SERIES 3252HP

CURTAIN WALL WITH A POLYAMIDE PRESSURE BAR

NOTE

THE INSTALLATION DETAILS FOUND IN THIS PACKAGE ARE GENERIC AND ARE FOR REPRESENTATION ONLY WITH THE INTENT OF GIVING THE INSTALLATION TEAM A VISUAL REPRESENTATION AS TO HOW THE ASSEMBLIES TYPICALLY INSTALL. THE SHOP SUBMISSION DRAWINGS AND DETAILS ARE THE GOVERNING DOCUMENTS AND AS SUCH THIS PACKAGE IS TO BE USED ONLY AS A RESOURCE

FOLLOW SEALANT MANUFACTURERS' RECOMMENDATIONS FOR USE AND APPLICATION OF ALL STRUCTURAL SILICONE SEALANT AND WEATHER SEAL SILICONE SEALANT.

CUSTOMER/PROJECT QUALITY ASSURANCE PROCEDURES ARE SEPARATE DOCUMENTS AND ARE TO BE FOLLOWED IN CONJUNCTION WITH THIS MANUAL.

11M0365_REV_A_11.21

HANDLING, STORAGE, AND PROTECTION OF ALUMINUM

The following precautions are recommended to protect the material against damage. Following these precautions will help ensure early acceptance of your products and workmanship.

A. HANDLE CAREFULLY.
AII aluminum materials at the job site must be stored in a safe place, well removed from possible damage by other trades. Cardboard wrapped or paper interleaved materials must be kept dry.

B. CHECK ARRIVING MATERIALS.
Check for quantity counts and keep records of where various materials are stored.

C. KEEP MATERIALS AWAY FROM WATER, MUD, AND SPRAY.
Prevent cement, plaster, or other materials from damaging the finish.

D. PROTECT THE MATERIALS AFTER ERECTION.
Protect erected frame with polyethylene or canvas splatter screen. Cement, plaster, terrazzo, other alkaline solutions, and acid based materials used to clean masonry are harmful to the finish. **If any of these materials come in contact with the aluminum, immediately remove with water and mild soap.**

PRESSURE PLATE HANDLING INSTRUCTIONS

HANDLING OF PRESSURE BARS SHOULD BE PERFORMED AS FOLLOWS:

Products are shipped either in a crate (wood or hybrid cardboard/wood) or palletized on a wood skid as specified by US ALUM or customer preference. Palletized material can be moved with a fork lift, tow motor, or hand truck. Crated material should be moved via a fork lift or tow motor and supported always at the midpoint of the crate.

If stacking created, work crates are not to be stacked more than three high and hybrid crated not more than two high. Improperly stacking crates or staking crated higher than recommended can cause creates to fall, causing potential injury to workers or damage to the material.

When handling US ALUM product directly, be sure to used the proper Personal Protective Equipment (PPE). The proper PPE should included, a minimum, gloves and eye protection. US ALUM products are not hazardous/toxic and do not require a MSDS.

IMPROPER STORAGE CONDITIONS:

The pressure bars must be properly supported for the entire length of the part to avoiding sagging of the material.

The longer the storage period, the greater the possibility of the sag becoming permanent if improperly stored. If the pressure bars are longer than the pallets or racks in which they are stored, they many sag at the ends. (i.e. 24 feet long strips on 20 feet long pallets) This also applies to pressure bar stored on pallets where there is no continuos floor or bottom support.

Bundled pressure plates may also become deformed over time if individual bundles are not removed, separated and straightened.

CORRECT STORAGE PROCEDURE:

In order to reduce bending, twisting, sagging or deforming of the pressure plates, store them in the following conditions:

- Store pressure plates so that the degree of sag is minimized
- Make sure to support protruding sections
- Brief storage periods, First In - First Out (FIFO)
- Store covered with an ideal room temperature range of 59 to 68º F (15 to 20º C)
- Keep profiles out of direct sunlight and contact with moisture

The rapidly changing technology within the architectural aluminum products industry demands that U.S. Aluminum reserve the right to revise, discontinue, or change any product line, specification, or electronic media without prior written notice.

NOTE: Dimensions in parentheses ( ) are millimeters unless otherwise noted.

GENERAL INSTALLATION NOTES

Recommended guidelines for all installations:

1. **REVIEW CONTRACT DOCUMENTS.** Check shop drawings, installation instructions, architectural drawings, and shipping lists to become thoroughly familiar with the project. The shop drawings take precedence and include specific details for the project. Note any **field verified** notes on the shop drawings prior to installing. The installation instructions are of a general nature and cover most conditions.

2. **INSTALLATION.** All materials are to be installed plumb, level, square, and true.

3. **INSTALLER QUALIFICATION.** The **Series 3252HP** curtain wall system is intended for fabrication, assembly, sealing, installation and glazing by professionals with appropriate knowledge and experience of the system(s) and their incorporation into various building conditions.

4. **BENCH MARKS.** All work should start from bench marks and/or column lines as established by the architectural drawings and the general contractor with guaranteed accuracy. Working from these datum points and lines determine:
   a) The plane of the wall in reference to offset lines provided on each floor.
   b) The finish floor lines in reference to bench marks on the outer building columns.
   c) Mullion spacing from both ends of masonry opening to prevent dimensional build-up of daylight opening.

5. **STEEL ANCHORS.** Steel anchors that weld to steel structure are normally line set before mullions are hung. Outstanding leg of anchors must be at 90 degrees to offset lines. Mullion space should be held to ±1/32" (0.8). Anchor clips vary per job conditions. Follow approved shop drawings for size and location of clips.

6. **FIELD WELDING.** All field welding must be adequately shielded to avoid any splatter on glass or aluminum. Results will be unsightly and/or structurally unsound. Advise general contractor and other trades accordingly. All field welds of steel anchors must receive touch-up paint (zinc chromate) to avoid rust.

7. **SURROUNDING CONDITIONS.** Make certain that construction which will receive your materials is in accordance with the contract documents. If not, notify the general contractor in writing and resolve differences before proceeding with work.

8. **ISOLATION OF ALUMINUM.** Aluminum to be placed in direct contact with uncured masonry or incompatible materials should be isolated with a heavy coat of bituminous paint. For steel reinforcement primer, use manufactuer's standard corrosion resistant primer, meeting or exceeding Sherwin Williams Kem Kromik® and ASTM D5894, 1008 Corrosion Resistance.

9. **SEALANTS.** The fabrication and installation of a structural silicone-glazed (SSG) or wet glazed system requires more technical knowledge and experience than is required for a conventional pressure-glazed or dry glazed system. The glazing contractor should take all steps as outlined and required by the structural silicone sealant manufacturer, glass fabricator, framing manufacturer, and the project professional engineer of record as well as follow local building code requirements and industry best practices to ensure the proper installation and safe performance of the SSG system.

   The glazing contractor for each project needs to ensure compliance with each step, including, but not limited to, design reviews, formal adhesion testing, formal compatibility testing, project specification compliance, validating procedures, field testing, and quality control validation of installed product and surrounding conditions.

   Testing of component materials for use in a SSG or wet glazed system is mandatory to fulfill project specifications and warranty requirements and must be submitted by the glazing contractor to the structural silicone manufacturer. All materials that comprise the structural silicone joint, such as the framing system (with the job-specific finish) and job-specific glass must be tested by the structural silicone manufacturer for compatibility and adhesion. All other accessory materials in contact with the structural silicone, such as setting blocks, spacers, gaskets, sweeps, air seals and expansion joints, must also be submitted to the silicone sealant manufacturer for compatibility testing.

   To ensure that nothing has changed in formulation or chemistry since the initial tests, subsequent testing during periodic time frames of the project is to be conducted to confirm continued acceptance of the material for use on the project.

   To ensure the structural performance and integrity of the insulating glass unit (IGU), the glazing contractor must submit the project shop drawings to the glass fabricator to obtain approval for use of their product(s) in any 2, 3 or 4-sided SSG applications.

GENERAL INSTALLATION NOTES CONT.

Recommended guidelines for all installations:

Quality control procedures for field glazing are to be increased beyond those required for shop glazing. Job conditions will normally have dust, dirt, and other construction debris on the surfaces where structural silicone is to be applied. Great care should be exercised in cleaning and preparing these surfaces for silicone application. The recommendations of the silicone sealant manufacturer are to be strictly enforced and followed. The fabrication and installation of the SSG system and its components, whether shop or field glazed, should be governed by a quality control program, and all steps, procedures, and test reports should be documented throughout the project.

Prior to installation of any SSG system, refer to industry documents (e.g., AAMA Curtain Wall Design Guide Manual, ASTM C1401-14, and AAMA SSGDG-17) for detailed instructions and recommendations.

THE GLAZING CONTRACTOR ASSUMES FULL RESPONSIBILITY FOR ENSURING COMPLIANCE WITH THE ABOVE, AND ASSUMES FULL LIABILITY FOR ANY ISSUES ARISING FROM NONCOMPLIANCE.

10. **FASTENING.** Within the body of these instructions "fastening" means any method of securing one part to another or to adjacent materials. Only those fasteners used within the system are specified in these instructions. Due to the varying perimeter conditions and performance requirements, perimeter and anchor fasteners are not specified in these instructions. For perimeter and anchor fasteners refer to the shop drawings or consult the fastener supplier.

11. **BUILDING CODES.** Due to the diversity in state/provincial, local, and federal laws and codes that govern the design and application of architectural products, it is the responsibility of the individual architect, owner, and installer to assure that products selected for use on projects comply with all the applicable building codes and laws. U.S. Aluminum exercises no control over the use or application of its products, glazing materials, and operating hardware, and assumes no responsibility thereof.

12. **EXPANSION JOINTS.** Expansion joints and perimeter seals shown In these instructions and in the shop drawings are shown at normal size. Actual dimensions may vary due to perimeter conditions and/or difference in metal temperature between the time of fabrication and the time of installation. Gaps between expansion members should be based on temperature at time of installation.

13. **GLAZING PRACTICES.** The air and water performance of the **Series 3252HP** curtain wall system is directly related to the completeness and integrity of the installation process, including but not limited to the assembly seals of the framing joinery, the installed glazing gaskets, and the alignment of the framing joinery glazing plane. Before glazing, verify the glazing pocket width and glazing infill thickness, as both must be in tolerance to assure adequate edge pressure and to achieve the desired air and water performance levels. (In general, framing systems utilizing 1” insulating glass are designed to accommodate a thickness variance of +/- 1/32”). Note: Excessive pressure can cause glass breakage and/or IGU failure. Consult the glass manufacturer for their recommended edge pressure per lineal inch.

    To achieve the designed and tested air and water performance, best practices include:

    - Glazing gaskets should be cut ¼” longer per foot, and lay flat, preferably for 24 hours
    - Gaskets should be cut as single monolithic pieces and “crowded” during their installation to avoid corner gaps caused by post-installation relaxation
    - The interior glazing gasket should be installed so as to avoid stretching, buckles, or tears
    - Corners must be cut square, and at a slight angle when required to conform to the bevel on the intersecting gasket; sealed and butted together.
    - Gasket corner joinery must also be crowded, and sealant applied onto the gasket contact frame surface and into gasket reglet raceway where applicable.
    - Gasket corner seals are to be done just prior to installing glass, while the sealant is still wet and uncured, and ensure exterior gaskets are installed so as to place the glass into it’s final in service condition and allow the sealant to conform to optimum configuration. Note: If the sealant cures prior to glazing, the cured sealant could create excessive edge pressure onto the glass and has the potential to cause glass breakage.
    - The glass must be checked for squareness, size dimension, and thickness along the edges paying attention to any variances from center edge to corner edge

GENERAL INSTALLATION NOTES CONT.

Recommended guidelines for all installations:

- Check the placement of the installed glass and verify there is proper edge bite into the pocket, and proper edge clearance from framing elements

After sealant has set and a representative amount of the wall has been installed and glazed (250 square feet or more) run a water hose test in accordance with AAMA 501.2 specifications to check installation. On large projects the hose test should be repeated during the glazing operation. Consult and follow NGA's GANA Manual and FGMA Glazing Manual for proper glazing technique and procedure.

14. **COORDINATION WITH OTHER TRADES.** Coordinate with the general contractor any sequence with other trades which offset curtain wall installation (i.e. fire proofing, back-up walls, partitions, ceilings, mechanical ducts, converters, etc.).

15. **CARE AND MAINTENANCE.** Final cleaning of exposed aluminum surfaces should be done in accordance with AAMA 609.1 for anodized aluminum and 610.1 for painted aluminum.

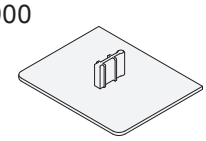
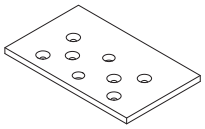
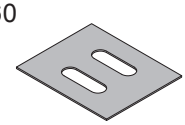
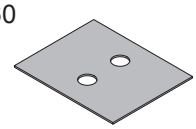
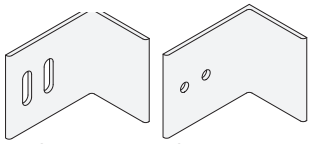
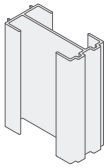
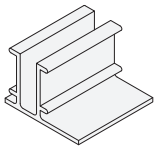
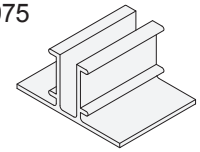
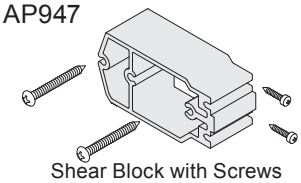
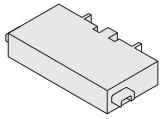
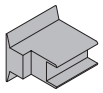
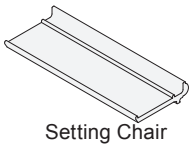
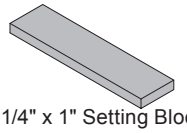
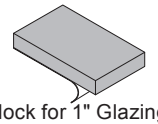
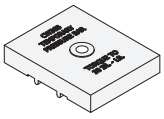
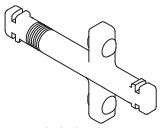
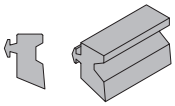
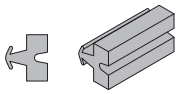
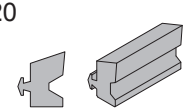
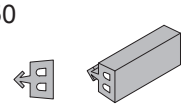
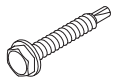
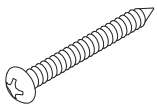
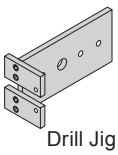
TABLE OF CONTENTS

PARTS LIST

EXTRUSIONS

CW935  5" SSG Vertical	PT905  5" Vertical	PT927  5" Horizontal	PC931  1" Perimeter Filler
PW901  3/4" x 2-1/2" Face Cap	CW950  Horizontal Cover	TB927  Polyamide Pressure Bar	PC921  1/4" Glazing Adaptor in 1" Pocket

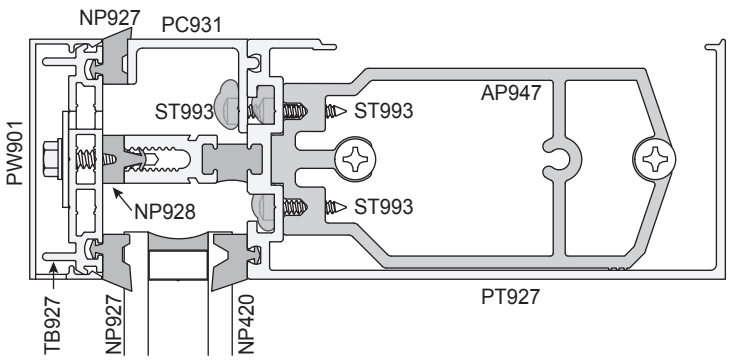
ACCESSORIES

CP900  Mullion End Cap	 Tapping Bar	AP360  Nylatron Slip Pad for Wind Load Anchor	AP360  Nylatron Slip Pad for Dead Load and Wind Load Anchor
 Steel Anchors Supplied by Customer	SL945  Splice Plate	AP965  "T" Anchor for PT905 5" Hollow Back Member	AP975  "F" Anchor for PT905 5" Hollow Back Member
AP947  Shear Block with Screws	WD900  SSG Water Diverter	HD975  End Dam	SC927  Setting Chair
SB577  1/4" x 1" Setting Block	AW901  Edge Block for 1" Glazing with 2 Sided Tape	CW368  Temporary Glass Retainer	SB450  Vertical SSG Gasket
NP927  Exterior Rigid Gasket	NP928  Thermo Isolator	NP420  Interior Sponge Gasket	SB450  Vertical SSG Gasket
MF070  1/4" Fender Washer	ST933  #8 x 3/4" Phillips Fillister HD SMS "A" for Shear Block and PC931 Perimeter Filler	MS240  1/4 - 20 x 1-1/4" HWH (GRD 5)	ST269  #12 x 2" PH SMS for Shear Block
DJ364  Drill Jig			

