



Mulling Procedure

Next Dimension Pro & Signature

<u>Materials</u>	<u>Part Number</u>
Mull Cover (Inside & Outside)	
• White	900055
• Clay	901155
Steel Reinforcement	
• 60" RO	2370424-5
• 72" RO	2370424-6
• 84" RO	2370424-7
Galvanized Spray	2370575
2-Sided Tape	394100
4" Mull Tape	
• White	2370462
• Clay (Clear)	2370463
#6x 5/8" Screws	500005
Foam End Plugs	531063
Drip Cap	
• White	900385
• Clay	901390
Silicone	
• White	798018W
• Clay	770029
1/2" Backer Rod (Local Hardware Store)	

Tools:

Hacksaw
Utility Knife
Rubber Mallet
Screwdriver
Putty Knife
Caulk Gun
Diagonal Cutting Pliers

1) Remove the nail fin from the side of each unit being mulled.

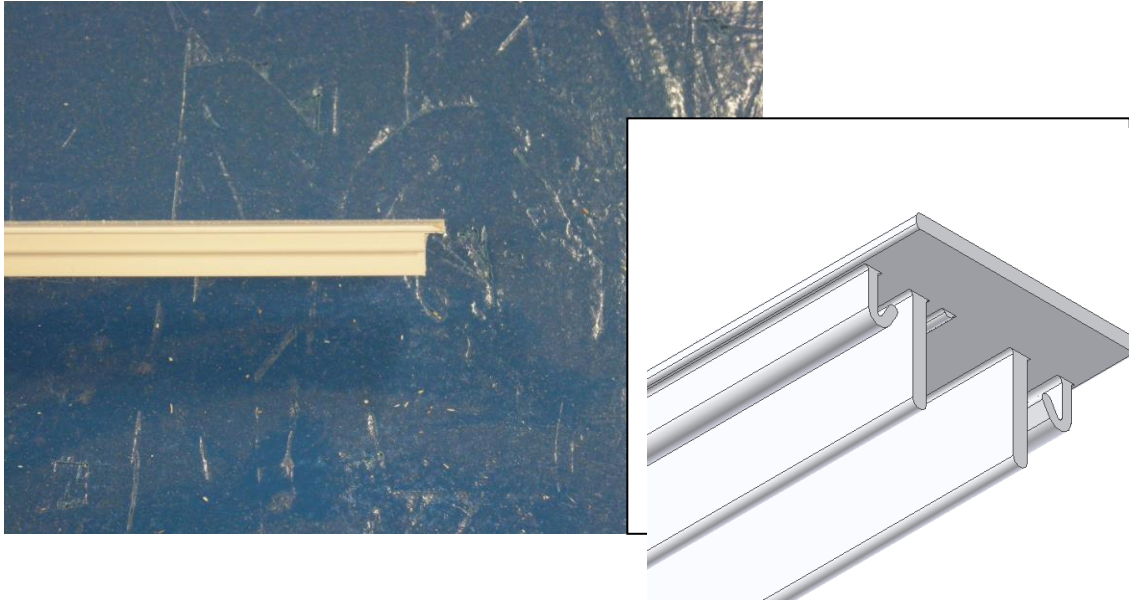


2) Clean out excess weld material at all 4 corners to be mulled using a chisel and hammer.



3) Cut the mull cover to correct length (Unit RO – ½")

- 4) Using a utility knife, cut the legs off of each end of mull cover as shown below to provide clearance over accessory groove and any excess weld material



