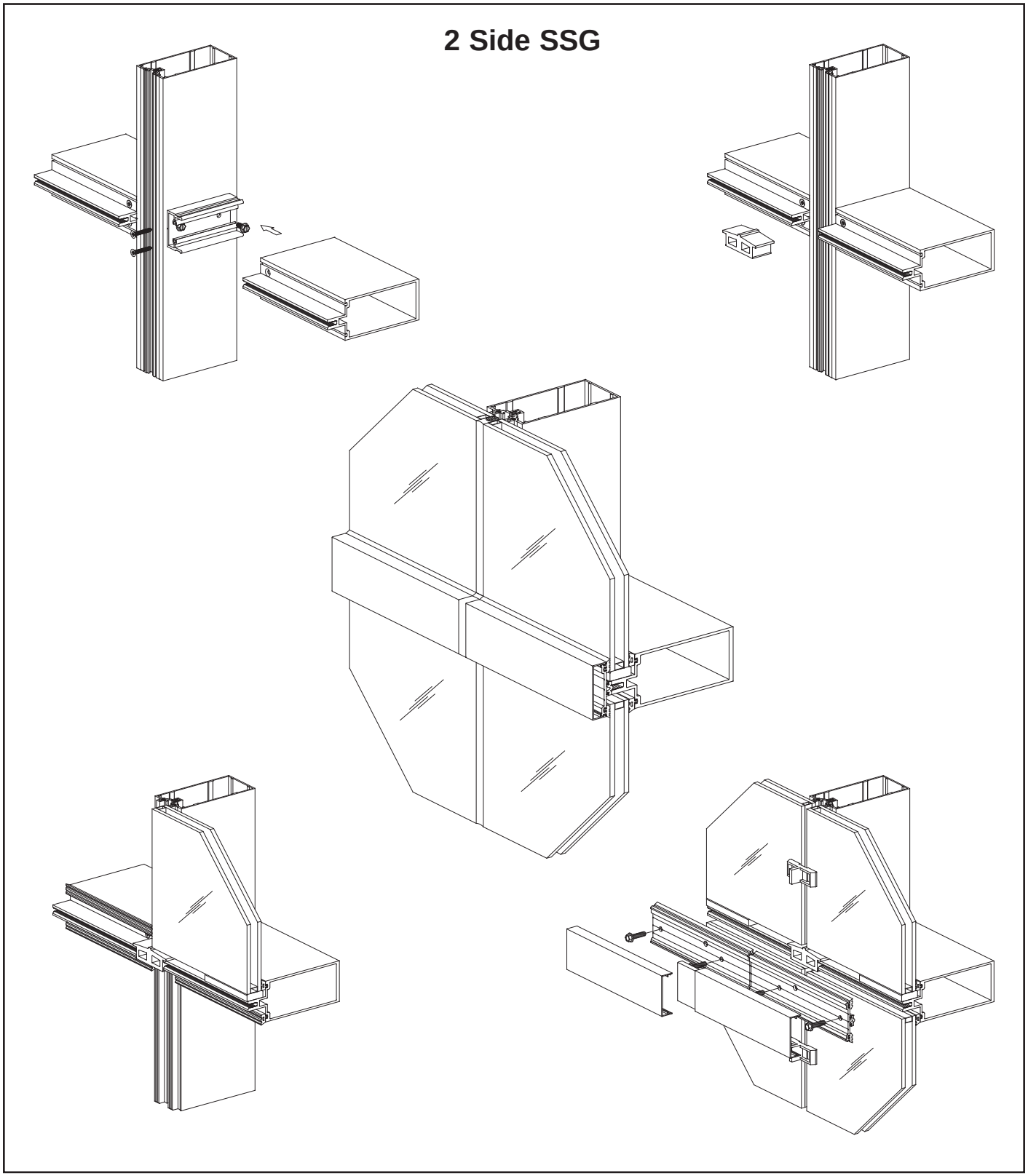
YCW 750 SSG Structural Silicone Glazed Curtain Wall System

2 Side SSG



Installation Manual

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Installation Notes

1. Do not drop, roll or drag boxes of aluminum framing. Move and stack boxes with proper support to prevent distortion. If fork lifts are used be especially careful about striking the boxes when lifting or moving.

2. Store in a dry, out of the way area. If rain exposure, condensation or any water contact is likely, then all packaging material should be removed. Wet packaging materials will discolor and may stain aluminum finishes and paints.

3. All materials should be checked for quality and quantity upon receipt, YKK AP must be notified immediately of any discrepancies in shipment. Check to make sure that you have the required shims, sealants, supplies and tools necessary for the installation.

4. Carefully check the openings and surrounding conditions that will receive your material. Remember, if the construction is not per the construction documents, it is your responsibility to notify the general contractor in writing. Any discrepancies must be brought to the general contractor's attention before you proceed with the installation.

5. Gather your shop drawings, materials, packing list, and this installation manual. Carefully review parts location, the sequence it goes therein, when you glaze it and how you seal it. Installation instructions are of a general nature and may not cover every condition you will encounter. The shop drawings and/or installation manuals were prepared specifically for the product.

6. Any material substitutions must be of equal or greater quality.

7. Make certain that material samples have been sent for compatibility testing for all manufacturer's sealants involved. Make certain sealants have been installed in strict accordance with the manufacturer's recommendations and specifications.

8. Remember to isolate, in an approved manner, all aluminum from uncured masonry or other incompatible materials.

9. System-to-structure fasteners are not supplied by YKK AP. Fasteners called out on shop drawings are to indicate minimum sizes for design loading.

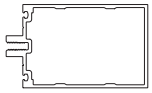
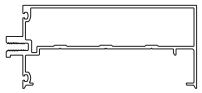
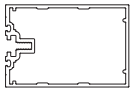
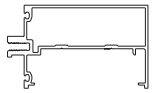
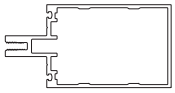
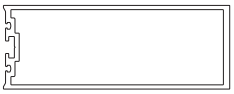
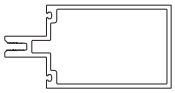
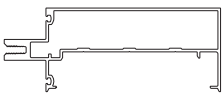
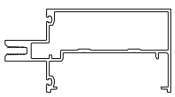
10. If any questions arise concerning YKK AP products or their installation, contact YKK AP for clarification before proceeding.

11. YKK AP storefront and/or curtain wall framing is typically completed before drywall, flooring and other products which may still be in process. Take the extra time to wrap and protect the work produced.

12. Cutting tolerances are plus zero, minus one thirty second unless otherwise noted.

13. Check our website, www.ykkap.com, for the latest installation manual update prior to commencing work.

FRAMING MEMBERS

	Jamb / Horizontal 2-1/2" x 5-1/4" For 1/4" Glazing	**E9-1246**		**Heavy SSG Mullion** 2-1/2" x 5-1/4" For 1/4" & 1" Glazing	**E9-3401**
	**Jamb / Horizontal** 2-1/2" x 3-3/4" For 1/4" Glazing	**E9-1250**		**SSG Mullion (Standard)** 2-1/2" x 5-1/4" For 1/4" & 1" Glazing	**E9-3402**
	**Horizontal** Two Piece 2-1/2" x 5-1/4" For 1/4" Glazing	**E9-1258**		**SSG Mullion** 2-1/2" x 3-3/4" For 1/4" & 1" Glazing	**E9-3423**
	**Horizontal** Two Piece 2-1/2" x 3-3/4" For 1/4" Glazing	**E9-1259**		**SSG Mullion** 2-1/2" x 6-3/4" For 1/4" & 1" Glazing	**E9-3426**
	Jamb / Horizontal 2-1/2" x 5-1/4" For 1" Glazing	**E9-1215**		**SSG Mullion** 2-1/2" x 5-1/4" For 90° O.S. Corner and Door Jamb	**E9-1265**
	Jamb / Horizontal 2-1/2" x 5-1/4" For 1" Glazing	**E9-1225**		**SSG Mullion** 2-1/2" x 3-3/4" For 90° O.S. Corner and Door Jamb	**E9-1266**
	**Jamb / Horizontal** 2-1/2" x 3-3/4" For 1" Glazing	**E9-1235**		**SSG Mullion** 2-1/2" x 6-3/4" For 90° O.S. Corner and Door Jamb	**E9-3535**
	**Jamb / Horizontal** 2-1/2" x 3-3/4" For 1" Glazing	**E9-3537**		**Horizontal Cover** For 5-1/4" Back Horizontals	**E9-1256**
	Jamb / Horizontal 2-1/2" x 6-3/4" For 1" Glazing	**E9-1242**		**Horizontal Cover** For 3-3/4" Back Horizontals	**E9-1038**
	**Horizontal** Open Back 2-1/2" x 5-1/4" For 1" Glazing	**E9-1255**		**Pressure Plate** E9-1216 with PVC Isolator Punched 9" O.C.	**AS-1216**
	**Horizontal** Open Back 2-1/2" x 3-3/4" For 1" Glazing	**E9-1257**		**Perimeter Pressure Plate** For 1/4" Glazing E9-3572 with PVC Isolator Punched 9" O.C.	**AS-3572**

* Splay mullions and other face covers are available, contact YKK AP.

FRAMING MEMBERS

	Perimeter Pressure Plate For 1” Glazing E9-3569 with PVC Isolator Punched 9” O.C.	**AS-3569**		**Perimeter Channel** For 1” Glazing	**E9-1231**
	Face Cover 2-1/2 x 3/4”	**E9-1206**		**90° Outside Corner SSG Glazing Adaptor** Use with E9-1265, E9-1265, & E9-3535	**E9-1273**
	Face Cover 2-1/2 x 1-3/4”	**E9-1229**		**90° Outside Corner SSG Glazing Adaptor** Use with E9-3401, E9-3402, E9-3423, & E9-3426	**E9-3413**
	Face Cover 2-1/2” x 2-3/8”	**E9-1219**		**90° Outside Corner Trim** For 1” Glazing	**E9-2009**
	Horizontal Face Cover 11/16” x 2-1/2”	**E9-1207**		**Interior Cover Base** Use with E9-1281	**E9-1280**
	Bull Nose Face Cover 2-1/2” x 2”	**E9-1293**		**Interior Cover** For 90° Outside Corner Use with E9-1280	**E9-1281**
	Glazing Adaptor For 1/4” glazing	**E9-1220**		**Interior Cover** For 90° Outside Corner Use with E9-1280 For 6-3/4” Depth Only	**E9-3548**
	Glazing Adaptor For 1/2” Glazing (Used with E9-1265)	**E9-1232**		**SSG Glazing Adaptor** For 1/4” Glazing	**E9-3422**
	Flush Pocket Filler For 1” glazing	**E9-1253**		**SSG Glazing Adaptor** For 1/2” Glazing (Used with E9-1265)	**E9-1276**
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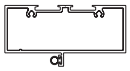
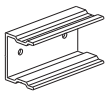
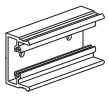
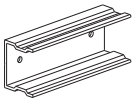
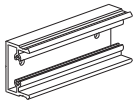
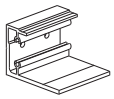
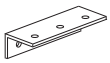
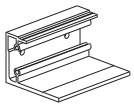
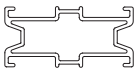
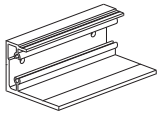
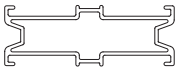
	Perimeter Anchor For 1” Glazing	**E9-1223**		**SSG Door Jamb Glazing Adaptor** For 1” Glazing	**E9-1269**

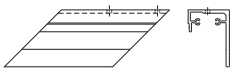
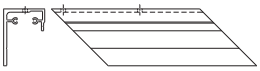
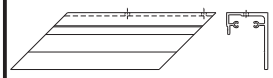
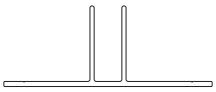
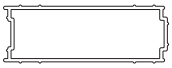
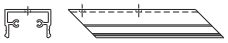
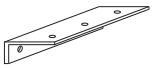
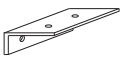
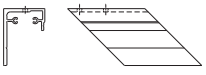
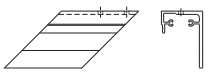
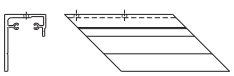
FRAMING MEMBERS

	SSG Door Jamb Glazing Adaptor For 1/4" Glazing	**E9-1270**		**Door Jamb** Use with AS-0417	**E9-1224**
	**Single Acting Transom Bar** Elastomer Weathering E2-0051 Included	**AS-0402**		**Snap-In Door Stop** Elastomer Weathering E2-0051 Included Use with E9-1224	**AS-0417**

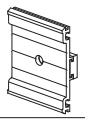
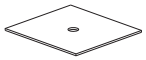
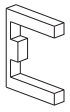
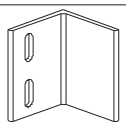
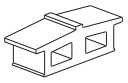
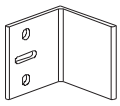
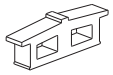
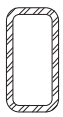
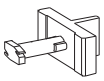
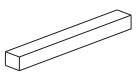
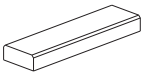
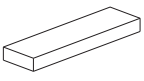
ACCESSORIES

	Standard Shear Block For E9-1235, E9-1250, & E9-3537, 3.125" Long	**E1-3503**		**Shear Block** (For E-Slot) For E9-1215, E9-1225, E9-1246, 4.375" Long	**E1-1200**
	**Standard Shear Block** For E9-1215, E9-1225, E9-1246, 4.375" Long	**E1-3504**		**Shear Block** (For E-Slot) For E9-1242, 6.000" Long	**E1-1236**
	**Standard Shear Block** For E9-1242, 6.000" Long	**E1-3506**		**Shear Clip** For E9-1257 & E9-1259 2.736" Long	**E1-1214**
	**"J" Anchor** For E9-1235, E9-1250, & E9-3537, 3.125" Long	**E1-3501**		**Shear Clip** For E9-1255 & E9-1258 3.986" Long	**E1-1213**
	**"J" Anchor** For E9-1215, E9-1225, E9-1246, 4.375" Long	**E1-3502**		**Mullion Splice Sleeve** Use with E9-3401 & E9-3402	**E1-3548**
	**"J" Anchor** For E9-1242, 6.000" Long	**E1-3505**		**Mullion Splice Sleeve** Use with E9-3426	**E1-3427**
	Shear Block (For E-Slot) For E9-1235, E9-1250, & E9-3537, 3.125" Long	**E1-1206**		**Mullion Splice Sleeve** Use with E9-1235, E9-1250 & E9-3537	**E1-1212**

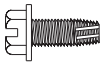
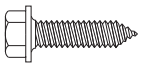
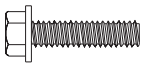
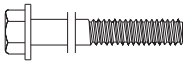
ACCESSORIES

	Mullion Splice Sleeve Use with E9-1266	**E1-1211**		**"J" Anchor for 90° Outside Corner (LH)** For E9-1215, E9-1225, E9-1246, 7.437" Long	**E1-3502B**
	Mullion Splice Sleeve Use with E9-1215 & E9-1225	**E1-1201**		**"J" Anchor for 90° Outside Cor. (RH)** For E9-1242 9.735" Long	**E1-3505A**
	Mullion Splice Sleeve Use with E9-1265	**E1-1210**		**"J" Anchor for 90° Outside Cor. (LH)** For E9-1242 9.735" Long	**E1-3505B**
	Mullion Splice Sleeve Use with E9-1242	**E1-1299**		**Mullion "T" Anchor (Standard)** For E9-3402 4.866" Long	**E1-1208**
	**Mullion Splice Sleeve** Use with E9-3535	**E1-1365**		**Mullion "T" Anchor** For E9-1266 3.260" Long	**E1-1223**
	Shear Block for 90° Outside Corner For E9-1235, E9-1250, & E9-3537, 5.794" Long	**E1-3503A**		**Mullion "T" Anchor** For E9-3512 & E9-3423 3.366" Long	**E1-1229**
	**Shear Block for 90° Outside Corner** For E9-1215, E9-1225, E9-1246, 7.562" Long	**E1-3504A**		**Mullion "T" Anchor** For E9-1265 & E9-3401 4.780" Long	**E1-1222**
	Shear Block for 90° Outside Corner For E9-1242 9.860" Long	**E1-3506A**		**Mullion "T" Anchor** For E9-3535 & E9-3426 6.328" Long	**E1-1278**
	**Shear Clip for 90° Outside Corner** For E9-1255 & E9-1258 7.135" Long	**E1-1213A** **E1-1213B**		**Mullion "F" Anchor** For E9-1266 3.260" Long	**E1-1235**
	**Shear Clip for 90° Outside Corner** For E9-1257 & E9-1259 5.369" Long	**E1-1214A** **E1-1214B**		**Mullion "F" Anchor** For E9-1235, E9-1250 & E9-3537, 3.462" Long	**E1-1232**
	**"J" Anchor for 90° Outside Corner (RH)** For E9-1235, E9-1250, & E9-3537, 5.669" Long	**E1-3501A**		**Mullion "F" Anchor** For E9-1265 & E9-3401 4.780" Long	**E1-1234**
	**"J" Anchor for 90° Outside Corner (LH)** For E9-1235, E9-1250, & E9-3537, 5.669" Long	**E1-3501B**		**Mullion "F" Anchor** For E9-1215 4.866" Long	**E1-1233**
	**"J" Anchor for 90° Outside Corner (RH)** For E9-1215, E9-1225, E9-1246, 7.437" Long	**E1-3502A**		**Mullion "F" Anchor** For E9-1225 & E9-1246 4.960" Long	**E1-1231**

ACCESSORIES

	Mullion "F" Anchor For E9-1242 6.453" Long	**E1-1240**		**Standard Joint Plug** For 1" Glazing EPDM Sponge	**E2-0102**
	**Temporary Glass Retainer** 2" Long	**E1-1294**		**Joint Plug** For slide in mullion at end bays, 1/4" glazing Use with E2-0123	**E2-0129**
	**Captured Mullion End Cap** For Insulated Glazing 2.500" x 2.313" x 0.050"	**E1-1286**		**Joint Plug** For slide in mullion at end bays, 1" glazing Use with E2-0123	**E2-0124**
	Stainless Steel Washer To be used as end cap	**FW-2500-SS**		**Joint Plug** Use with E9-1223 & E9-1231	**E2-0505**
	Face Cover Splice Sleeve For E9-1206	**E1-1202**		**E-Slot Plug** For slide in mullion at end bays	**E2-0123**
	**Wind Load Anchor** Steel with Zinc Oxide Paint Refer to Shop Drawings for Anchor Dimensions	**E1-1204*** Project Specific		**SSG Joint Plug** For 1" Glazing	**E2-0245**
	**Dead Load Anchor** Steel with Zinc Oxide Paint Refer to Shop Drawings for Anchor Dimensions	**E1-1205*** Project Specific		**SSG Joint Plug** For 1/4" Glazing	**E2-0279**
	**Reinforcing Steel** 2" x 4" x 1/4" For 5-1/4" Back Verticals Steel with Zinc Oxide Paint	**E1-0162**		**Temporary Glass Retainer** For 1" Glazing	**E3-0001**
	Setting Block For 1/4" Glazing EPDM with Pressure Sensitive Adhesive	**E2-0112**		**Temporary Glass Retainer** For 1/4" Glazing	**E3-0006**
	**Side Block** For 1/4" Glazing EPDM with Pressure Sensitive Adhesive	**E2-0113**		**Isolator Tape** 1/8" x 7/16" Use with Perimeter Pressure Plate	**E2-0239**
	**Setting Block** For 1" Glazing EPDM with Pressure Sensitive Adhesive	**E2-0104**		**Anchor Slip Pad** For Dead Load & Wind Load Anchors	**E3-0103**
	**Side Block** For 1" Glazing EPDM with Pressure Sensitive Adhesive	**E2-0105**		**Interior Glazing Spacer** Silicone Use with SSG Verticals	**E2-0126**
	Standard Joint Plug For 1/4" Glazing EPDM Sponge	**E2-0125**		**Exterior Glazing Gasket** Silicone	**E2-0127**

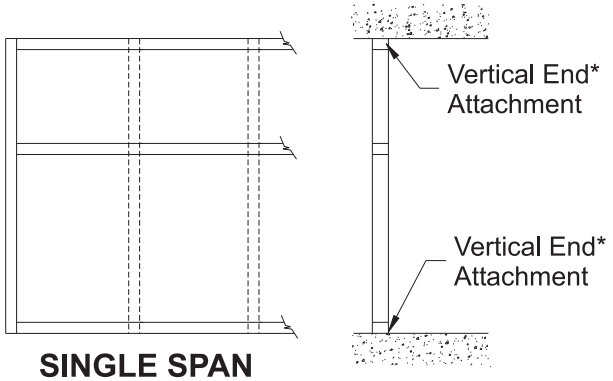
ACCESSORIES

	Interior Glazing Gasket Silicone	**E2-0128**		**1/4”-20 x 5/8” HWHS** Type F, Zinc Plated Steel For Attachment of Shear Block to Vertical	**HF-2510 -W1**
	Interior Glazing Spacer (5/16” Depth) Silicone Use with SSG Verticals	**E2-0261**		**1/4”-20 x 1” HWHS** Type F, Zinc Plate Steel, For Attachment of Shear Block to Vertical with Steel Reinforcing	**HF-2516 -W1**
	#8 x 3/8” PHSMS Zinc Plated Steel For Attachment of Glazing Adaptors	**PC-0806**		**1/4”-20 x 1” HWHMS** Zinc Plate Steel For Attachment of Pressure Plate to Mullion	**HD-2516 -W3**
	#10-24 x 5/8” PHSMS Type F, Stainless Steel For Attachment of Glazing Adaptor	**PF-1010 -SS**		**1/4”-20 x 1” HWHMS** Zinc Plate Steel For Attachment of “J” Anchor at Jamb	**HM-2516**
	#8 x 1/2” FHSMS Type AB, Zinc Plated Steel, Undercut For Attachment of Face Cover Splice Sleeve	**FC-0808**		**1/4”-20 x 3-1/2” HWHMS** Zinc Plate Steel For Attachment of “J” Anchor at Intermediate Vertical	**HM-2556**
	#12 x 3/4” FHSMS Type AB, Zinc Plt. Stl., Exposed Fasteners For Attachment of Horizontal to Shear Block	**FC-1212**		**1/4”-20 Nut HHMS** Zinc Plate Steel, For Attachment of “J” Anchor at Intermediate Vertical & Jamb	**HM-2500**
	#12 x 1-1/4” FHSMS Type AB, Zinc Plt. Stl., Concealed Fasten. For Attachment of Horizontal to Shear Block	**FC-1220**		**1/4” Flat Washer** Zinc Plate Steel, For Attachment of “J” Anchor at Intermediate Vertical & Jamb	**WW-2500**
	#10 x 5/8” FHSMS Type AB, Zinc Plated Steel For Attachment of Mullion End Cap E1-1288	**FC-1010**		**1/4” Lock Washer** Zinc Plate Steel, For Attachment of “J” Anchor at Intermediate Vertical & Jamb	**WS-2500**
	#14 x 5/8” FHSMS Type AB, Zinc Plated Steel, For Attachment of Mullion End Caps E1-1286 & FW-2500-SS	**FC-1410**			

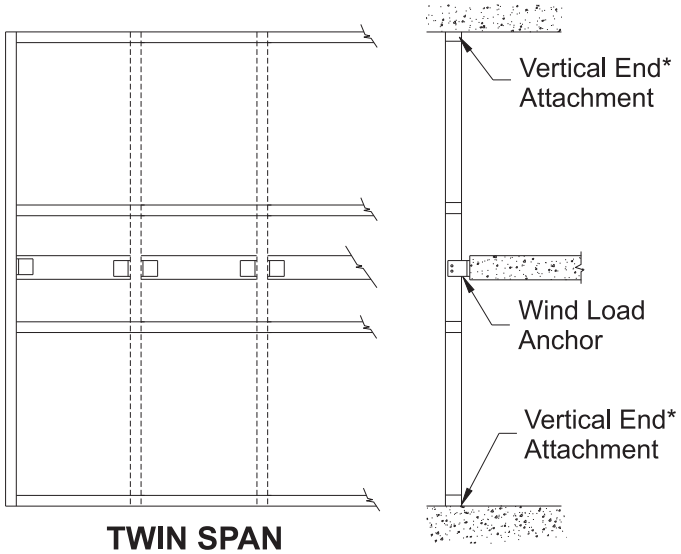
FRAME FABRICATION

FRAME TYPES / ANCHORING METHODS

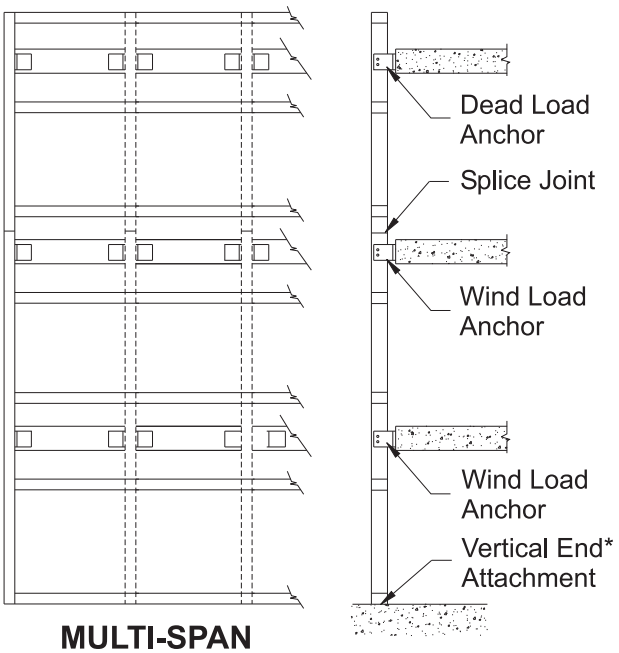
The following is a guideline for common types of frames. Refer to shop drawings for exact layout of frames.



SINGLE SPAN



TWIN SPAN



MULTI-SPAN

Smaller units may be assembled on the ground and tipped in place. Larger units require being stick assembled in place.

Note: If YKK does not prepare the shop drawings for the project, a qualified engineer must approve all anchors and mullions for wind load and dead load.

All anchors must be attached to structurally sound material that will accommodate the anchor reactions.

* Vertical end attachment will be continuous perimeter anchor, “J” anchor, or mullion end anchor.

Fabrication of YCW 750 SSG varies depending on the type of vertical end attachment required for a given project:

Perimeter Anchors are for low load anchoring conditions (maximum 500lb. end load reaction): E9-1248, E9-1223, & E9-1231

“J” Anchors are for medium to high load conditions: E1-3501, E1-3502, & E1-3505.

Mullion End Anchors “F” & “T” are for high load conditions. See Accessories on **Page-5**.

FRAME FABRICATION

FRAME TYPES / ANCHORING METHODS

Using Perimeter Anchors:

-Jamb mullions must be notched as shown in **Detail 1** on **Page 9**.

Using Mullion End Anchors:

YCW 750 SSG has three possible end anchoring conditions: “J”, “T”, and “F”.

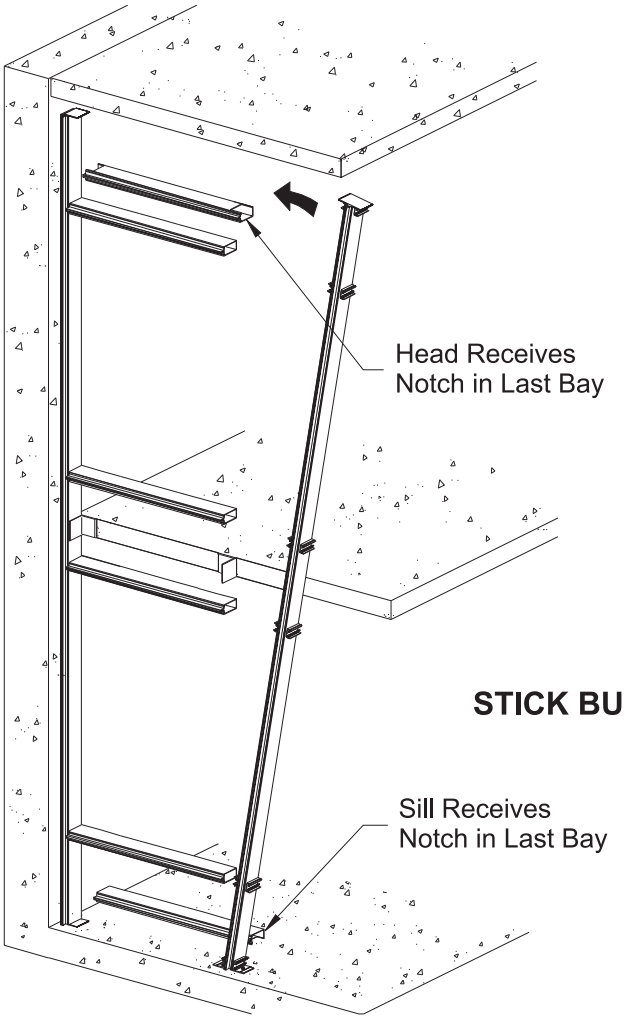
-”J” anchors are used with jambs and intermediate verticals at the sill only.
-”T” anchors are used with intermediate verticals at the head and sill.
-”F” anchors are used with jamb mullions at the head and sill.
-Anchor usage depends on end reaction, stress, and attachment.

Mullions should be pre-assembled with shear blocks/clips, end anchors, and steel or aluminum reinforcing if necessary.

Framing Members for Stick Build:

-Head and sill members must be notched as shown **Detail 9** on **Page 15** to clear the mullion end anchors.
-Closed horizontal members are used at all intermediate locations except at end bays.
-Open back intermediate horizontals are used at end bays to clear the shear clips.

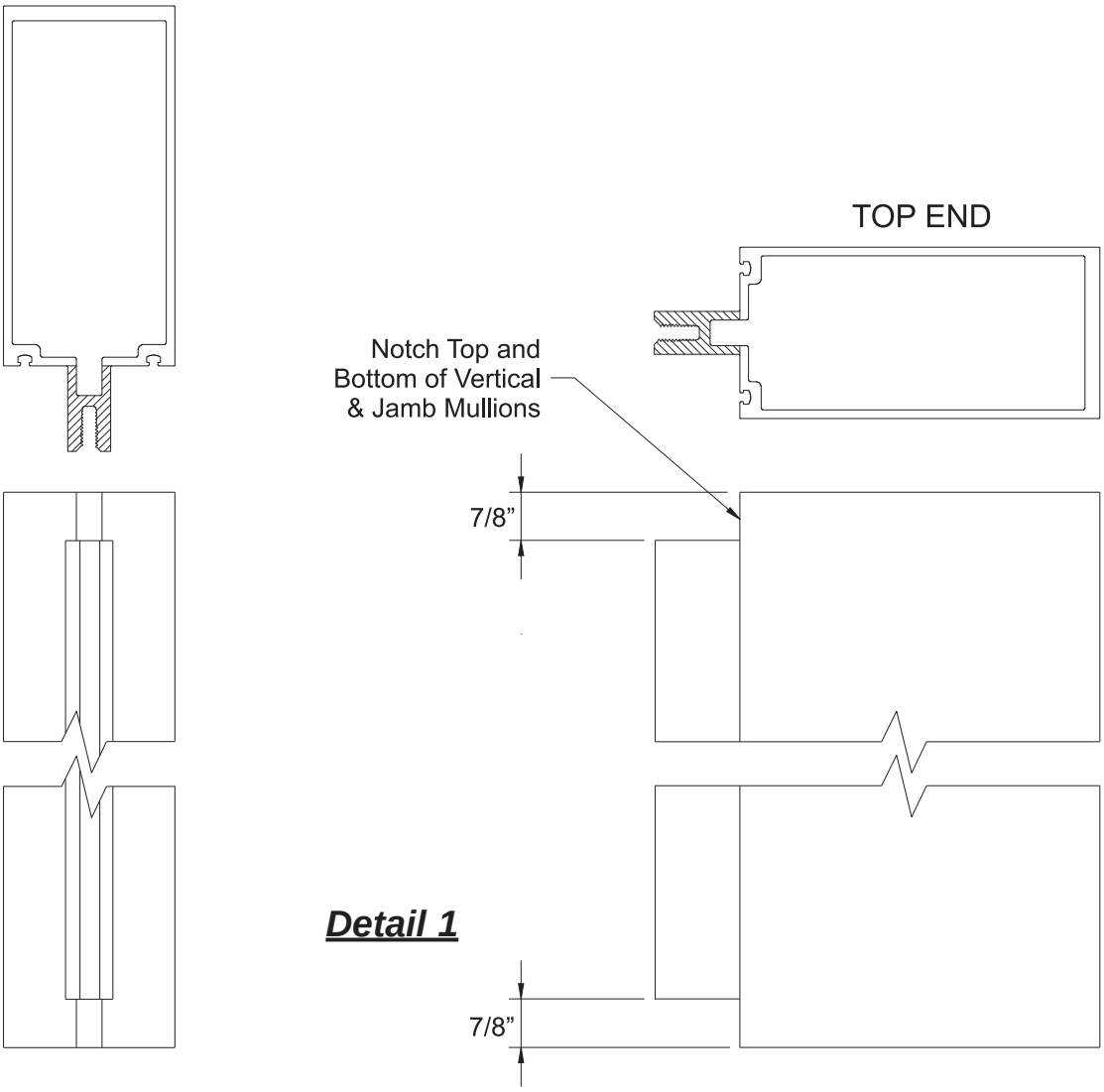
Note: When using stick build construction, check overall frame width every fifth mullion as the wall is installed to prevent the buildup of cumulative tolerance errors.



STICK BUILD

FRAME FABRICATION

FABRICATE VERTICAL MULLIONS



Detail 1

Step 1

-Cut all vertical and jamb mullions to dimensions as shown on shop drawings. Allow for 1/2” caulk joint around the frame & 1/2” joint at vertical splices.

Step 2

-If you are using continuous perimeter anchors, E9-1223 or E9-1248, the top and bottom of jamb mullions must be notched as shown in **Detail 1**.

Note: **Do not** notch jamb mullions when using mullion end anchors: “J”, “T”, or “F”.