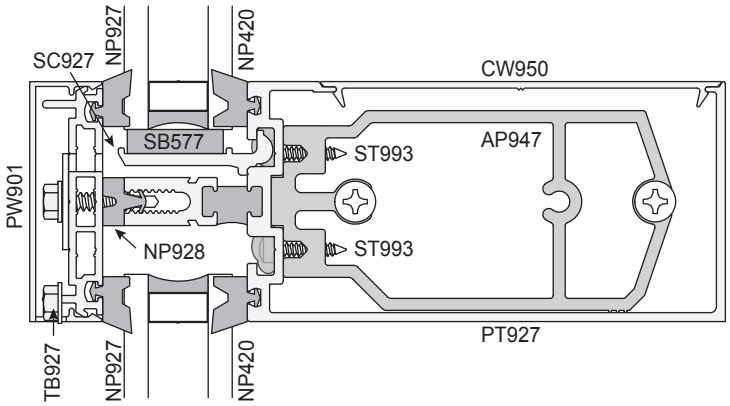
V 2024-1008

TYPICAL ELEVATION

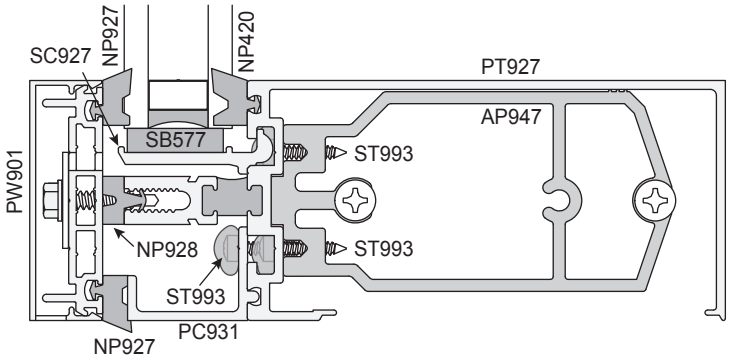
HEAD



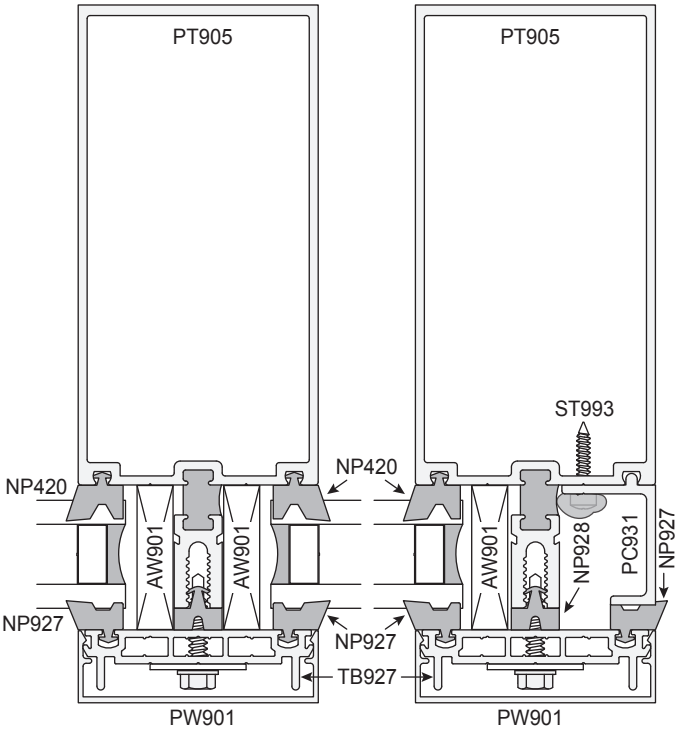
INTERMEDIATE



SILL

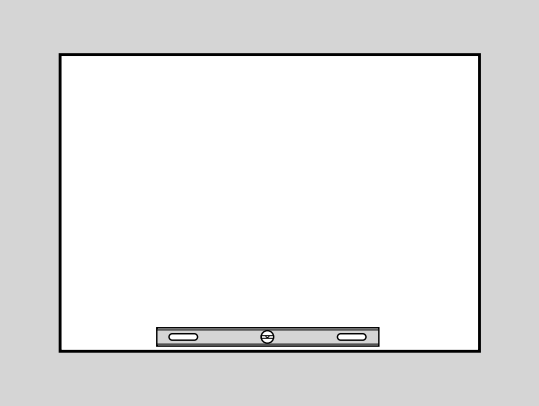


VERTICAL MULLIONS

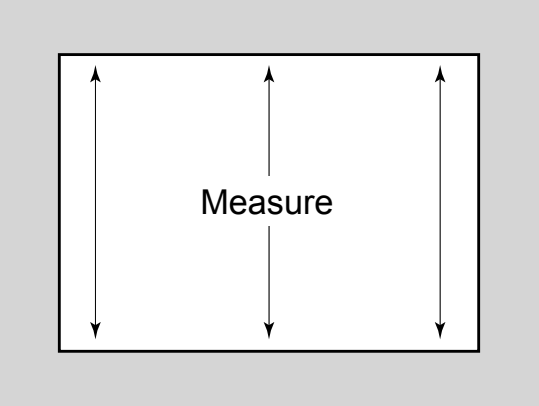


SITE PREPARATION
BEFORE INSTALLATION

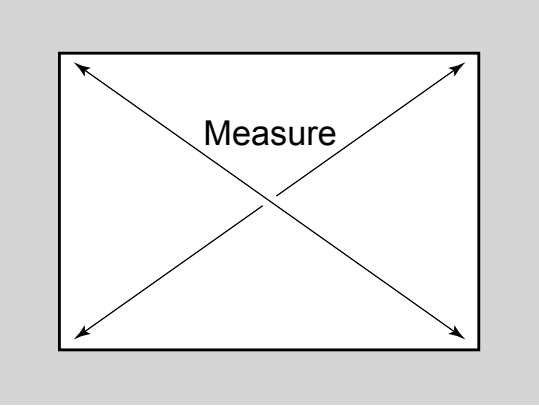
1. Review and measure the opening.
2. Verify rough window opening size 1/2" (13) clearance in both width and height to the window. Verify framing is plumb, straight, and true around window opening. Measure opening at each end and at center vertically and horizontally. Make corrections to openings as required. Measure opening diagonally to check squareness. Chip concrete high points to flush and rounded corners to square.



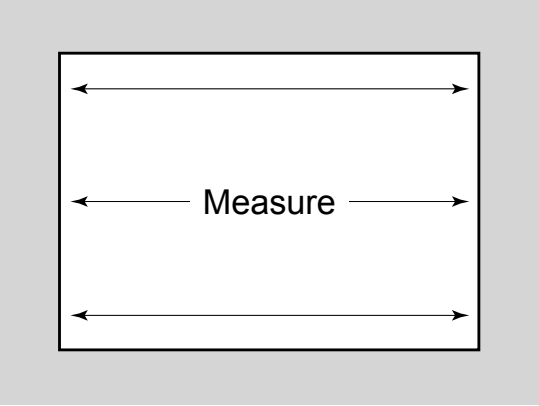
LEVEL



VERTICAL DIMENSION



SQUARE



HORIZONTAL DIMENSION

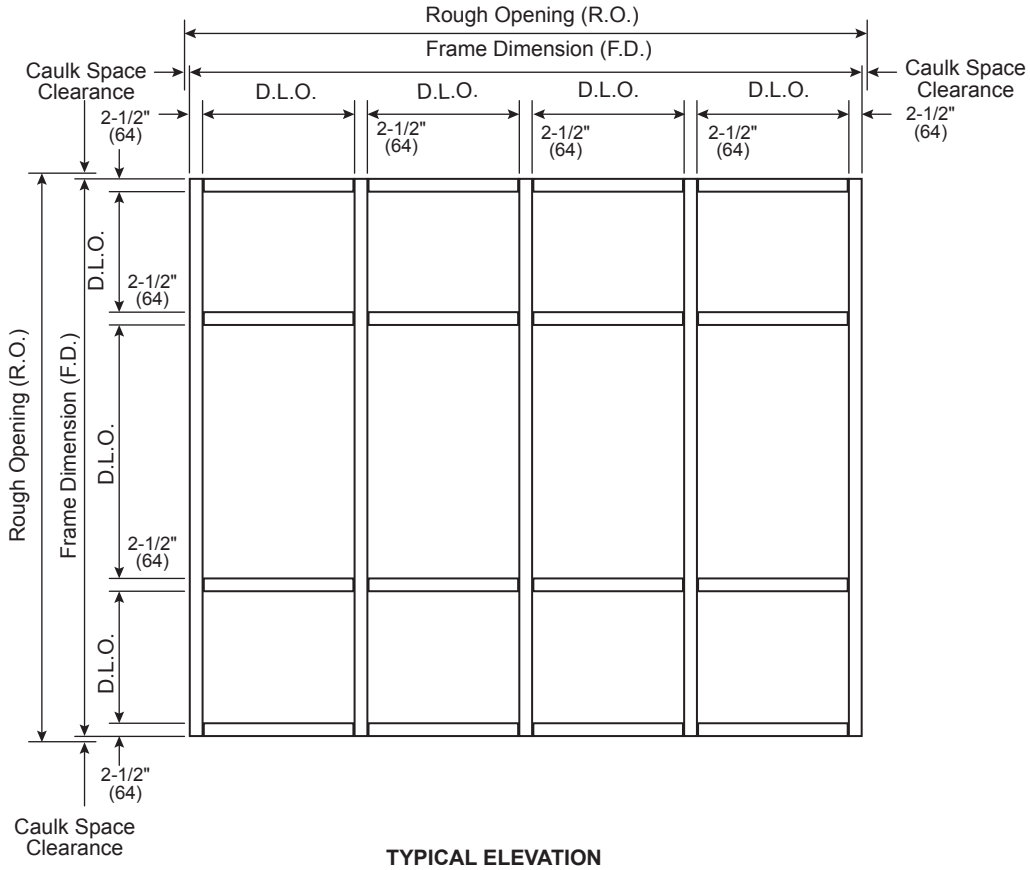
FRAME FABRICATION

CUTTING

Details shown on these instructions are 1" (25) glazing systems and 5" (127) back members.

1. Cut members to size. Use the following information below:

Component	Dimensioning
Vertical Members: R.O.	R.O. Minus Top and Bottom Clearances
Vertical Pressure Bars:	F.D. Minus 1/4" (6)
Vertical Face Covers:	F.D. Minus 1/32" (0.8)
Horizontal Members:	D.L.O. Minus 1/32" (0.8) - plus 0"
Horizontal Pressure Bars:	D.L.O. Minus 1/4" (6)
Horizontal Face Covers:	D.L.O. Minus 1/32" (0.8)
Vertical Transition Adapters:	D.L.O. Plus 1" (25)
Horizontal Transition Adapters:	D.L.O. Minus 1/8" (3)



TYPICAL ELEVATION

DETAIL A

V 2024-1008

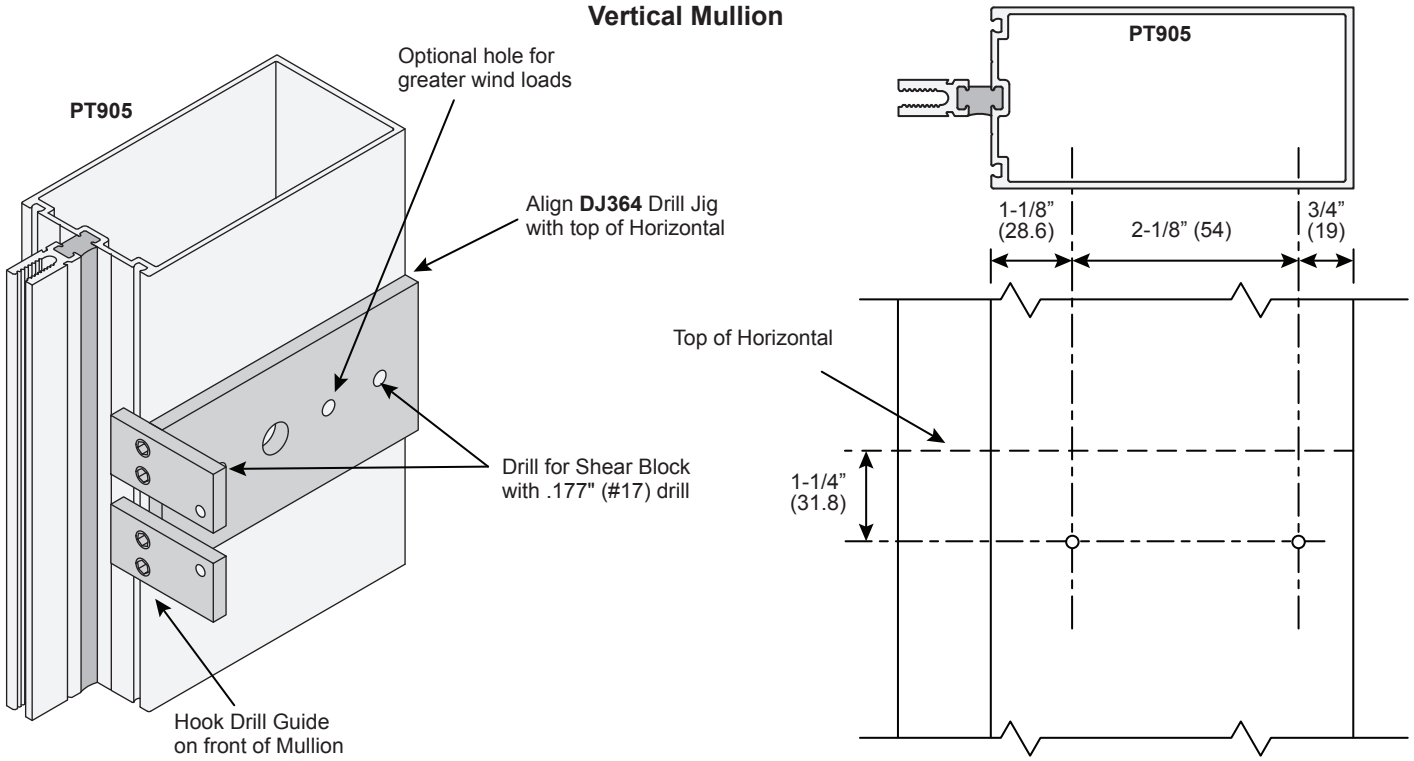
NOT TO SCALE

FRAME FABRICATION (CONTINUED)

DRILLING

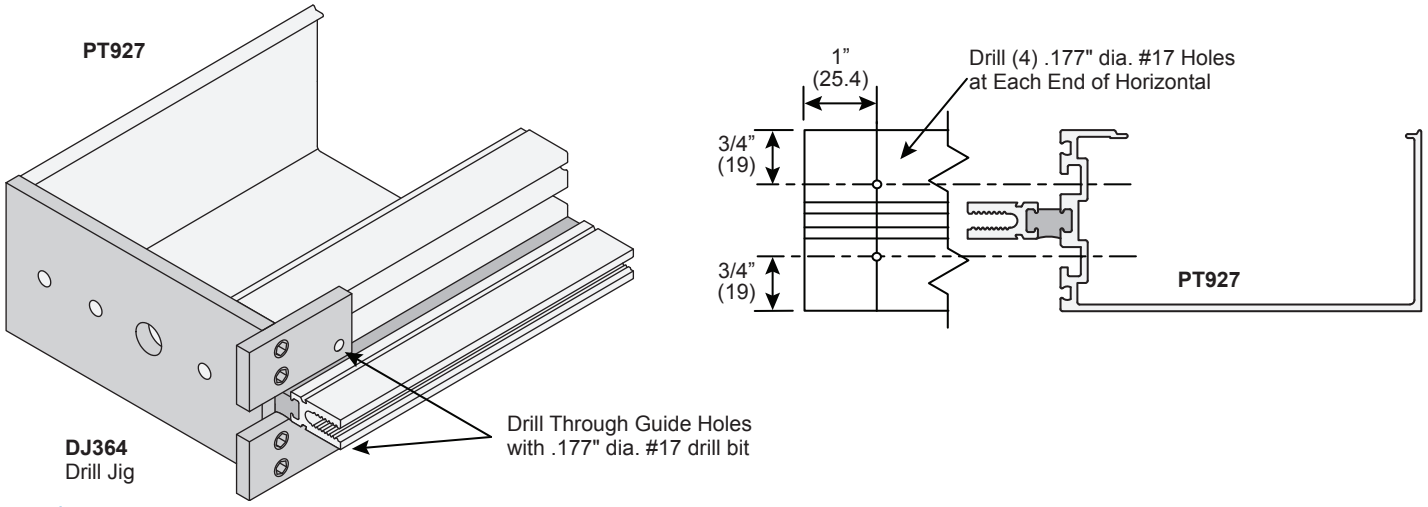
1. Cut members to size. Use the following information below:
2. Mark on verticals the location of horizontal members and drill holes for shear blocks. Drill Jigs are available. See **DETAIL B** for drill jig usage.

Vertical Mullion



DETAIL B

Horizontal Member



DETAIL C

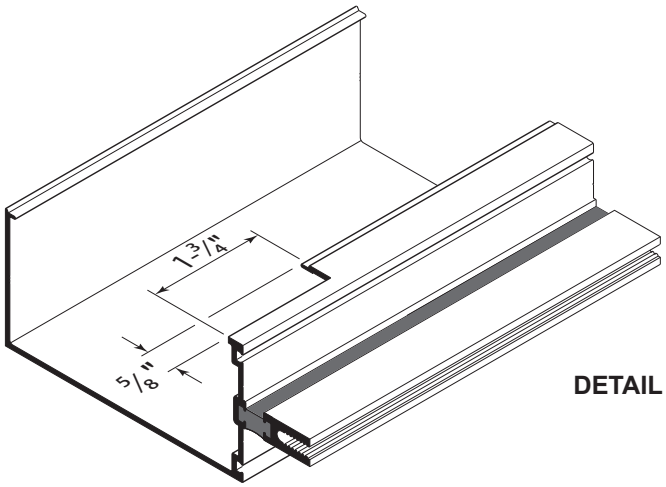
NOT TO SCALE

V 2024-1008

FRAME FABRICATION (CONTINUED)

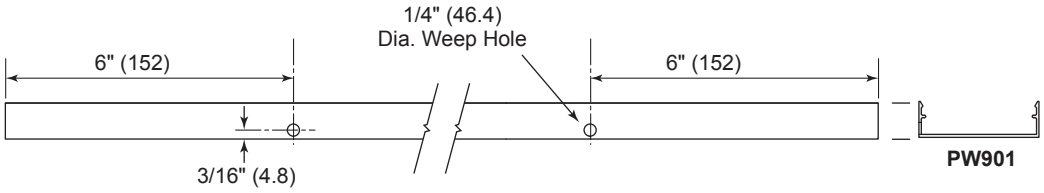
NOTCHING

1. Cut members to size. Use the following information below:
2. Mark on verticals the location of horizontal members and drill holes for shear blocks. Drill Jigs are available. See **DETAIL B** for drill jig usage.
3. Fabricate ends of horizontal members for shear block pick-up screws. See **DETAIL C** for drill jig usage.



