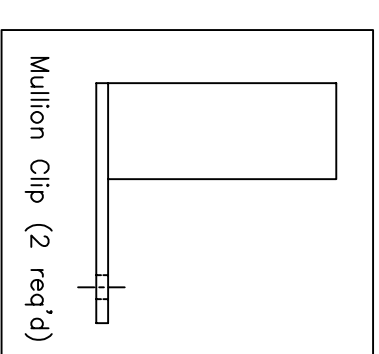
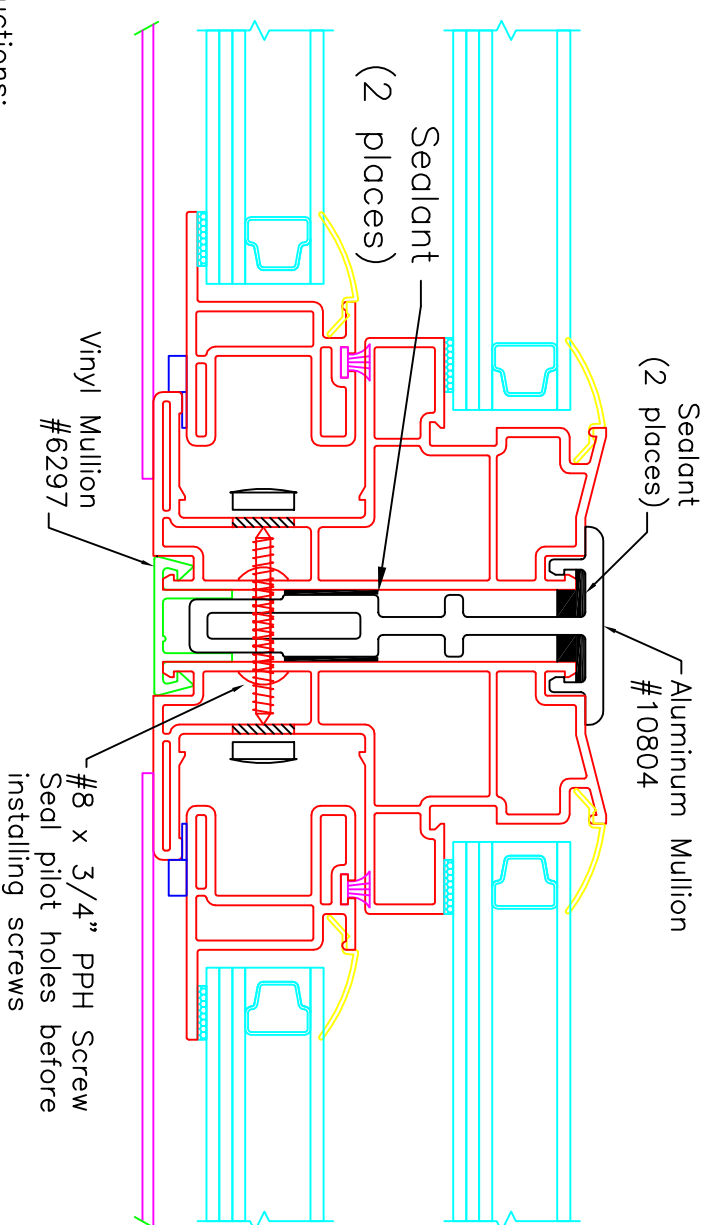
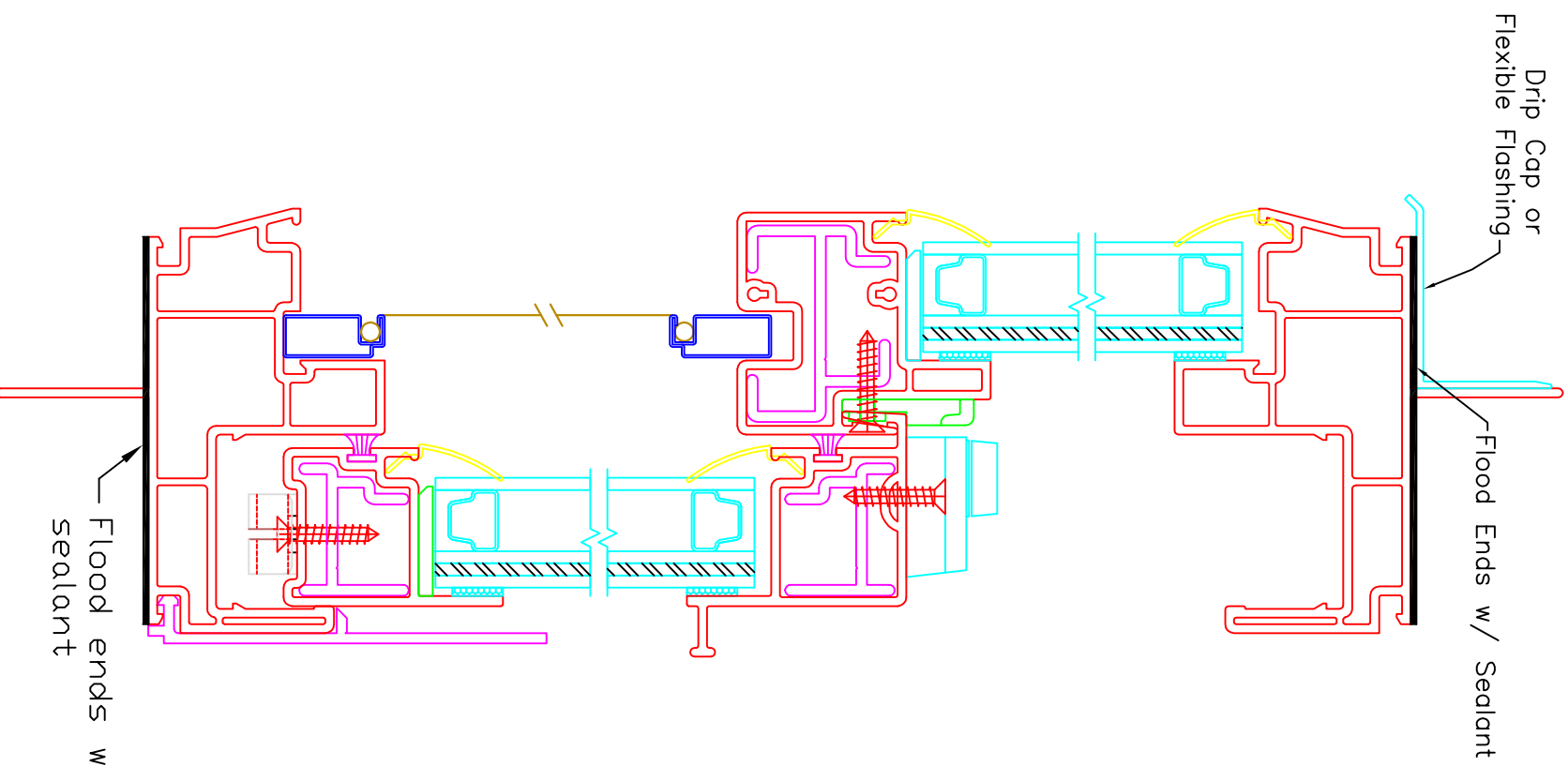