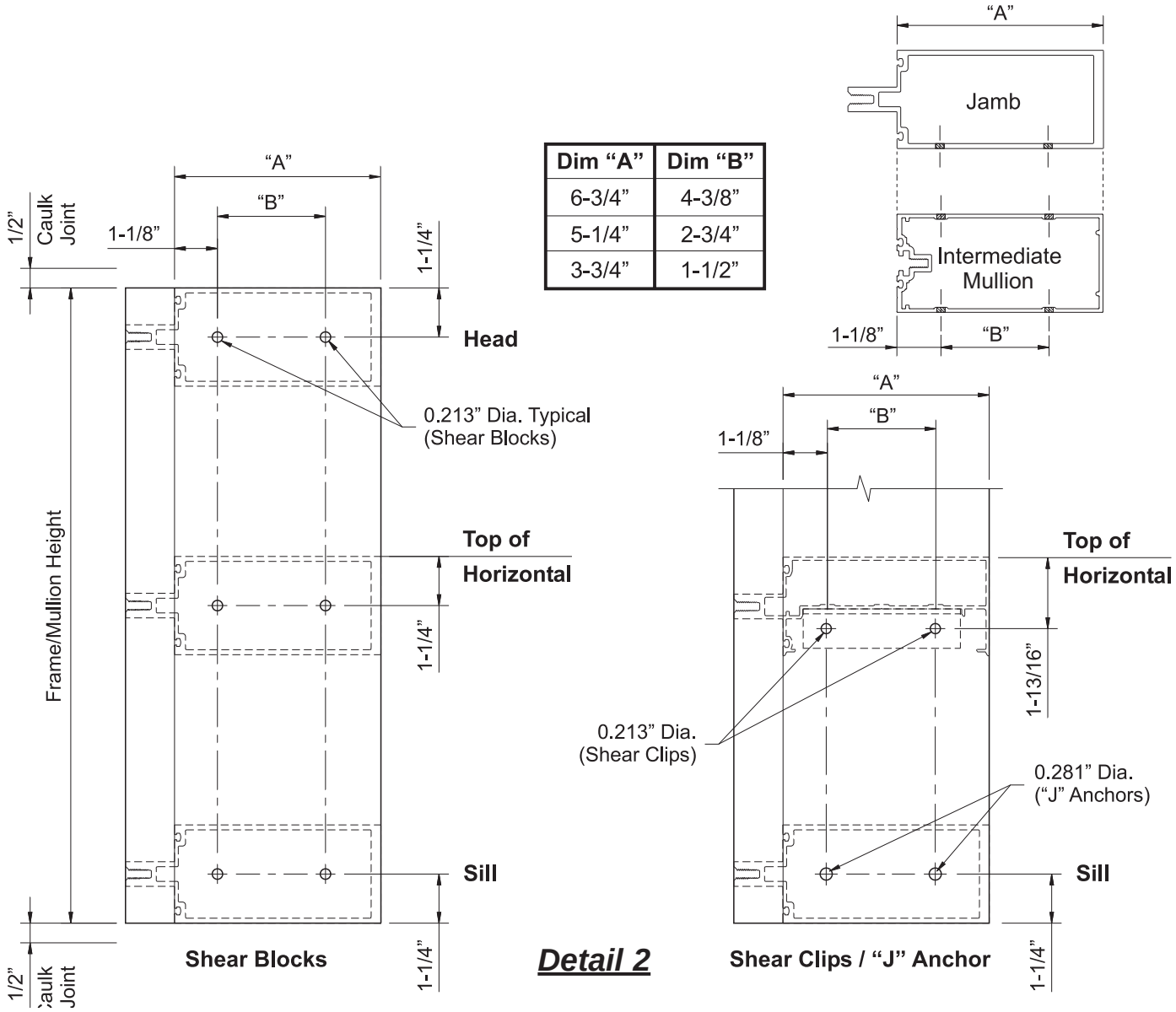
FRAME FABRICATION

STEP 3
FABRICATE VERTICAL MULLIONS

-Mullion hole locations for shear blocks, shear clips, and “J” anchors are shown below.
-Drill 0.213” dia. (#3 drill bit) holes for shear block/clip attachment at the locations indicated.
Drill 0.281” dia. (#9/32 drill bit) holes for “J” anchor attachment at the sill.
See **Detail 2**.

Note: Hole locations for shear clips, E1-1213 & E1-1214, are not the same as for shear blocks and “J” anchors.

Dim “A”	Dim “B”
6-3/4”	4-3/8”
5-1/4”	2-3/4”
3-3/4”	1-1/2”



Detail 2

FRAME FABRICATION

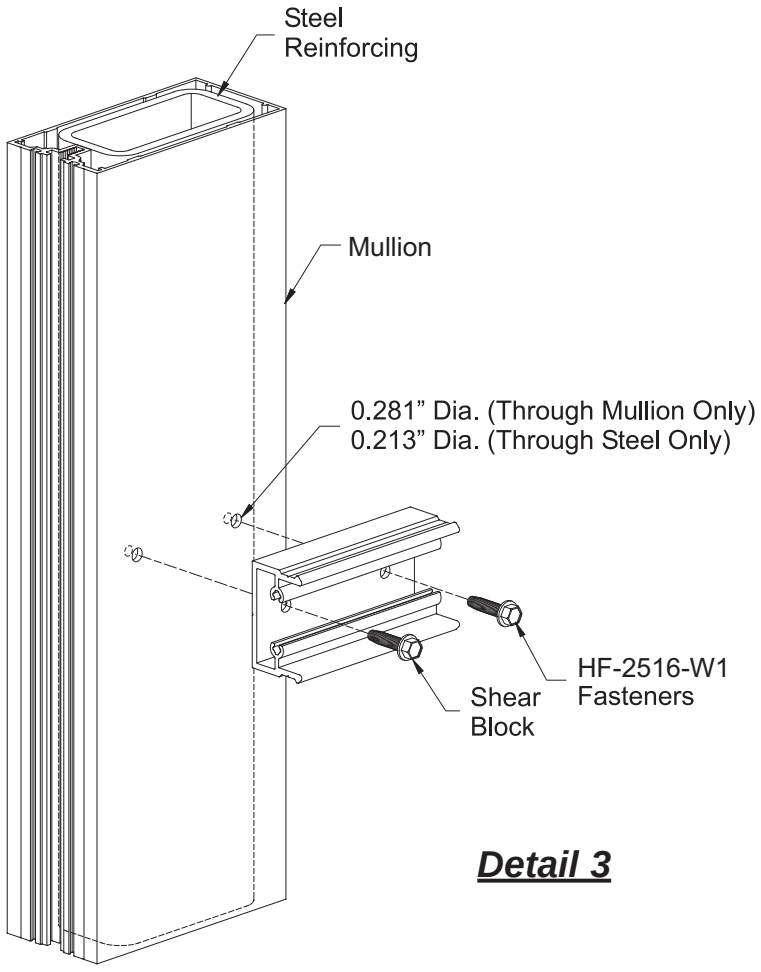
STEP 4
USING ALTERNATE REINFORCING

Engineering calculations may require the vertical mullions to be reinforced with either steel or aluminum.

-Steel reinforcing is always fastened through the shear blocks.
-Slide the steel reinforcing into the mullion and into position.
-Drill a 0.281” diameter (#9/32 bit) hole in the vertical mullion being careful not to drill a hole in steel reinforcing.
-Drill a 0.213” diameter (#3 bit) hole in the steel reinforcing through the previous holes.
-Attach the shear blocks to the mullion and steel with two HF-2516 fasteners per block.

See **Detail 3**.

Note: Exact size of reinforcing to be determined by a qualified engineer.



Detail 3

FRAME FABRICATION

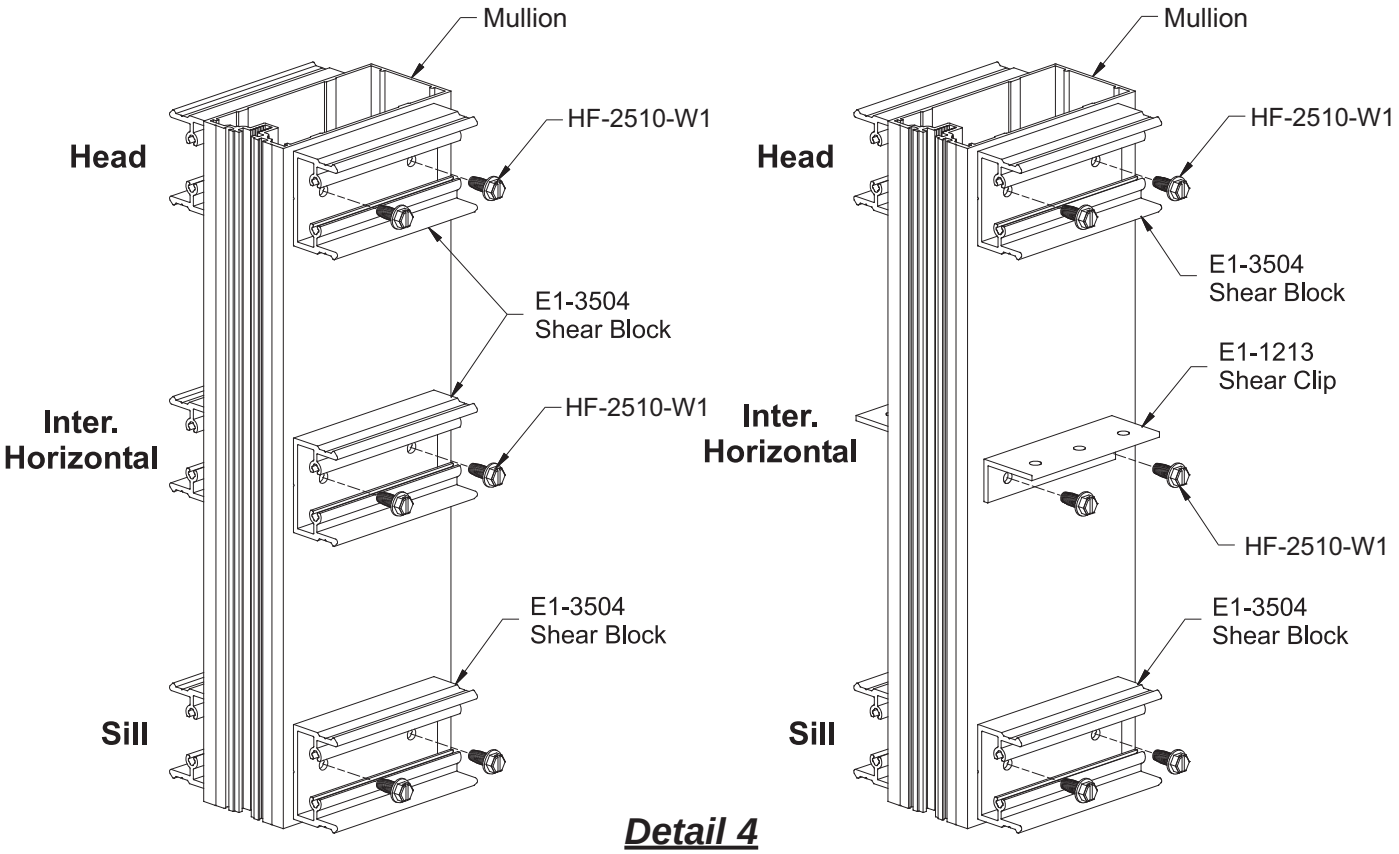
STEP 5
ATTACH SHEAR BLOCKS/CLIPS FOR HORIZONTALS

Shear blocks are used to attach one piece horizontal members to the jamb and vertical mullions:
- E1-3503 for 3-3/4” back members.
- E1-3504 for 5-1/4” back members.
- E1-3506 for 6-3/4” back members.

Shear clips are used to attach two piece intermediate horizontal members to the jamb and vertical mullions:
- E1-1213 for 5-1/4” back members.
- E1-1214 for 3-3/4” back members.

-Attach the shear blocks/clips to jambs and verticals with two HF-2510 fasteners per block. See **Detail 4**.

Note: See **Step 4** on the previous page when using reinforcing.



Detail 4

FRAME FABRICATION

STEP 6
ATTACH “J” ANCHORS

In addition to anchoring the curtain wall frame to the structure, “J” anchors are used to attach sill members to jamb and vertical mullions:

E1-3501 for 3-3/4” back members.
E1-3502 for 5-1/4” back members.
E1-3505 for 6-3/4” back members.

Note: “J” anchors are used at the sill only.

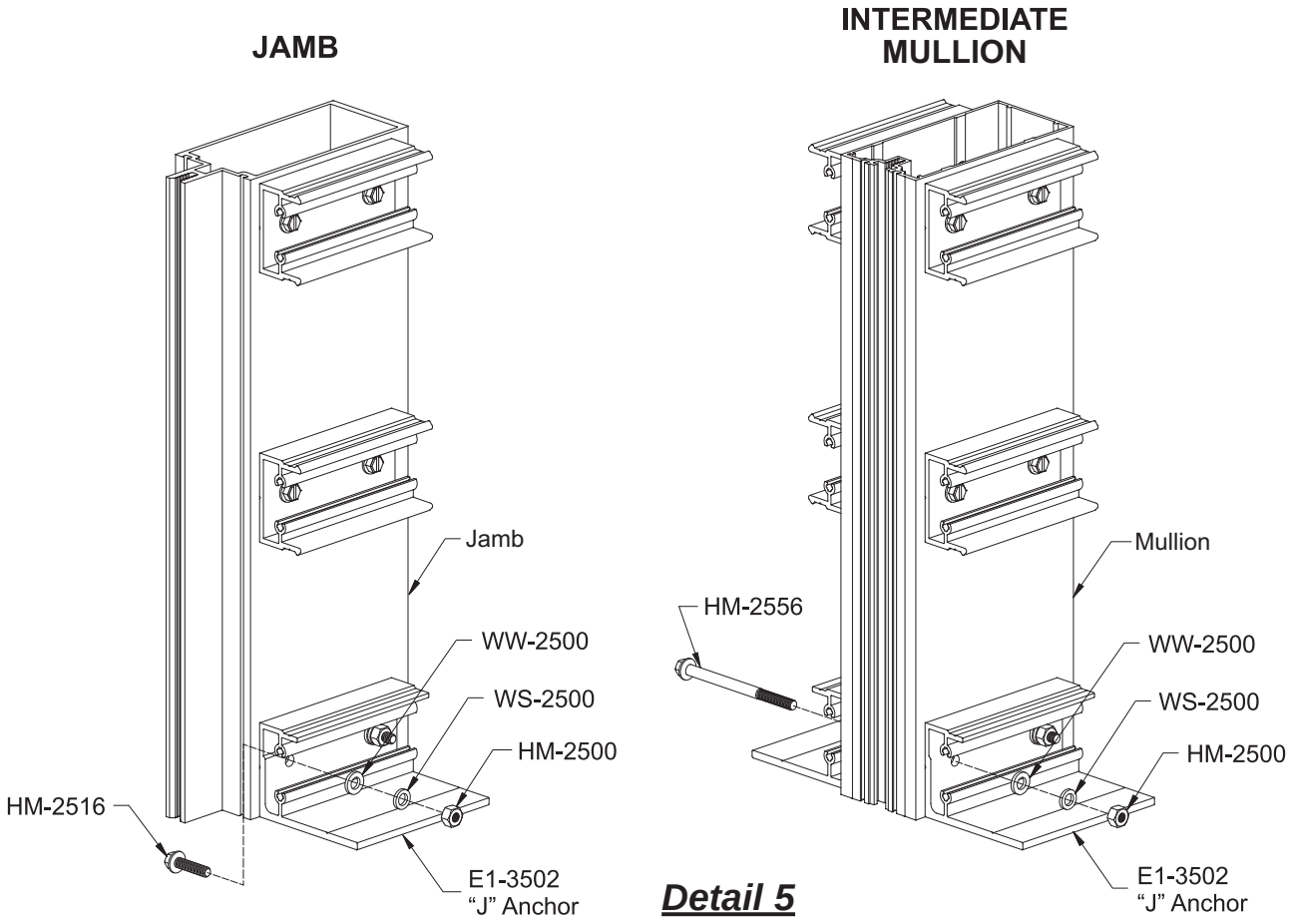
Attach “J” anchors at jambs:

-Align the “J” anchor with the mullion and insert the HM-2516 bolts through the inside of the mullion and out the “J” anchor.
-Install 1/4” flat and lock washers between the anchor and HM-2500 hex nuts.

Attach “J” anchors at intermediate verticals:

-Align the “J” anchors and insert the HM-2556 bolts through both anchors and the mullion.
-Install 1/4” flat and lock washers between the anchor and HM-2500 hex nuts.

See **Detail 5**.



Detail 5

FRAME FABRICATION

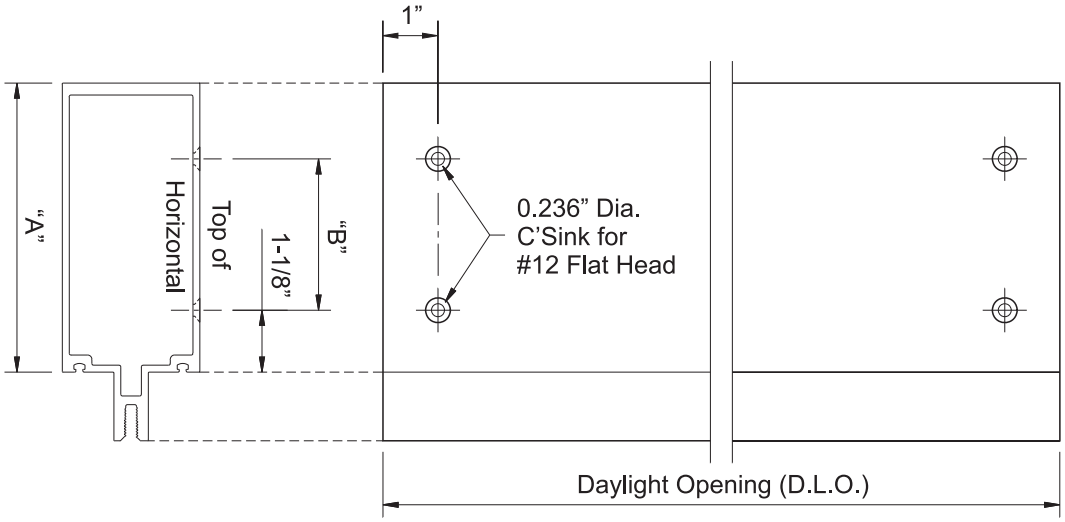
STEP 7
FABRICATE HORIZONTAL MEMBERS

-Cut all horizontal members to the daylight opening as shown in shop drawings.
-Horizontal members must be fabricated as shown below to attach to shear blocks or clips.

Horizontals with Exposed Fasteners:

-Layout hole locations on the top of the horizontal at both ends as shown below.
-Drill 0.236” diameter (#B bit) holes and countersink for #12 flat head fasteners.
See **Detail 6**.

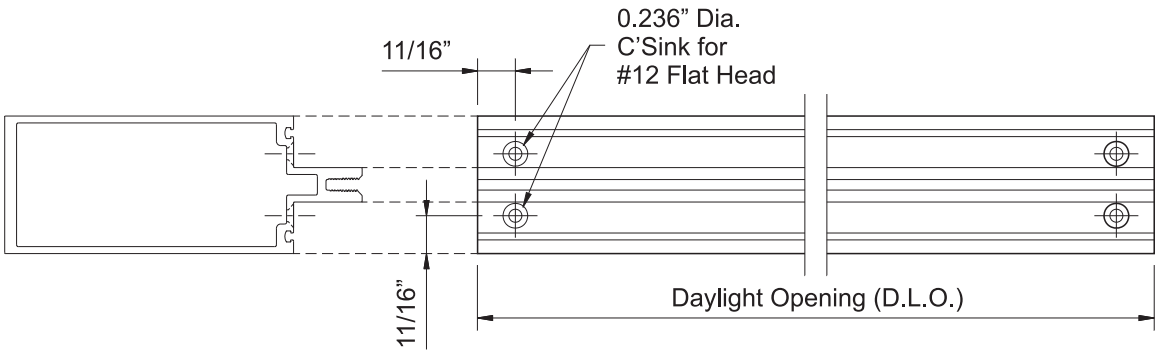
Dim “A”	Dim “B”
6-3/4”	4-3/8”
5-1/4”	2-3/4”
3-3/4”	1-1/2”



Detail 6

Horizontals with Concealed Fasteners:

-Layout hole locations on the face of the horizontal at both ends as shown below.
-Drill 0.236” diameter (#B bit) holes and countersink for #12 flat head fasteners.
See **Detail 7**.



Detail 7

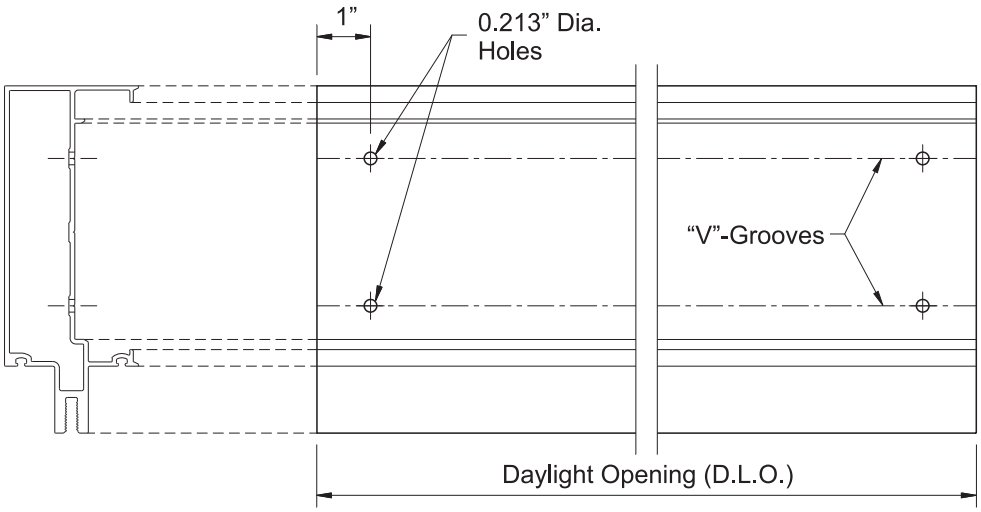
FRAME FABRICATION

STEP 7 (Continued)
FABRICATE HORIZONTAL MEMBERS

Two Piece Horizontals:

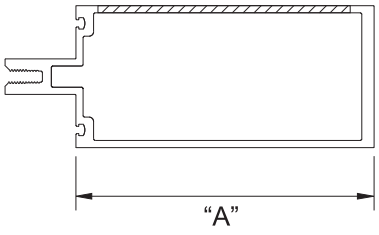
-Layout hole locations on the bottom of the horizontal along the “V”-grooves at both ends.
-Drill 0.213” diameter (#3 bit) holes at each location.
Be careful not to penetrate the outer wall of the mullion.
See **Detail 8**.

Detail 8



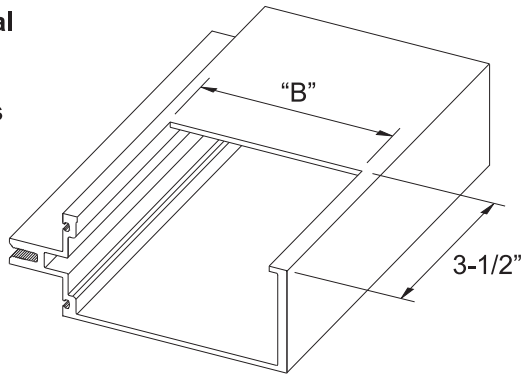
If Mullion End Anchors Are Used
Head and Sill Members Require Additional Fabrication:

-Head and sill members must be notched out at each end to clear mullion end anchors and anchor bolts.
-See **Detail 9** below for notch dimensions.



Dim “A”	Dim “B”
6-3/4”	6-1/4”
5-1/4”	4-3/4”
3-3/4”	3-1/4”

Notch Horizontal Ends to Clear End Anchors & Anchor Bolts



Detail 9

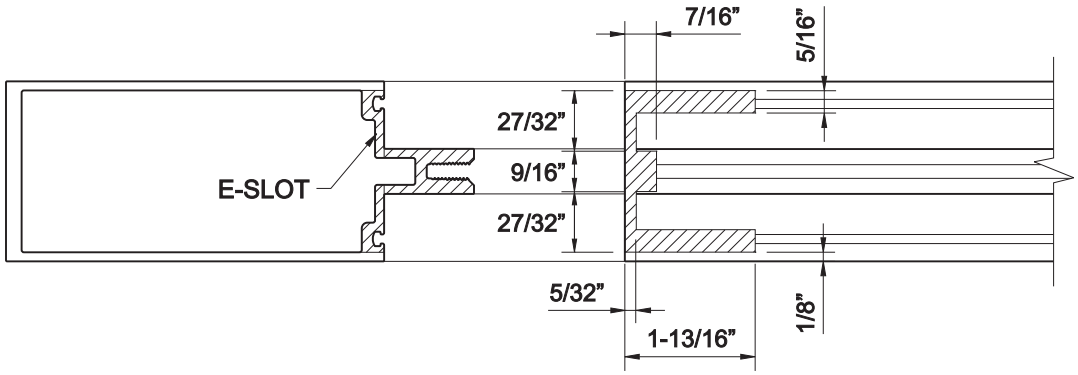
FRAME FABRICATION

STEP 7 (Continued)
FABRICATE HORIZONTAL MEMBERS

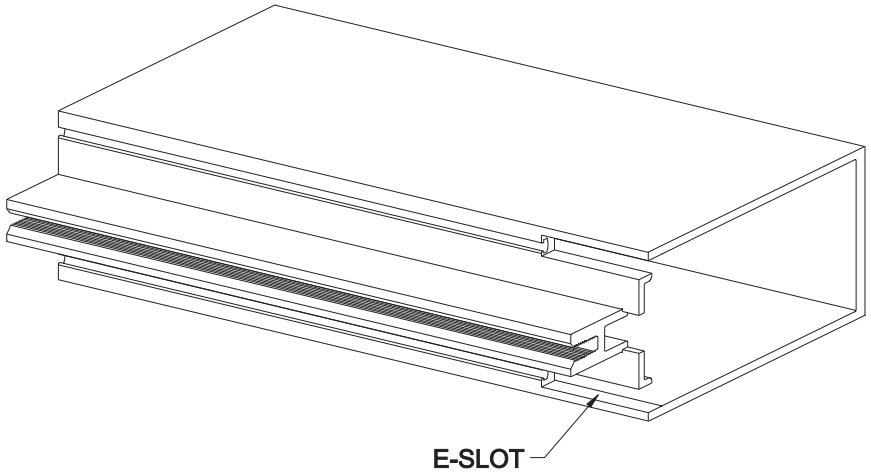
One Piece Horizontals at End Bays (E-SLOT):

When using one piece horizontals at end bays, horizontals must slide in from the interior. In order to clear the shear blocks on the verticals:

-Notch the face and tongue of the horizontal at both ends as shown below. See **Detail 10**.



Detail 10

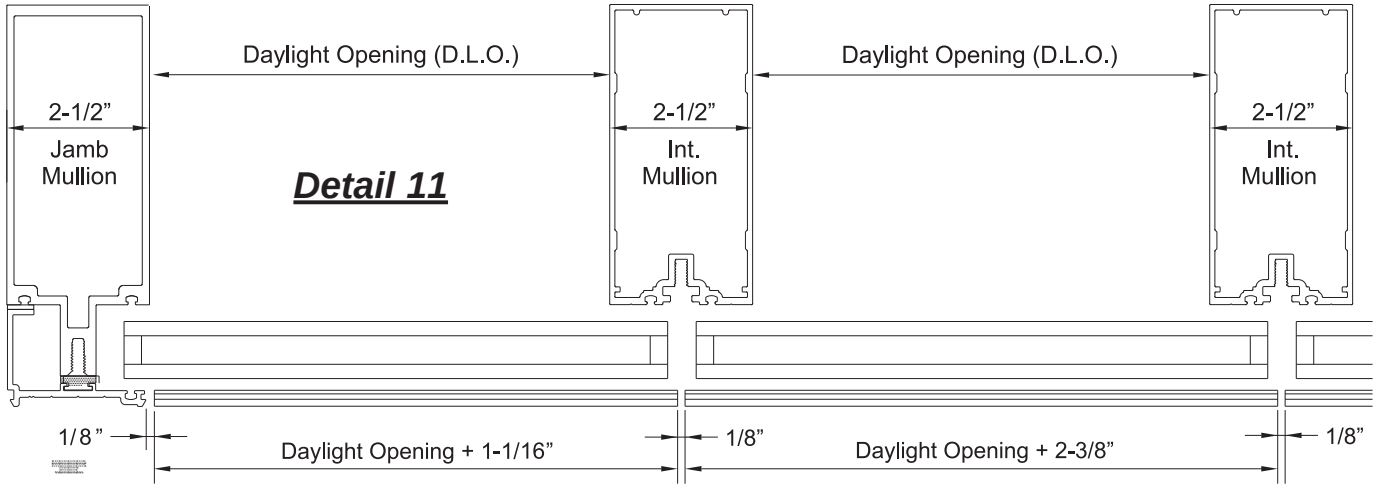


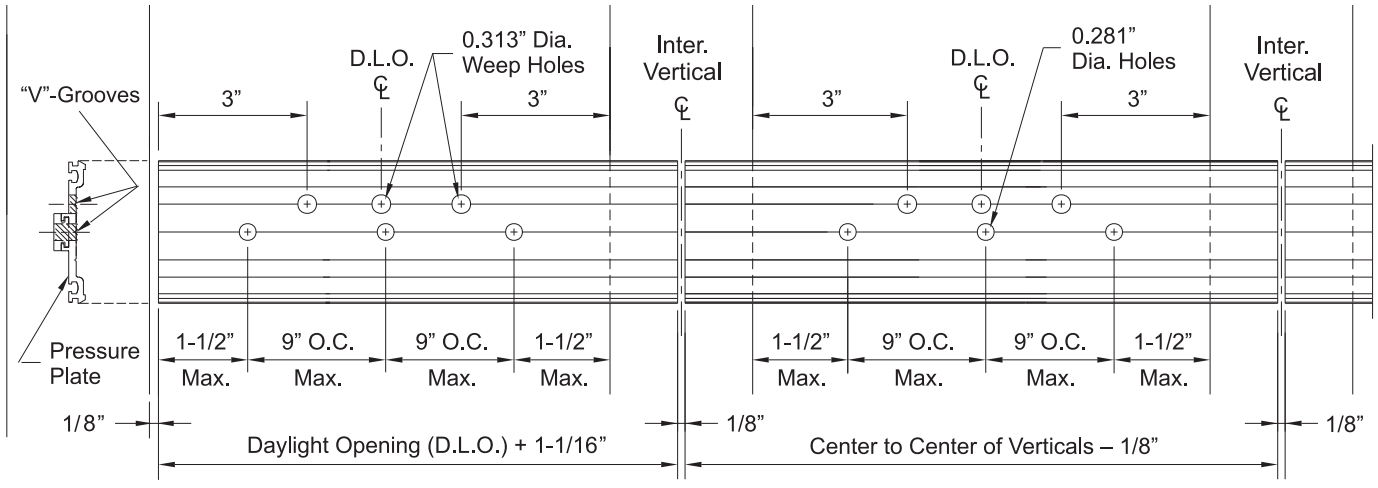
FRAME FABRICATION

STEP 8
FABRICATE PRESSURE PLATES

-Cut all jamb pressure plates to the same length as the jamb mullions.
-Drill additional holes if required to ensure that end holes are within 1-1/2” of each end.
-If jamb members are spliced, cut pressure plates to accommodate for 1/2” expansion joint as shown in **Step 10** on **Pages 19 & 20**.

-Cut horizontal pressure plates as shown in **Detail 11**.
  -Cut pressure plates between jamb and intermediate mullions to D.L.O. plus(+) 1-1/16”.
  -Cut pressure plates between intermediate verticals to D.L.O. plus(+) 2-3/8”.
  -For pressure plates spanning more than one bay, cut them to the centerline to centerline dimension between mullions minus(–) 1/8”.
-Pressure plate stock lengths have 0.281” dia. holes factory punched every 9”. Drill additional holes if required to ensure that end holes are within 1-1/2” of each end.
-Drill two 0.313” diameter weep holes 3” from each end and one at the centerline of the pressure plate for each lite of glass.



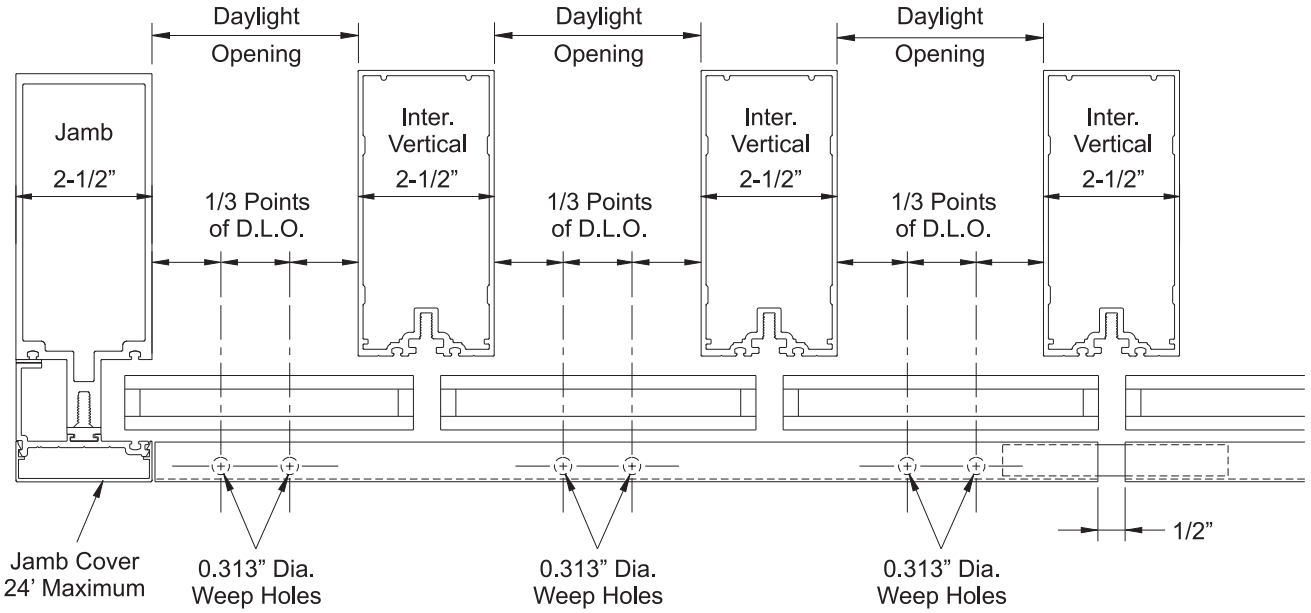


FRAME FABRICATION

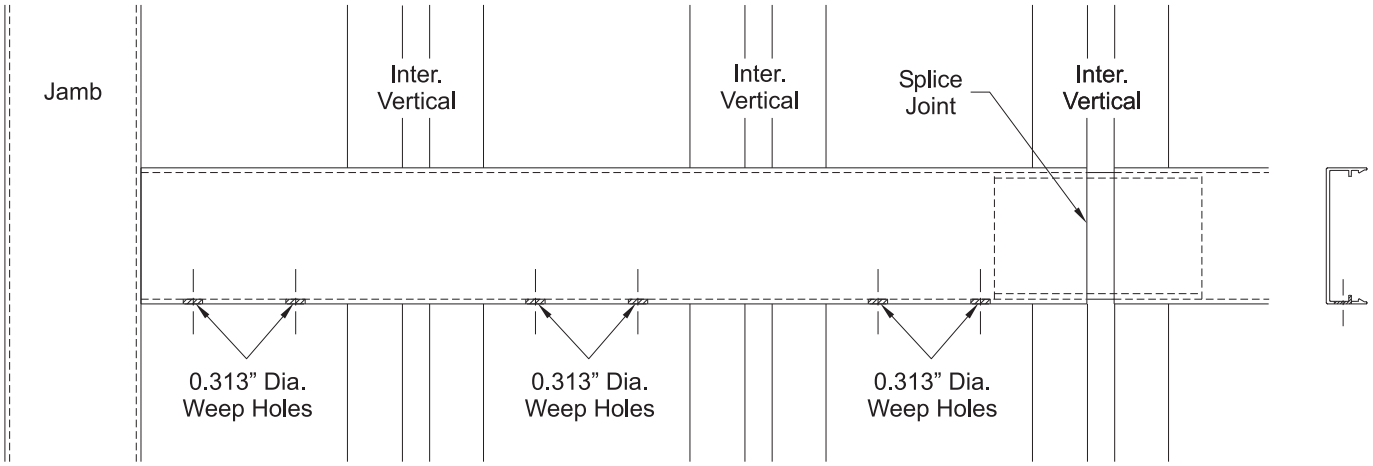
STEP 9
FABRICATE FACE COVERS

-Cut jamb face covers to the same length as the jamb mullions unless the mullions are spliced. If jamb mullions are spliced, cut jamb covers to accommodate for the 1/2" expansion joint as shown in **Step 10** on **Pages 19 & 20**.

