

## Ribbon Window (400 Series) Assembly Instructions

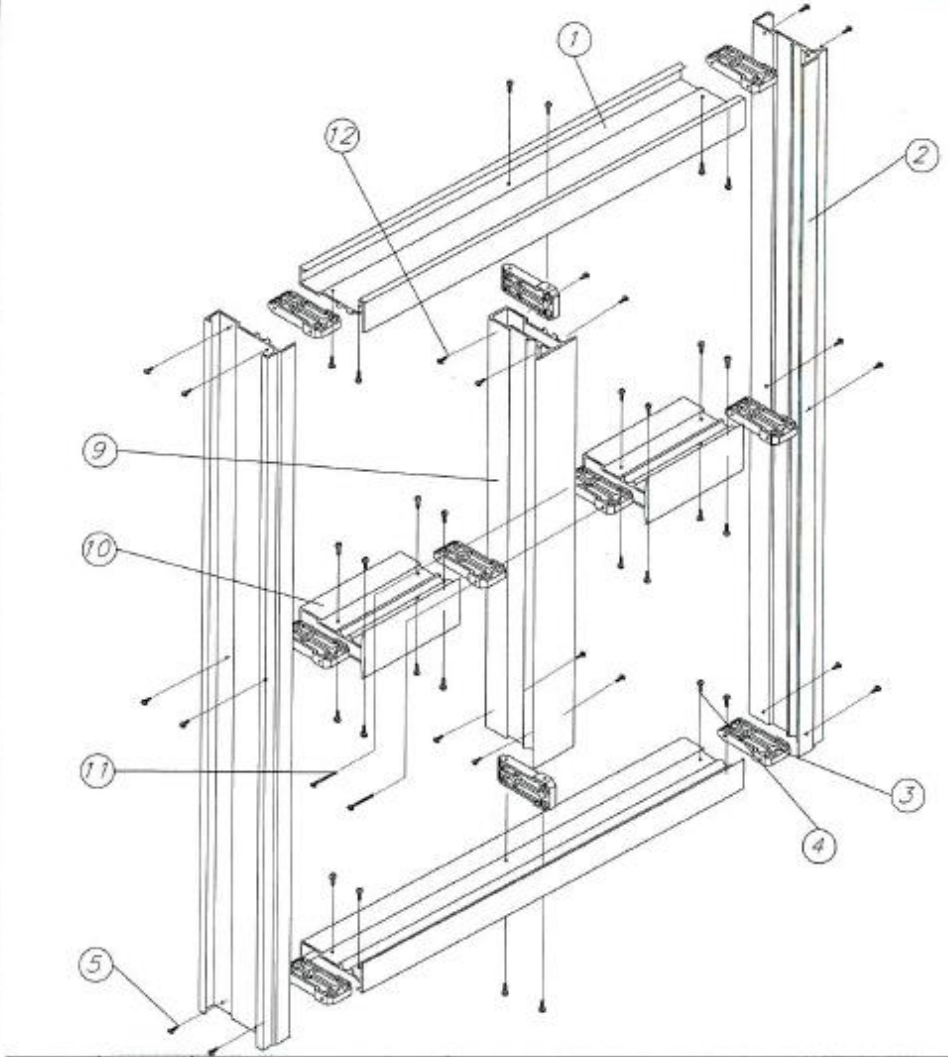
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### ***GENERAL:***


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1. USE CARE while moving the window unit to avoid cracking or breaking of fiberglass frame.
2. DO NOT drag or push as damage may occur
3. If storing windows for any length of time, please consult Alpen's installation, handling & storage checklist.
4. Make sure all surfaces are clean and dry before assembly.
5. Do not assemble windows or glaze outdoors or in unconditioned spaces if temperature is below 40°F.
6. The frame construction must be well sealed at all joints, shear blocks and profile connections and fasteners.
7. Follow Sealant Manufacturer's instructions for surface preparation and sealant application.
8. Clean off excess sealant from all surfaces.

