anchor type and embedment depending on loads and substrate.
Details A and B show fixed (dead load) and expansion (wind load) anchors. Anchor type, size and quantity vary per job requirements. Details shown are to be used as a guide only. See approved shop drawings for actual conditions.

Step 1. Secure verticals to anchor clips after alignment has been completed.

Note: Mullion spacing must be held to within ± 1/32". Check overall frame dimension every four bays to monitor dimension build up.

**Fixed Anchor** (Dead Load Anchor)
- Nylatron pad
- Primary bolts with nuts, flat washer and lock washer
- Match drill holes after alignment has been completed.
- 1-1/2" min.

**Expansion Anchor** (Wind Load Anchor)
- Primary bolts with nuts, flat washer and lock washer
- Match drill holes after alignment has been completed.
- Nylatron pad
- Note: Many installations require anchors on both sides of mullions.
- 1-1/2" min.

Back off nut 1/4” turn after tightening to allow for thermal movement.
JAMB ANCHOR INSTALLATION
Multi-Span Condition

STEP 2.

Note: Details shown are to be used as a guide only. See approved shop drawings for actual conditions.

8" long SR150-1 Steel tap plate

Attach with AS27 (#12 1-1/2" PFH #3 self drill). Match drill tap plate and verticals with anchor after alignment has been completed. Tap threads to match 5/8" Ø bolt.

Primary bolt with lock washer. Size to match shop drawings, if provided.

1/16" Nylatron slip pad

Detail C
Fixed Anchor (Dead Load) shown

Note: Reference Detail B on page 26 for wind load anchor.
SPLICE DETAIL
Vertical Mullion - Multi-Span

STEP 3.
1. Clean splice sleeves and all joint surfaces. Apply bond breaker tape at areas where sleeve will be sealed to avoid three side adhesion.
2. Slide sleeve into the upper member before it is installed and use duct tape to hold it in retracted position.
3. Install AS25 stop screw 2-7/8" from top of lower member as shown below.
4. Install upper member, remove duct tape and let extruded sleeve slide down until it rests on top of stop screw.
5. Seal joint over sleeve as shown on Detail “F” (page 29). Stagger joints on back members, pressure bars and face covers.
SPLICE DETAIL
Vertical Mullion - Multi-Span

STEP 4.

Slope sealant to direct drainage between pressure bar and face cap (use backer rod as required).

Seal cover joint as shown (use backer rods as required).

Note: Reference page 44, Detail “B” for location of fastener on face cover at splices.

Install (2) AS25 (#12-14 X 3/4”) self drill fasteners as shown.
FRAME INSTALLATION
B.G. Splice Sleeve

STEP 1.

Apply bond breaker tape along face of splice.

Seal joint between mullions at face and splice.

Seal and tool joint between mullions. Seal to run across face, tongue and minimum 1-1/2" along sides of mullion.

Attach splice with **AS25** (#12-14 X 3/4") self drilling fasteners, (2) per side. (Fasteners required for dead load splice only. **Omit for expansion anchors**).

**PW207-1**
Splice sleeve

**PW208**

**PW209**

**PW211-1**
Splice sleeve
(2 Required)

**Detail G**

1/2" joint based on 1/4" live load.

2 3/4"
FRAME INSTALLATION
Splice Sleeve

STEP 1.

Insert backer rod into tongue of upper and lower mullions.

Seal joint between mullions. Seal to run across face, tongue and minimum 1-1/2" along sides of mullion.

1/2" joint based on 1/4" live load.

Apply bond breaker tape along face of splice.

Seal joint between mulls at face and splice.

Install splice sleeve to each side of mullion.

Attach splice with AS25 #12-14 x 3/4" self drilling fasteners, (2) per side. (Fasteners required for dead load splice only. Omit for expansion anchors).

1/2" min.

3/4" joint based on 1/4" live load.

1-1/2"

3/4"
FRAME INSTALLATION
Vertical Mullion Splicing

Note 1: Do not install fasteners on upper half for expansion anchors.

STEP 1
Insert backer rod between glass and tongue of mullion prior to installing pressure bars.

STEP 2
Seal between pressure bars.

STEP 3
When installing face caps leave 1/2" joint between caps. Note joint based on 1/4" expansion.

Reference page 44 for attaching covers to prevent slippage at splice locations.
FRAME INSTALLATION
Perimeter Sealant Locations
(Wet Glaze Shown)

STEP 1. Once all frames are installed and the system has been anchored to the substrate, apply weather seal around the entire perimeter. See details below for the correct location of the perimeter sealant and backer rod. Interior cosmetic seal is optional.

Note: Install perimeter caulking prior to installing glass and pressure bars.
FRAME INSTALLATION
End Dams

Critical Seal!
Apply sealant to all three contact surfaces prior to installation as shown.

Critical Seal!
Fill gasket reglet behind end dam with sealant.

STEP 1

Seal along tongue of horizontal across face and tongue of mullion before installing SP204 end dams.

STEP 2

Tool sealant along top of end dam to form a water tight seal.

STEP 3

Force sealant into gasket reglet.

Apply sealant to face of end dam just prior to installing vertical pressure bar.

