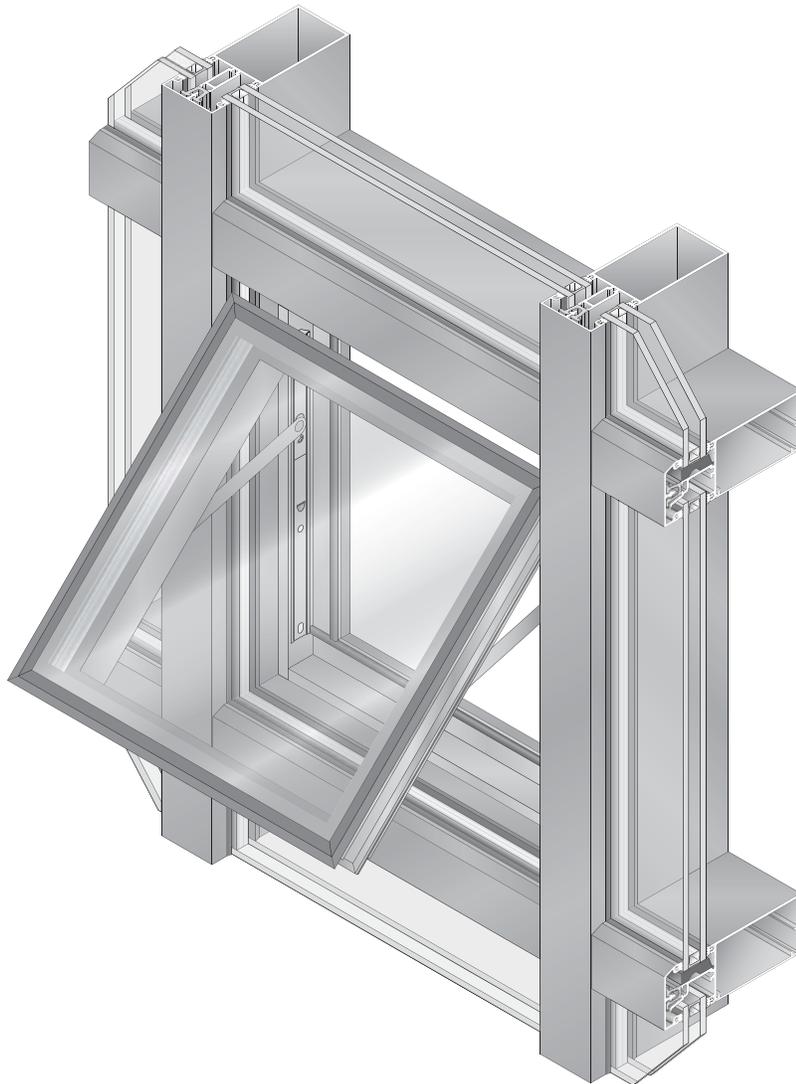


INSTALLATION INSTRUCTIONS

SERIES 7500 WINDOW SYSTEMS



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SERIES 7500 WINDOW SYSTEMS

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INSTALLATION INSTRUCTIONS

GENERAL NOTES

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.

All aluminum materials at 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 and keep records of where various materials are stored.

C. KEEP MATERIAL 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.***

The rapidly changing technology within the architectural aluminum products industry demands that United States 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.

Other metric units shown in this manual are:

- | | |
|------------------|------------------|
| m - meter | Kg - kilogram |
| Pa - pascal | KPa - kilopascal |
| MPa - megapascal | N - newton |

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 general nature and cover most conditions.
2. **INSTALLATION.** All materials are to be installed plumb, level and true. Install operable windows preglazed only.
3. **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.
4. **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.
5. **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.
6. **ISOLATION OF ALUMINUM.** Aluminum to be placed in direct contact with uncured masonry or incompatible materials should be isolated with a heavy coat of zinc chromate or bituminous paint.
7. **SEALANTS.** Sealants must be compatible with all materials with which they have contact, including other sealant surfaces. Consult with sealant manufacturer for recommendations relative to joint size, shelf life, compatibility, cleaning/priming, tooling, adhesion, etc. It is the responsibility of the **Glazing Contractor** to submit a statement from the sealant manufacturer indicating that glass and glazing materials have been tested for compatibility and adhesion with glazing sealants, and interpreting test results relative to material performance, including recommendations for primers and substrate preparation required to obtain adhesion. The chemical compatibility of all glazing materials and framing sealants with each other and with like materials used in glass fabrication must be established. ***This is required on every project.***
8. **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.
9. **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. United States Aluminum exercises no control over the use or application of its products, glazing materials and operating hardware and assumes no responsibility thereof.
10. **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. Gap between expansion members should be based on temperature at time of installation.
11. **WATER HOSE TEST.** As soon as a representative amount of the wall has been glazed (500 square feet or 46.5 m²) a water hose test should be conducted in accordance with AAMA 501.2 specifications to check the installation. On all jobs the hose test should be repeated every 500 square feet (46.5m²) during the glazing operation.
12. **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.).
13. **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.