## SYSTEM OVERVIEW



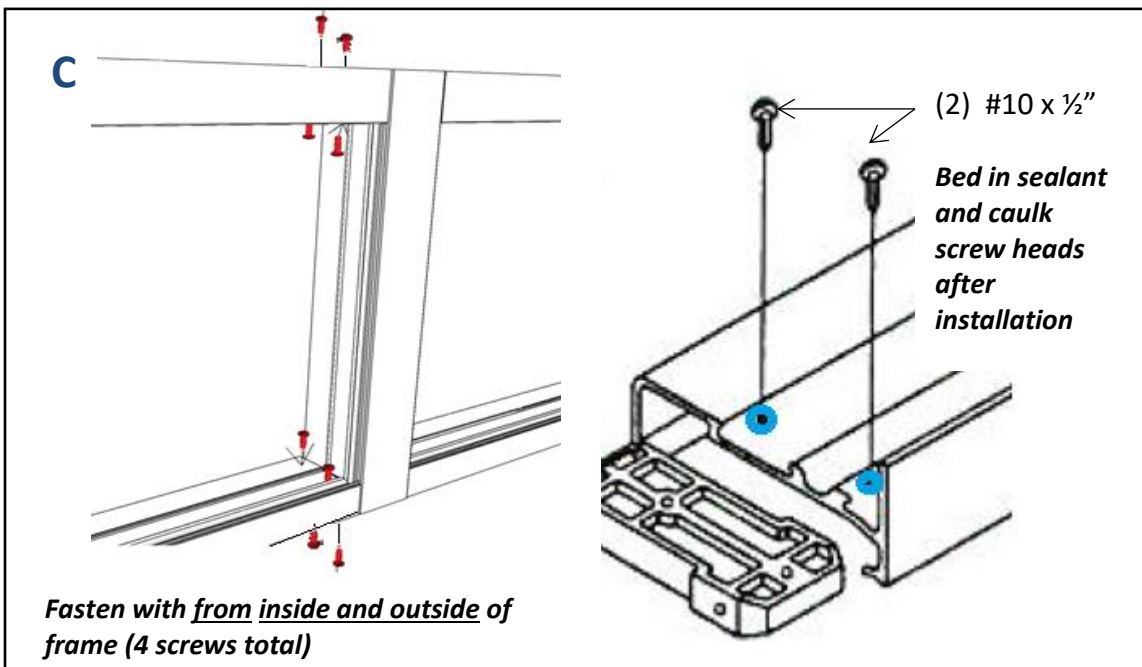
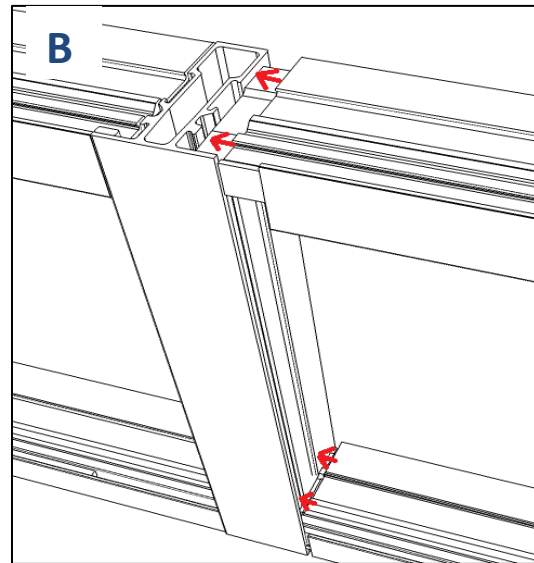
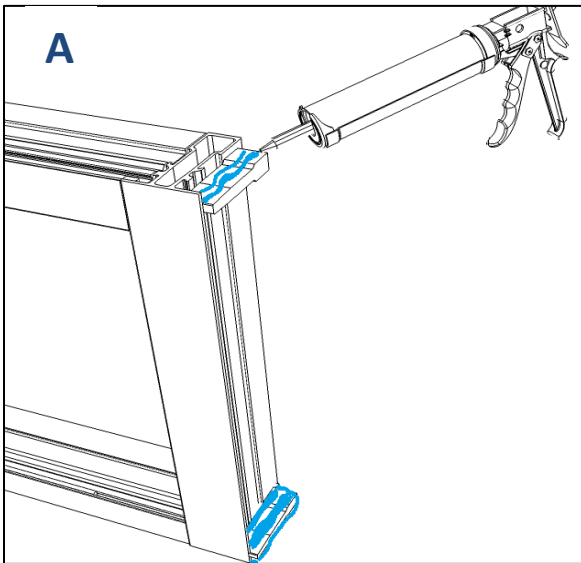
12	24	-	SCREW S.S. #10x3/8.PH.TYPE A	STEEL
11	2	-	SCREW S.S. #10x3 1/2.PH.TYPE A	STEEL
10	2	405	TRANSOM	FIBERGLASS
9	1	405	MULLION	FIBERGLASS
8	16	410 OR 428	GLASS STOP	PVC OR ALUM.
7		GL-TAPE	GLAZING FOAM	
6	4	-	DOUBLE INSULATING GLASS	GLASS
5	16	-	SCREW S.S. #10x3/4.TH.TYPE A	STEEL
4	8	-	SCREW S.S. #10x1/2.PH.TYPE A	STEEL
3	10	412	SHEAR BLOCK	PLASTIC
2	2	402	PERIMETER/FRAME#402	FIBERGLASS
1	2	401	PERIMETER/FRAME#401	FIBERGLASS