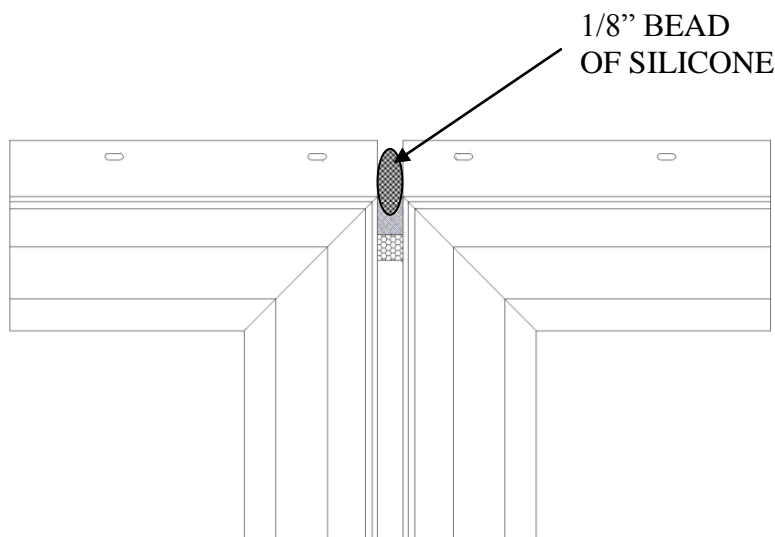
- 5) Place a long piece of mull tape onto a 2x4 skid. Make sure the tape is long enough to completely cover the gap between the units. Set the first unit approximately in the center of the tape as shown below.



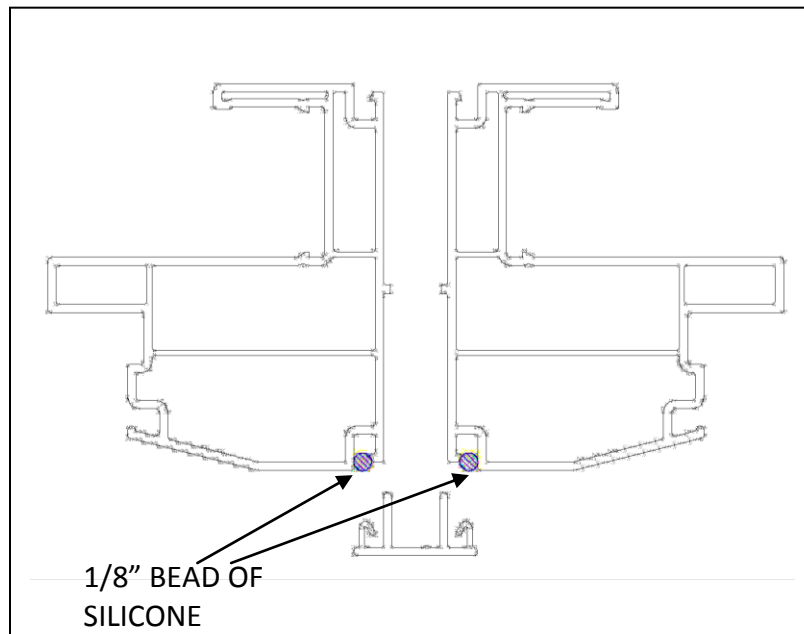
- 6) Place other unit(s) on a 2x4 making sure to leave an appropriate gap for the mull. Leave tape as shown below.



- 7) Apply a 1/8" bead of silicone to the tape in the gap between the nail fins (see below). Fold the tape over the nail fin and make sure there are no bubbles. Press down on the gap between the nail fins to disperse silicone and minimize height of silicone addition. Remove extra tape on interior and exterior using a knife.



8) Apply a 1/8" bead of silicone to each unit in the exterior frame accessory groove as shown below:

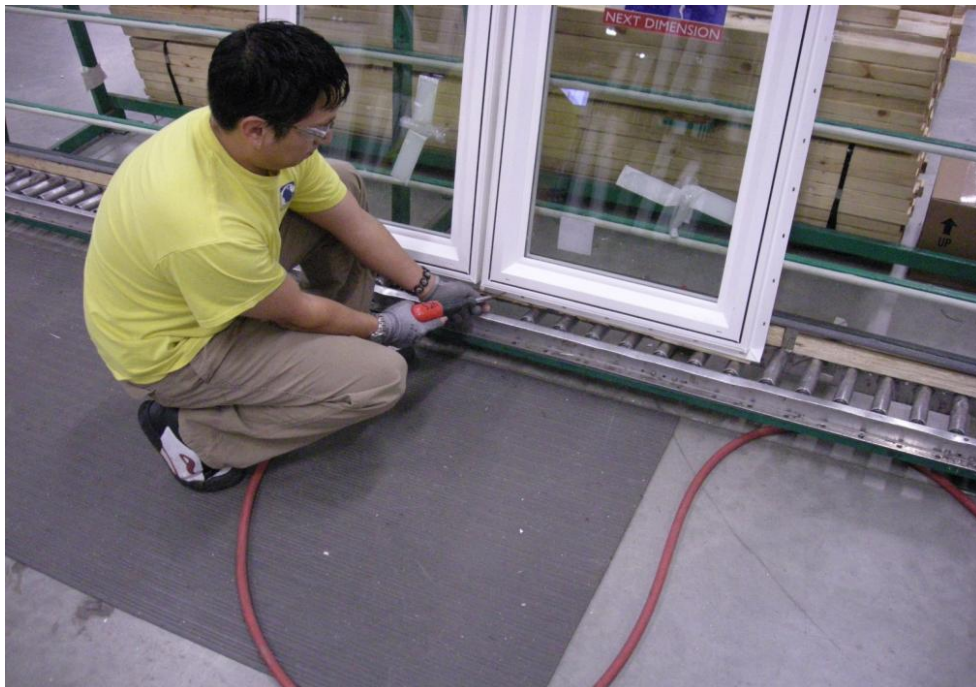


9) Drive in the mull cover using a mallet as shown below



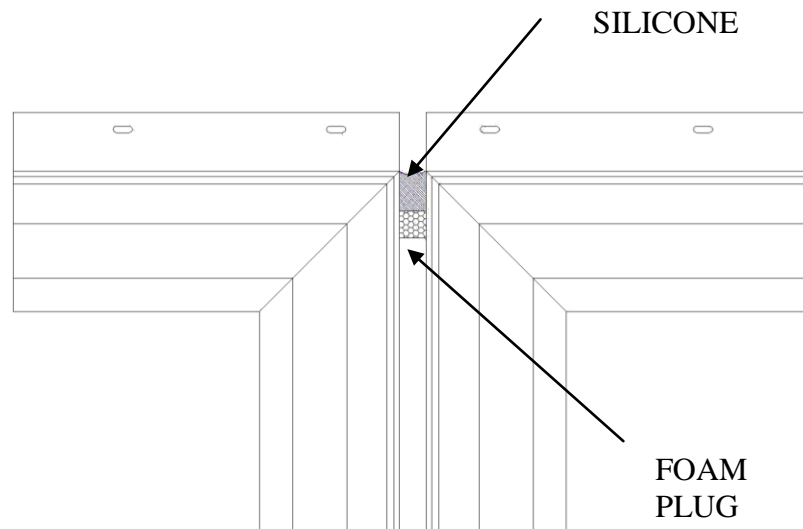
10) Make sure the mull cover extends the full length of the unit

11) Screw mull unit to 2x4 skid, see below.

