

ARCTIC FRONT 45X JOBSITE GUIDELINES: EXTERIOR GLAZE

ASSEMBLY

Clean before sealing

EXTERIOR GLAZED SCREW RACE ASSEMBLY

Seal ends of Horizontal Members as shown and inside Glazing Reglets where they will meet Vertical Members.

EXTERIOR GLAZED SHEAR BLOCK ASSEMBLY

- Seal ends of Horizontal Members as shown and inside Glazing Reglets where they will meet Vertical Members.
- Attach Shear Blocks using 45AFS9 Screws and install 45ATFS24 Roll Pins.
- Fit Horizontal Members over Shear Blocks.
- Secure 45AFP60 Shear Block with 45ATFS7 Screw.
- Secure 45AC119 Shear Blocks with 45ATFS6 Screws.

ANCHOR INSTALLATION

- Install 45AFP58 Head Anchors on each end of Head, 4" away from each Mullion and at all Anchor Points on Jamb.
- Drill through Anchors, Head, and Jamb at all Anchor Points. Refer to Shop Drawings for Anchor size and frequency.
- Install 45XFA PVC Filler between Anchors at Head (required) and at Jamb (optional) to improve perimeter seals.

NOTE: Screws are included with Shear Blocks. 45ATFS24 Roll Pin is packaged separately.

INSTALLATION

END DAM INSTALLATION

NOTE: DO NOT use End Dams on ends that butt against Door Jambs.

- Hold End Dam against Sub Sill and drill 5/32" holes.
- Apply sealant to End Dam and ends of Sub Sill.
- Fill screw holes with sealant.
- Use #8 x 7/8" PHP SMS screws to secure. Trim excess length.
- Seal and tool joint and seal over screw heads.

SUB SILL INSTALLATION

Temporarily shim between End Dam and Wall. Remove before sealing perimeter.

NOTE: Only pin Sub Sill at one point per cut length. Pin Sub Sill at Wall.

Ensure Sub Sill is level. DO NOT tilt towards interior.

Seal over fastener heads.

Shim at Anchor Points. Position fasteners in center of elongated holes.

NOTE: Refer to Shop Drawings for fastener size and frequency.

FRAME INSTALLATION

- Butter End Dam.
- Apply continuous sealant on Sub Sill front and back legs.
- Set front of frame in Sub Sill.
- Tilt frame back into place.
- Clean excess sealant.
- Push frame against wall. Shim when necessary.
- Shim and fasten Head at Head Anchors.
- Seal 4" (102 mm) Interior Snap Joint on 45XVE.
- Repeat Steps 2 through 7 above to snap next frame into place.

DOOR FRAME INSTALLATION

- Leave front of Door Jamb clear of sealant for drainage.
- Create bed of sealant for Sub Sill. Seal minimum of 1" above back leg of Sub Sill.
- Refer to SUB SILL INSTALLATION to install Sub Sill.
- Apply continuous sealant along Sub Sill front and back legs.
- Continue with FRAME INSTALLATION.

SPLICE INSTALLATION

12 FT (3.6 m) Maximum Length between Splice. Install using Method A or Method B.

NOTE: Gap is tooled and sealed after FRAME INSTALLATION.

EXTRUDED ALUMINUM SPLICE

- Apply 3/4" Bond Breaker Tape to center bottom side of Sleeve.
- Apply silicone and tool full length of Splice.
- Place Splice Sleeve.
- Apply Bond Breaker Tape to other side.
- Ensure Splice Sleeve is level.
- Seal over Tape, extending 1/4" (6 mm) on either side. Seal entire perimeter of Sleeve.

SPICE SEALING

Seal and tool Gap at Interior Splice Joint.

FINISHING

PERIMETER SEALING

Install Backer Rod and seal perimeter with Cat. No. 795 Silicone Sealant.

NOTE: The quality of Perimeter Seals may be improved by using 45XFA PVC Filler between 45AFP58 and 45AFP59 Anchor Plates.

SPICE SEALING

Seal and tool Gap at Interior Splice Joint.

GLAZING

GLASS THICKNESS

Correct combination of Gaskets and Adaptors for each Glass Thickness.

GLAZING PREPARATION

Determine correct combination of Gaskets and Glazing Adaptors for each Glass Thickness using illustrations on the left.

NOTE: 45XHA, 45XHB, 45XHC, and 45XVA use Adaptors shown on left of each Glass Thickness while 45XVE use Adaptors shown on the right.

PREPARE GLAZING ADAPTORS:

Cut Vertical Gaskets D.L.O. plus 1" (25 mm) plus 3/8" (10 mm) per foot. Vertical Gaskets run through.

Cut Horizontal Gaskets D.L.O. plus 3/8" (10 mm) per foot. Horizontal Gaskets are mitered at corners and sealed to Vertical Gaskets during installation.

PREPARE GLAZING ADAPTORS:

Cut Vertical Adaptors D.L.O. plus 7/8" (22 mm). Vertical Adaptors run through.

Cut Horizontal Adaptors D.L.O. minus 1/16" (2 mm). Horizontal Adaptors are sealed to Vertical Adaptors during installation.

GLAZING ADAPTOR INSTALLATION

- Apply continuous bead of sealant in Interior Glazing Reglets.
- Install Interior Vertical Adaptor and then Interior Horizontal Adaptor.
- Seal Adaptor Glazing Reglets at corner.
- Install Interior Vertical Gasket and then Interior Horizontal Gasket.
- Seal Gaskets at corner, 2" in each direction.
- Follow Steps 4 - 12 below to set Glass.

EXTERIOR GLAZING

- Seal Interior Glazing Reglets at corner.
- Install Interior Vertical Gasket and then Interior Horizontal Gasket.
- Seal Gaskets at corner, 2" in each direction.
- Inset Glass into Deep Pocket.
- Slide Glass into Shallow Pocket.
- Push Glass up into Upper Glazing Pocket.
- Push Glass tight against Interior Gaskets.
- Snap in Glass Stop.
- Install "W" Edge Block in Deep Pocket.
- Install Exterior Gaskets using the same procedure as Step 2 above.
- Embed 45AFP2 Water Diverter in Sealant on both ends of 45XVA Intermediate Horizontal.
- Seal around edges of Water Diverter.
- Repeat steps 1 through 12 to install Top Lite.

NOTE: Clean Glazing Pockets of debris before glazing to prevent blockage of weeps or drains.

NOTE: 1/2" (13 mm) Glass with 45AFL66 Gaskets and 45XVP Adaptor Exterior Installation shown above.

MORE INFORMATION

Refer to the Installation Manual for more information on:
Frame Fabrication: Exterior and Interior
Interior Glazed Installation

Contact Technical Sales at (800) 582-7501
for Assistance and Replacement Parts.