ITEM	QTY.	DWG.NO./CAT.NO.	DESCRIPTION	MATERIAL
 30 Constellation Court Toronto, Ontario M9W 1K1			<b>SHEET 1/1</b> NO. REVISION DATE 1. K.C. Dec.06	DR. BY. J.L. DATE Feb.99 SCALE
			<b>OPTION WITH MULLION OR TRANSOM BLOWOUT</b>	<b>400-301</b>

## ASSEMBLY INSTRUCTIONS:

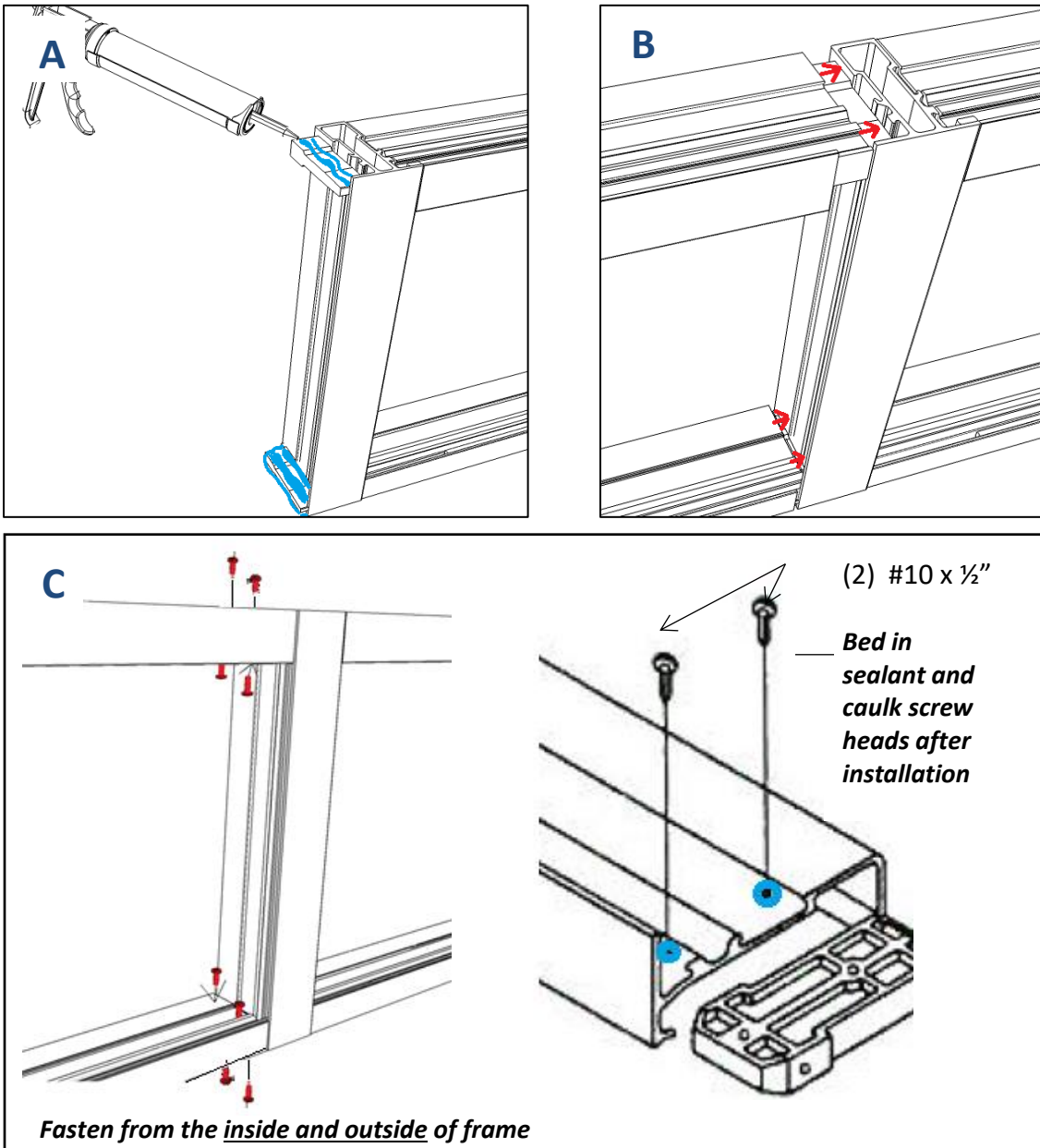
### 1) Attach Horizontal Head and Sill Frame Profiles to Left-Side of Factory-Assembled Unit

- Apply polyurethane sealant (Xtrabond 9500 or equiv.) to exposed factory-installed shear blocks **(A)**.
- Slide each of the two supplied Horizontal Frame Profiles over shear blocks **(B)**.
- Align holes in shear blocks with holes pre-drilled in jamb profiles and fasten frames to shear blocks using two (2) #10 x ½" Screws provided **(C)**.
- Caulk all screw penetrations and exposed screw heads.



## 2) Attach Horizontal Head and Sill Mullion Profiles to Right-Side of Factory-Assembled Unit

- Apply polyurethane sealant (Xtrabond 9500 or equiv.) to factory-installed exposed shear blocks **(A)**.
- Slide each of the two supplied Horizontal Frame Profiles over shear blocks **(B)**.
- Align holes in shear blocks with holes pre-drilled in jamb profiles and fasten frames to shear blocks using four (4) supplied #10 x ½" screws. Fasten with two (2) screws from exterior and two (2) screws from interior **(C)**.
- Caulk all screw penetrations and exposed screw heads.