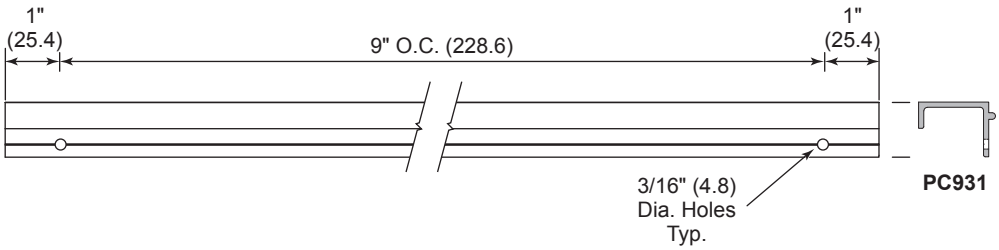
DETAIL D

FACE PLATE WEEP HOLES



DETAIL E

PERIMETER FILLER



DETAIL F

NOT TO SCALE

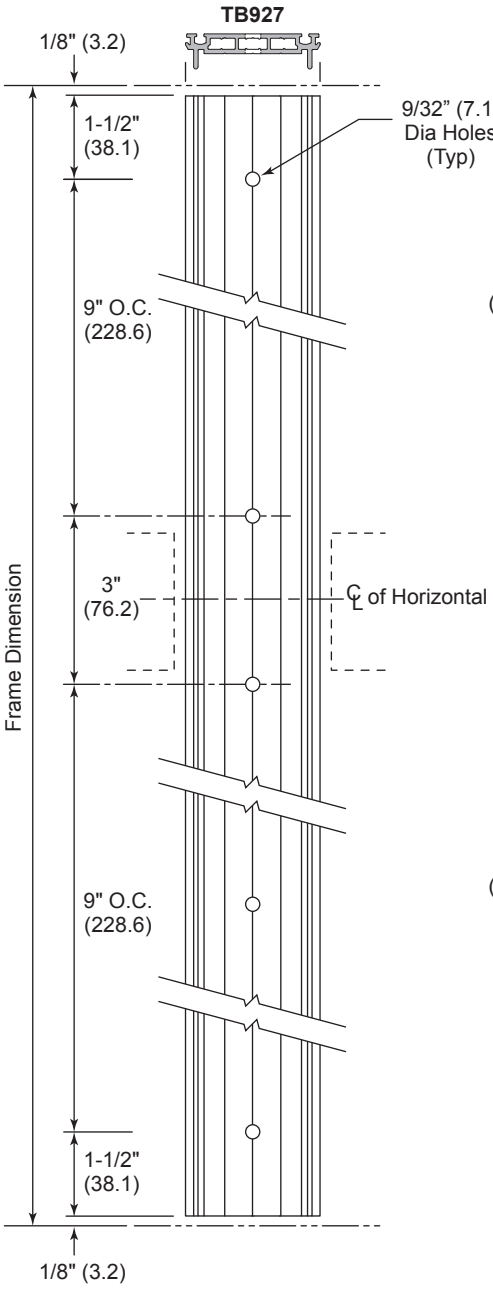
V 2024-1008

FRAME FABRICATION (CONTINUED)

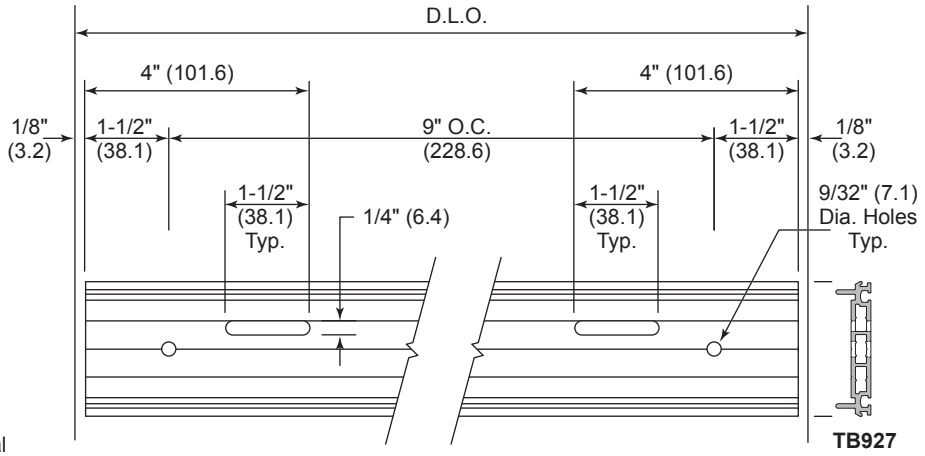
PRESSURE BARS

1. Cut members to size. Use the following information below:
2. Mark on verticals the location of horizontal members and drill holes for shear blocks. Drill Jigs are available. See **DETAIL B** for drill jig usage.
3. Fabricate ends of horizontal members for shear block pick-up screws. See **DETAIL C** for drill jig usage.
4. Some open back Head and Sill Members require notching at each end for shear block clearance as shown in **DETAIL D**.

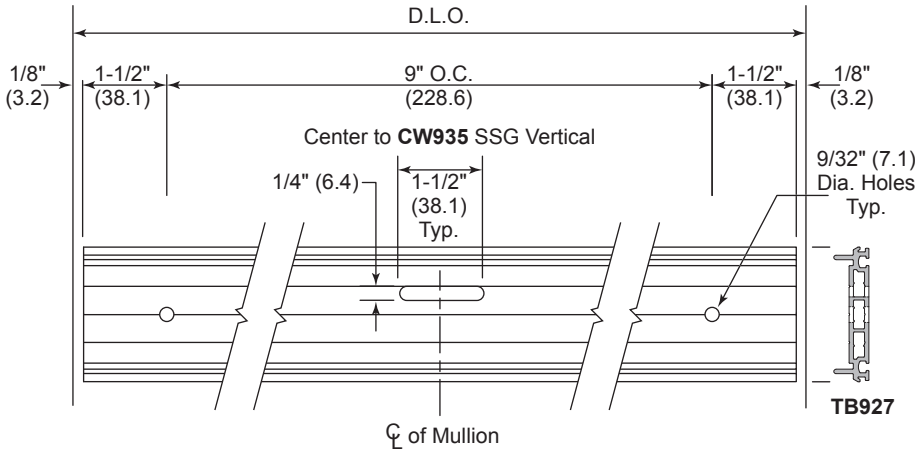
Vertical Pressure Bar



Horizontal Pressure Bar



Horizontal Pressure Bar for SSG Installation



DETAIL G

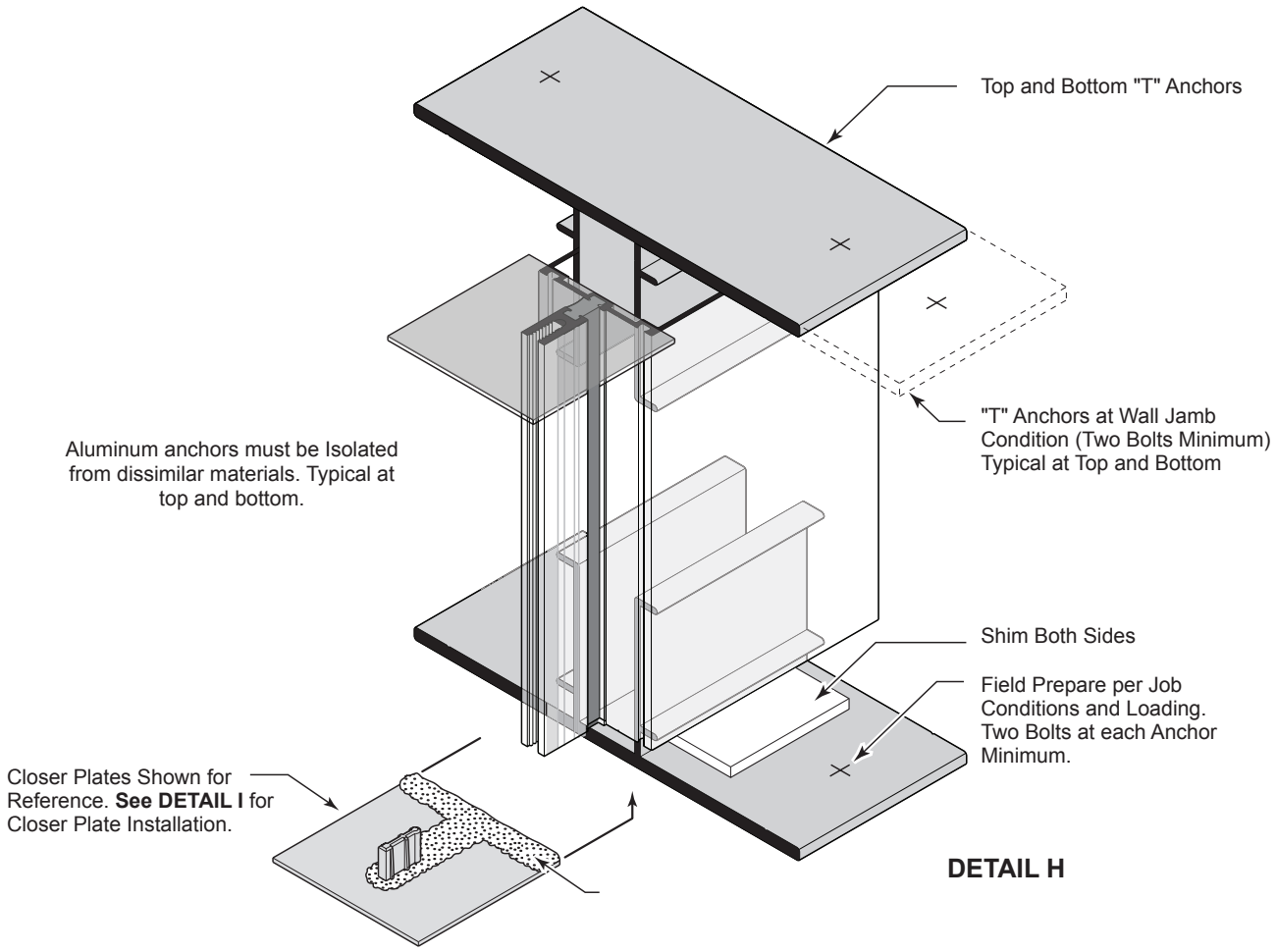
NOT TO SCALE

FRAME INSTALLATION

NOTE: ANCHOR TYPE AND SIZES VARY PER JOB REQUIREMENTS. DETAILS SHOWN ARE TO BE USED AS A GUIDE ONLY. SEE APPROVED SHOP DRAWINGS FOR ACTUAL CONDITIONS.

SINGLE SPAN CONDITION

1. Slide top and bottom "T" anchors into vertical members. See **DETAIL H**.
2. Install verticals plumb and level. If shims are required place them directly under each vertical for proper load distribution. Secure top and bottom anchors to structure. Secure verticals to anchor clips after alignment has been completed.

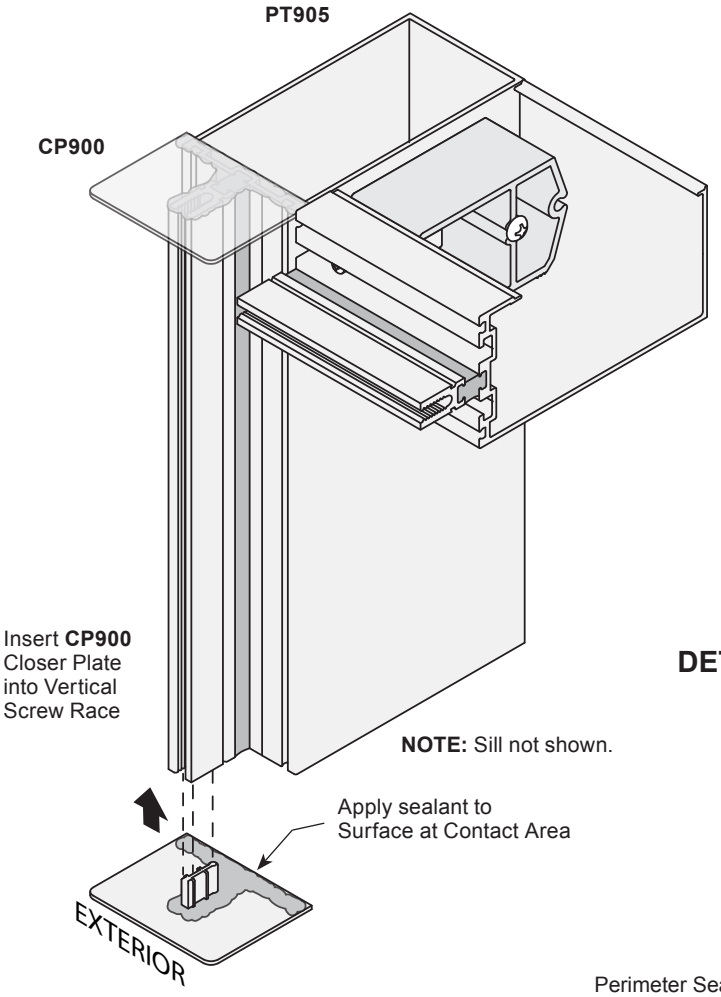


DETAIL H

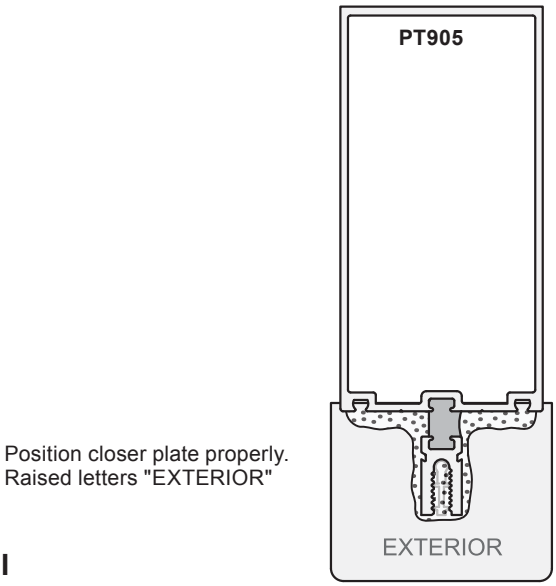
NOT TO SCALE

FRAME INSTALLATION (CONTINUED)
SINGLE SPAN CONDITION (CONTINUED)

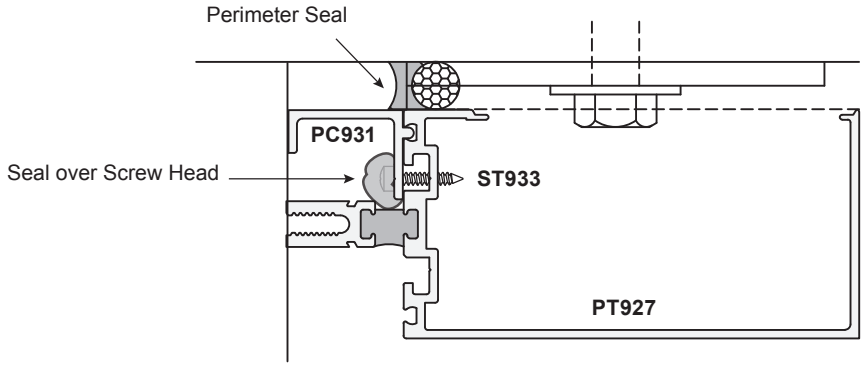
3. Apply sealant to closer plates as shown in **DETAIL I.** Install at top and bottom of Jambs and Mullions after Head and Sill members are in place.



NOTE: Clean All Surfaces prior to Applying Sealants. See Sealant Manufacturer Requirements. TYPICAL AT ALL CONDITIONS



DETAIL I

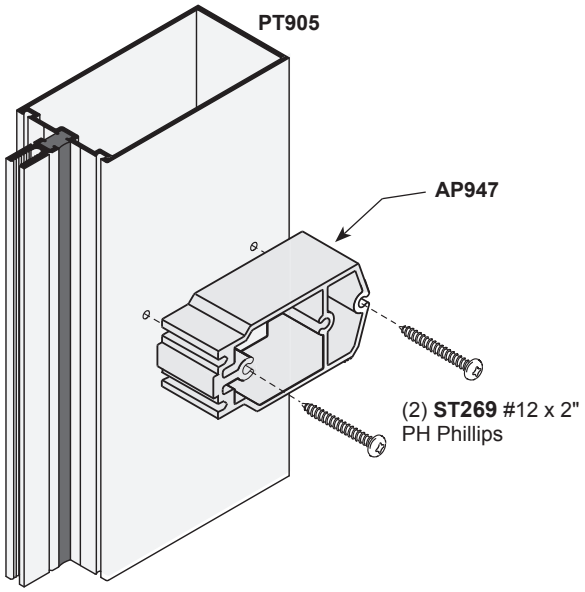


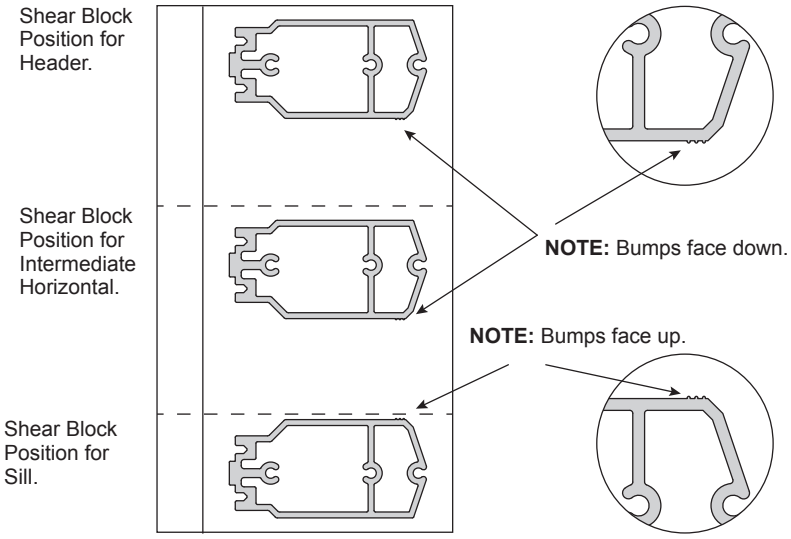
DETAIL J

NOT TO SCALE

FRAME INSTALLATION (CONTINUED)
SINGLE SPAN CONDITION (CONTINUED)

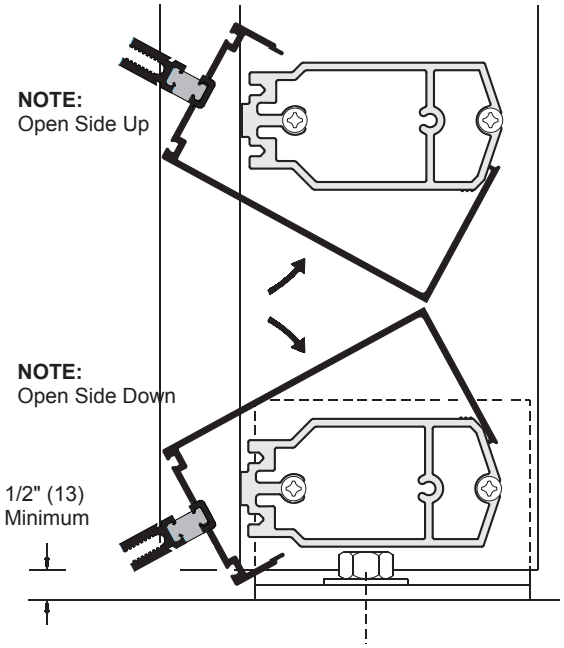
4. Once all verticals and perimeter members are installed, seal around perimeter. See **DETAIL J.** Perimeter caulking must be completed prior to installation of glass and Pressure Bars. Ensure perimeter sealant has smooth transition across vertical End Dams.

