



RELIANCE™ - TC SS

Outside Glazed

installation & glazing manual

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.

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IMPORTANT NOTICE:

Completely read these instructions prior to beginning work. These recommendations are for general erection/installation procedures only. For actual job conditions, see shop drawings if applicable. For perimeter anchor types and spacing, refer to the approved shop drawings or consult structural engineer/project design professional.

GENERAL NOTES

The **Reliance™-TC SS** 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.

Check all shop drawings and installation instructions to become familiar with the project before work begins. The shop drawings take precedence and include specific details for the project. The installation instructions are of a general nature and only cover the most common conditions.

GLAZING PRACTICES

The air and water performance of the **Reliance™-TC SS** 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:

1. Surfaces to be sealed should be cleaned with isopropyl alcohol or solvent and dried as recommended by sealant manufacturer to remove all dirt and cutting oils. Sealant at shear blocks should be a minimum 3/16" diameter nominal placed completely around the top, face and bottom of the shear block without gaps in the sealant. Exposed surfaces should be cleaned after installing the horizontal. Inspect joint for complete sealant contact, especially where the horizontal meets the face of the vertical member. Repair joint as required.
2. Glazing gaskets should be cut 1/4" longer per foot, and lay flat, preferably for 24 hours.
3. Gaskets should be cut as single monolithic pieces and "crowded" during their installation to avoid corner gaps caused by post-installation relaxation.
4. The interior glazing gasket should be installed so as to avoid stretching, buckles, or tears.
5. 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.
6. Gasket corner joinery must also be crowded, and sealant applied onto the gasket contact frame surface and into gasket reglet raceway where applicable.
7. 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 its 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.
8. 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.
9. Check the placement of the installed glass and verify there is proper edge bite into the pocket, and proper edge clearance from framing elements.

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10. 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.

Vertical movement of mullion at intermediate floors requires special expansion joints and glazing materials. For designs and applications that may require greater movement, or special considerations please contact your local Oldcastle BuildingEnvelope® facility.

ARCHITECTURAL PRODUCT

It is the responsibility of Oldcastle BuildingEnvelope® to supply a system to meet the architect's specification.

BUILDING CODES

Oldcastle BuildingEnvelope® does not control the application nor selection of its product configurations, sealant, or glazing materials, and assumes no responsibility thereof. It is the responsibility of the owner, architect, and installer to make these selections in strict compliance with applicable laws and building codes.

PERIMETER SEALANTS

Due to varying job conditions, all perimeter sealants used should be approved by the sealant manufacturer to ensure the sealant will function for the conditions shown in these instructions and shop drawings. Sealants must be compatible with all surfaces where adhesion is required, including other sealant surfaces. Use primers where directed by sealant manufacturer. Be sure to store sealants at recommended temperature and check container for remainder of shelf life before using.

STRUCTURAL 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.

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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.

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.

MATERIAL AND WORK ACCEPTANCE

OLDCASTLE BUILDINGENVELOPE® MATERIALS

Check all material upon arrival for quality and to assure against shipping damage. Any visible damage must be noted on the freight bill at the time of receipt. If a claim is required, then the receiving party must process a claim with the freight company.

OTHER TRADES WORK

Completely check construction that will receive your materials against contract documents. Notify general contractor by letter of any discrepancies before proceeding with work. Failure to do so constitutes acceptance of work by other trades.

MATERIAL HANDLING, PROTECTION, AND STORAGE

Handle the material carefully. Do not drop from the truck. Stack with adequate separation so that the material will not rub together. Store material off the ground. Protect against the elements and other construction hazards by using a well-ventilated covering away from other trades. Remove material from package if it is wet or located in a damp area.

SHOP

- Cardboard wrapped or paper interleaved material must be kept dry. Immediately remove aluminum from cardboard or paper interleaved materials should it get wet to prevent staining or etching the aluminum finish.
- Check arriving materials for quantity and keep record of where various materials are stored.

JOB SITE

- Material at job site must be stored in a safe place well removed from possible damage by other trades.

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- Cardboard wrapped or paper interleaved materials must be kept dry. Immediately remove aluminum from cardboard or paper interleaved materials should it get wet to prevent staining or etching the aluminum finish.
- Keep record of where various materials are stored.
- Protect materials after erection. Cement, plaster, and other alkaline solutions are harmful to the finish.

EXPANSION JOINTS

Expansion joints and perimeter seals shown in these instructions and in the shop drawings are shown at standard size. Actual dimensions may vary due to perimeter conditions and/or differences in metal temperature between the time of fabrication and time of installation. For example, a 12-foot unrestrained length of aluminum extrusion can expand or contract 3/32 of an inch over a 50-degree Fahrenheit change. Any movement potential should be accounted for at time of the installation.

GLASS

Glazing gaskets are designed for a compression fit against glass and can accommodate (+/- 1/32"). Be sure to check overall glass size and thickness. Consult glass manufacturer for correct setting block location and length for glass sizes in excess of 40 sq./ft.

CLEANING

Final cleaning of exposed aluminum surfaces should be done in accordance with AAMA 609.1 for anodized aluminum and AAMA 610.1 for painted aluminum. Cement, plaster, terrazzo, alkaline and acid-based materials used to clean masonry are very harmful to finishes and should be removed immediately or permanent staining will occur. A spot test is recommended before any cleaning agent is used. Aluminum shall be cleaned with plain water containing a mild detergent. No abrasive agent shall be used.

GENERAL CONSTRUCTION NOTES

- A. Study these instructions, shop drawings, erection drawings, and architectural drawings before starting any work. Follow installation and glazing instructions.
- B. Completely check construction which will receive your materials against contract documents. Notify the general contractor by letter of any discrepancies before proceeding with your work since this constitutes acceptance of work by other trades.
- C. Coordinate protection of installed materials with general contractors and other trades.
- D. Do not install wall if there is a walkway with a downslope towards an entrance or a storefront.
- E. All materials are to be installed plumb and level.
- F. All work should start from an established benchmark and column centerlines established by the architect and the general contractor.
- G. Protect all aluminum to be placed directly in contact with uncured masonry or incompatible materials with a heavy coat of zinc chromate or bituminous paint.
- H. After sealant is set and a representative amount of the wall has been glazed (500 square feet or more), run a water hose test to check installation. On large jobs, hose test should be repeated during glazing operation. Test should be conducted in accordance with AAMA 501.2 specifications. This test should not be performed at entrances installed in the system.

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SUGGESTIONS FOR IMPROVING SYSTEM THERMAL PERFORMANCE

To maintain or improve your wall installation the following items should be considered.

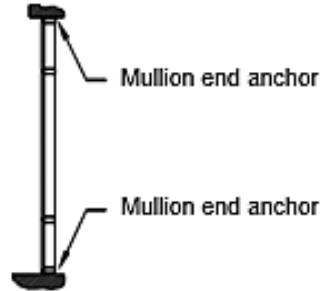
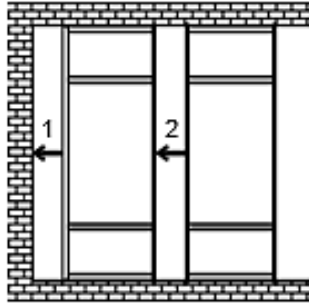
- A. Blinds or drapes prevent warm air from adequately flowing over the window surface.
- B. Warm air ventilators too far from the window will not adequately wash the window with air to prevent condensation.
- C. In extreme conditions the fan of the heating system should not cycle on and off but should run continuously.
- D. Some heating systems have a water injection feature that can raise humidity levels. the higher the humidity level the more likely condensation or frost will form. Raising the temperature and reducing humidity will usually solve the problem.
- E. On rare occasions an extremely cold storm may cause frost to appear on the glass framing. A space heater and electric fan blowing along the plane of the window wall can reduce or eliminate this temporary condition.

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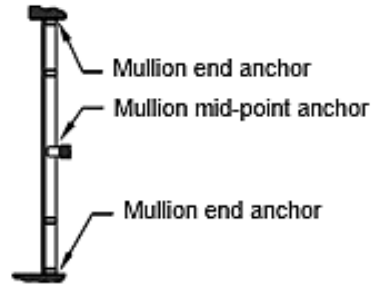
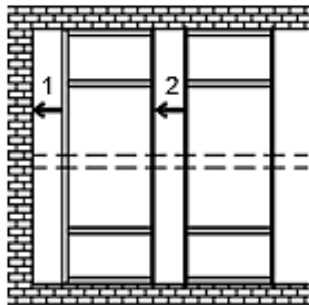
INSTALLATION TYPES

1.0 Reference Diagrams

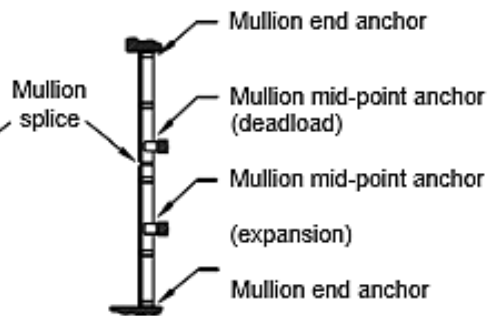
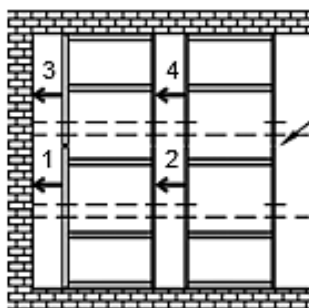
The following diagrams represent common types of installation for this product. Refer to approved shop drawings for specifics regarding splicing and anchoring of frame



Single Span



Twin Span



Multi-Span

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FRAME FABRICATION

NOTE: The opening must be square and plumb before installation.

2.0 Frame Fabrication

NOTE: Unless otherwise noted, the details shown in these instructions reflect the 7 1/4" system. Part numbers and dimensions in parentheses () refer to the 6" system. Instructions for other back member depths are similar. **NOTE:** Structural silicone glazed vertical mullion is referred to as "SSG mullion"

- 2.1 Measure ROUGH OPENING to determine FRAME WIDTH and FRAME HEIGHT dimensions. Allow 1/2" minimum clearance for shimming and caulking around perimeter of frame.
- 2.2 Cut material to size. **See FIGURE 1** for guide.

Frame Members

Verticals	FRAME HEIGHT (ROUGH OPENING minus top & bottom joints)
Vertical Pressure Plates	FRAME HEIGHT minus 1/4"
Vertical Face Covers	FRAME HEIGHT (vertical covers run through)
Intermediate Horizontals	Daylight Opening (D.L.O.)
Head and Sill Members	D.L.O.
Horizontal Pressure Plates	D.L.O. minus 1/4" Horizontal
Face Covers	D.L.O. minus 1/16"
Head & Sill Interior Covers	D.L.O. minus 1/16"

Accessories

Glazing Gaskets	
Exterior	Pressure Plate length plus allowance*
Interior at Verticals	D.L.O. plus 1" plus allowance* (vertical gaskets run through)
Interior at Horizontals	D.L.O. plus allowance*
Silicone Spacer Gaskets	D.L.O. plus 1" plus allowance*
Thermal Isolator	Vertical length (crowd in place to avoid gaps at ends) (cut back 3/4" from bottom of vertical mullions)
Vertical Air Seal Gasket	Vertical length
<i>*Glazing gaskets should be cut 1/4" longer per foot of aluminum extrusion. Set aside and lay flat until ready to glaze.</i>	

Other Members (as required)

Glazing adaptors

Horizontal	D.L.O. minus 1/32"
Vertical	D.L.O. plus 1"

**See "VERTICAL SPLICING" instructions for special instructions on cut lengths and fabrication in these areas.*

Door Subframe

Jamb	DOOR OPENING plus 7/8"
Header	DOOR OPENING minus 1/32"

Flush Door Pressure Plate

Jamb	DOOR OPENING plus 3/4"
Header	DOOR OPENING minus 1/16"

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Flush Door Face Cover

Jamb DOOR OPENING plus 2-1/2"
 Header DOOR OPENING minus 1/16"

Glass Sizing

Field Glazing 1/2" glass bite typical (D.L.O. plus 1")
 Captured Mullions 1" glass bite at verticals (D.L.O. plus 2")
 SSG Verticals 1/2" glass bite at horizontals (D.L.O. plus 1")

Shop Glazing

Captured Mullions 9/16" glass bite typical (D.L.O. plus 1 1/8")
 SSG Verticals 1" glass bite at verticals (D.L.O. plus 2")
 9/16" glass bite at horizontals (D.L.O. plus 1 1/8")

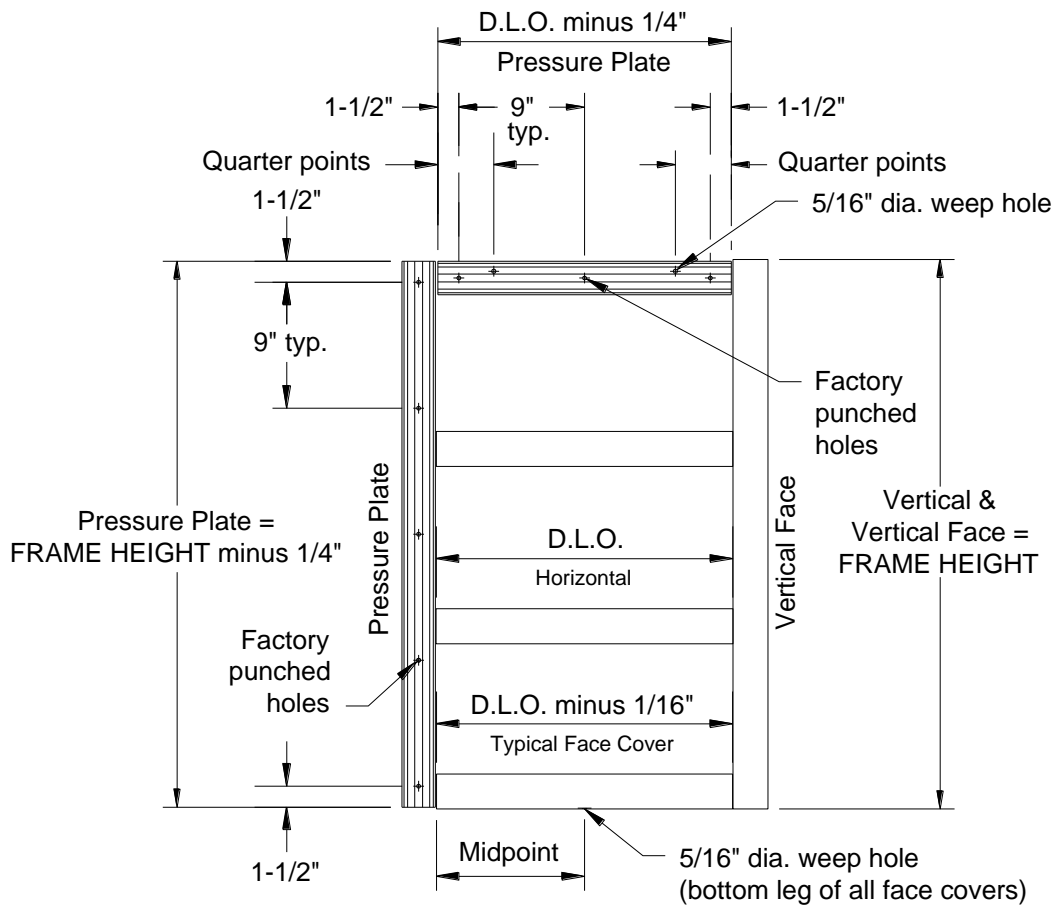
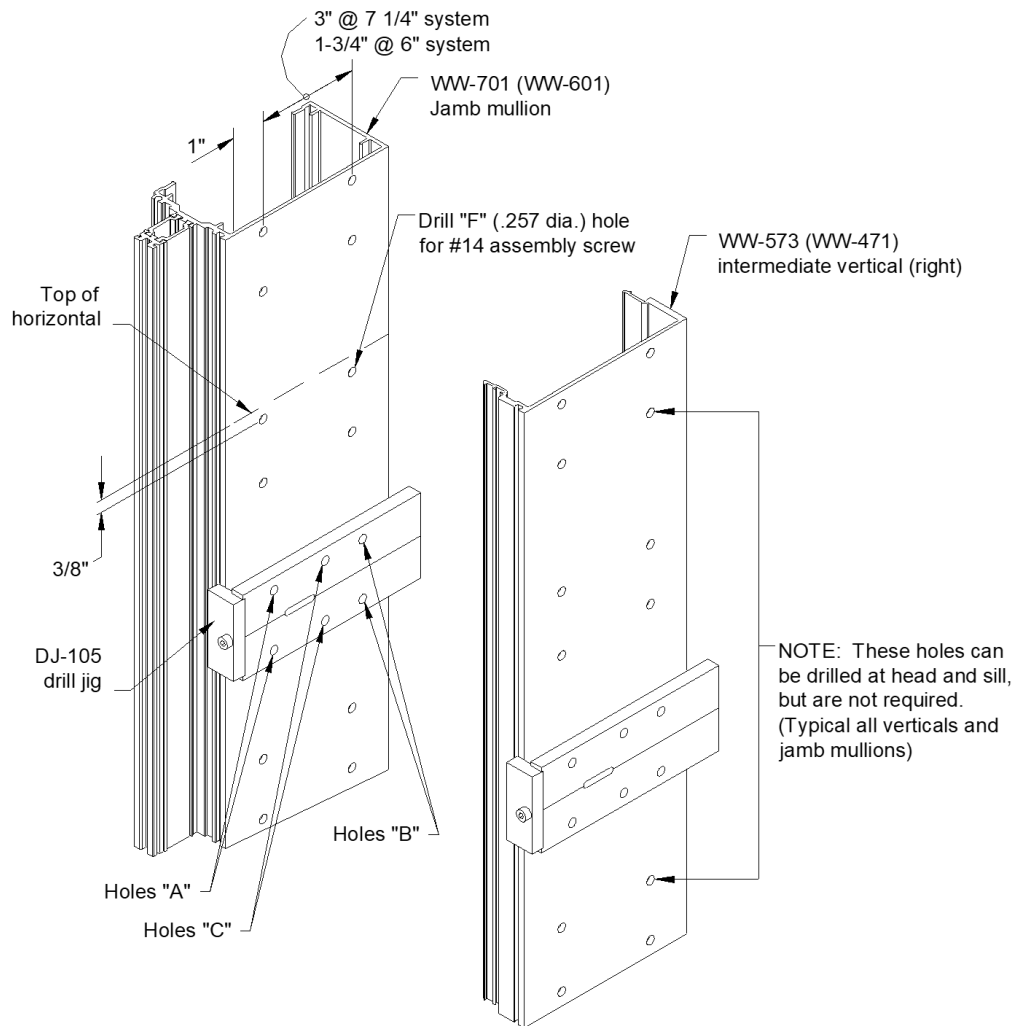


Figure 1: Material Fabrication Guide

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3.0 Vertical Fabrication

- 3.1 Fabricate vertical mullions for horizontal members with EZ Punch tooling or **DJ-105 drill jig**. When using the drill jig, drill holes 'A' and 'B' for the 7 1/4" system and 'A' and 'C' for the 6" system. Use 'F' drill (.257 dia.) for assembly screws. Drill all four holes. **See FIGURE 2.** When working from horizontal centerlines, align the slot milled into the drill jig with the centerline. Drill (1) 5/16" diameter weep hole at face of captured mullions, 1/2" from the bottom of each mullion. **See FIGURE 3.**
- 3.2 Drill a #29 (.136 dia.) hole at top and bottom in each half of the intermediate vertical mullions for the mullion cap. **See FIGURE 3.**
- 3.3 Install and seal end caps to top and bottom of jamb mullions with (1) FS-202 #8 X 1/2" PPH screw. **See FIGURE 4.**



WW-573 (WW-471) captured vertical mullion shown.
IW-544 (IW-444) & IW-545 (IW-445) SSG mullions are similar.

