

VINYL WINDOWS AND DOORS

Manufactured by Pella Corporation

VINYL 1" STRUCTURAL MULLION ASSEMBLY

Be sure to thoroughly read and understand all the steps before beginning the mullion assembly process. It is recommended this process be completed by a construction professional.

YOU WILL NEED TO SUPPLY:

- High quality, multi-purpose sealant
- Isopropyl Alcohol

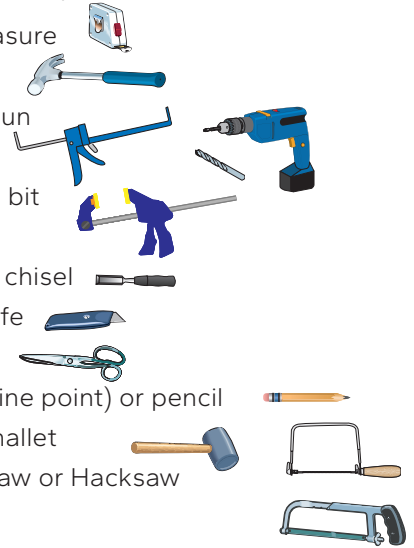


MULLION KIT, PARTS INCLUDED:

- 1" Mullion Stiffener
- Foam Tape
- Mullion Clip (2)
- Foam Plug (2)
- Mullion Truss Plate (2)
- 3/8" Flat Head Screws (20)
- Color Matched Tape (14")
- End Anchor (2)
- Splice Key (2)

TOOLS REQUIRED:

- Tape measure
- Hammer
- Sealant gun
- Drill
- 3/16" Drill bit
- Clamps
- 1/4" wide chisel
- Utility knife
- Scissors
- Marker (fine point) or pencil
- Rubber mallet
- Coping Saw or Hacksaw



REMEMBER TO USE APPROPRIATE PERSONAL PROTECTIVE EQUIPMENT.

FIELD MULLION RULES:

1. Muller product combination cannot exceed: 72 square feet for 1" Mullion system.
2. The length of any mullion may not exceed 108".
3. Any window greater than 25 square feet may not be mulled horizontally above a fixed 1-wide product.
4. One (1) inch mullion not allowed on 5/8" or 2-1/4" flange frames.
5. Twenty-five (25) square feet max upper unit when mulled over 1-wide fixed greater than 72" wide.

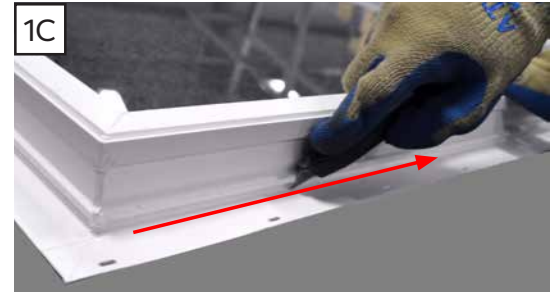
1 Prepare the Windows:

NOTE: Before starting, verify the products when mulled together will fit the rough opening.

- A. **Remove the packing material from the windows.** Inspect product; DO NOT mull or install damaged windows.
- B. **Lay out the windows on a flat surface with exterior side up** in the intended mullion assembly position. Place a mark on the jamb on the sides to be combined. If windows have nail fins, the fins on these sides of the windows will be removed. If block frame windows with no fins, proceed to step 1H.

1 Prepare the Windows (continued):

C. **Score along the length of the nail fin** with a utility knife 2 to 3 times on the jambs of the fins to be removed.

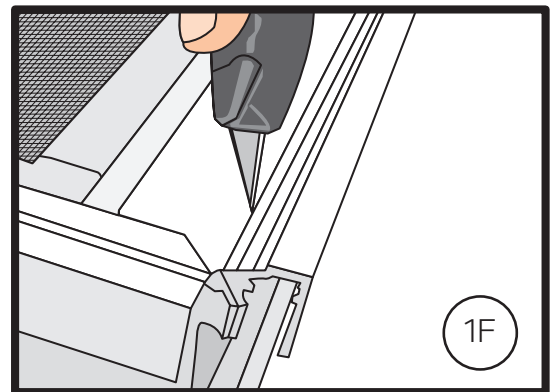
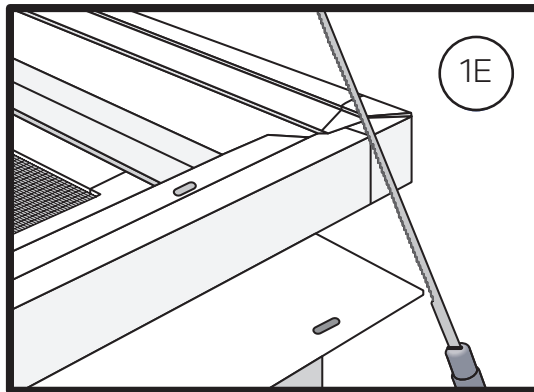


