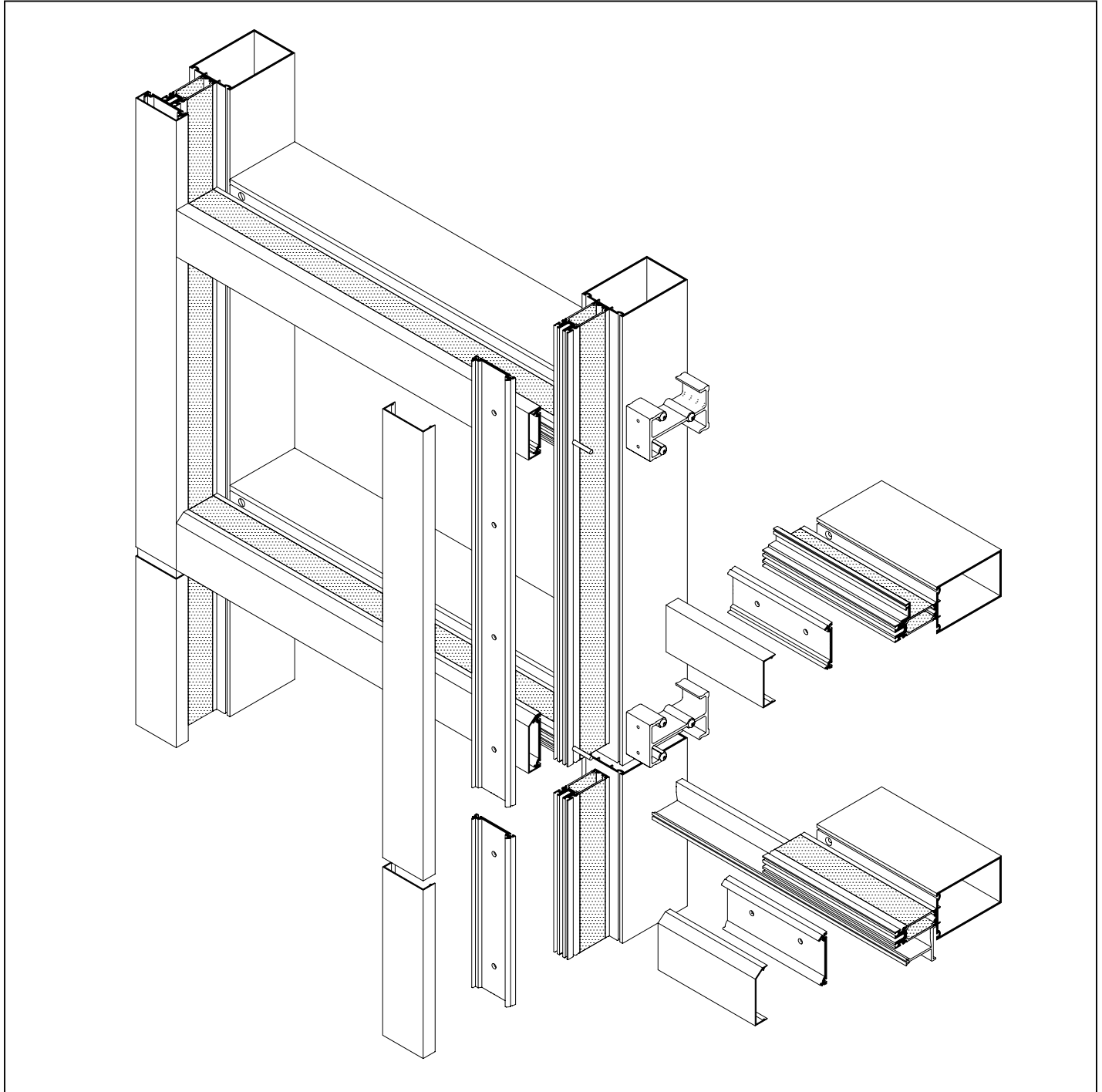


INSTALLATION



INSTRUCTIONS

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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These instructions show the general installation sequence and procedure for typical installation. They supplement the shop details and notations on installation and glazing.

SECTION	PAGE	
I	3	GENERAL INFORMATION
II	4-5	COMPONENTS
III	6-12	GRID FABRICATION
IV	13	ANCHOR ASSEMBLY
V	14-15	GRID ASSEMBLY
VI	16	EXPANSION JOINT ASSEMBLY
VII	17	PERIMETER SEAL APPLICATION
VIII	18	BACK PAN INSTALLATION
IX	19-24	GLAZING
X	24	GLAZING COMBINATIONS

Consult the KawneerDirect website for the latest updates to these instructions before beginning work on your project.

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GENERAL NOTES

These installation instructions are a supplement to the approved shop drawings.

Use in conjunction with those drawings.

HANDLING - STORING - PROTECTING ALUMINUM

- A. **HANDLE CAREFULLY** - Don't drop from the truck. Stack with adequate separation so material will not rub together. Store off the ground. Protect against elements and other construction trades.
- B. **KEEP MATERIAL AWAY FROM WATER, MUD AND SPRAY** - Prevent cement, plaster and other materials from damaging the finish.
- C. **PROTECT THE MATERIALS AFTER ERECTION** - by wrapping with kraft paper or by erecting visqueen or canvas splatter screens. Cement, plaster, terrazzo and other alkaline materials are very harmful to the finish and should be removed with water and mild soap before setting occurs. Under no circumstances allow these materials to dry or permanent staining will occur.

GENERAL RULES. . . The following practices are recommended for all installations:

- A. Read complete instructions before ordering glass, fabricating or assembling metal.
- B. **CHECK SHOP DRAWINGS** to become thoroughly familiar with job. In any case where there is a difference between approved shop drawings and these instructions, the shop drawings should be followed.
- C. All materials are to be **INSTALLED PLUMB, LEVEL AND TRUE.**
- D. All work should start from established bench marks and column centre lines established by the architectural drawings and the general contractor.
- E. The sequence of erection should be coordinated with the job superintendent so delays are prevented and risk of material damage is minimized. **IF PRE-SETTING OF ANCHORAGE IS REQUIRED, COORDINATE WITH GENERAL CONTRACTOR AND SUPERVISE LOCATION.**
- F. Make certain construction which will receive your materials is according to the contract documents. If not, notify the general contractor **IN WRITING, AND RESOLVE DIFFERENCES BEFORE PROCEEDING WITH YOUR WORK.**
- G. Insulate all aluminum to be placed directly in contact with the masonry or incompatible materials with a heavy coat of zinc chromate or bituminous paint.
- H. Follow Kawneer Installation and Glazing Instructions.
- J. Check all material on arrival for quantity.

K. Be sure you have all the materials and tools needed to begin the installation:

- (1) Approved Shop Drawings or Layout from Installation Instructions.
- (2) Level and Plumb (Transit).
- (3) Fasteners and Drivers as required.
- (4) Perimeters and Accessories such as Anchors, Fasteners, Sleeves or Splice Caps.
- (5) Sealing Materials
- (6) Glazing Materials.

L. Follow sealant manufacturer's recommendations for proper sealant and application. All sealants and mastics must be compatible with all surfaces including other sealant surfaces. Where required all sealants must adhere to all surfaces including other sealant surfaces.

7500 WALL SYSTEM NOTES

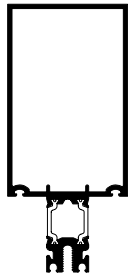
7500 wall is available with 1" and 2" infill framing members. Framing members will also accept 1/4" infills.

Glass bite is 1/2" at verticals and horizontals. At the head of a spandrel lite at an expansion joint only, glass bite is 3/4". Glass sizes must be calculated from approved shop drawings.

The primary perimeter seal must be located at the shoulder of the mullion tube.

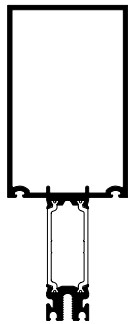
Unless otherwise specified, it is recommended that silicone sealant be used for all internal seals.

Sealant must be applied per the sealant manufacturer's recommendations and pass all adhesion and compatibility testing. At all joint seals, sealant must adhere to metal, gaskets, thermal separator and joint plug materials. Clean all surfaces prior to application of sealant and prime where necessary to achieve proper adhesion.



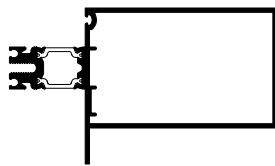
Mullion
Double Glazed

824211 6 5/16" System
824214 7 9/16" System



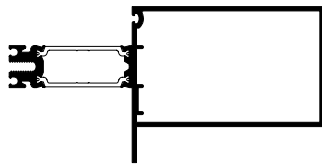
Mullion
Triple Glazed

824201 7 5/16" System
824215 8 9/16" System



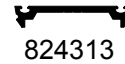
Expansion Horizontal
Double Glazed

824212 6 5/16" System
824223 7 9/16" System



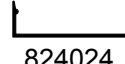
Expansion Horizontal
Triple Glazed

824202 7 5/16" System
824224 8 9/16" System



Pressure Plate

824313



3/4" Snap-on Cover

824024



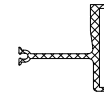
Expansion Horizontal
Pressure Plate

824311



Expansion Horizontal
Snap-on Cover

824004



Head Retainer Clip
for Triple Glazed

824301



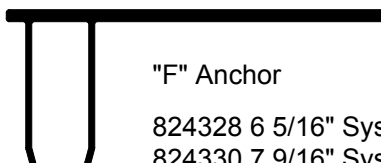
Head Retainer Clip
for Double Glazed

824302



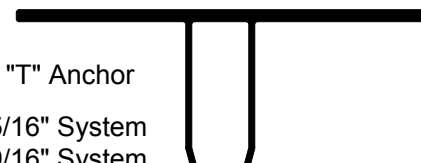
Spandrel Adaptor

824011



"F" Anchor

824328 6 5/16" System
824330 7 9/16" System
824328 7 5/16" System
824330 8 9/16" System

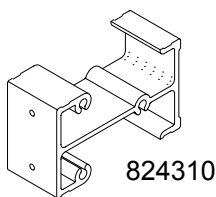


"T" Anchor

824329 6 5/16" System
824331 7 9/16" System
824329 7 5/16" System
824331 8 9/16" System

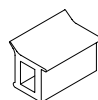
Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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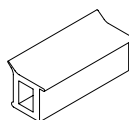


Shear Block

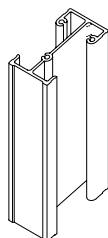
824310



824306
Corner Plug
Double Glazed



824307
Corner Plug
Triple Glazed



Expansion Sleeve
824312 6 5/16" System
824312 7 5/16" System



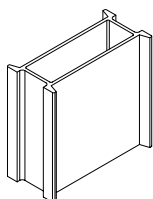
027228
Interior Bulb Gasket
(Spandrel Adaptor)



027780
Exterior Gasket



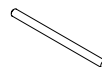
127141
Interior Gasket



Expansion Sleeve
162307 7 9/16" System
162307 8 9/16" System



027785
Nose Seal Gasket



824325
3/16" Dia. Stainless Steel Pin

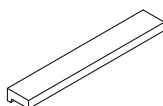


823350
Pressure Bar for
Airseal Membrane



028316

#8 x 3/8" F.H., Philips
300 SS, Self Tapping
(Snap cover screw)

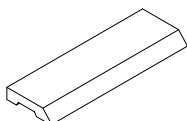


027782
Setting Block
Single Glazed



029163

#10-16 x 5/8" P.H., Robertson
400 SS, Self Tapping
(Airseal membrane / back pan screw)

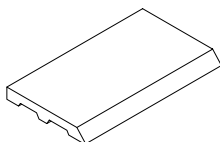


027783
Setting Block
Double Glazed



029311

#1/4"-20 x 5/8" R.H. Machine Screw
Robertson, 300 SS,
(Pressure plate screw)



027784
Setting Block
Triple Glazed

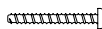


029312

#10 x 1/2" F.H., Robertson
300 SS, Self Tapping
(Shear block screw)
(Sleeve fixing screw)

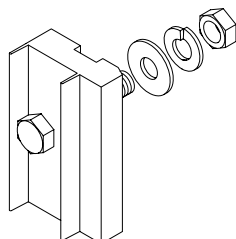


"W" Side Block
123391 Double Glazed
123392 Triple Glazed



029313

#12 x 1-7/8" P.H., Robertson
300 SS, Self Tapping
(Shear block screw)



216482
Anchor Back-up
Assembly



977083

#10-16 x 3/4" P.H., Robertson
400 SS, Self Drilling
(Head retainer clip screw)



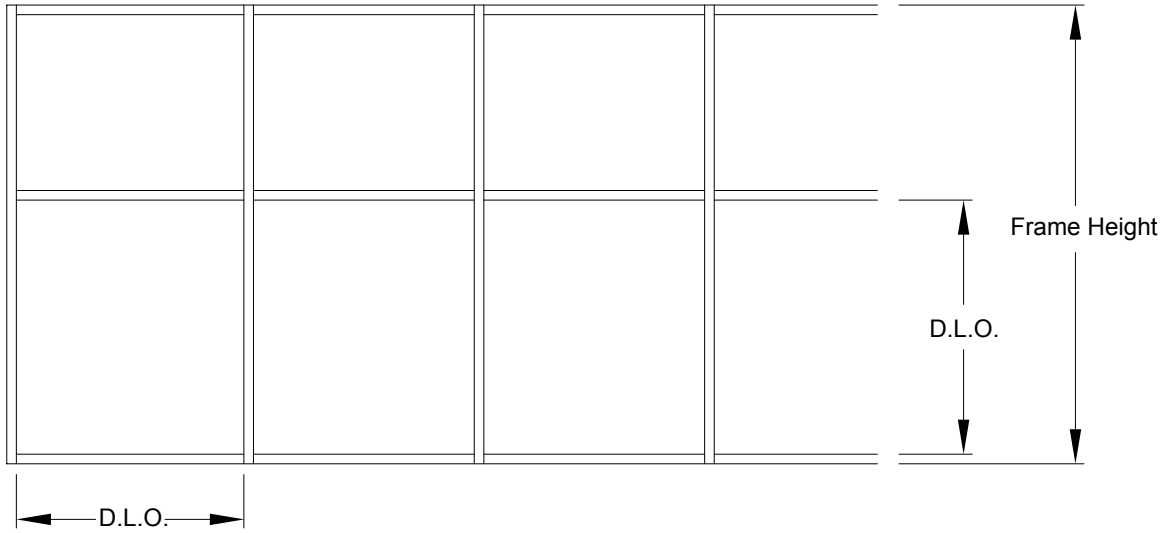
128348

#10-16 x 1 1/4" F.H., Philips
400 SS, Self Drilling
(Sleeve fixing screw)