-Cut horizontal covers 1/32" short of jamb mullion on jamb side of frame. Covers are to be spliced at every third light of glass at the centerline of vertical mullion. Optionally, covers may be spliced at every centerline of vertical mullions.
-Drill two 0.313" diameter weep holes as shown, at 1/3 points of each daylight opening. See **Detail 12**.



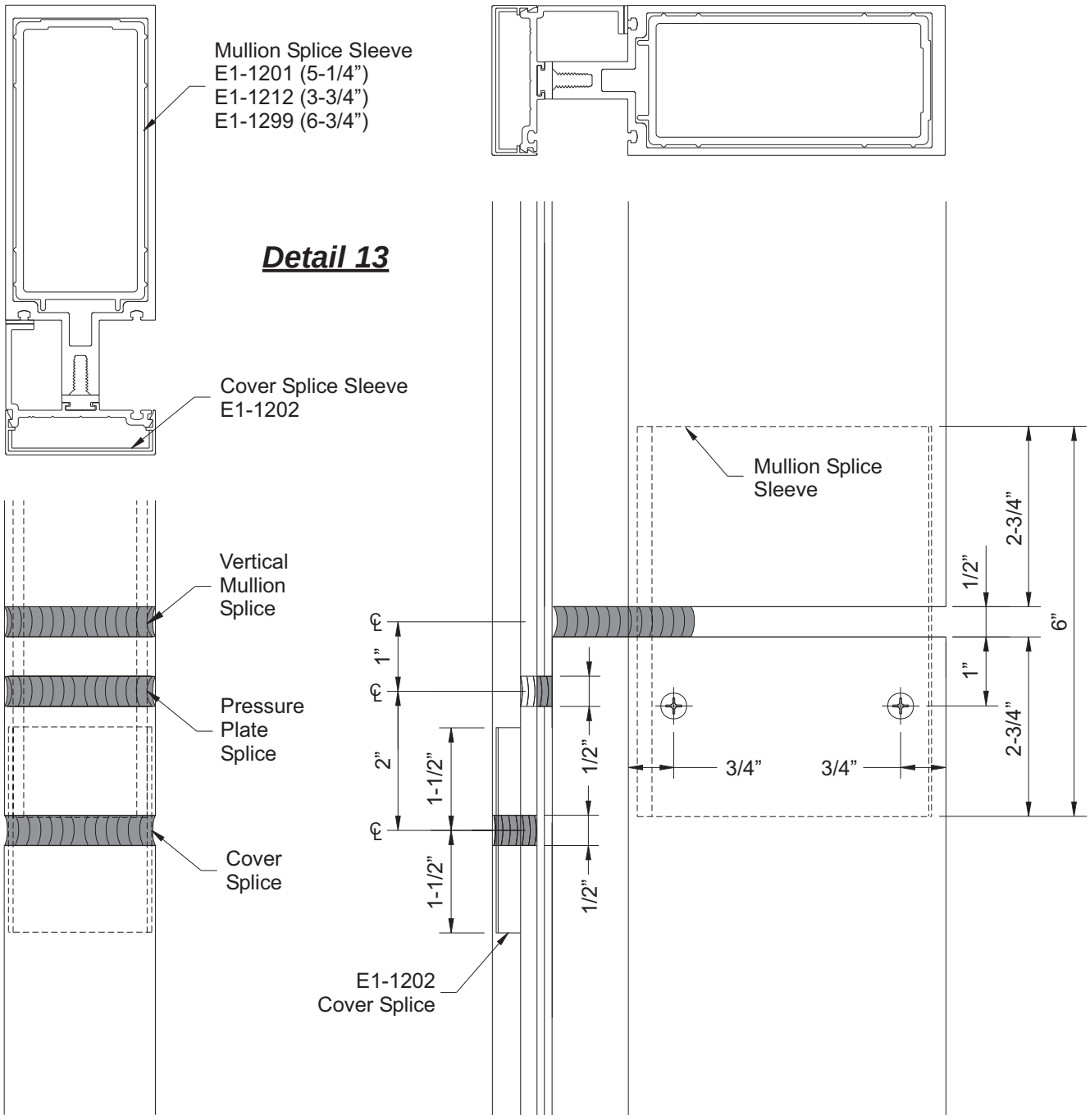
Detail 12



FRAME INSTALLATION

STEP 10
TYPICAL VERTICAL SPLICE

Stagger Mullion, Pressure Plate, and Cover Splice Joints as Shown Below.



FRAME INSTALLATION

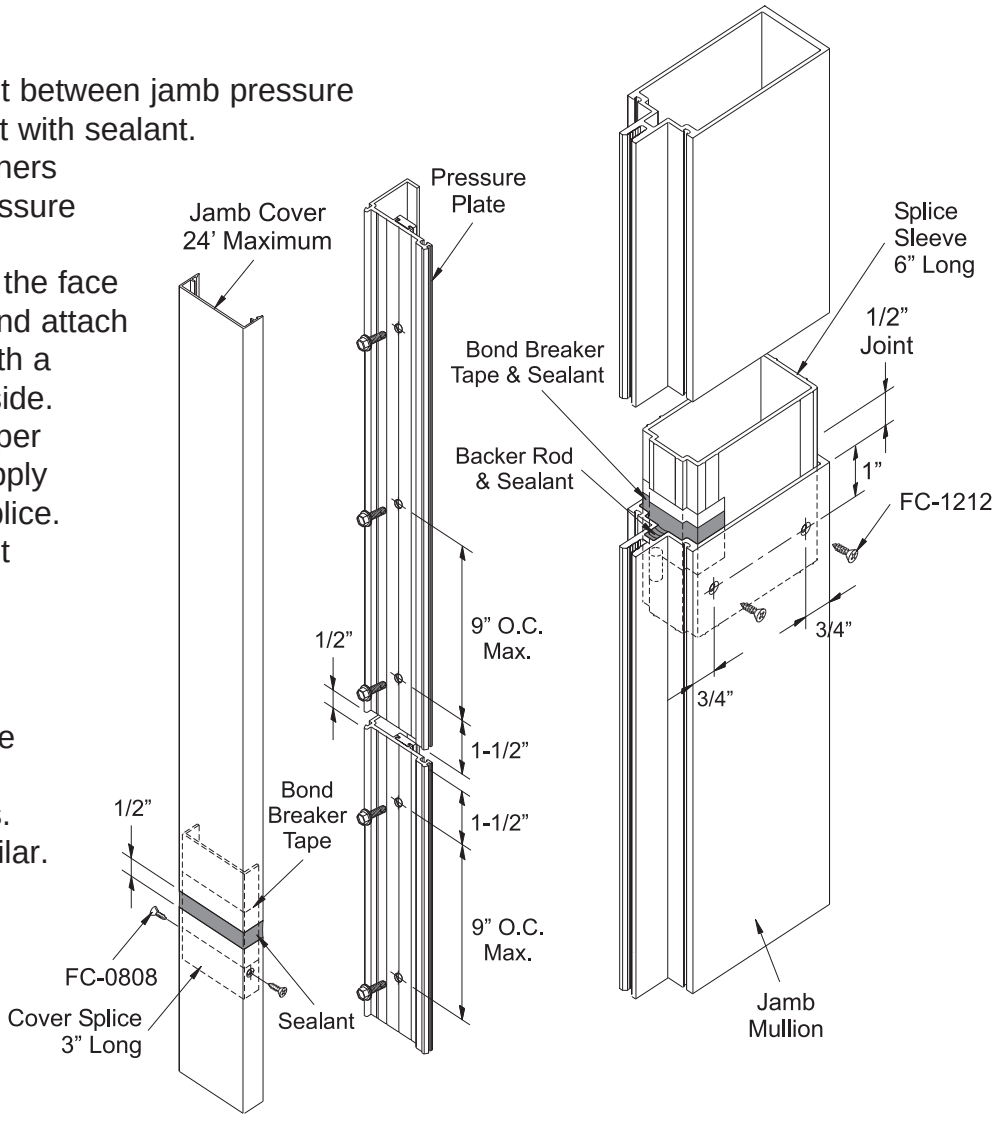
STEP 10 (Continued)
TYPICAL VERTICAL SPLICE

-Clean all surfaces as recommended by sealant manufacturer.
-Apply bond breaker tape to the face of the splice sleeve at its midpoint (3” from top or bottom).
-Lower the splice sleeve into top of lower mullion 2-3/4” and attach with two FC-1212 fasteners on both sides of the mullion. Screws should be installed 3/4” from the front and back of mullion and 1” down from the top.
-When using 1” glazing jamb mullions, stuff a small piece of backer rod 1/2” down the cavity behind mullion tongue and pump in sealant to fill the cavity.
-Apply non-curing sealant to the face of splice sleeve on the upper half.
-Carefully slide the upper mullion down onto the splice sleeve and place a 1/2” temporary shim between the mullions to properly locate them.
-Secure the upper mullion to the mid anchors and remove the temporary shims.
-Apply and tool sealant to the face and sides of the splice sleeve to create a water tight joint.

-Leave a 1/2” expansion joint between jamb pressure plate splices and fill the joint with sealant.
-Locate pressure plate fasteners 1-1/2” from each end of pressure plate splice as shown.
-Apply bond breaker tape to the face of the cover splice sleeve and attach it to the lower face cover with a FF-0808 fastener on each side.
-Prior to snapping on the upper portion of the face cover, apply sealant to the face of the splice.
-Leave a 1/2” expansion joint between face cover splices.

See **Details 13 & 14**.

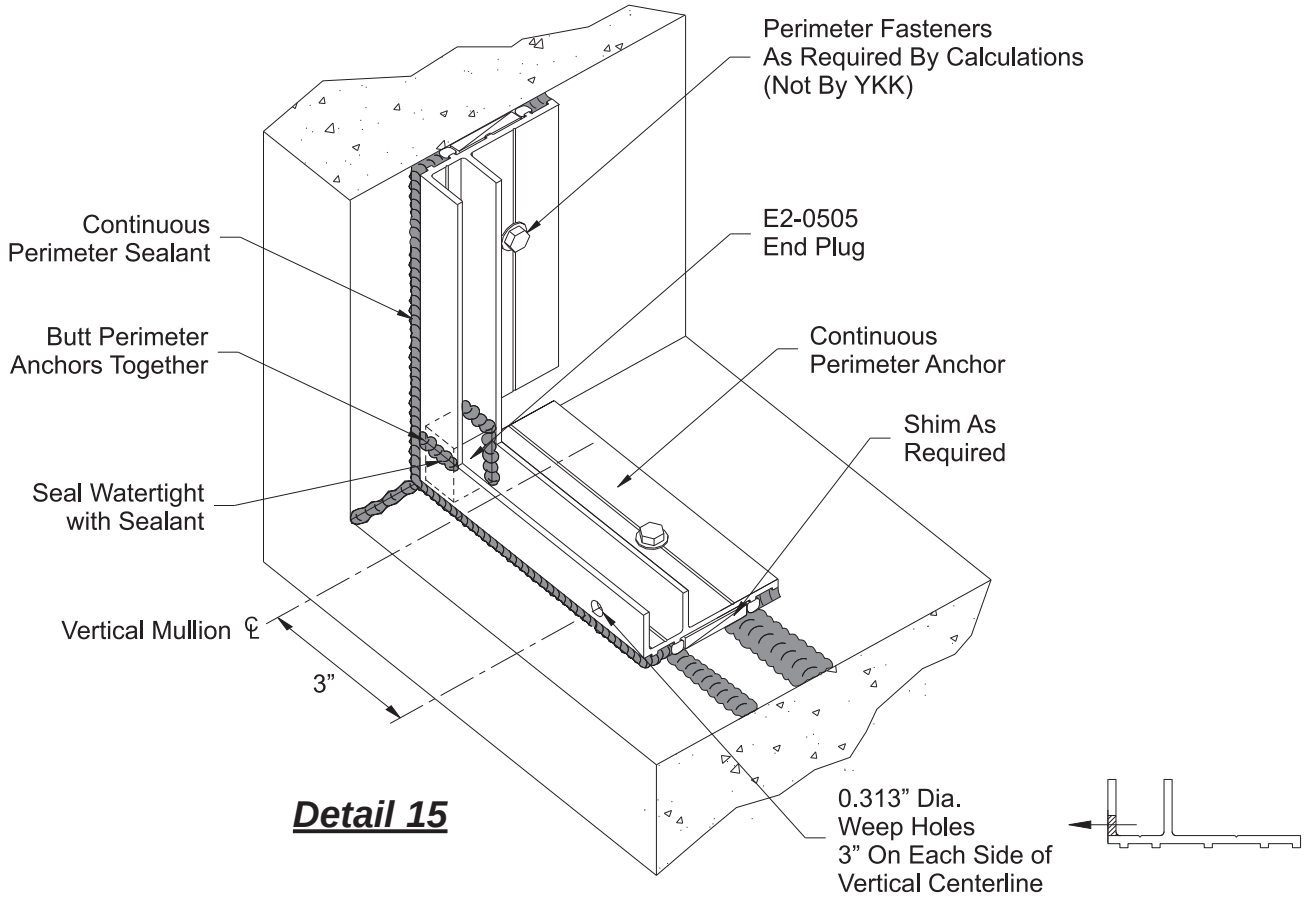
Note: Face covers, pressure plates, and mullions are staggered at splice locations. SSG vertical splices are similar.



Detail 14

FRAME INSTALLATION

STEP 11
INSTALL CONTINUOUS PERIMETER ANCHOR



Detail 15

-Cut perimeter anchors to size:
  Head and sill anchors stop 1/8” short of the jambs.
  Vertical jamb anchors butt in between head and sill anchors.
-Install perimeter anchors with appropriate perimeter fasteners. Refer to shop drawings or engineering calculations for type and spacing of fasteners. Shim as required to install anchors level.
-When splicing head and sill pieces together, leave 3/8” joint for expansion and install end plug, E2-0505, that has been buttered with sealant on the front, back, and bottom at the joint.
-Run continuous sealant along the perimeter between the anchors and the substrate.
-Seal corners of butted perimeter anchors watertight with sealant.
-Butter E2-0505 end plug with butyl on all sides that touch the anchors. Then push end plug into place and tool excess sealant that comes through the cracks.
-Field drill 0.313” diameter weep holes in perimeter anchor (exterior face only) at sill 3” from center line of vertical on each side.

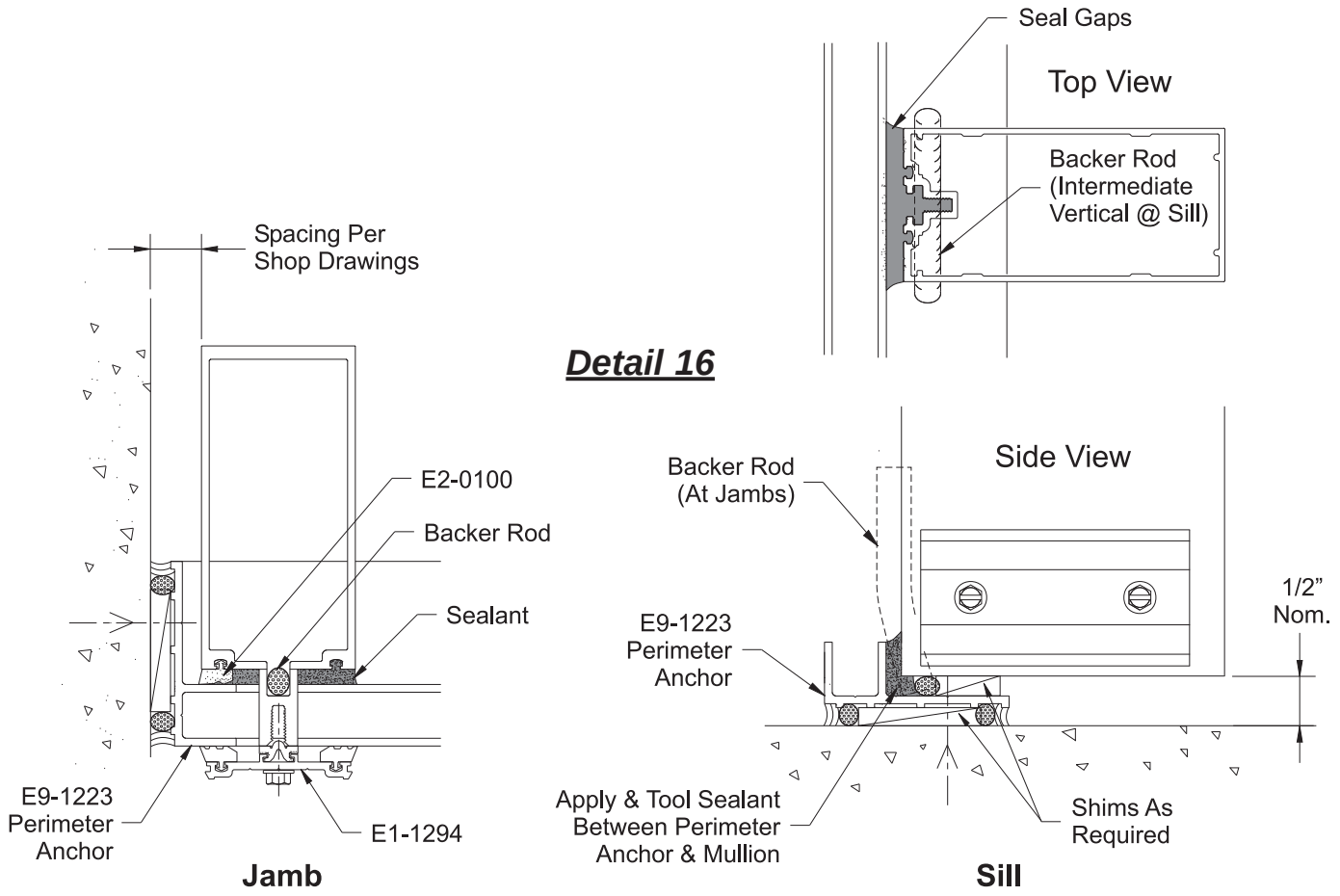
See **Detail 15**.

FRAME INSTALLATION

STEP 12
JAMB/VERTICAL INSTALLATION
WITH PERIMETER ANCHORS

-The notched ends of jamb mullions for 1” glazing leaves the interior of the mullion exposed and must be plugged prior to installation.
  -Install a small piece of backer rod into the notched out space directly behind the tongue at the top and bottom of the jamb mullions.
  -Push the backer rod into the opening at the face of the mullion.
  -Apply and tool sealant to seal off the opening made by the notch.
-Install interior gasket, E2-0100, to jamb mullion (jamb side only) the full length of the mullion.
-Position jamb into opening as shown in **Detail 16**.
-Seal the gap between the perimeter anchor and vertical glazing pocket with sealant.
-Install temporary retainer clip, E1-1294, at the top and bottom of the mullion.

-Place a small length of backer rod below each SSG vertical and set the mullion onto the perimeter anchors as shown below.
-Seal all gaps between the SSG vertical and the perimeter anchor at the sill.
See **Detail 16.**



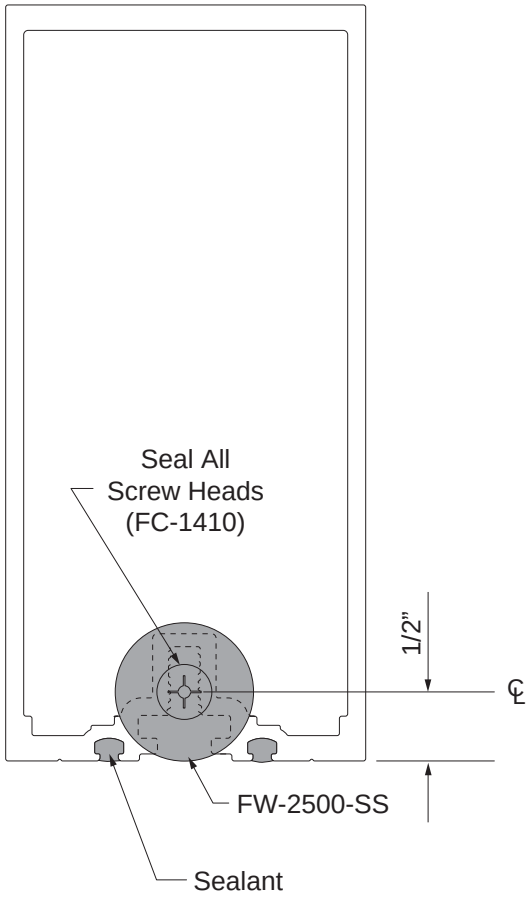
Detail 16

FRAME INSTALLATION

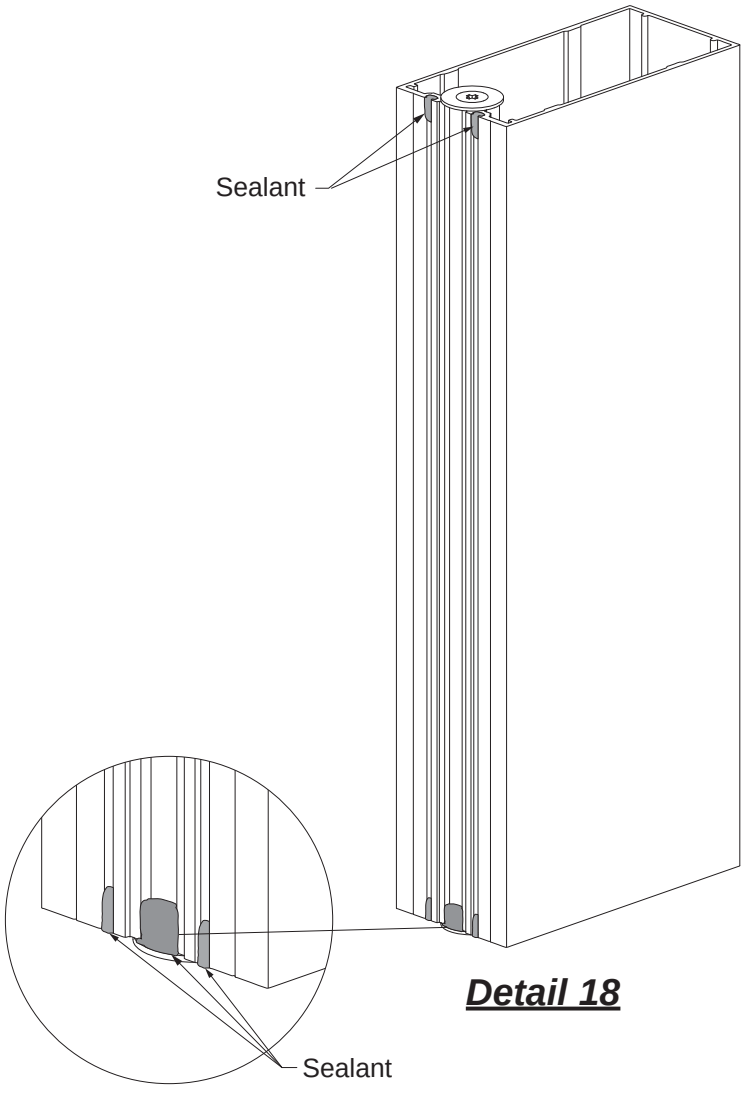
STEP 13
ATTACH SSG MULLION END CAPS

Mullion end caps are required at the head and sill of jamb and mullions.

-Clean the mullion ends and mullion end caps with a cleaner and method approved by the sealant manufacturer.
-Apply sealant to the spline cavity and along the front of the mullions on both ends prior to installing mullion end caps, FW-2500-SS. Also apply sealant to the reglets at both ends of the mullion.
-Attach the mullion end caps to each end of the mullion with FC-1410-SS fasteners as shown **Detail 17**.
-Tool the excess sealant flush between the mullion end cap and the mullion and at the reglets.
-Seal over all screw heads.
-At the bottom of the mullions, apply sealant to the center cavity to a height of 1/2”.
See **Detail 18**.



Detail 17

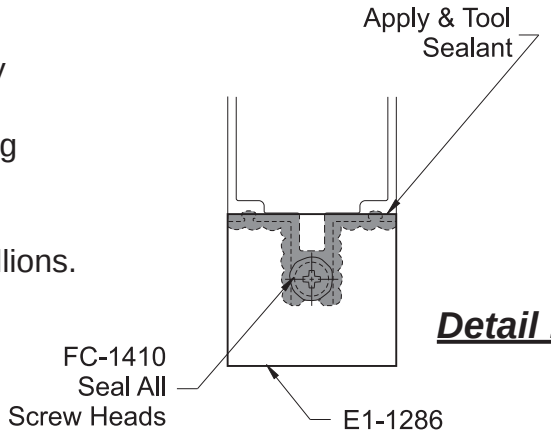


Detail 18

FRAME INSTALLATION

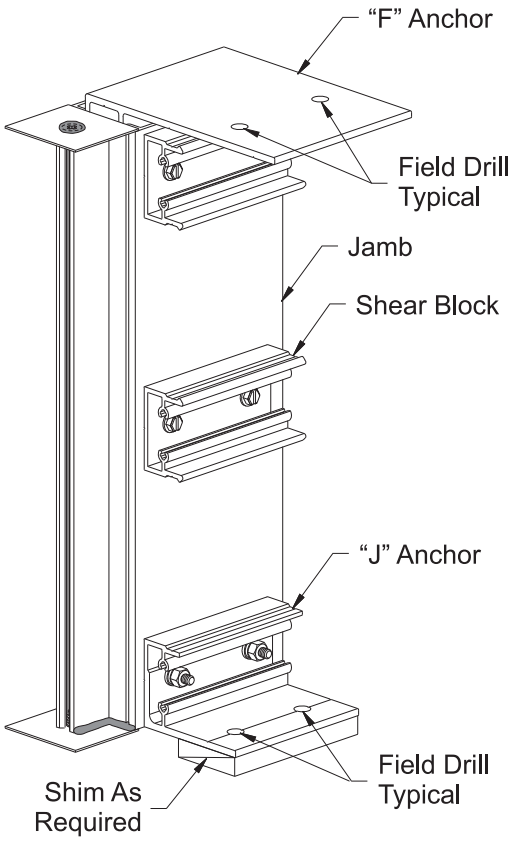
STEP 13A
JAMB/VERTICAL INSTALLATION
WITH MULLION END ANCHORS

-Clean all contact surfaces as recommended by sealant manufacturer.
-Apply sealant into the screw raceway and along the front edge of the jamb mullion at each end.
-Prior to erecting jambs, install end caps, E1-1286 at the top and bottom of the jamb mullions.
-Apply and seal mullion end caps.
-Seal all screw heads with sealant.
See **Detail 19**.

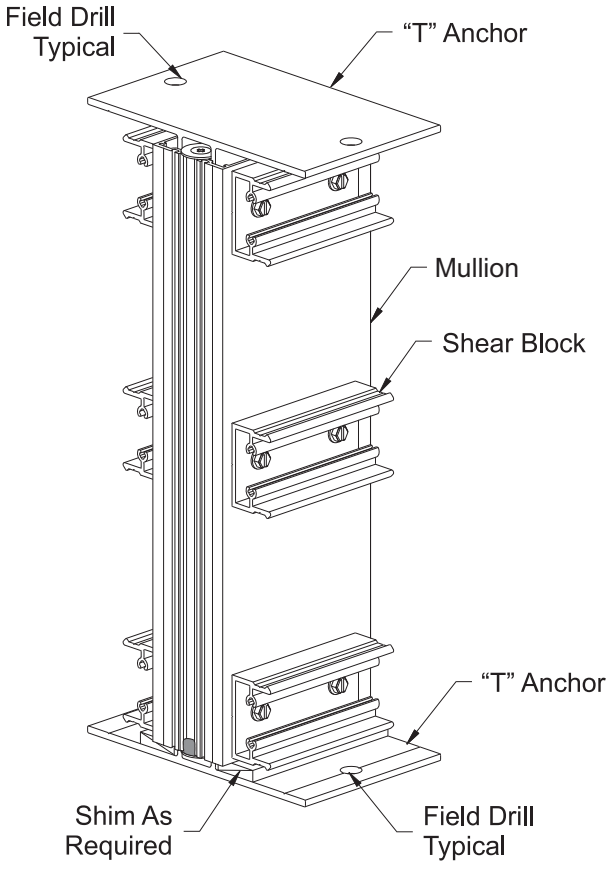


Detail 19

-Insert mullion “T” and “F” anchors into the top and bottom of the mullions before erecting them into the opening.
-Erect and locate the jamb and vertical mullions and temporarily attach them to the structure. All mullions must be installed plumb and true.
-Field drill holes in “T”, “F”, and “J” anchors for the appropriate anchor fasteners according to shop drawings or engineering calculations. Consult YKK if load requirements are in question.
See **Detail 20**.



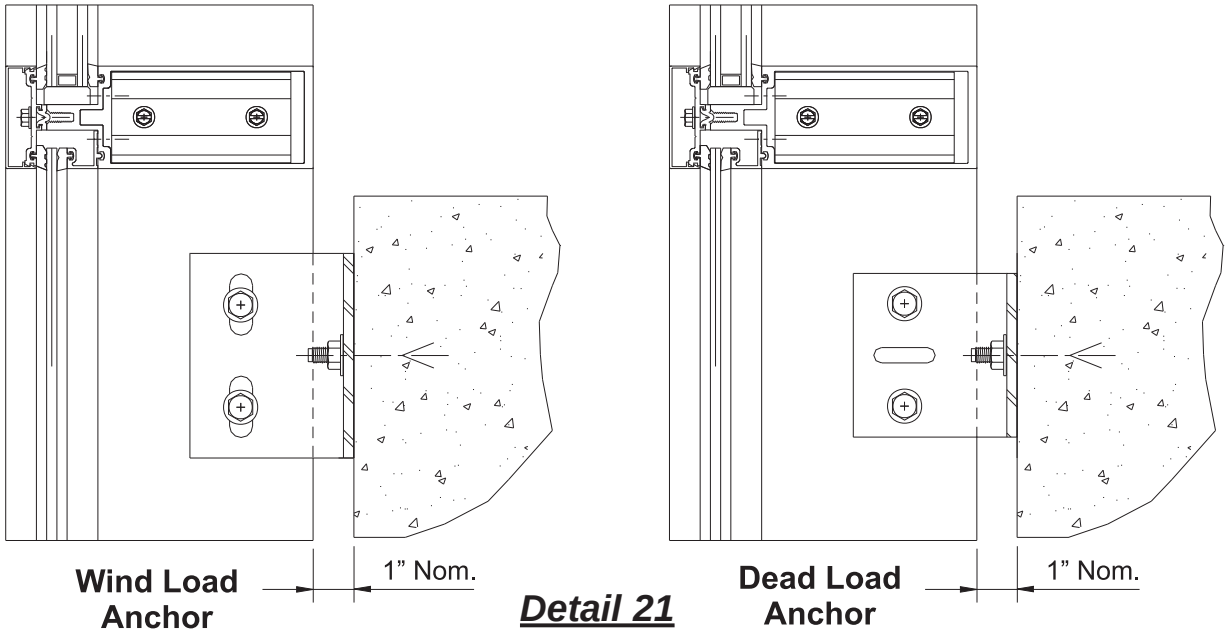
Detail 20



FRAME INSTALLATION

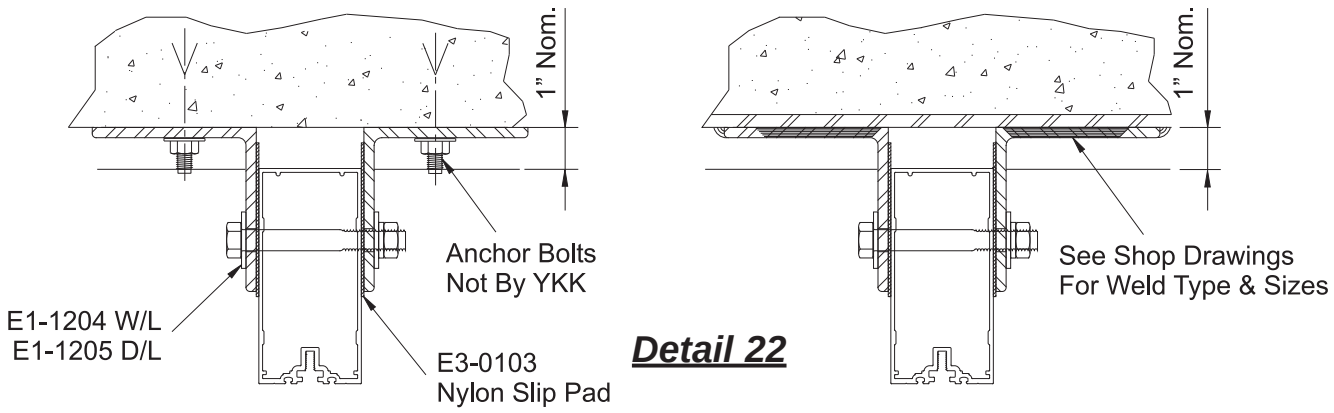
STEP 14
INSTALL WIND LOAD / DEAD LOAD ANCHORS

-Install steel wind load and dead load anchor clips. Anchor clips are normally template or line set before mullions are hung. Outstanding leg of clip must be set at 90° to offset line. The back of the vertical mullion should set 1” from the anchoring substrate.
See **Detail 21**.



