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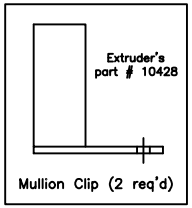
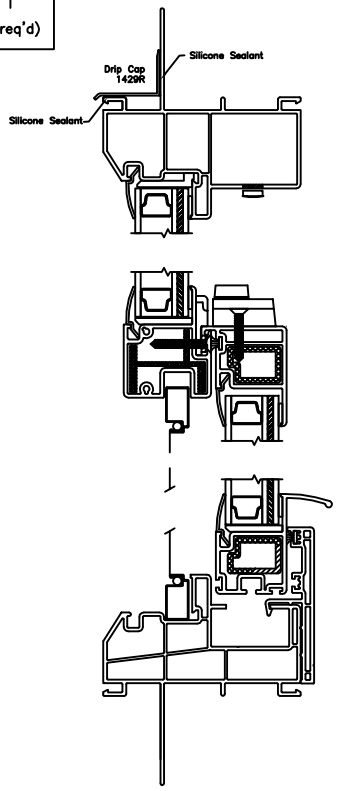
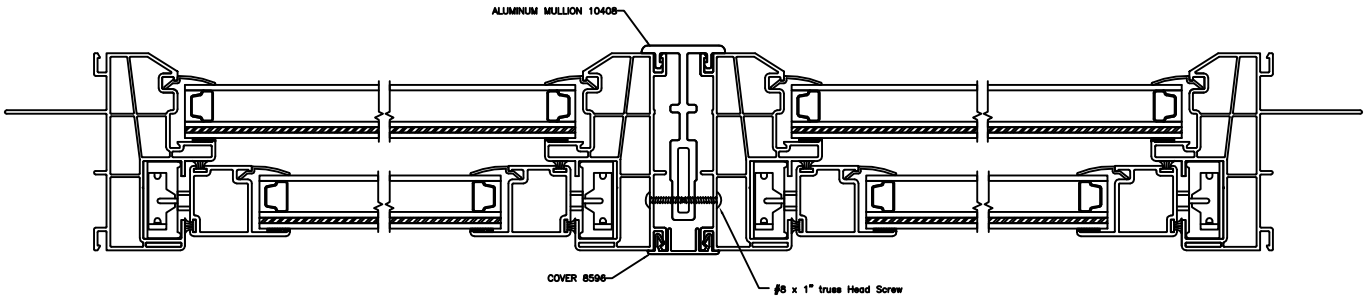



Mulling Prep Instructions:

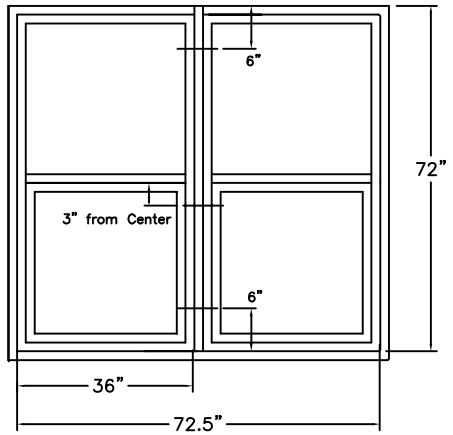
1. Determine inside, and outside of windows to be mulled.
2. Remove opposing nail fins located on vertical jambs.

Mulling Instructions:

1. Place windows side by side in a vertical position.
2. Apply a large bead of sealant on vertical jambs, 1" in from inside surface.
3. Apply sealant in the vertical grooves, outside surface, where mullion will snap–in.
4. Snap–in Aluminum Mullion #10408, as shown in assembly.
5. At locations shown in Fastener Detail, drill 1/8" pilot holes (centered) in vertical balance pockets of both windows. Do not install screws thru clips, at this time.
6. Drill 3/8" holes thru first wall of vinyl, fill each hole with sealant.
7. Install #8 x 1" P.T.H. screws, refill holes with sealant and snap on buttons.
8. Snap on Vinly Mullion Cover #8596, as shown in assembly.

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. At top exterior of unit, apply a large bead of sealant to the top of both windows.
4. Apply vinyl drip cap #1429R and staple to fin.
5. Clip Fasteners: install 2 per clip – #10 x 1 3/4" P.P.H. screws.




TITLE:
50 S.H. IMPACT ASSY
ADW-13 50 SH Twin Mulling Instructions

| REVISIONS | | VERTICAL SECTION | | ECN # |
|---|---|---|---|---|
| NO. | DATE | DESCRIPTION | CHG'D BY | ECN-2006-0996 (Initial Issue) |
| X | X-XX-XXXX | XXXXXXXXXXXXXXXXXX | XXXXXX | ECN-XXXX-XXXX |

ATRIUM COMPANIES, INC.