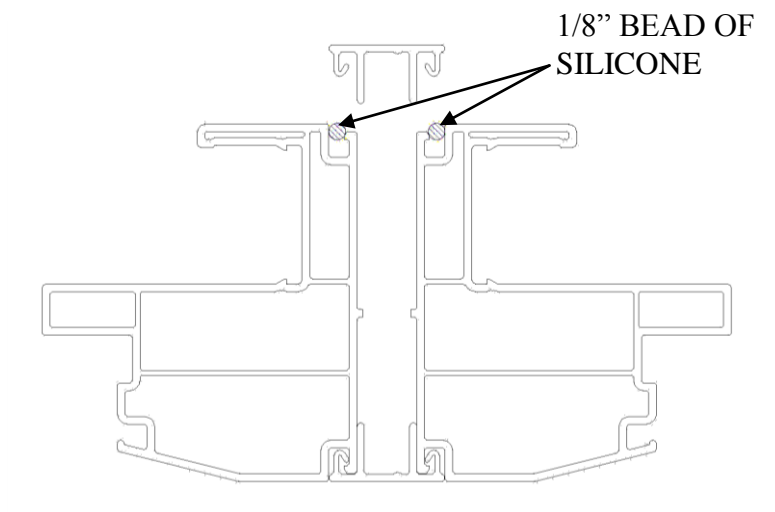


12) Flip unit 180 degrees so you have access to the interior and the mull cavity

- 13) Fill the ends of each mull cavity with silicone to 1" depth and insert foam plug to $\frac{3}{4}$ " from end by pressing into the previously applied silicone as shown below. **Important:** No voids or pinholes allowed!



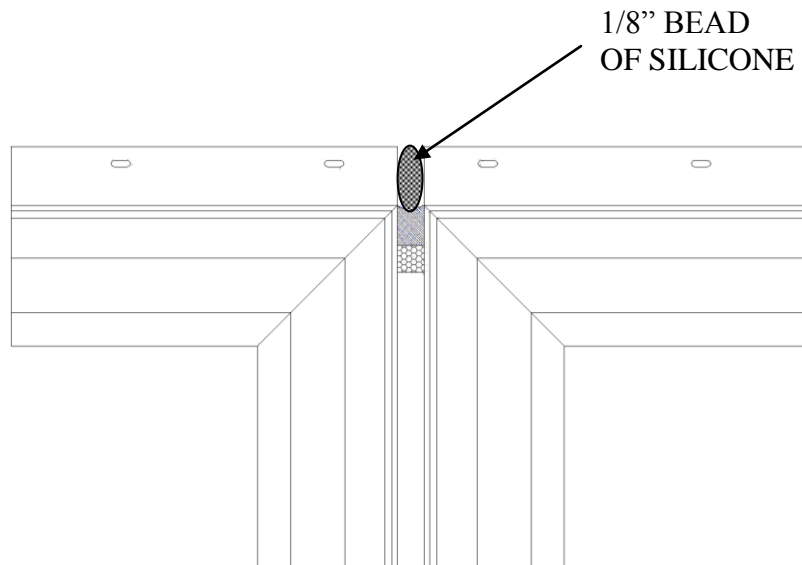
- 14) Apply a 1/8" bead of silicone to interior frame accessory groove