Detail 21

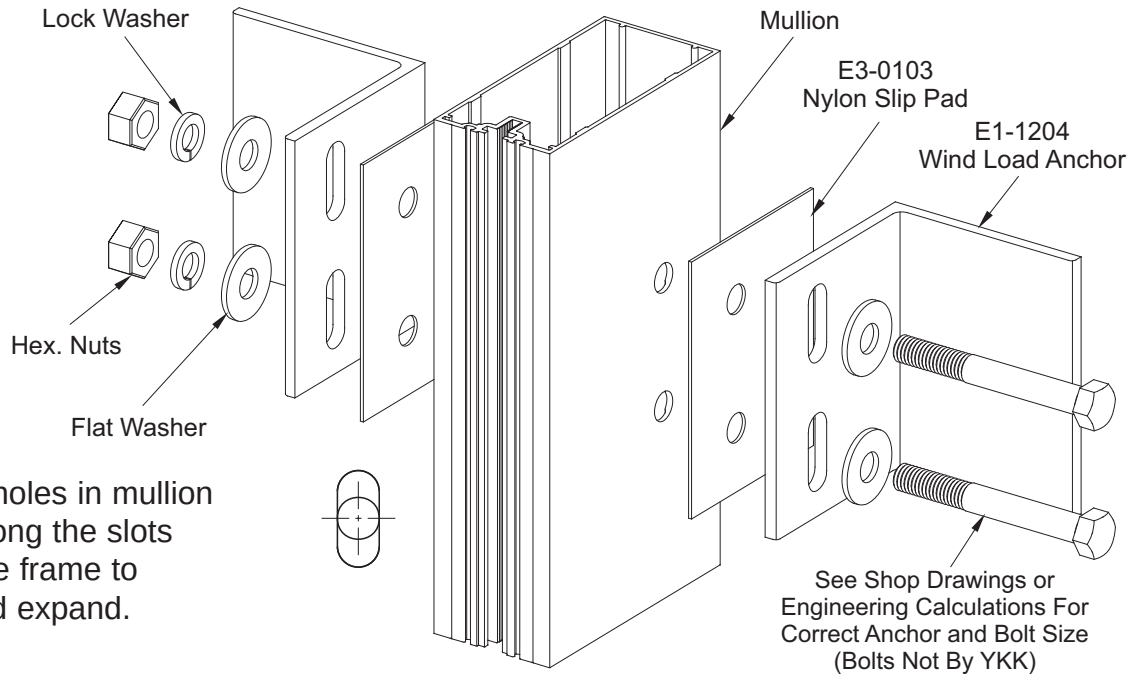
-Install, plumb, and align vertical mullions. Drill and install appropriate diameter anchor bolts. If shop drawings are not prepared by YKK AP, all anchors and bolts must be checked by a qualified engineer.
-Nylon slip pads, E3-0103, must be installed between mullion and anchor.
See **Detail 22**.



Detail 22

FRAME INSTALLATION

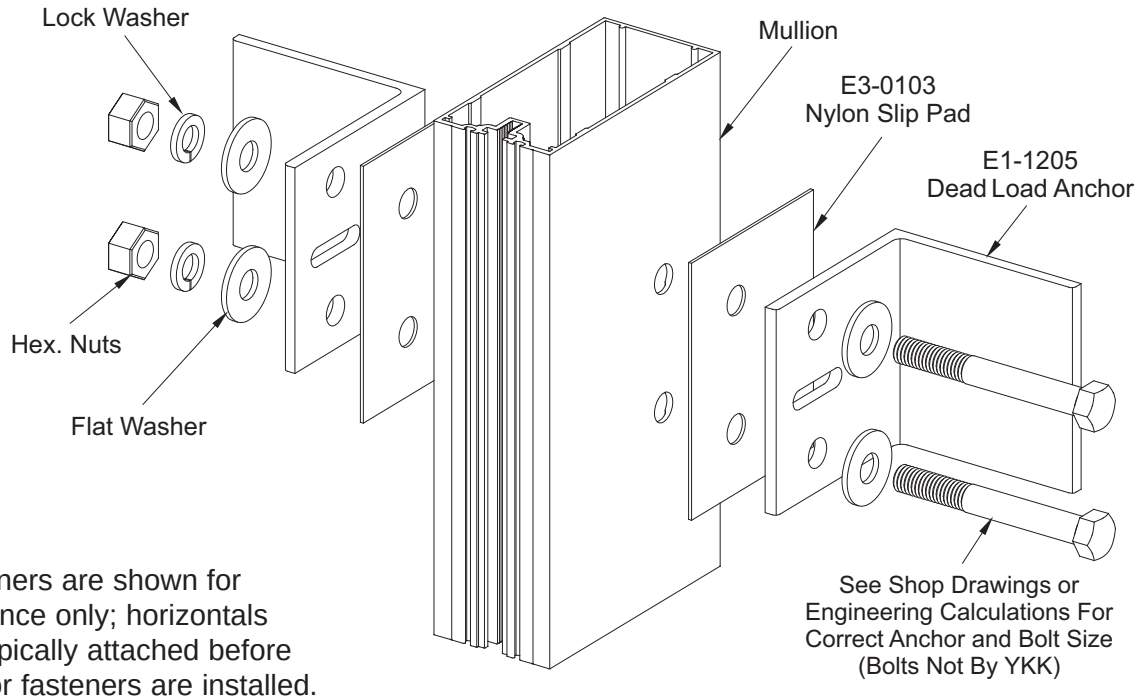
TYPICAL WIND LOAD ANCHOR



Note: Drill holes in mullion centered along the slots to permit the frame to contract and expand.

Detail 23

TYPICAL DEAD LOAD ANCHOR



Note: Fasteners are shown for reference only; horizontals are typically attached before anchor fasteners are installed.

FRAME INSTALLATION

STEP 15
ATTACH HORIZONTAL MEMBERS

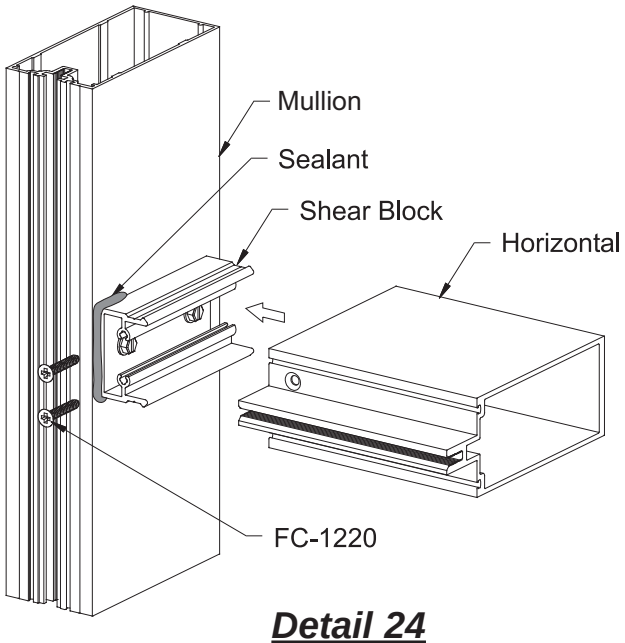
-Just prior to attaching the horizontal members to the vertical, apply sealant to the front of the shear block as shown below.

Note: Before applying any sealant, clean aluminum surfaces using cleaner and method approved by sealant manufacturer.

For Concealed Fasteners:

-Slide the horizontal members towards the vertical and attach them to the shear blocks at each end with two FC-1220 fasteners.
-Tool and wipe away any excess sealant at the vertical to horizontal joints.
See **Detail 24**.

CONCEALED FASTENERS

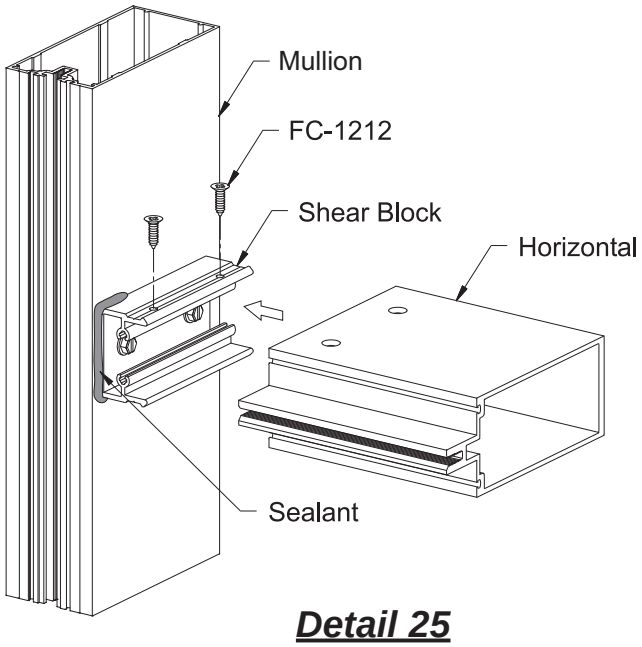


Detail 24

For Exposed Fasteners:

-Slide the horizontal members towards the vertical and transfer the hole locations on top of the horizontal to the shear block.
-Remove the horizontal and drill a 0.189” dia. (#12 bit) hole at each hole location.
-Slide the horizontal back against the vertical and attach it to the shear block with two FC-1212 fasteners at each end.
-Tool and wipe away any excess sealant at the vertical to horizontal joints.
See **Detail 25**.

EXPOSED FASTENERS



Detail 25

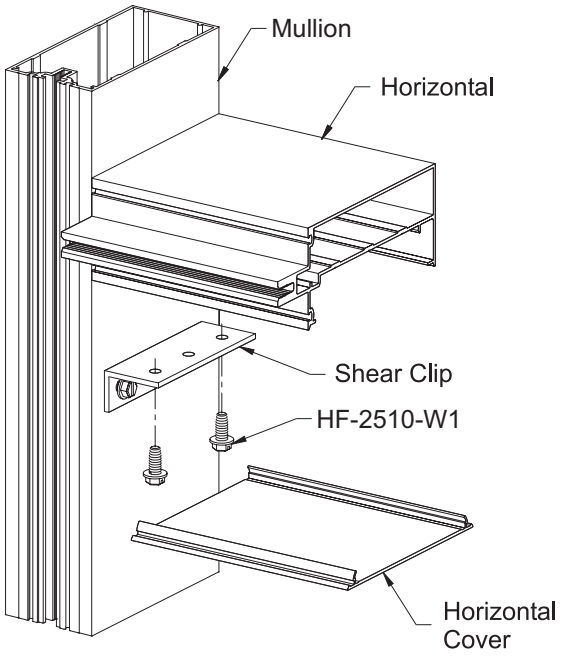
FRAME INSTALLATION

STEP 15 (Continued)
ATTACH HORIZONTAL MEMBERS

For Two Piece Horizontals:

-Lower the horizontal down onto the shear clip. Make sure the horizontal and vertical glazing pockets are flush.
-Attach the horizontal to the shear clip from the underside of the horizontal using two HF-2510 fasteners at each end.
-Snap on the horizontal cover.
See **Detail 26**.

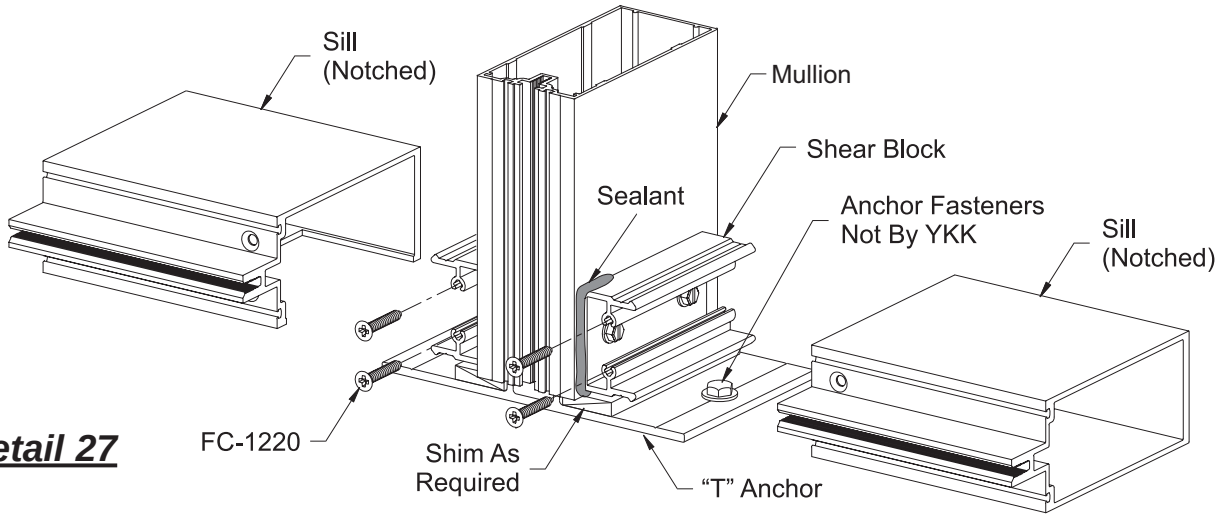
TWO PIECE HORIZONTAL



Detail 26

At Head and Sills:

-Mullion end anchors must be installed before head and sill members are attached.
  -Provide anchor fasteners as per job requirements. See approved shop drawings or engineering calculations for appropriate anchor fasteners.
  -Install the anchor fasteners as recommended by fastener manufacturer.
-Attach head and sill members according to the procedures previously outlined with the notched out portion facing the anchors.
See **Detail 27**.
Caution: There must always be a shim under the mullion to transfer glazing dead loads to the foundation.



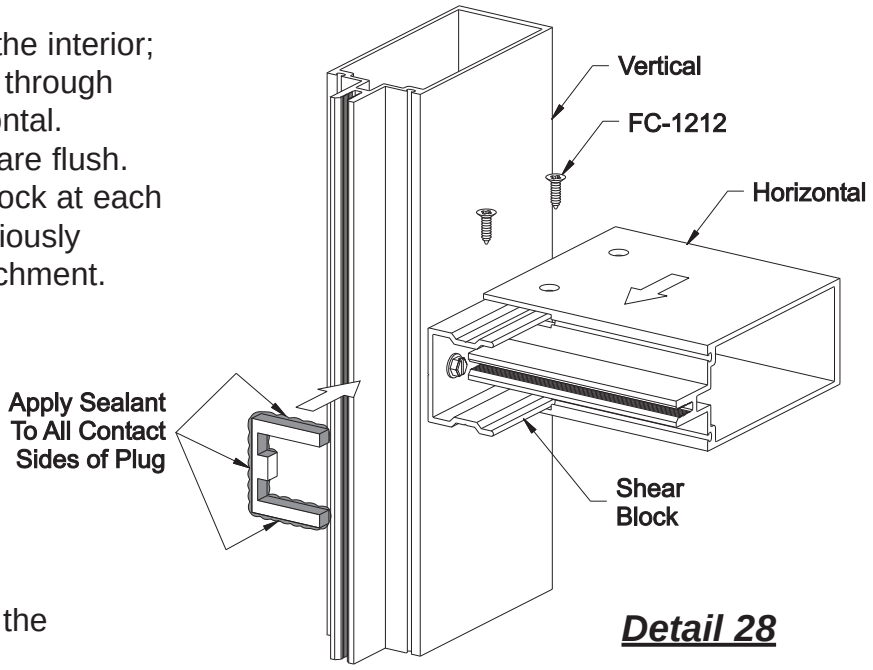
Detail 27

FRAME INSTALLATION

STEP 15 (Continued)
ATTACH HORIZONTAL MEMBERS

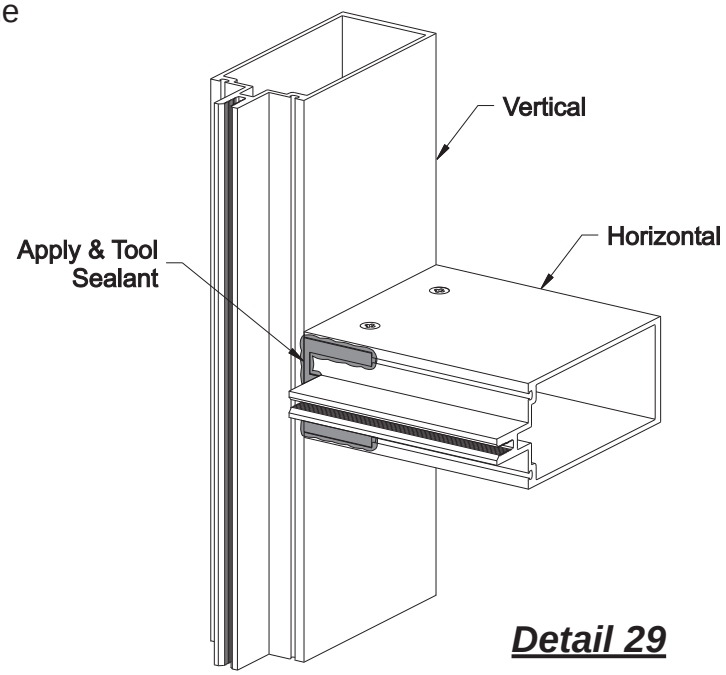
For One Piece Horizontals at End Bays:

-Slide the horizontal into place from the interior; the shear blocks should easily pass through the E-Slots at the ends of the horizontal. Make sure that the glazing pockets are flush.
-Attach the horizontal to the shear block at each end with FC-1212 fasteners as previously instructed for exposed fastener attachment.
See **Detail 28**.



Detail 28

-Apply sealant to all contact sides of the E-Slot plug, E2-0123.
-Insert the E-Slot plugs into place and press them firmly against the shear blocks.
-Cover the entire slot with sealant and tool the sealant to ensure a watertight seal.
See **Detail 29**.

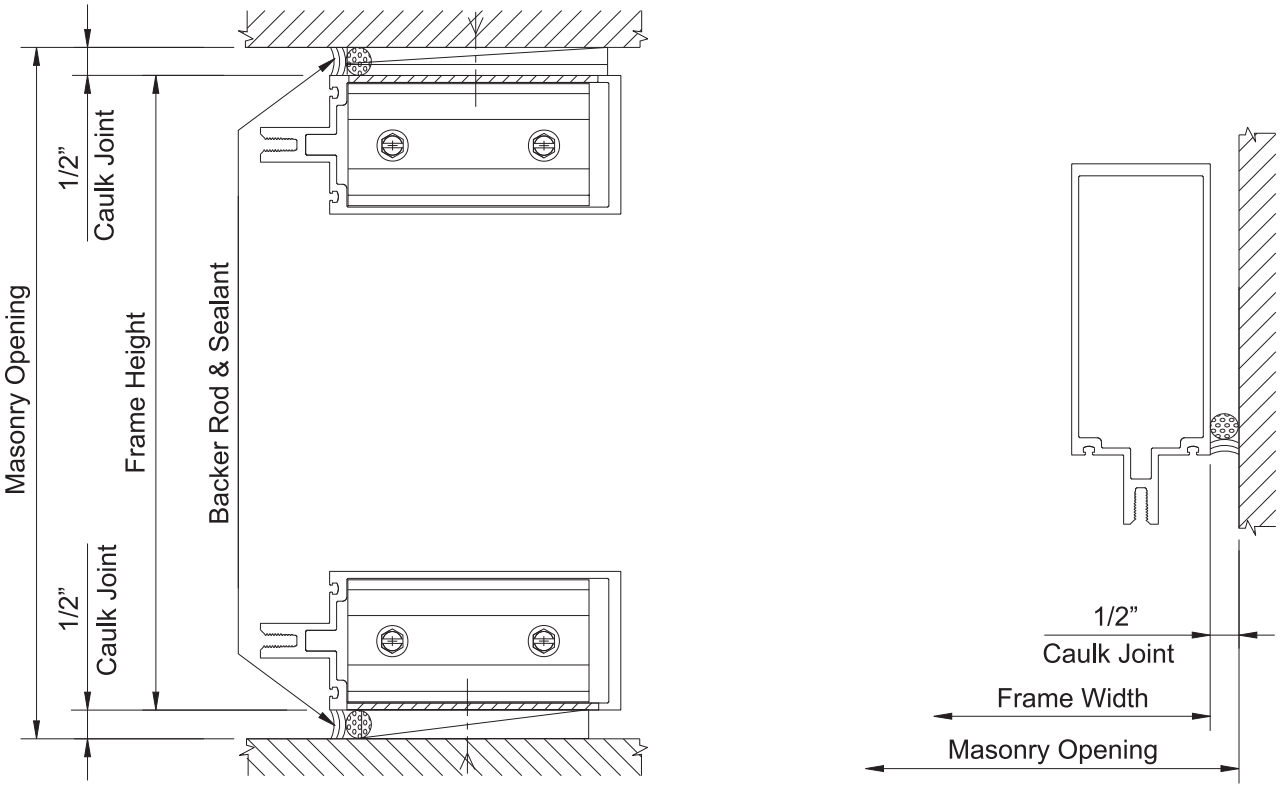


Detail 29

FRAME INSTALLATION

STEP 16
APPLY PERIMETER SEALANT

-Clean the area around the perimeter of the frame with cleaner and method approved by sealant manufacturer.
-Push in backer rod between the perimeter of the frame and the substrate about 1/4".
-Apply a quality sealant to the perimeter of the frame.
-Tool the sealant making sure that sealant does not get into the gasket reglets.
See **Detail 30**.



Detail 30

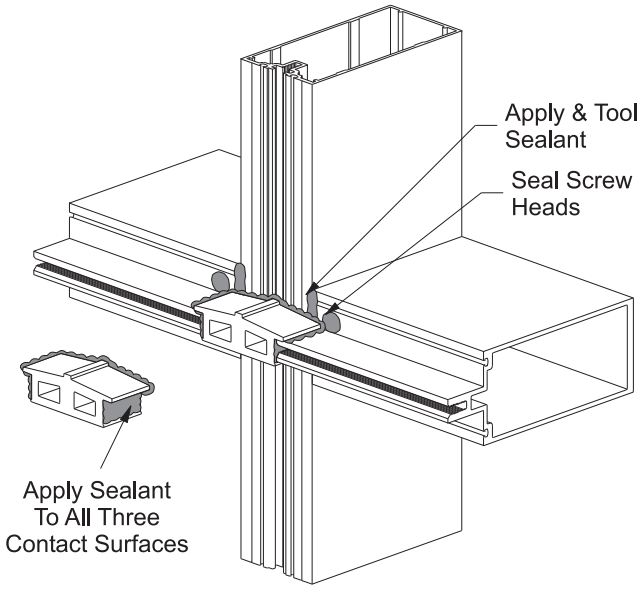
FRAME INSTALLATION

STEP 17
INSTALL JOINT PLUGS

At Intermediate SSG Verticals:

The space between the horizontals at each SSG vertical must be closed with joint plugs, E2-0245 for 1” glazing or E2-0279 for 1/4” glazing.

-Clean the area around the vertical and horizontal intersection with an approved cleaner.
-Apply and tool sealant to the intersection of the horizontal and vertical.
-Apply sealant to the three contact sides of the joint plug and into all cavities behind where the joint plug will go.
-Press joint plug firmly against face of mullion.
-Tool the sealant to ensure a watertight seal.
-Seal all exposed screw heads on the face of the mullion.
See **Detail 31**.

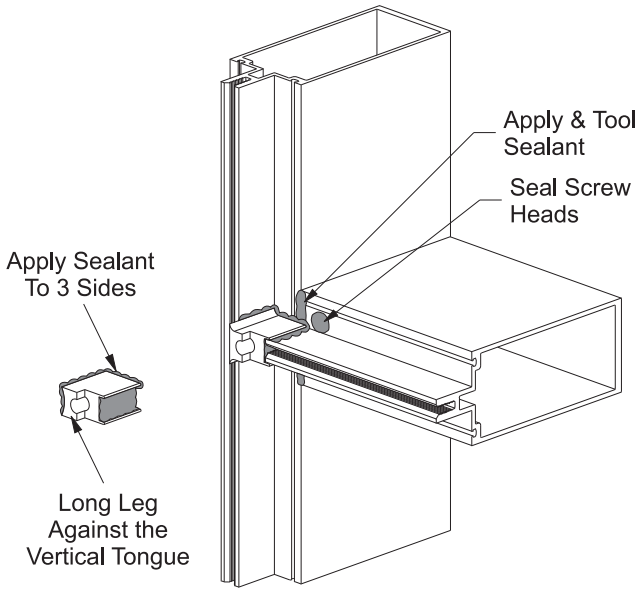


Detail 31

At Jamb Mullions:

The tongue of the horizontal mullion must be sealed to the tongue of the jamb mullion with joint plugs, E2-0102 for 1” glazing or E2-0125 for 1/4” glazing.

-Clean the area around the tongue intersection with an approved cleaner.
-Apply and tool sealant to the intersection of the horizontal and jamb mullions.
-Apply sealant to the three contact sides of the joint plug and at the intersection of the vertical and horizontal glazing pocket.
-Install joint plug as shown with the long leg of plug against the vertical tongue.
-Press joint plug firmly against face of mullion.
-Tool the sealant to ensure a watertight seal.
-Seal all exposed screw heads on the face of the mullion.
See **Detail 32**.

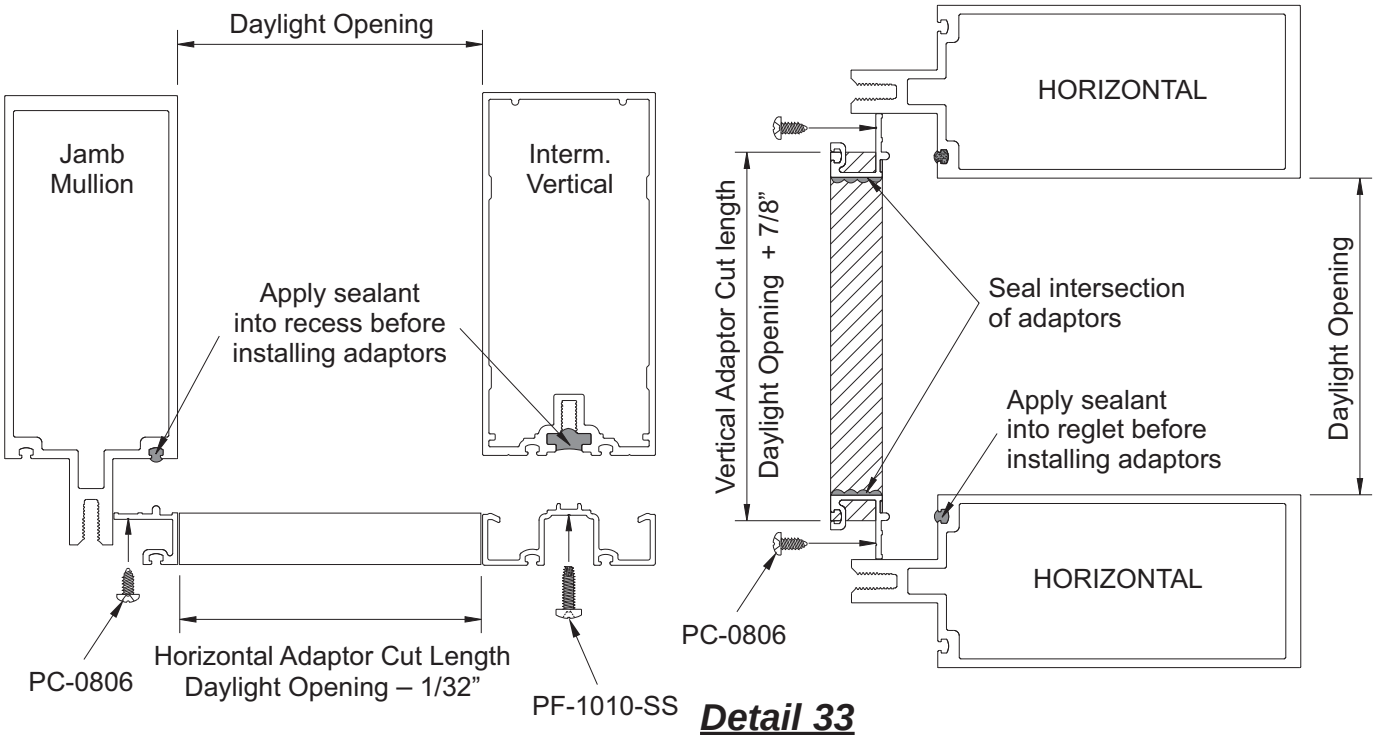


Detail 32

GLAZING

STEP 18
INSTALL GLAZING ADAPTORS
(When Required)

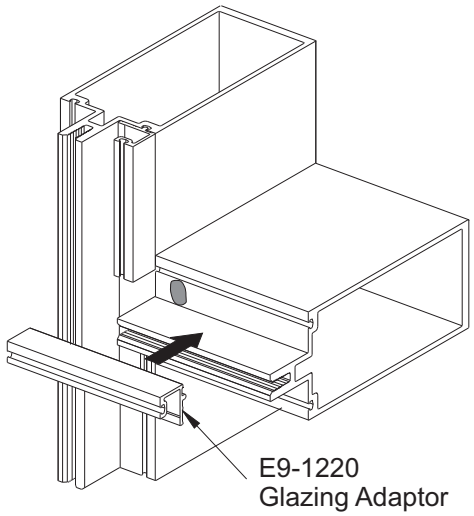
Note: 1/4” glazing adaptors shown
1/2” glazing adaptors similar.



Detail 33

-Cut glazing adaptors to size:
Vertical Cut Length = Daylight Opening plus(+) 7/8”.
Horizontal Cut Length = Daylight Opening minus(–) 1/32”.

-Predrill each adaptor with 0.189” dia. (#12) holes 2” from each end and 24” O.C.
-Dry fit adaptors and match drill 0.141” diameter (#28) holes on mullion to receive PC-0806 and PF-1010-SS screws.
-Clean the area around the mullion glazing reglet and the glazing adaptor with a cleaner approved by the sealant manufacturer.
-Apply sealant to the glazing reglets of the mullion, SSG mullion recesses, and the ends of the horizontal adaptors.
-Install the adaptors with PC-0806 screws 2” from each end and at the center of the adaptor. Install the vertical adaptors first and make sure they are centered along the day light opening.
-Tool sealant at all adaptor intersections and seal all screw heads.
See **Detail 33**.

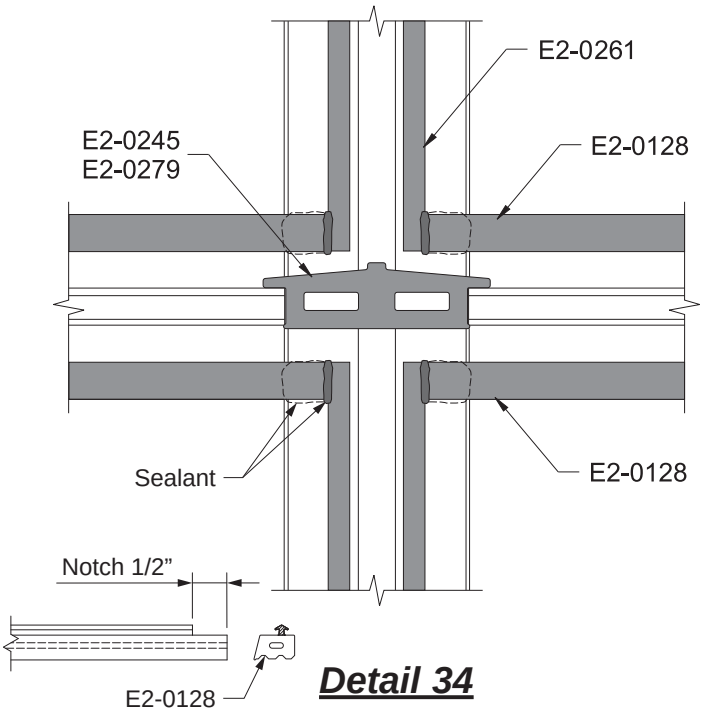


GLAZING

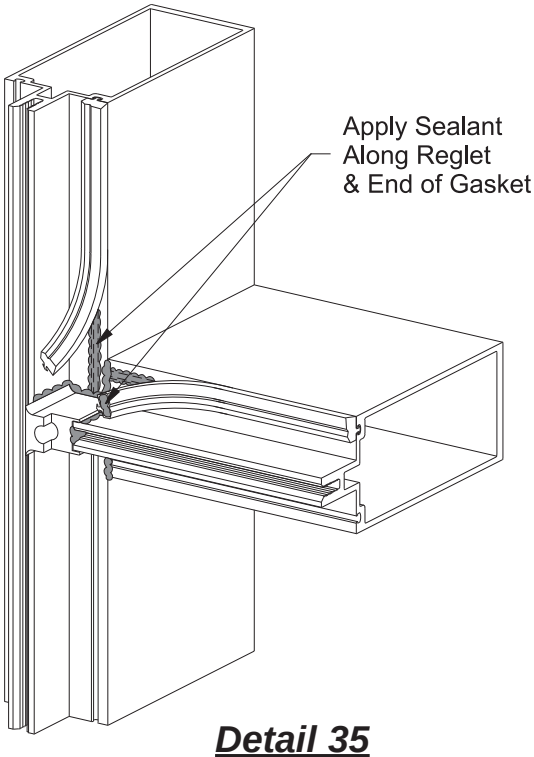
STEP 19
INSTALL INTERIOR GLAZING GASKETS & SPACERS AT SSG MULLION

-Cut vertical gaskets and spacers to Daylight Opening plus(+) 1-1/2”.
-Cut horizontal gaskets to Daylight Opening plus(+) 1” plus(+) 1/4” per each foot of opening width.
-Notch horizontal gaskets 1/2” at each end.
-Apply sealant where the notched horizontal gasket overlaps the mullion and where it meets the vertical spacer.
-Install vertical gaskets and spacers first, centered along the daylight opening.
-Install horizontal glazing spacers by pushing each end into the reglet. Next press the center of gasket into the reglet and then push the rest of the gasket into the reglet working from the center towards each end.

See **Detail 34**.