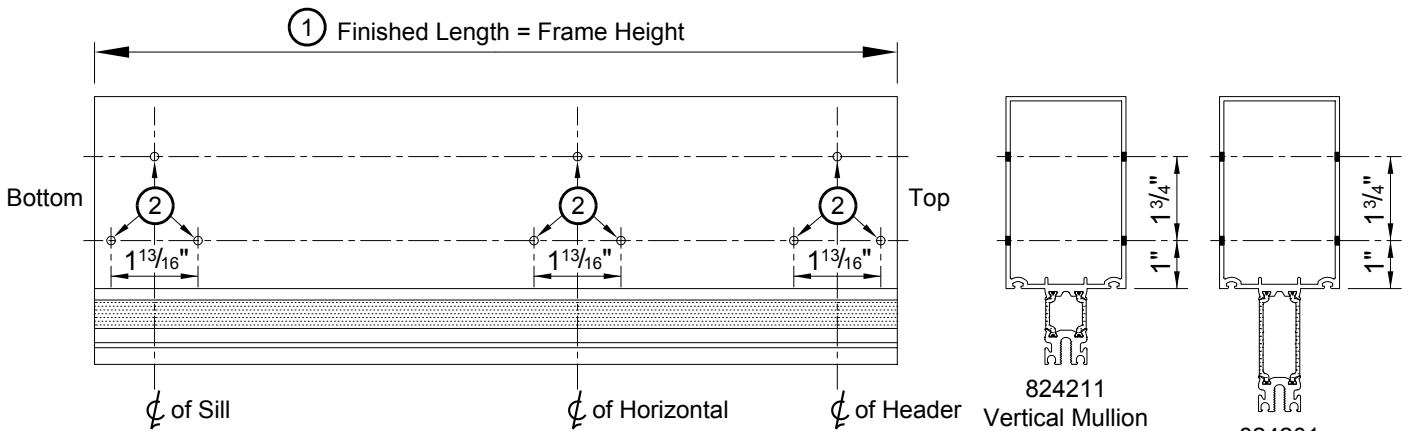
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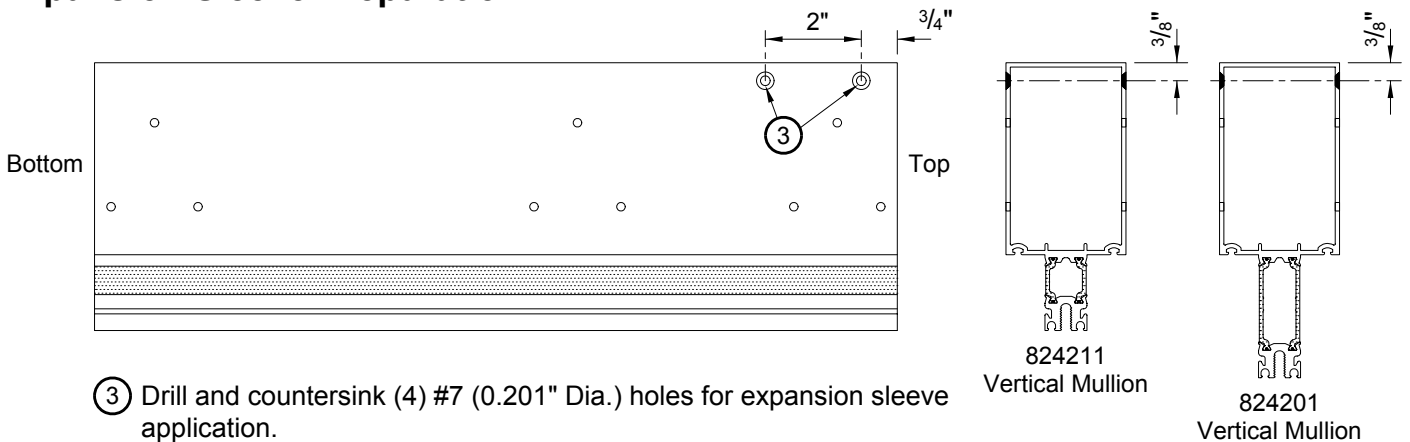


Vertical Mullions - Shear Block Preparation



- ① Cut to length required.
- ② Drill (3) #16 (0.177" Dia.) holes for shear blocks at each horizontal centerline as shown. (Delete holes at jamb conditions as required.)

Expansion Sleeve Preparation



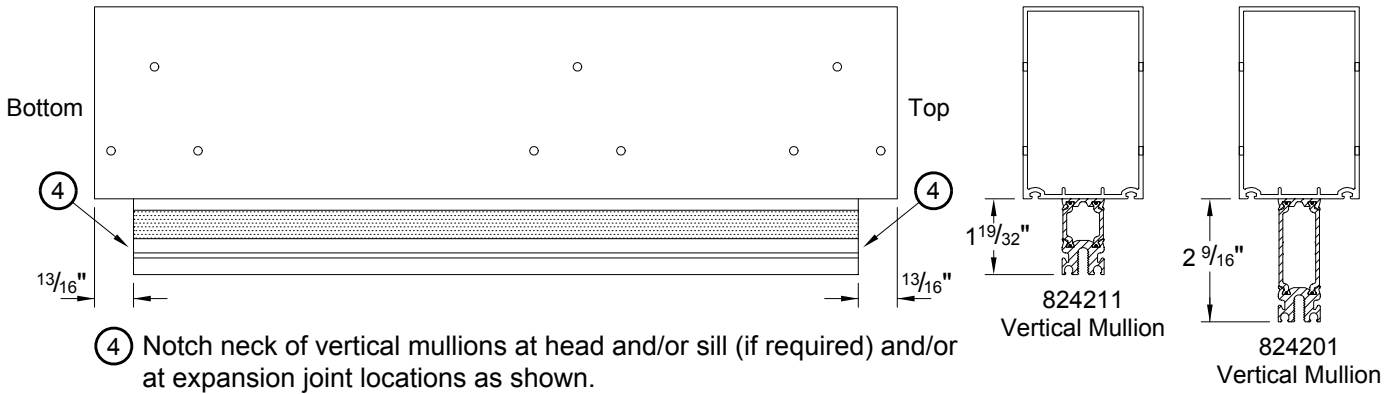
- ③ Drill and countersink (4) #7 (0.201" Dia.) holes for expansion sleeve application.

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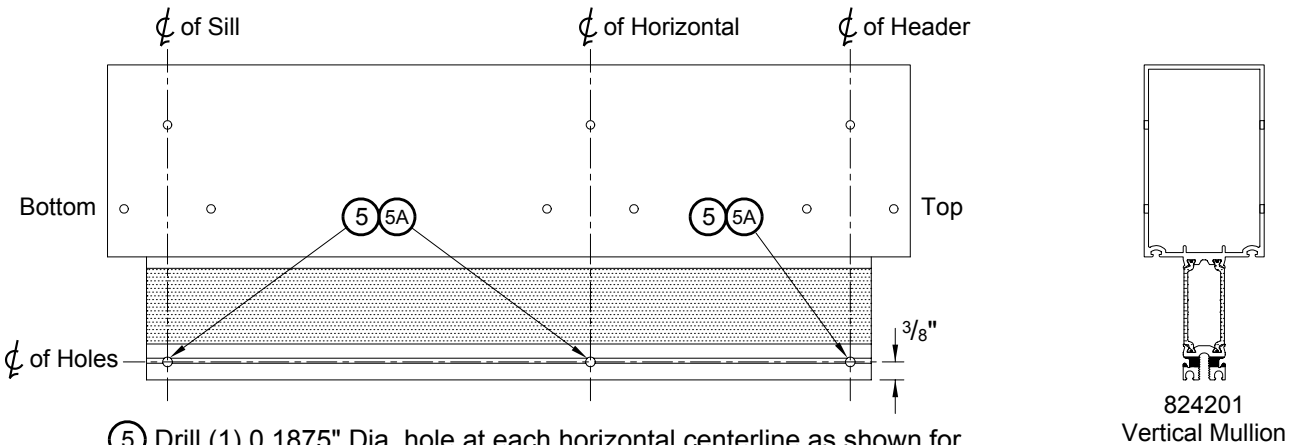
Vertical Mullions - Mullion Nose Preparation

Review shop drawings to determine if this operation is required.

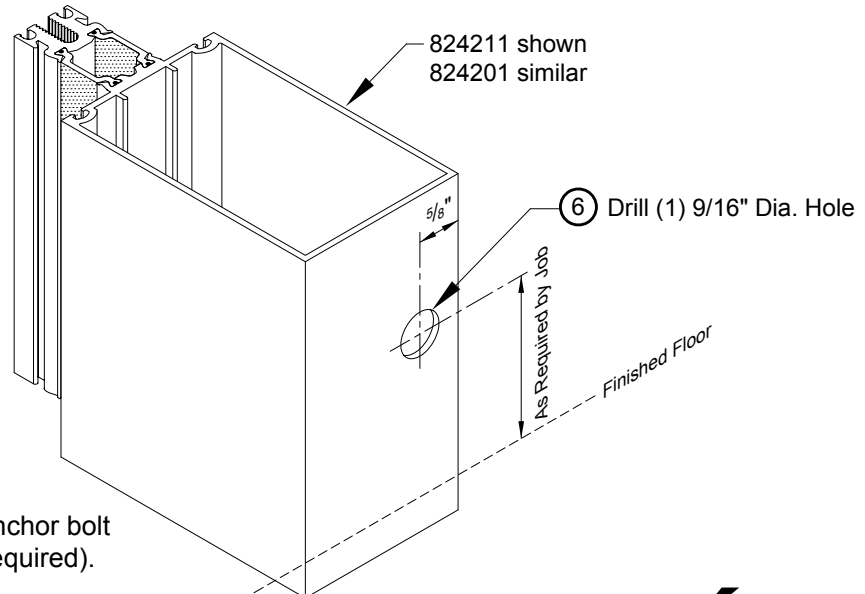


Nose Pin Preparation

Required for all transoms supporting 7550 triple glazed applications;
Not required for 7525 double glazed applications.



Anchor Back-Up Preparation



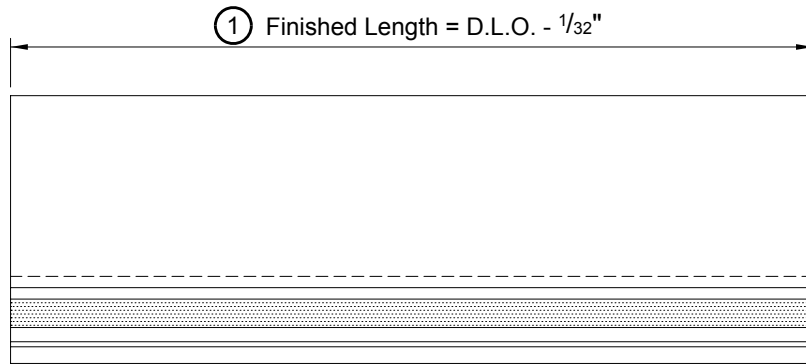
⑥ Drill (1) anchor hole at anchor bolt centerline as shown (if required).

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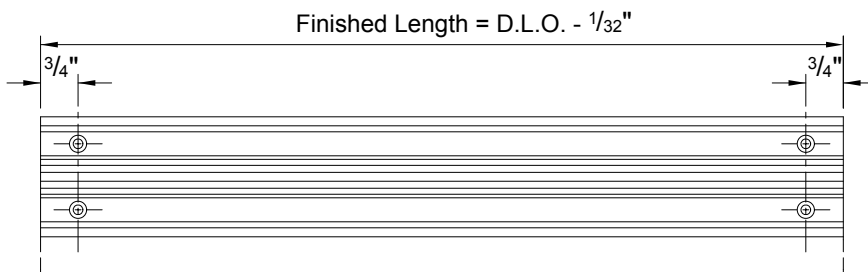
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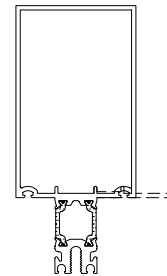
Horizontal Transoms - 7525 and 7550 Transoms Supporting Single and Double Glazing



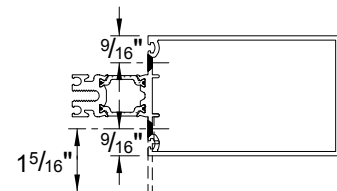
① Cut to length required.



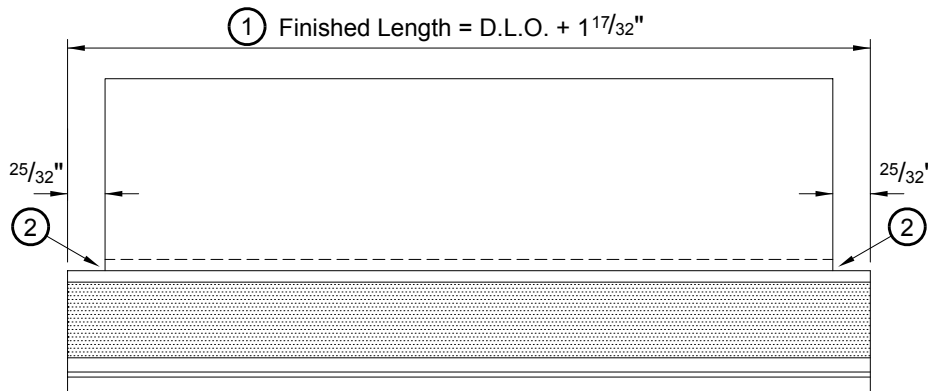
② Drill (2) #7 holes (0.201" Dia.) by 82° countersink at each end of horizontal as shown.