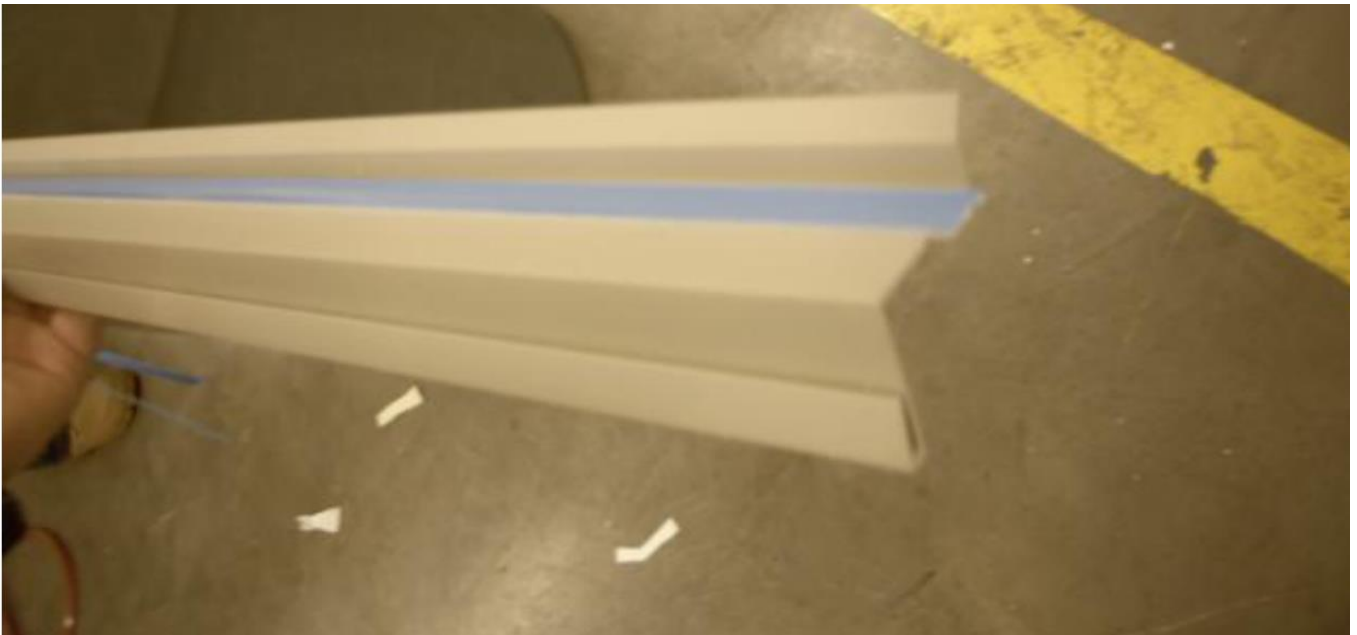
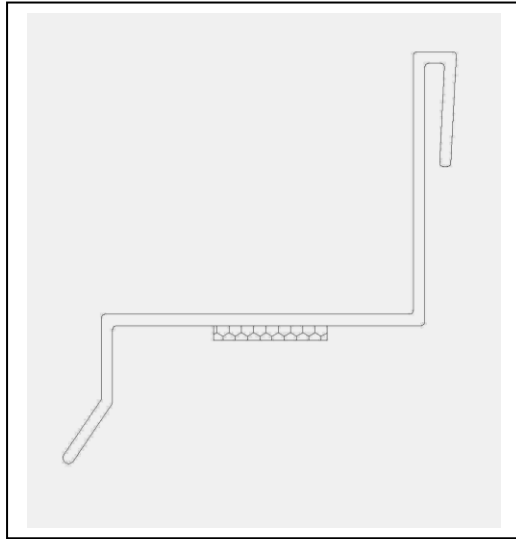
- 15) Apply interior mull cover that has been notched and cut to proper length. Remove excess silicone at the ends of each mullion with putty knife or foam plug. **Important:** Check sealant area. No voids or pinholes allowed!



- 16) Apply a strip of vinyl tape across each nail fin gap at the end of each mullion. Apply a 1/8" bead of silicone to the tape in the gap between the nail fins (see below). Fold the tape over the nail fin and make sure there are no bubbles. Press down on the gap between the nail fins to disperse silicone and minimize height of silicone addition. Remove extra tape on interior and exterior using a knife.

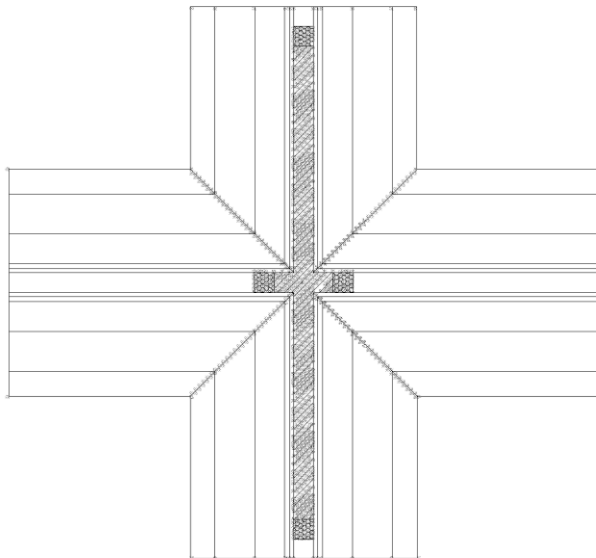


- 17) Cut the drip cap to correct length (Unit RO – ½") and apply adhesive foam tape to the underside.

