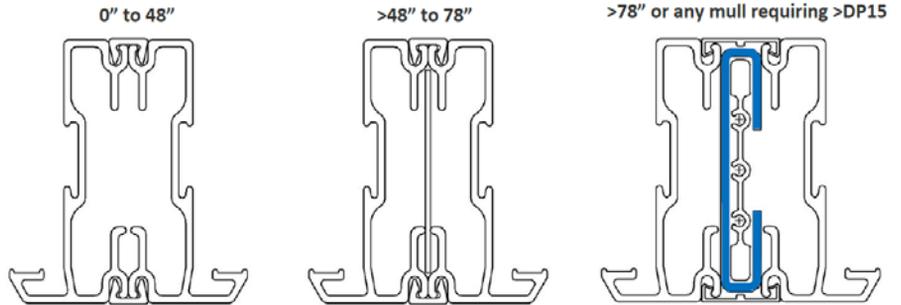




Alpen windows are tested to commercial design load ratings. In order to ensure mullered assemblies meet similar wind and structural load requirements, Alpen HPP offers a variety of factory-mullered solutions as well as technical design support for field-assembled solutions.

Structural Mullions for Alpen Windows

Factory mulling of Alpen's ZR-X Series windows is available for 2, 3 and 4-unit combination assemblies. Follow these guidelines to choose correct mullion type based on window size and design load requirements:



OPTION 1: "Tight Mull"

OPTION 2: Tight Mull with Steel Insert

OPTION 3: 1/2" Structural Mull with 4" bracket inserts

Mulling Capabilities

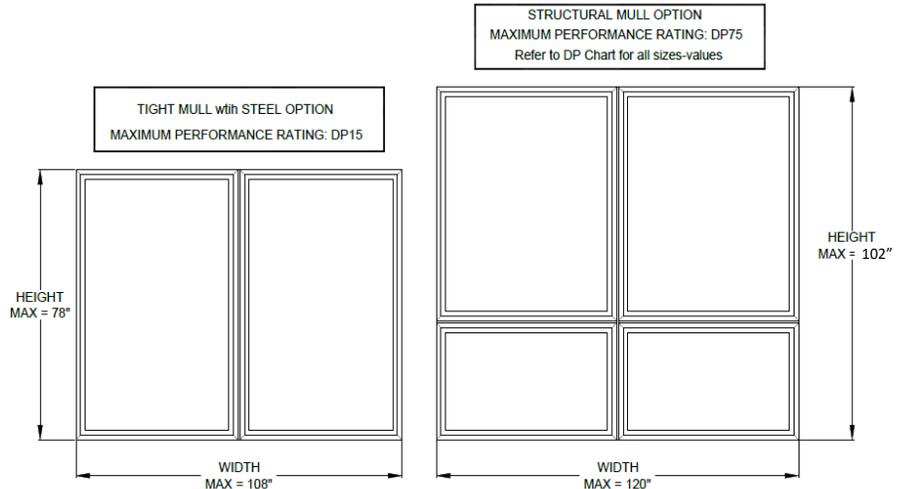
Structurally reinforced mullions allow larger mullered combinations and higher design loads:

- Mullion ratings **up to DP-75**
Refer to the ZR-X Structural Mullion DP Chart datasheet for specific size ratings
- Overall assembly sizes **up to 60 square feet**

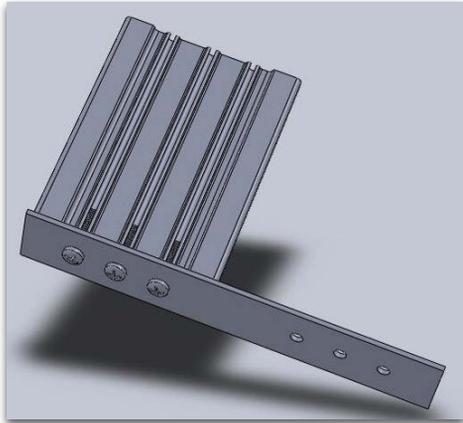


All Alpen windows can be combined into mullered assemblies – combine fixed and operable windows for maximum performance, daylighting and ventilation with minimal sightlines obstructing views.

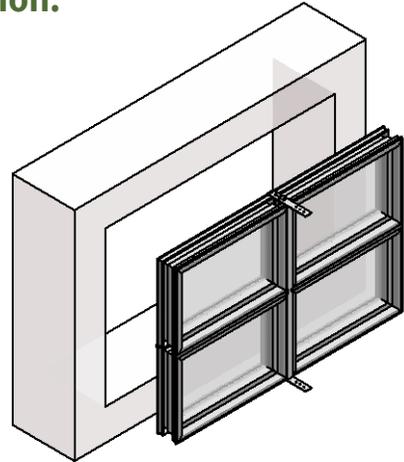
Mullered assemblies larger than 60 square feet and comprised of 5 or more windows may be available. Contact Alpen HPP for design review and engineering support.



Additional Information for Structural Mullion:



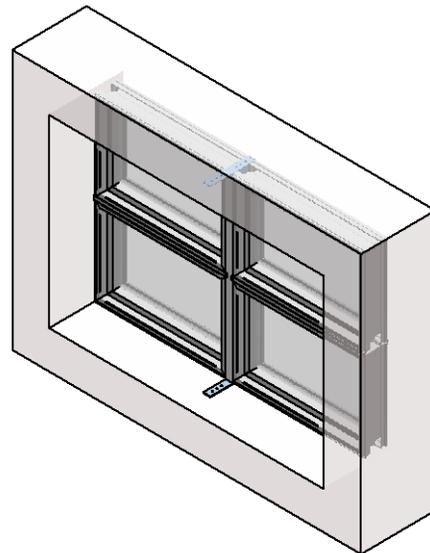
Two 4" aluminum reinforcements are inserted into the mullion at Alpen's factory and windows will be packaged with two 6" aluminum plates that serve as mullion anchors.



Before installing the window, fasten the two 6" aluminum plate anchors to the top and bottom of the mullion through the 4" aluminum mull reinforcement on top and bottom of the window.



Clear adhesive can be used prior to inserting secure plate on both sides of the structural mullion to keep the plate in place until the window is set in the opening. Plate may be turned to interior or exterior depending on application.



After the window is installed, fasten through nailing fin or brackets to secure window in opening, then fasten mullion anchors to rough opening to secure mullion and transfer mullion load to framing.