THIS DRAWING IS PROPRIETARY AND CONFIDENTIAL TO ATRUM COMPANIES, INC. AND SHALL NOT BE REPRODUCED, COPIED OR DISSEMINATED WITHOUT THE EXPRESSED WRITTEN PERMISSION OF ATRUM COMPANIES, INC..



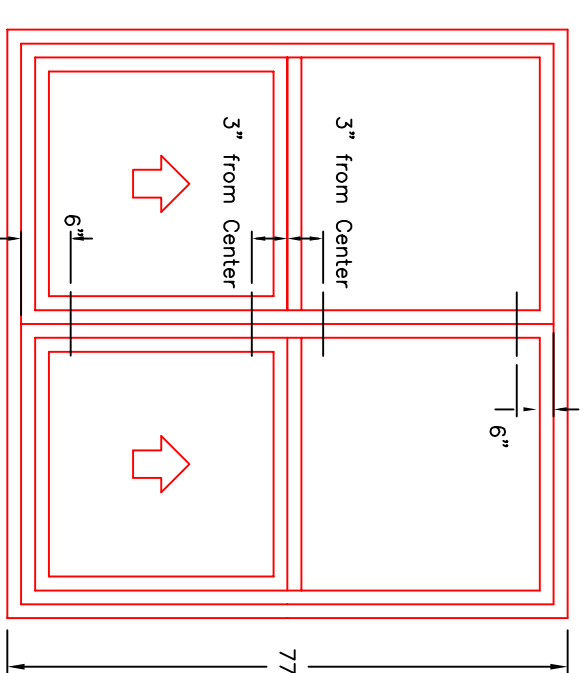
- Mulling Prep Instructions:**
1. Determine inside and outside of windows to be mulled.
 2. Remove opposing nail fins located on vertical jambs.