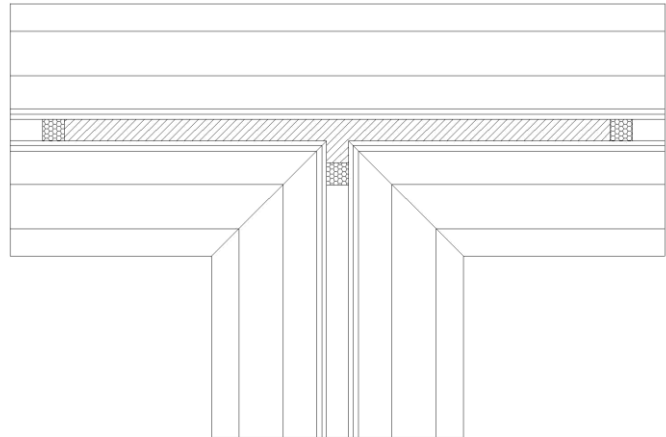


- 18) Remove release paper off of tape and apply drip cap to top of unit

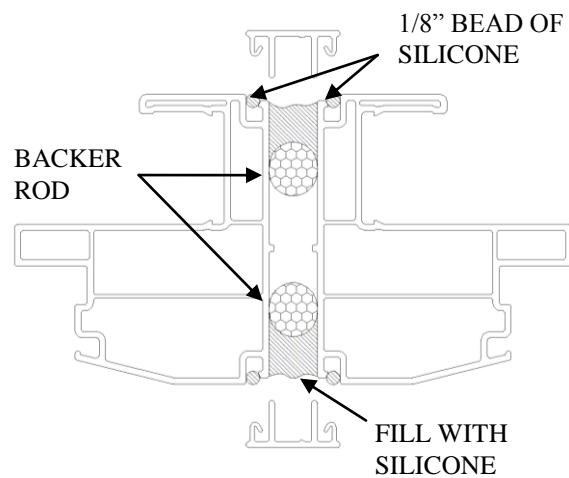
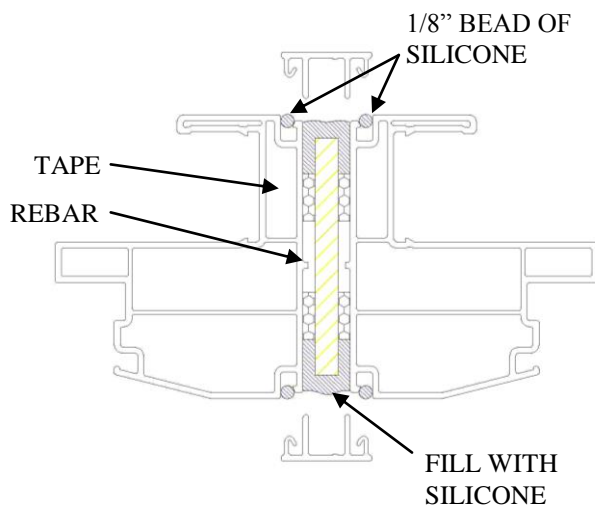
Special Procedure for Mullion Intersections



4 – Way Mull



3 – Way Mull



- A. Clean the intersecting corners of the mull to allow the mull cover to seat into the accessory groove

- B. Certain sizes require reinforcing steel bar. Contact your Windsor representative for sizes and configurations that require rebar.
- C. If reinforcement is required, apply tape to both sides of the rebar as shown below:



- D. Apply rebar to one set of units using pan head $\frac{3}{4}$ zinc screw



- E. Seal and apply exterior mull covers as shown in steps 4-10

F. Fill the interior mull cavities 6" above and below mull bar intersection



G. Complete the unit as shown in steps 13 through 18