Note:
SP204 End Dam required on all joints (head, sill, intermediate horizontals)

SP204 End Dam

Trim NG14 or NG16 to allow for fit of SP204
B.G. FRAME INSTALLATION

Bridges

STEP 1.

Critical Seal!
Apply sealant to all three contact surfaces prior to installation as shown.

NG14 Spacer gasket

Seal along tongue of horizontal and across face of mullion before installing SP208 bridge.

STEP 2.

Trim NG14 to allow for fit of SP208 Bridge.

 Completely seal around SP208 bridge and NG14 gasket as shown.

Tool sealant along top and sides of bridge to form a water tight seal.
GLAZING
Setting Block Installation

Locate two setting blocks on each sill and intermediate horizontal member as shown. Reference Dead Load Charts for this system in Architectural Detail book and/or shop drawings for correct location based on glass size.

SB18
(4” Long)
Setting Block
(2 per lite)

Confirm that Setting Block does not obstruct Weep Holes in PW204.
GLASS SIZE FORMULAS
Captured and B.G. Mullions

(Wet Glaze Shown)

Glass Sizes for Captured System:

Glass Width and Height = D.L.O. + 1-1/2 "

Glass Sizes for Butt Glazed System: (See Detail A below)

Glass Height = D.L.O. + 1-1/2 
Glass Width (Butt Glaze on Both Sides) = D.L.O. + 2"
Glass Width (Butt Glaze on One Side and Captured on the Other Side) = D.L.O. + 1-3/4"

Glass Width at 90° Corner:

With Captured Intermediate Vertical = D.L.O. + 1-1/2 "
With B.G. Intermediate Vertical = D.L.O. + 1-3/4"

Note: Glass tolerances are not addressed in the above formulas. Consult the glass manufacturer for glass tolerances prior to ordering. Structural silicone must be applied from the interior and weatherseal from the exterior.
Step 1.

Note:
NG14 Gasket
is cut D.L.O. + 1-1/4"

Note:
Vertical gaskets
do not run through.

Apply a 1" spot of Dow 995
to each intersection prior to
setting glass. Confirm that
sealant fills joints.

Note: NG14
spacer gaskets
do not run through.
Step 1.

**Note:**

**NG14 Gasket**

is cut D.L.O. + 1-1/4”

Apply a 1” spot of Dow 995 to each intersection prior to setting glass. Confirm that sealant fills joints.

**Note:**

Vertical gaskets do not run through.

**Note:**

**NG14 spacer gaskets** do not run through.
GLAZING
Glass Installation

Step 2.

Dry Glazed: Apply Dow 995 to each intersection and tool as glass is installed. Reference Detail A on page 38. NG16 joints must be completely sealed together and to glass.

Wet Glazed: Install glass and center in opening. Retain glass with SP253 temporary retainers. Retainers should remain in place until structural silicone has fully cured on B.G. Mullions.

Note: Remove temporary retainers one mullion at a time and install PW204-1 pressure bars. Do not rely on temporary retainers to hold glass for extended periods. SP253 temporary retainers should be saved and reused.

Apply sealant to face of end and bridge dams just prior to installing the pressure bars. Critical seal.

Leave SP253 temporary retainers on B.G. Mullion until silicone has cured. Then remove and apply exterior cosmetic seal.

Torque SP253 temporary glass retainer to 30 in. lbs. Do not over torque.

Note: For B.G. Installation, position smooth side of SP253 against glass. Use (#12-14 x 2") self drill screw to attach SP253 at B.G. Mullion. Do not use these fasteners for attaching PW204 pressure bars.
GLAZING
Pressure Bar Installation - Captured

Install AS32 vertical pressure bar fasteners from bottom to top and horizontal pressure bar fasteners from center outward. Make sure one fastener is located 1-1/2" maximum from vertical/horizontal joint intersections to ensure proper pressure over end dams. While installing pressure bar fasteners, take care not to disengage NG12 pressure bar spacer.

Step 1. Attach vertical pressure bars leaving a 1/8" gap at top and bottom with AS32 (#12 x 1-1/4" HWH #3 self-drilling fasteners). Using electrically powered hand held drill/driver, torque AS32 fasteners to 85-90 in. lbs. If using battery power tools, it is recommended that installer frequently check for accurate torque settings, as battery power will diminish over time.
Step 2. Center horizontal pressure bars in opening leaving a 1/8" gap at each end and attach.
Step 3. Upon completion of pressure bars installation and just prior to installing face covers, seal all gaps at intersection of vertical/horizontal pressure bar joints and tool the sealant.
GLAZING
Pressure Bar Installation - B.G.

Install AS32 vertical pressure bar fasteners from bottom to top and horizontal pressure bar fasteners from center outward. Make sure one fastener is located 1-1/2” maximum from vertical/horizontal joint intersections to ensure proper pressure over end dams. While installing pressure bar fasteners, take care not to disengage NG12 pressure bar spacer.

Note: Weep holes (two per lite) are always on top.