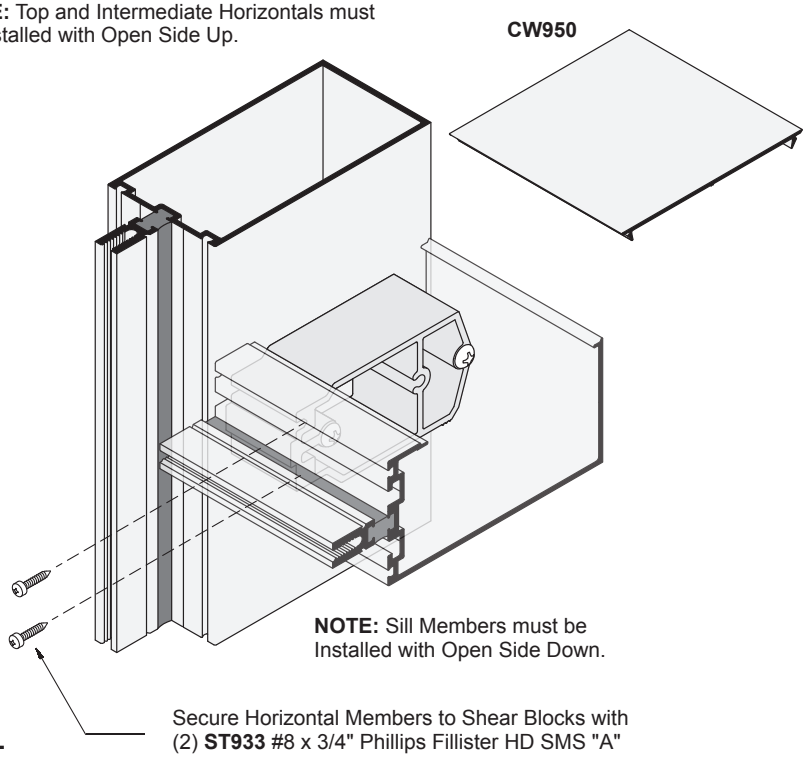




DETAIL K

NOTE: Top and Intermediate Horizontals must be Installed with Open Side Up.





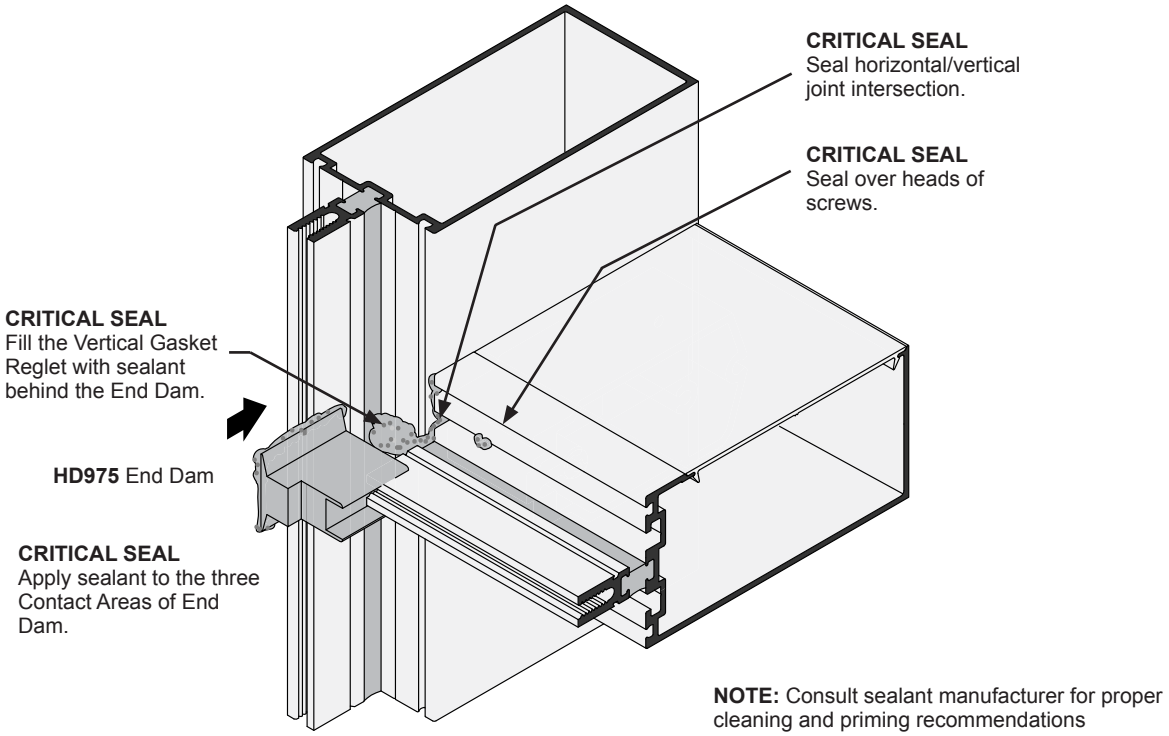
DETAIL L

NOT TO SCALE

FRAME INSTALLATION (CONTINUED)

SINGLE SPAN CONDITION (CONTINUED)

1. Slide top and bottom "T" anchors into vertical members. See **DETAIL H**.
2. Install verticals plumb and level. If shims are required place them directly under each vertical for proper load distribution. Secure top and bottom anchors to structure. Secure verticals to anchor clips after alignment has been completed.
3. Apply sealant to closer plates as shown in **DETAIL I.** Install at top and bottom of jambs and mullions after head and Sill Members are in place



DETAIL M

NOTE: End dams occur at head and sill as well.

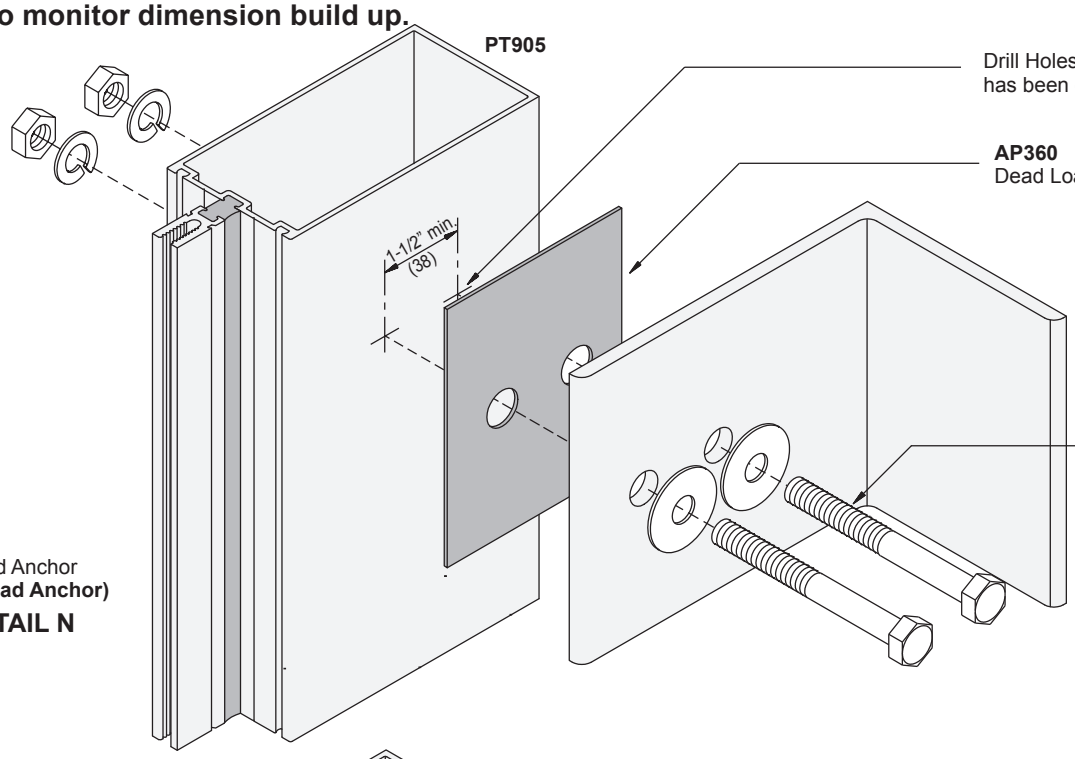
NOT TO SCALE

FRAME INSTALLATION (CONTINUED)

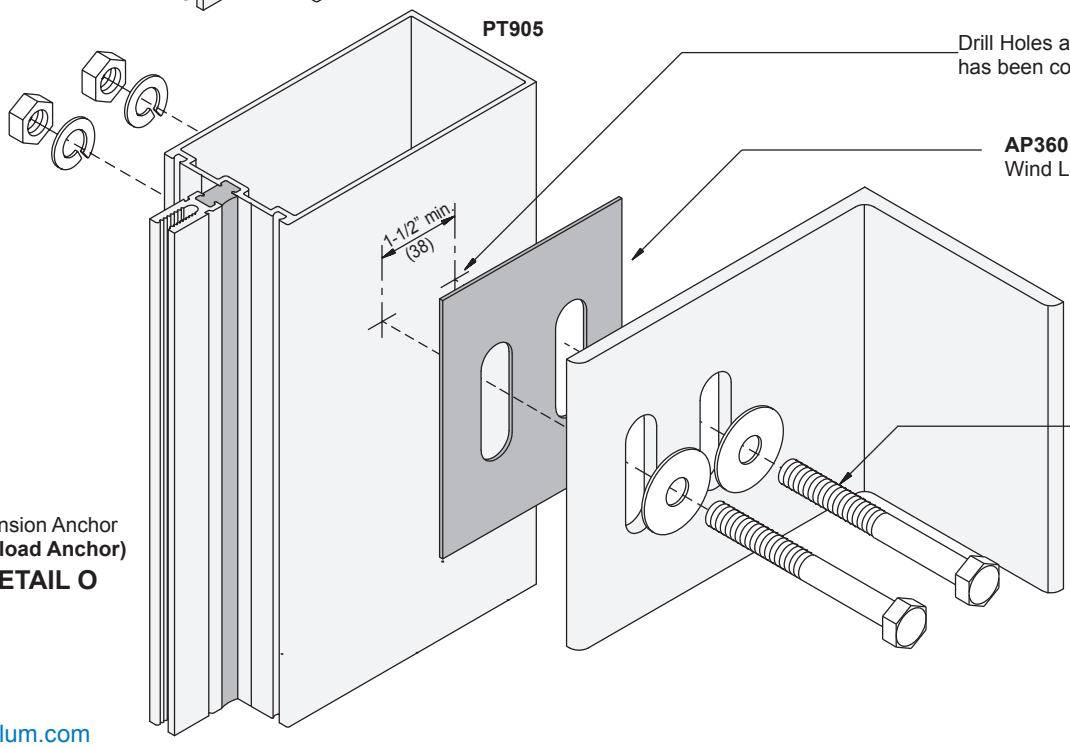
MULTI-SPAN CONDITION

Details N and O show fixed (deadload) and expansion (windload) anchors. Anchor type and size vary per job requirements. Details shown are to be used as a guide only. See approved shop drawings for actual conditions.

NOTE: Mullion spacing must be held to within +1/32" (0.8). Check overall frame dimension every four bays to monitor dimension build up.



Fixed Anchor
(Deadload Anchor)
DETAIL N



Expansion Anchor
(Windload Anchor)
DETAIL O

NOT TO SCALE

V 2024-1008

GLAZING

GLASS SIZES

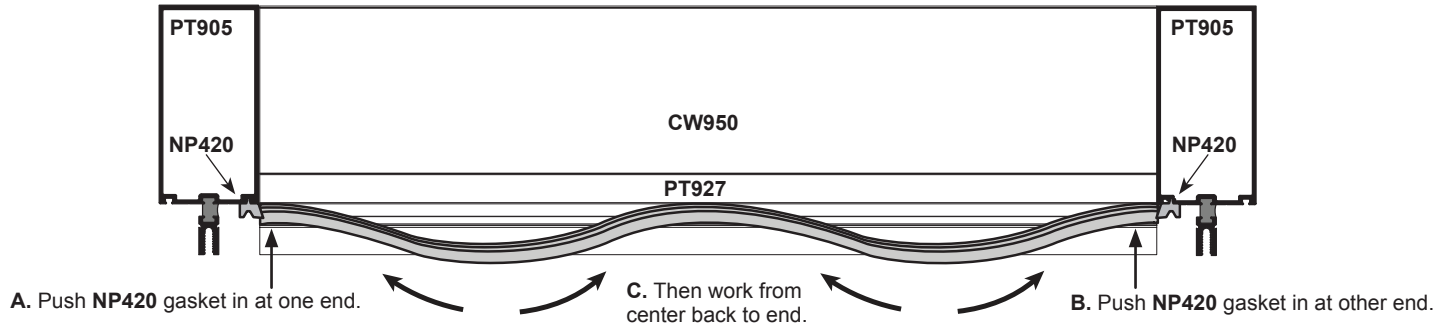
GLASS WIDTH AND HEIGHT = DAYLIGHT OPENING + 1" (25)

NOTE: These formulae do not take into account glass tolerances. Consult glass manufacturer before ordering glass.

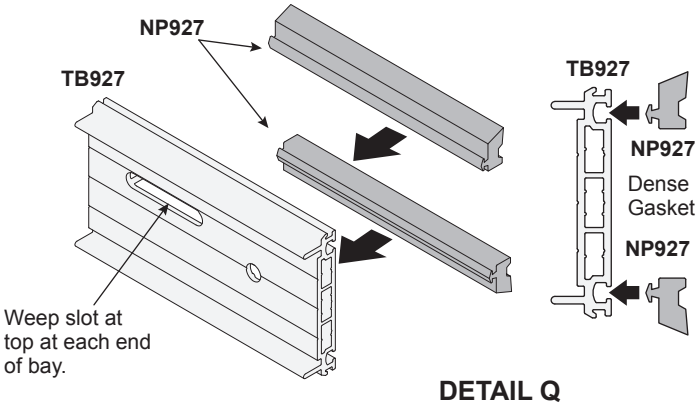
Remove gaskets from carton and lay flat in a clean, dry area in order to recover shape. Allow gaskets to relax at least two hours at temperatures above 50°F (10°C). Glaze with gaskets above 40°F (4.44°C). If necessary warm gaskets in a hot box prior to installing.

Use **NP927** dense gasket at exterior, **NP420** sponge gasket at interior and **NP928** thermal isolator gasket at interior.

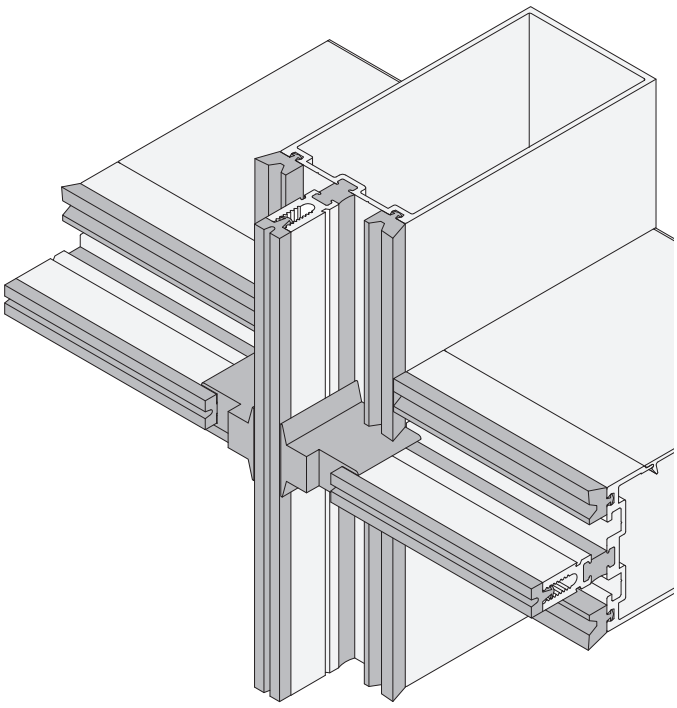
1. Cut gaskets allowing 1/8" (3) extra length per foot of extrusion to allow for shrinkage. Vertical gaskets on mullion run past horizontal gaskets by 5/8" (16). Horizontal gaskets butt against vertical gaskets. Push gaskets into reglet at ends and then work from center to each end. See **DETAIL P**.
2. Install back gaskets into vertical and horizontal members and front gaskets into pressure bars. See **DETAIL Q**. Horizontal pressure bar gaskets should extend 1/8" (3) beyond each end of the extrusions. Vertical pressure bar gaskets run continuous.

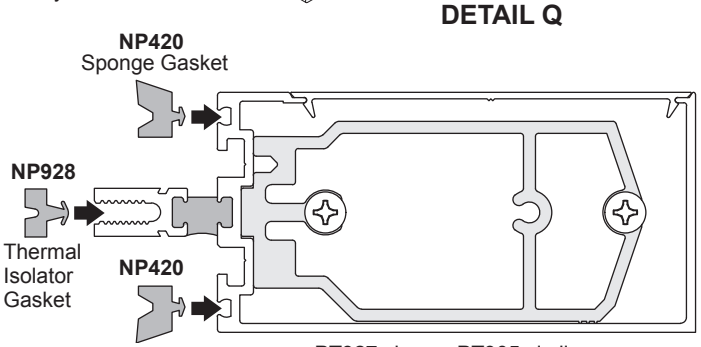


DETAIL P



DETAIL Q





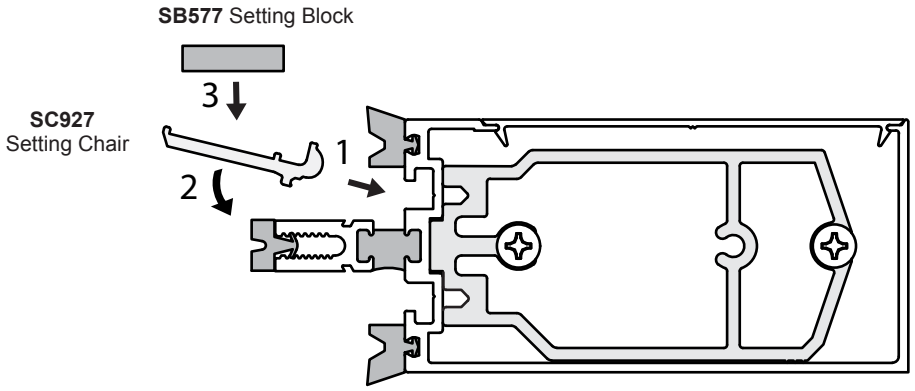
PT927 shown. **PT905** similar.