824211 shown
824212 similar
824201 similar
824202 similar

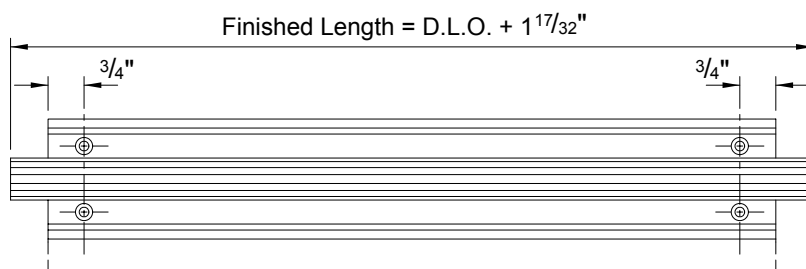


Horizontal Transoms - 7550 Transoms Supporting Triple Glazing

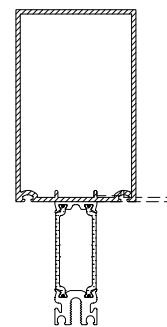


① Cut to length required.

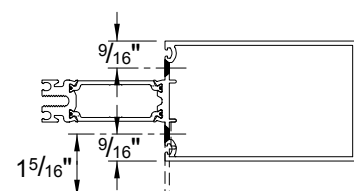
② Cope at each end of triple glazed horizontals as shown.



③ Drill (2) #7 holes (0.201" Dia.) by 82° countersink at each end of horizontal as shown.



824201 shown
824202 similar



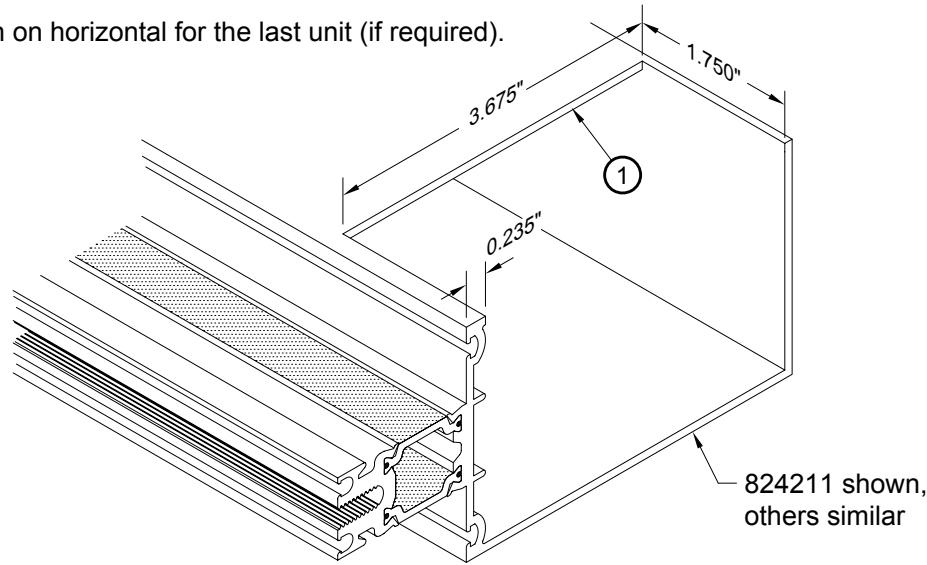
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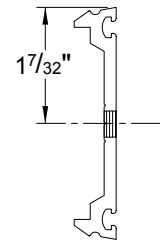
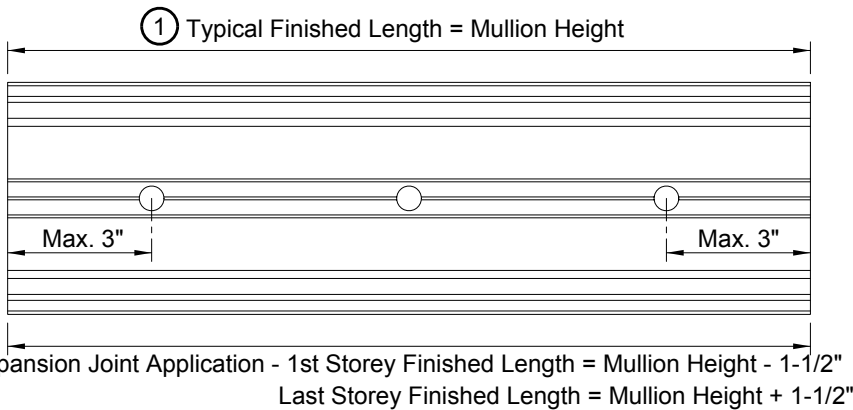
Horizontal Transoms - Preparation For The Last Unit

The following preparation may be required to facilitate installation of the last unit.

- ① Notch on horizontal for the last unit (if required).



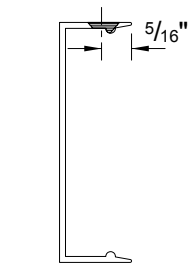
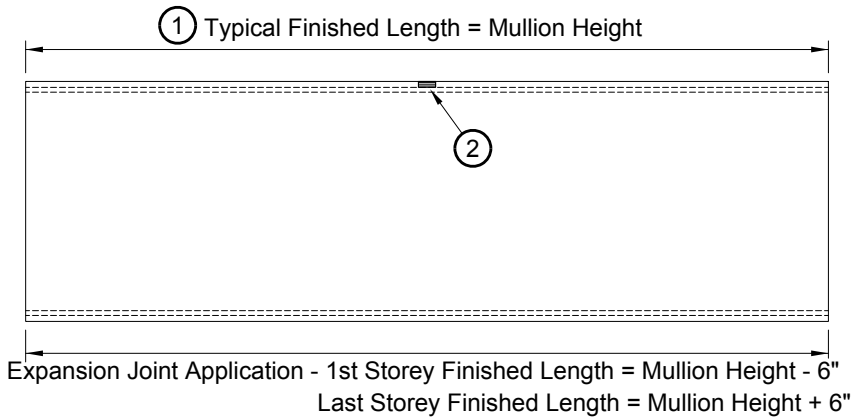
Vertical Pressure Plates



824313 Pressure Plate

- ① Cut to length required.
- ② Punch (1) 0.257" Dia. hole, Max. 3" from each end as shown.

Vertical Snap-on Cover



824024 Snap-on Cover

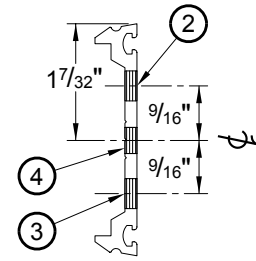
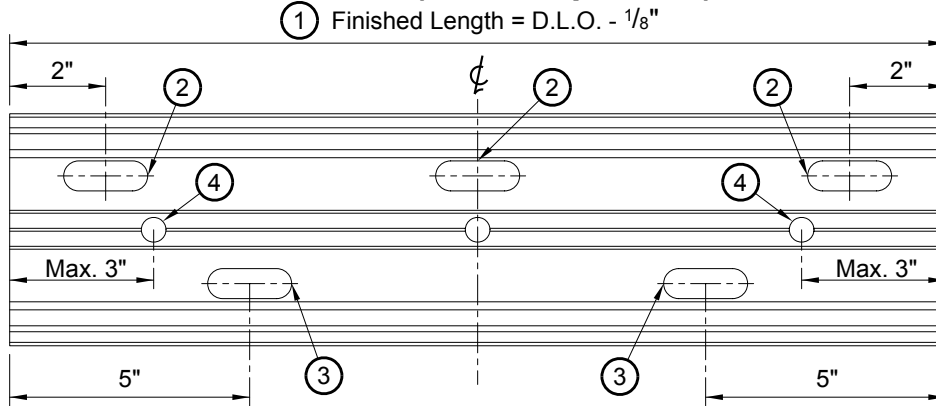
- ① Cut to length required.
- ② Drill and countersink (1) #15 hole (0.18" Dia.) at the horizontal closest to the cover height center, (if no horizontal transom, locate screw hole at header) for (1) #28-316, #8 x 3/8" self tapping screw.

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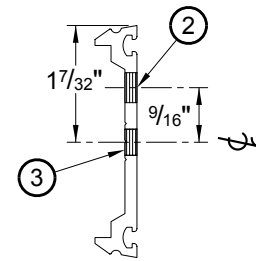
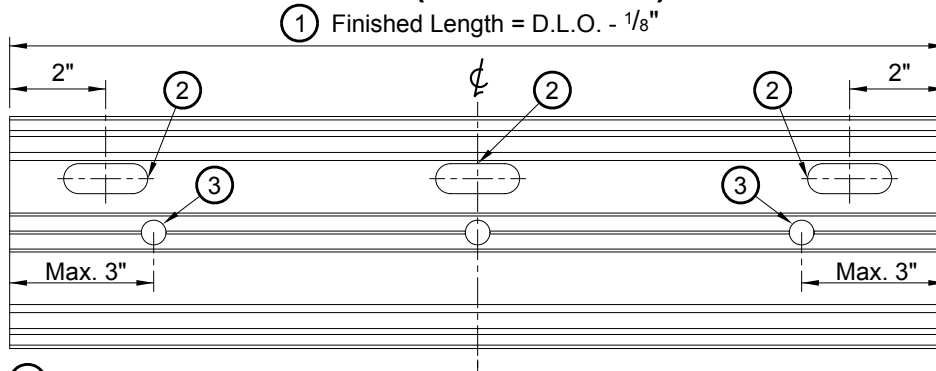
Horizontal Pressure Plates (Above Spandrel)



824313
Pressure Plate

- ① Cut to length required.
- ② Fabricate (1) $\frac{5}{16}$ " x $\frac{7}{8}$ " drain slot at each end and center as shown.
- ③ For head of spandrel only fabricate (1) $\frac{5}{16}$ " x $\frac{7}{8}$ " vent slot at each end as shown.
- ④ Punch (1) 0.257" Dia. hole at each end as shown.

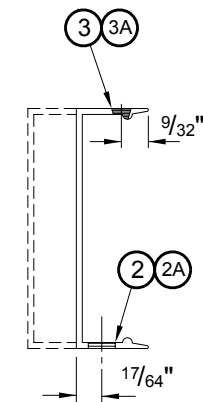
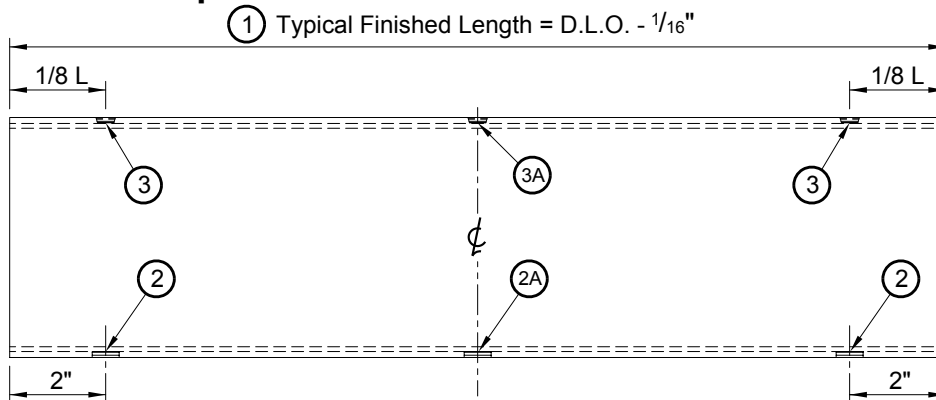
Horizontal Pressure Plates (Above Vision)



824313
Pressure Plate

- ① Cut to length required.
- ② Fabricate (1) $\frac{5}{16}$ " x $\frac{7}{8}$ " drain slot at each end and center as shown.
- ③ Punch (1) 0.257" Dia. hole at each end as shown.

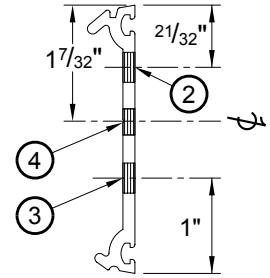
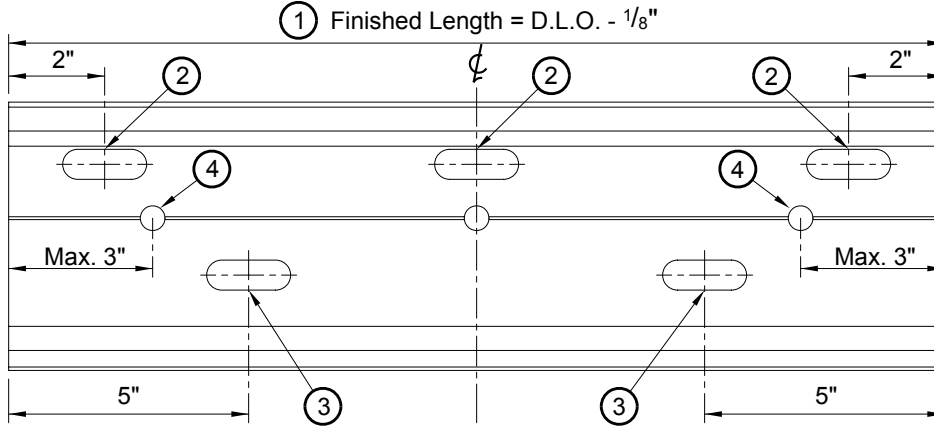
Horizontal Snap-on Cover



824024
Snap-on Cover

- ① Cut to length required.
- ② Drill (1) $\frac{9}{32}$ " Dia. drain hole at each end.
- ②A Drill (1) $\frac{9}{32}$ " Dia. drain hole at center for covers over 48" long.
- ③ Drill and countersink (2) #15 holes at $\frac{1}{8}$ points for horizontal covers with projection greater than $1\frac{1}{4}$ " for #28-316, #8 x $\frac{3}{8}$ " self tapping screws.
- ③A Drill and countersink (1) #15 hole at center for covers over 48" long for #28-316, #8 x $\frac{3}{8}$ " self tapping screw.