Figure 2: Vertical Mullion Fabrication

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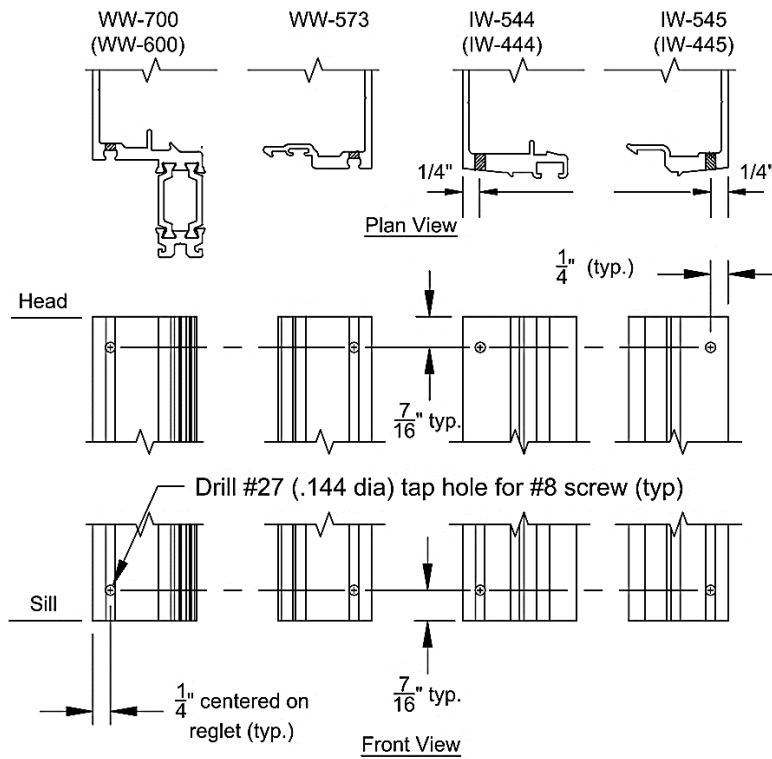


Figure 3: Vertical Prep for Mull Caps

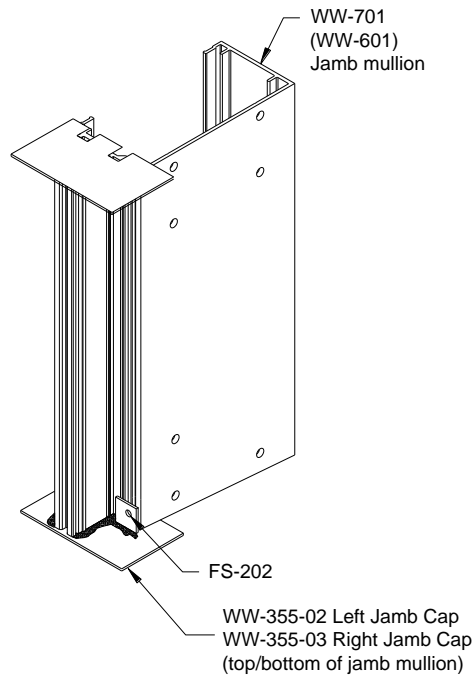


Figure 4: Jamb/Mullion End Caps

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4.0 Pressure Plate and Cover Fabrication

- 4.1 Drill 5/16" diameter weep holes at 1/4 points in the horizontal pressure plate. **See FIGURE 5** for aluminum pressure plate and **FIGURE 6** for polyamide pressure plate. Horizontal pressure plates at SSG mullions will have weep holes located at 1/4 points of each DLO and will span multiple openings, but not to exceed 3 lies.
- 4.2 Drill 5/16" diameter weep hole at the center of each DLO in horizontal covers. **FIGURES 5 & 6.**
- 4.3 All pressure plates have factory-punched holes for screws at 9" O.C. To ensure proper pressure on the glazing, 7/32" diameter holes may need to be drilled at the ends of each horizontal pressure plate as required. Locate at 1 1/2" maximum from the ends. **See FIGURE 7.**

NOTE: The 5/16" dia. weep holes in the WW-159-01 Polyamide pressure plates need to be drilled with a common # 3 stepped drill bit, to properly drill an exterior 7/16" dia. hole at the exterior. This is a requirement to direct the water outward and not sit in the hollow cavity. Any modifications will void the warranty.

NOTE: For SSG applications, face covers typically run across mullions, so there will be multiple holes in each horizontal face cover.

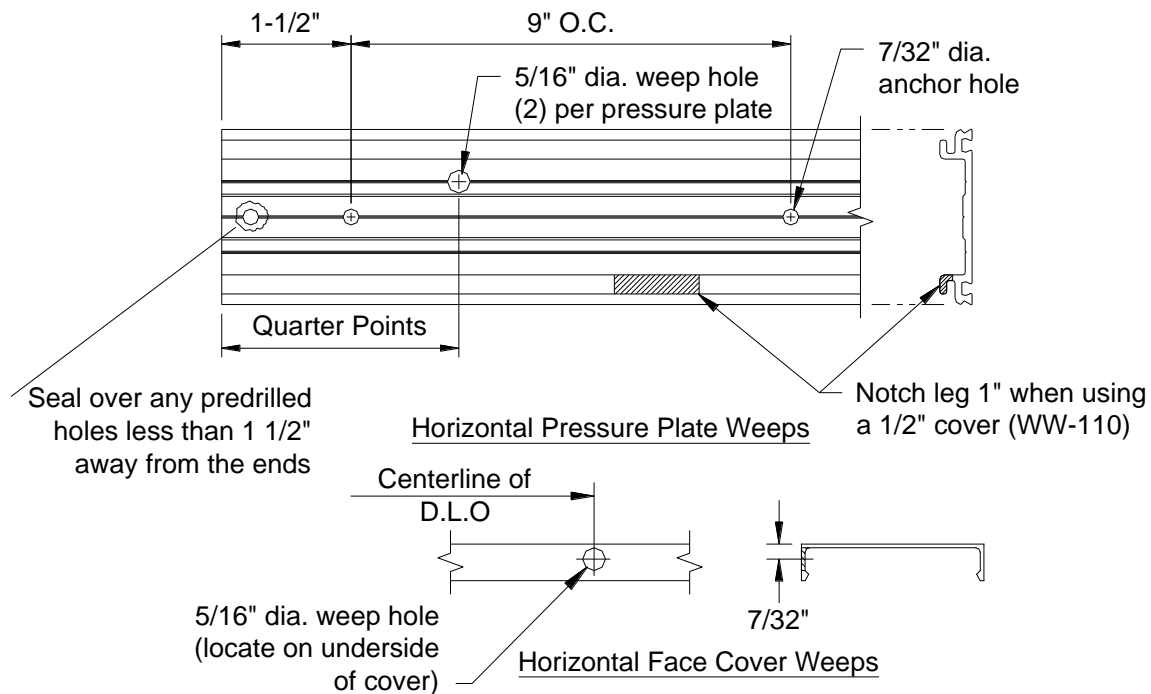


Figure 5: Horizontal Weep Holes (aluminum pressure plate)

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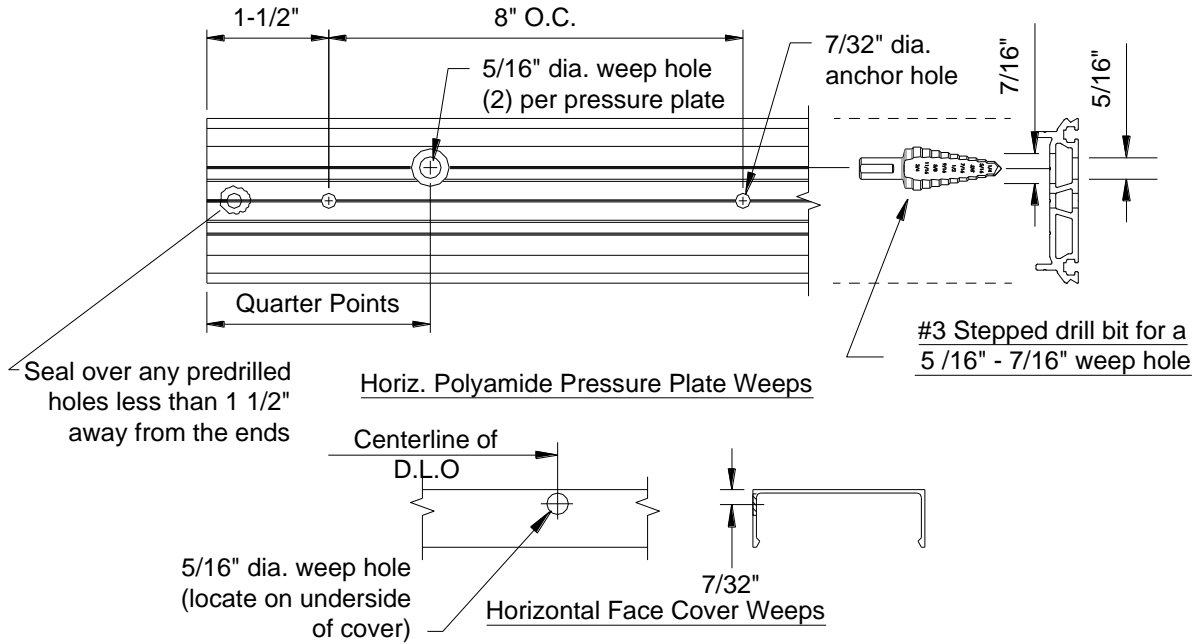


Figure 6: Horizontal Weep Holes (polyamide pressure plate)

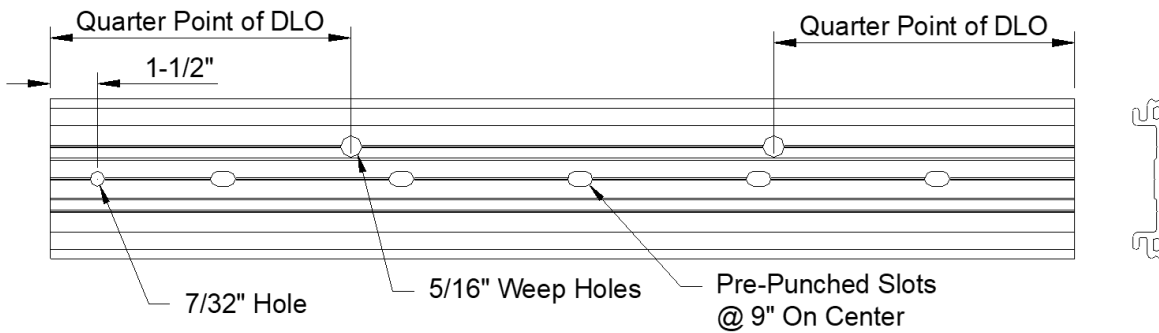


Figure 7: Pressure Plate Fabrication

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FRAME INSTALLATION AND ASSEMBLY

5.0 Frame Assembly

- 5.1 Starting with the left jamb of the opening, lay out verticals and horizontals for assembly of the bay. **See FIGURE 8.**
- 5.2 Clean with Isopropyl alcohol and apply sealant to ends of horizontals prior to attaching to verticals. Attach to verticals with FS-8 #14 x 1" Hex Head screws. Three screws are required at each head and sill; four are required at intermediate horizontals. **See FIGURE 9A.** Tool excess sealant at horizontal-to-vertical joints
- 5.3 Install CW-998 bulb gasket into race at center of captured mullions. Crimp ends of mullion to lock into position. **See FIGURE 9B.**
- 5.4 If mullions are spliced, slide splice sleeves into the bottom of the upper bay mullion. Secure with tape. **See FIGURE 10.** Install one (1) FS-322 #14 x 1" TEK screw into the top of the lower bay mullion to act as a stop screw for splices during frame installation. **See FIGURE 11.**
- 5.5 After bay is assembled, clean and apply sealant to all contact surfaces on vertical and horizontal mullions where the zone plugs will be installed (captured mullions only). Apply sealant to horizontal tongue receptor on zone plug and install at the end of each horizontal, head and sill. Tool any excess sealant around front end of zone plug where thermal isolator abuts the zone plug. Tool sealant in the glazing pockets to ensure a watertight fit. **See FIGURE 19.**
- 5.6 Repeat steps 5.1 to 5.5 until all bays have been assembled

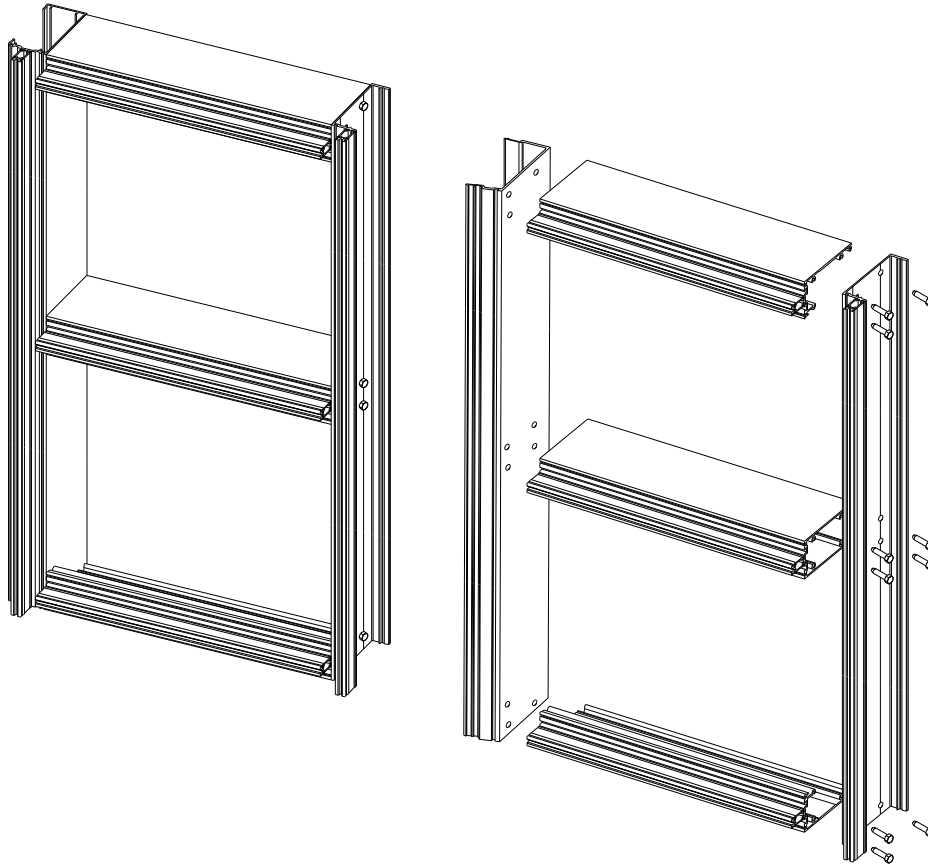


Figure 8: Frame Assembly Guide

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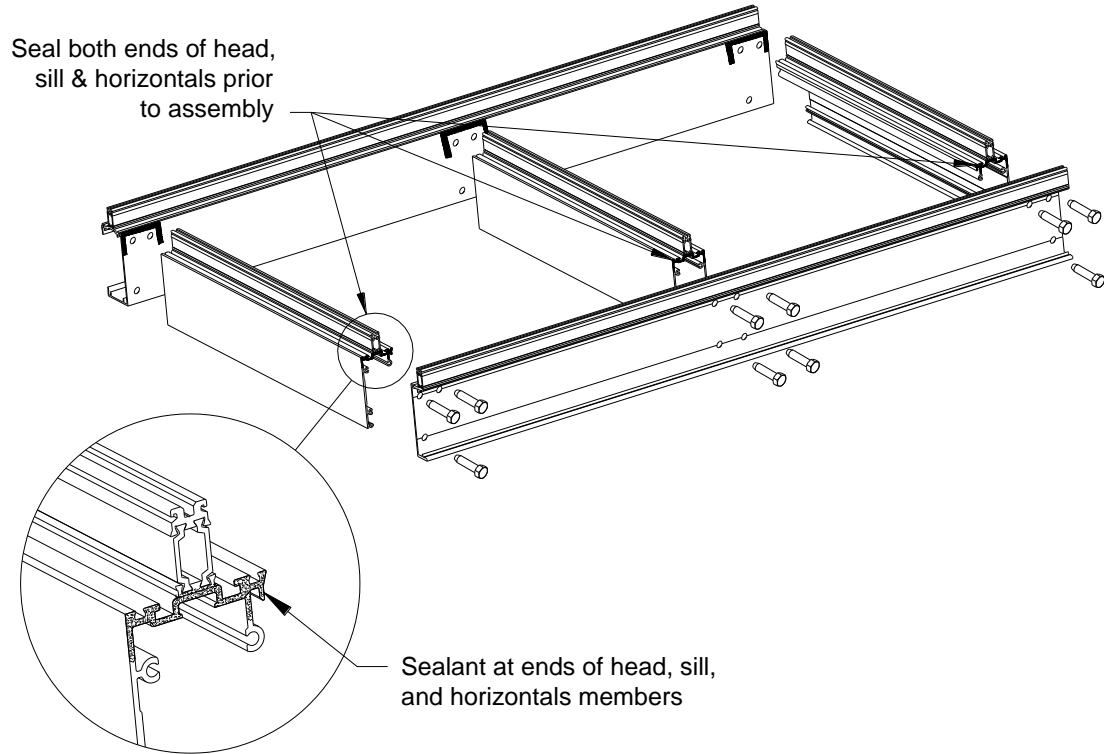


Figure 9A: Vertical to Horizontal Attachment

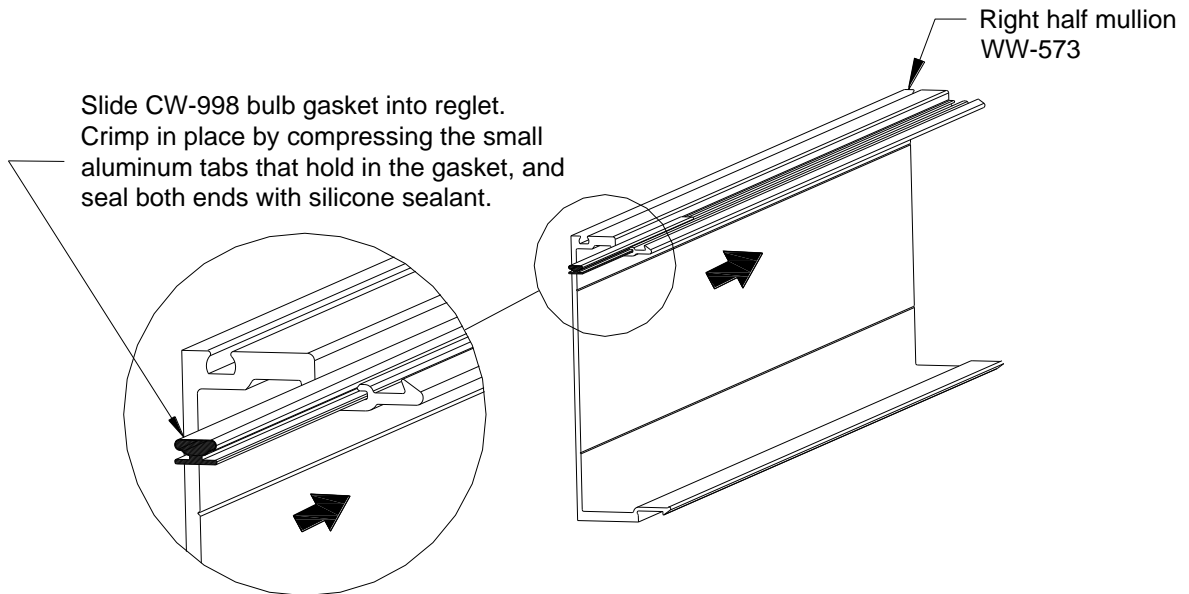


Figure 9B: CW-998 Air Seal Gasket Installation

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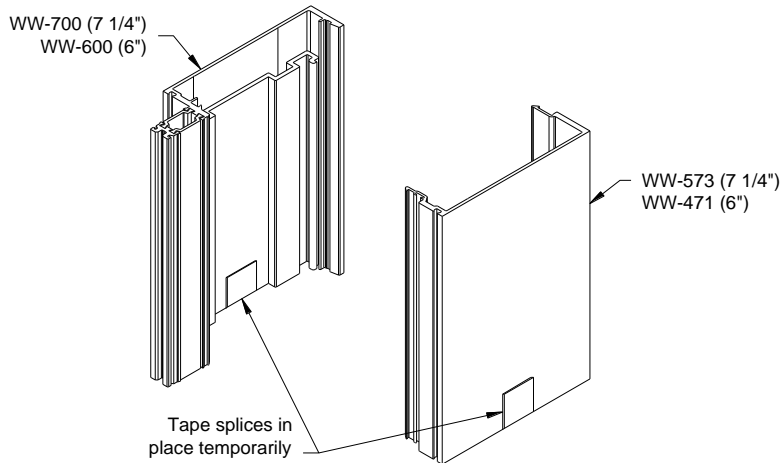


Figure 10: Splice Installation in Upper Mullions (Captured Shown, SSG Similar)

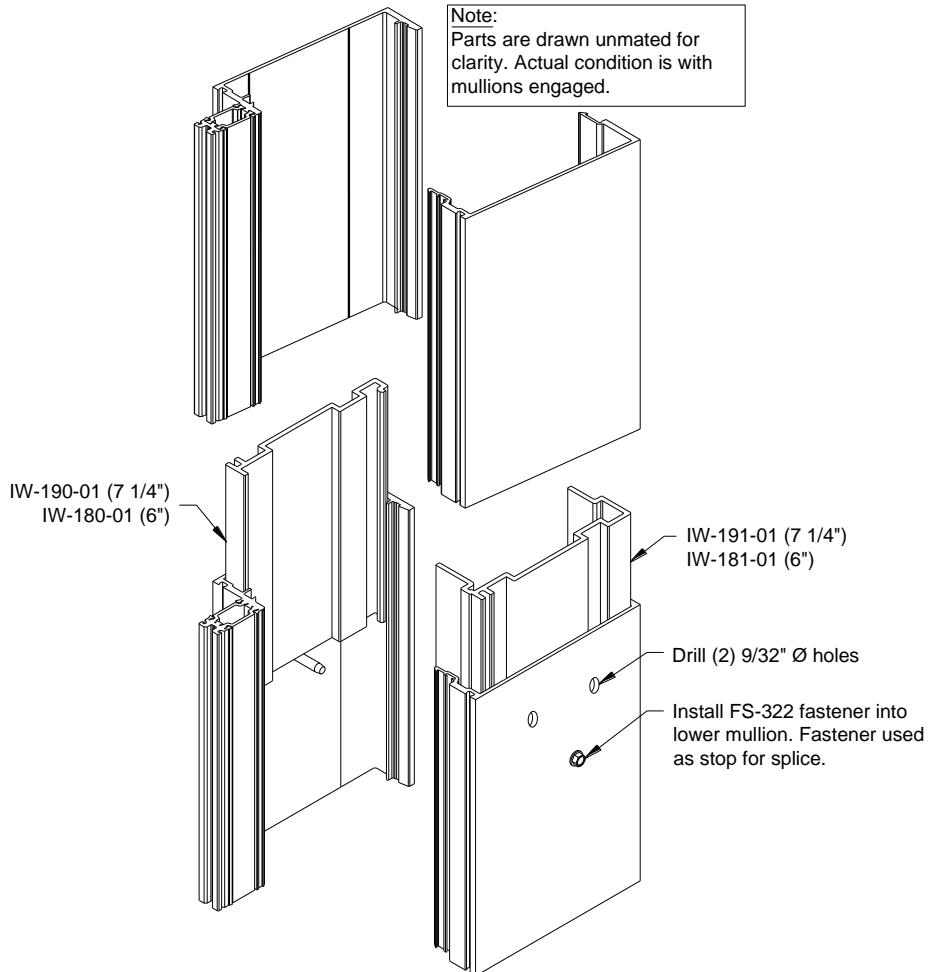


Figure 11: Splice Stop Screw

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6.0 Frame Anchoring

NOTE: Anchor type and sizes vary per job requirements. Details shown in these instructions are to be used as a guide only. Refer to approved shop drawings for actual conditions.