NOT TO SCALE

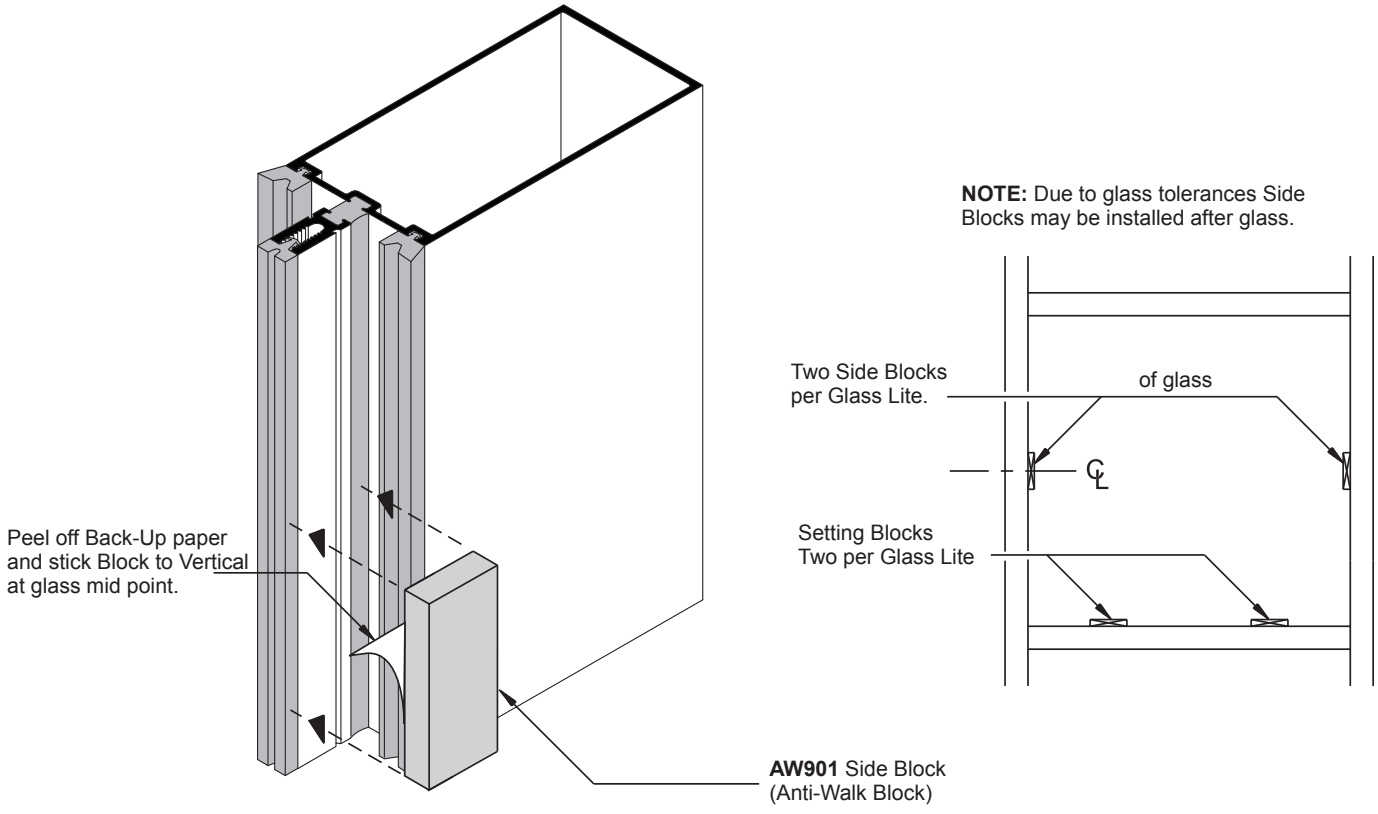
V 2024-1008

GLAZING (CONTINUED)

1. Cut gaskets allowing 1/8" (3) extra length per foot of extrusion to allow for shrinkage. Vertical gaskets on mullion run past horizontal gaskets by 5/8" (16). Horizontal gaskets butt against vertical gaskets. Push gaskets into reglet at ends and then work from center to each end. See **DETAIL P**.
2. Install back gaskets into vertical and horizontal members and front gaskets into pressure bars. **See DETAIL Q.**



DETAIL R



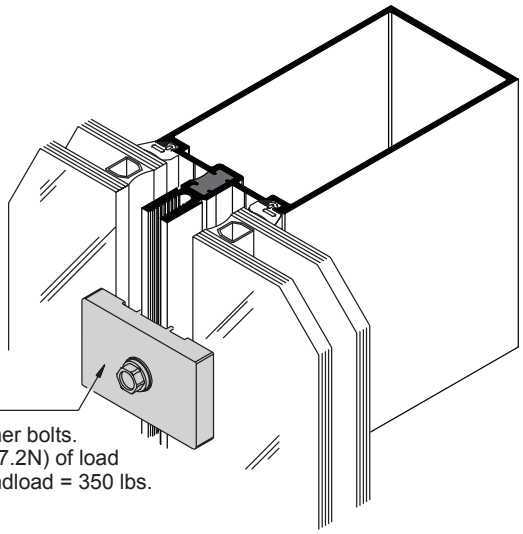
DETAIL S

V 2024-1008

GLAZING (CONTINUED)

3. Cut gaskets allowing 1/8" (3) extra length per foot of extrusion to allow for shrinkage. Vertical gaskets on mullion run past horizontal gaskets by 5/8" (16). Horizontal gaskets butt against vertical gaskets. Push gaskets into reglet at ends and then work from center to each end. See **DETAIL P**.

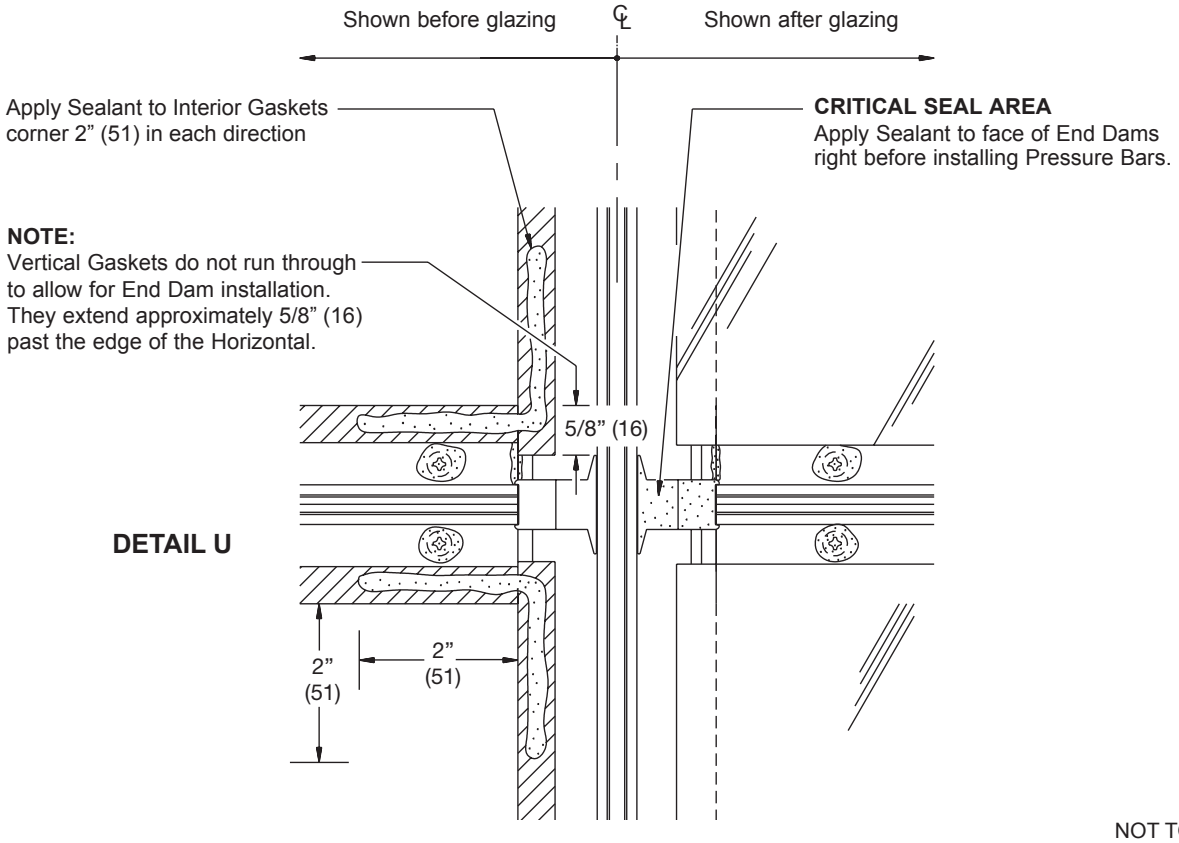
DETAIL T



CW368 Temporary Glass Retainer.
Torque to 30 in.-lbs. (3.4N.m)
NOTE: Do not over torque Glass Retainer bolts.
Use one Retainer per each 150 lbs. (667.2N) of load
(i.e. if Glass Height x Glass Width x Windload = 350 lbs.
use three Retainers each side of glass).

4. Install back gaskets into vertical and horizontal members and front gaskets into pressure bars. See **DETAIL Q**. Horizontal pressure bar gaskets should extend 1/8"

DETAIL U



NOT TO SCALE

V 2024-1008

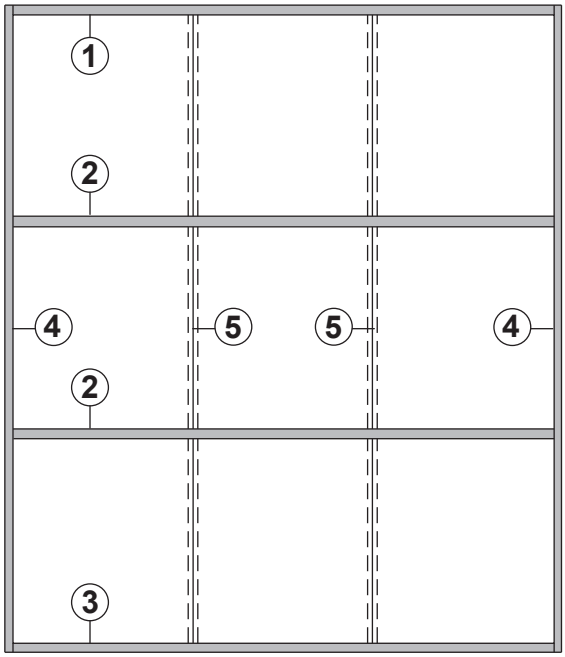
STRUCTURAL SILICONE GLAZING

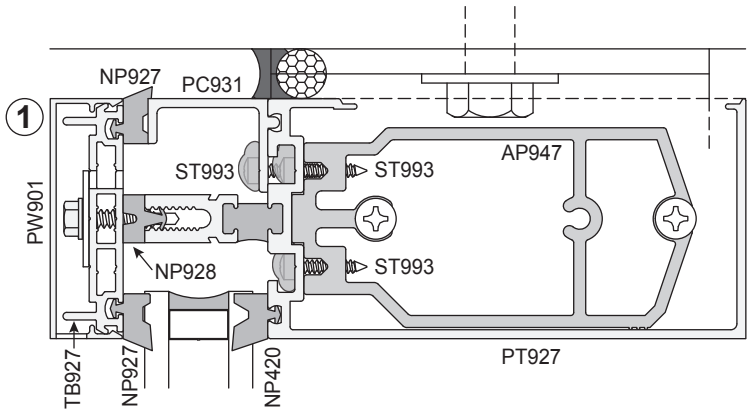
TYPICAL ELEVATION

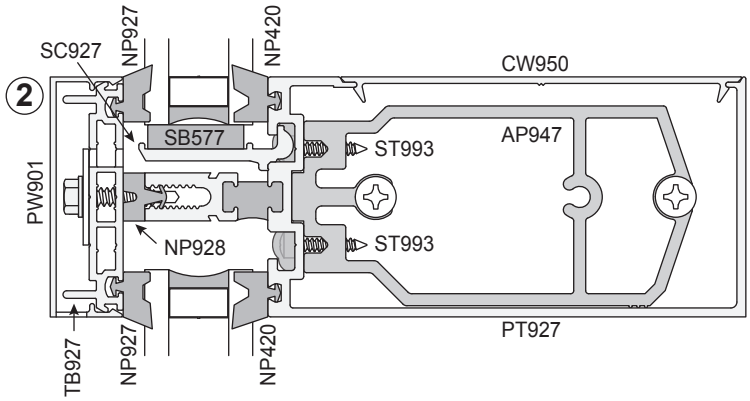
GLASS WIDTH & HEIGHT = DAYLIGHT OPENING + 1" (25)

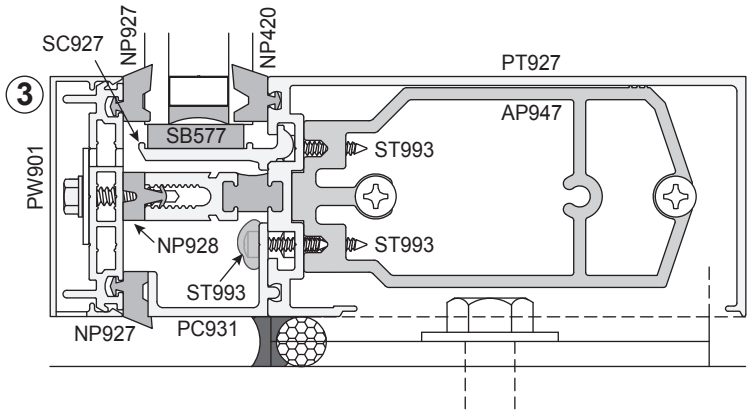
NOTE: These formulae do not take into account glass tolerances. Refer to item 8 of the General Installation Notes on Page 3 regarding structural sealants.

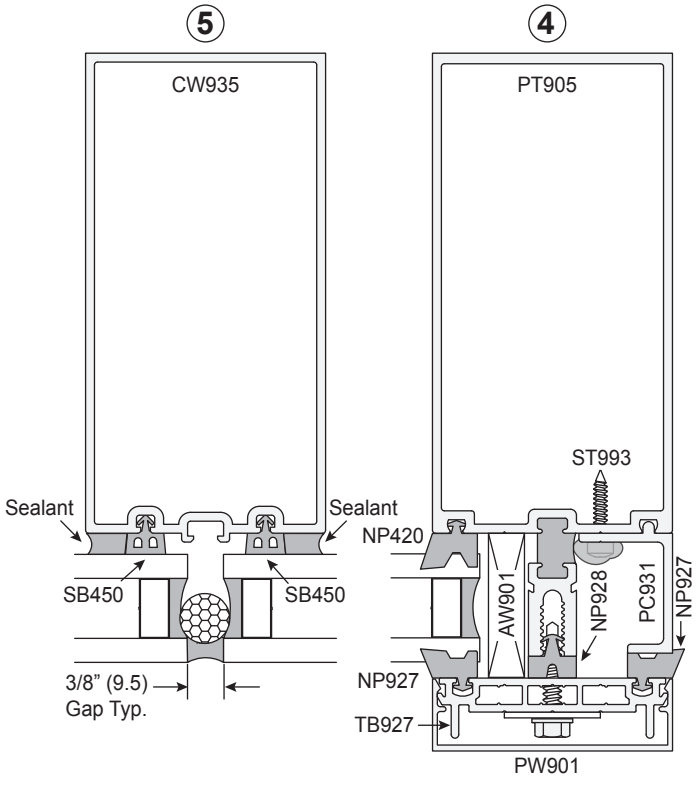
CONSULT GLASS MANUFACTURER BEFORE ORDERING GLASS.











DETAIL V

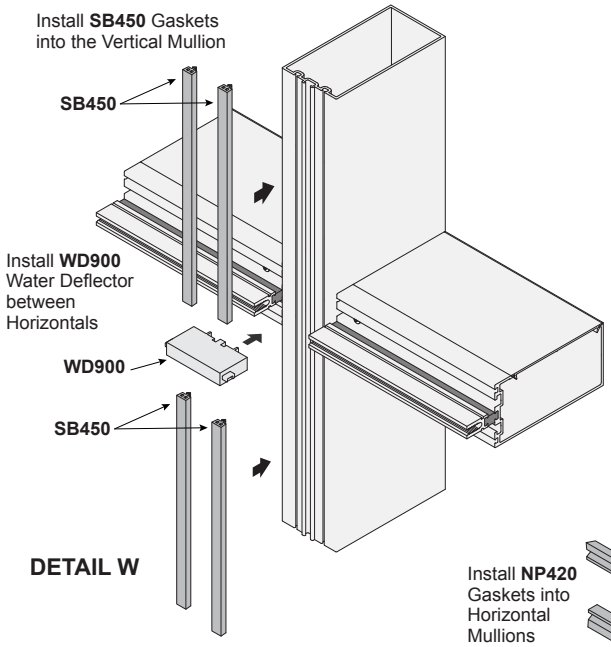
NOT TO SCALE

STRUCTURAL SILICONE GLAZING (CONTINUED)

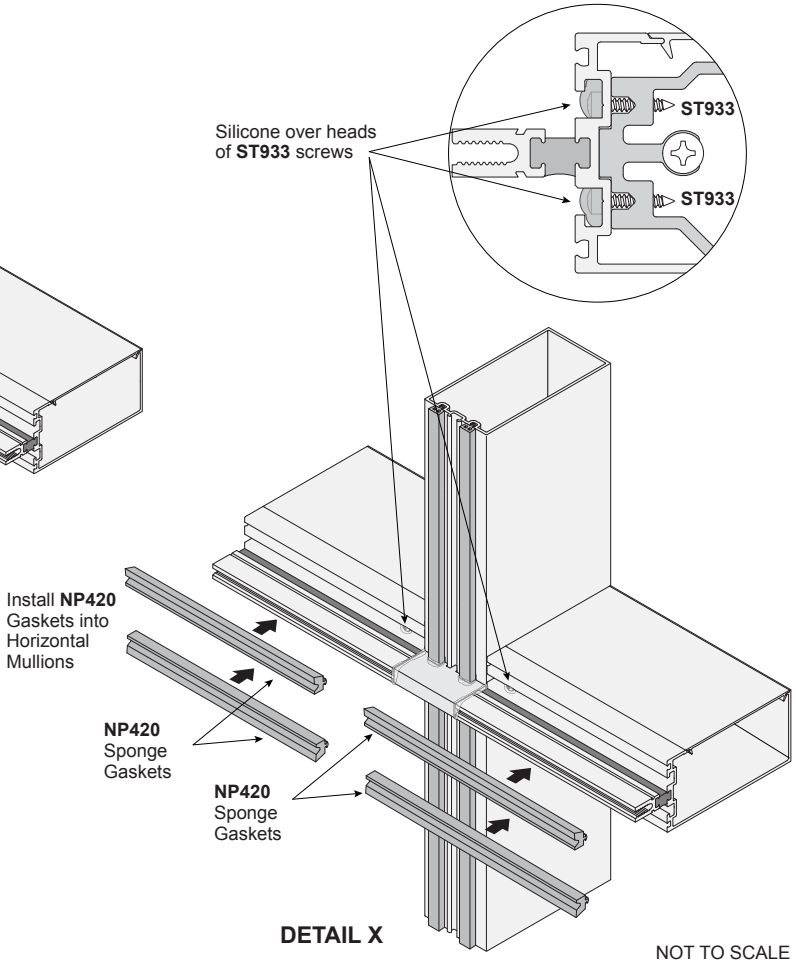
Remove gaskets from carton and lay flat in a clean, dry area in order to recover shape. Allow gaskets to relax at least two hours at temperatures above 50°F (10°C). Glaze with gaskets above 40°F (4.44°C). If necessary, warm gaskets in a hot box prior to installing.