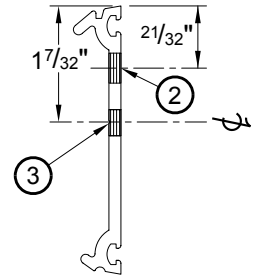
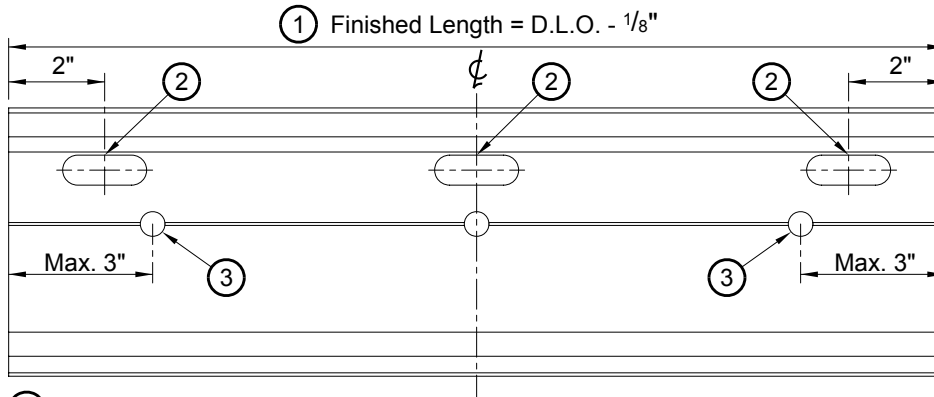
Expansion Pressure Plates (Above Spandrel)



824311
Pressure Plate

- ① Cut to length required.
- ② Fabricate (1) 5/16" x 7/8" drain slot at each end and center as shown.
- ③ For head of spandrel only fabricate (1) 5/16" x 7/8" vent slot at each end as shown.
- ④ Punch (1) 0.257" Dia. hole at each end as shown.

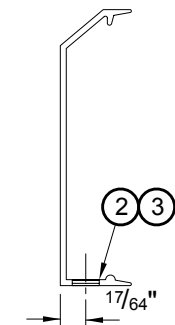
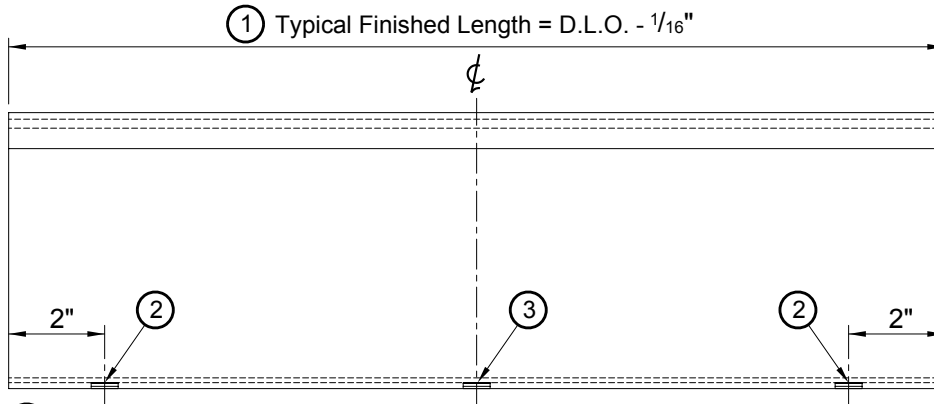
Expansion Pressure Plates (Above Vision)



824311
Pressure Plate

- ① Cut to length required.
- ② Fabricate (1) 5/16" x 7/8" drain slot at each end and center as shown.
- ③ Punch (1) 0.257" Dia. hole at each end as shown.

Expansion Snap-on Cover



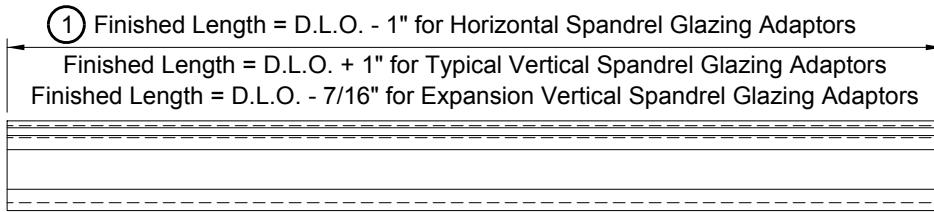
824004
Horizontal Cap

- ① Cut to length required.
- ② Drill (1) 9/32" Dia. drain hole at each end as shown.
- ③ Drill (1) 9/32" Dia. drain hole at center for covers over 48" long.

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Spandrel Adaptors

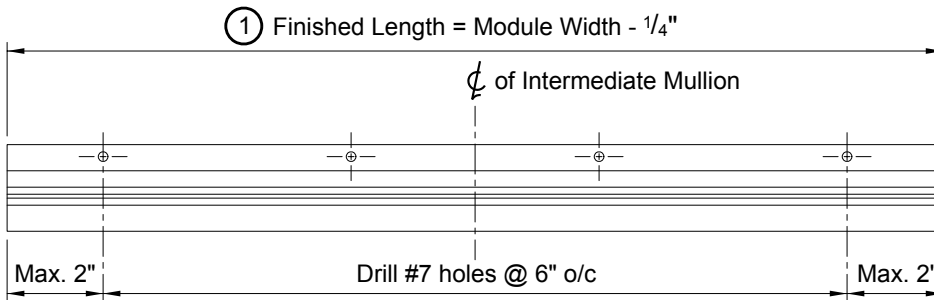


① Cut to length required.



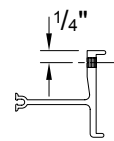
824011
Spandrel Adaptor

Panel Head Retainer - Intermediate Typical

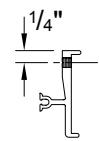


① Cut to length required.

② Drill (1) #7 (0.201" Dia.) hole at Max. 2" from each end and at 6" o/c.

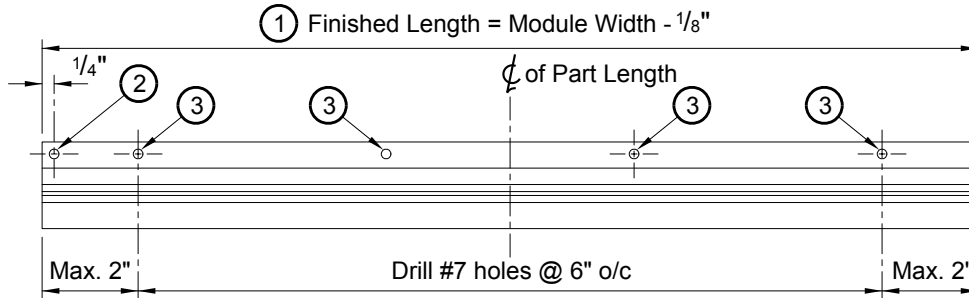


824301



824302

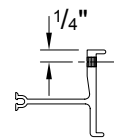
Panel Head Retainer - Jamb Condition



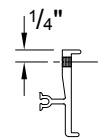
① Cut to length required.

② Drill (1) #7 (0.201" Dia.) hole at 1/4" from end at jamb location.

③ Drill (1) #7 (0.201" Dia.) hole at Max. 2" from each end and at 6" o/c.

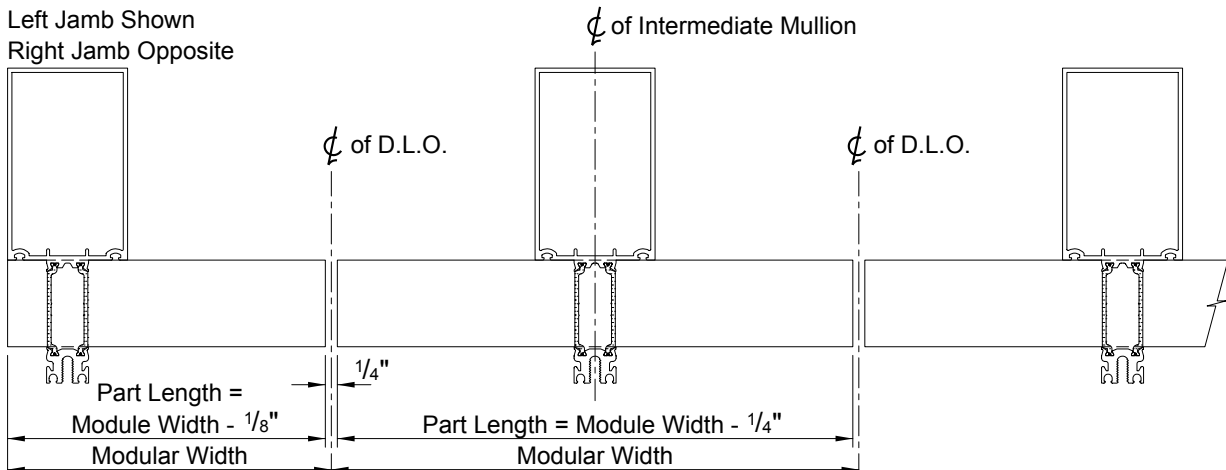


824301

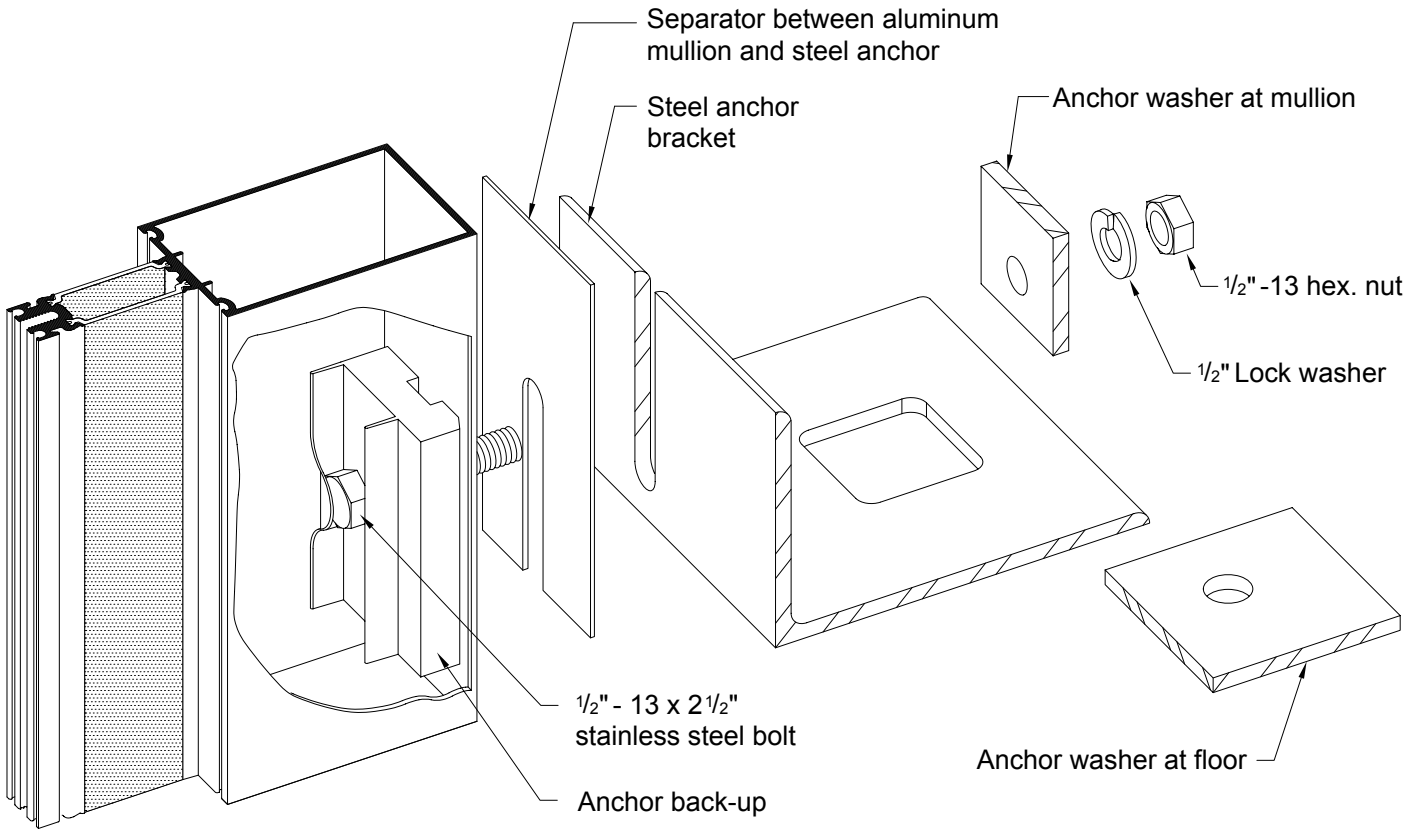


824302

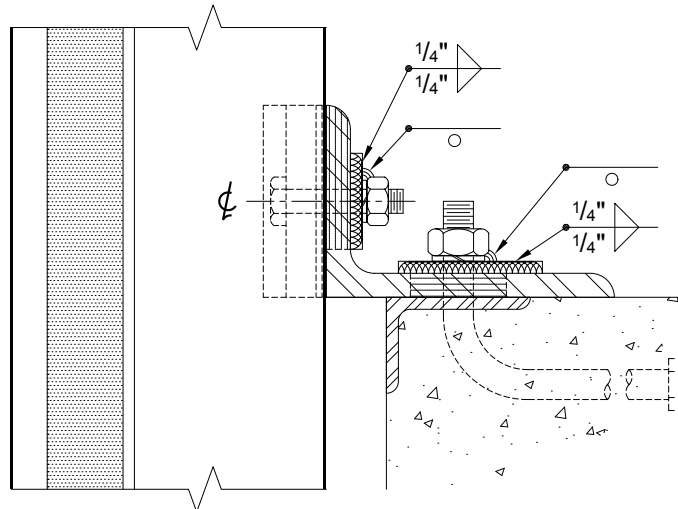
Left Jamb Shown
Right Jamb Opposite



7550 shown, 7525 similar, typically in all pages.