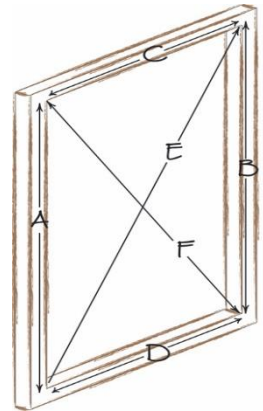




**BEFORE PROCEEDING, CHECK THAT YOUR NEWLY ASSEMBLED UNIT IS SQUARE**

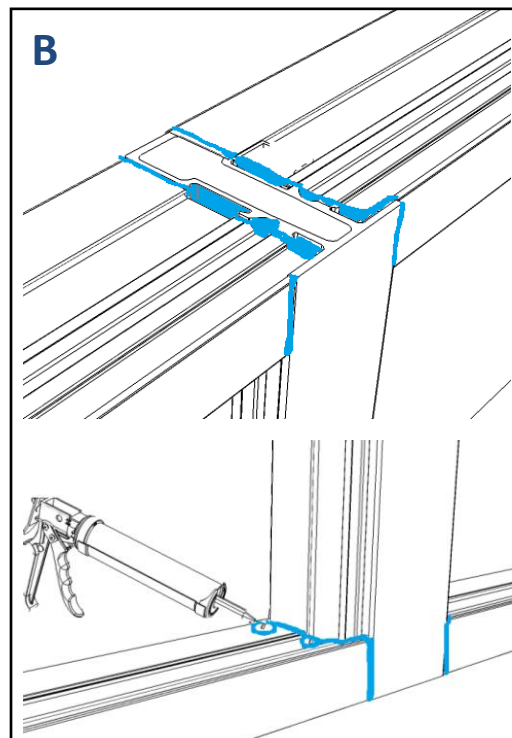
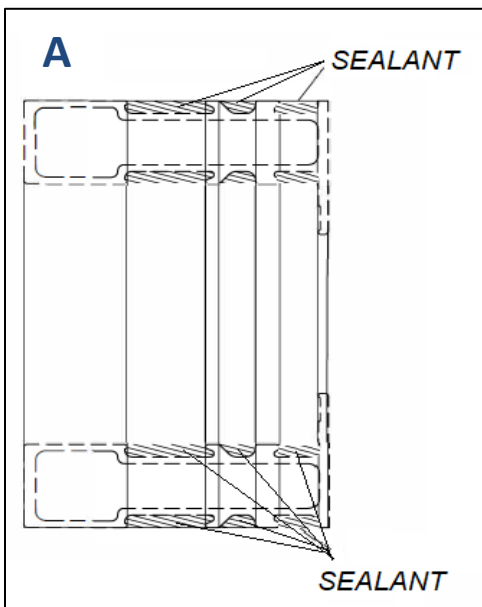
### 3) Check for Square

- Check to ensure frames and glass opening are square and level and that the newly assembled Vertical and Horizontal Profiles are not racked or twisted.
- If window is not square, remove screws and re-install before proceeding to final steps.



### 4) Seal All Frame Connections **\*THIS IS A CRITICAL STEP\***

- Apply polyurethane sealant (Xtrabond 9500 or equiv.) to all frame connections to fill all **voids and gaps** at all interior and exterior frame connections **(A)**
- Apply polyurethane sealant (Xtrabond 9500 or equiv.) sealant to all interior and exterior **frame surface connections (B)**. Sealant should fill all joints and gaps to form a complete air- and water-tight assembly.



**5) Field Glaze Window** (optional if before or after installation)*a. Field-Glazing Prior to Installation:*

- i. On a clean, flat surface lay the entire window assembly flat.
- ii. Check glass opening for square and that the newly assembled Vertical and Horizontal Profiles are not racked or twisted.
- iii. Glaze following Alpen Ribbon Window Installation Instructions and proceed to install window noting items below.

*b. Field-Glazing After Installation:*

- i. Follow Alpen Ribbon Window Installation Guidelines for installing the window frame installation
- ii. Ensure shims are at all anchoring locations to prevent frame from bowing
- iii. Before tightening all fasteners to secure window into opening, check again to make sure window and glass opening is plumb, level and square, and that the newly assembled Vertical and Horizontal Profiles are not racked or twisted.
- iv. Field glaze following Alpen Ribbon Window Installation Instructions