Step 1. Remove temporary retainers one mullion at a time. Attach vertical pressure bars leaving a 1/8” gap at top and bottom with AS32 (#12 x 1-1/4” HWH #3 self-drilling fasteners). Using an electrically powered hand held drill/driver, torque AS32 fasteners to 85-90 in. lbs. If using battery power tools, it is recommended that installer frequently check for accurate torque settings, as battery power will diminish over time.

Step 2. Center horizontal pressure bars in opening leaving a 1/8” gap at each end and attach.

Step 3. Upon completion of pressure bars installation and just prior to installing face covers, seal all gaps at intersection of vertical/horizontal pressure bar joints and tool the sealant.

Critical Seal

Note: Recommended drive speed for AS32 is 2000 rpm.
1. Remove temporary retainers one vertical at a time and install pressure bars using AS32 (#12 x 1-1/4” HWH #3 self-drilling fasteners) and a cordless adjustable clutch driver/drill with a 3/8” driver. Torque fasteners to 85-90 inch pounds. Periodically check the torque setting on the adjustable clutch driver/drill. **Note:** Recommended drive speed for AS32 is 2000 rpm.

2. Install wall jamb pressure bar fasteners from bottom to top and horizontals from center outward. Locate AS32 fasteners 1-1/2” maximum from vertical/horizontal intersections to ensure proper pressure over end and bridge dams. Reference **Step 1, page 41.**

3. Remove temporary retainers from horizontals, one bay at a time, and center horizontal pressure bars in opening leaving 1/8” gaps at ends and 1/2” at splice joints. Attach with AS32 fasteners, reference **Detail “A”** below.

4. Upon completion of pressure bars installation and just prior to installing face covers, seal all gaps at intersection of vertical/horizontal pressure bar joints and tool the sealant.

5. Seal and tool between pressure bar & face cover splices. Tool sealant. Keep sealant away from face cover snap area.

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**Pressure bar splicing & sealing at B.G. Mullions**

*Note: Intermediate Horizontal shown; Head & Sill similar*
HORIZONTAL FACE COVER
Splice Joints - B.G. Installation

1. Locate 1/2” wide splice joints at center line of vertical members.
2. Confirm pressure bar is sealed correctly as shown. See Page 42, Detail “A”.
3. Do not align face cover splices directly over pressure bar splices. Offset 6” minimum. See Detail “C”.
4. Set backer rod between face cover and pressure bars at joint and seal. Tool sealant. See Detail “D”.

Note: Pin one end of each face cover with AS31 fastener to prevent slippage. Reference Detail “C” on page 44.
FACE COVER INSTALLATION

1. Care must be taken to prevent damage of face covers during installation. Use a piece of wood such as 2" x 4" approximately 8-10" long and a 3" diameter Stanley 3 lb. Compo-Cast dead blow soft face hammer.

2. Install vertical face covers first. Do not displace top and bottom mullion caps when installing face covers. Pinning of vertical face cover is required to prevent slippage. Use one AS31 on each side per cut length, concealed behind horizontal face cover as shown. See Detail B.

3. Install snap-in horizontal face covers with the weep holes located on the bottom side.

4. Horizontal face covers exceeding 1-1/2" in depth must be pinned on top side with AS31 fastener to prevent disengagement. Locate one fastener at mid-point for 3-5 ft. lengths. On longer lengths, locate at 3'-0" O.C. See Detail C.

SEALING MULLION END CAPS

Top and Bottom (Top Shown - Bottom Similar)

1. Seal top and bottom of each vertical mullion end cap as shown. **Note:** Vertical face covers are cut mullion length -1/32".
INTERIOR TRIM INSTALLATION
Checking Joinery Seals and Anchor Bolts

Step 1. Check seals at all vertical/horizontal joints and reseal if required.

Step 2. Check all perimeter anchor bolts to make sure they are installed and secure.

Step 3. Insert PW203 interior trim cover into receiver and snap downward into place. Use dead blow mallet and wooden block as required. Take care not to ding or bend cover.

Note: Interior trim covers may be omitted in spandrel areas when not visible from interior.
**ENTRANCE SUBFRAMES**

**Note:** Refer to **FRAMES & ENTRANCES** section of this manual for additional fabrication and installation instructions. Entrance Frames may be installed simultaneously with Curtain Wall or after Curtain Wall installation has been completed.

- **PW202**
- **PW613** Pocket Filler
- **PW650** Door jamb
- **PW214** Snap-in door stop
- **DS200-1**
- **SP204** End Dam
- **SP211** Bottom end cap. Seal as shown.
- **Critical Seal!**
- **TH4** Threshold for door. Ref. page 47 for attachment to substrate.

Seal pocket of door subframe up to top of threshold.
SUBFRAME FASTENER CHART

4 Ea. (#12 x 2” H.H. #3 self drilling fastener) at header for surface closer ▲

4 Ea. AS25 (#12 x 3/4” HWH #3 self drilling fastener) at jambs

Steel Substrate: 1/4” Ø Tek Screws (5 ea.)
Concrete Substrate: 1/4” Ø Tapcons (5 ea.)
(With 1-3/4” Minimum Embedment)

▲ For C.O.C. Tubular Header, use 4 ea.
AS25 with access holes concealed under
DS202-1 offset arm cover.