D. **Bend the fin down and then up** to remove the fin from the frame.

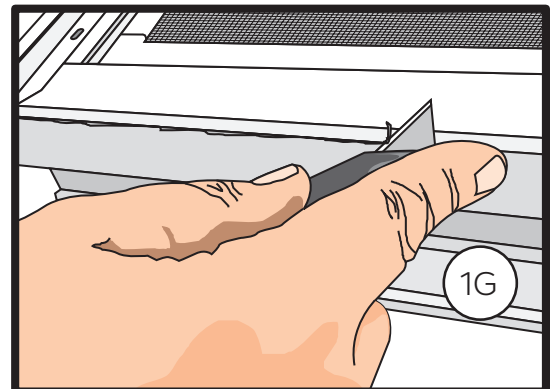


E. **Remove the J-mould (if applicable)** from the surfaces that will be mullered together. Lay the product (with the interior surface down) on a smooth clean surface. Using a coping saw, make a horizontal and a vertical cut that align with the point where the J-mould meets the exterior face of the product. Cut until the blade reaches the point where the vertical and horizontal J-mould meet. Bend and remove the cut out section of the J-mould corner.

F. **Using a utility knife, score (3 times) the point where the J-mould attaches to the exterior face of the product.** Beginning at one end of the J-mould, grasp the J-mould with pliers and bend the J-mould toward the interior of the product. Continue along the entire length of the product until the J-mould is removed from the product.

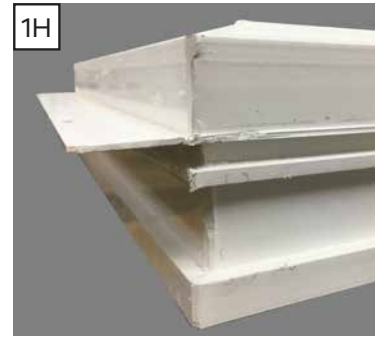
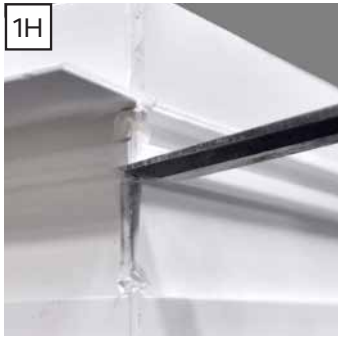
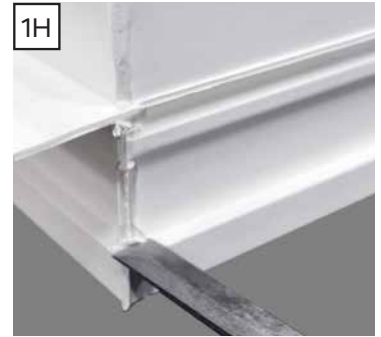
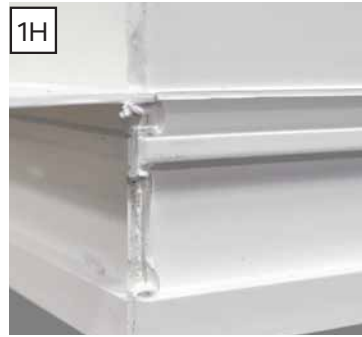


G. **Using a utility knife, cut off any excess material** that does not break off the accessory groove.



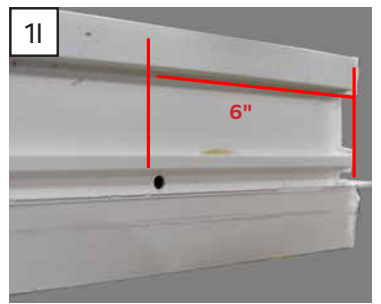
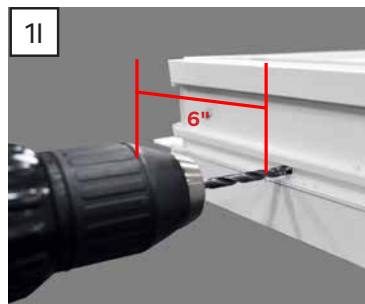
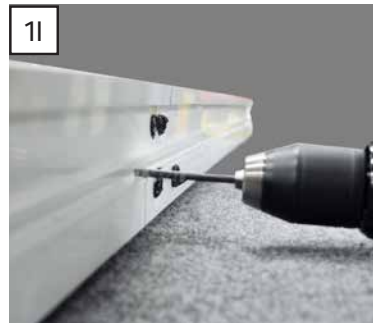
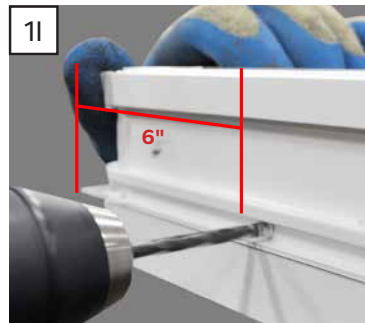
1 Prepare the Windows (continued):

H. **Clean excess vinyl weld from each corner.** Use a chisel to clean the corners adjacent to where the fin was removed. Excess vinyl must be removed so the structural mullion reinforcement and the end clip will fit flush against the frame. This groove must also be cleaned for through mullions.