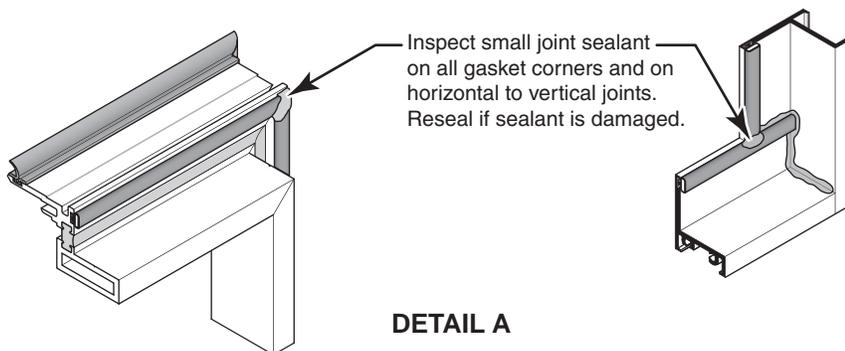
SERIES 7500 INSTALLATION INSTRUCTIONS

These instructions cover installation and glazing of project-out awning windows into storefront, window wall and curtain wall systems.

Allow a minimum clearance of 1/4" (6.4) vertically and horizontally. Window units are fabricated and assembled at the factory. Windows may be shop or field glazed.

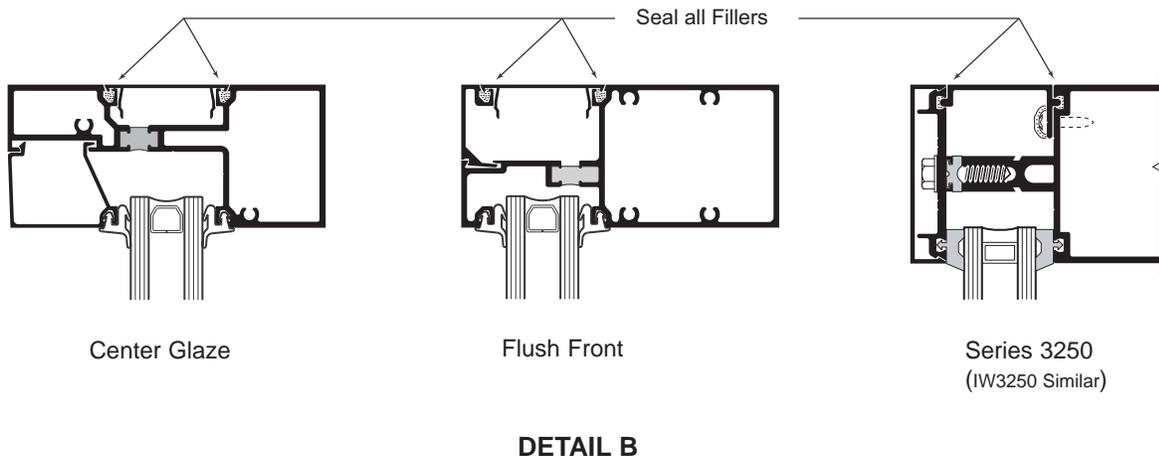
FRAME INSTALLATION

1. Visually inspect all bulb gasket corners to ensure no damage has occurred during shipment. See (DETAIL A). If required, apply small joint sealant to damaged areas, leaving vent open for proper drying.