MANUFACTURING LOCATIONS: ADW-13

| | | | |
|---|---|---|---|
| ALLOY: | TEMPER: | EST. AREA in: XXXXX | TOLERANCES: X.XX = +/– X.XX; X.XXX = +/– X.XXX; X.X DEG = +/– X.X DEG |
| MATERIAL: | SCALE: 1=1/2 | EST. AREA cm: XXXXX<br>EST. WEIGHT in lb./ft.: XXXXX<br>EST. WEIGHT in kg./m: XXXXX | SHEET SIZE: ANSI B |
| DRAWN BY: | APPROVED BY: RI | DATE: 12-5-07 | DRAWING TYPE OR DIE #: 50 SH TWIN Sheet 1/1 |

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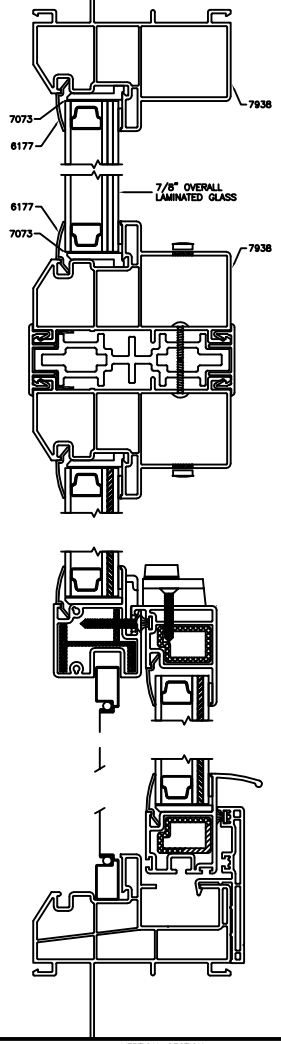
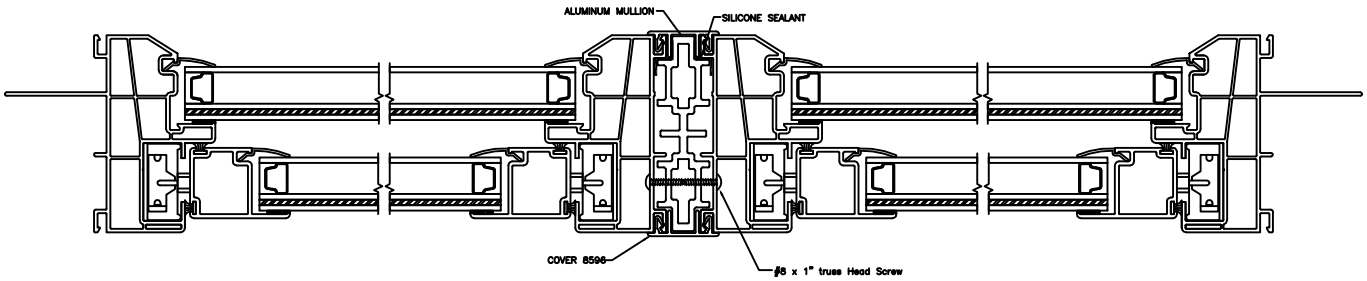



VERTICAL SECTION




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.

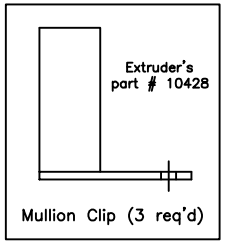
Transom Mulling Instructions:

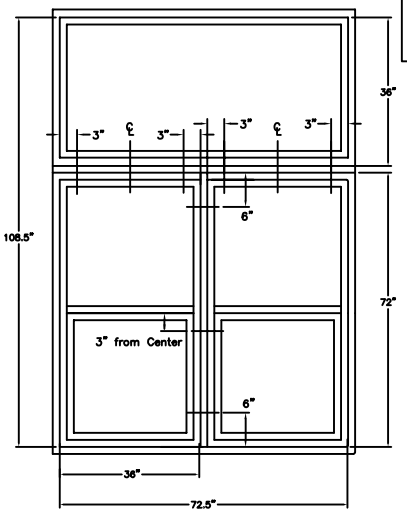
At top of mullion, fill open are with sealant.

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 | | | | ECN # |
|---|---|---|---|---|
| NO. | DATE | DESCRIPTION | CHG'D BY | ECN-2006-0996 (Initial Issue) |
| X | X-XX-XXXX | XXXXXXXXXXXXXXXXX | XXXXXX | ECN-XXXX-XXXX |

ATRIUM COMPANIES, INC.

MANUFACTURING LOCATIONS: ADW-13

TITLE: 50 S.H. IMPACT ASSY
ADW-13 50 SH New Mull Assembly

| ALLOY: | TEMPER: | EST. AREA in: XXXXX | TOLERANCES: X.XX = +/– X.XX |
|---|---|---|---|
| | | EST. AREA cm: XXXXX | X.XXX = +/– X.XXX |
| MATERIAL: | SCALE: 1=1 | EST. WEIGHT lb./ft.: XXXXX | X.X DEG = +/– X.X DEG |
| | | EST. WEIGHT kg./m: XXXXX | SHEET SIZE: ANSI B |
| DRAWN BY: | APPROVED BY: RI | DATE: 2-11-08 | DRAWING TYPE OR DIE #: 50 SH TWIN STACK Sheet 1/1 |