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 mullled 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 mullled 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.

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Vertical Impact Mullion Kit

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<th>Description and Color</th>
<th>Part/Profile Number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Mull tie*</td>
<td>W8952</td>
</tr>
<tr>
<td></td>
<td>Interior mull trim 120” (3048)</td>
<td>W1241</td>
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<tr>
<td></td>
<td>Aluminum Stiffener*</td>
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<td>Mull sealant foam tape - 1 sided adhesive 96” (2438)</td>
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<tr>
<td></td>
<td>Aluminum mulling pin*</td>
<td>A330</td>
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<tr>
<td></td>
<td>Aluminum Stiffener - 2 sided adhesive tape (black)* 96” (2438)</td>
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<tr>
<td></td>
<td>Nailing fin connector</td>
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<tr>
<td></td>
<td>Mull sill block 8” (203)</td>
<td>W11120</td>
</tr>
<tr>
<td></td>
<td>Mull sill block screw*</td>
<td>11800758</td>
</tr>
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* 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.
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.

   **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.

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

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You Will Need to Supply

<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Safety glasses</td>
<td>Hearing protection</td>
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<tr>
<td>Phillips screwdriver</td>
<td>Hammer</td>
</tr>
<tr>
<td>Power drill</td>
<td>3/16” drill bit</td>
</tr>
<tr>
<td>Clamps</td>
<td>Hacksaw</td>
</tr>
<tr>
<td>Silicone sealant w/gun</td>
<td></td>
</tr>
<tr>
<td>1/2” crown x 1” leg staples</td>
<td></td>
</tr>
<tr>
<td>3/16” crown x 1” leg staples</td>
<td></td>
</tr>
</tbody>
</table>

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**Figure 1**

**Figure 2**

**Figure 3**

**Figure 4**

**Figure 5**
6. 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.

7. 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.

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

9. 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.

10. 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

<table>
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<tr>
<th>Illustrations (not to scale)</th>
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<td>Interior mull trim</td>
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<td></td>
<td>Mull sealant foam tape - 1 sided adhesive*</td>
<td>10500214</td>
</tr>
<tr>
<td></td>
<td>Nailing fin Connector</td>
<td>10500213</td>
</tr>
</tbody>
</table>

* 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](image)

**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](image)
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 mulled units in place. See 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.

5. Apply a third clamp and wood blocks to interior as needed. Make sure mulled units are flush and square at the sill and jamb liners. Fasten interior of mulled 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.

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.