- 6.1 **Reliance™-TC SS** can be anchored to the building condition by either hard fastening directly through the head/sill member, **see FIGURE 12**, or slide-in mullion anchors that fit inside the vertical mullions. **See FIGURE 13**. If using the slide-in anchors, install into ends of mullions prior to erecting the frame.
- 6.2 Starting with the first bay, install into opening plumb and level. Check perimeter to maintain proper caulk joint. Anchor to structure per approved shop drawings.
- 6.3 Just prior to setting next bay into opening, seal bulb gasket at sill to 6" above bottom of mullion. **NOTE: THIS 6" SEAL IS REQUIRED AT THE SILL AND BOTTOM OF MULLIONS AT SPLICE JOINT. See FIGURE 14.**
- 6.4 Set next bay into opening by engaging mullion halves together. Ensure that bottom of mullion halves align. Anchor this bay to structure. **See FIGURE 15.**
- 6.6 Repeat steps 6.2 through 6.4 until all bays are installed. Check D.L.O. and diagonal dimensions every four bays to ensure correct spacing and frame squareness to prevent dimensional buildup.
- 6.7 If mullions are spliced, release splice sleeves from upper mullions and allow to fall onto the set screws at the lower mullions. Attach to lower mullions with (2) FS-8 #14 x 1" HH. Refer to "VERTICAL SPLICING" section for sealing instructions.
- 6.8 At SSG mullions, apply sealant to all contact surfaces on vertical and horizontal mullions where zone bridges will be installed. Apply sealant to horizontal tongue receptor on zone bridge and install at the end of each horizontal, head and sill members. Tool any excess sealant around front end of zone bridge where the thermal isolator runs through. Tool sealant in the glazing pockets to ensure a watertight fit. **See FIGURE 20 (page 23).**

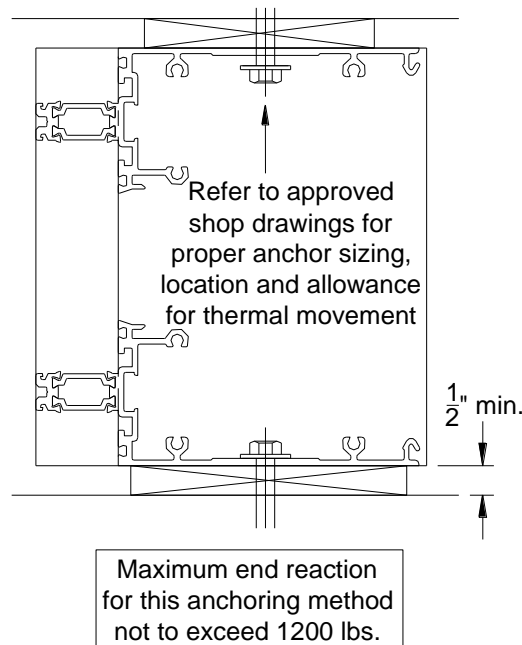


Figure 12: Hard Anchor Method

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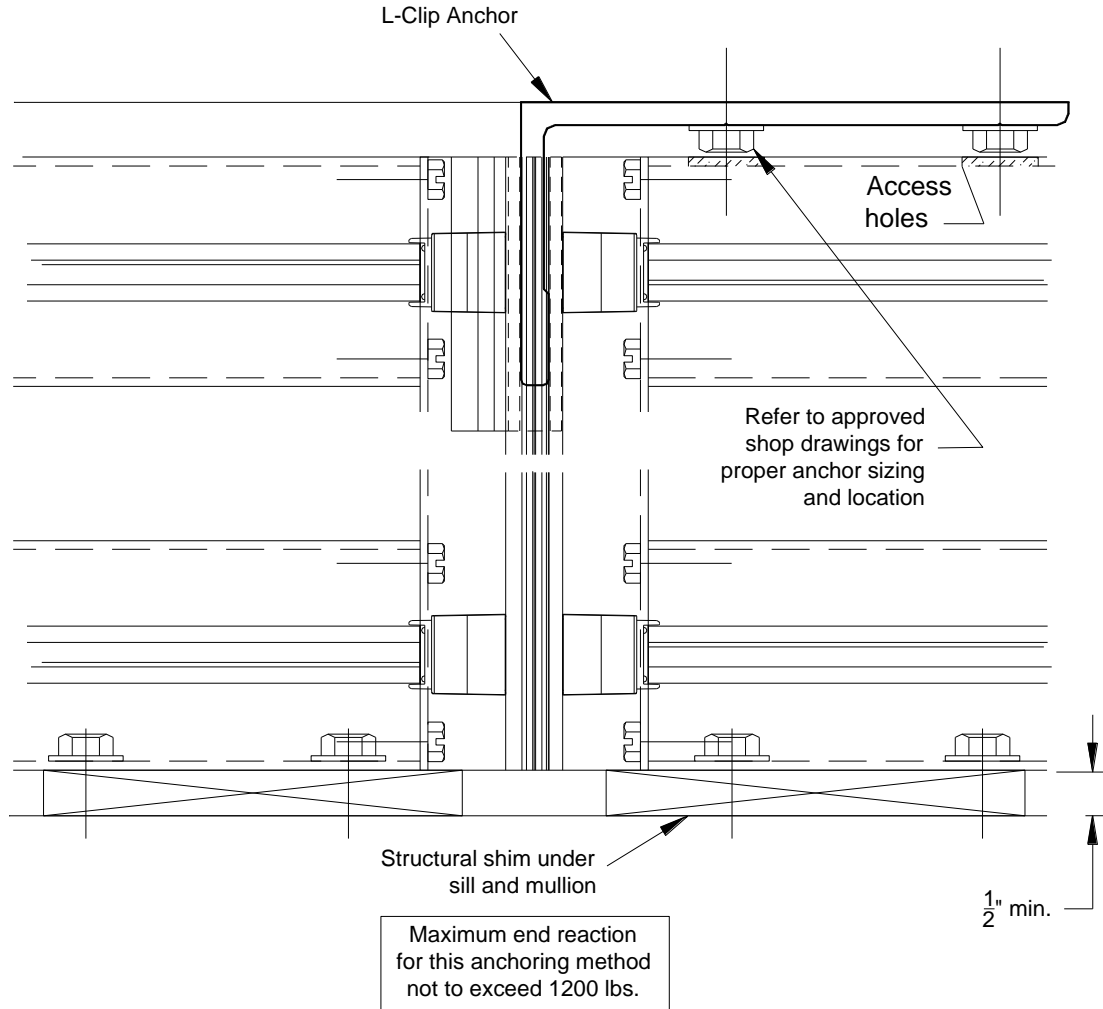


Figure 13: Slide-In Anchor Method

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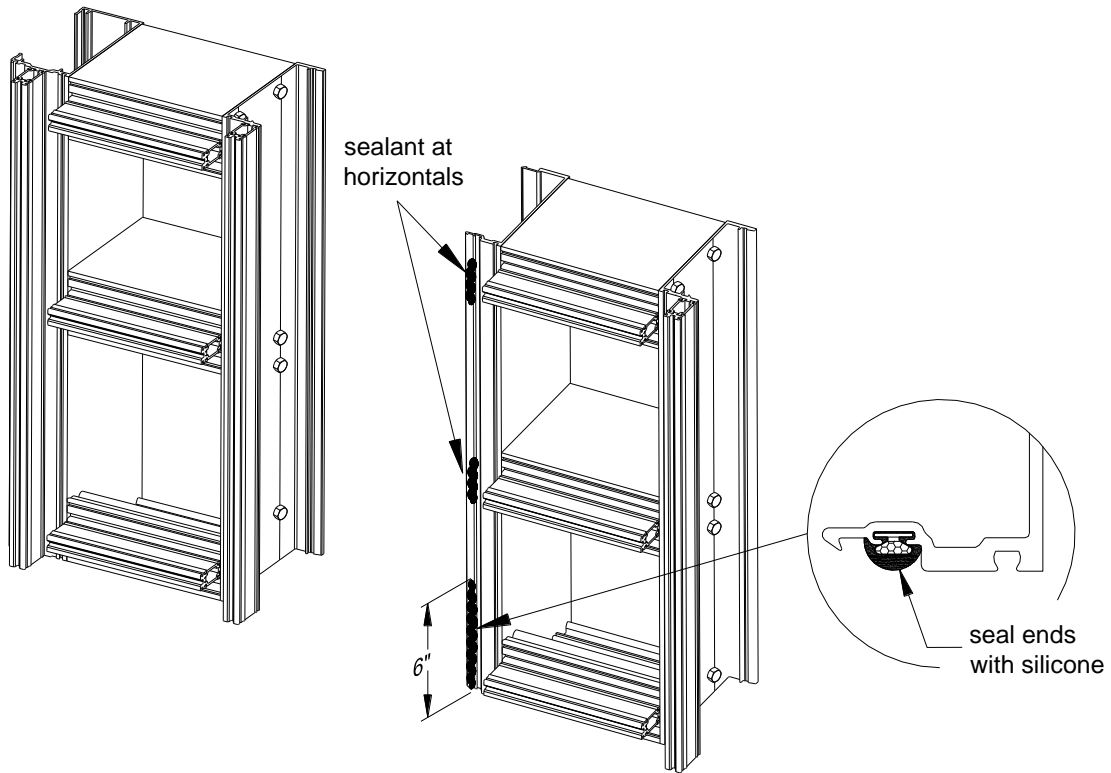


Figure 14: Slide-In Anchor Method

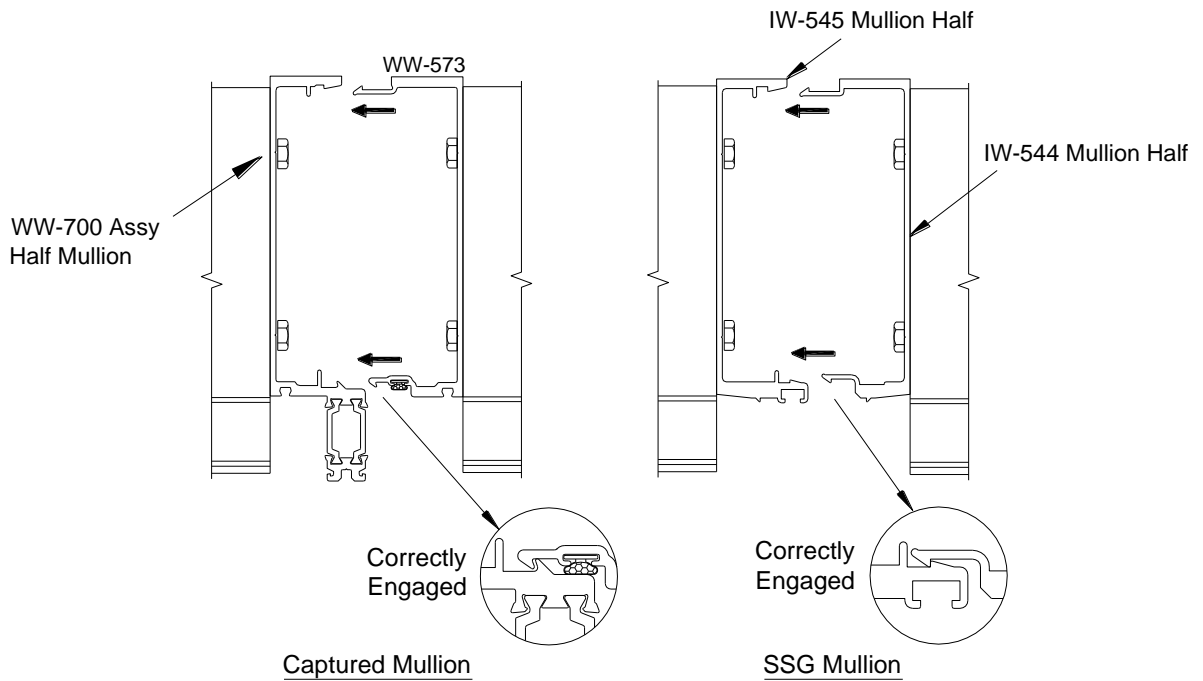


Figure 15: Mullion Engagement

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7.0 Mullion Cap Installation

7.1 Prior to installing mullion caps at top and bottom of all intermediate verticals, clean and seal the end of the mullions & caps thoroughly. Install onto mullion with (2) FS-202 #8 x 1/2" Phillips Pan Head screw. **See FIGURES 16A & 16B.** Tool sealant and cap seal all screws. **THIS IS A CRITICAL SYSTEM SEAL.** Use care when installing mullion end caps to ensure that the bulb gasket seal (STEP 6.3) is married with the end cap seal.

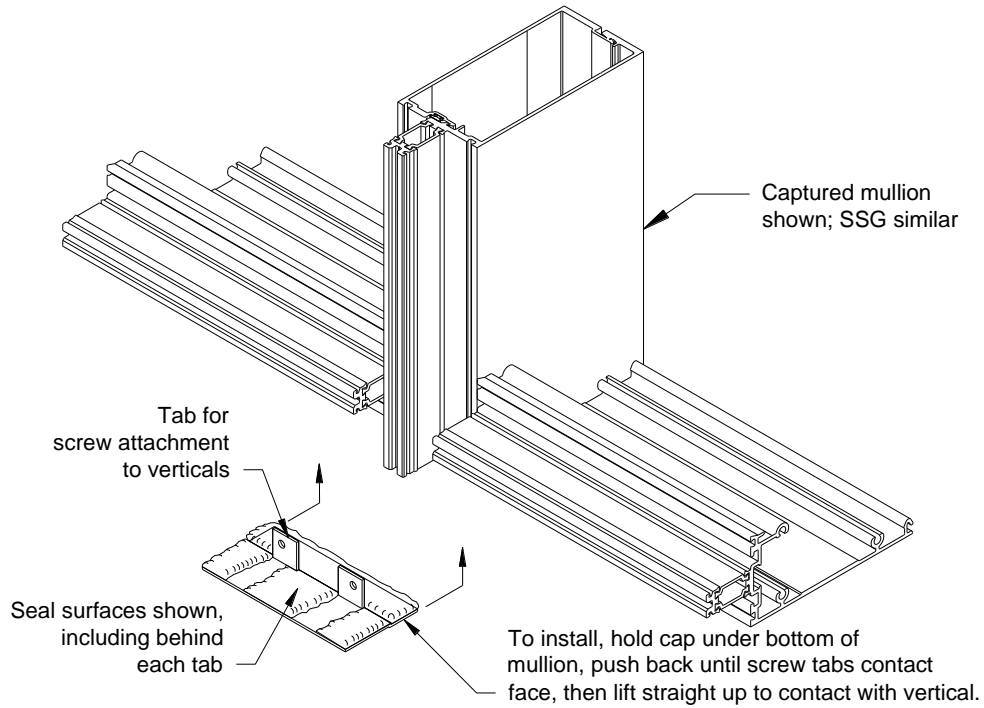


Figure 16A: Mull Cap Installation (Head Similar)

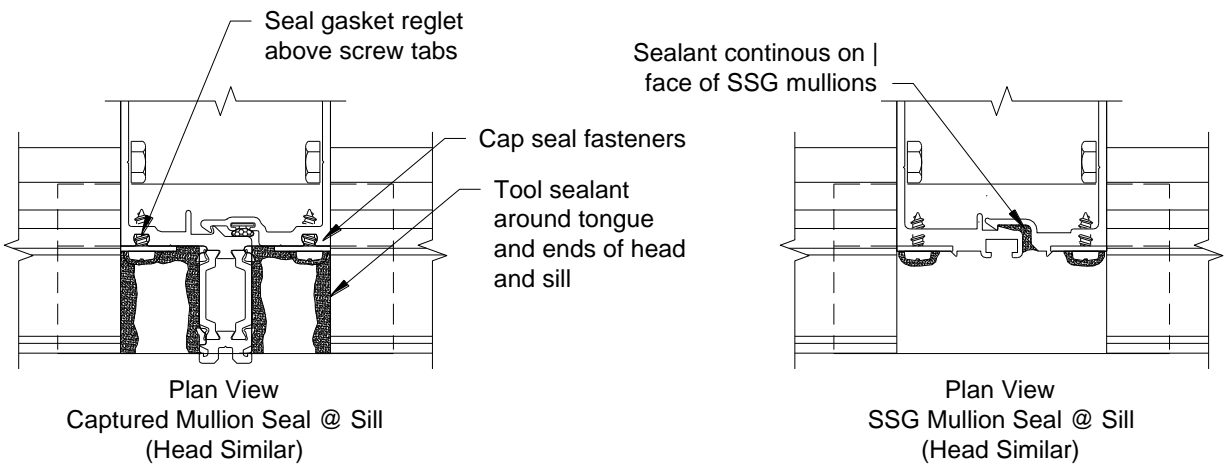


Figure 16B: Mull Caps Install and Sealing (Head Similar)

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8.0 Pocket Filler Attachment & Perimeter Seal

- 8.1 Insert WW-366 Pocket Filler into the jamb gasket reglet and attach with FS-43 every 18" O.C.
- 8.2 Run a continuous line of sealant the full length of WW-366, as shown in **FIGURE 17**.
- 8.3 When all framing members are installed, apply the perimeter seal. **See FIGURE 18**. The interior perimeter seal is not required for system performance but may be required for cosmetic purposes.