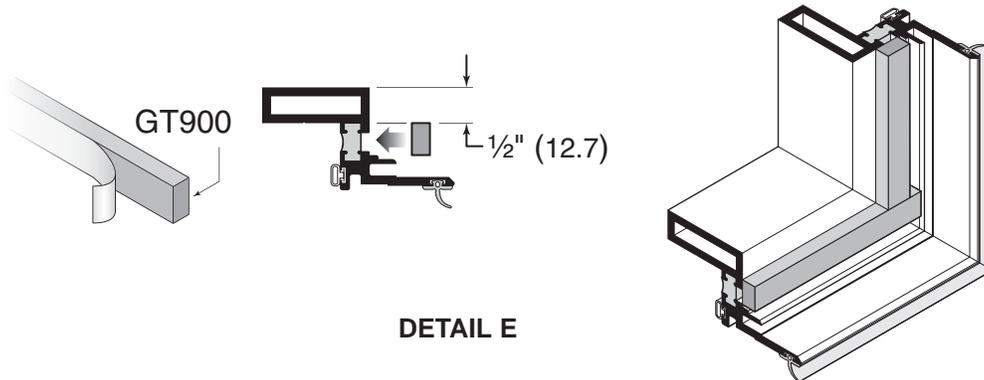
2. If necessary, remove sash from frame prior to installation by removing screws attaching hinges to sash.
3. Apply sealant to all reglets receiving pocket fillers at window locations. See (DETAIL B)

NOTE: Refer to appropriate glazing system manual for proper water diverter installation and sealing instructions before installation of pocket fillers.

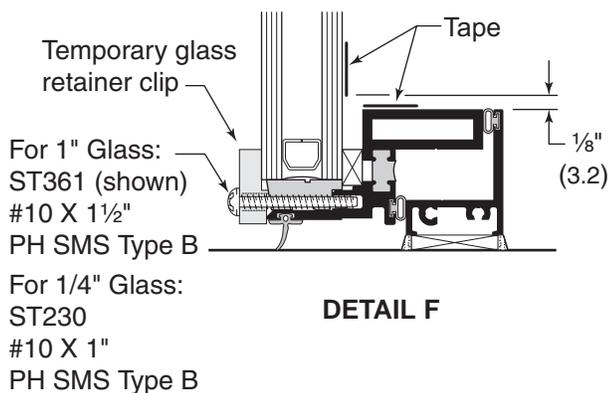


GLAZING

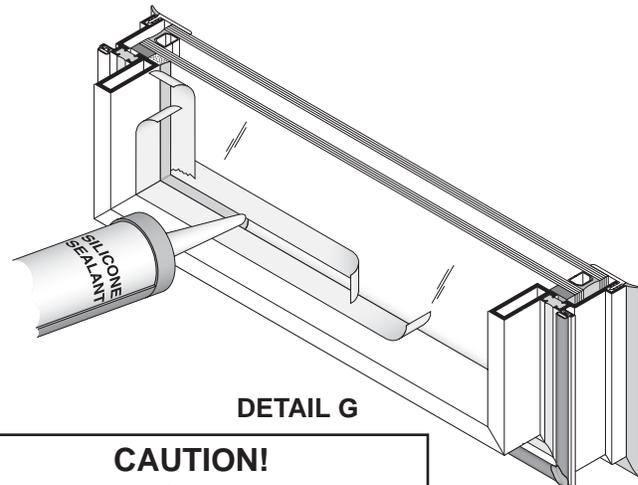
3. Cut and peel protective backing from tape: Apply tape full length of horizontal members, 1/2" (12.7) from edge of fin. Apply tape to the vertical members, butting tight to horizontal tape, 1/2" (12.7) from edge of fin. See **DETAIL E**.



4. Set glass into opening pressing against spacers.
5. Install temporary glass retainer clips using ST261 for 1" glass or ST230 for 1/4" glass. See **DETAIL F**.
6. Mask off aluminum at edge of glass pocket and mask glass 1/8" (3.2) from the edge of aluminum as shown in **DETAIL F and G**.
7. Apply structural silicone, tool and remove masking tape. Use caution in removing tape to avoid marring tooled silicone. **Follow sealant manufacturers recommendations for surface preparation and cure times.**



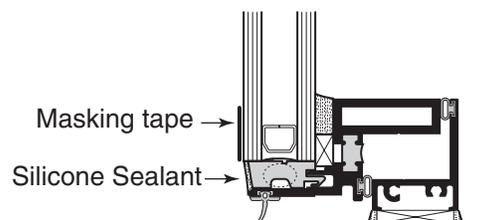
DETAIL F



DETAIL G

CAUTION!
Be sure silicone fills reglet completely.

8. Remove temporary glazing clips and mask edges of glass.
9. Apply exterior weatherseal to glass perimeter. See **DETAIL H**. Use caution in removing tape to avoid marring tooled silicone. **Follow sealant manufacturers recommendations for surface preparation and cure times.**



DETAIL H