Detail 34



Detail 35

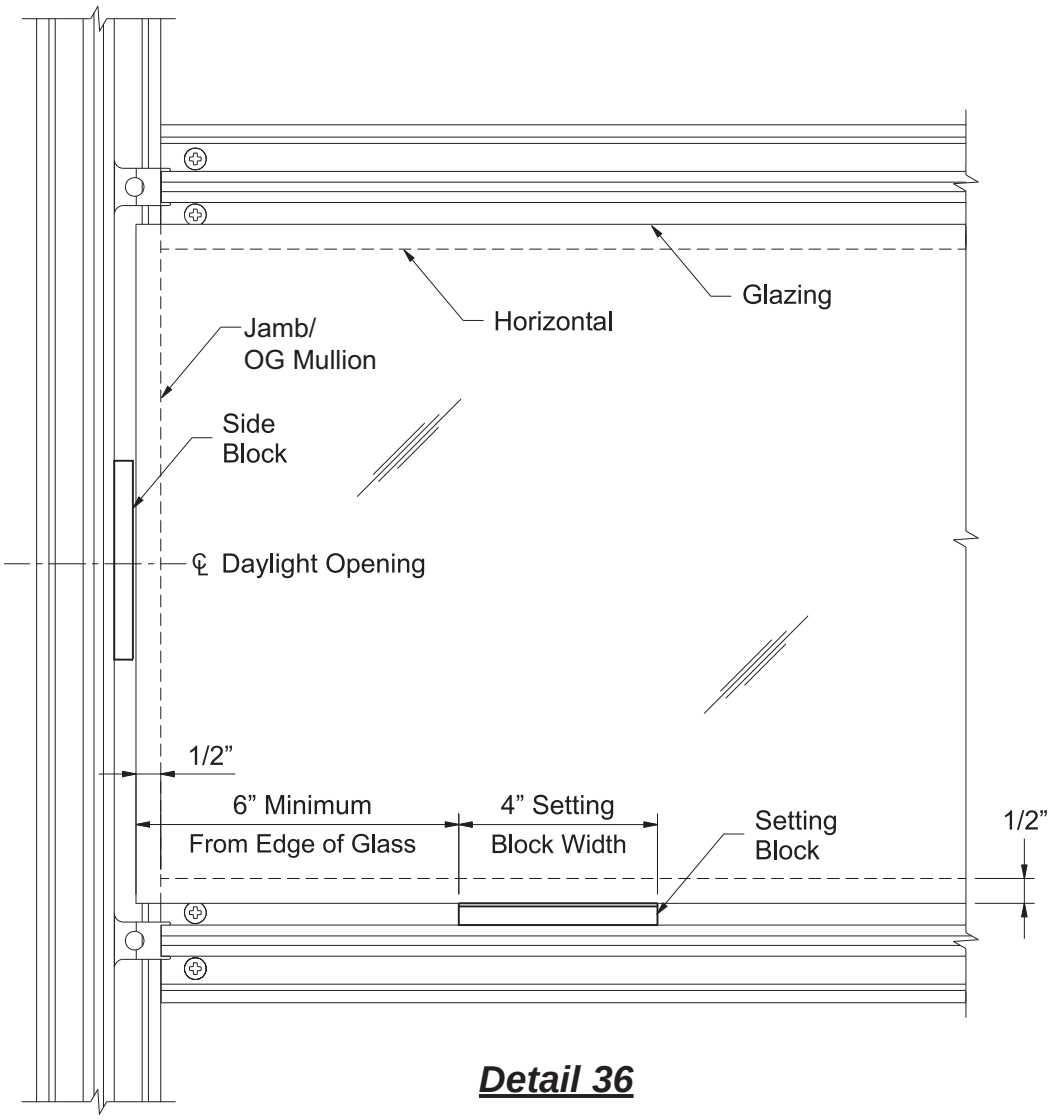
Glazing gaskets require additional sealant at the jamb and horizontal intersection.

-Pull the last 3” of each gasket away from the reglet.
-With gasket end held out of the way, run a 2” to 3” bead of sealant into the reglet at each end.
-Apply sealant to each end of the horizontal gasket.
-Reinsert the gasket ends and press them firmly against the face of the mullion.
-Apply and tool sealant at the intersection of the vertical and horizontal gaskets.

See **Detail 35**.

GLAZING

STEP 20
INSTALL SETTING & SIDE BLOCKS



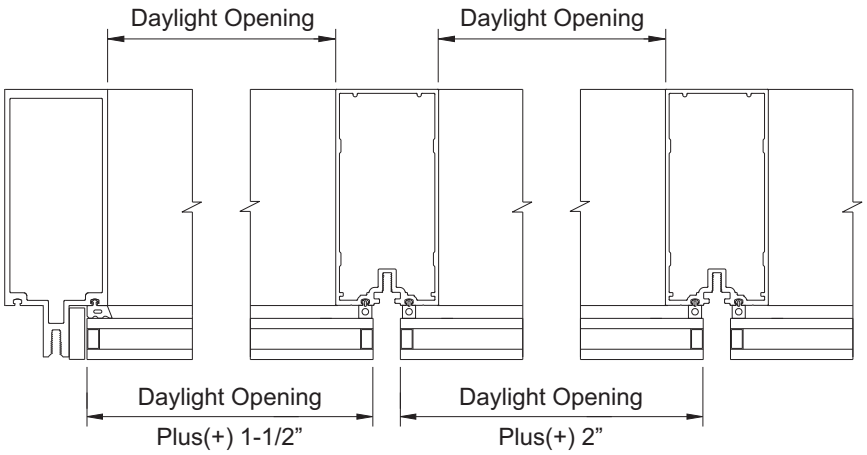
Detail 36

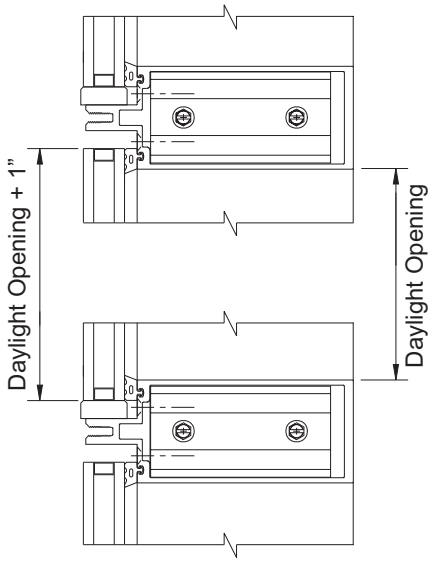
-Install setting blocks, E2-0104 for 1” glazing or E2-0112 for 1/4” glazing, at 1/4 points of daylight opening or minimum of 6” from edge of glass, whichever is greater.
Consult YKK AP for setting block requirements on units that exceed 60” x 90” or 40 sq. ft.
-Install side blocks, E2-0105 for 1” glazing or E2-0113 for 1/4” glazing, centered along the daylight opening at each jamb.
See **Detail 36**.

GLAZING

STEP 21
INSTALL EXTERIOR GLAZING GASKETS

-Cut exterior jamb glazing gaskets to the same length as the jamb pressure plates.
-Cut exterior horizontal glazing gaskets to daylight opening plus 3/16” per foot of opening width.
-Install jamb glazing gaskets centered along the jamb pressure plates.
-Install horizontal gaskets by pushing each end into the reglet of the pressure plate. Next press center of gasket into reglet; then push gasket into reglet working from center towards the ends.
Caution: Do not stretch the gaskets.



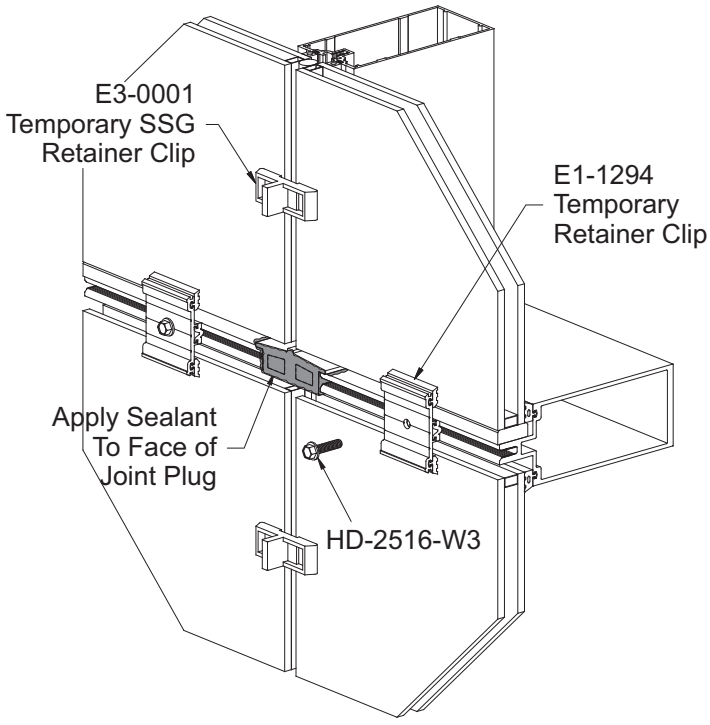


STEP 22
INSTALL GLASS

-Install glass at this time.
See **Detail 37** for glass sizes.
-As each lite is installed, attach a temporary retaining clip, E1-1294, in the middle of each horizontal and 4” from glass edge at each end with HD-2516-W3 fasteners.
-Additionally, secure glass with SSG temporary glass retainers every 3’-0” maximum along the SSG verticals.
-Apply sealant to the face of the joint plug just prior to installing pressure plates. Do not allow sealant to skin over prior to installing pressure plates.
See **Detail 37**.

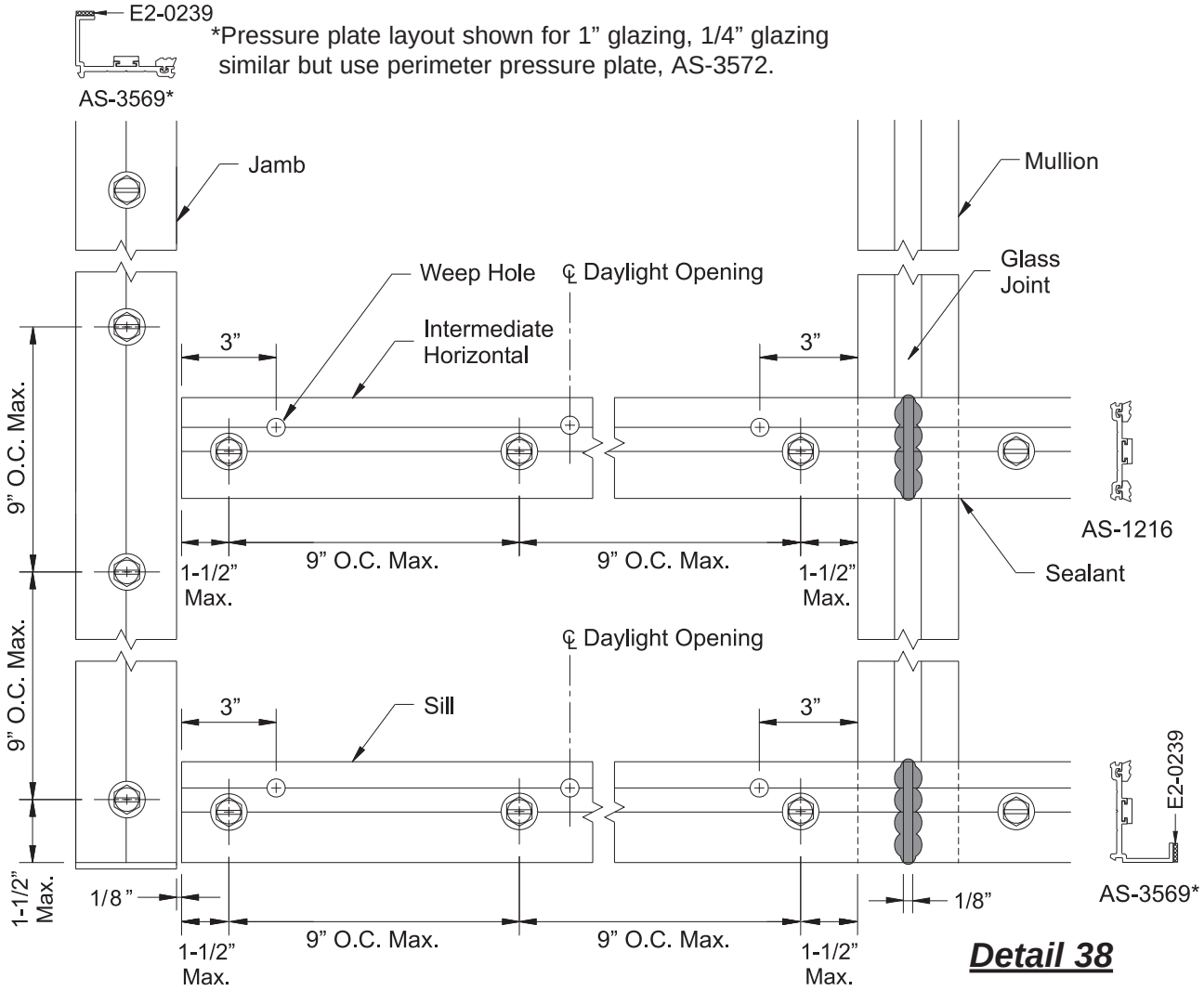
Note: Sealant must form a complete seal between the exterior gasket, pressure plate, thermal isolator, and the joint plug.

Detail 37



GLAZING

STEP 23
PRESSURE PLATE LAYOUT AND ASSEMBLY



Detail 38

-Pressure plate stock lengths are factory punched with 0.281” diameter holes at 9” o.c. maximum. After cutting, additional holes may be required to have bolts within 1-1/2” of each end.
-Install isolator tape, E2-0239, onto the back leg of the perimeter pressure plates.
-Install jamb pressure plates using HD-2516-W3 bolts. Initially torque bolts to 30 inch pounds with a speed wrench or torque limiting screw gun. Work from the bottom up.
-Center and install horizontal pressure plates in opening, leaving gaps at the ends as shown.
-Starting at the center of each pressure plate, tighten each retainer bolt to 50 inch pounds.
-Apply and tool sealant to completely seal gaps at the pressure plate ends.
-Torque all vertical pressure plate bolts to 50 inch pounds.
See **Detail 38**.

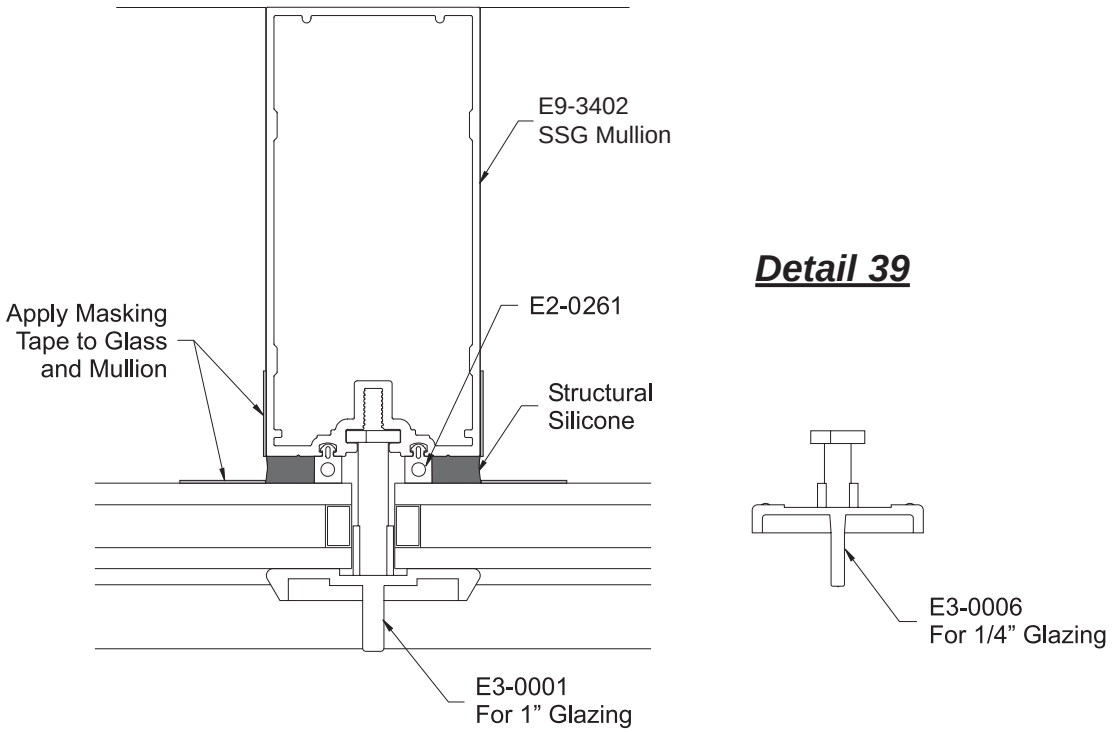
Note: Pressure plate AS-1216 must be used instead of AS-3569 on the perimeter when using perimeter anchors. Mullion end cap, E1-1286, must be installed at jambs when using mullion end anchors: “F” or “J”.

GLAZING

STEP 24
APPLY INTERIOR STRUCTURAL SILICONE SEALANT

-Carefully read and follow sealant manufacturers sealant recommendations.
-Make sure all silicone contact surfaces and joints have been cleaned with cleaner and method recommended by sealant manufacturer.
-Apply masking tape to the mullion and glass as shown in **Detail 39**.
-Apply an approved structural silicone from the bottom to the top of the joint. Use positive pressure to completely fill the cavity between the glass and vertical mullion.
-Using a nylon spatula or other non-scratching implement, tool the silicone immediately after running the vertical joint. Exert positive pressure while tooling to ensure that the silicone completely fills the cavity.
-Be careful not to remove too much silicone. The silicone should make complete contact with the glass and aluminum surfaces. The finished joint should be flush with the edge of the vertical.
See **Detail 39**.

-Allow silicone to cure as per manufacturer's recommendations. Temporary retainers should be left in place until silicone has cured.



Detail 39

Caution: Do not permit the silicone to skin over before it is tooled. Immediately remove masking tape after tooling the silicone.

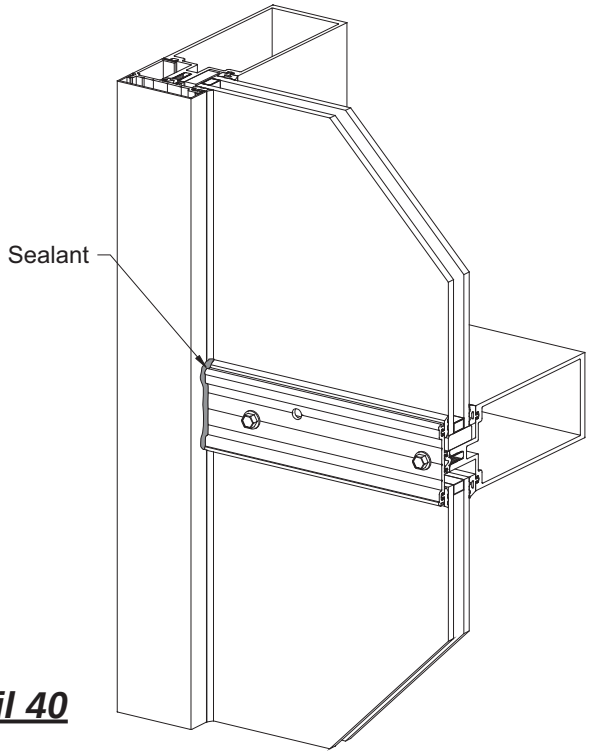
GLAZING

STEP 25
INSTALL EXTERIOR JAMB FACE COVERS

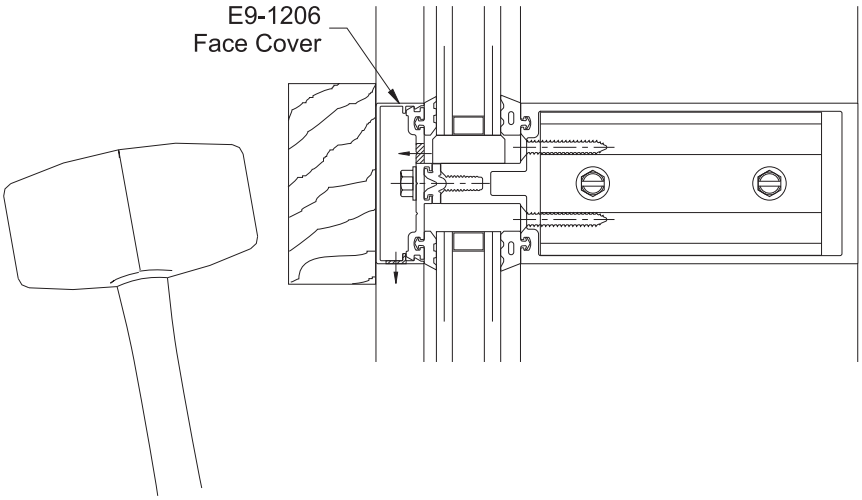
-Snap on exterior jamb face covers using a mallet and clean piece of lumber. Start at one end. Work block and mallet down the vertical.

-Apply sealant to the joint between the horizontal pressure plate and the jamb face cover. Make sure all sealant contact surfaces have been cleaned with method recommended by sealant manufacturer.

See **Detail 40**.



Detail 40



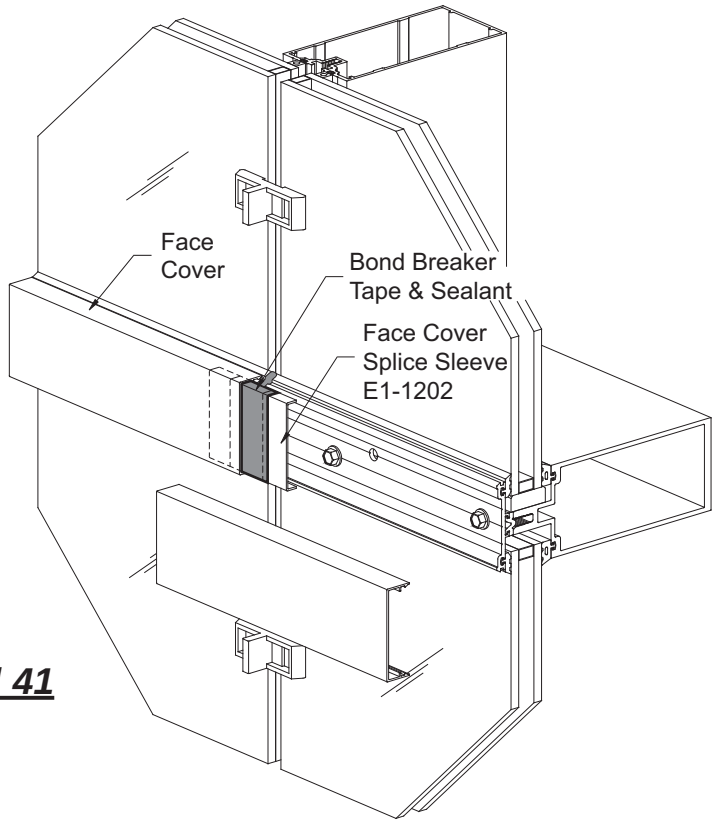
GLAZING

STEP 25A
INSTALL EXTERIOR HORIZONTAL FACE COVERS

-Snap on exterior horizontal face covers using a mallet and clean piece of lumber. Start at one end. Work block and mallet across the horizontal.

-If horizontal face covers are spliced, apply bond breaker tape and sealant to the face of the splice sleeve, E1-1202, and insert it at the end of the first cover.
-Attach the second face cover leaving a 1/2" joint between the two covers.
-Seal the joint between the face covers with sealant.
See **Detail 41**.

Note: Face cover splice joint should align with the vertical glass joint.



Detail 41

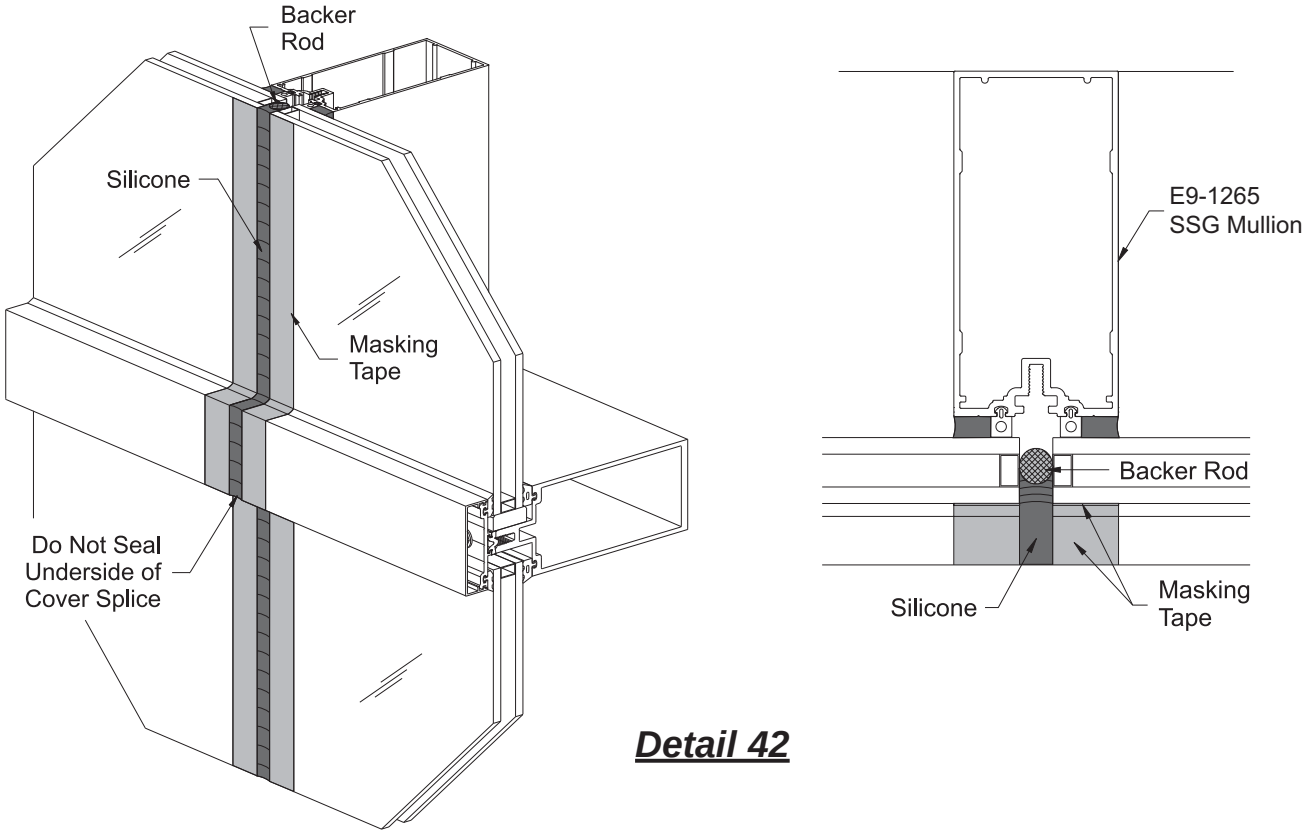
GLAZING

STEP 26
APPLY EXTERIOR WEATHERSEAL

-Once interior structural silicone has cured, remove the temporary retainer clips and insert an approved open cell polyurethane backer rod into the glass joint.
-Clean all silicone contact surfaces and joints with cleaner and method recommended by sealant manufacturer.
-Apply masking tape to the edges of the glass and aluminum as shown in **Detail 42**.
-Apply silicone sealant into the cavity between the mullion and glass starting from the bottom and work towards the top. Use positive pressure so that the silicone sealant completely fills the cavity.

Note: The underside of face cover splices are left unsealed to allow for weepage.

-Using a spatula or other non-scratching implement, tool the silicone sealant immediately after running the joint. Exert positive pressure while tooling to ensure that the silicone sealant makes complete contact with all surfaces. Be careful not to remove too much silicone.



Detail 42

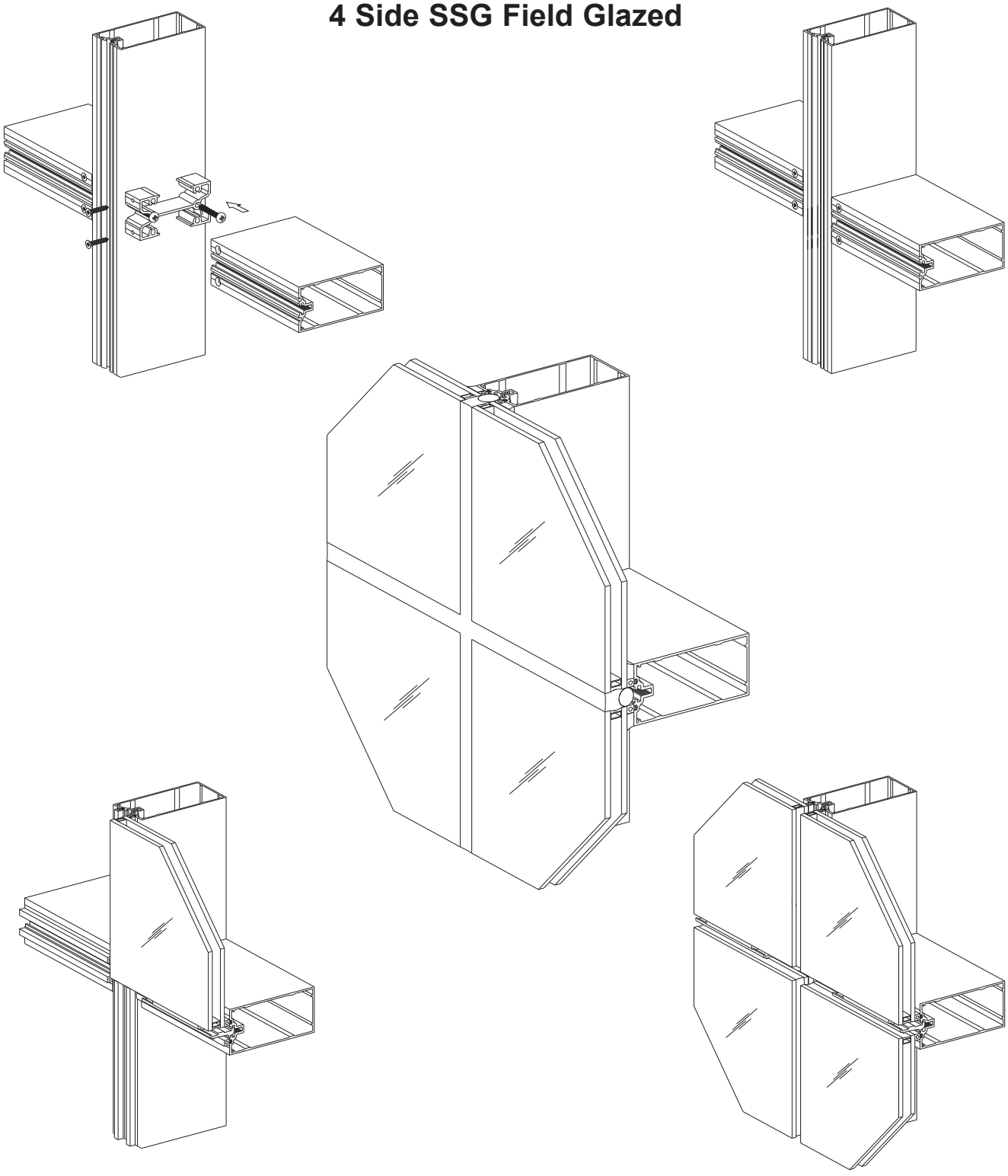
Caution: Do not permit the silicone to skin over before it is tooled. Immediately remove masking tape after tooling the silicone.

YKK AP America Inc.

270 Riverside Parkway
Suite A
Austell, Georgia 30168
www.ykkap.com

YCW 750 SSG Structural Silicone Glazed Curtain Wall System

4 Side SSG Field Glazed



Installation Manual

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Installation Notes

1. Do not drop, roll or drag boxes of aluminum framing. Move and stack boxes with proper support to prevent distortion. If fork lifts are used be especially careful about striking the boxes when lifting or moving.

2. Store in a dry, out of the way area. If rain exposure, condensation or any water contact is likely, then all packaging material should be removed. Wet packaging materials will discolor and may stain aluminum finishes and paints.

3. All materials should be checked for quality and quantity upon receipt, YKK AP must be notified immediately of any discrepancies in shipment. Check to make sure that you have the required shims, sealants, supplies and tools necessary for the installation.

4. Carefully check the openings and surrounding conditions that will receive your material. Remember, if the construction is not per the construction documents, it is your responsibility to notify the general contractor in writing. Any discrepancies must be brought to the general contractor's attention before you proceed with the installation.

5. Gather your shop drawings, materials, packing list, and this installation manual. Carefully review parts location, the sequence it goes therein, when you glaze it and how you seal it. Installation instructions are of a general nature and may not cover every condition you will encounter. The shop drawings and/or installation manuals were prepared specifically for the product.

6. Any material substitutions must be of equal or greater quality.

7. Make certain that material samples have been sent for compatibility testing for all manufacturer's sealants involved. Make certain sealants have been installed in strict accordance with the manufacturer's recommendations and specifications.

8. Remember to isolate, in an approved manner, all aluminum from uncured masonry or other incompatible materials.

9. System-to-structure fasteners are not supplied by YKK AP. Fasteners called out on shop drawings are to indicate minimum sizes for design loading.

10. If any questions arise concerning YKK AP products or their installation, contact YKK AP for clarification before proceeding.

11. YKK AP storefront and/or curtain wall framing is typically completed before drywall, flooring and other products which may still be in process. Take the extra time to wrap and protect the work produced.

12. Cutting tolerances are plus zero, minus one thirty second unless otherwise noted.

13. Check our website, www.ykkap.com, for the latest installation manual update prior to commencing work.

Important Notice for SSG Curtain Wall Systems:

In order to properly perform and to maintain structural integrity, in addition to all other installation requirements, structurally glazed curtain wall systems rely specifically upon effective and appropriate structural sealant selection and installation.

It is the responsibility of the glazing contractor to take all steps to ensure the installed structural sealant is capable of meeting all applicable project requirements in accordance with industry standards. Such steps on each project may include, but are not limited to, design reviews, formal adhesion testing, project specification compliance, validating applications, field testing, auditing, sealant design strength analysis, and the quality control review of the installation and surrounding conditions.

Subject to project specific design pressures, requirements, and/or specifications, the structural sealant that is used between the glass and framing system must be capable of withstanding tensile and shear stresses imposed by the curtain wall without failing adhesively or cohesively.

The structural sealant's capability to withstand these stresses are dependent on several factors including, but not limited to, type of structural sealant, method of application (i.e. cleaning, primer), construction of glazing material (i.e. insulating glass unit (IGU), other infill, and finish of framing (i.e. anodizing, paint).

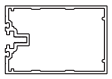
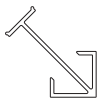
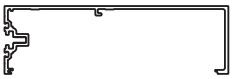
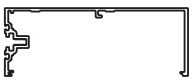
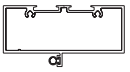
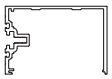
- Adhesive failure occurs when sealant pulls away from substrate cleanly, leaving no sealant material behind.
- Cohesive failure occurs when sealant breaks or tears within itself but does not separate from each substrate because sealant-to-substrate bond strength exceeds sealant's internal strength.

The IGU and/or other infill must be constructed for installation into structurally sealant glazed curtain walls. Notify the manufacturer or fabricator of the IGU and/or infill and advise of the product's application into 2 or 4-sided structurally sealant glazed curtain walls along with the project's design requirements so that appropriate fabrication steps are taken.

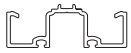
Secondary Notice for SSG Curtain Wall Systems:

Standard product details and system offering supports single and twin span applications only. For multi-span applications or elevation configurations that require the application of vertical expansion components, please contact YKK AP engineering for review.