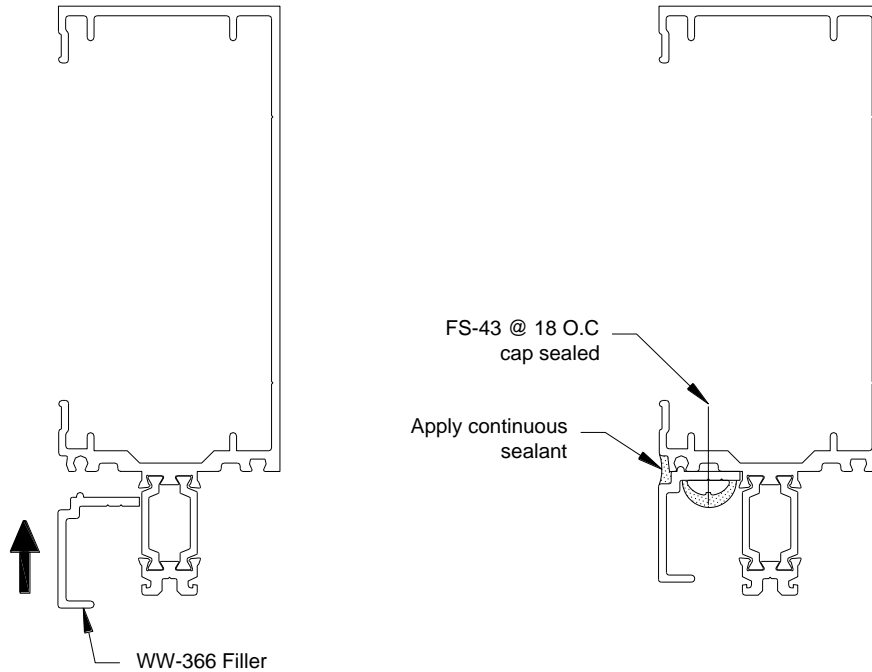


Figure 17: Pocket Filler Attachment at Jamb

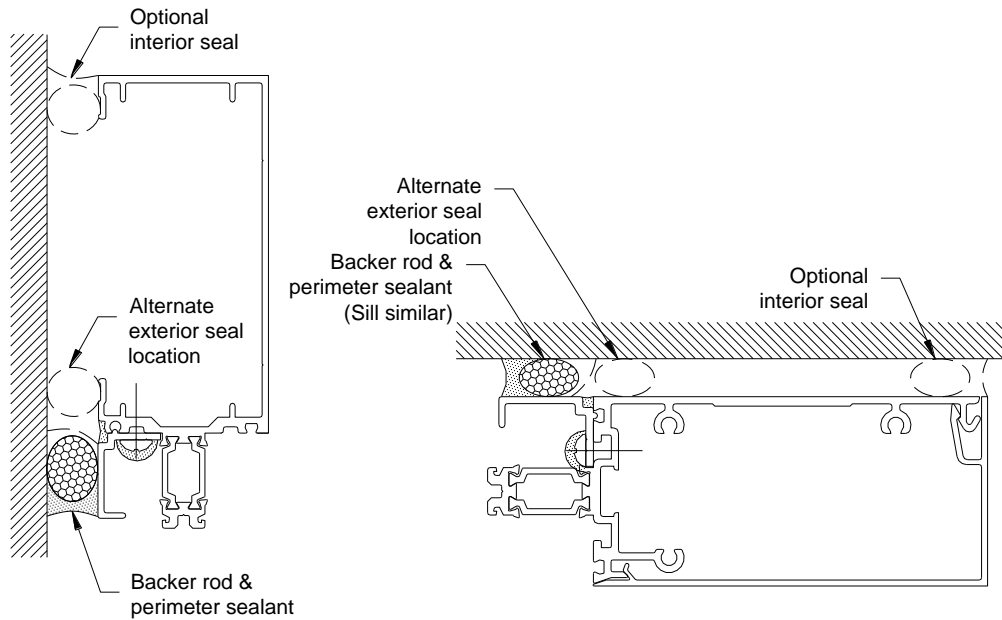


Figure 18: Perimeter Seal

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9.0 Zone Plugs

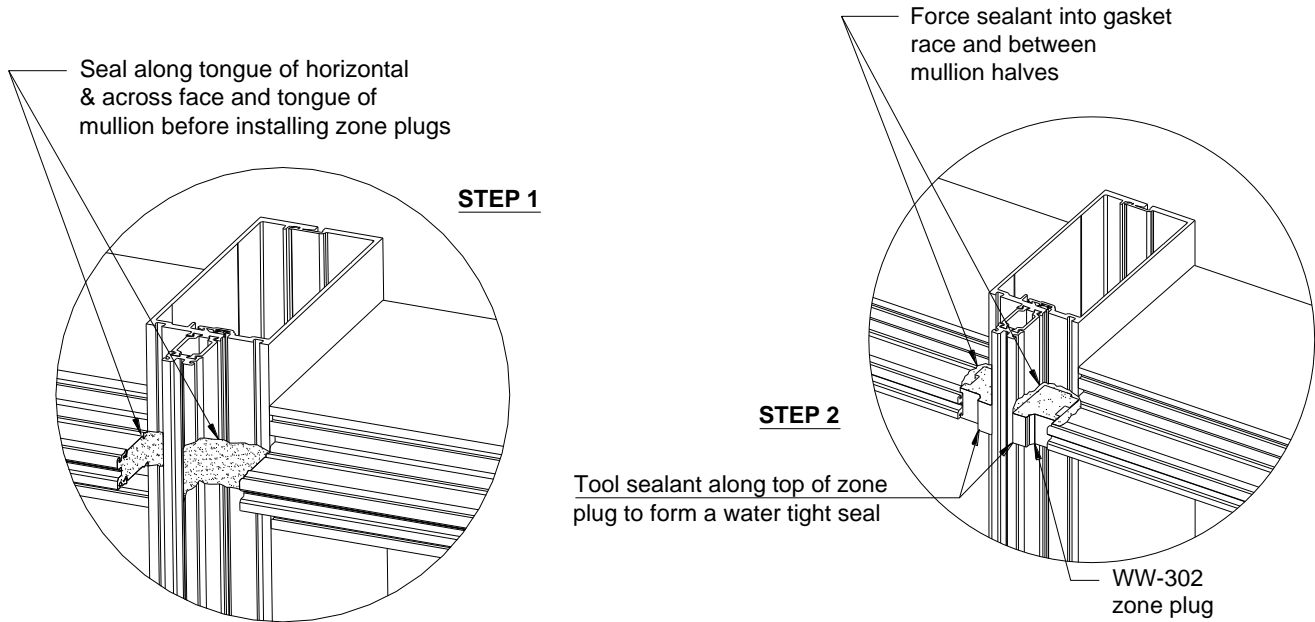


Figure 19: Zone Plug Installation - Captured Mullions

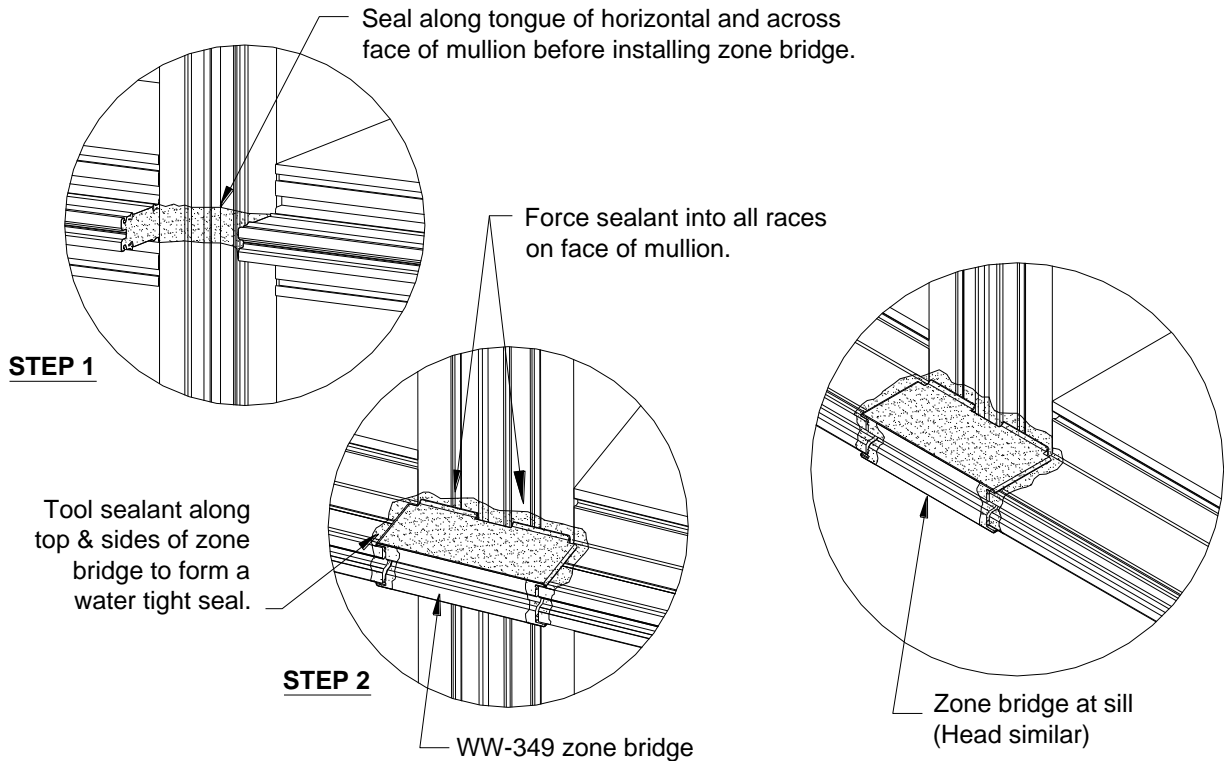


Figure 20: Zone Bridge Installation - SSG Mullions

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GLAZING

10.0 Gasket Installation & Setting Glass

- 10.1 Install face gaskets into all pressure plates. Crowd gaskets into pressure plates to avoid gaps caused by relaxation of gasket material. Gaskets should extend about 1/8" beyond end of pressure plates.
- 10.2 If not done so already, install interior gaskets, running the vertical gaskets through and abutting the horizontal gaskets with a slight bevel. For SSG mullions install GP-102; for SSG horizontals install GP-106 spacer gasket into inner most reglet. **DO NOT SEAL GASKETS UNTIL JUST PRIOR TO SETTING GLASS. See FIGURE 21.**
- 10.3 Install GP-108 thermal isolator into groove on face of mullion tongues. Run through at vertical splice joints. **SEE FIGURE 22.**

NOTE: Mullion splices must be sealed before installing GP-108 isolator.

NOTE: To avoid silicone curing before glass is set in place and contamination from job-site debris, glazing prep work must be done as each opening is glazed. Do not pre-seal the gaskets in the entire frame; seal only the gaskets in the opening for which you are ready to set glass.

- For mullions that are spliced, run interior (frame) gasket through the splice joint. Trim the gasket dart as required to form an airtight seal. If mullion splice seal is cured, set gasket in fresh silicone.
- Crowd gaskets into corners, cutting horizontal gaskets at a slight angle to conform to the bevel on vertical gaskets.
- Pulling the horizontal gasket back at the ends, seal joint at gasket corners **JUST PRIOR TO GLAZING THE OPENING**. Release the gasket back to its original position, making sure sealant fills the entire joint.
- Tool corner joints after glass is set and temporary glazing retainers are in place.

NOTE: Sealant is not required at the horizontal gasket abutting and SSG mullion. This gap will be sealed during application of the structural silicone.

- 10.4 Position setting blocks at correct locations (two per lite). Refer to approved shop drawings or deadload charts. **NOTE:** Consult glass manufacturer for correct setting block location and length for glass sizes in excess of 40 sq.ft.
- 10.5 Set glass in opening. Ensure that glass bite is equal on all sides. **CAUTION:** Be certain that glass is placed firmly against interior gasket to ensure a proper seal and to avoid binding the glass on the setting block.
- 10.6 Temporarily hold glass in the opening with WW-162-01 or WW-333-01 temporary glazing retainers and FS-325 screws. Torque screws to 60 in-lbs. **NOTE:** Use the SPW-PP-3 retainer for SSG verticals. **See FIGURES 23.**
 - WW-162-01 or WW-333-01 temporary glazing retainers must be applied at each glass edge 3" from the corner of the glass. Glass edges greater than 4' in length but less than 8' require an additional retainer at the glass mid-span. **See FIGURES 23 & 24.**
 - Retainers are intended for short term use only. Additional retainers may be required to withstand full design wind load pressures.
 - Full length pressure plates must be installed if severe weather or high wind loads are anticipated.

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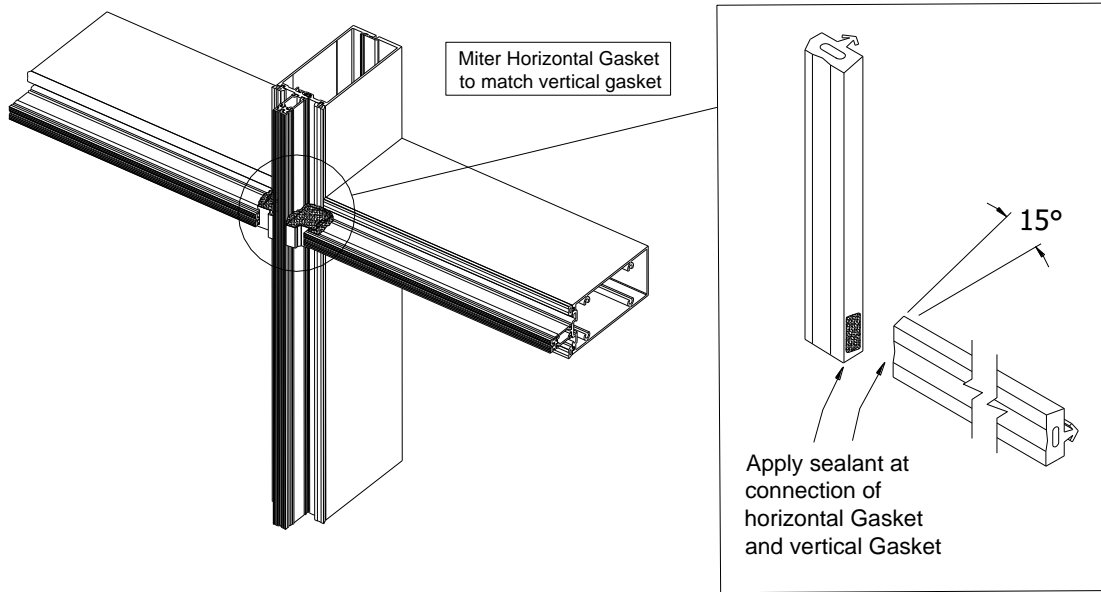


Figure 21: Interior Gaskets Install to Verticals and Horizontals

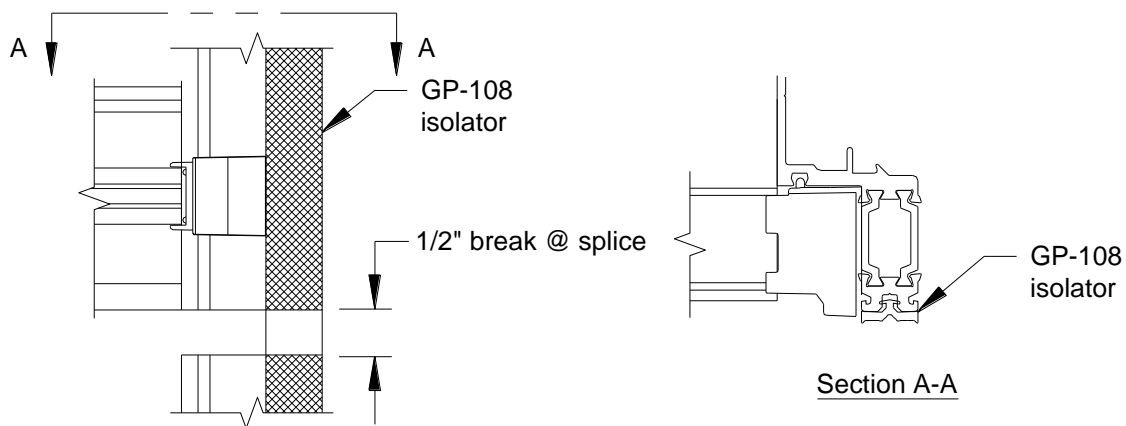


Figure 22: Isolator at Bottom of Each Vertical

- 10.7 If required, install GP-111 (1" glass) side blocks with silicone at centerline of each lite, along vertical edges, or per approved shop drawings. For framing that will be subjected to seismic events, consult glass manufacturer for preferred location. NOTE: Side blocks are not required at SSG mullions.
- 10.8 Repeat steps 10.4 through 10.7 until all glass is set, working row by row up the elevation.
- 10.9 Just prior to installing vertical pressure plates, apply sealant to face of each horizontal zone plug. **See FIGURE 27.** Vertical pressure plates must be installed before horizontal pressure plates are applied. Pressure plate screws must be located 1 1/2" from horizontal & vertical

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mullion intersections in order to maintain proper compression on the glass. Drill additional 7/32" holes in pressure plates as required.

- 10.10 After removing vertical temporary retainers, install vertical aluminum pressure plates with FS-325 screws, holding the pressure plates back 1/8" from the ends of the vertical mullion. **DO NOT OVERTORQUE, See FIGURE 28 (page 29).**
- 10.11 After removing horizontal temporary retainers, center horizontal pressure plates in opening, leaving 1/8" gap on each end. Make sure that weep holes are on the top side of the pressure plate. Install using FS-325 screws. **DO NOT OVER TORQUE.**

NOTE: Horizontal pressure plates and face covers run continuous over SSG mullions, not to exceed 3 lites in length. **See FIGURE 27** for splicing and sealing instructions.

- 10.12 After all pressure plates are installed on the frame, torque the FS-325 screws to 90 in-lbs. The use of either a drill motor with a torque limiter or torque wrench can be used. If using a cordless drill, check torque periodically since battery usage may affect the torque setting.
- 10.13 Install vertical face covers. Using a wood block to protect the cover, apply with a dead blow soft face hammer. Pin the vertical face covers once per length as required, concealing pin at a horizontal location.
- 10.14 Seal horizontal pressure plates against the vertical face covers. Tool sealant into the joint. **See FIGURE 28 (page 29).**
- 10.15 Install horizontal face covers, leaving an equal gap at each end. Make sure the weep hole in the face cover is facing down.

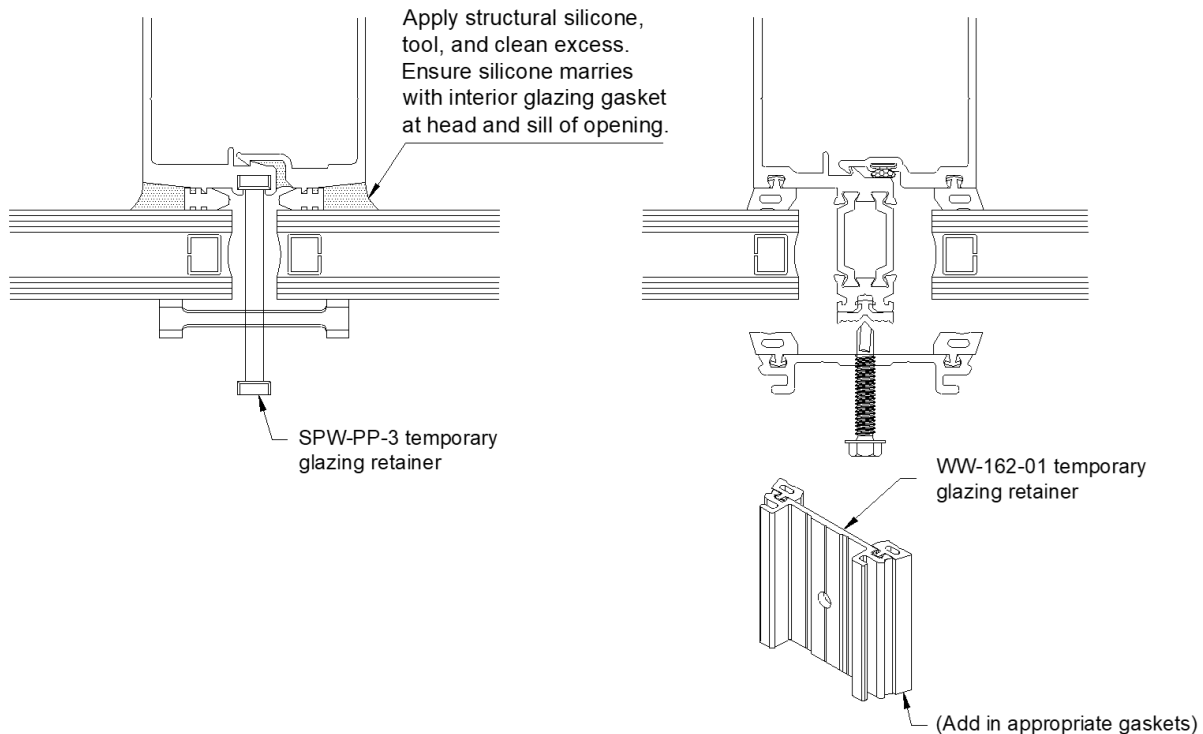


Figure 23: Temporary Retainers SSG & Captures Mullions

! SAFETY NOTE: Temporary retainers are not intended to meet safety glazing fall out requirements!