Assemble anchor back-up and anchor bracket to mullion as shown. Position mullion and fix to floor slab with steel angle, steel washer plate, lock washer and nut as shown below.

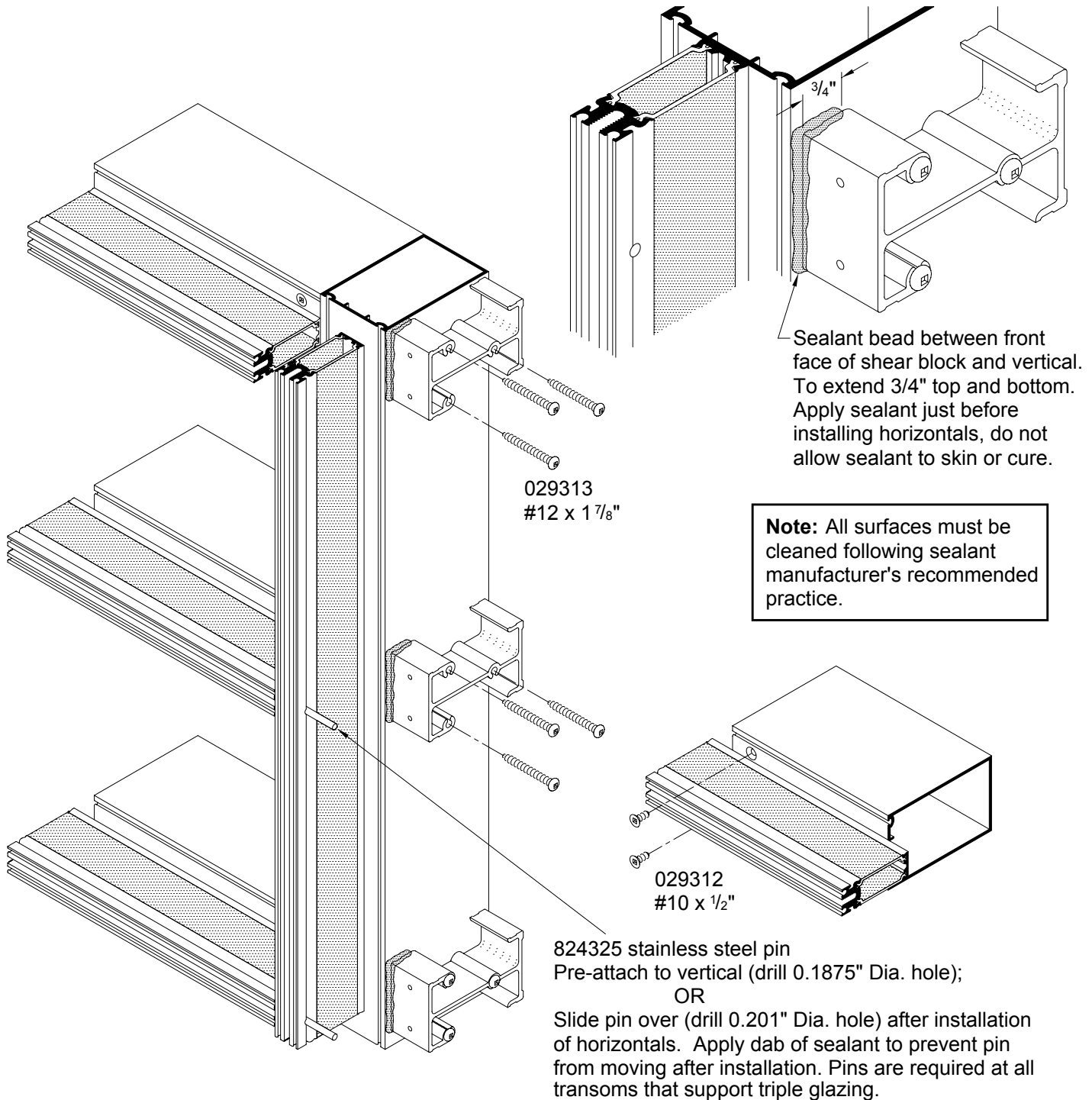


After final adjustment of grid for in-out, up-down, and sideways position, weld washer plates to steel angle to fix position. Tack weld 1/2" - 13 hex nut to washer plates. For windload only (requires vertical movement), add teflon washers between mullion and anchor, also between anchor and steel washer. Finally tighten nut and back-off one turn and tack weld nut to steel washer.

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Attach shear blocks to verticals as shown using (3) 029313 #12 x 1-7/8" pan head self tapping screws per shear block.



Just before assembling the horizontal apply a generous bead of sealant between the front face of the shear block and the vertical, and extend 3/4" top and bottom as shown.

Butter coped end of horizontal with sealant, attach the horizontal to the vertical by using (2) 029312 #10 x 1/2" flat head self tapping screws per joint as shown and seal screws. Tool any squeezed out sealant and clean any excess from exposed surfaces of the vertical and horizontal mullions.

Secure triple glazed horizontal necks by installing 824-325 stainless steel pin from the holes drilled on vertical mullion nose.

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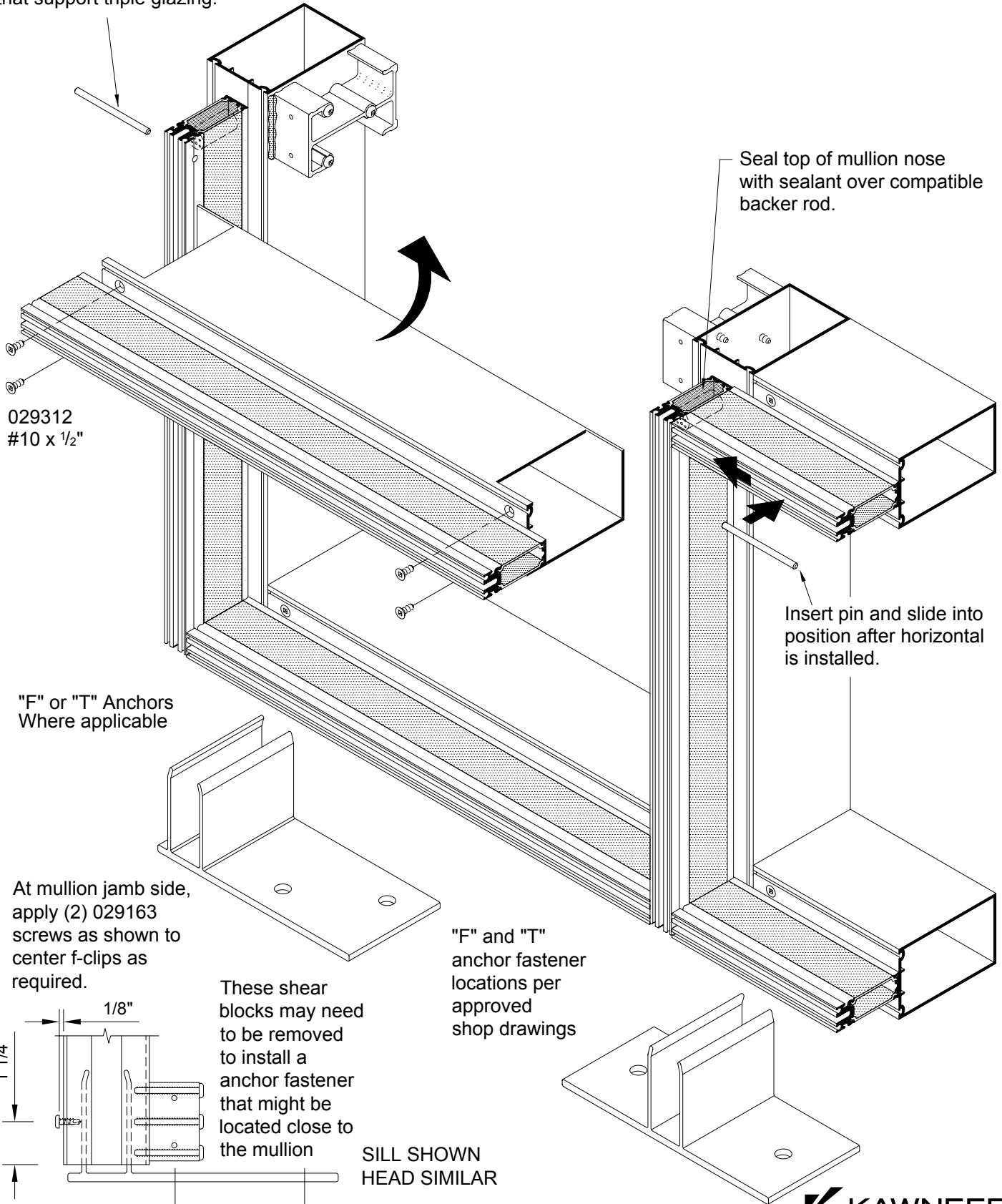
For large runs, installation of the last horizontal requires special procedures. Shown below is one method with horizontal notched to clear the shear blocks. Please note that notched tongue and pin is not typically required for head transoms that do not support triple glazing. Details shown below are for reference.

Install 824325 stainless steel nose pin to secure triple glazed horizontal neck. Pin is required only at transoms that support triple glazing.

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029312
#10 x 1/2"

Seal top of mullion nose with sealant over compatible backer rod.

Insert pin and slide into position after horizontal is installed.

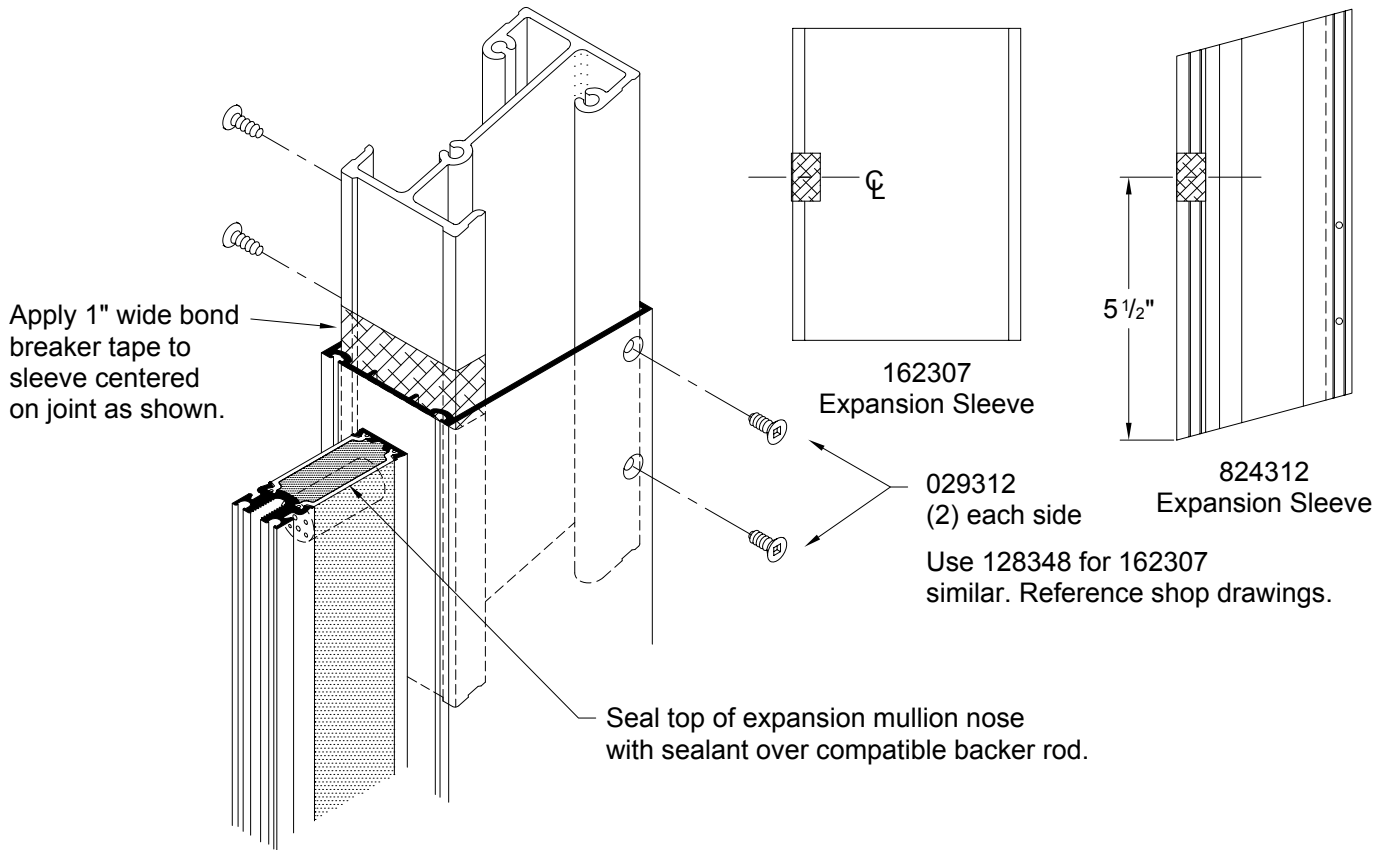
"F" or "T" Anchors Where applicable

At mullion jamb side, apply (2) 029163 screws as shown to center f-clips as required.