For the intermediate horizontal mullions, use **NP927** rigid gasket at exterior and **NP420** sponge gasket and **NP928** thermal isolator gasket at interior stem. Use **SP450** spacer gasket on the Intermediate Vertical Mullions.

1. Cut gaskets 1/8" (3) longer per foot of extrusion to allow for shrinkage. Vertical gaskets on mullion run past horizontal gaskets by 5/8" (16). Horizontal gaskets butt against vertical gaskets. Insert a water deflector between the two horizontal members and install spacer gaskets into verticals. See **DETAIL W**.
2. Install the **NP420** gaskets into the intermediate horizontal mullions. Seal the horizontal gaskets to the vertical gaskets and the joints around all water deflectors as shown in **DETAIL X**.
3. Position the two setting blocks on the horizontal mullions for each glass lite as directed by the deadload charts and shop drawings. See **DETAIL R** on Page 20.
4. Remove paper backing from the side blocks and apply to the Jambs only, at approximately mid-height of glass. See **DETAIL S** on Page 20.



DETAIL W



DETAIL X

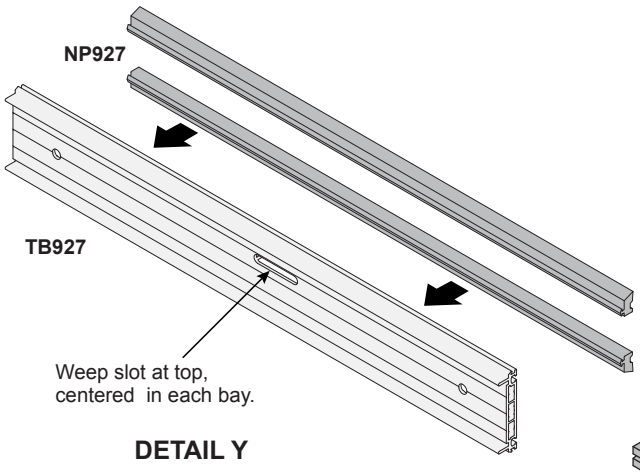
NOTE: Seal ends of gaskets and joints around water deflector.

NOT TO SCALE

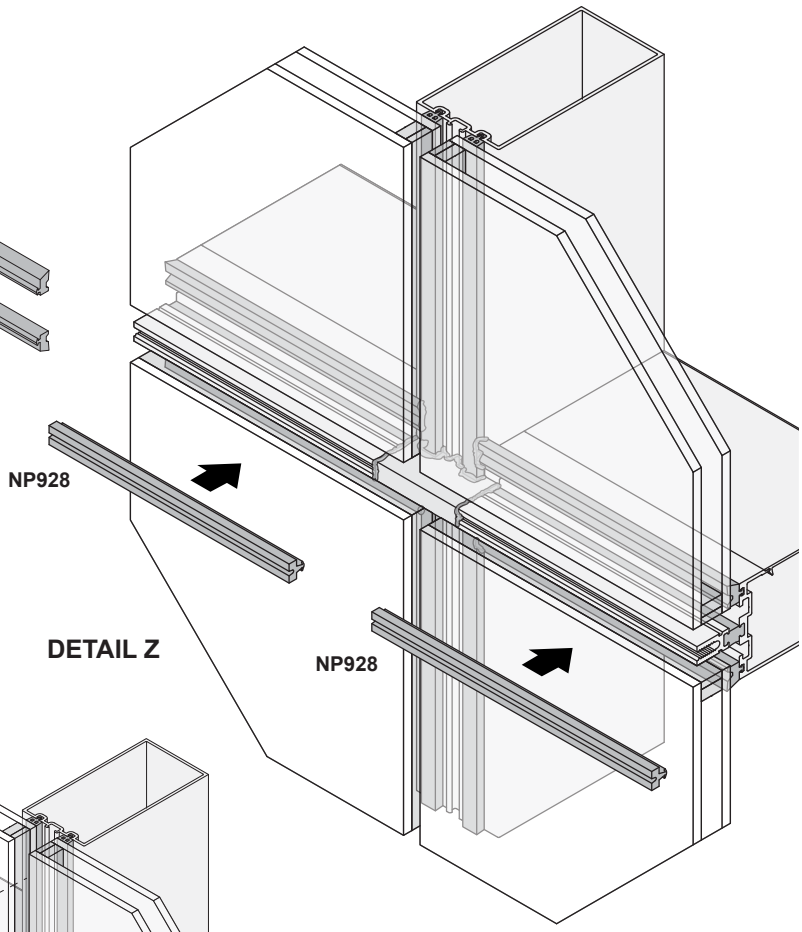
V 2024-1008

STRUCTURAL SILICONE GLAZING (CONTINUED)

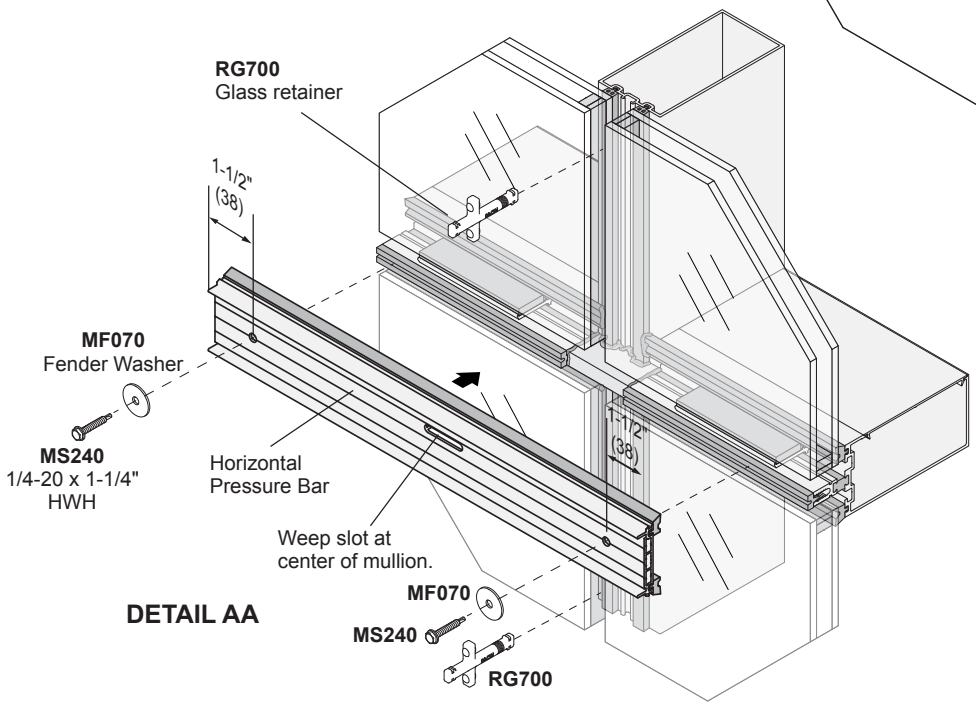
1. Cut gaskets 1/8" (3) longer per foot of extrusion to allow for shrinkage. Vertical gaskets on mullion run past horizontal gaskets by 5/8" (16). Horizontal gaskets butt against vertical gaskets. Insert a water deflector between the two horizontal members and install spacer gaskets into verticals. See **DETAIL W**.
2. Install the **NP420** gaskets into the intermediate horizontal mullions. Seal the horizontal gaskets to the vertical gaskets and the joints around all water deflectors with as shown in **DETAIL X**.



DETAIL Y



DETAIL Z

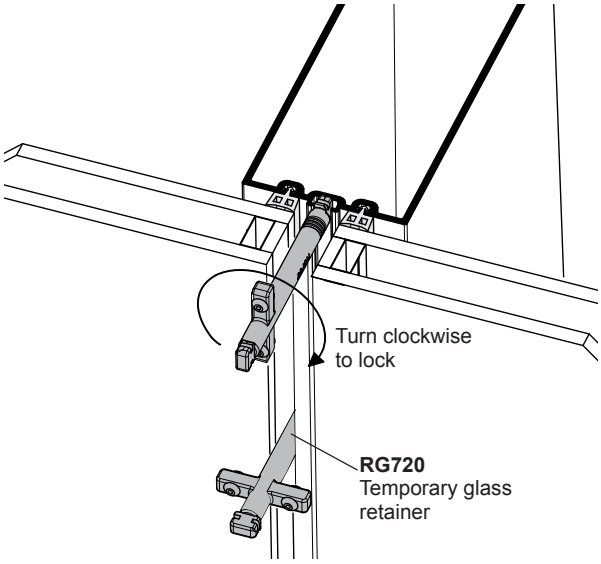


DETAIL AA

NOT TO SCALE

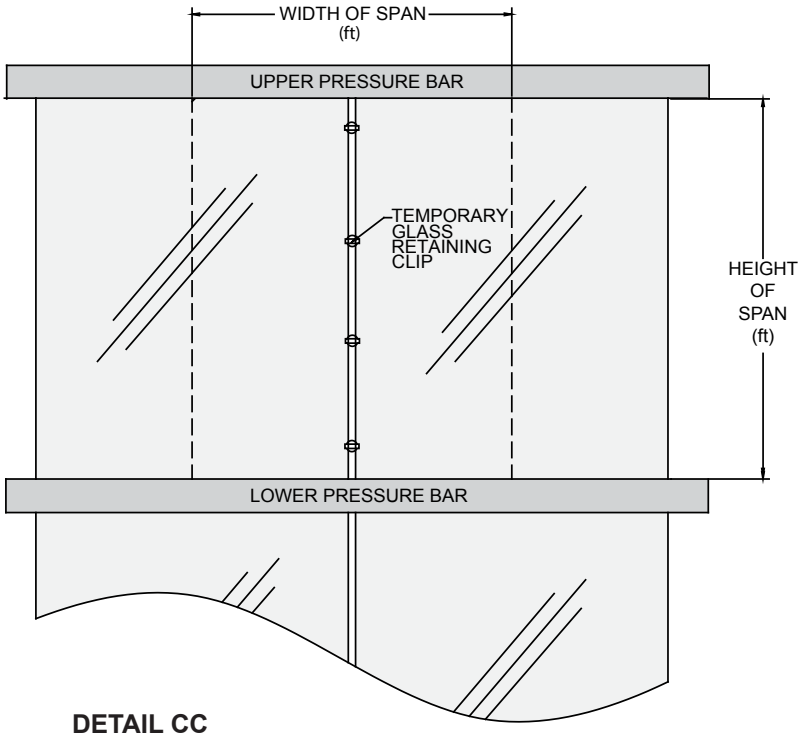
STRUCTURAL SILICONE GLAZING (CONTINUED)

1. Cut gaskets 1/8" (3) longer per foot of extrusion to allow for shrinkage. Vertical gaskets on mullion run past horizontal gaskets by 5/8" (16). Horizontal gaskets butt against vertical gaskets. Insert a water deflector between the two horizontal members and install spacer gaskets into verticals. See **DETAIL W**.



DETAIL BB

$$\text{NUMBER OF CLIPS} = \frac{\text{WIDTH OF SPAN} \times \text{HEIGHT OF SPAN} \times \text{WINDLOAD (psf)}}{150}$$



DETAIL CC

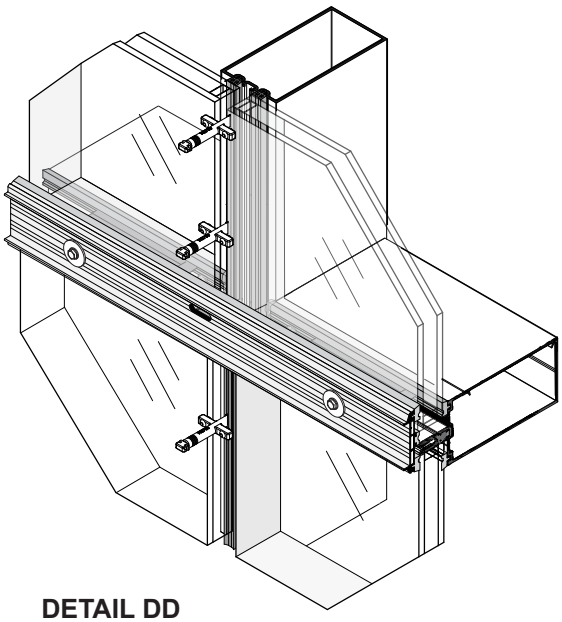
NOT TO SCALE

V 2024-1008

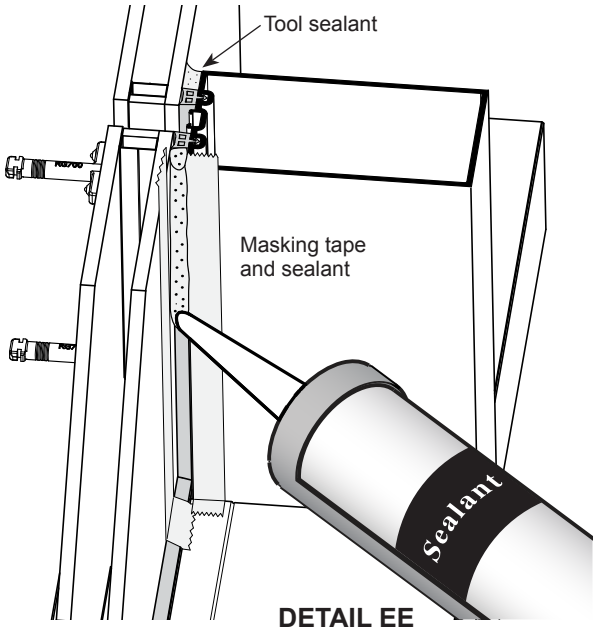
STRUCTURAL SILICONE GLAZING (CONTINUED)

1. Cut gaskets 1/8" (3) longer per foot of extrusion to allow for shrinkage. Vertical gaskets on mullion run past horizontal gaskets by 5/8" (16). Horizontal gaskets butt against vertical gaskets. Insert a water deflector between the two horizontal members and install spacer gaskets into verticals. See **DETAIL W**.
2. Install the **NP420** gaskets into the intermediate horizontal mullions. Seal the horizontal gaskets to the vertical gaskets and the joints around all water deflectors as shown in **DETAIL X**.

NOTE: Always follow structural silicone manufacturer's instructions and recommendations for surface preparation and silicone application.