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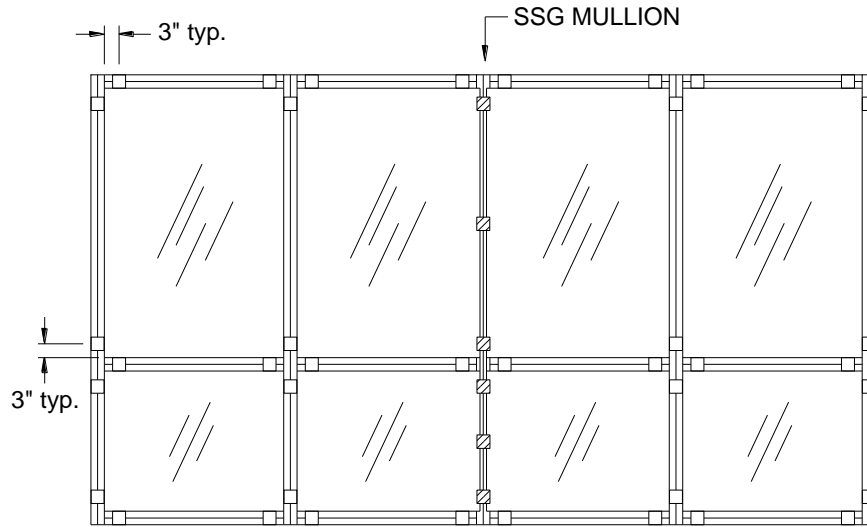


Figure 24: Typical Location of Temporary Glazing Retainers

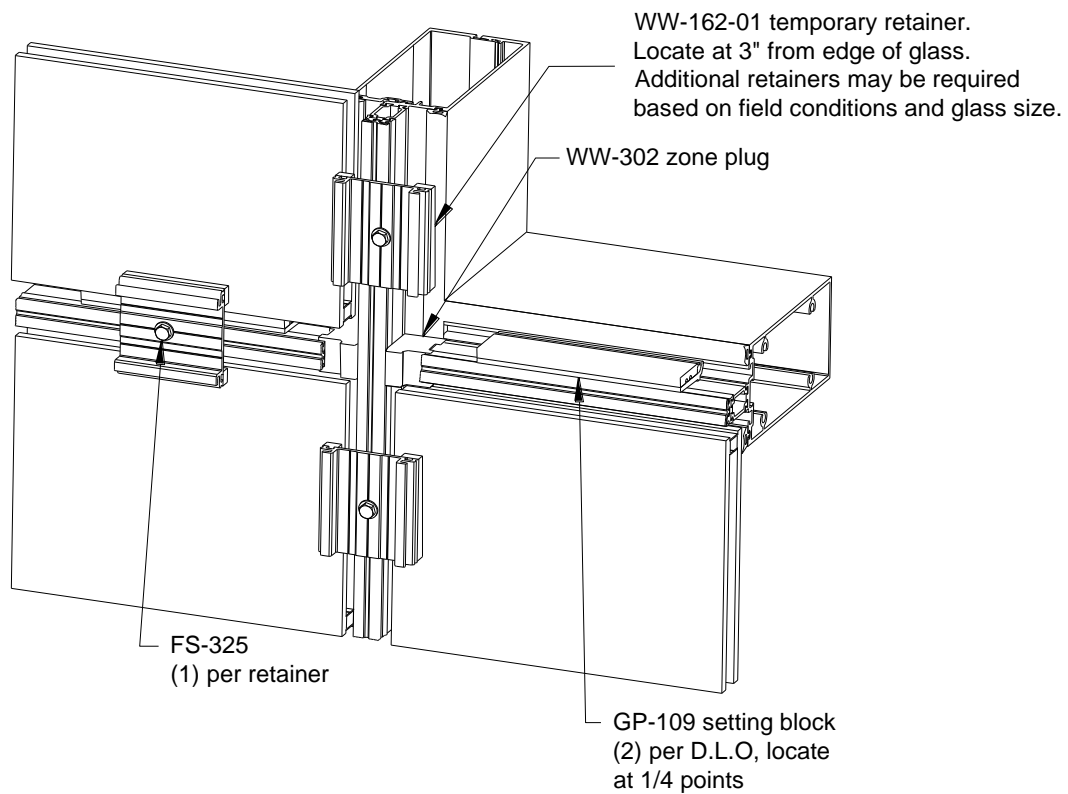


Figure 25: Temporary Glazing Instructions

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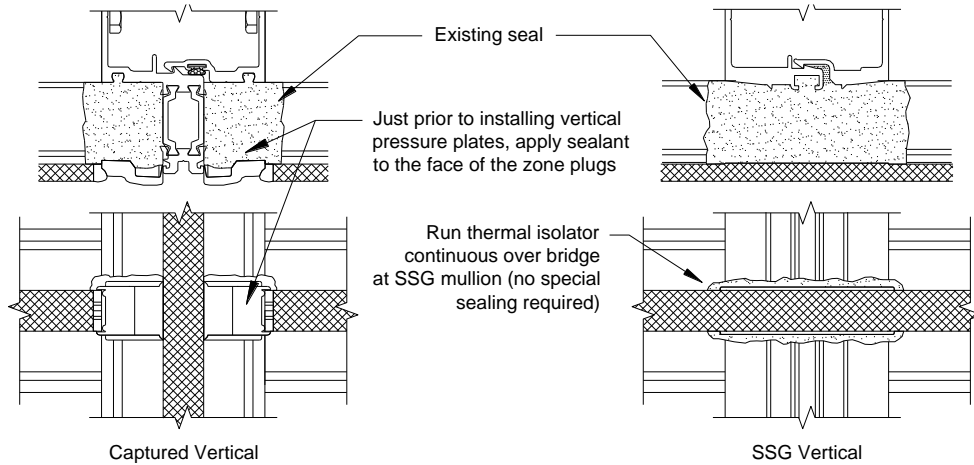


Figure 26: Sealing for Pressure Plates

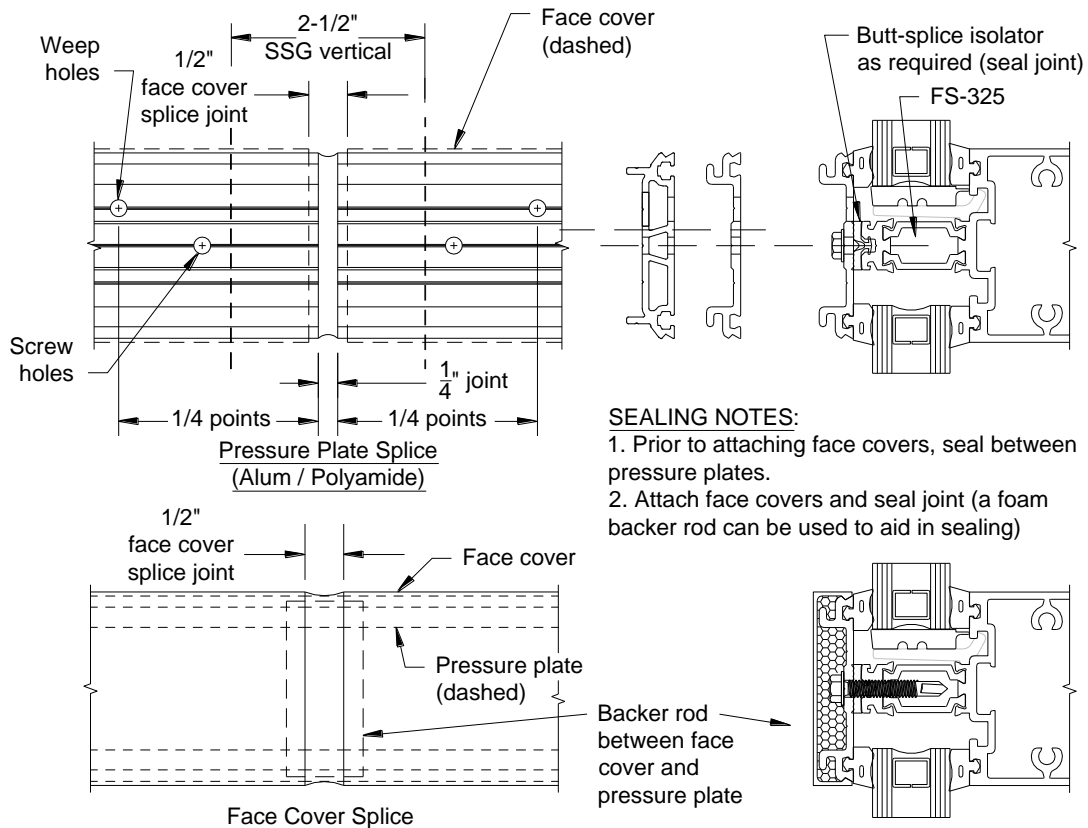


Figure 27: Pressure Plate/Face Cover Splicing & Sealing at SSG Mullions (Intermediate Horizontal Shown; Head & Sill Similar)

Glazing Notes:

1. GP-103 dense EPDM gasket used on interior and exterior of system.
2. Remove gaskets from reels and allow to relax overnight before installing.
3. Cut gaskets to allow minimum 1/4" per foot for any relaxation of gasket that may occur after installation.

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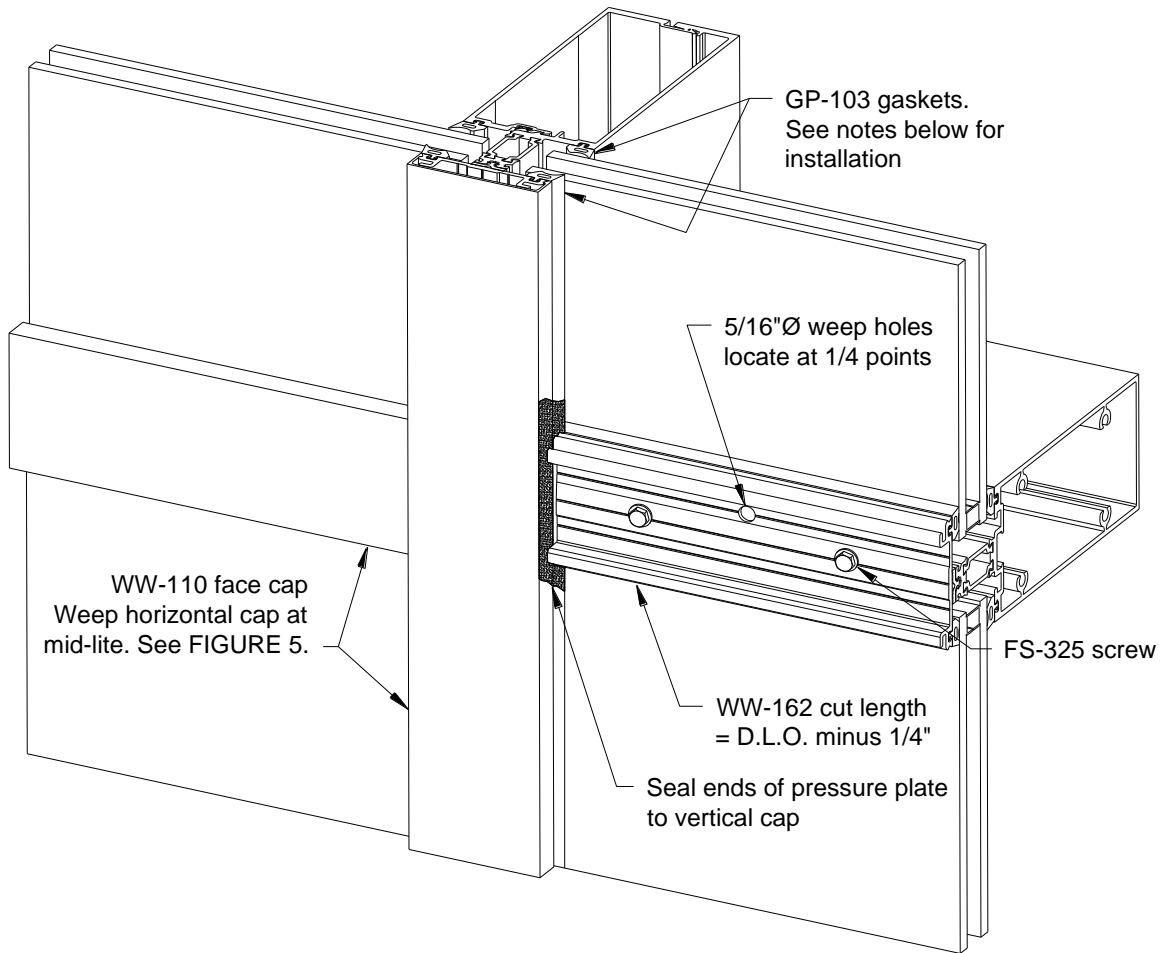


Figure 28: Sealing Horizontal Pressure Plates

11.0 Face Covers

Vertical Covers:

The use of safety fasteners to mechanically fasten exterior face covers is required for all vertical covers which run through at the head and sill, and all covers, both vertical and horizontal with a depth greater than 3/4". Spacing of the safety fastener is dependent on cover depth, wind load, and snow and ice load conditions. For a standard depth vertical cover up to 14'-0" in length, a single fastener on one side of the cover should be sufficient. Location of the fastener in the center of the length is preferable, but not absolute. For aesthetics, it may be desirable to locate the fastener at a horizontal, so fastener is concealed underneath the horizontal face cover. For vertical covers which are 4" or greater in depth, two fasteners, one on each side of the cover, opposing each other, are required. Again, location of the fasteners in the center of the length is preferred but not absolute. For vertical covers which are 8" or greater in depth, multiple fasteners, placed on each side of the cover opposing each other, may be required. Harmonics caused by wind vibration must be considered, as well as lateral wind load on the cover itself, wind load deflection of the mullion and cover, and snow and ice load.

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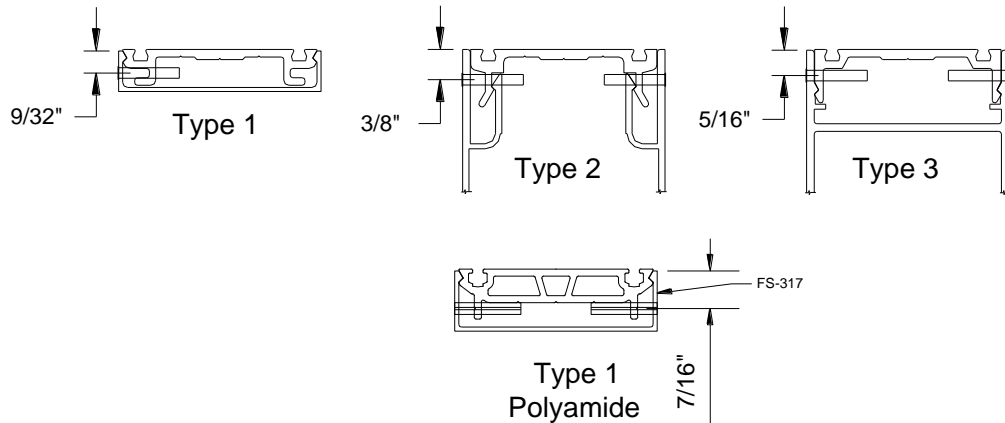


Figure 29: Face Cover Fabrication at Vertical

Horizontal Covers:

For a horizontal cover up to 8'-0" in length and up to 4" deep, a single fastener located at the center of the length on the top side of the cover should be sufficient. Location of the horizontal fasteners on the top side is the best practice. For horizontal covers greater than 8'-0" or deeper than 4", multiple fasteners may be required. Harmonics caused by wind vibration must be considered, as well as wind load deflection of the horizontal and cover, and snow and ice load.

See FIGURE 24 below for three common pressure plate and face cap installations, other custom profiles may be used and attached following this method. Type 1 may be used up to 4" in depth. Type 2 and 3 are for caps 4" or greater, with type 3 being preferred for any cap or cap assembly greater than 8". All caps shown below will be attached using a (FS-317) 1/8" x 3/4" S.S. Headed Roll Pin. Drill cap with a 1/8" (.125") clearance hole.

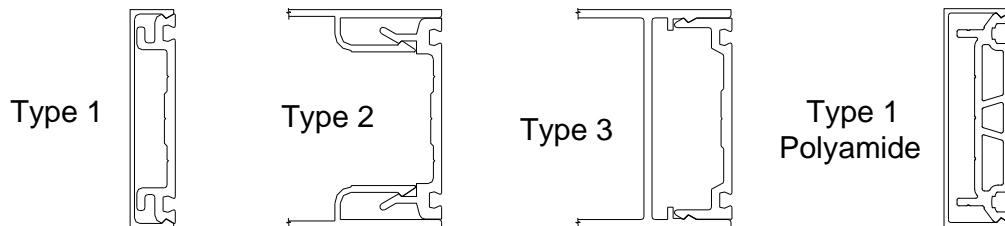


Figure 30: Face Cover Fabrication at Horizontal

12.0 Standard Vertical Splice

Note: Follow sealant manufacturer's guidelines for proper joint width based on anticipated movement. A minimum 1/2" joint is recommended. Standard splice joints are engineered to accommodate thermal expansion only. They do not allow for movement in floor levels. Refer to approved shop drawings for special circumstances or contact your nearest Oldcastle BuildingEnvelope® facility.

- 12.1 Drill (2) 9/32" dia. holes in lower mullion for splice attachment and one 7/32" hole in lower mullion stop screw, **see FIGURE 31.**
- 12.2 Apply bond breaker tape to the face of splice sleeves, returning back on the sides 1" minimum. Insert backer rod into the hollow at the top of the lower vertical mullion, sealing this void. Seal between top and bottom mullions from the front of the tongue to 1" behind the glass pocket.

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Follow the contour of the glazing reglets with the sealant to ensure a good seal when gaskets are installed. **See FIGURE 32.**

12.3 Offset pressure plates and face covers, sealing pressure plate and face cover joints as shown in **FIGURE 33.**

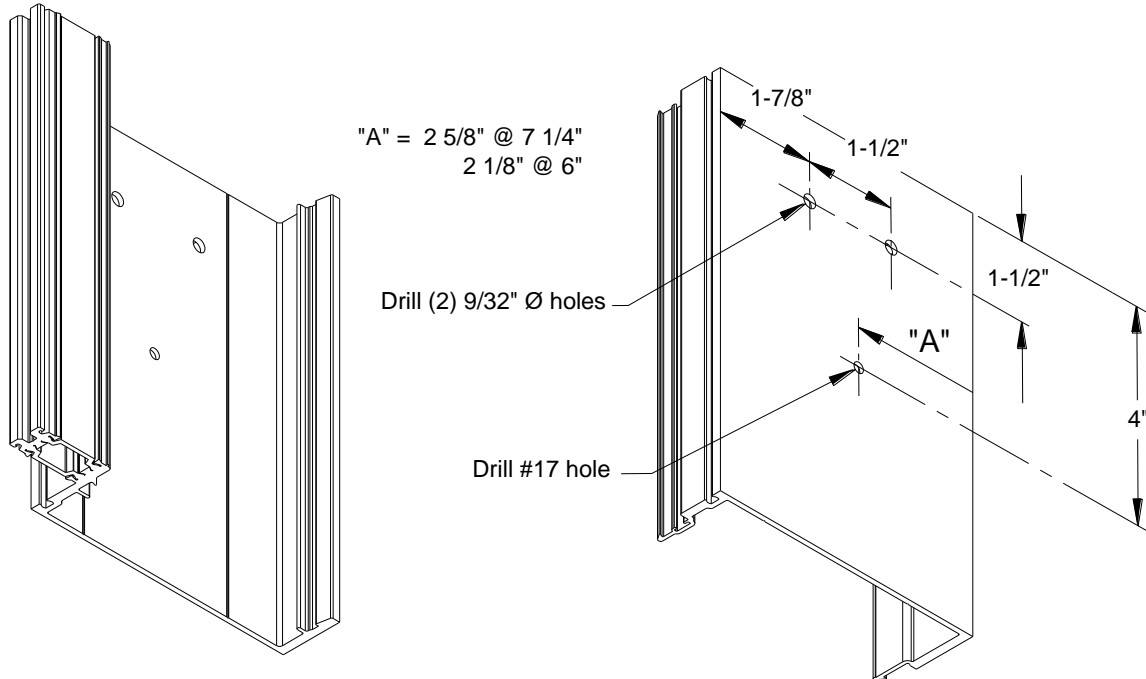


Figure 31: Vertical Mullion Fabrication

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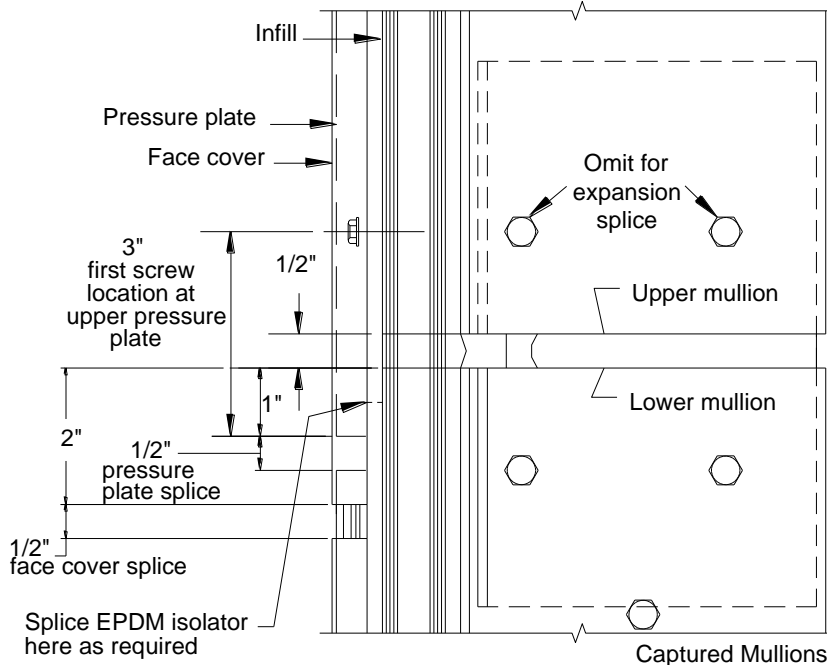
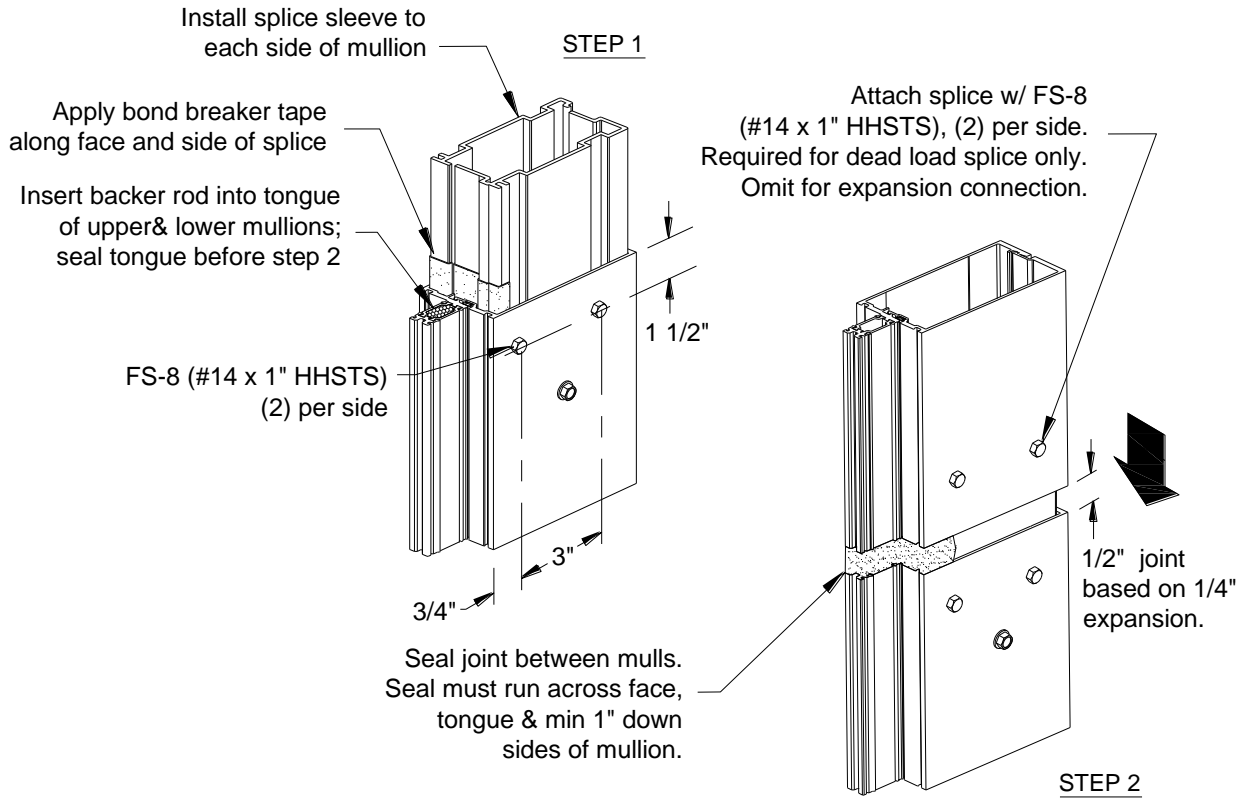