These shear blocks may need to be removed to install an anchor fastener that might be located close to the mullion

"F" and "T" anchor fastener locations per approved shop drawings

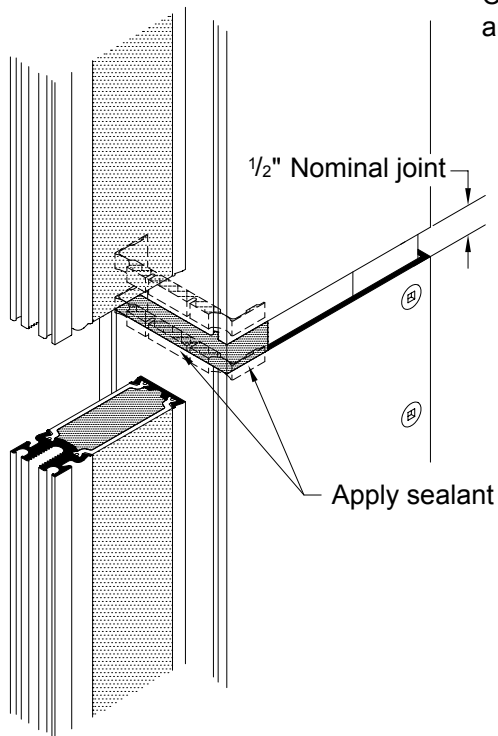
SILL SHOWN HEAD SIMILAR



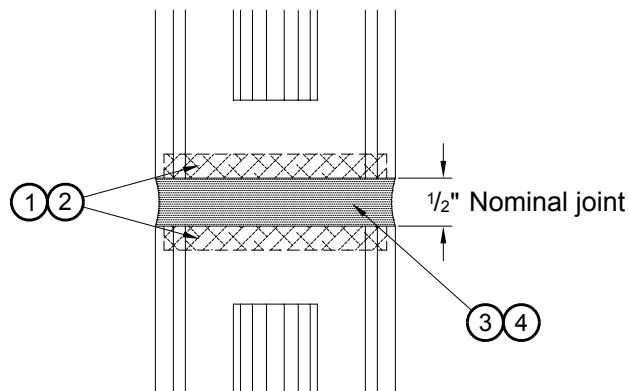
Fix sleeve to bottom mullion with (4) 029312 #10 x 1/2" self tapping screws as shown.

Install upper mullion to proper position being sure to maintain construction joint between mullions at 1/2". Steel shim spacer could be used to assist in this.

Clean all joint surfaces per sealant manufacturer's recommendations and apply sealant as shown.

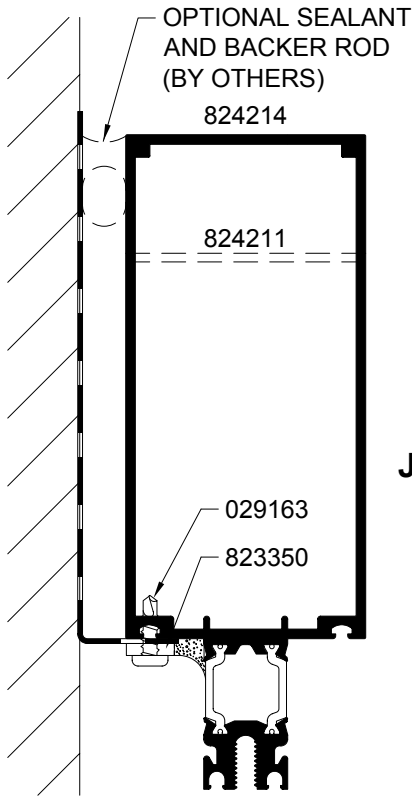


- ① First to top and bottom cavity between mullion and sleeve.
- ② Tool in.
- ③ Apply as shown.
- ④ Tool joint

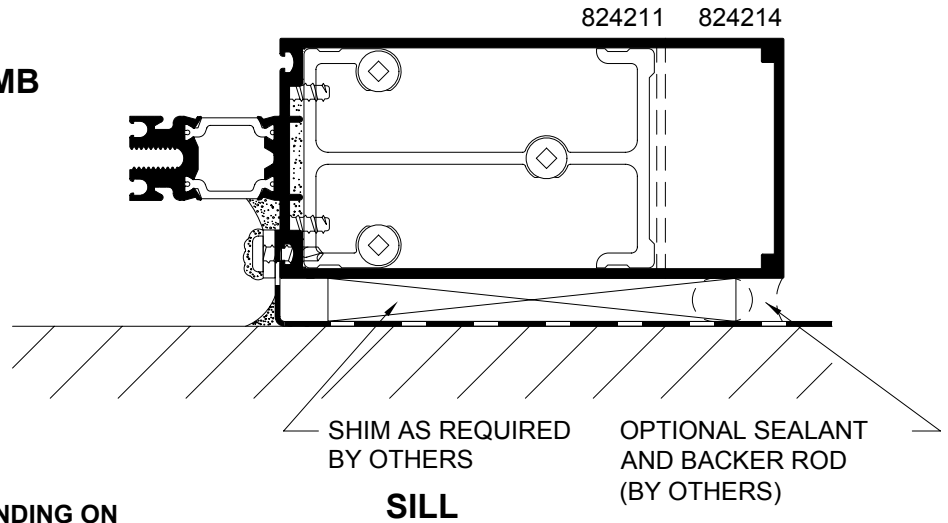


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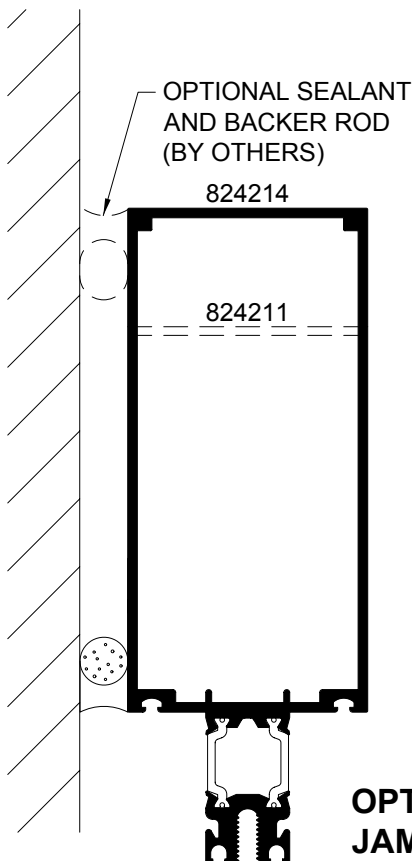
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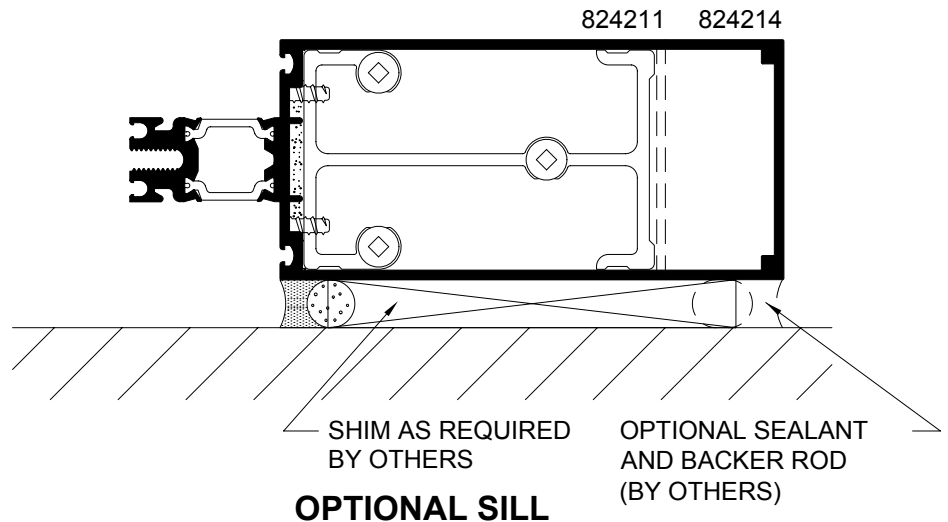
For installation utilizing an air barrier membrane, clean materials per sealant manufacturers recommendations. Ensure that membrane is sufficiently bedded into a generous bead of sealant as shown. Install 823350 pressure bar along the outer reglet and fasten with 029163 screws at 12 in. on center. Seal over screw heads and apply a fillet bead of sealant between the pressure bar and the mullion neck around the perimeter. Tool sealant.



NOTE:
INTERFACE DETAILS VARY DEPENDING ON
BUILDING CONSTRUCTION DETAILS.
REFERENCE SHOP DRAWINGS.

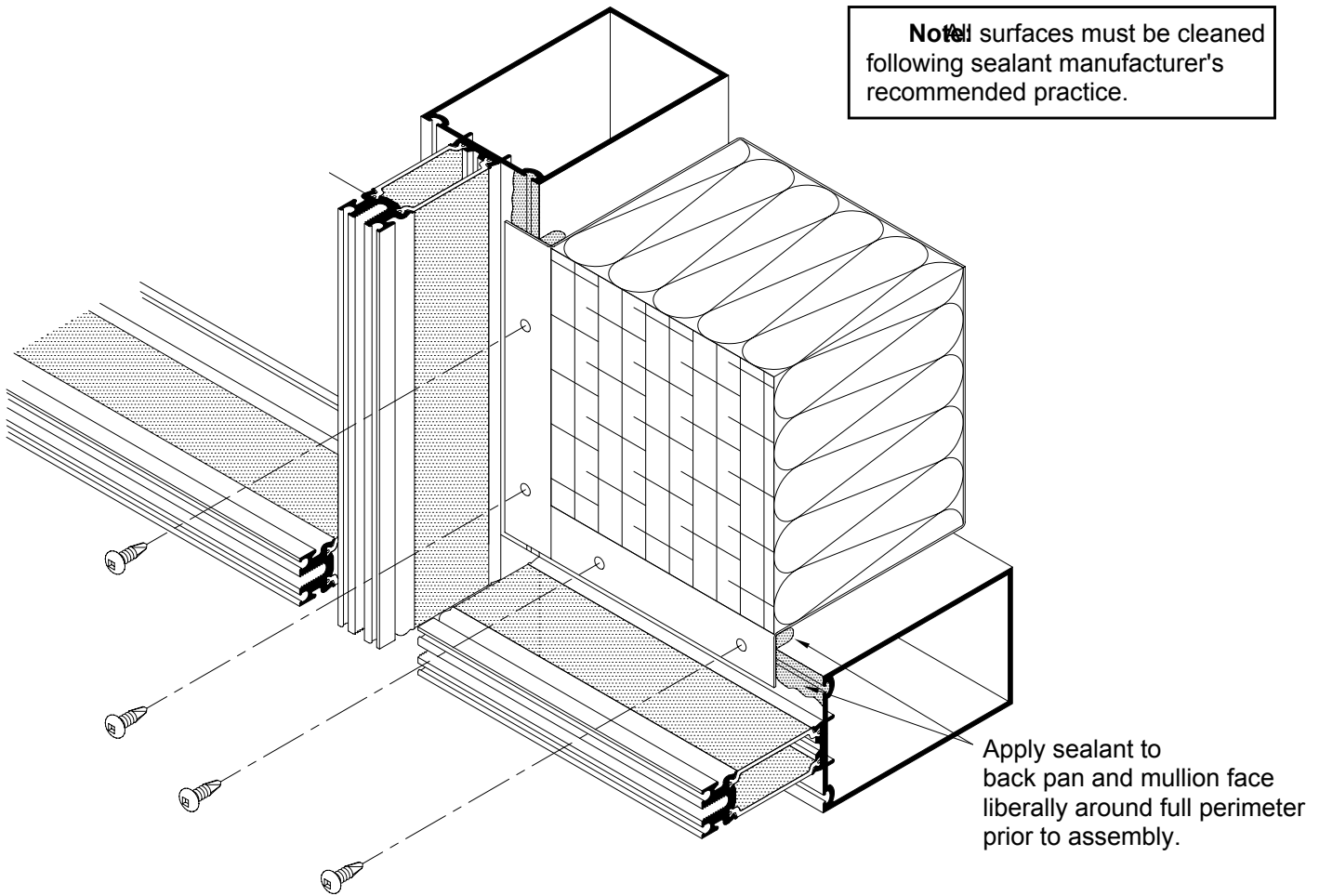


For installation utilizing perimeter sealant, clean materials per sealant manufacturers recommendations. Install backer rod and perimeter seals at the mullion edge as shown below. Tool sealant.



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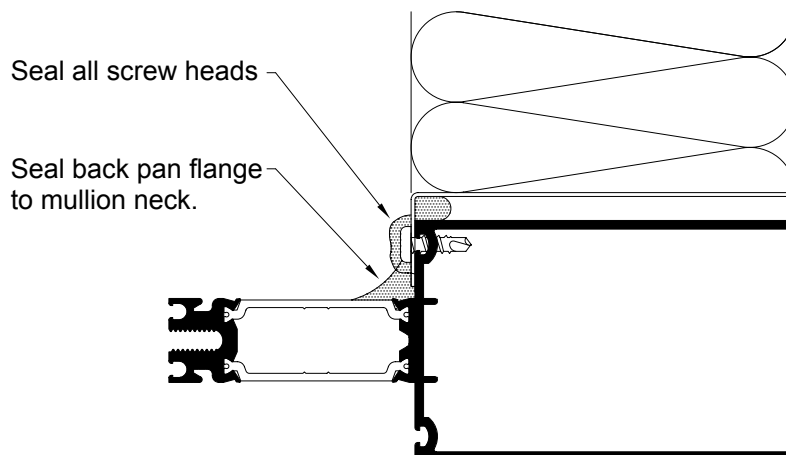
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Prior to installing back pan apply generous bead of sealant to inside corner of back pan flange and butter mullion face with sealant as shown. Wipe out excess sealant at transom neck for installation of joint plugs. Reference next two sheets.

Fix back pan to grid with 029163 #10 x 5/8" self drilling screws.

Seal over all screw heads and apply generous fillet bead of sealant between back pan flange and mullion neck around perimeter. Do not seal head of back pan at expansion joint condition. This area will be sealed by head retainer clip and butyl tape.