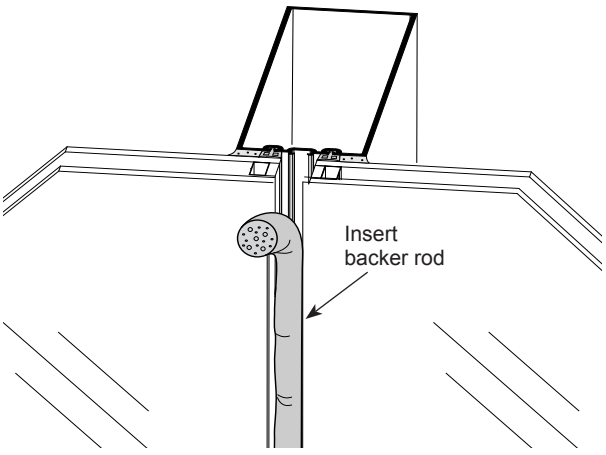


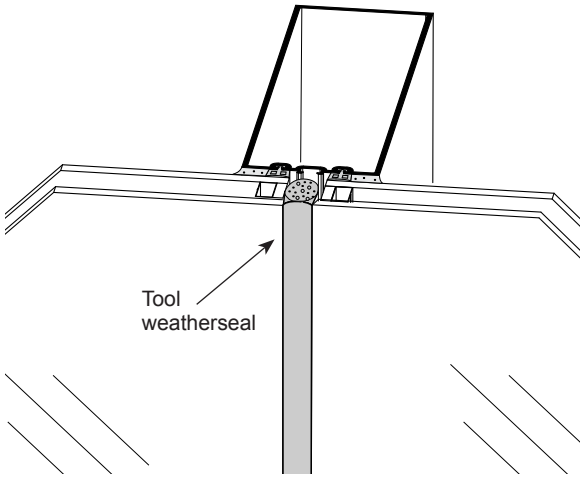
DETAIL DD



DETAIL EE

3. Position the two setting blocks on the horizontal mullions for each glass lite as directed by the deadload charts and shop drawings. See **DETAIL R** on Page 20.
4. Remove paper backing from the side blocks and apply to the Jambs only, at approximately mid-height of



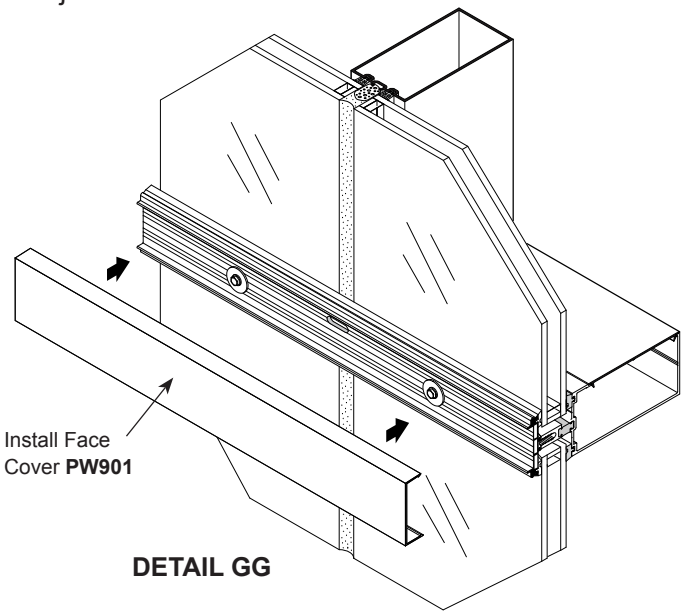


DETAIL FF

NOT TO SCALE

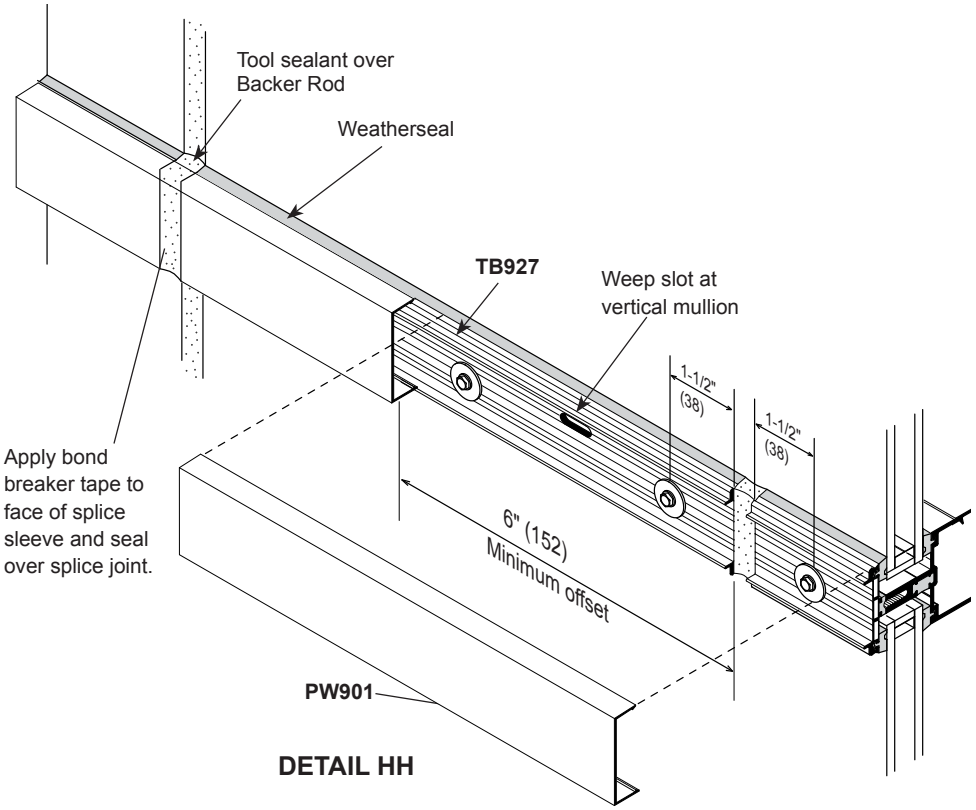
STRUCTURAL SILICONE GLAZING (CONTINUED)

1. Cut gaskets 1/8" (3) longer per foot of extrusion to allow for shrinkage. Vertical gaskets on mullion run past horizontal gaskets by 5/8" (16). Horizontal gaskets butt against vertical gaskets. Insert a water deflector between the two horizontal members and install spacer gaskets into verticals. See **DETAIL W**.
2. Install the **NP420** gaskets into the intermediate horizontal mullions. Seal the horizontal gaskets to the vertical gaskets and the joints around all water deflectors as shown in **DETAIL X**.



DETAIL GG

HORIZONTAL FACE COVER SPLICE JOINTS



DETAIL HH

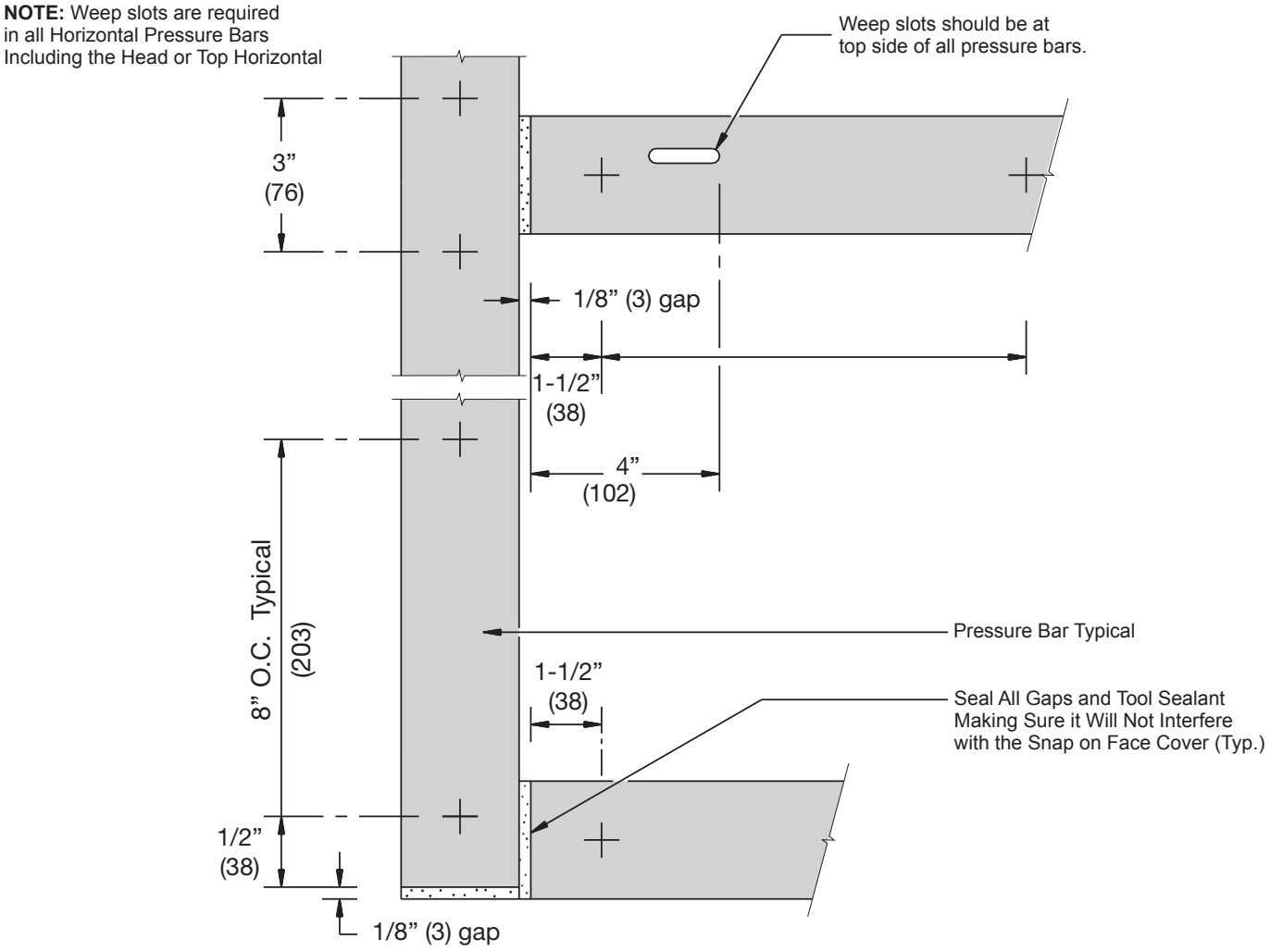
NOT TO SCALE

V 2024-1008

PRESSURE BAR INSTALLATION

Install vertical pressure bar bolts from bottom to top and horizontal pressure bar bolts from center outward. Always locate bolts 1-1/2" (38) maximum from vertical/horizontal intersections to ensure proper pressure over end dams. See DETAIL S. Be sure pressure bar spacer is not disengaged.

1. Install vertical pressure bars first leaving 1/8" (3) gaps at top and bottom. Using a speed wrench, torque bolts to 30 inch pound (3.4N.m). Increase torque to 40 inch pound (4.0 N.m) minimum after all four sides have been secured. NOTE: weep slots must be in top side of all horizontal pressure bars and level with bottom of glazing pocket to ensure proper drainage. See **DETAIL II**.
2. Center horizontal pressure bars in opening leaving 1/8" (3) gaps at each end.
3. Seal gaps at vertical/horizontal intersections and at top and bottom of vertical pressure bars. See **DETAIL II**.
4. Install vertical face covers first. Do not disturb top and bottom closure plates when installing face covers. Pinning of vertical face cover is required to prevent slippage. Use one pin on each side per cut length, concealed behind horizontal face cover closer to center line or as shown on shop drawings. See **DETAIL U**.



DETAIL II

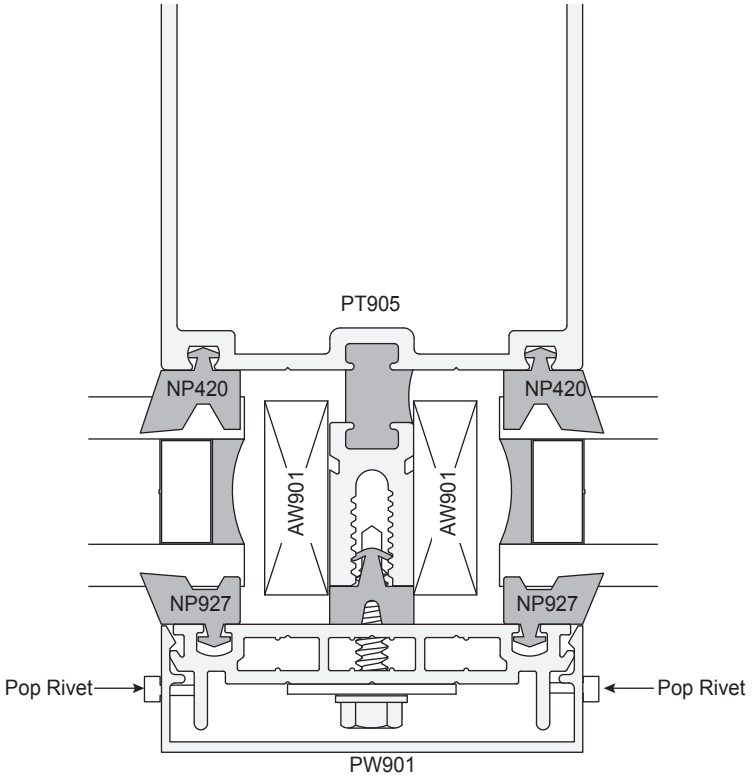
NOT TO SCALE

FACE COVER INSTALLATION

Care must be taken to prevent damage of face covers during installation. Use a piece of wood such as 2" x 4" x 12" (51 x 102 x 305) and a dead blow soft face hammer.

Install vertical pressure bar bolts from bottom to top and horizontal pressure bar bolts from center outward. Always locate bolts 1-1/2" (38) maximum from vertical/horizontal intersections to ensure proper pressure over

NOTE: Extended face covers require a special pressure bar. Pin vertical extended covers with one 1/8" (3) diameter pop rivet on each side per cut length (optional #10 x 1/2" FH SMS) See **DETAIL JJ**. Extended horizontal covers must be pinned on top side at both ends.

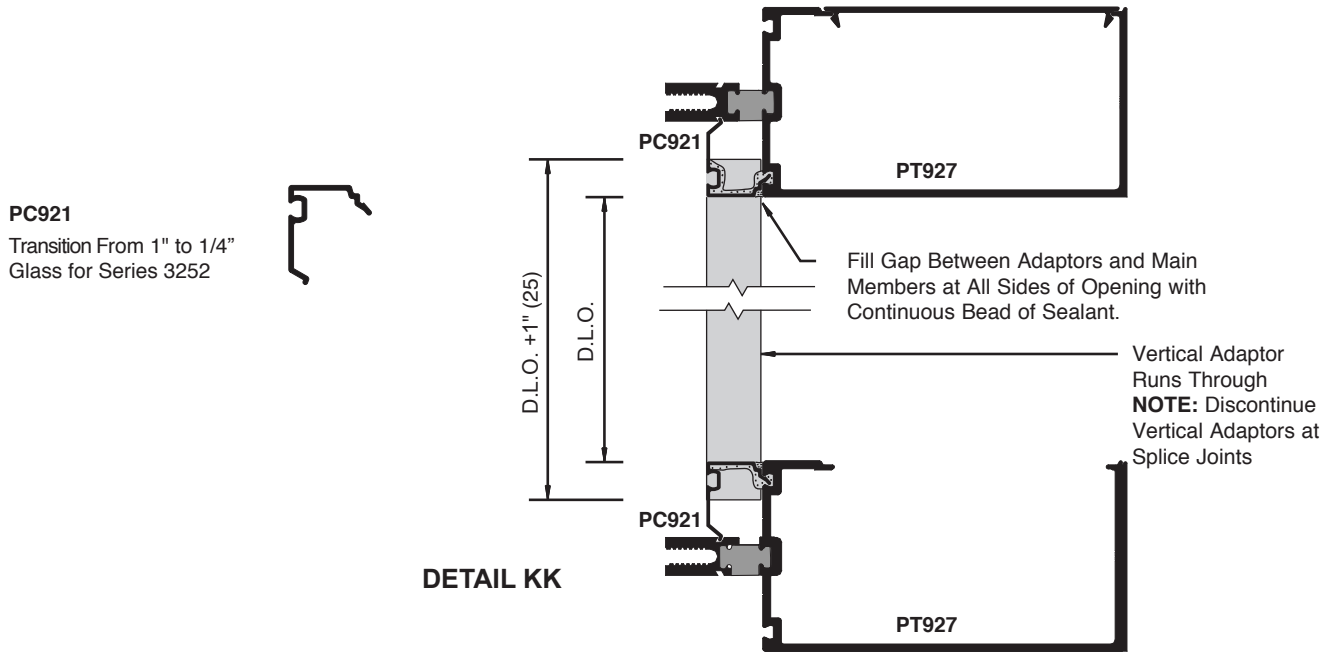


1/16" x 1/2" (1.6 x 13) pop rivet or roll pin at center of cut length on each side. (Concealed behind horizontal face cover)

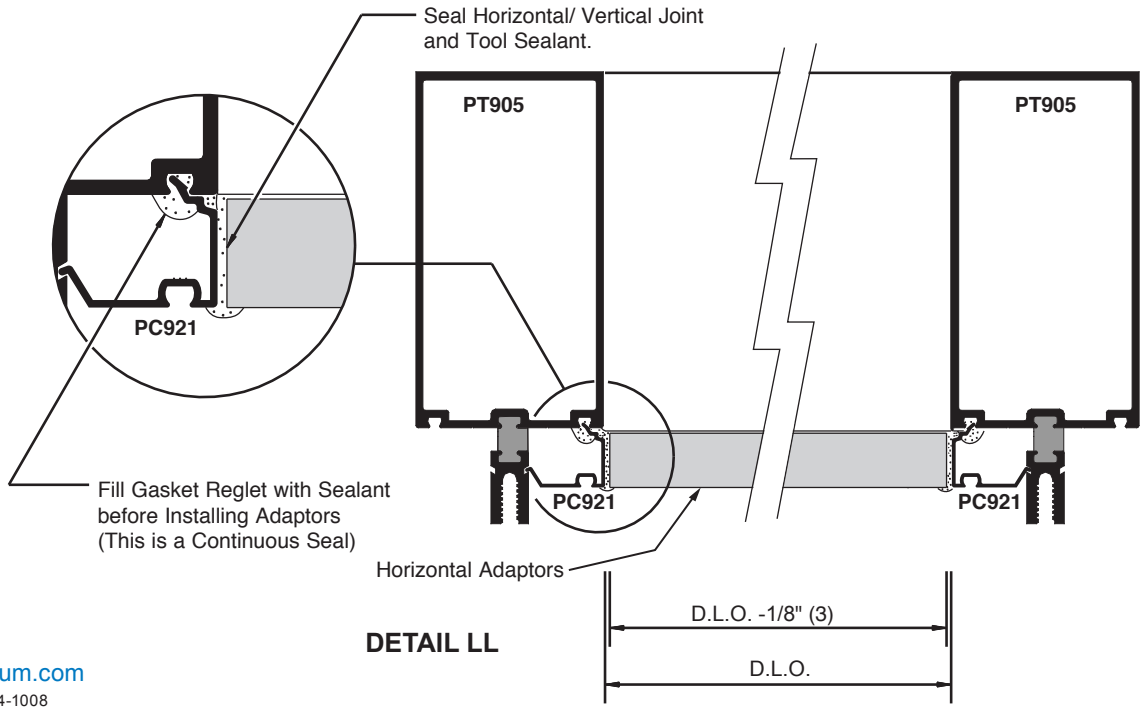
DETAIL JJ

TRANSITION GLAZING

1. Apply sealant into gasket reglets before installing snap-in transition adaptors.
2. Install vertical adaptors first.
3. Install horizontal adaptors and seal horizontal/vertical joints. Tool sealant. See **DETAIL KK and LL**.