Figure 32: Standard Vertical Splice Joint

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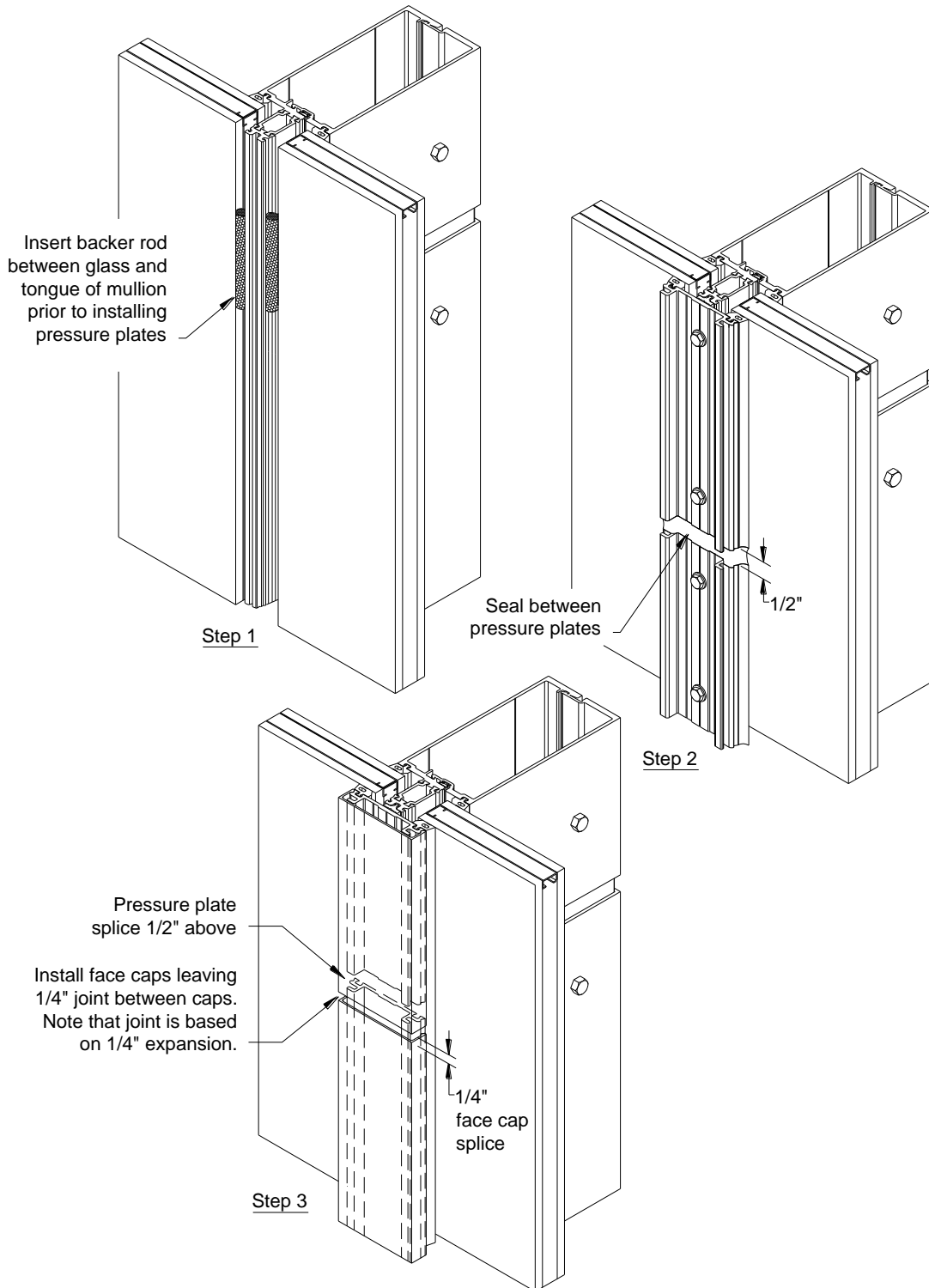


Figure 33: Splice Joint Sealing Instructions

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REGLAZING

13.0 Reglazing Procedure

- 13.1 Reglazing must be done from the exterior. Carefully remove face covers surrounding the lite of glass to be deglazed. **See FIGURE 34.**

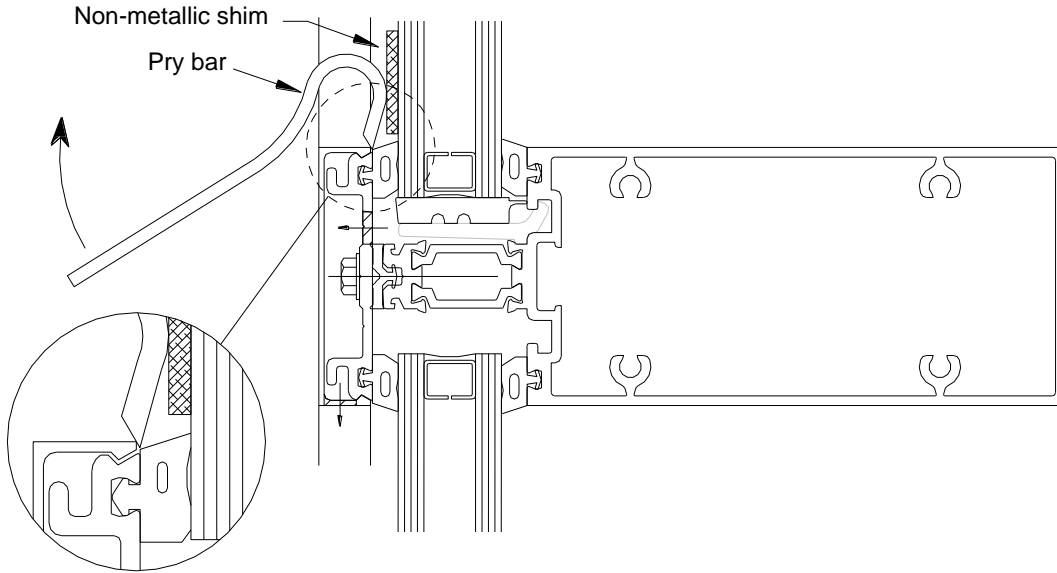


Figure 34: Deglazing

- 13.2 Remove vertical and horizontal Pressure Plates adjacent to lite that must be replaced. Temporarily clip surrounding glass in place with **WW-162-01** or **WW-333-01** temporary glazing retainers. Torque to **50 in-lbs**. Refer to steps 10.4 to 10.7 for instructions on locating the retainers.
- 13.3 Remove lite of glass and existing Gaskets from opening. Clean debris and sealant from aluminum framing members and Pressure Plates.
- 13.4 Install new gaskets into framing and install new lite of glass.

REINFORCEMENT

14.0 Mullion Reinforcement

NOTE: Refer to wind load charts in the detail catalog for single span and equal twin span conditions. For all other conditions such as unequal twin spans, knee brace, and multi-span conditions, contact your local Oldcastle BuildingEnvelope® facility for mullion reinforcing requirements or consult a qualified professional engineer. Refer to approved shop drawings for placement, size, and quantity of reinforcing required and means of attachment.

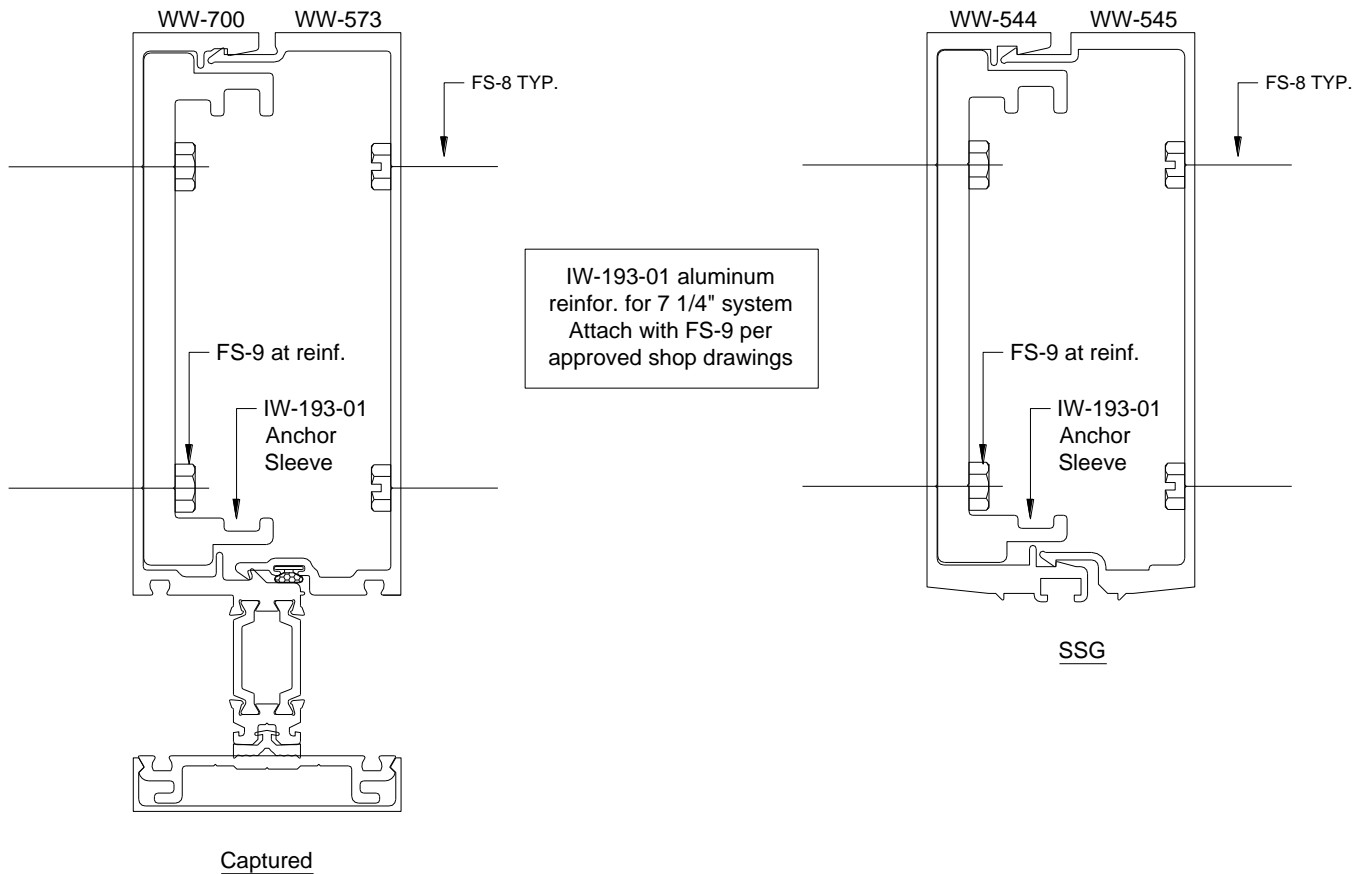


Figure 35: Typical Aluminum Reinforcement Attachment

General Notes:

1. IW-183-01 & IW-193-01 aluminum reinforcement may be used continuously without steel depending on structural requirements.
2. In all cases where either the continuous IW-183-01 or IW-193-01 is used, FS-9 frame assembly fasteners will be applied through the reinforcement sleeve anchor. **See FIGURE 35.**
3. In cases where steel attached directly to side wall of mullion, assemble frame through steel with FS-8 fasteners. **See FIGURE 36.**
4. See manual for attachment location and procedure.

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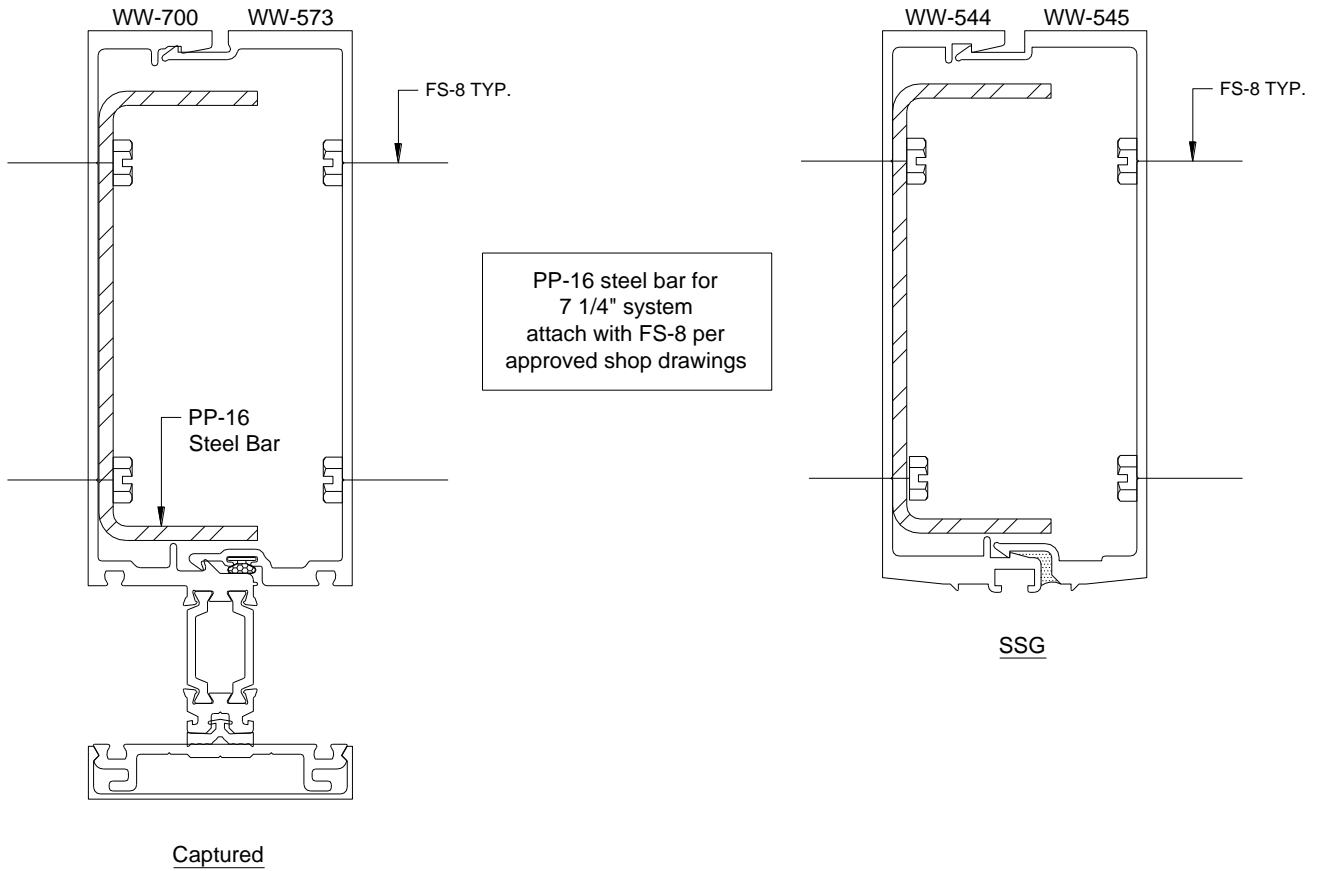


Figure 36: Typical Steel Reinforcement Attachment

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CORNERS

15.0 Captured OS 90° & 135° Corner Assemblies

NOTE: Fabricate and assemble as shown below. **FIGURE 37** shows the basic layout of the standard one-piece Corner Mullion assembly. This detail is for general reference and does not necessarily reflect all conditions. For specific assembly, sealing and anchoring notes, refer to approved shop drawings.

