

Integrity Double Hung Impact Mullion Kit Instructions



BEFORE YOU BEGIN

IMPORTANT

Read these instructions thoroughly before beginning to assemble any multiple Integrity units. Failure to assemble as recommended will void any warranty, written or implied. Refer to specific product installation instructions for proper installation methods.



WARNING

Practice safety! Wear safety glasses or goggles and appropriate hearing protection when assembling multiple Integrity window and door products.

NOTE: When specifying or considering the structural load requirements for windows and doors, it is important to consider the method of fastening the unit(s) together in addition to the method of fastening multiple assemblies into an opening. The methods contained herein may not be appropriate for all performance requirements. Selection of the appropriate fastening method(s) is the sole responsibility of the installer, contractor, structural engineer, architect, building owner and/or installer.

Double Hung multiple assemblies can be ordered factory mullioned up to 4 units wide by 1 unit high, or 2 units wide by 2 units high as long as the following limitations are not exceeded:

Maximum RO Width: 113 1/2" (2883) not to exceed

76 1/4" (1937) in height.

Maximum RO Height: 92" (2337) not to exceed

62 1/2" (1588) in width.

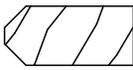
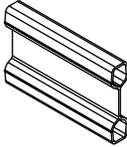
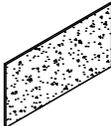
Assemblies exceeding these limitations must be field mullioned and must be assembled using a structural mullion kit designed specifically for Integrity multiple assemblies. Contact your Integrity dealer for additional information.

The construction adhesive called for in the round top over double hung instructions should meet AFG-01 specifications.

Table of Contents

Vertical Impact Mullion Kit.....	1
Horizontal Impact Mullion Kit	4

Vertical Impact Mullion Kit

Parts Shipped With Impact Mullion Kit		
Illustrations (not to scale)	Description and Color	Part/Profile Number
	Mull tie*	W8952
	Interior mull trim 120" (3048)	W1241
	Aluminum Stiffener*	A2145
	Mull sealant foam tape - 1 sided adhesive 96" (2438)	10501124
	Aluminum mulling pin*	A330
	Aluminum Stiffener - 2 sided adhesive tape (black)* 96" (2438)	11406227
	Nailing fin connector	10500213
	Mull sill block 8" (203)	W11120
	Mull sill block screw*	11800758

* Length/color/number will vary depending on particular mull kit ordered.

NOTE: Mullion kits will also include either mullion clips or mullion brackets with screws, depending on the type of installation. See Supplemental Instructions for IZ3 Rated Products for more information.

You Will Need to Supply

Safety glasses	Hearing protection
Phillips screwdriver	Hammer
Power drill	3/16" drill bit
Clamps	Hacksaw
Silicone sealant w/gun	
1/2" crown x 1" leg 16 gauge staples w/gun	
3/16" crown x 1" leg 18 gauge staples w/gun	

Mulling Procedures - Vertical

1. Lay frames on a flat surface in the desired mulling configuration (interior facing up). Remove nailing fin from side jambs that will be mulled together. Apply mull sealant foam tape along the entire length of one jamb to be mulled ensuring it is located 1/4" (6) from the exterior edge of the Ultrex frame. See figure 1.



Figure 1

IMPORTANT

Units should be flush and square with each other.

2. Partially pull nailing fin/drip cap from head jambs near mullion to expose side jamb nailing fin kerf and allow for mulling pin installation later.
3. Apply 2 sided foam tape to both sides of aluminum stiffener as shown, starting/stopping 3" (76) from each end. See figure 2. Install stiffener to Ultrex jamb locating stiffener 2" (51) from exterior edge of head jamb. See figure 3.