DETAIL KK



DETAIL LL

NOT TO SCALE

VERTICAL SPLICE JOINTS

Splice joint width should be based on sealant movement capability and on the following formula:

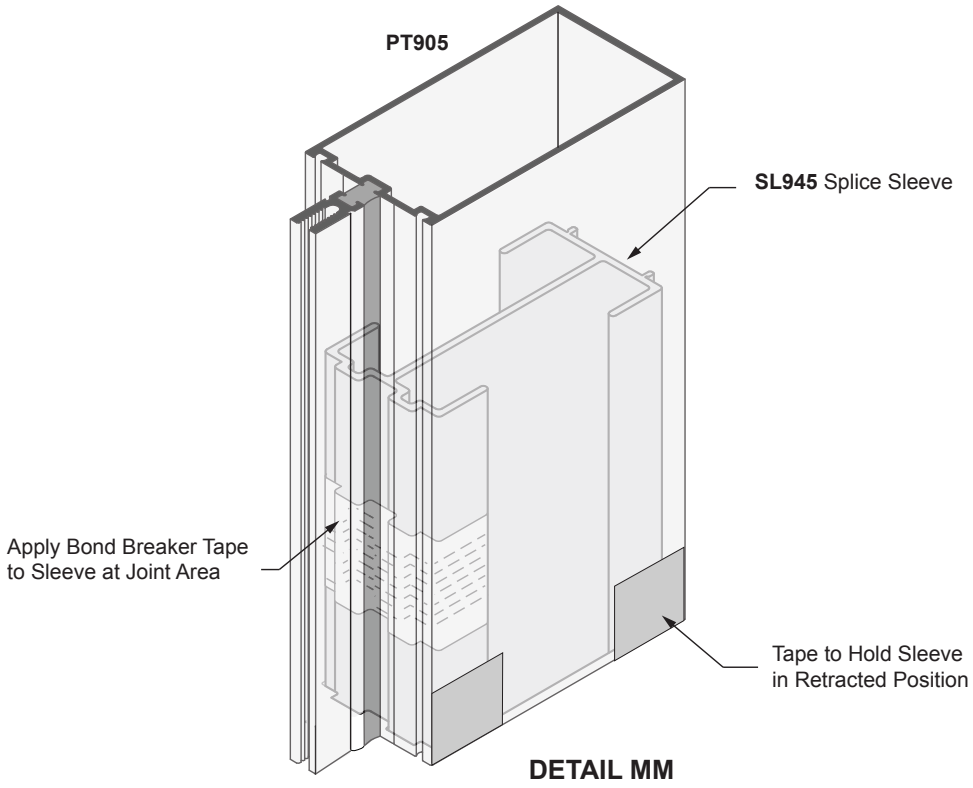
Linear expansion for aluminum, in inches	**=**	**Length (") x F° difference in temperature x .0000129**
Linear expansion for aluminum, in millimeters	**=**	**Length (mm) x C° difference in temperature x .02322**

A 1/2" (13) minimum joint is recommended. Use a 1/2" (13) spacer shim to set and hold the mullion joint constant during erection. Remove the shim after attaching the verticals to the anchors. **Splice joints must occur at spandrel areas.**

NOTE: Splice joints are designed to accommodate thermal movement only. They do not compensate for variations in floor levels.

SPLICE SLEEVE

1. Clean splice sleeves and all joint surfaces. Apply Bond Breaker Tape at areas where sleeve will be sealed to avoid three side adhesion (**DETAIL MM**).
2. Slide sleeve into the upper member before it is installed and tape to hold it in retracted position. See **DETAIL MM**.

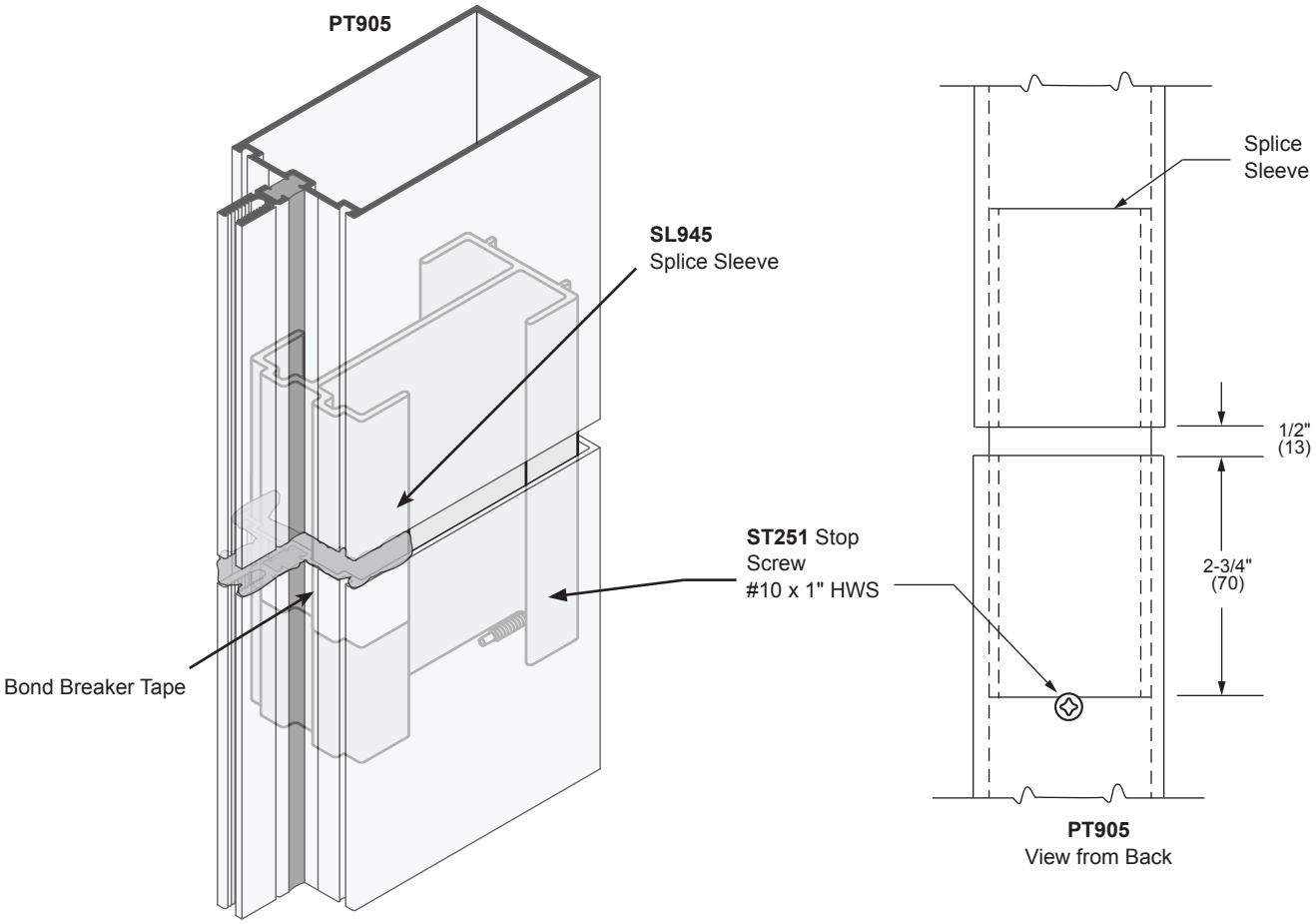


DETAIL MM

V 2024-1008

VERTICAL SPLICE JOINTS (CONTINUED)
SPLICE SLEEVE (CONTINUED)

1. Clean splice sleeves and all joint surfaces. Apply Bond Breaker Tape at areas where sleeve will be sealed to avoid three side adhesion (**DETAIL MM**).
2. Slide sleeve into the upper member before it is installed and tape to hold it in retracted position. See **DETAIL MM**.
3. Install **ST251** stop screw #10 x 1" HWS at location 2-3/4" (70) down from top of extrusion at inside of lower member (**DETAIL NN**).

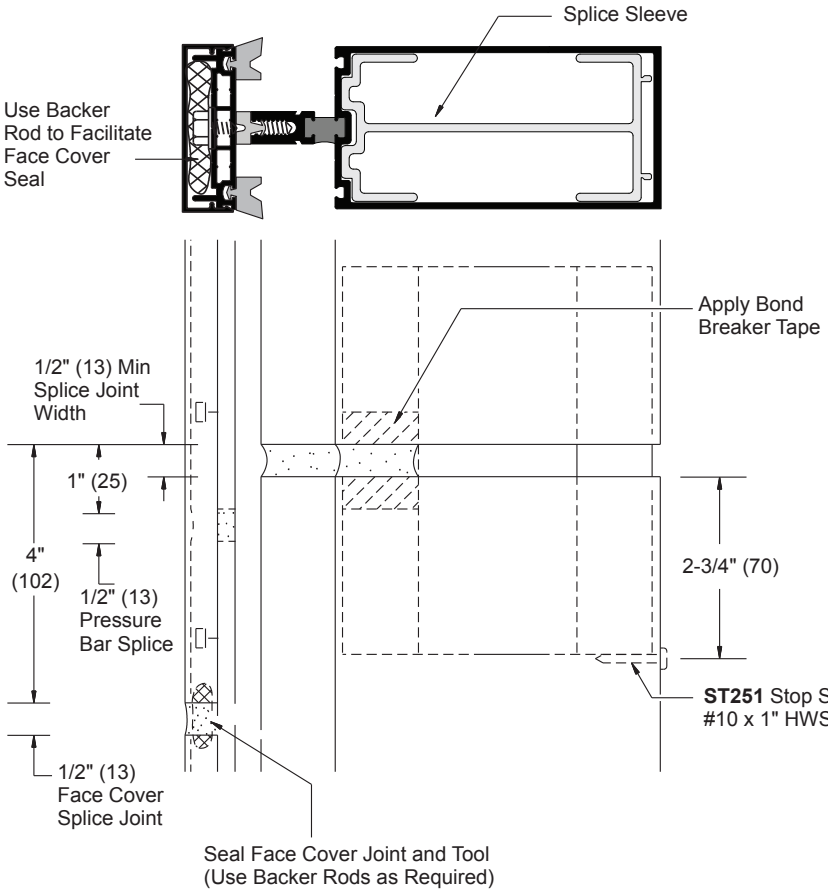


DETAIL NN

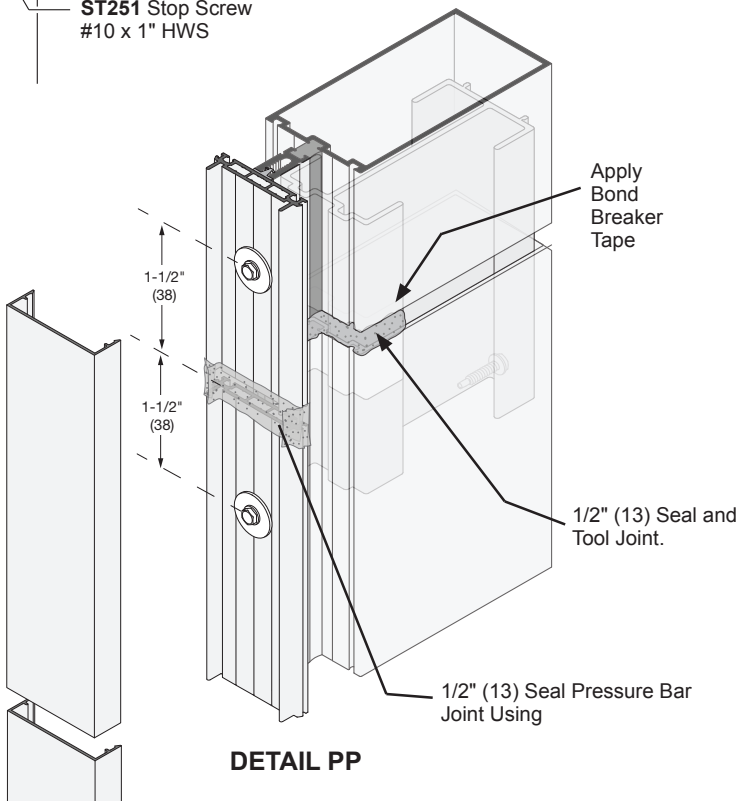
VERTICAL SPLICE JOINTS (CONTINUED)

PRESSURE BAR AND FACE PLATE

1. Clean splice sleeves and all joint surfaces. Apply Bond Breaker Tape at areas where sleeve will be sealed to avoid three side adhesion (**DETAIL MM**).



DETAIL OO

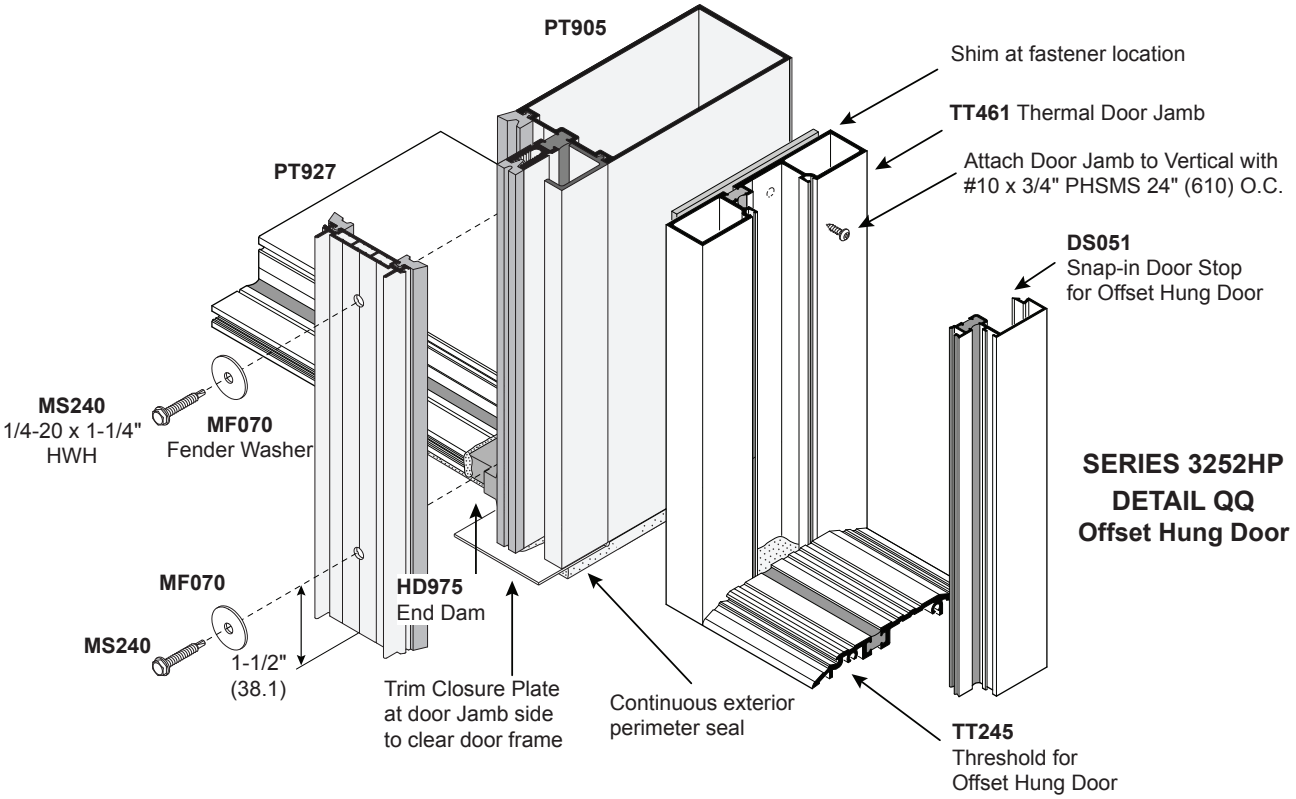


DETAIL PP

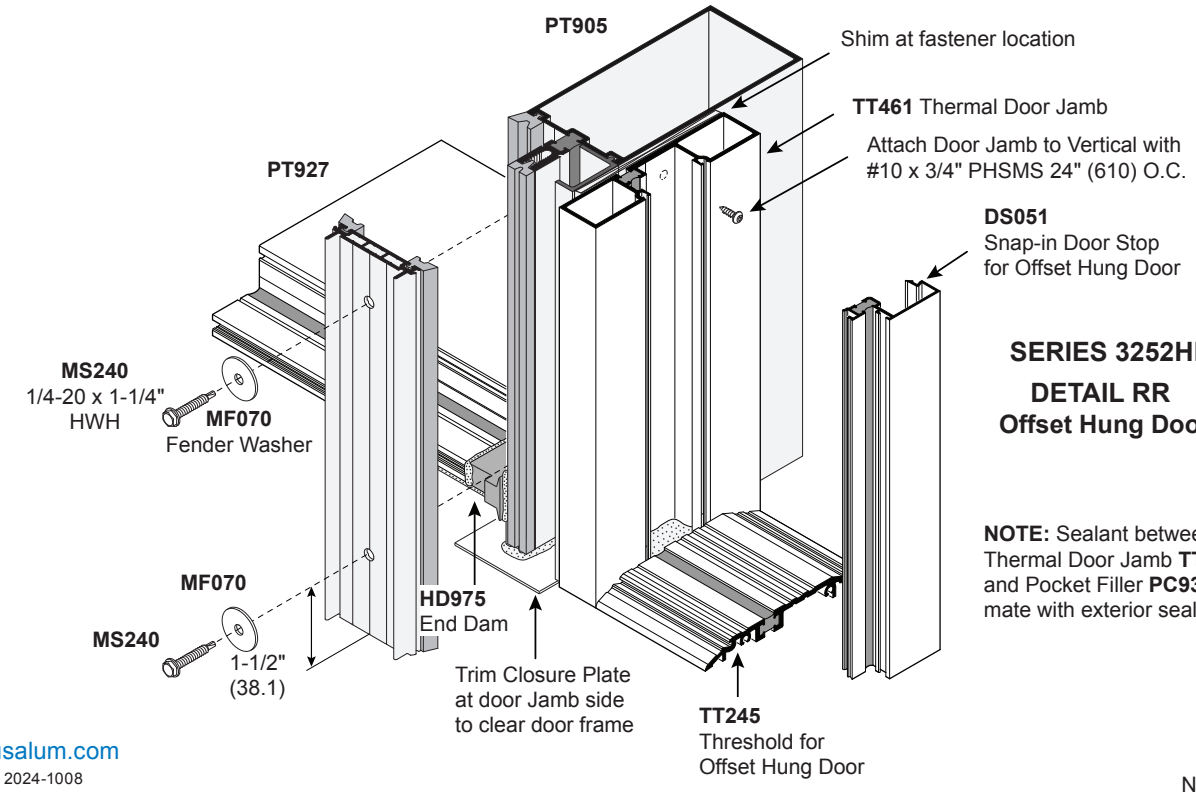
NOTE: Consult Sealant Manufacturer for Proper Cleaning and Priming Recommendations.

ENTRANCE FRAMES

Entrance Frames may be installed simultaneously with Curtain Wall or after Curtain Wall installation has been completed. Use **PC952** or **PC352** pocket fillers to close glazing pocket at door side.



SERIES 3252HP
DETAIL QQ
Offset Hung Door



SERIES 3252HP
DETAIL RR
Offset Hung Door

NOTE: Sealant between Thermal Door Jamb **TT461** and Pocket Filler **PC931** must mate with exterior seal.

NOT TO SCALE