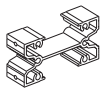
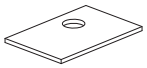
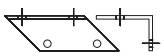
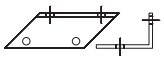
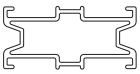
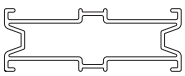
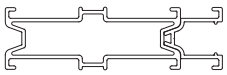
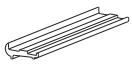
FRAMING MEMBERS

	Vertical / Horizontal 2-1/2" x 8-1/4"	**E9-3430**		**Horizontal Flush Filler** Use with E9-3403	**E9-3162**
	Vertical / Horizontal 2-1/2" x 6-3/4"	**E9-3426**		**Horizontal Flush Filler** Use with E9-3424	**E9-3595**
	Vertical / Horizontal 2-1/2" x 5-1/4"	**E9-3402**		**Perimeter Trim**	**E9-3409**
	**Vertical / Horizontal** 2-1/2" x 3-3/4"	**E9-3423**		**90° Outside Corner** **SSG Mullion Adaptor**	**E9-3413**
	Vertical Heavy Duty 2-1/2" x 5-1/4"	**E9-3401**		**Corner Trim**	**E9-3414**
	**Head/Sill/Horizontal** Open Back 2-1/2" x 8-1/4"	**E9-3431**		**90° Outside Corner** **Interior Cover Base** Use with E9-1281	**E9-1280**
	**Head/Sill/Horizontal** Open Back 2-1/2" x 6-3/4"	**E9-3428**		**90° Outside Corner** **Interior Cover**	**E9-1281**
	Head/Sill/Horizontal Open Back 2-1/2" x 5-1/4"	**E9-3403**		**Single Acting** **Transom Bar** Elastomer Weathering E2-0051 Included	**AS-0402**
	**Head/Sill/Horizontal** Open Back 2-1/2" x 3-3/4"	**E9-3424**		**Door Jamb Adaptor** Use with AS-0417	**E9-2344**
	Horizontal Flush Filler Use with E9-3431	**E9-3188**		**Snap-In Door Stop** Elastomer Weathering E2-0051 Included Use with E9-2344	**AS-0417**
	Horizontal Flush Filler Use with E9-3428	**E9-8489**		**Glazing Adaptor** For 1/4" Glazing (SSG Mullions)	**E9-3421**

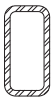
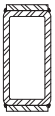
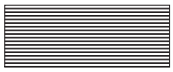
FRAMING MEMBERS

	**Vertical Glazing Adaptor** For 1/4” Glazing (SSG Mullions)	**E9-3422**		

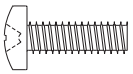
ACCESSORIES

	Standard Shear Block For 3-3/4” Depth Members Use (2) PF-2528 & (2) FC-1212	**E1-3425**		**Perimeter Trim Clip**	**E1-3543**
	**Standard Shear Block** For 5-1/4” to 8-1/4” Depth Members Use (2) PF-2528 & (2) FC-1212	**E1-3542**		**End Cap** For Perimeter Trim	**E1-3579**
	**RH Shear Clip For 90° Corner**	**E1-3540A**		**Intermediate Vertical “T” End Anchor*** For E9-3423	**E1-1229**
	**LH Shear Clip For 90° Corner**	**E1-3540B**		**Intermediate Vertical “T” End Anchor*** For E9-3401	**E1-1222**
	**Mullion Joint Sleeve** For E9-3401 and E9-3402	**E1-3548**		**Intermediate Vertical “T” End Anchor*** For E9-3402	**E1-1208**
	**Mullion Splice Sleeve** For E9-3426	**E1-3427**		**Intermediate Vertical “T” End Anchor*** For E9-3426	**E1-3580**
	**Mullion Splice Sleeve** For E9-3430	**E1-3566**		**Intermediate Vertical “T” End Anchor*** For E9-3430	**E1-3568**
	Spacer For 90° Corner Use With E1-3411	**E1-3550**		**Corner Vertical “T” End Anchor*** For E9-3423	**E1-1229A**
	**Setting Block Chair**	**E1-3545**		**Corner Vertical “T” End Anchor*** For E9-3401	**E1-1222A**

ACCESSORIES

	Corner Vertical "T" End Anchor* For E9-3402	**E-1208A**		**Temporary Glass Retainer** 2" Long	**E1-1294**
	Corner Vertical "T" End Anchor* For E9-3426	**E1-3580A**		**Wind Load Anchor*** Refer to Shop Drawings For Anchor Dimensions	**E1-1204**
	Corner Vertical "T" End Anchor* For E9-3430	**E1-3568A**		**Dead Load Anchor*** Refer to Shop Drawings For Anchor Dimensions	**E1-1205**
	Jamb "F" End Anchor* For E9-3423	**E1-1230**		**Steel Reinforcing** 2" x 4" x 1/4" Steel Tube	**E1-0162**
	Jamb "F" End Anchor* For E9-3401	**E1-1234**		**Steel Reinforcing** 2" x 4" x 1/4" Steel Tube & (2) 1/4" x 1-3/4" Steel Bars	**E1-0154**
	Jamb "F" End Anchor* For E9-3402	**E1-1233**		**Silicone Splice Sleeve**	**E2-0070**
	Jamb "F" End Anchor* For E9-3426	**E1-3581**		**Glazing Spacer Tape**	**E2-0110**
	Jamb "F" End Anchor* For E9-3430	**E1-3569**		**SSG Glazing Spacer**	**E2-0261**
	SSG Mullion End Cap Stainless Steel	**FW-2500-SS**		**Weep Tube**	**E3-0102**
	Setting Block With Pressure Sensitive Adhesive Use With E1-3545	**E2-0224**		**Nylon Slip Pad** For Wind Load & Dead Load Anchor	**E3-0103**

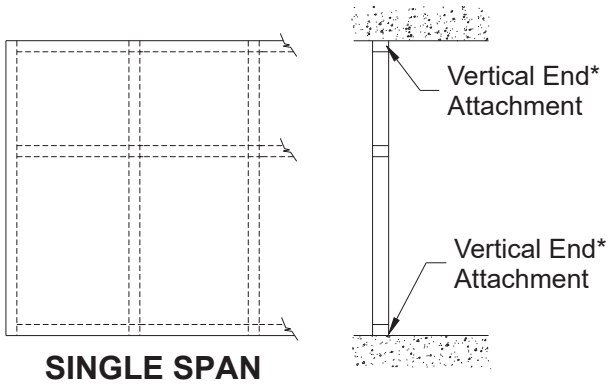
FASTENERS

	#12 x 5/8" PHSMS Type AB, Zinc Plated Steel For Attachment of End Cap to Perimeter Trim	**PC-1210**		**1/4"-20 x 3/4" PHMS** Stainless Steel For Attachment of Perimeter Trim Clip to Mullion	**PM-2512-SS**
	#12 x 3/4" FHSMS Type AB Zinc Plated Steel, For Attachment of Horizontal to Shear Block (Exposed Fastener)	**FC-1212**		**#10 x 3/8" PHMS** Stainless Steel For Attachment of Perimeter Trim Clip to Perimeter Trim	**PM-1006-SS**
	#14 x 5/8" FHSMS Type AB Zinc Plated Steel, For Attachment of FW-2500-SS Mullion End Cap to Mullion	**FC-1410**		**#10 x 1-1/4" FHSMS Type AB,** Zinc Plated Steel For Attachment of Optional Glazing Adaptors	**FC-1020**
	1/4-20 x 1-3/4" LG Type F Zinc Plated Steel, For Attachment of Mullion to Shear Block	**PF-2528**		**1/4"–20 x 2-1/2" PHMS** Stainless Steel For Attachment of Temporary Glass Retainer	**PM-2540-SS**

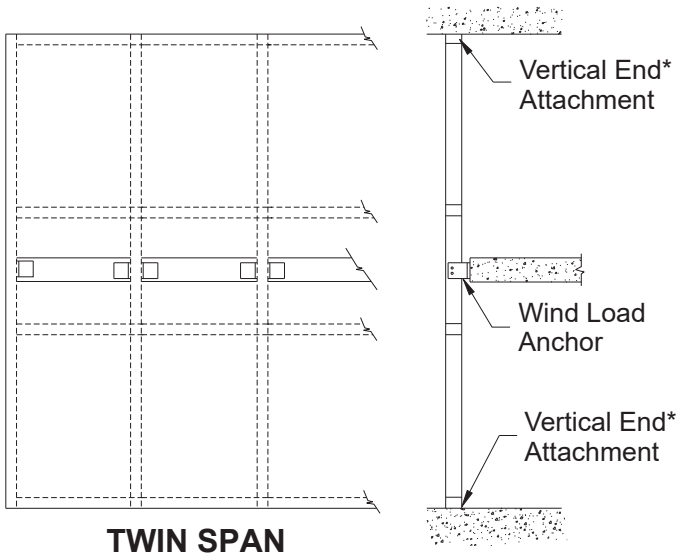
FRAME FABRICATION

FRAME TYPES / ANCHORING METHODS

The following is a guideline for common types of frames. Refer to shop drawings for exact layout of frames.



SINGLE SPAN



TWIN SPAN

Smaller units may be assembled on the ground and lifted into place. Larger units require being stick assembled in place.

Note: If YKK AP does not prepare the shop drawings for the project, a qualified engineer must approve all anchors and mullions for wind load and dead load.

All anchors must be attached to structurally sound material that will accommodate the anchor reactions.

FRAME FABRICATION

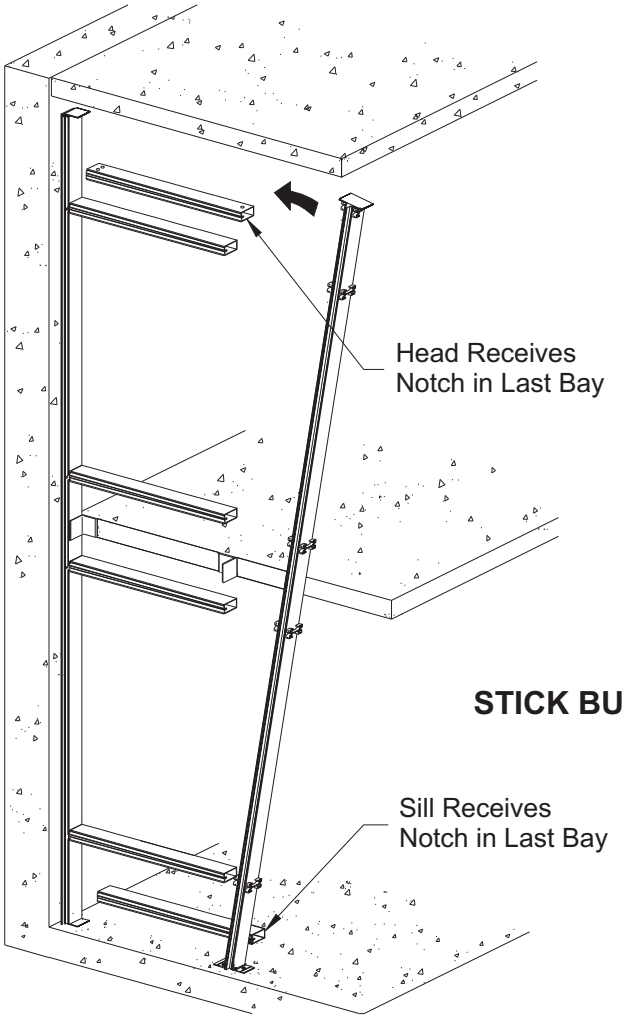
FRAME TYPES / ANCHORING METHODS

Mullions can be pre-assembled with shear blocks/clips, end anchors, and steel or aluminum reinforcing if necessary.

Framing Members for Stick Build:

-Tubular horizontal members are used at all intermediate locations except at end bays.
-Open back intermediate horizontals are used at end bays to clear the shear blocks.

Note: When using stick build construction, check overall frame width every fifth mullion as the wall is installed to prevent the buildup of cumulative tolerance errors. Mullions must be installed plumb, horizontals must be installed level.

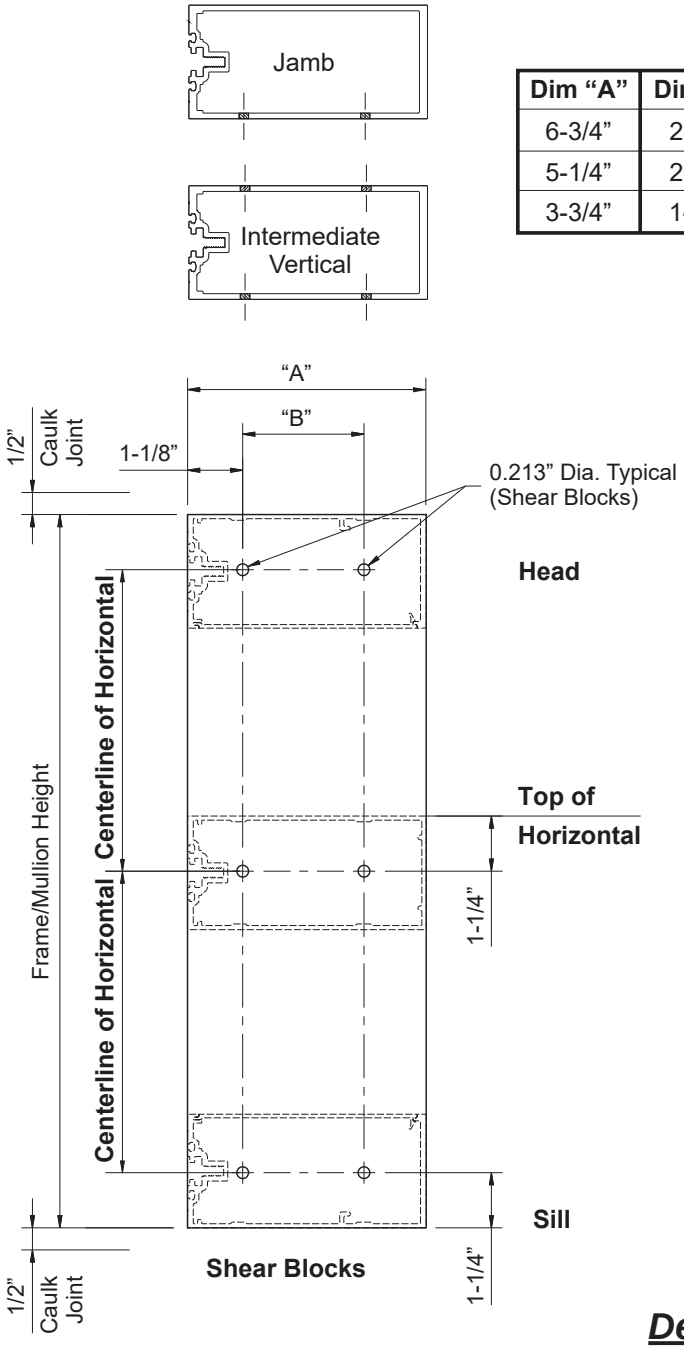


STICK BUILD

FRAME FABRICATION

STEP 1
FABRICATE MULLIONS

-Mullion hole locations for shear blocks are shown below.
-Drill 0.213” dia. (#3 drill bit) holes for shear block attachment at the locations indicated. See **Detail 1**.



Dim “A”	Dim “B”
6-3/4”	2-3/4”
5-1/4”	2-3/4”
3-3/4”	1-1/2”

*See Note on **Page iii**.

Detail 1

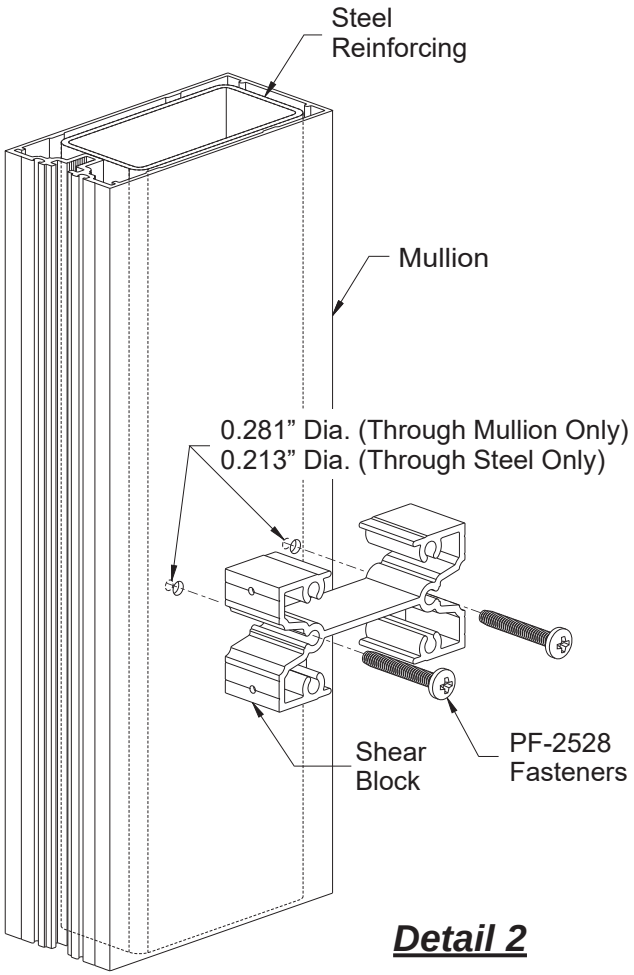
FRAME FABRICATION

STEP 2
USING ALTERNATE REINFORCING

Engineering calculations may require the mullions to be reinforced with either steel or aluminum.

-Reinforcing shall be attached to the mullion in accordance with engineering requirements
-Slide the reinforcing into the mullion and into position.
-When attaching reinforcing at shear block locations, drill a 0.281” diameter (#9/32 bit) hole in the mullion, being careful not to drill a hole in reinforcing.
-Drill a 0.213” diameter (#3 bit) hole in the reinforcing through the previous holes.
-Tap the 0.213” hole to accomodate a 1/4-20 fastener.
-Attach the shear blocks to the mullion and steel with two PF-2528 fasteners per block.
See **Detail 2**.

Note: Reinforcing to be determined by a qualified engineer.
Steel reinforcing must be coated to insulate the steel from the aluminum.



Detail 2

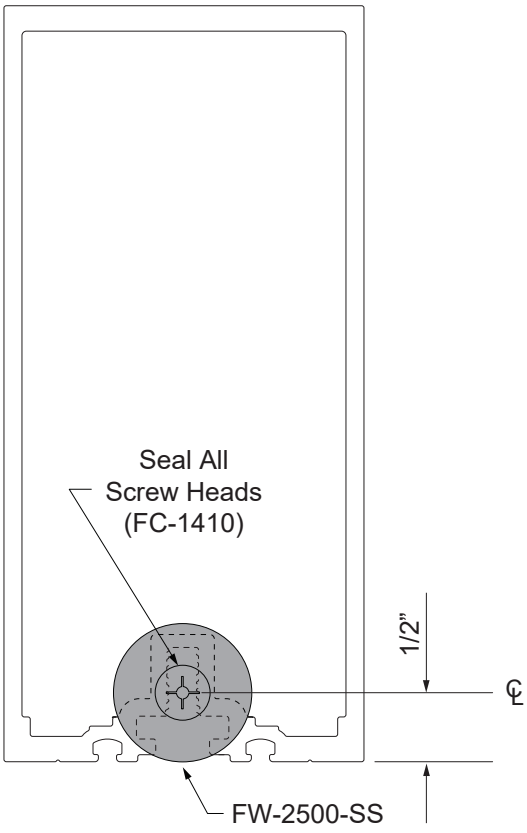
FRAME FABRICATION

STEP 3
ATTACH MULLION END CAPS

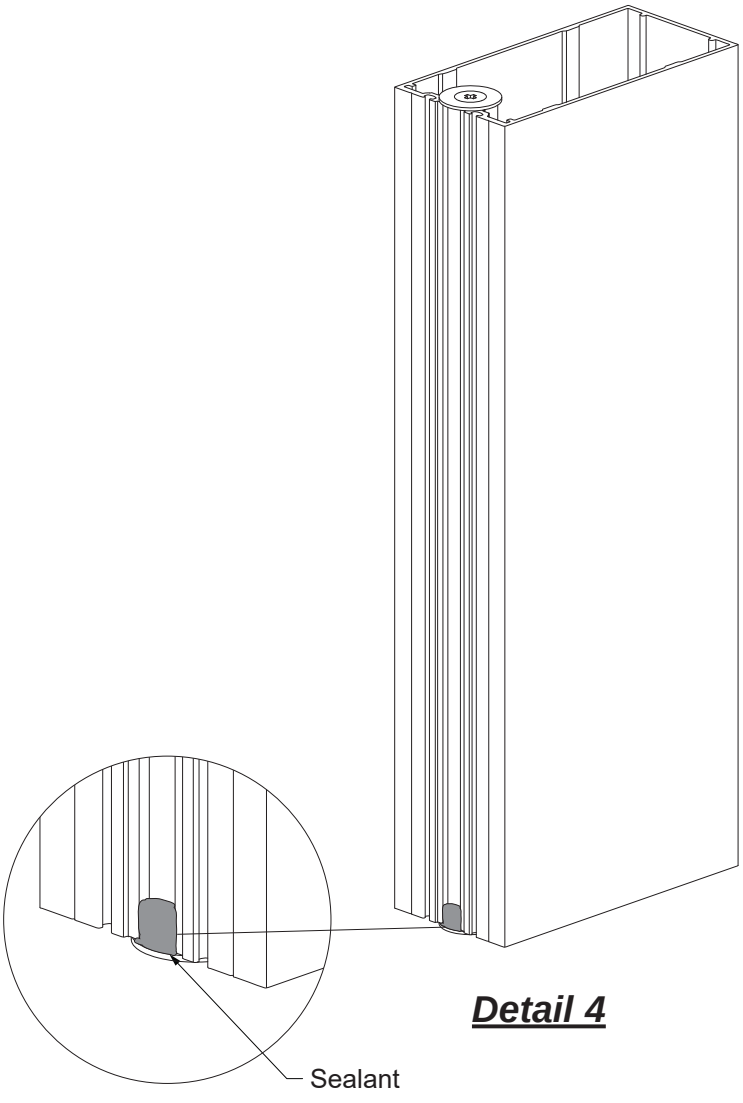
Mullion end caps are required at the head and sill of jamb and mullions.

-Clean the mullion ends and mullion end caps with a cleaner and method approved by the sealant manufacturer.
-Apply sealant to the spline cavity and along the front of the mullions on both ends prior to installing mullion end caps, FW-2500-SS.
-Attach the mullion end caps to each end of the mullion with FC-1410 fasteners as shown **Detail 3**.
-Tool the excess sealant flush between the mullion end cap and the mullion.
-Seal over all screw heads.
-At the bottom of the mullions, apply sealant to the center cavity to a height of 1/2”.

See **Detail 4**.



Detail 3



Detail 4

FRAME FABRICATION

STEP 4
ATTACH SHEAR BLOCKS FOR HORIZONTALS

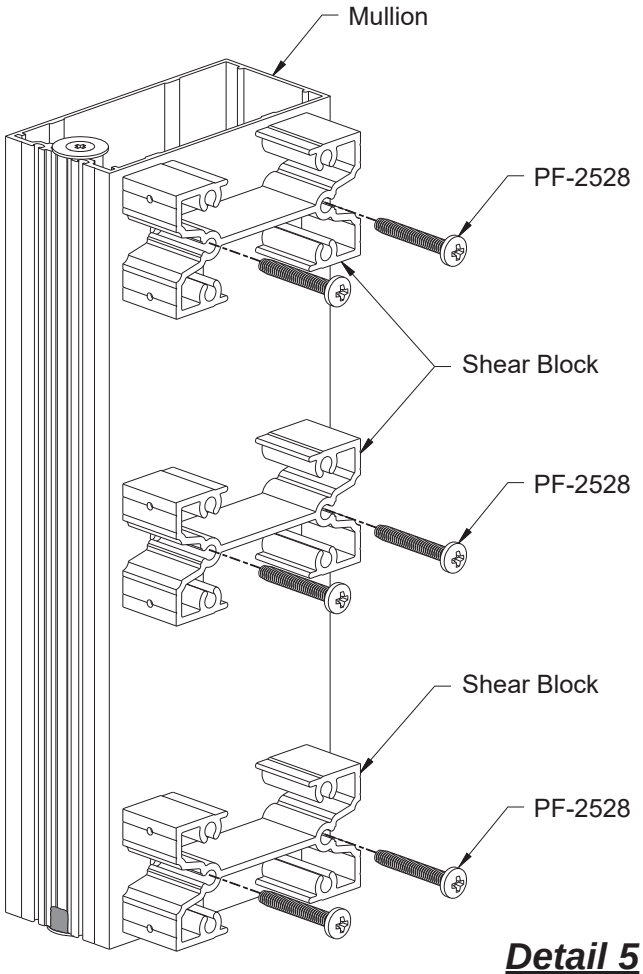
Shear blocks are used to attach horizontal members to the jamb and mullions:

-Attach the shear blocks to jambs and mullions with two PF-2528 fasteners per block.

See **Detail 5**.

-Additional fasteners may be required to accomodate special project conditions.

Note: See **Step 2** on **Page 8** when using reinforcing.



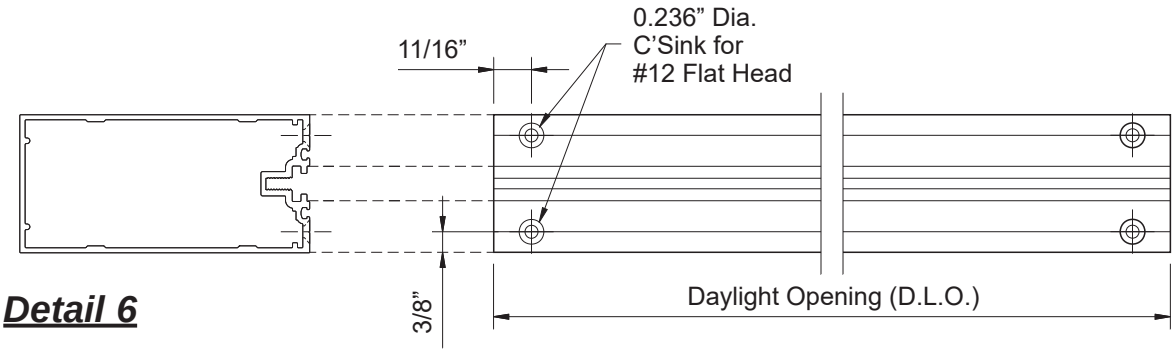
Detail 5

FRAME FABRICATION

STEP 5
FABRICATE HORIZONTAL MEMBERS

Horizontals with Concealed Fasteners:

-Layout hole locations on the face of the horizontal at both ends as shown below.
-Drill 0.236” diameter (#B bit) holes and countersink for #12 flat head fasteners.
See **Detail 6**.

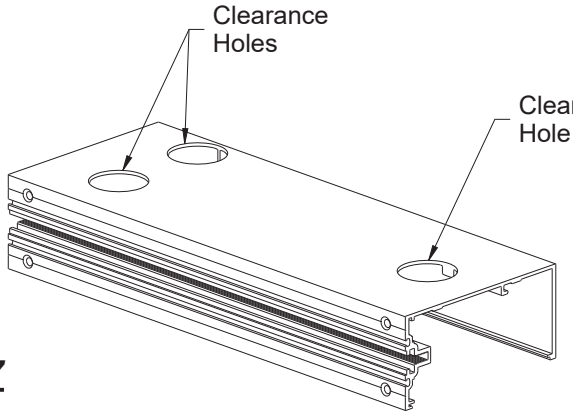


Detail 6

Head and Sill Horizontal Member Anchor Preps:

-Drill appropriate size clearance holes at each end of the mullion as shown in **Detail 7**, or according to shop drawings or engineering calculations to align with corresponding anchor holes in “T” and “F” anchors.

Typical Fabrication for “F” Anchor



Typical Fabrication for “T” Anchor

Detail 7

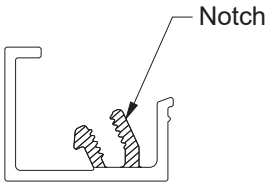
FRAME FABRICATION

STEP 6
FABRICATE PERIMETER TRIM

-Cut E9-3409 perimeter trim as shown in **Detail 8**.
-For elevations over 24’ in length or height, perimeter trim must be spliced. Perimeter trim splice joint must be 1/2” and located no more than 18’ between splice joints. Refer to **Detail 29** on **Page 26.**

-Notch perimeter trim 1-1/4” from each splice end as shown in **Detail 9**.

Detail 8



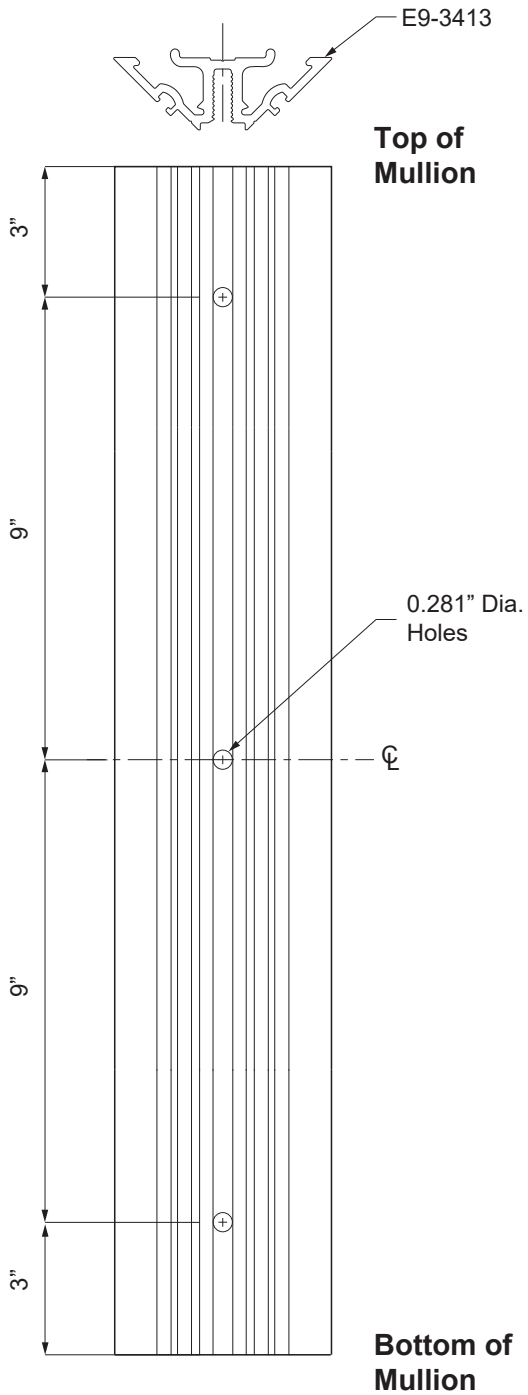
Detail 9

FRAME FABRICATION

STEP 7
FABRICATE CORNER GLAZING ADAPTOR

-Cut E9-3413 outside corner mullion adaptor to vertical mullion length.
-Drill 0.281” dia. (9/32 bit) clear holes every 9” on center.

See **Detail 10**.



Detail 10

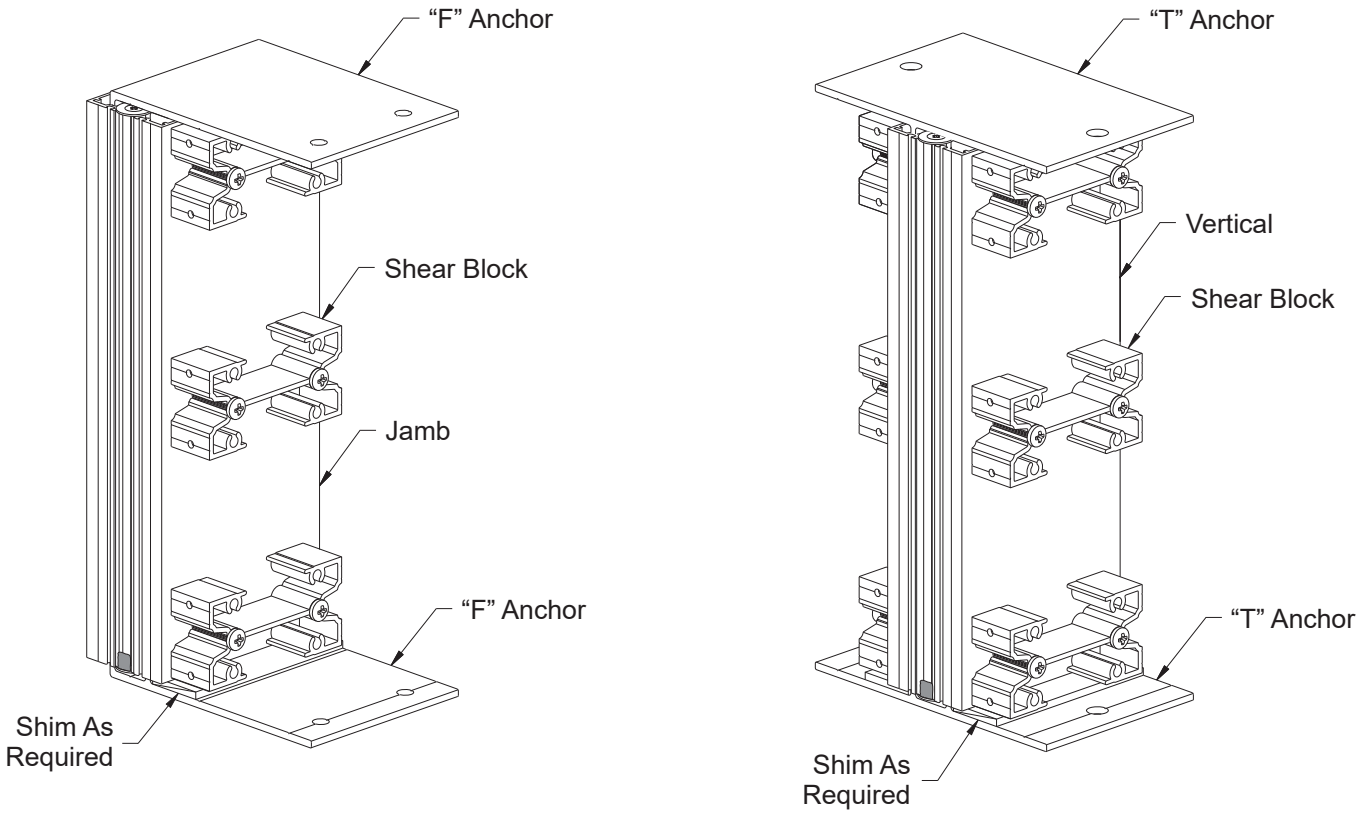
FRAME INSTALLATION

STEP 8
JAMB/MULLION INSTALLATION
WITH MULLION END ANCHORS

-Insert mullion “T” and “F” end anchors into the top and bottom of the mullions before erecting them into the opening.
-Position the jamb and intermediate mullions and attach them to the structure.

See **Detail 11**.