Mulling Instructions:

1. Place windows side by side in a vertical position.
2. Apply a 3/8" bead of sealant on vertical jambs, 1" in from inside surface (see drawing).
3. Apply a 3/8" bead of sealant on the mullion where it will contact the jamb (see drawing).
4. Snap-in Aluminum Mullion #10804, as shown in assembly.
5. At locations shown in Fastener Detail, drill 1/8" pilot holes (centered) in vertical balance pockets of both windows.
6. Drill 3/8" holes thru first wall of vinyl, fill each hole with sealant.
7. Install #8 x 3/4" P.P.H. screws, refill holes with sealant and snap on buttons.
8. Snap on Vinyl Mullion Cover #6297, as shown in assembly.
9. Flood cavities at each end of the mullion with sealant. Note— do not fill mull clip hollows.

Field Installation Instructions:

1. At mullion top and bottom, fill open areas with sealant.
2. Slide Mullion Clips into mullion interior cavities, top and bottom.
3. Install #8 x 3/4" P.P.H. screws, at HEAD and SILL. 1" from corners, refer to Fastener Detail. Follow steps Mulling Instructions 6, 7, and 8.
4. At top exterior of unit, apply a large bead of sealant to the top of both windows.
5. Apply drip cap or flexible flashing to gap in fins.
6. Clip Fasteners: install 2 per clip — #10 x 1 3/4" P.P.H. screws.



REVISIONS

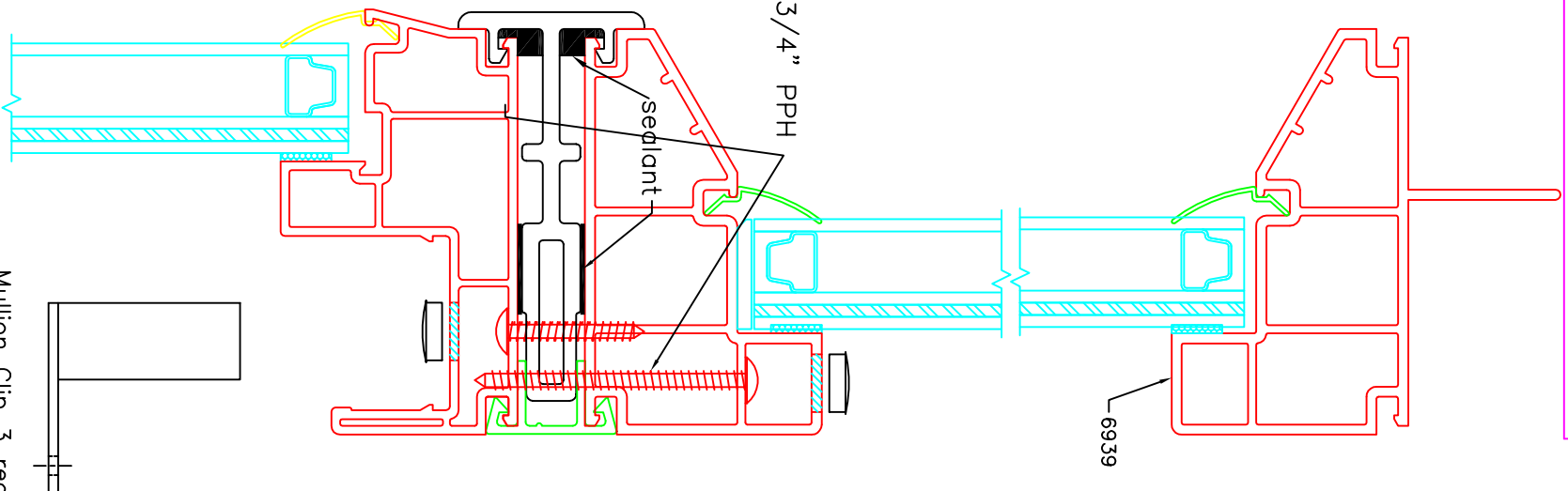
NO.	DATE	DESCRIPTION	CHG'D BY

MANUFACTURING LOCATIONS:



TITLE
Series 30/230 Impact Single Hung
ADW-01 30 230 SH TW Mulling Instructions

ALDVI	TEMPER	EST. AREA lb XXXX	TOLERANCES
			XXX = +/- .XXX XXXX = +/- .XXXX XX DEG = +/- .XX DEG
MATERIAL	SCALE	EST. WEIGHT IN lb./ft. XXXX	SHEET SIZE
	1:1		ANSI C
EST. WEIGHT IN kg/m XXXX	DATE	APPROVED BY:	DRAWING
	28 JANUARY 2009 <td>Doug H. <td>30 230 SH Mullion Detail</td> </td>	Doug H. <td>30 230 SH Mullion Detail</td>	30 230 SH Mullion Detail
			Sheet 1/1



Mulling Prep Instructions:

1. Determine inside and outside of windows to be mulled.
2. Remove opposing nail fins located on SH vertical jambs, heads, and transom sill.

Twin Mulling Instructions:

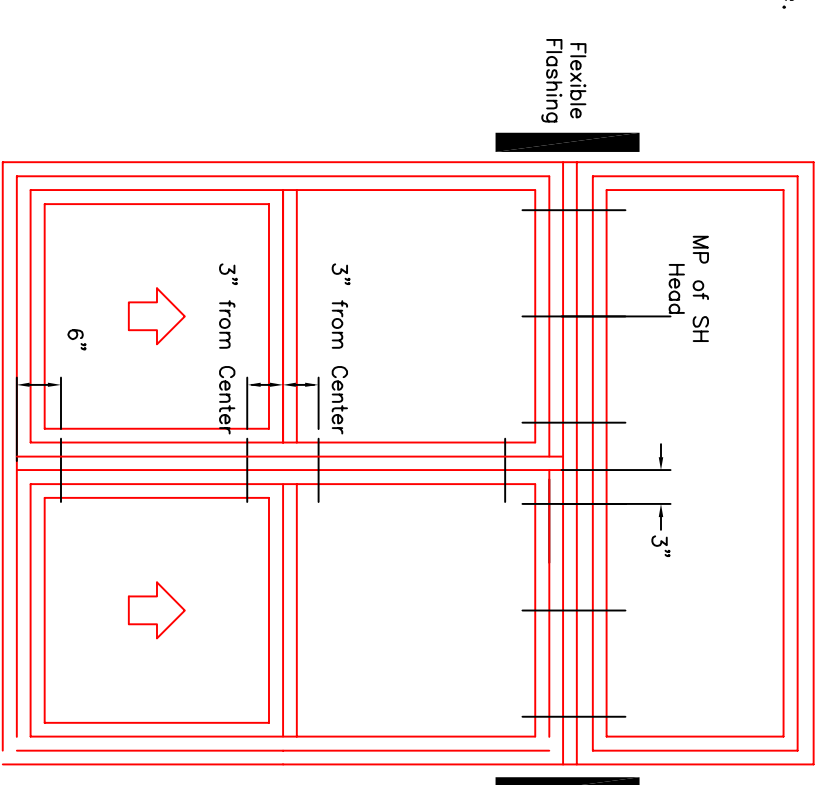
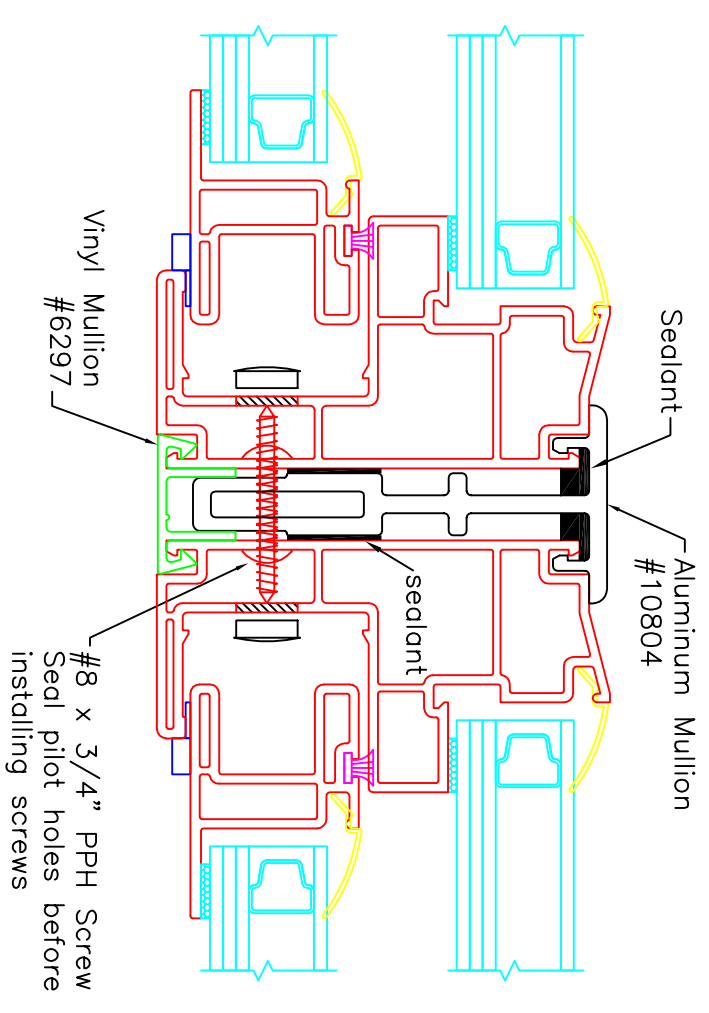
1. Place windows side by side in a vertical position.
2. Apply a 3/8" bead of sealant on vertical jambs, 1" in from inside surface.
3. Apply a 3/8" bead of sealant on the mullion where it will contact the jamb.
4. Snap-in Aluminum Mullion #10804, as shown in assembly.
5. At locations shown in Fastener Detail, drill 1/8" pilot holes (centered) in vertical balance pockets of both windows.
6. Drill 3/8" holes thru first wall of vinyl, fill each hole with sealant.
7. Install #8 x 3/4" P.P.H. screws, refill holes with sealant and snap on buttons.
8. Snap on Vinyl Mullion Cover #6297, as shown in assembly.