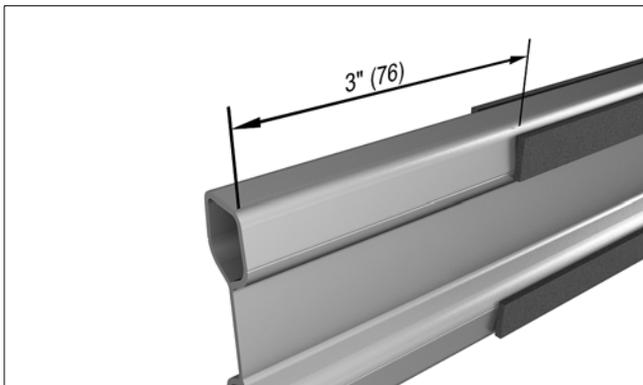


Figure 2



Figure 3

4. Insert 8" (203) sill block 4" (102) into sill cavity and secure with #7x5/8" screw. See figure 4.



Figure 4

5. Position the units together in the desired configuration. Check to be sure that the frames at both ends of the mullion are flush and the nailing fin kerfs are aligned. Lightly clamp units together on interior (use wood blocks to protect interior) near each end to hold two mulled units in place. See figure 5.

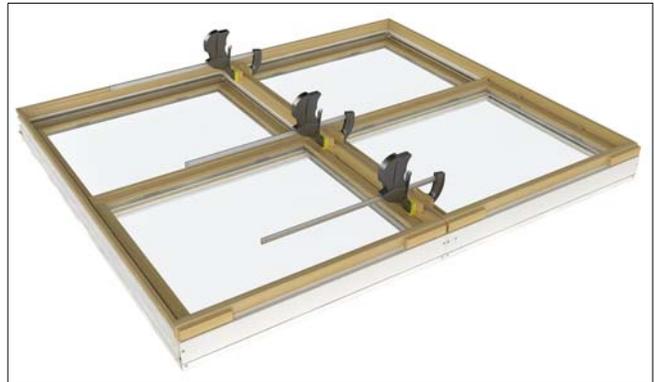


Figure 5

- Slide the mulling pin in the full length of the mullion. A hammer may aid in the application of the mull pin. The mull pin ends must be recessed 1/4" (6) to allow sealant application later. See figure 6.



Figure 6

- Remove the wood standing blocks at the sills near the mullion. Center mull tie block at junction points and attach with four 3/16"x1" 18 gauge staples into each unit. See figure 7.

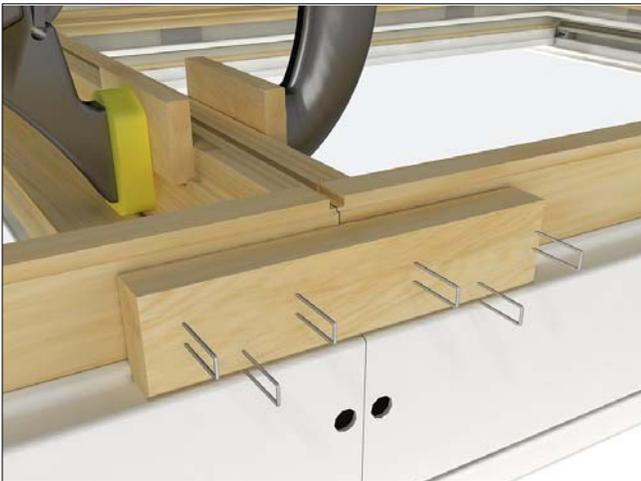


Figure 7

- Join the wood frame members along the interior of the mullion. Apply a third clamp and wood blocks to interior as needed. Make sure mullied units are flush and square at the sill and jamb liners. Fasten interior of mullied units with 1/2"x1" 16 gauge staples spaced every 4" (102).

- Apply silicone sealant at the mullion from the frame exterior edge to the drip cap/nailing fin kerf and across the kerf over the mulling pin. Apply nailing fin connector at the head jamb and sill by removing the paper backing from the connector and pressing into place. See figure 8.