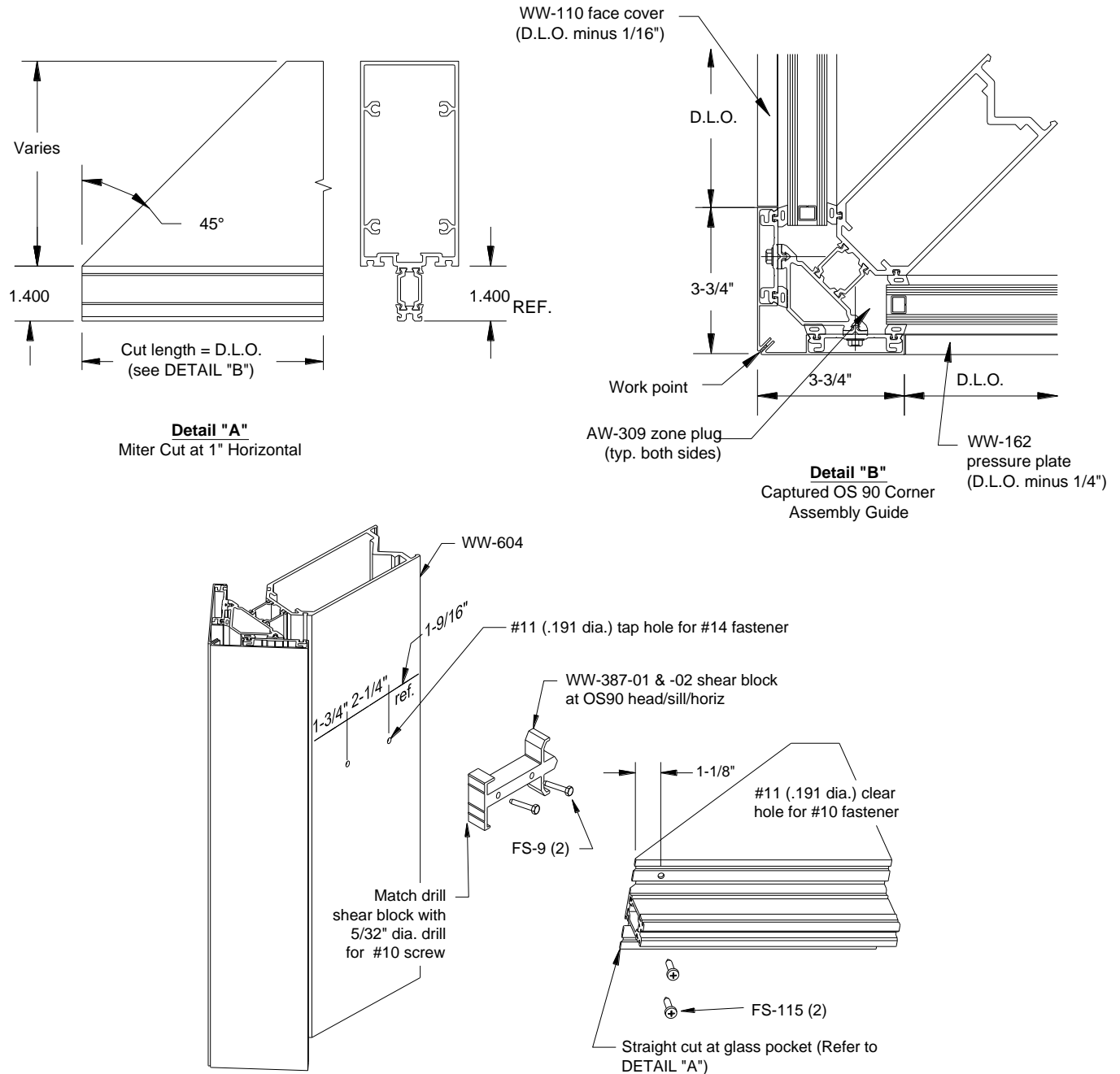


Figure 37: Captured OS 90° Corner Assembly

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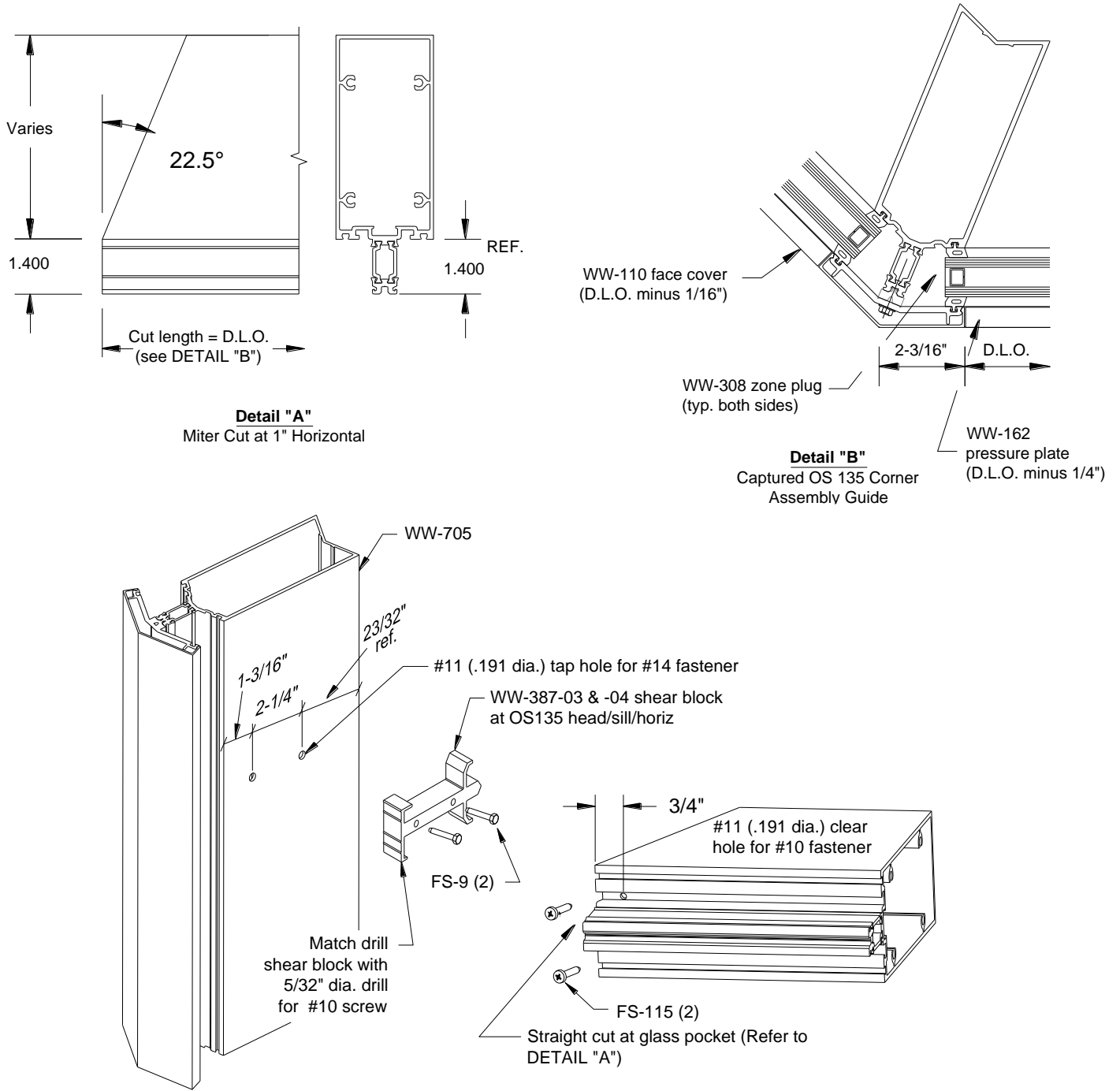


Figure 38: Captured OS 135° Corner Assembly

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16.0 Captured IS 90° & 135° Corner Assemblies

NOTE: Fabricate and assemble as shown below. **FIGURE 39** shows the basic layout of the standard one-piece Corner Mullion assembly. This detail is for general reference and does not necessarily reflect all conditions. For specific assembly, sealing and anchoring notes, refer to approved shop drawings.

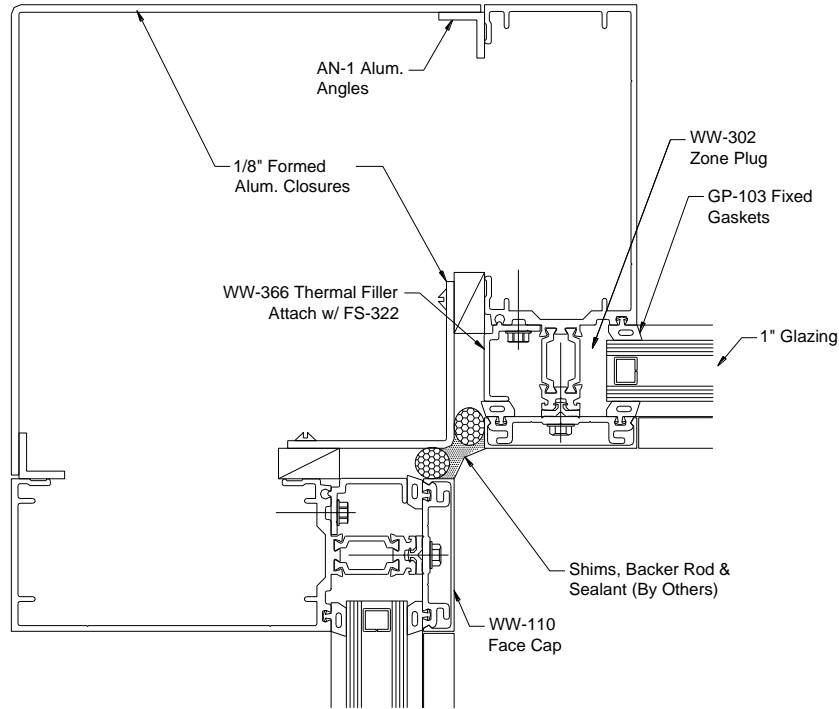


Figure 39: Captured IS 90° Corner Assembly

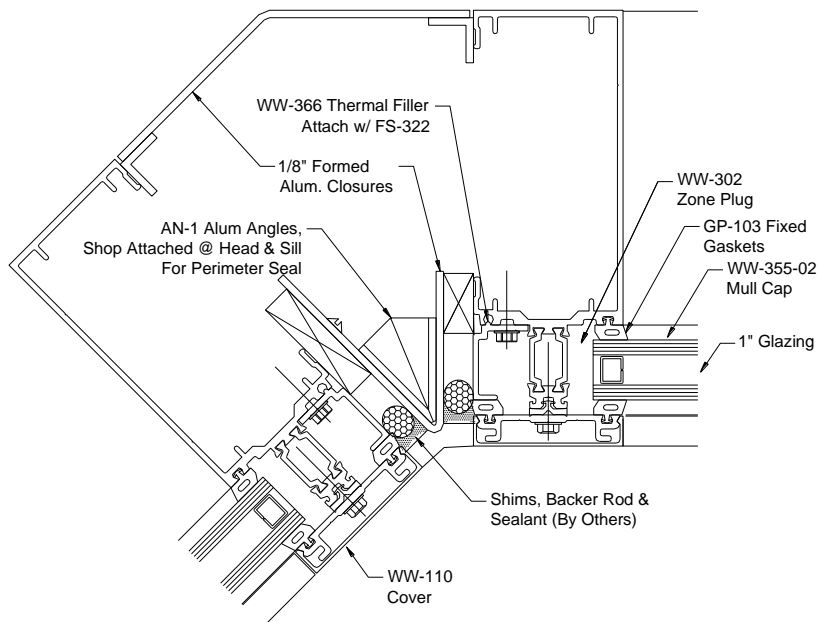


Figure 40: Captured IS 135° Corner Assembly

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DOOR FRAMING

17.0 ENTRANCES

NOTE: Fabricate and assemble as shown in **FIGURES 40 & 41**. Refer to SECTION 8 for the fabrication and installation of the WW-366 Pocket Filler.

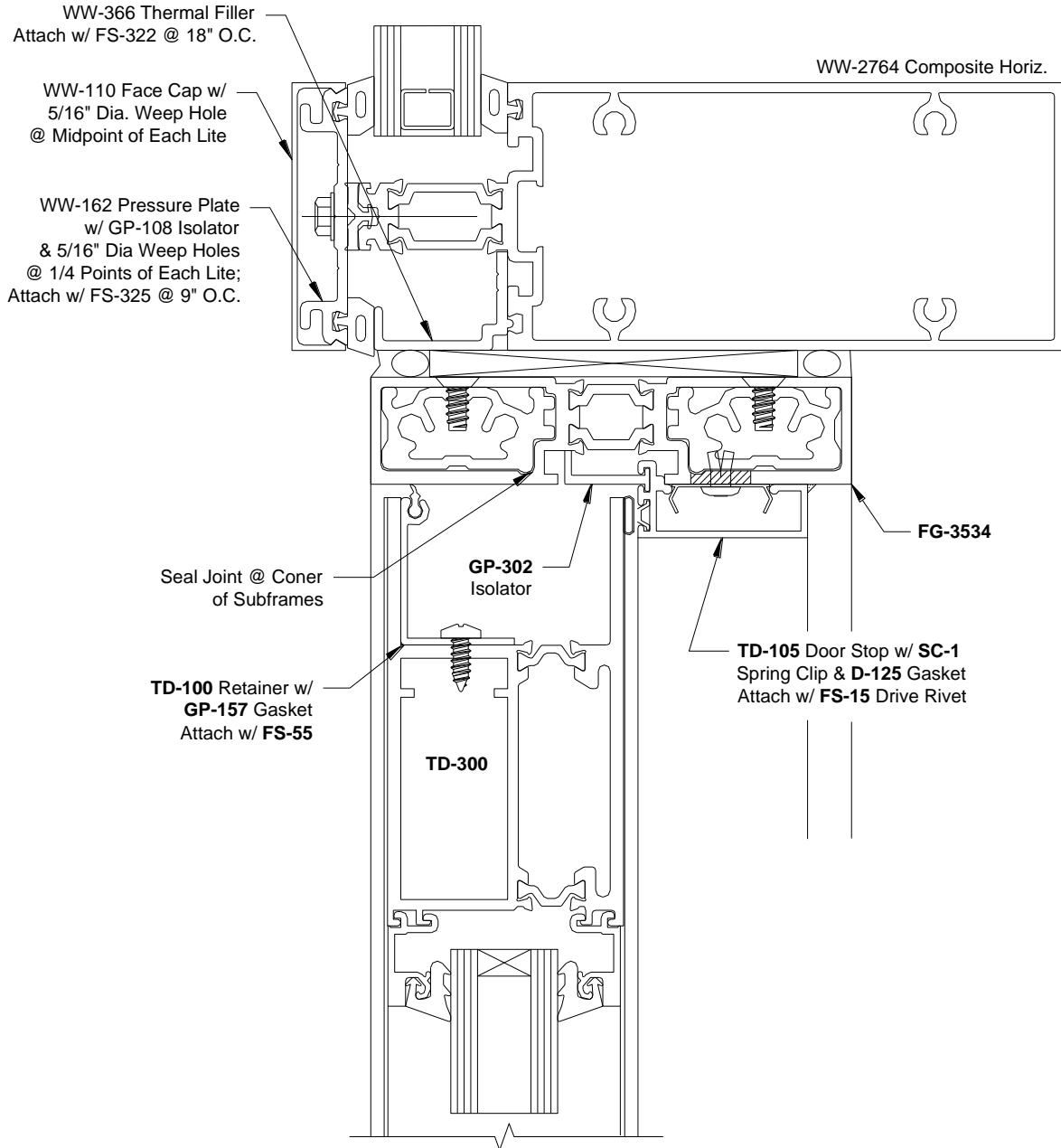


Figure 41: Attaching Subframes

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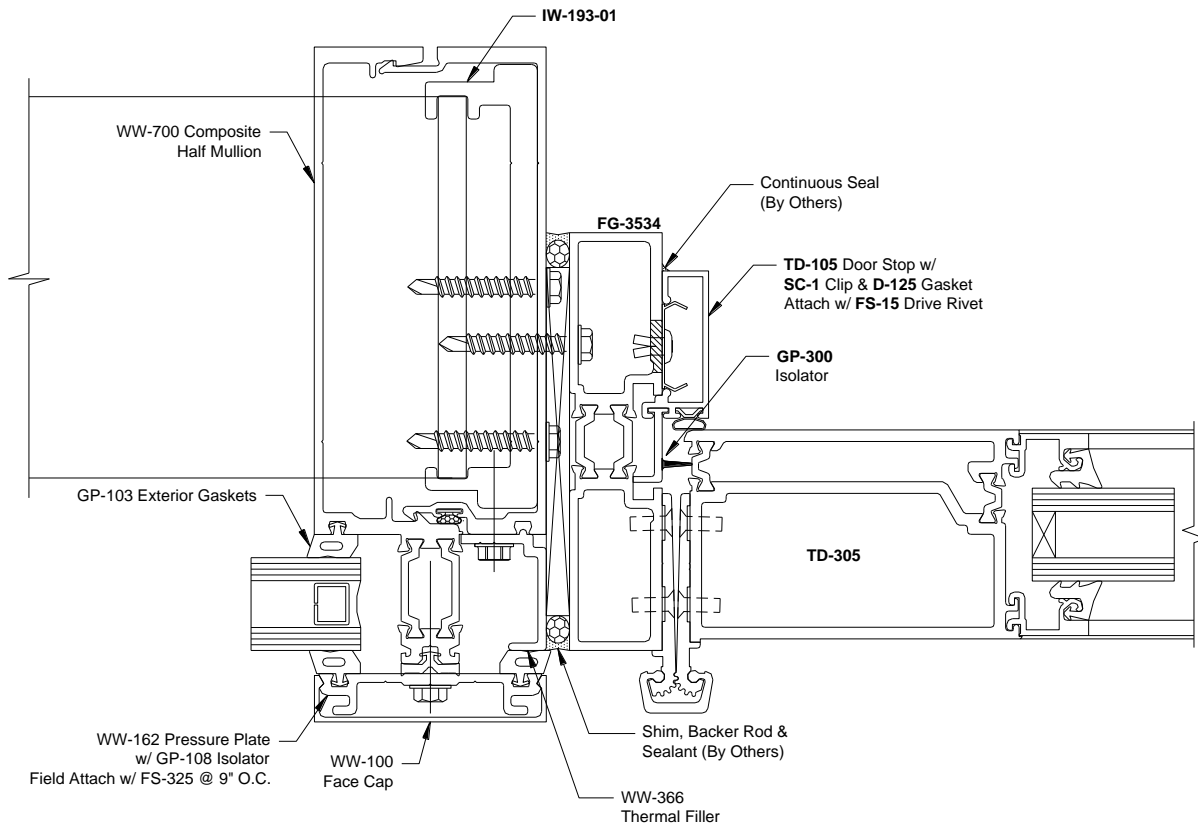


Figure 42: Attaching Subframes

SSG HORIZONTAL INSTALL

18.0 Fabrication and Assembly

! NOTE: SSG horizontals to be used with captured verticals only. Not for 4-sided SSG

- 18.1 Drill a 5/16" diameter weep hole on the V-groove on each side of vertical pressure plate as shown on **FIGURE 43**.
- 18.2 At each end of the SSG horizontal, drill #11 (.191 DIA.) clear hole for a #10 fastener and countersink (.375 dia) as shown on **FIGURE 44**. (2) at each end of member.
- 18.3 Place zone plug, set in sealant as shown on **FIGURES 45 & 46**.
- 18.4 Install GP-106 spacer gasket onto face of SSG horizontal as shown on **FIGURE 47**.
- 18.5 Drill #20 (.161) holes as shown on **FIGURE 48** before the glass is installed. After the glass is set, attach temporary clips WW-333-01 using a FS-102 fastener.
- 18.6 Thoroughly clean the affected areas and seal the exterior face with backer rod and approved silicone sealant, **see FIGURE 49**.

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RELIANCE™ - TC SS Curtain Wall Outside Glazed

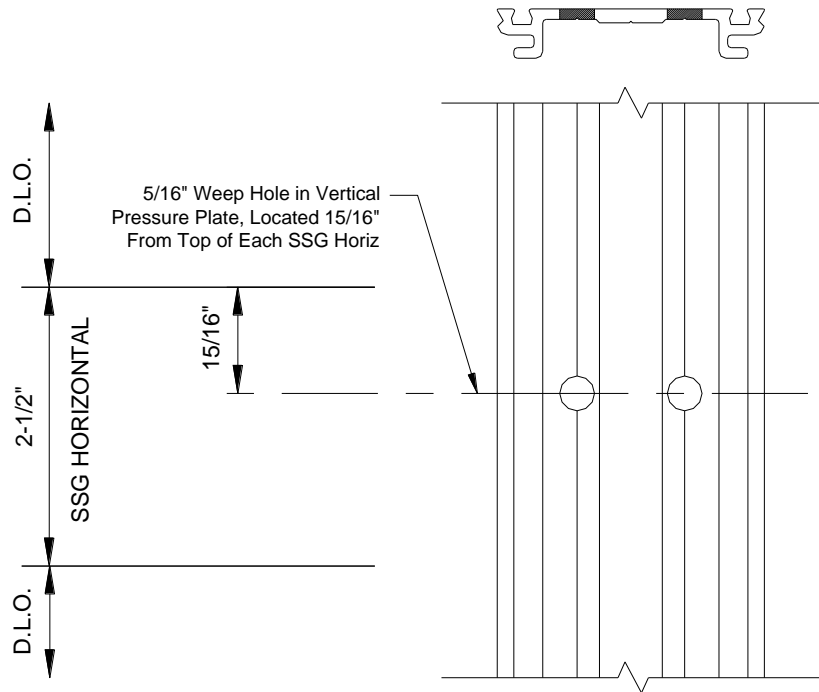


Figure 43: Vertical Weep Holes

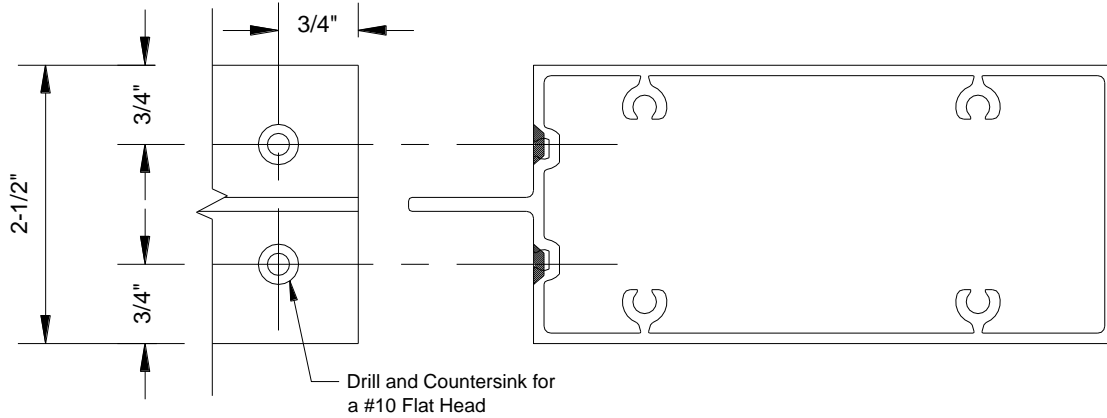


Figure 44: SSG Horizontal Fabrication

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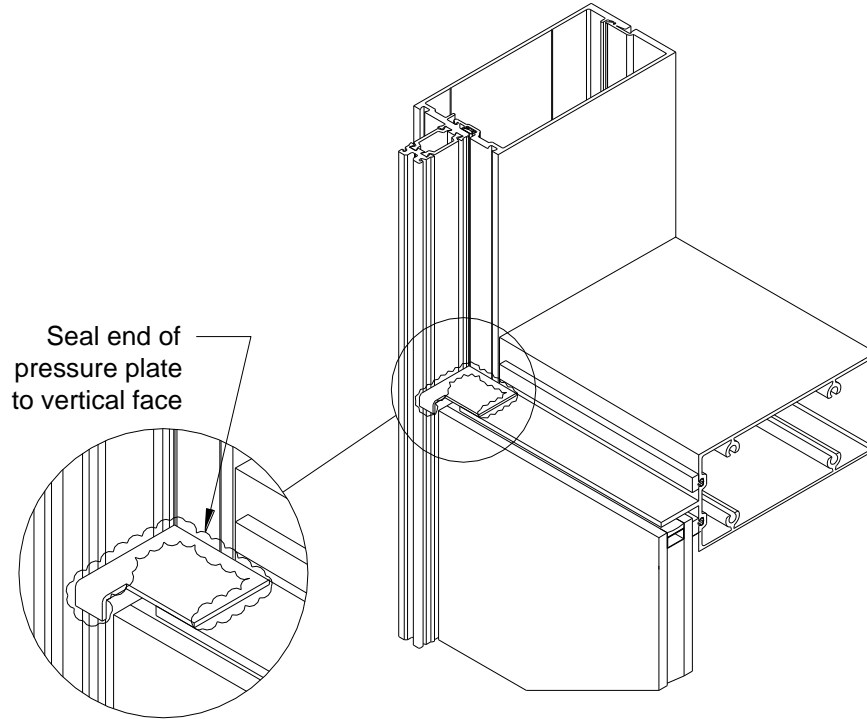