Note: Shim under the mullions to transfer glazing dead loads to the building structure.



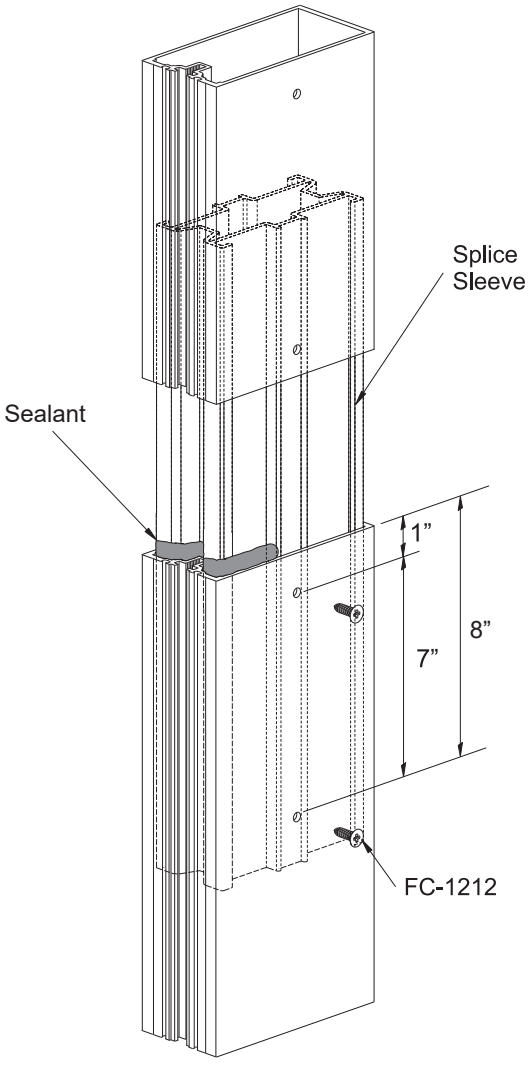
Detail 11

FRAME INSTALLATION

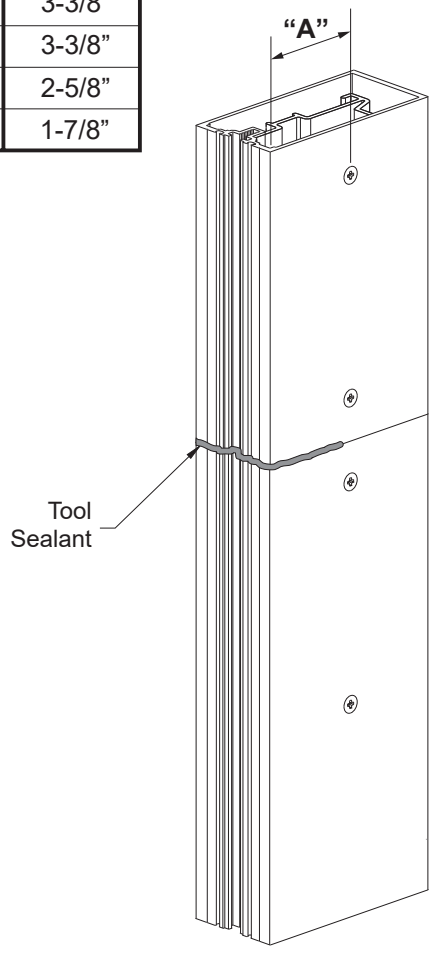
STEP 9
TYPICAL MULLION SPLICE

-Clean all surfaces as recommended by sealant manufacturer.
-Drill .236” splice sleeve attachment holes into the upper and lower mullion. Attachment hole locations should be drilled as shown in chart below from the front and back of mullion, and 1” and 8” down from the top of the lower mullion and 1” and 8” up from the bottom of the upper mullion.
-Lower the splice sleeve into top of lower mullion 9”. Match drill .189” splice sleeve anchor holes into the splice sleeve and attach with (2) two FC-1212 fasteners, on both sides of the lower mullion.
-Slide the upper mullion down over the splice sleeve flush with the top of the lower mullion. Match drill .189” splice sleeve anchor holes into the splice sleeve and attach with (2) two FC-1212 fasteners, on both sides of the upper mullion.
-Apply and tool sealant to the face and sides of the splice sleeve. See Note on **Page iii**.

See **Detail 12**.



Mullion Depth	Dim “A”
8-1/4”	3-3/8”
6-3/4”	3-3/8”
5-1/4”	2-5/8”
3-3/4”	1-7/8”

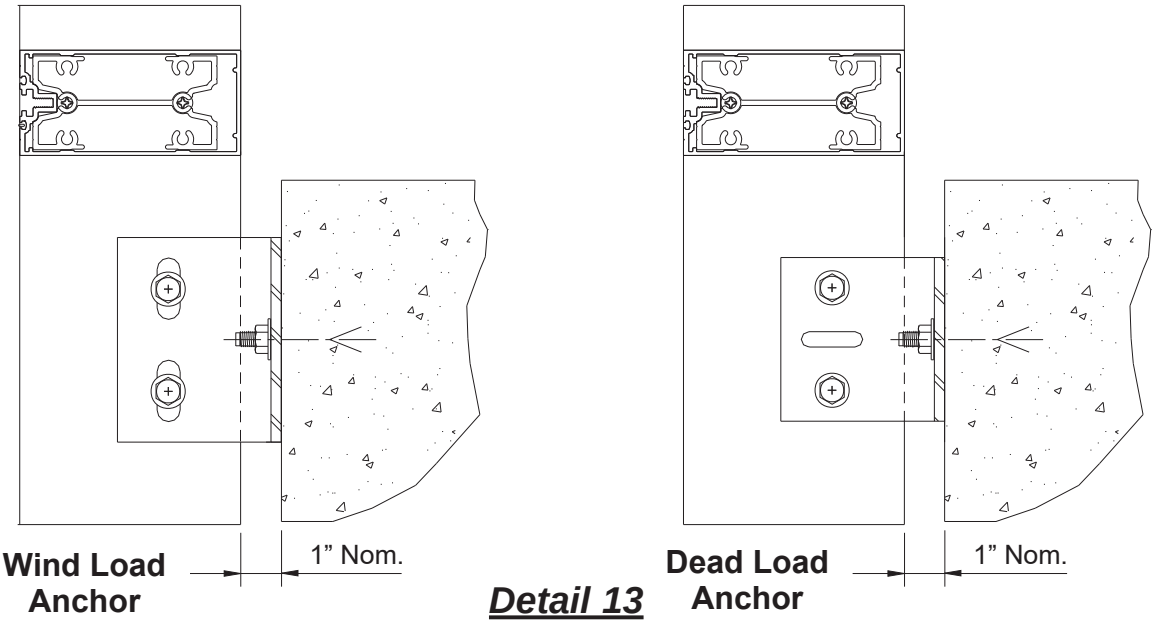


Detail 12

FRAME INSTALLATION

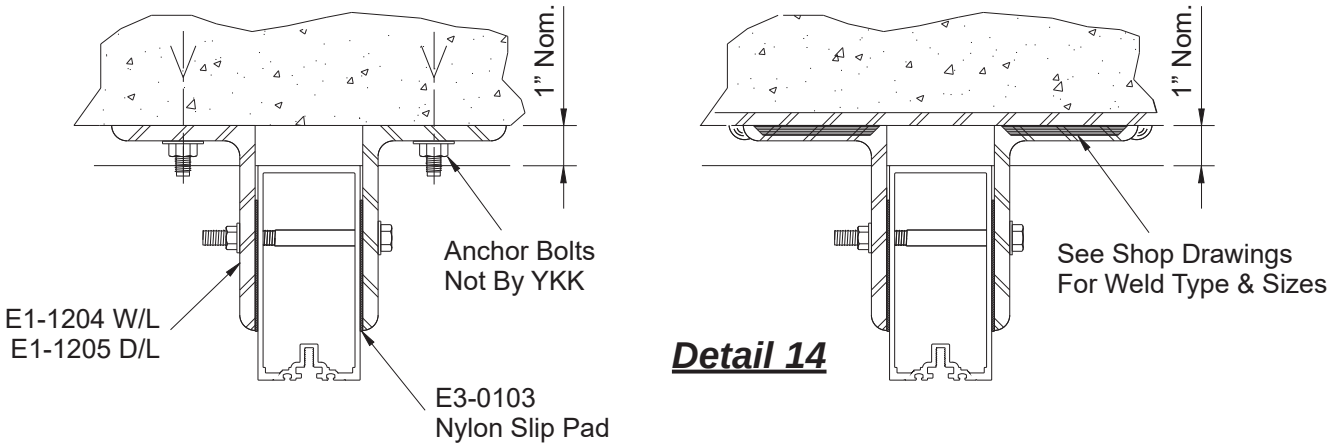
STEP 10
INSTALL WIND LOAD / DEAD LOAD ANCHORS

-Install steel wind load and dead load anchor clips. Anchor clips are normally template or line set before mullions are installed . When using standard YKK AP anchors, typical space between the back of the mullion and the anchoring substrate to be 1” nominal.
See **Detail 13**.



Detail 13

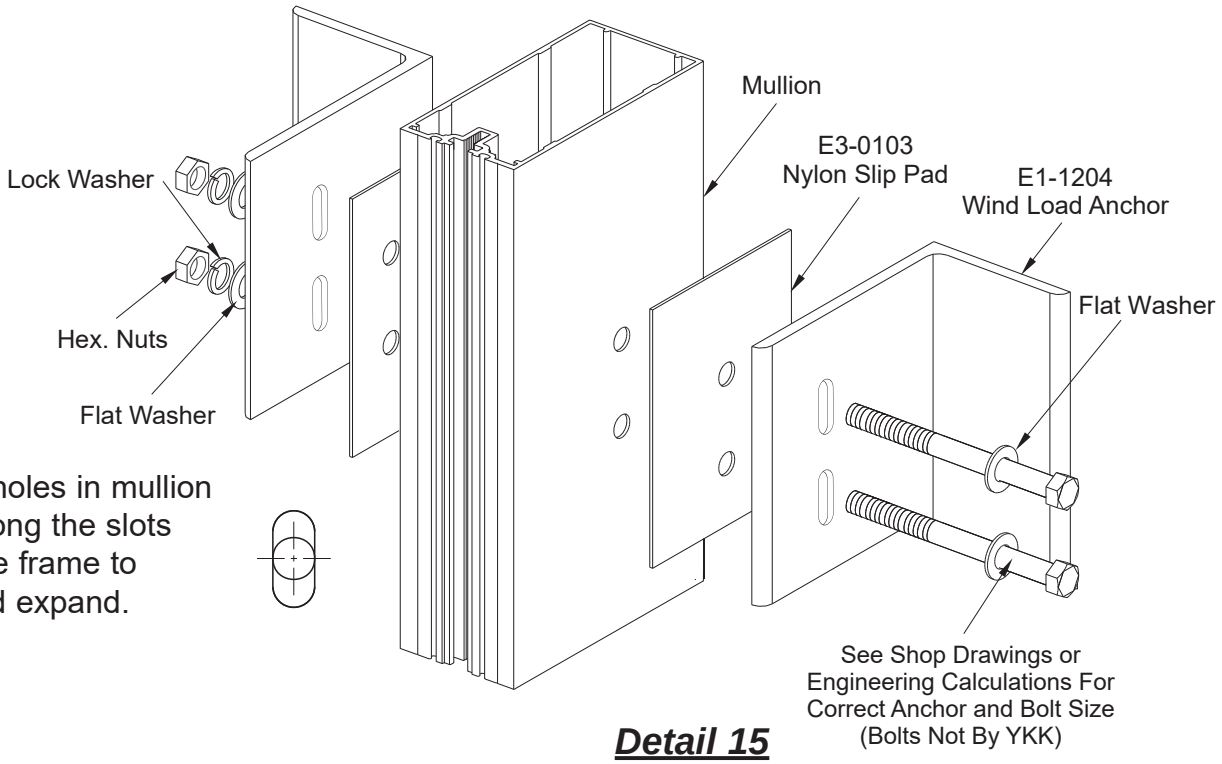
-After positioning mullions, drill and install appropriate diameter anchor bolts. All anchors and bolts must be checked by a qualified engineer.
-Nylon slip pads, E3-0103, must be installed between mullion and anchor.
See **Detail 14**.



Detail 14

FRAME INSTALLATION

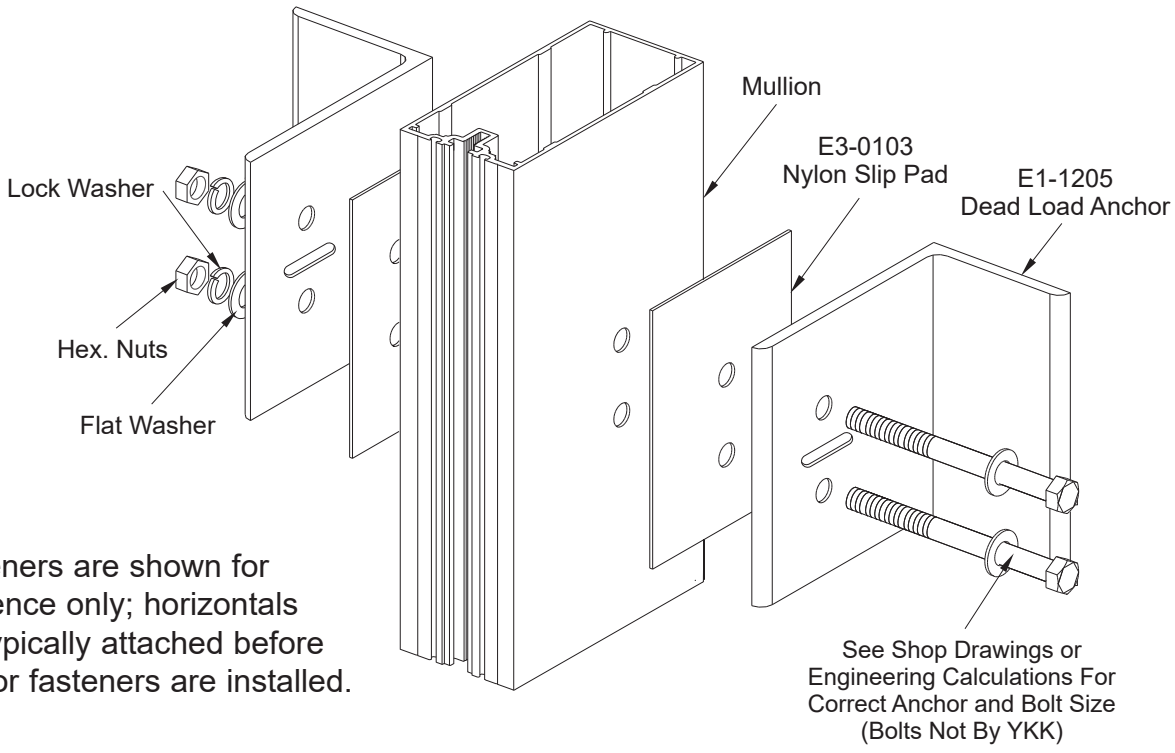
TYPICAL WIND LOAD ANCHOR



Note: Drill holes in mullion centered along the slots to permit the frame to contract and expand.

Detail 15

TYPICAL DEAD LOAD ANCHOR



Note: Fasteners are shown for reference only; horizontals are typically attached before anchor fasteners are installed.

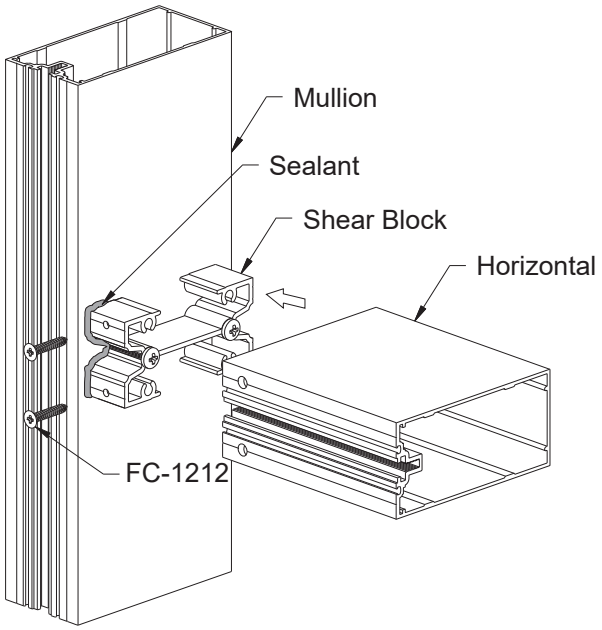
FRAME INSTALLATION

STEP 11
ATTACH HORIZONTAL MEMBERS

Note: Before applying any sealant, clean aluminum surfaces using cleaner and method approved by sealant manufacturer.

-Just prior to attaching the horizontal members to the mullion, apply sealant to the front of the shear block as shown.
-Slide the horizontal members towards the mullion and attach them to the shear blocks at each end with two FC-1212 fasteners.
-Tool and wipe away any excess sealant at the mullion to horizontal joints.
-Seal horizontal to shear block fastener heads.

See **Detail 16**.



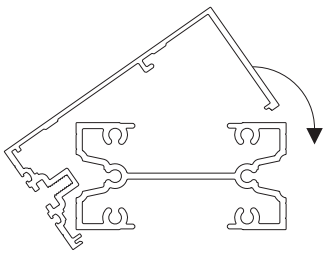
Detail 16

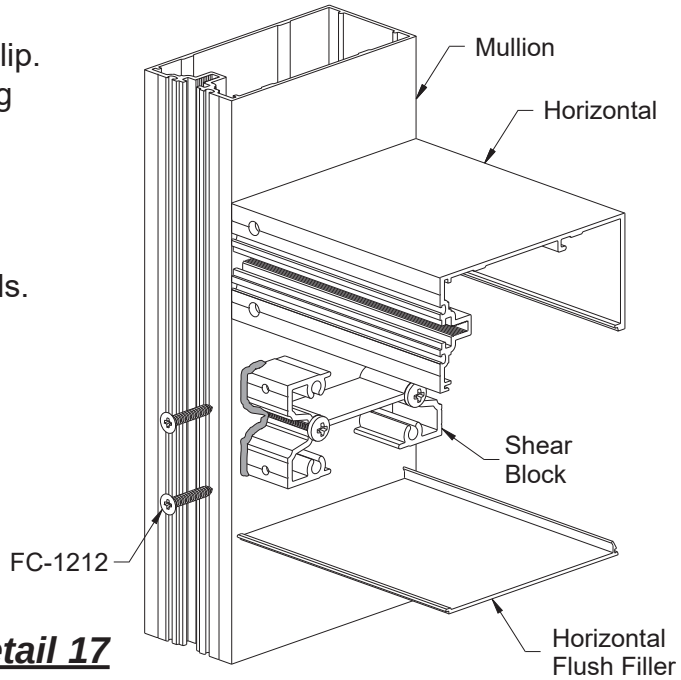
For Two Piece Horizontals:

Note: Before applying any sealant, clean aluminum surfaces using cleaner and method approved by sealant manufacturer.

-Just prior to attaching the horizontal members to the mullion, apply sealant to the front of the shear block as shown.
-Rotate the horizontal down over the shear clip. Make sure the horizontal and mullion glazing pockets are flush.
-Attach the horizontals to the shear blocks with two FC-1212 fasteners.
-Snap on the horizontal flush filler.
-Seal horizontal to shear block fastener heads.

See **Detail 17**.





Detail 17

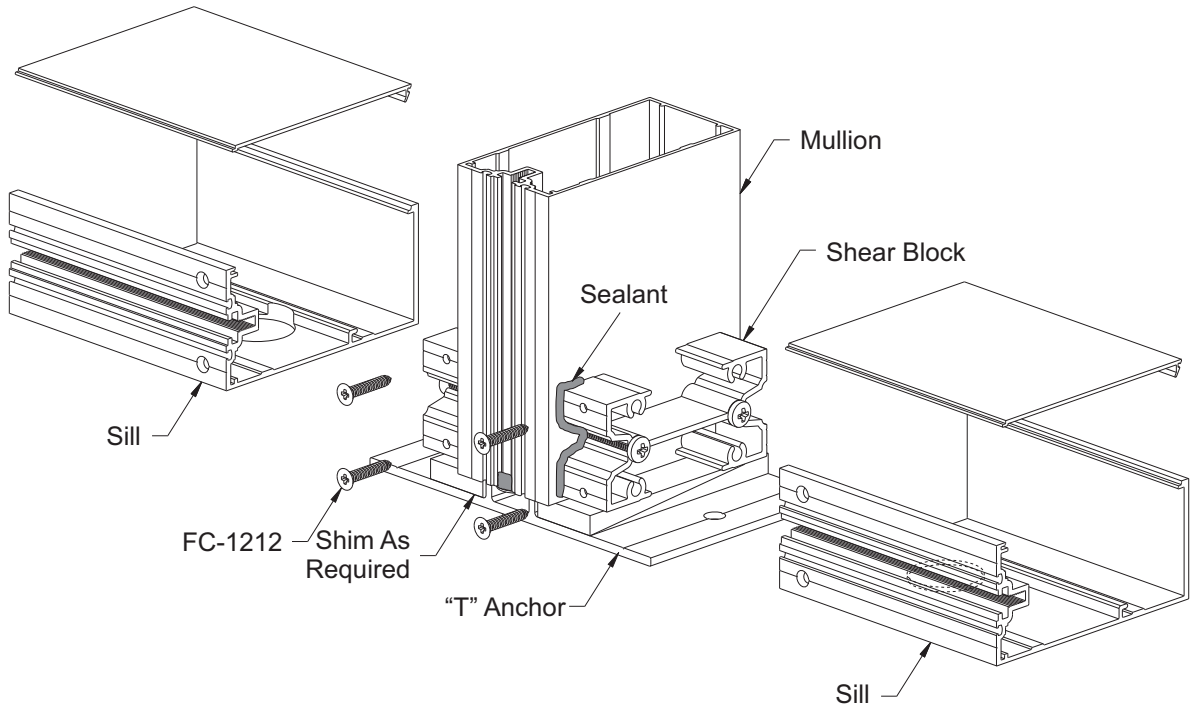
FRAME INSTALLATION

STEP 11 (Continued)
ATTACH HEAD AND SILL MEMBERS

Note: Before applying any sealant, clean aluminum surfaces using cleaner and method approved by sealant manufacturer.

-Just prior to attaching the horizontal members to the mullion, apply sealant to the front of the shear block as shown.
-Seal head/sill to shear block fastener heads.

See **Detail 18**.



Detail 18

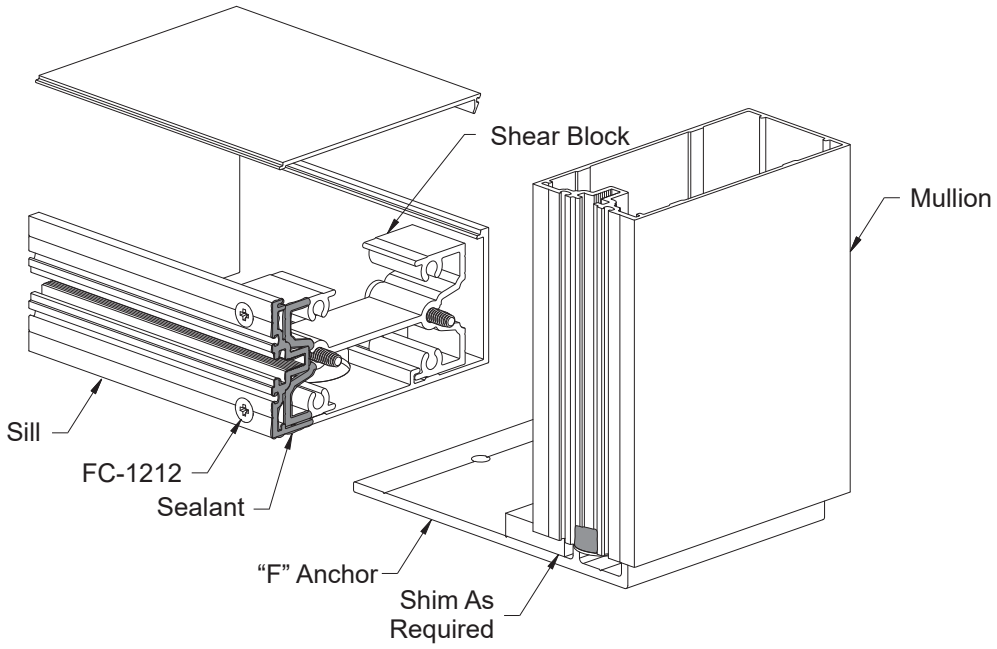
STEP 11 (Continued)
ATTACH HEAD AND SILL MEMBERS

Open Back Head & Sill Members at End Bays:

-To clear the mullions at end bays shear blocks must be pre-attached to the head and sill members through the face of the mullion with FC-1212 fasteners.
-Just prior to attaching the horizontal members to the mullion, apply sealant to the front of the horizontal and shear block as shown.
-Position the head/sill members into place and attach the shear blocks to the mullions with two PF-2528 fasteners per shear block.
-Provide anchor fasteners per approved shop drawings or engineering calculations.
-Install the anchor fasteners as recommended by fastener manufacturer.
-Snap on the mullion flush filler.
-Seal head/sill to shear block fastener heads.

See **Detail 19**.

Caution: A solid shim **must** be placed under the mullion to transfer glazing dead loads to the foundation.



Detail 19

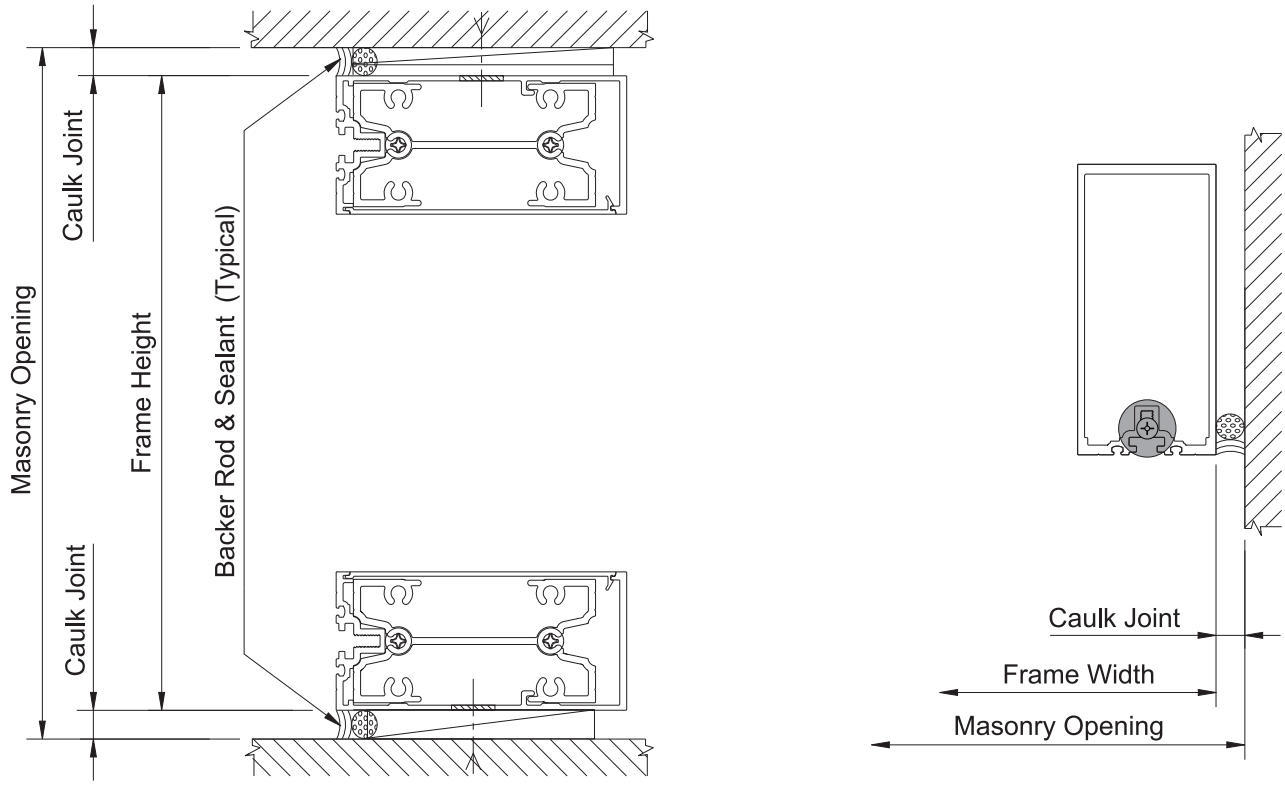
FRAME INSTALLATION

STEP 12
APPLY PERIMETER SEALANT

-Clean the area around the perimeter of the frame with cleaner and method approved by sealant manufacturer. **Note:** Taping the front face of the mullion is recommended to keep the surface free of sealant.
-Place backer rod between the perimeter of the frame and the substrate.
-Apply and tool sealant to the substrate and the curtain wall frame.

See **Detail 20**.

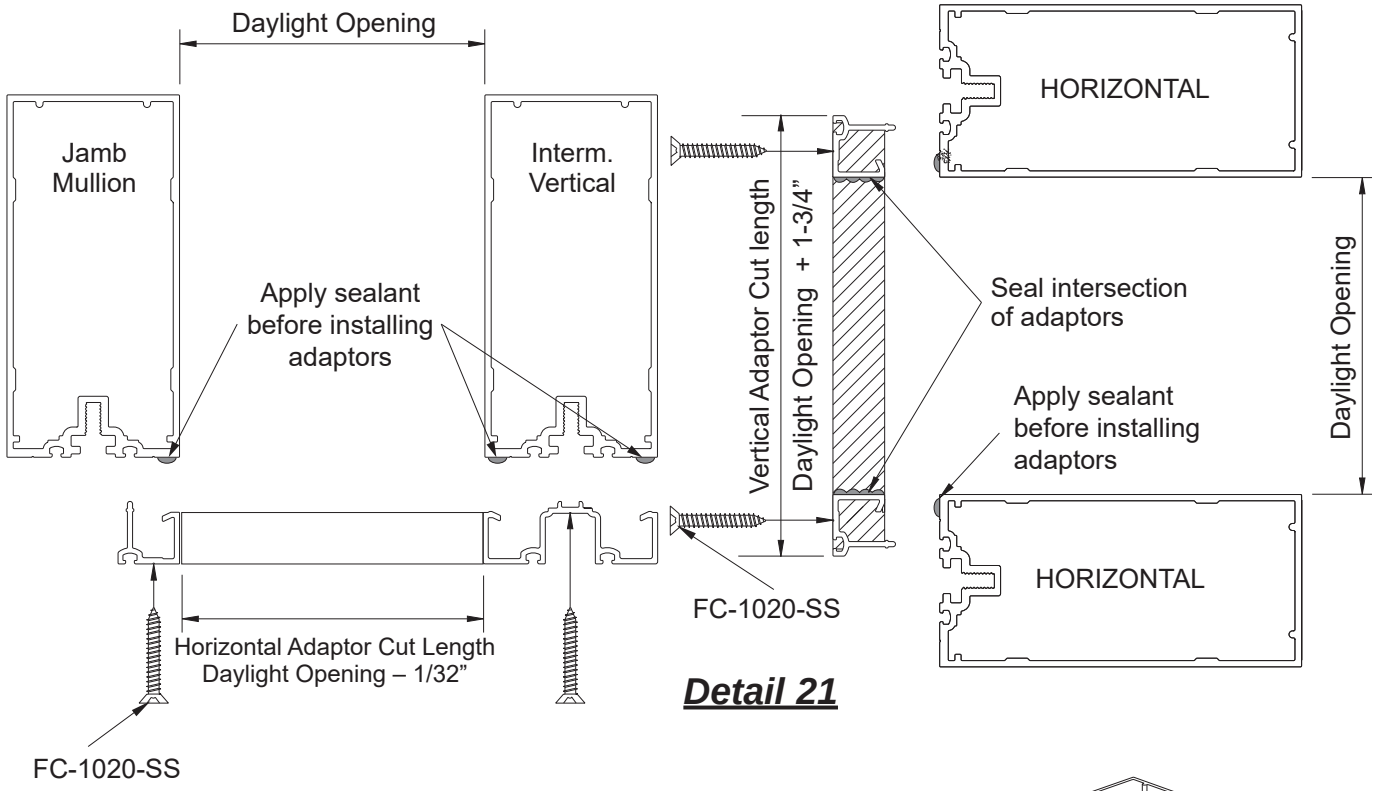
Note: Additional space at the caulk joint may be required to allow for expansion and/or contraction of the system per a qualified engineer's review, (1/2" typical, 1/4" minimum).



Detail 20

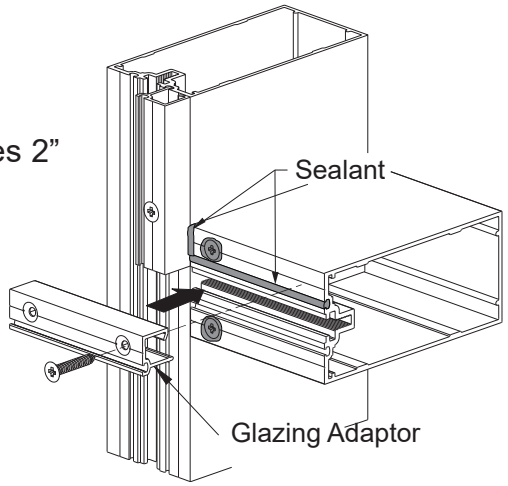
GLAZING

STEP 13
INSTALL GLAZING ADAPTORS
(When Required for 1/4" Glazing)



Detail 21

-Cut glazing adaptors to size:
Vertical Cut Length = Daylight Opening plus(+) 1-3/4".
Horizontal Cut Length = Daylight Opening minus(–) 1/32".
-Drill and countersink each adaptor with 0.189" dia. (#12) holes 2" from each end and 24" O.C., or as directed by P.E. calculations.
-Dry fit adaptors and match drill 0.141" diameter (#3) holes on mullion to receive FC-1020-SS screws.
-Clean the area around the mullion glazing reglet and the glazing adaptor with a cleaner approved by the sealant manufacturer.
-Apply sealant to the front face of the mullion as shown, and the ends of the horizontal adaptors.
-Install the adaptors with FC-1020-SS screws. Install the horizontal adaptors first centered along the daylight opening.
-Tool sealant at all adaptor intersections and seal all screw heads.
See **Detail 21** and **Detail 22**.