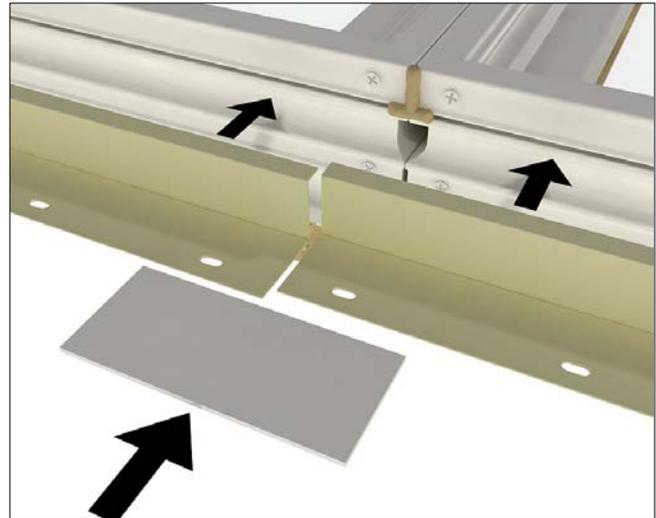
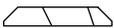
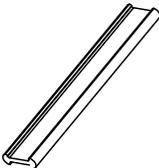
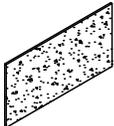


Figure 8

- If applicable, jamb extension can now be installed. Follow installation instructions for installing unit into rough opening or masonry opening.

NOTE: Interior mull trim should be applied only after unit is completely installed and interior trim is applied.

Horizontal Impact Mullion Kit

Parts Shipped With Horizontal Impact Mullion Kit		
Illustrations (not to scale)	Description and Color	Part/Profile Number
	Mull tie*	W8952
	Interior mull trim	W1242
	Aluminum mulling pin*	A330
	Mull sealant foam tape - 1 sided adhesive*	10500214
	Nailing fin Connector	10500213

* Length/color/number will vary depending on particular mull kit ordered.

NOTE: Mullion kits will also include either mullion clips or mullion brackets with screws, depending on the type of installation. See Supplemental Instructions for IZ3 Rated Products for more information.

You Will Need to Supply

Safety glasses	Hearing protection
Phillips screwdriver	Hammer
Power drill	3/16" drill bit
Clamps	Hacksaw
Silicone sealant w/gun	
1/2" crown x 1" leg 16 gauge staples w/gun	
3/16" crown x 1" leg 18 gauge staples w/gun	

Mulling Procedures - Horizontal

1. Lay frames on a flat surface in the desired mulling configuration (interior facing up). Remove nailing fin from the head jambs and sills that will be mulled together. Apply the mull sealant foam tape along the entire length of the head jamb of the lower unit. Mull tape should be located 1/4" (6) from the exterior edge of the Ultrex frame. See figure 9.



Figure 9

IMPORTANT

Units should be flush and square with each other.

2. Remove standing blocks from the sill of the upper unit. Install the mull filler block to the full length of the sill of the upper unit with 3/16"x1" 18 gauge staples as shown in figure 10.



Figure 10

3. Position the units together in the desired configuration. Check to be sure that the frames at both ends of the mullion are flush and the nailing fin kerfs are aligned. Lightly clamp units together on interior (use wood blocks to protect interior) near each end to hold the 2 sided mullied units in place. See figure 11.

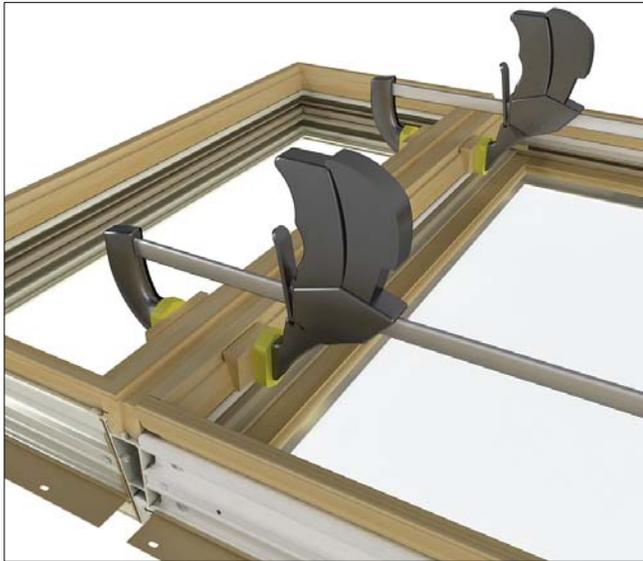


Figure 11

4. Slide the mulling pin in the full length of the mullion. A hammer may aid in the application of the mull pin. The mull pin ends must be recessed 1/4" (6) to allow sealant application later. See figure 12.