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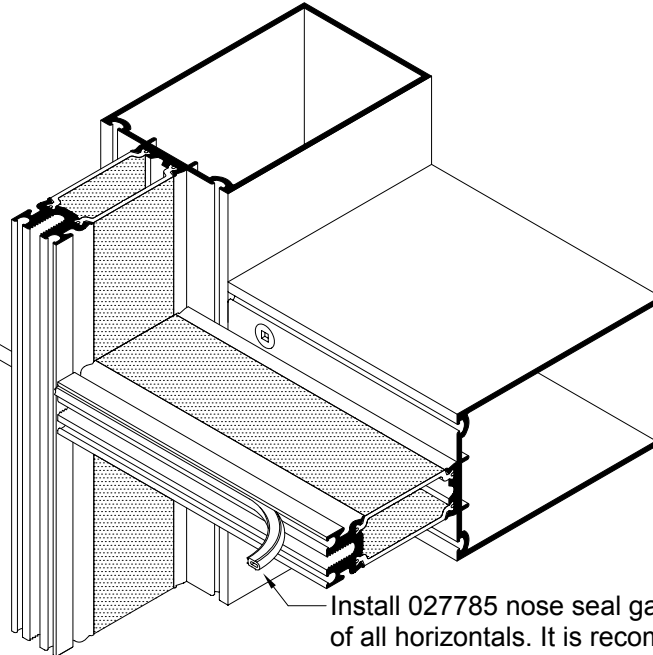
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Typical glass bite for 7525 and 7550 framing is 1/2". The glass bite at the head of spandrel lite at expansion joint only, is 3/4". Reference Engineering Details, detail #6.

Note: All surfaces must be cleaned following sealant manufacturer's recommended practice.

Secure horizontal transom neck to vertical mullion with 3/16" stainless steel pin 824325.

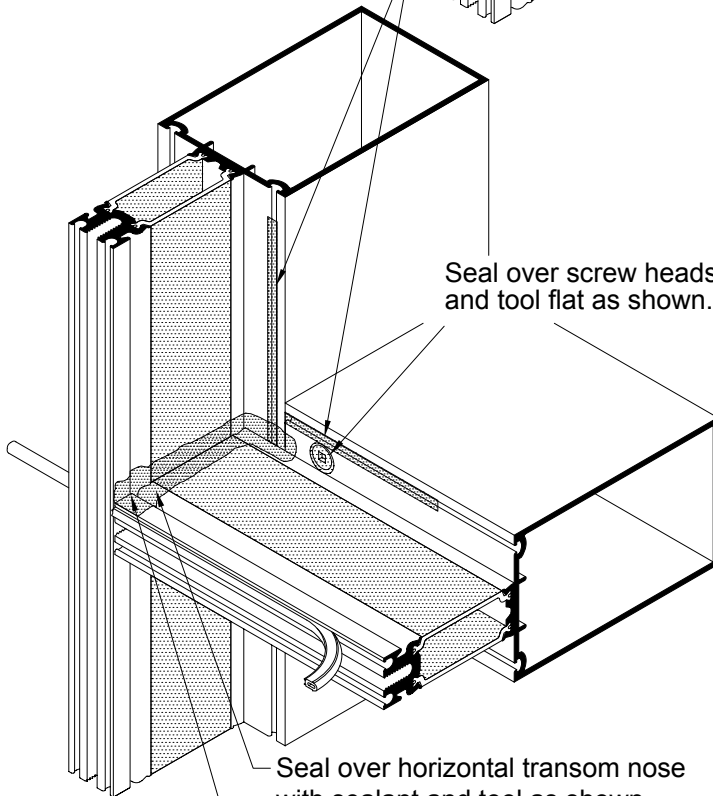
Seal gasket rebates for approximately 3" from corners as shown.



Install 027785 nose seal gasket in upper pocket only, of all horizontals. It is recommended to install to the horizontal in shop environment to ease installation. Allow 1/2" overhang per side to account for shrinkage.

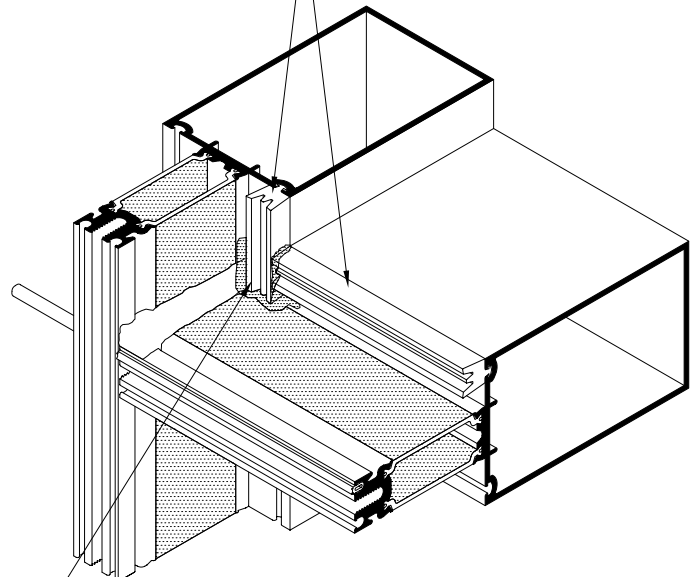
Install 127141 interior gasket.
 Vertical gasket length = D.L.O. + 1 1/2" + 1/8" / ft
 Horizontal gasket length = D.L.O. + 1/8" / ft

Seal over screw heads and tool flat as shown.



Seal over horizontal transom nose with sealant and tool as shown. Sealant should be neatly applied to prevent contact with I.G. unit.

Ensure all cavities are adequately sealed.



Seal back of interior gasket at corners, as shown. Tool all sealant squeeze out.

Note: If glass is to be set after sealant has cured, make sure there is no excess sealant on the gasket surface which will contact the glass.

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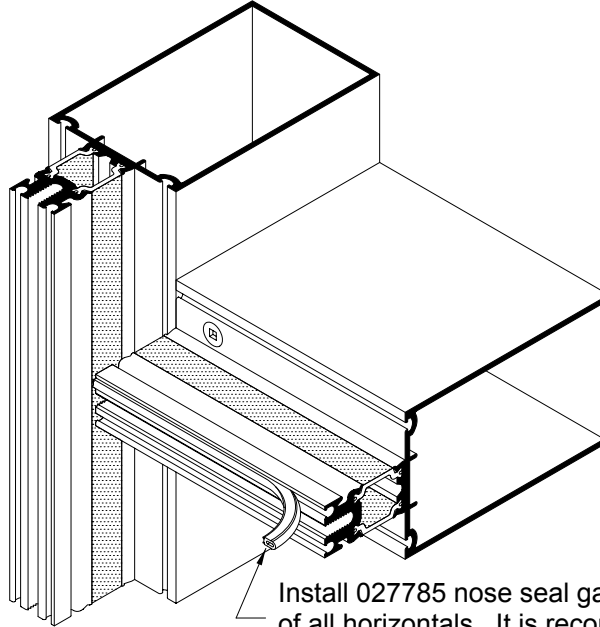
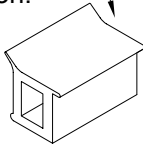
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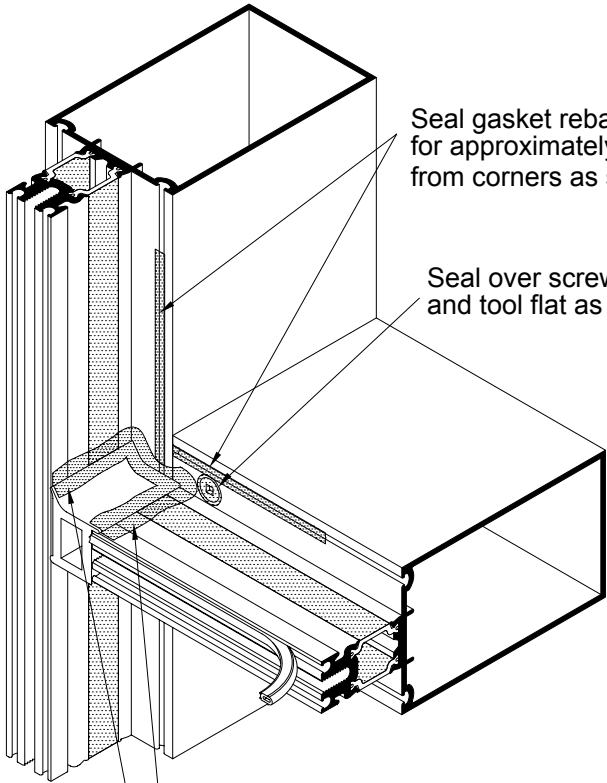
Note: All surfaces must be cleaned following sealant manufacturer's recommended practice.

Solvent wipe joint plug and butter end of joint plug with silicone and install. Seat firmly in place to face of mullion.

7525
824306 shown
7550
824307 similar



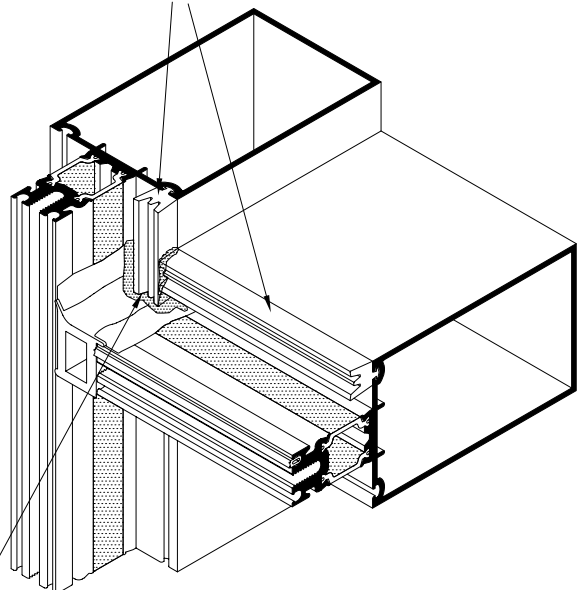
Install 027785 nose seal gasket in upper pocket only, of all horizontals. It is recommended to install to the horizontal in shop environment to ease installation. Allow 1/2" overhang per side to account for shrinkage. Trim prior to inserting joint plug.



Seal gasket rebates for approximately 3" from corners as shown.

Seal over screw heads and tool flat as shown.

Install 127141 interior gasket.
Vertical gasket length = D.L.O. + 1 1/2" + 1/8" /ft
Horizontal gasket length = D.L.O. + 1/8" /ft



Seal back of interior gasket at corners, as shown. Tool all sealant squeeze out.

Note: If glass is to be set after sealant has cured, make sure there is no excess sealant on the gasket surface which will contact the glass.

Seal over joint plug with sealant and tool as shown. Sealant should be neatly applied to prevent contact with I.G. unit.

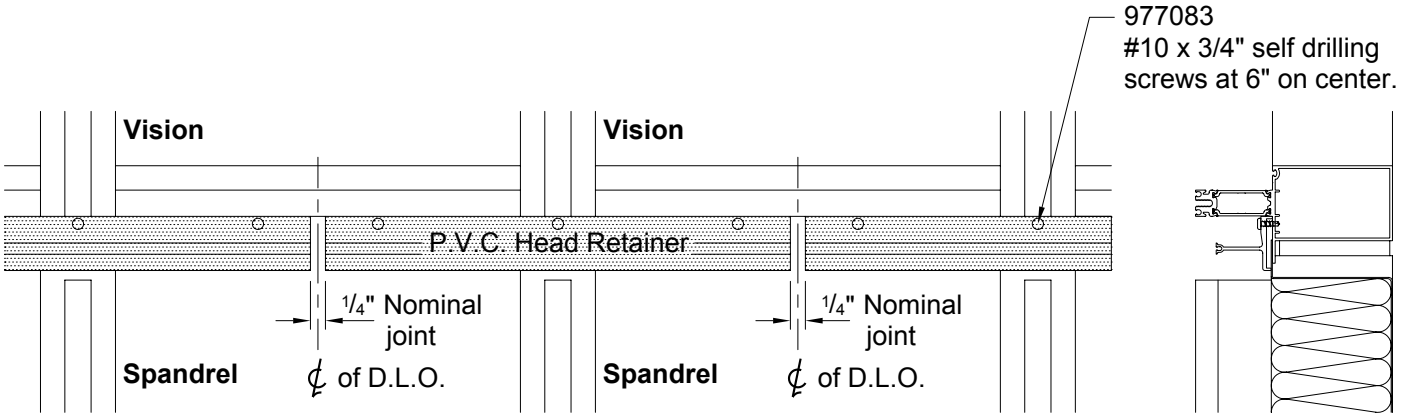
Ensure all cavities are adequately sealed.

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SPANDREL GLAZING

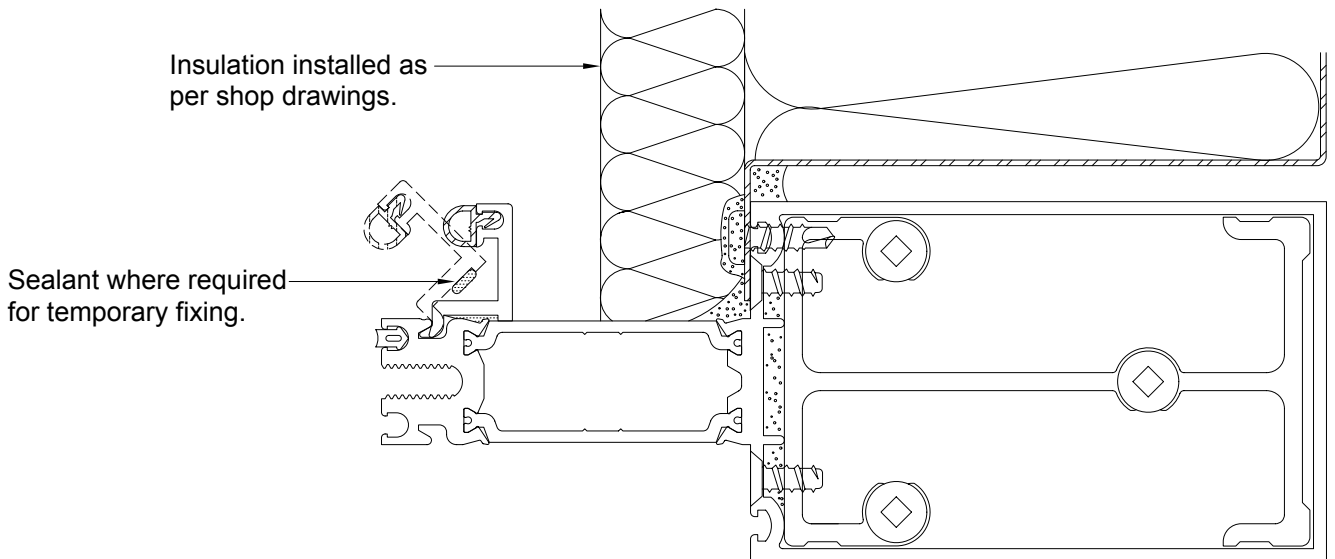
At expansion joint conditions apply 824308 1-1/2" x 1/4" butyl tape to P.V.C. head retainer clip and install as shown. Butyl tape should protrude 1/8" from each end of clip so that it fills 1/4" gap at joint when installed. Fasten with 977083 #10 x 3/4" pan head self drilling screws at 6" on center.