Figure 45: Zone Plug at SSG Horizontal

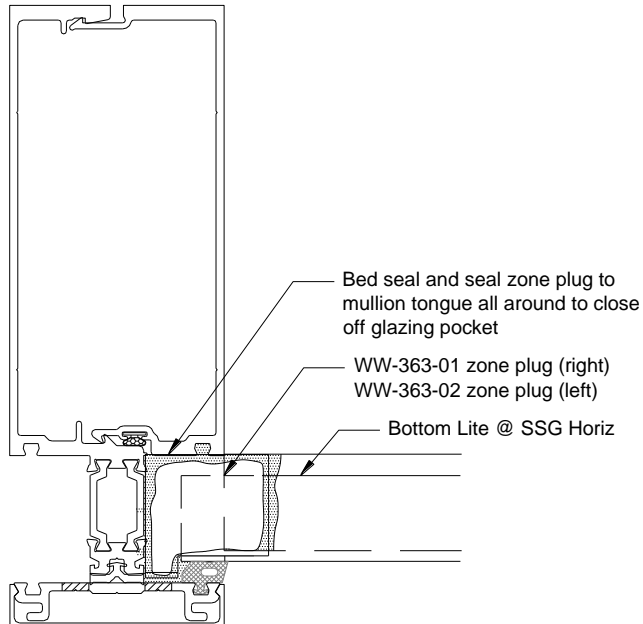


Figure 46: Zone Plug Top View

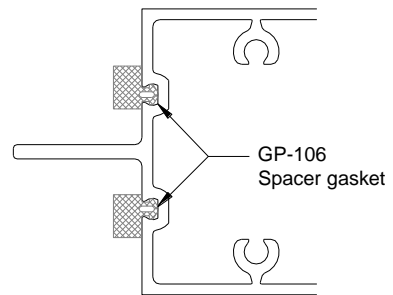


Figure 47: Spacer Gasket Install

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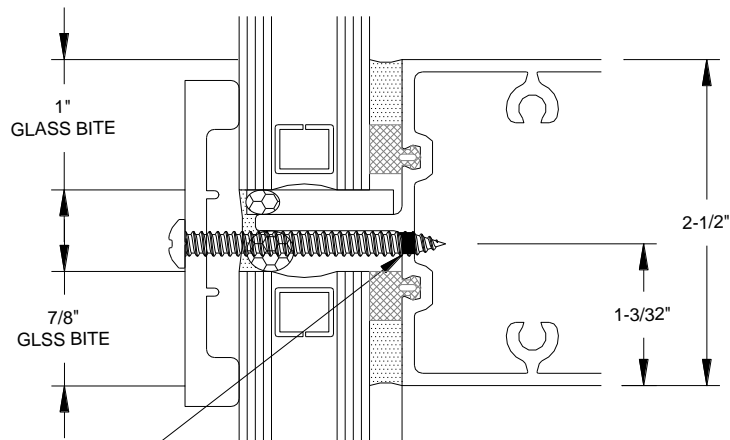
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Sealant note:

After removing the temporary clip, the hole created by the fastener must be sealed before running the exterior weather seal at the face of glass.

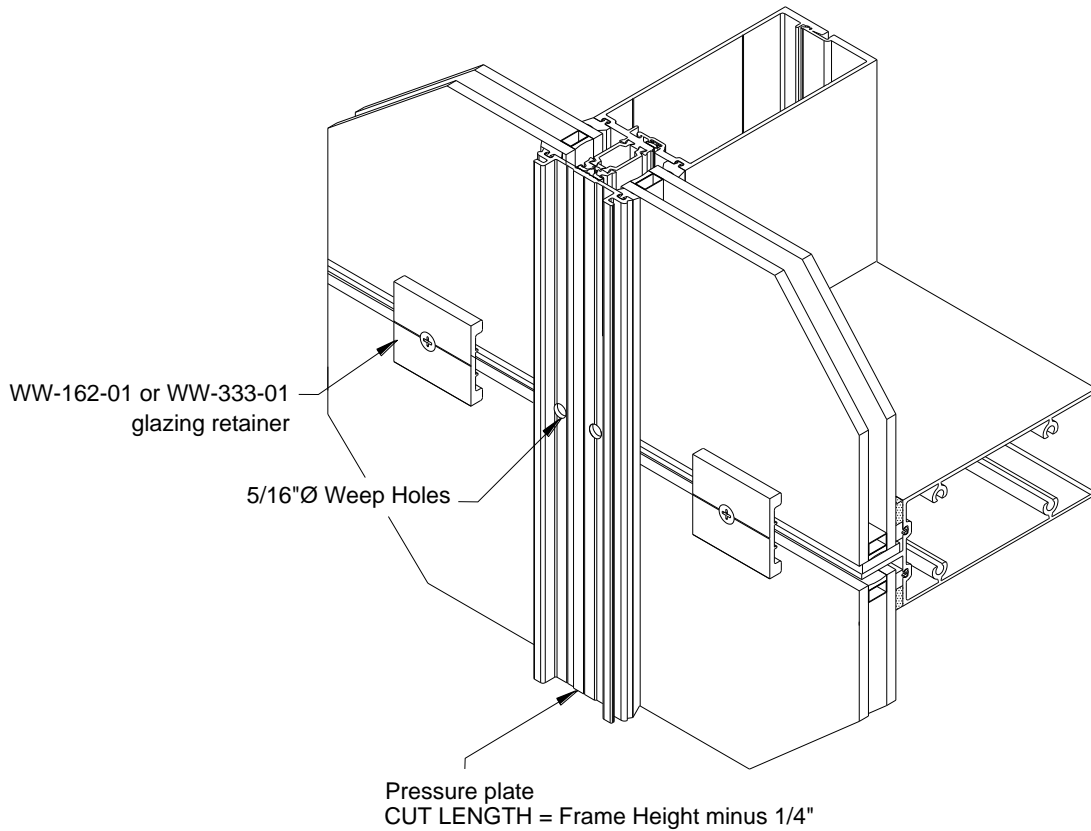


Figure 48: Temporary Clips at SSG Horizontal

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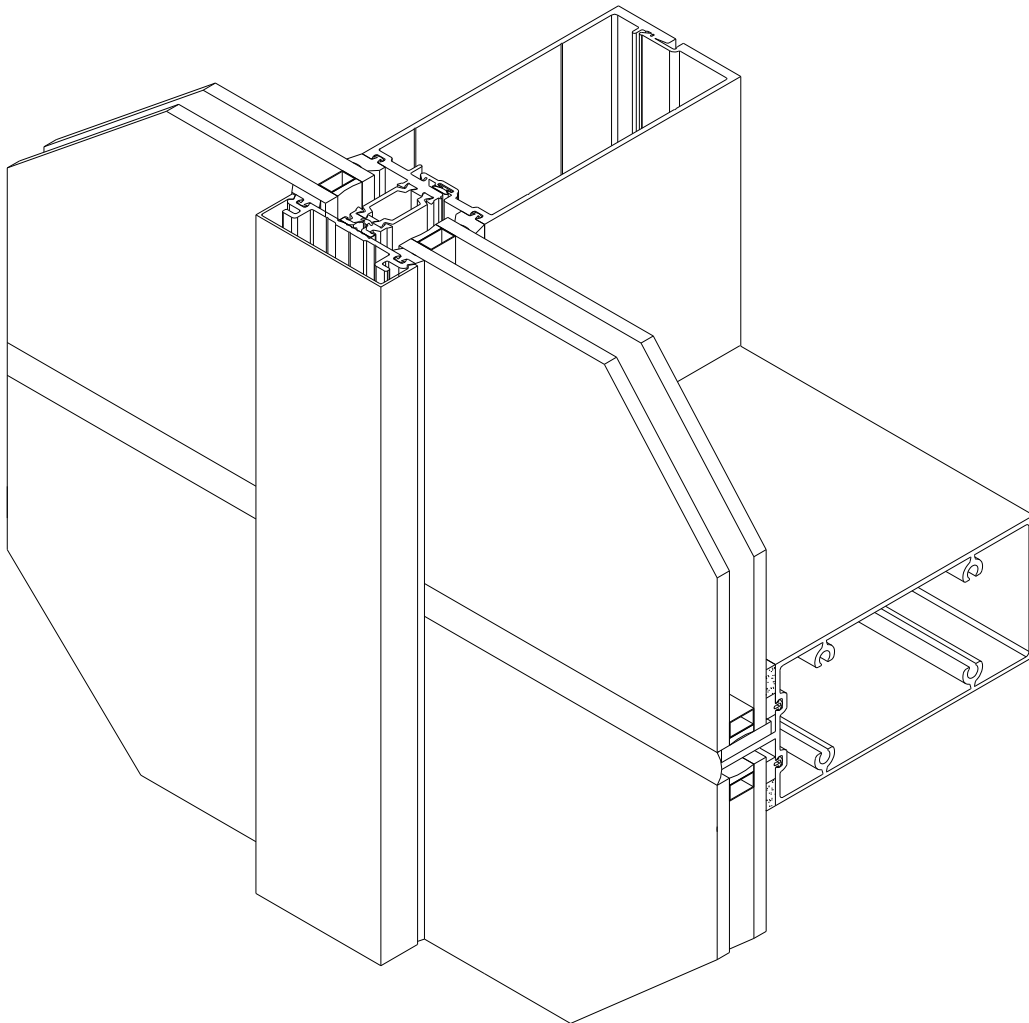
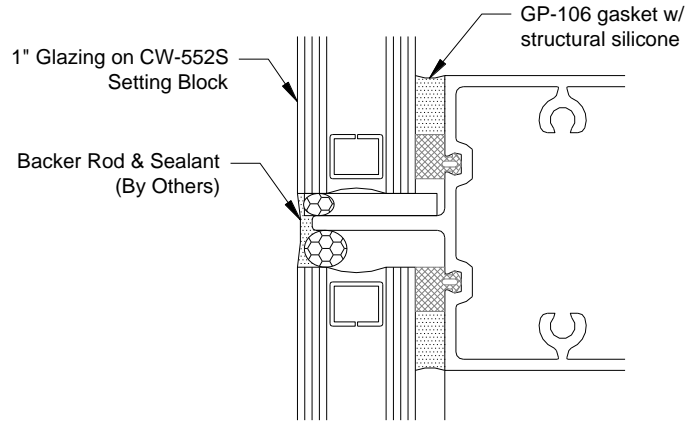


Figure 49: Cover and Sealant

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









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
PARTS LIST

Parts not shown to scale.









4" BACKMEMBERS 6" SYSTEM DEPTH

	Head/Sill Cover used w/ WW-602
	Vertical Half (Right)
	Expansion Horizontal
	Vertical Half (Left)
	Jamb Composite
	Head/Sill Composite
	Horizontal Composite
	SSG Vertical (Left)
	SSG Vertical (Right)
	135° Corner Mullion
	SSG Horizontal







5 1/4" BACKMEMBERS 7 1/4" SYSTEM DEPTH

	Head/Sill Cover used w/ WW-2766
	Vertical Half (Right)
	Expansion Horizontal
















5 1/4" BACKMEMBERS - cont'd 7 1/4" SYSTEM DEPTH

	Vertical Half (Left)
	Jamb Composite
	135° Corner Mullion
	SSG Vertical (Left)
	SSG Vertical (Right)
	SSG Horizontal
	Horizontal Composite
	Head/Sill Composite

COMMON EXTRUSIONS All System Depths and Infills

	Typical Face Cap
	Face Cap for Polyamide Pressure Plate
	Polyamide Pressure Plate
	Aluminum Pressure Plate
	"F" Anchor for WW-601 Jamb Mullion
	"F" Anchor for WW-701 Jamb Mullion

STANDARD ACCESSORIES All System Depths and Infills

	"T" Anchor for IW-544
	"T" Anchor for IW-444
	Vertical Mullion Splice for IW-444 & WW-600
	Vertical Mullion Splice for IW-445 & WW-471
	Jamb Mullion Splice for WW-601
	Head Anchor Sleeve for IW-444 & WW-600
	Vertical Mullion Splice for IW-544 & WW-700
	Vertical Mullion Splice for IW-545 & WW-573
	Jamb Mullion Splice for WW-701
	Head Anchor Sleeve IW-544 & WW-700
	Gasket Retainer Expansion Horizontal
	Gasket Retainer Expansion Horizontal
	Vertical Cap (intermediate mullion)
	Vertical Cap (left jamb)
	Vertical Cap (right jamb)

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
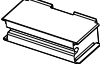



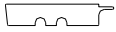








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





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






STANDARD ACCESSORIES All System Depths and Infills

 WW-366	Thermal Pocket Filler
 WW-302	Zone Plug 1" Infill
 WW-349	SSG Bridge
 WW-364	Zone Plug Deep Pocket
 WW-365	Zone Plug Shallow Pocket
 WW-333-01	Temporary Glazing Retainer for Captured Mullions
 GP-101	Setting Block
 GP-102	SSG Spacer Gasket Corner Mullions 1/4" F.C.
 GP-103	Typical Gasket 1/4" F.C.
 GP-108	Isolator
 GP-111S	Side Block
 GP-144	Gasket Expansion Expansion Horizontal
 GP-198	Co-Extruded Isolator at Sunshade Anchor
 CW-552S	Setting Block SSG Horizontal
 CW-998	Bulb Gasket Intermediate Verticals










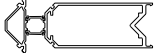

STANDARD ACCESSORIES All System Depths and Infills

 SPW-PP-3	Temporary Glazing Retainer for SSG Verticals
 SPW-295	Baffle Retainer
 AW-127	Setting Chair
 HP-1004	Weep Baffle
 SS-202-01	Sunshade Anchor
 BM-1016	Splice for WW-604

CORNER MULLIONS & ACCESSORIES

 WW-283-01	90° Shear Block (left) used with WW-484, WW-584
 WW-283-02	90° Shear Block (right) used with WW-484, WW-584
 WW-283-05	135° Shear Block (left) used with WW-484, WW-584
 WW-283-06	135° Shear Block (right) used with WW-484, WW-584
 WW-387-01	90° Shear Block (left) used with WW-702, WW-704, WW-713 WW-602, WW-603, WW-613
 WW-387-02	90° Shear Block (right) used with WW-702, WW-704, WW-713 WW-602, WW-603, WW-613
 WW-387-03	135° Shear Block (left) used with WW-702, WW-704, WW-713 WW-602, WW-603, WW-613
 WW-387-04	135° Shear Block (right) used with WW-702, WW-704, WW-713 WW-602, WW-603, WW-613

CORNER MULLIONS & ACCESSORIES - cont'd

 WW-102-22	"T" Anchor for WW-604
 WW-308	Zone Plug 135° Captured O.S.
 AW-309	Zone Plug 90° Captured O.S.
 WW-115	Face Cap 90° Captured O.S.
 WW-154	Face Cap 135° Captured O.S.
 WW-171	Pressure Plate 135° Captured O.S.
 WW-220	Mullion Extension 90° O.S for 7-1/4" system
 WW-321	135° Outside Mullion Cap
 WW-323	90° Outside Mullion Cap
 WW-604	90° Corner Mullion 6" & 7-1/4" systems
 CW-823	Mullion Extension 90° O.S for 6" system

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





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



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STANDARD FASTENERS

 FS-8	#14 x 1" Phillips Hex Head Horizontals to Verticals & Splice Sleeves to Mullions
 FS-9	#14 x 1-1/2" Phillips Hex Head - for Steel Reinforcement
 FS-19	10-16 X 5/8 Hex Washer Head TEK
 FS-115	#10 X 1" Phillips Pan Head SMS B PT
 FS-202	#8 X 1/2" Phillips Pan Head
 FS-306	1/4"-20 X 3" Hex Washer Head
 FS-320	#10 x 1/2" U-Drive Fastens Mull Caps
 FS-322	#12-14 x 1" Hex Washer Head Drillflex Fastens Pressure Plate to Mullion (IW-442 & IW-542) & Attach Splices
 FS-325	#12-24 X 1-11/32" Hex Washer Head Drillflex Fastens Pressure Plate to Mullion (WW-442 & WW-542)
 FS-337	#12-14 x 1-1/4" Hex Washer Head #3 PT Drill Flex
 FSN-37	1/4"-20 Hex Nut
 FSW-65	1/4" Lock Washer



DOOR EXTRUSIONS

 D-186	Door Subframe (3/4" Sightline)
 F-16	Door Header OHCC (2" Sightline)
 DS-1	Flush Door Frame & Optional D-186 Door Stop (Use with SC-1 Clip)
 SC-1	Spring Clip for DS-1 Door Stop
 FS-15	3/16" x 7/16" Drive Rivet Fastens SC-1 Clip

DRILL FIXTURES

 DJ-105	Drill Jig prep for mullions WW-573, WW-701
--	--

STEEL REINFORCEMENT

 CW250-PP-16	Steel Channel for WW-700, WW-706 (20'-1")
 RS-21	Steel Channel for IW-440 & IW-444, (20'-1")

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INSTALLATION CHECKLIST

- Before installation, verify correct steel reinforcing is attached properly and located correctly.
- Verify pressure plates fastener holes 1-1/2" from the ends. Horizontal pressure plates should have two 5/16" weep holes at quarter points.
- Horizontal face covers should have one 5/16" weep hole at the center of the cover.
- Bond breaker tape should be applied to prevent 3-sided adhesion. Examples: mullion splice sleeve, cover sleeve, etc., prior to sealing.
- End caps should be fully sealed and fastened to both ends of all vertical mullions.
- Nylon Slip Pads should be used between all wind load/deadload anchors and mullions.
- Sealant should be applied around the front of the shear blocks just prior to attachment of the horizontal mullions to the shear blocks at all vertical/horizontal joints.
- Backer rod and 1/4" minimum caulk joint at jambs head, and sill.
- Verify all horizontal/vertical intersections have joint plugs. Apply sealant to surfaces of joint plug and insert between horizontal/vertical. Tool excess sealant.
- Sealant over horizontal/vertical mullion joint seam, and any exposed horizontal shear block fasteners.
- Glazing adapters applied with a continuous bead of sealant in the mullion glazing race before inserting and fastening the adapters. Also, ensure the adapter to end cap has been sealed.
- Interior vertical gaskets cut to D.L.O. + 1/4" per foot + 1". Interior horizontal gaskets should be cut to D.L.O. + 1/4" per foot
- After interior gaskets are installed, pull both horizontal and vertical gaskets out of the glazing race at the corners and seal the reglet 3" over the horizontal and 3" up the vertical mullion. Press the gaskets back into the races and seal the seam at the vertical/horizontal gasket intersection. Do not allow sealant to cure before setting glass.
- Setting blocks placed on the horizontals at their appropriate locations for the size of the glass. The setting blocks should not obstruct the path of water to the weep holes in the pressure plates.
- Side blocks positioned on both sides of each lite of glass at the centerline of the vertical daylight opening. Additional side blocks are required for seismic conditions.
- Just prior to application of the vertical pressure plates, apply sealant to the face of the joint plugs.
- Horizontal pressure plates should be applied after vertical pressure plates.
- Pressure plate fasteners torqued per appropriate application