Transom Mulling Instructions:

1. Apply a 3/8" bead of sealant on twin HEADS, transom SILL 1" in from inside surface. At top of mullion, fill open are with sealant.
2. Apply a 3/8" bead of sealant on the mullion where it will contact the jamb.
3. Snap-in Aluminum Mullion #10804, as shown in assembly.
4. Follow steps 5 to 7 for Single Hung HEAD fastener installation.
5. Follow steps 5 to 7 for Transom SILL fastener installation. Use #8 x 1 3/4" P.P.H..
6. Snap on Vinyl Mullion Cover #6297, as shown in assembly.

Field Installation Instructions:

1. Follow Twin and Transom Mulling Instructions.
2. Slide Mullion Clips into mullion interior cavities, bottom, and both sides.
3. Install #8 x 3/4" P.P.H. screws, at SILL. 1" from corners, refer to Fastener Detail. Follow steps Mulling Instructions 5, 6, and 7.
4. Apply flexible flashing at vertical intersection of SH and Transom.



REVISIONS

NO.	DATE	DESCRIPTION	CHG'D BY

MANUFACTURING LOCATIONS:

TITLE: **Series 30/230 Impact Single Hung**
ADW-01 30 230 SH TW with Transom Mulling Instructions

ALLOY:	TEMPER:	EST. AREA IN XXXXX	TOLERANCES:
			XXX = +/- .XXX XX = +/- .XX X = +/- .X
MATERIAL:	SCALE:	EST. WEIGHT IN lb./ft. XXXXX	SHEET SIZE:
	NTS		ANSI C
DRAWN BY:	APPROVED BY:	DATE:	DRAWING:
JTS	DH	28 JAN 2009	30 SH TW ST Mull Detail