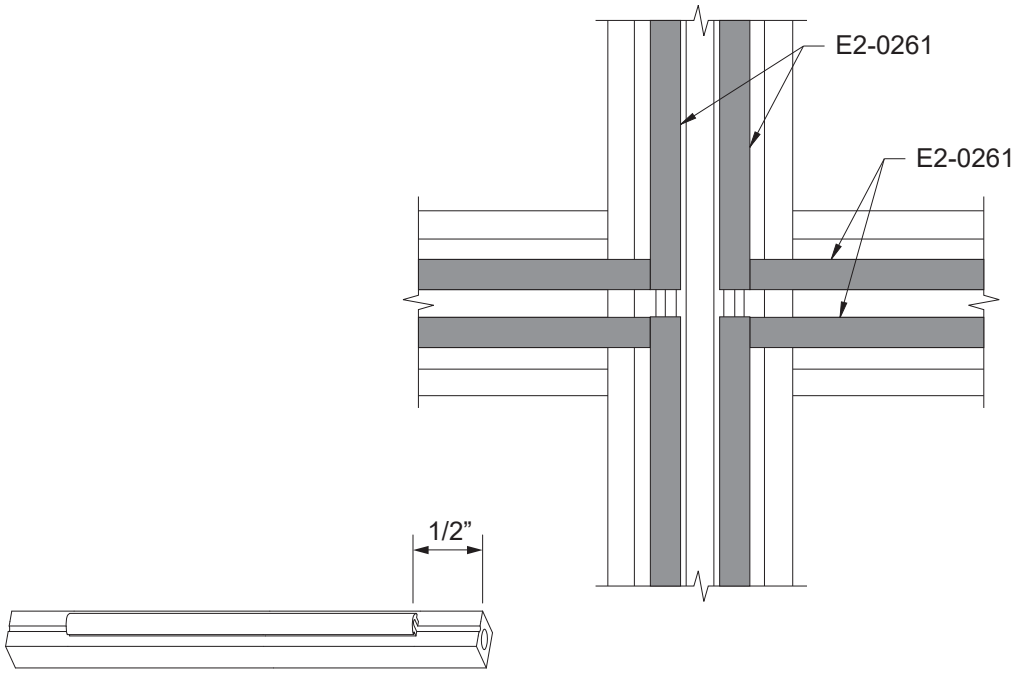
Detail 22

GLAZING

STEP 14
INSTALL INTERIOR GLAZING SPACERS

-Cut vertical glazing spacers to Daylight Opening plus (+) 1-3/4". If no glazing adaptors are used, vertical glazing spacers may run continuous to the length of the vertcial mullion
-Cut horizontal glazing spacers to Daylight Opening + 1".
-Install vertical glazing spacers first, centered along the daylight opening.
-Notch dart off 1/2" on both ends of horizontal gasket as shown in **Detail 22**.
-Install horizontal glazing spacers by pushing each end into the reglet. Next press the center of glazing spacer into the reglet and then push the rest of the spacer into the reglet working from the center towards each end.

See **Detail 23**.



Detail 23

Glazing

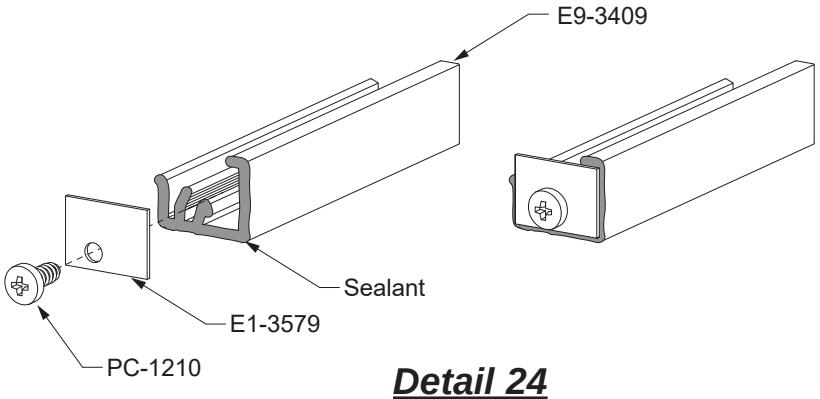
STEP 15
ATTACH PERIMETER TRIM

Sill and Jamb Perimeter Trim

Note: E1-3579 end cap must be attached at each end of the E9-3409 head, jamb and sill perimeter trim.

-Clean all joint surfaces using cleaner approved by sealant manufacturer.
-Apply sealant to the E9-3409 perimeter trim as shown in **Detail 24**.
-Fasten the E1-3579 end cap to the E9-3409 perimeter trim with one PC-1210 screw.
-Clean and remove excess sealant.

See **Detail 24**.



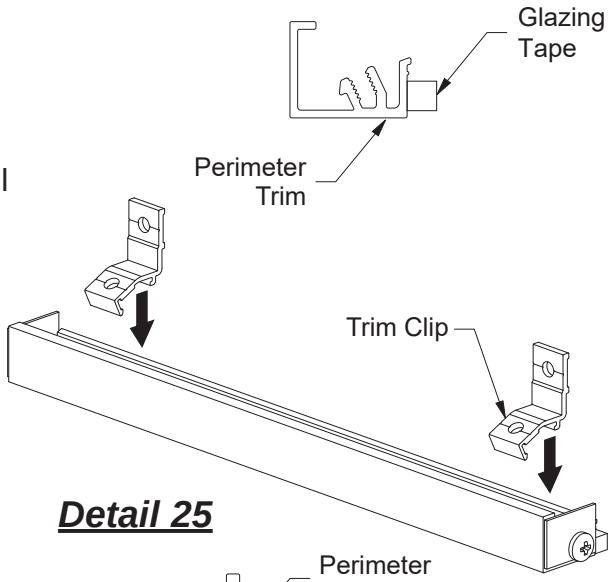
Detail 24

Glazing

STEP 15 (Continued)
ATTACH PERIMETER TRIM

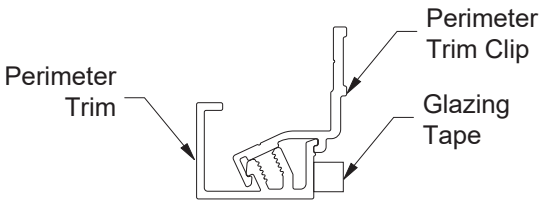
Sill Perimeter Trim

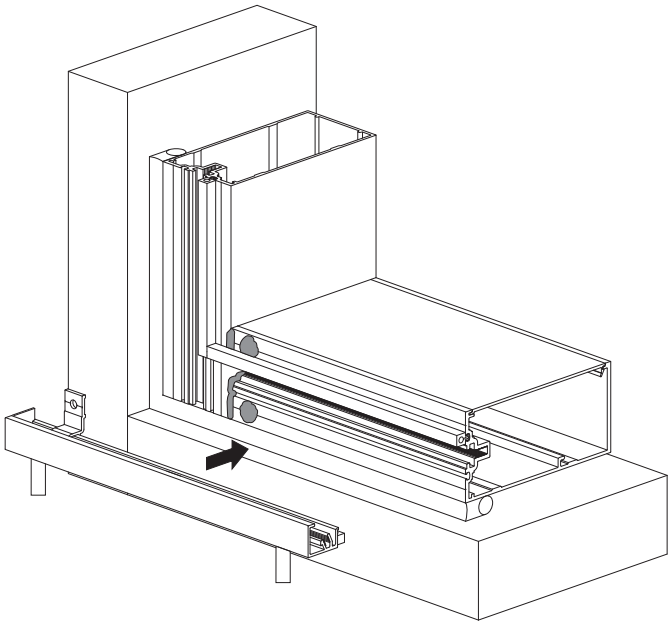
-Apply E2-0110 spacer tape to the entire length of the E9-3409 perimeter trim member.
-Attach E1-3543 perimeter trim clip to the E9-3409 perimeter trim member 1-1/4” from each end and at all intermediate vertical locations. Trim clip locations can be adjusted after perimeter trim is adhered to the sill member
See **Detail 25.**



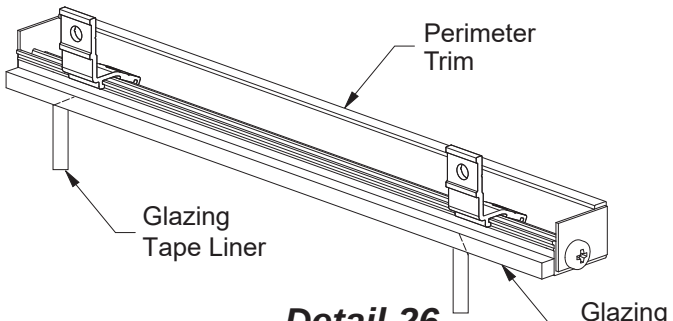
Detail 25

-Pull back the tapes liner of the perimeter trim 2” from each end to expose the adhesive backing.
-Press the perimeter trim firmly onto the sill member.
-Pull the remaining tape liner from the tape of the perimeter trim while continuing to press the perimeter trim firmly against the sill member.
See **Detail 26** and **Detail 27**.





Detail 27



Detail 26

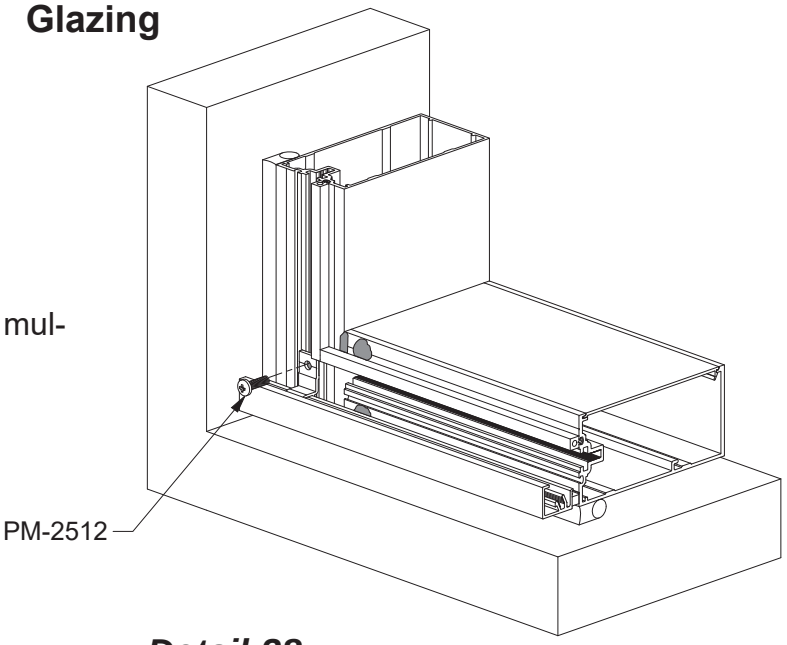
Glazing

STEP 15 (Continued)
ATTACH PERIMETER TRIM

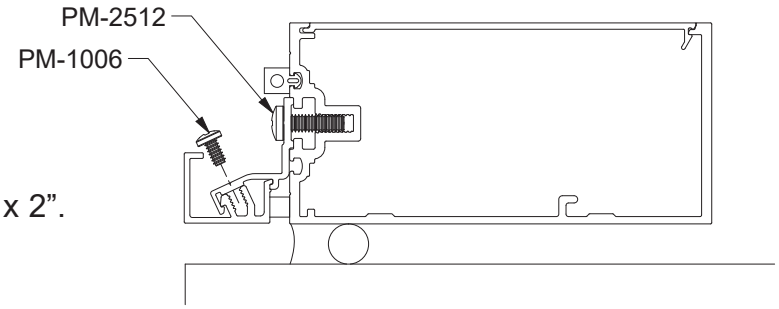
Sill and Head Perimeter Trim

-Using PM-2512-SS fasteners, fasten the perimeter trim clips into the spline of the mullions.
-Using PM-1006-SS fasteners, fasten the perimeter trim clip into the spline of the perimeter trim.

See **Detail 28**.



Detail 28

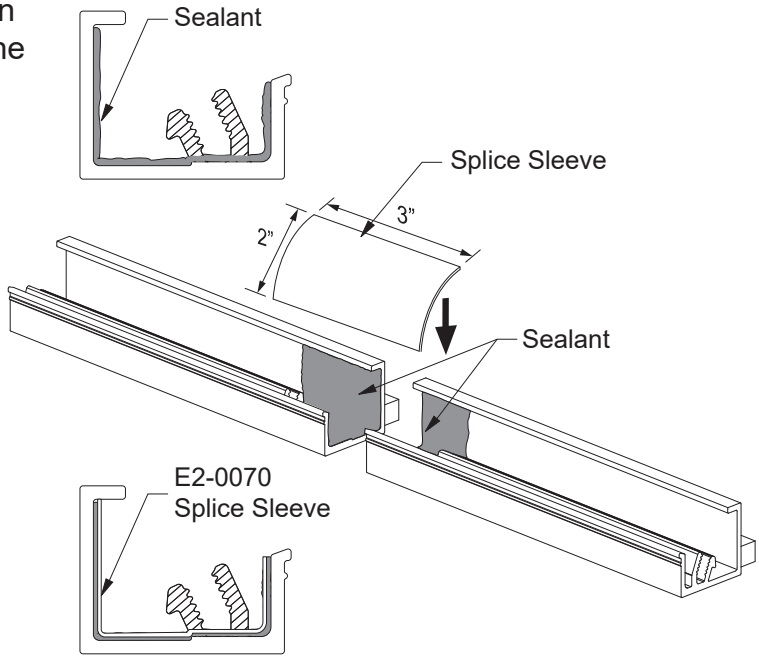


Sill Perimeter Trim Splice

-Cut E2-0070 silicone splice sleeve to 3” x 2”.
-Clean perimeter trim and silicone splice sleeve per sealant manufacturer’s recommendations at the splice location.
-Seal the perimeter trim at the splice location as shown in **Detail 29**, before positioning the flashing. Fit the silicone splice sleeve into the perimeter trim.
-Tool excess sealant.

See **Detail 29**.

Detail 29



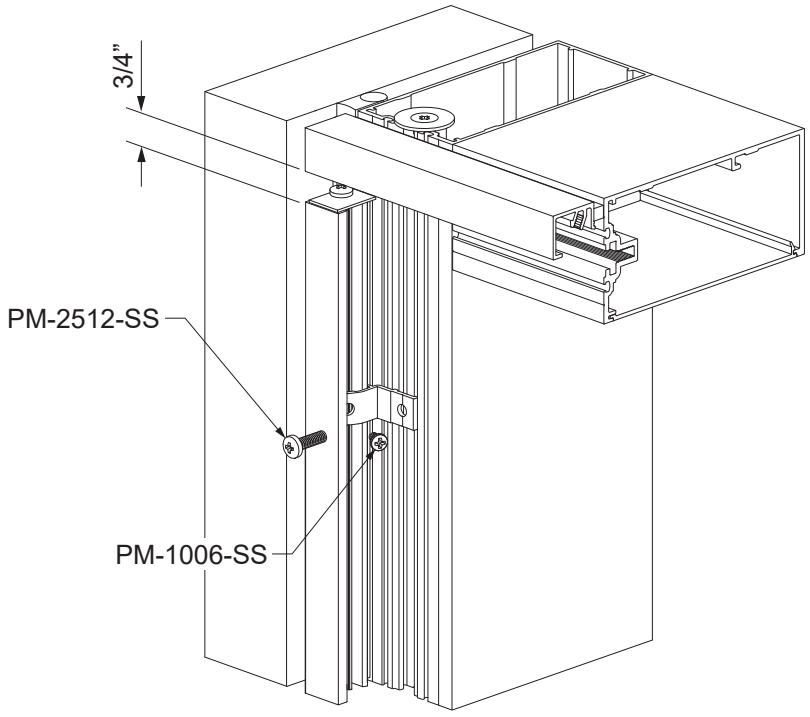
Glazing

STEP 15 (Continued)
ATTACH PERIMETER TRIM

Jamb Perimeter Trim

-Prepare the perimeter trim at jamb locations as stated on **Page 25**.
-Trim clips should be located 2” from each end of the perimeter trim, and 3’ on center.
-Using PM-2512-SS fasteners, fasten the perimeter trim clips into the spline of the jamb member.
-Using PM-1006-SS fasteners, fasten the perimeter trim clip into the spline of the perimeter trim.

See **Detail 30**.



Detail 30

Head Condition Shown, Sill Condition Similar

Glazing

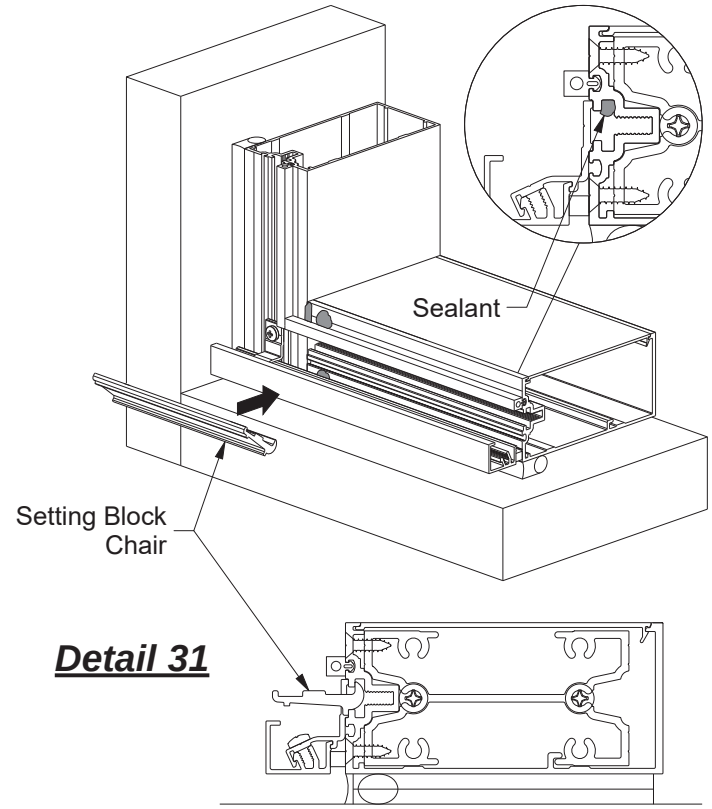
STEP 16
INSTALL SETTING BLOCK CHAIRS AND SETTING BLOCKS

Note:
Setting block chairs and setting blocks to be located at 1/4 points, or in accordance with glass manufacturers requirements.

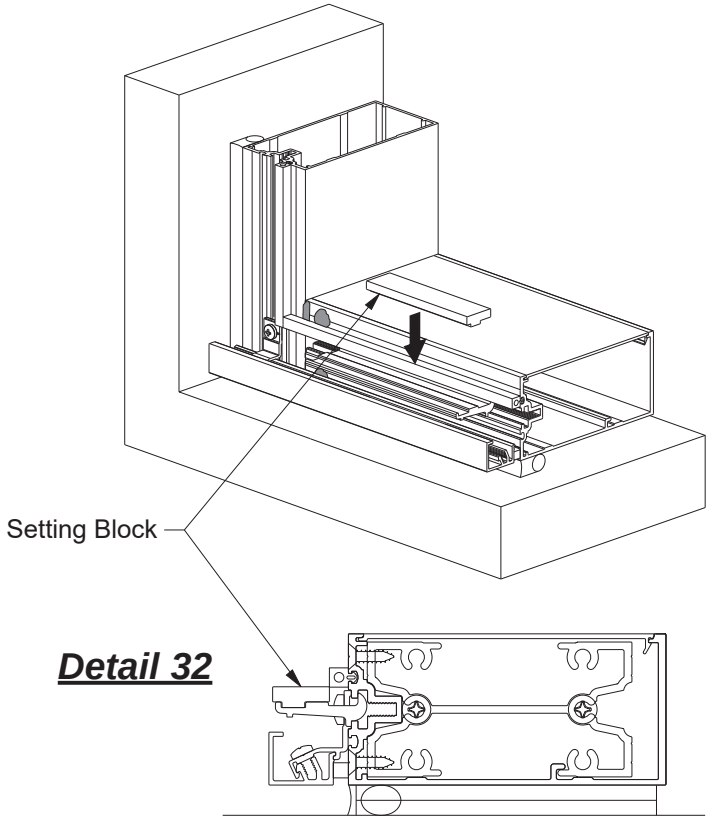
-Install the setting block chair, E1-3545. See **Detail 31**.

-Adhere the setting block E2-0224 to the top side of the setting block chair by removing tape backing.

See **Detail 32**.



Detail 31

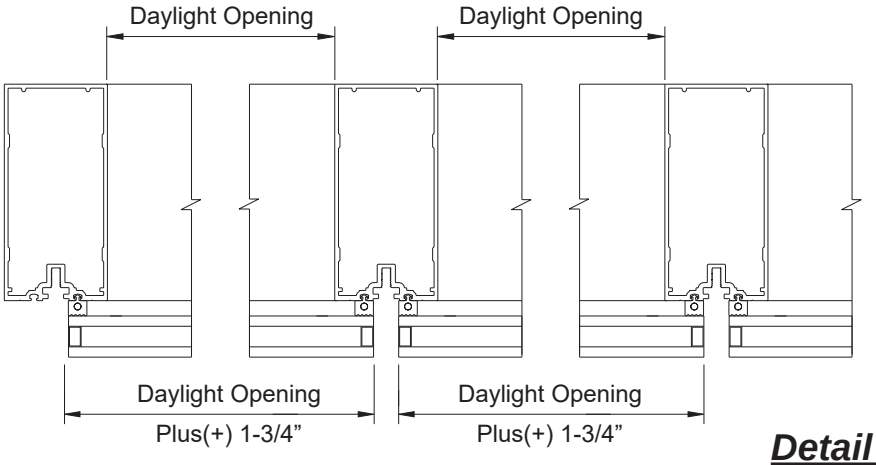


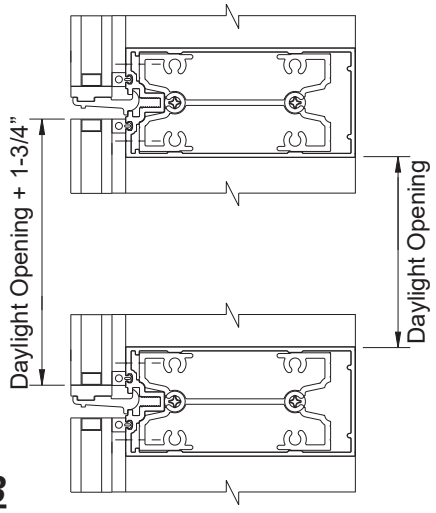
Detail 32

GLAZING

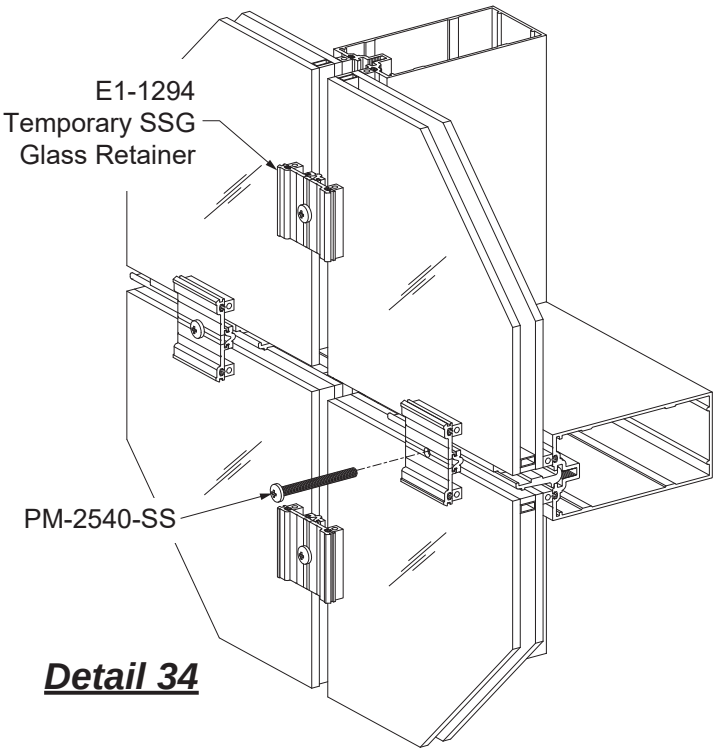
STEP 17
INSTALL GLASS

-Install glass at this time. See **Detail 33** for glass sizes.
-As each lite is installed, attach temporary glass retainers E1-1294, in the middle of each horizontal and 6” from glass edge at each end.
-Additionally, secure glass with temporary glass retainers every 2’-0” maximum vertically and horizontally.
See **Detail 34**.





Detail 33

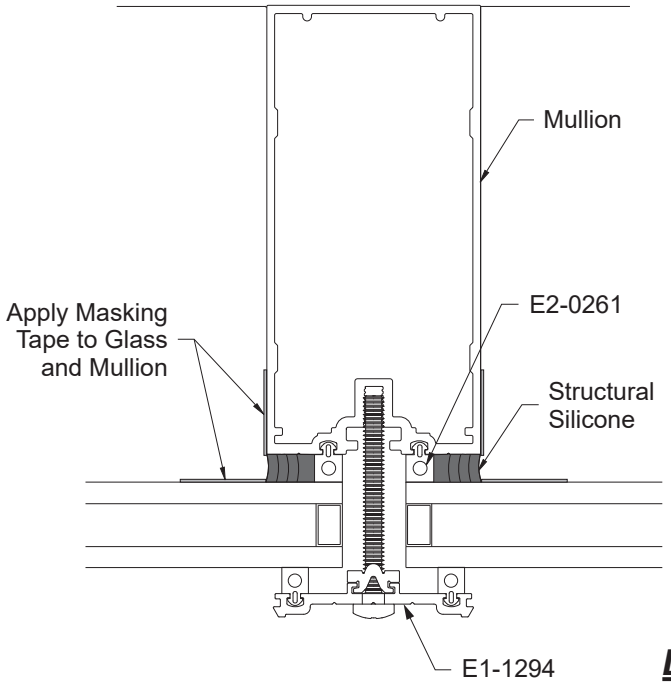


Detail 34

GLAZING

STEP 18
APPLY INTERIOR STRUCTURAL SILICONE SEALANT

-Carefully read and follow sealant manufacturers instructions.
-Make sure all silicone contact surfaces and joints have been cleaned with cleaner and method recommended by sealant manufacturer.
-Apply masking tape to the mullion and glass as shown in **Detail 35**.
-Apply an approved structural silicone from the bottom to the top of the joint. Use positive pressure to completely fill the cavity between the glass and mullion.
-Using a nylon spatula or other non-scratching implement, tool the silicone immediately after running the mullion joint. Exert positive pressure while tooling to ensure that the silicone completely fills the cavity.
-Be careful not to remove too much silicone when tooling. The silicone should make complete contact with the glass and aluminum surfaces. The finished joint should be flush with the edge of the mullions and horizontals.
See **Detail 35**.
-Remove masking tape immediately after tooling before silicone skin forms.
-Allow silicone to cure as per manufacturer's recommendations. Temporary retainers should be left in place until silicone has fully cured. Contact structural silicone manufacturer for expected cure times.



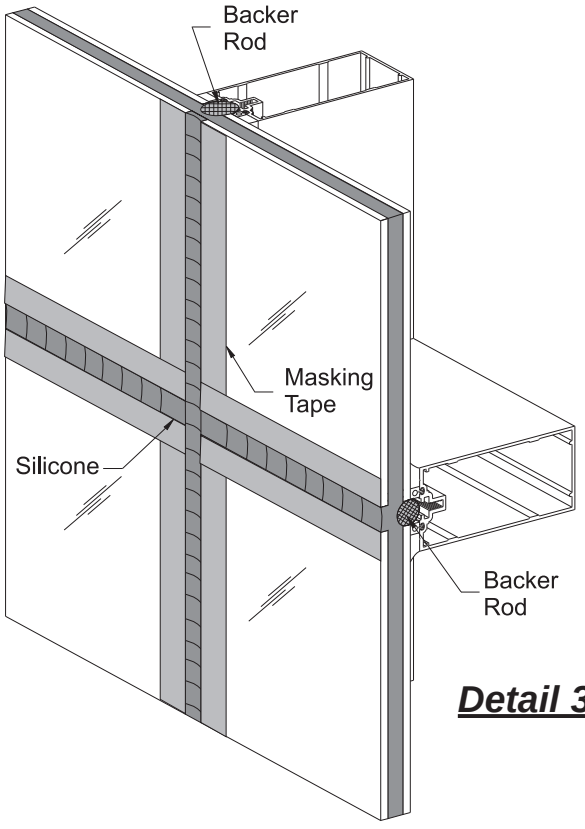
Detail 35

Caution: Do not permit the silicone to skin over before it is tooled. Immediately remove masking tape after tooling the silicone.

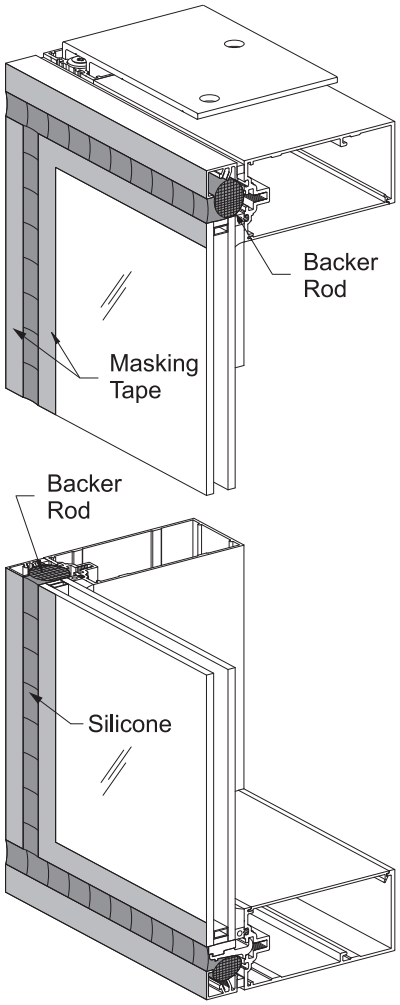
GLAZING

STEP 19
APPLY EXTERIOR WEATHERSEAL

-Once interior structural silicone has fully cured, remove the temporary retainer clips and insert backer rod between the lites of glass.
-Clean all silicone contact surfaces and joints with cleaner and method recommended by sealant manufacturer.
-Apply masking tape to the edges of the glass as shown in **Detail 36**.
-Apply silicone sealant into the cavity between the lites of glass. Use positive pressure so that the silicone sealant completely fills the cavity.
-Using a nylon spatula or other non-scratching implement, tool the silicone sealant immediately after running the joint. Exert positive pressure while tooling to ensure that the silicone sealant makes complete contact with all surfaces. Be careful not to remove too much silicone when tooling.
-Remove masking tape immediately after tooling before silicone skin forms.



Detail 36



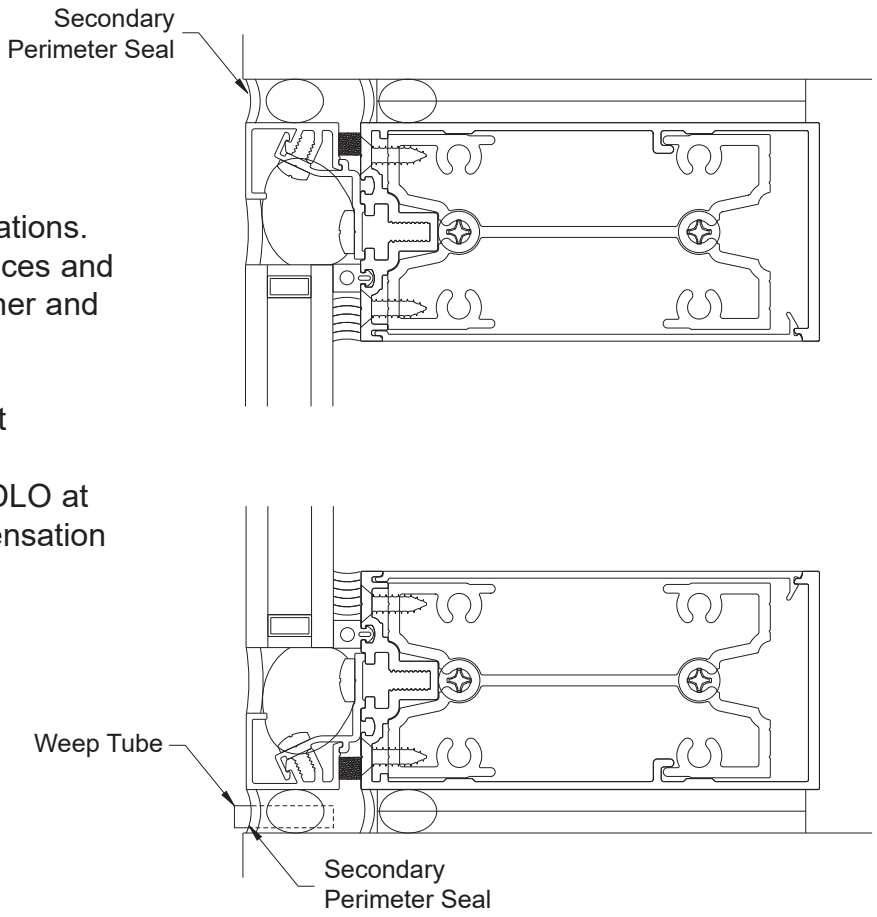
Caution: Do not permit the silicone to skin over before it is tooled. Immediately remove masking tape after tooling the silicone.

GLAZING

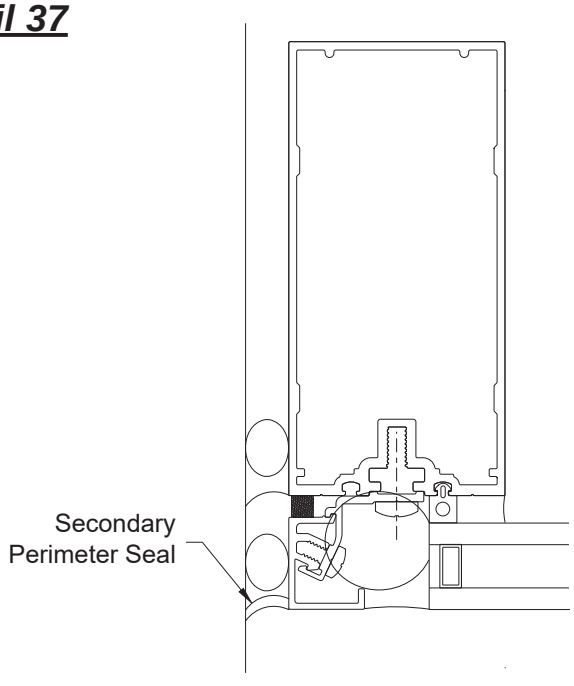
STEP 20
INSTALL SECONDARY PERIMETER SEALS

-Carefully read and follow sealant manufacturers sealant recommendations.
-Make sure all silicone contact surfaces and joints have been cleaned with cleaner and method recommended by sealant manufacturer.
-Install backer rod and apply sealant to the areas indicated in **Detail 37**.
-Apply E3-0102 weep tubes, 2 per DLO at 1/4 points to allow any water condensation to weep to the exterior.

See **Detail 37**.



Detail 37



YKK AP America Inc.
270 Riverside PKWY
Suite A
Austell, Georgia 30168
www.ykkap.com