Seal over the 1/4" joint with high quality butyl sealant, and tool.

Install interior bulb gasket to head retainer. Gasket can be installed continuous along horizontal run of the curtain wall.

Install interior bulb gasket to 824011 spandrel adaptor, cut to adaptor length. Rotate adaptor into position on mullion nose as shown at location required. Adaptor can be temporarily fixed in position with sealant (be sure adaptor is fully seated in position before sealant cures).

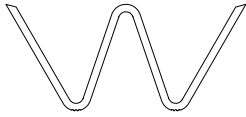


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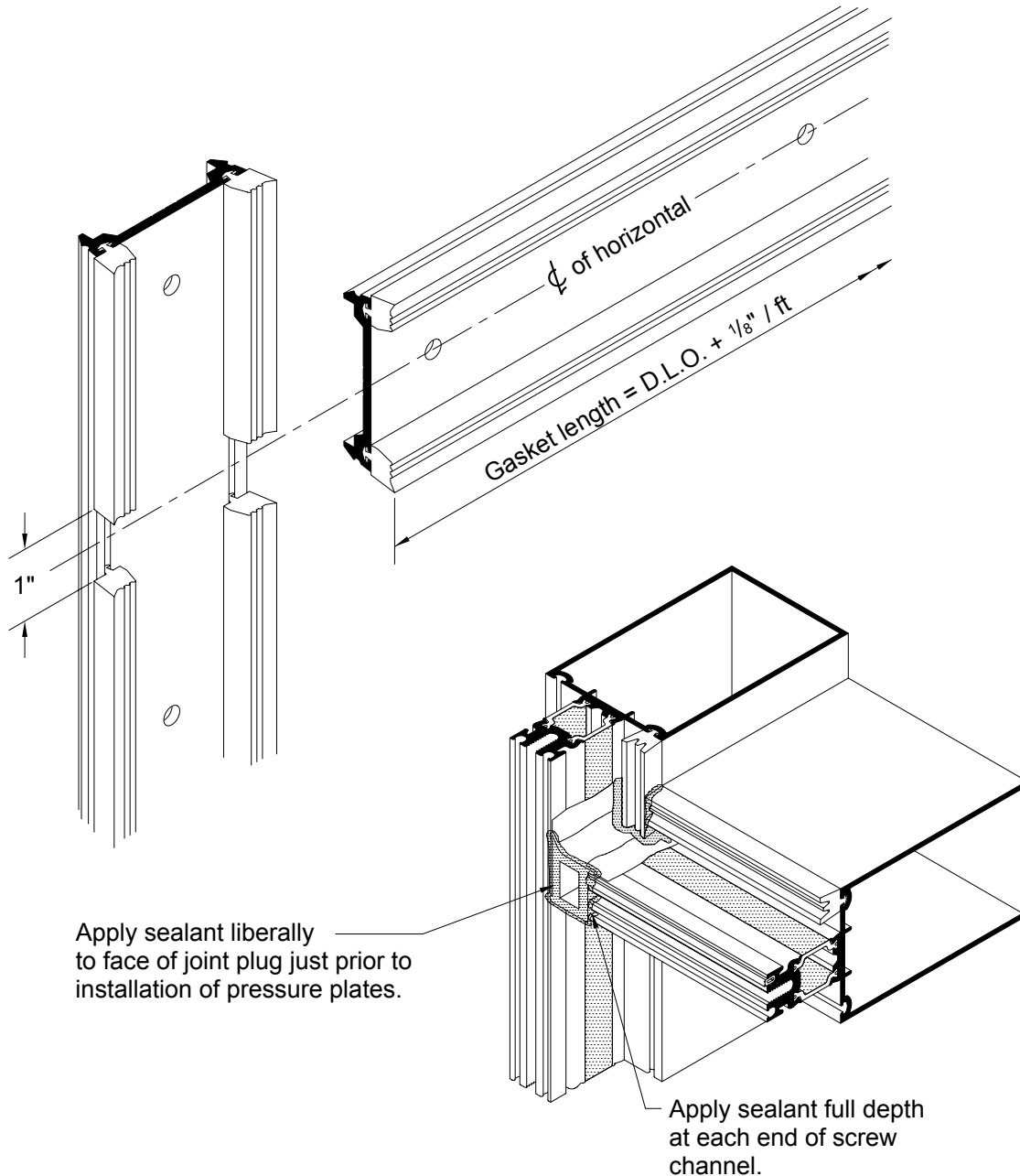
Install setting blocks. For 7525, locate at 1/4 points from edge of glass unit, or as shown on shop drawings. For 7550, locate at 6" (152 mm) from edge of glass unit, or as shown on shop drawings. Set glass in place and center side-to-side. Temporarily fix glass with clips made from short pieces of pressure plate and exterior gasket and 029311, 1/4" - 20 x 5/8" machine screw.

Install "W" blocks at center height of insulating glass units between edge of glass and mullion tongue.



"W" Side Block
123391 Double Glazed
123392 Triple Glazed

Install 027-780 exterior gasket to vertical and horizontal pressure plates as shown. Gasket must be removed from vertical pressure plates for approximately 1" at each horizontal centerline location to clear joint plug and horizontal mullion nose.

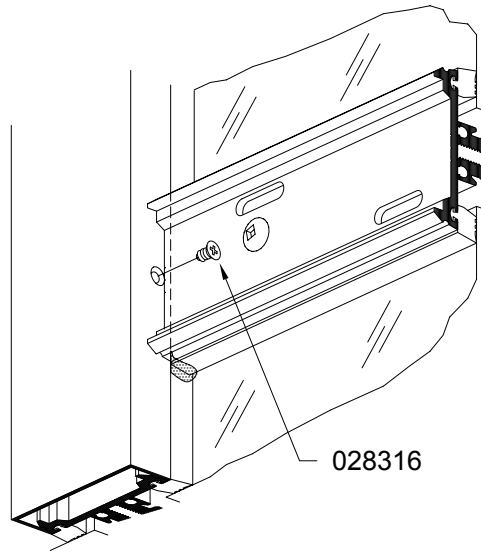
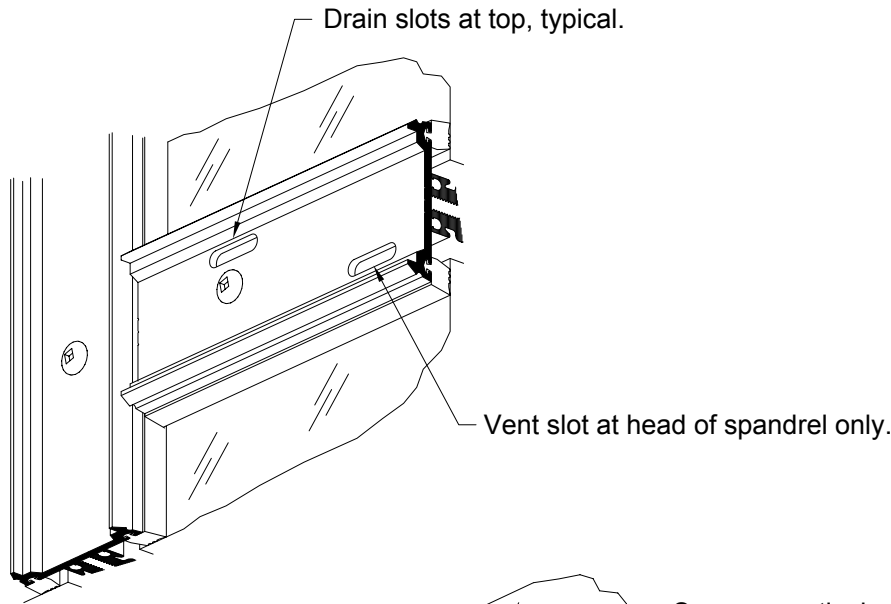


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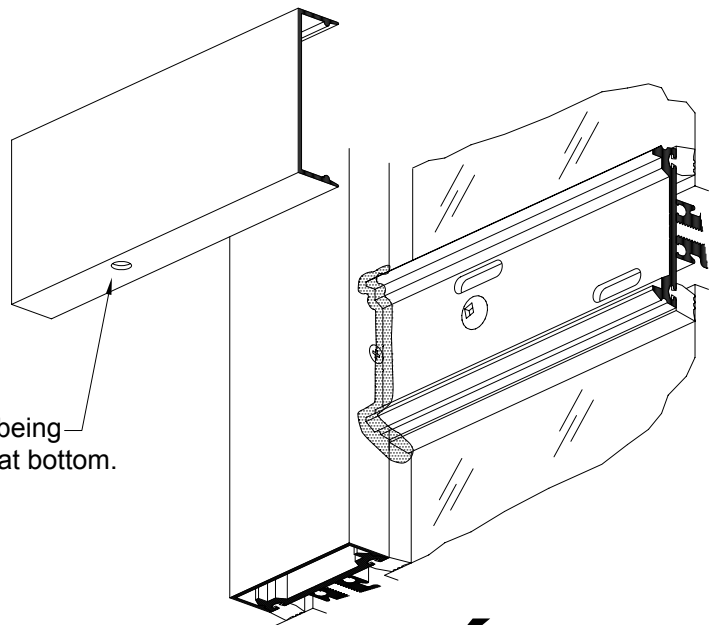
Install vertical and horizontal pressure plates using 029311, 1/4" - 20 x 5/8" machine screw at 6" on center.

Note: Seal over screws holes not used with sealant at horizontal pressure plates to reduce water entry into glazing pocket at top of the lower lite of glass.



Snap on vertical cap. Match drill .147 dia. (#26 drill) holes in leg of pressure plate using cap as a template. Secure cap with 028316 #8 x 3/8" F.H. self tapping screw. Typically one location per vertical at horizontal centerline.

Seal gap between horizontal pressure plate and vertical cover with sealant and tool. Snap on horizontal caps.

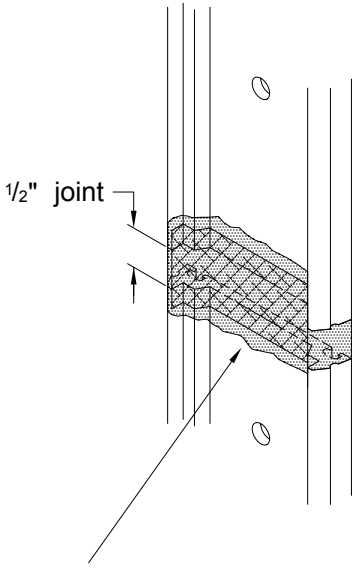


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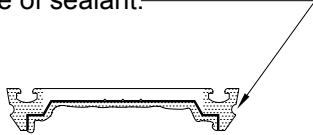
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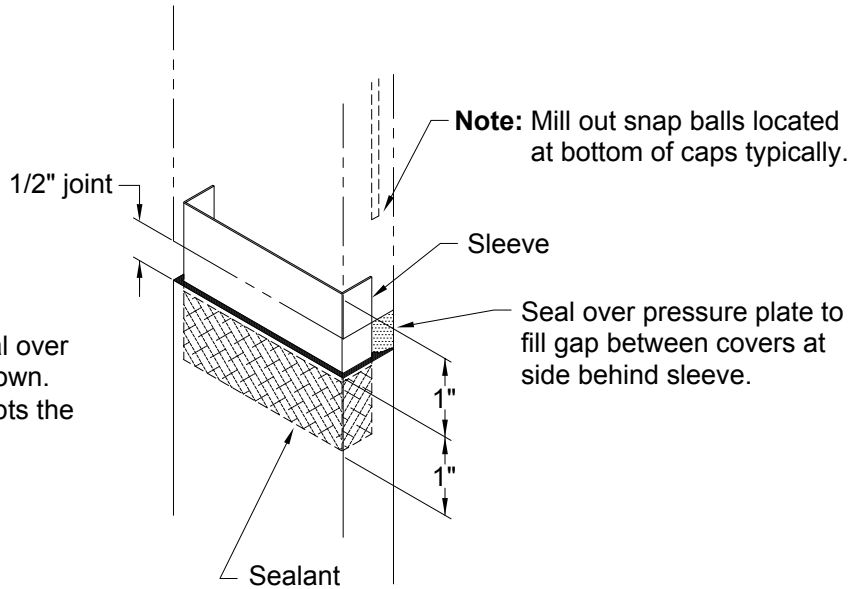
Seal joint between pressure plates at expansion condition as shown.



Apply 1" bond breaker tape over joint and seal over tape, tying seal onto the pressure plate as shown. Tool sealant. Keep the snap race which accepts the snap on cover free of sealant.



At expansion joint conditions or at any cap control joint, a sleeve is required at the top of the lower snap cover. Bond the formed sleeve to the cover as shown with silicone sealant and allow to cure prior to installing the cover. Install the covers progressing from the bottom frames up.



GLAZING COMBINATIONS

INFILL THICKNESS	MULLION TYPE	EXTERIOR GLAZING	INTERIOR GLAZING	ADAPTOR
0.925" to 1.075"	7525	027780	127141	-
6mm (1/4") Spandrel	7525	027780	027228	824011 / 824302
1.925" to 2.075"	7550	027780	127141	-
6mm (1/4") Spandrel	7550	027780	027228	824011 / 824301

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