NOTE: If mulling a direct glaze polygon to a double hung unit, drill out the nailing fin/drip cap kerf on the sill of the polygon with a 3/16" drill bit. This will help facilitate the installation of the aluminum mulling pin. Clean away any fibers or filings from the kerf area.

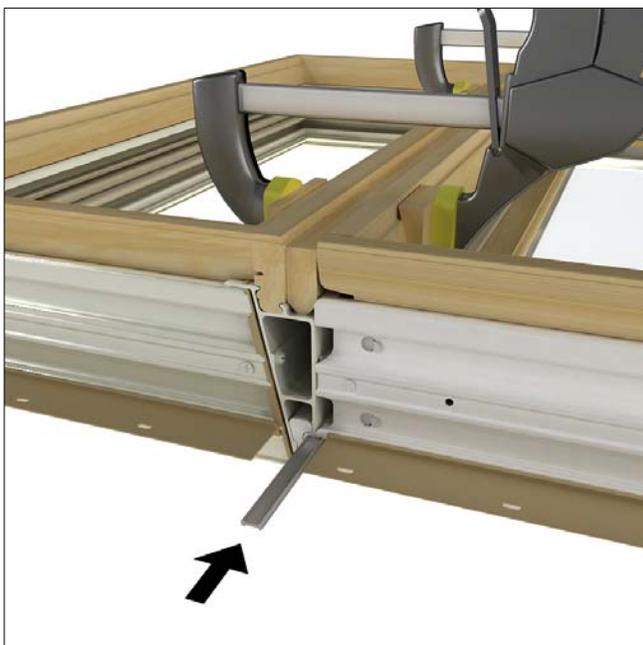


Figure 12

5. Apply a third clamp and wood blocks to interior as needed. Make sure mullied units are flush and square at the sill and jamb liners. Fasten interior of mullied units with 1/2"x1" 16 gauge staples spaced every 4" (102).
6. Apply silicone sealant at the mullion from the frame exterior edge to the drip cap/nailing fin kerf and across the kerf over the mulling pin as shown in illustration 6. Apply nailing fin connector at the jambs by removing the paper backing from the connector and pressing into place. See figure 13.

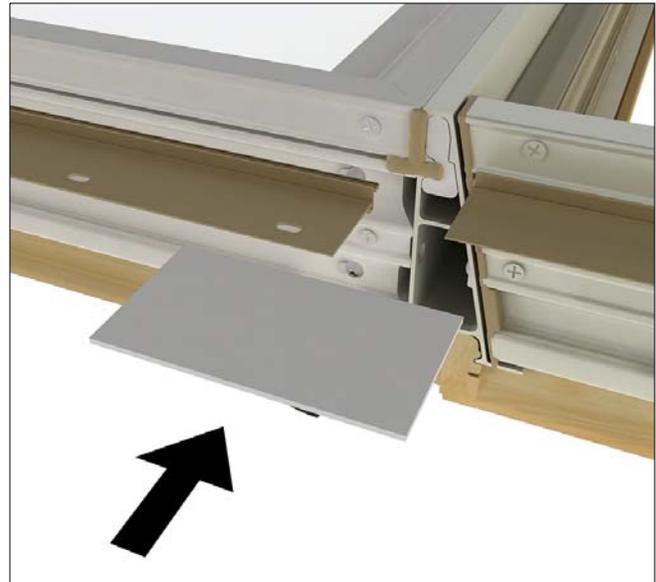


Figure 13

7. If applicable, jamb extension can now be installed. Follow installation instructions for installing unit into rough opening or masonry opening.

NOTE: Interior mull trim should be applied only after unit is completely installed and interior trim is applied.