I. HORIZONTAL MULLIONS ONLY:

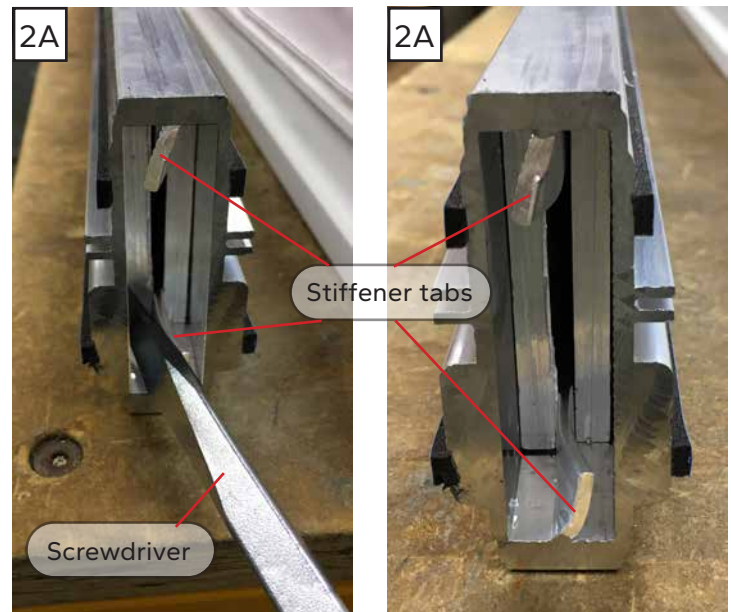
Drill three 3/16" diameter weep holes through the first outer vinyl layer of the frame on the top (head) of the bottom unit in the location shown. One 6" from each end and one in the center. Off set the center hole if mulling composite units.



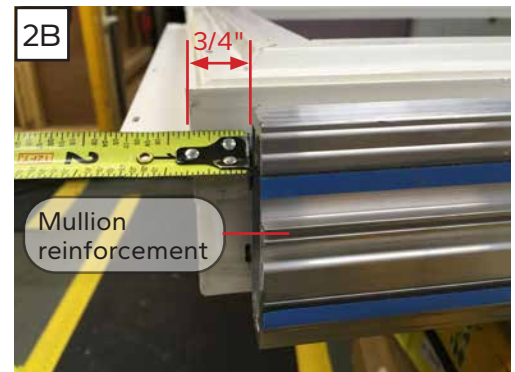
2 Exterior Mullion Assembly:

A. **If mullion requires reinforcement**, insert additional aluminum reinforcement in the stiffener bar 1" past flush and pry the stiffener tabs to lock it in place.

NOTE: Don't pry them all the way shut because an end anchor will still need to be inserted.



B. **Dry fit the mullion reinforcement**; there should be 3/4" on each end. Mark one end for correct placement.



C. **If needed**, trim any left over nail fin to allow the mullion reinforcement to fit flush against the frame. Clean frame sides to be mullied with Isopropyl prior to attaching the mullion.

D. **Remove the tape backing paper from both pieces of tape** on the side of the mullion reinforcement to be placed against the frame.

E. **Place the mullion reinforcement against the window** with one end aligned with the mark made in step 2B.



F. **Dry fit the second window to the first window** with the mullion reinforcement.

G. **Remove the tape backing paper** from both pieces of tape on the mullion reinforcement.

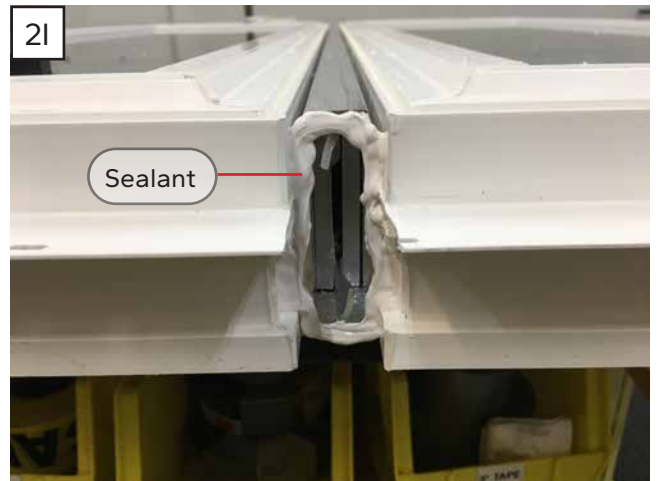


2 Exterior Mullion Assembly (continued):

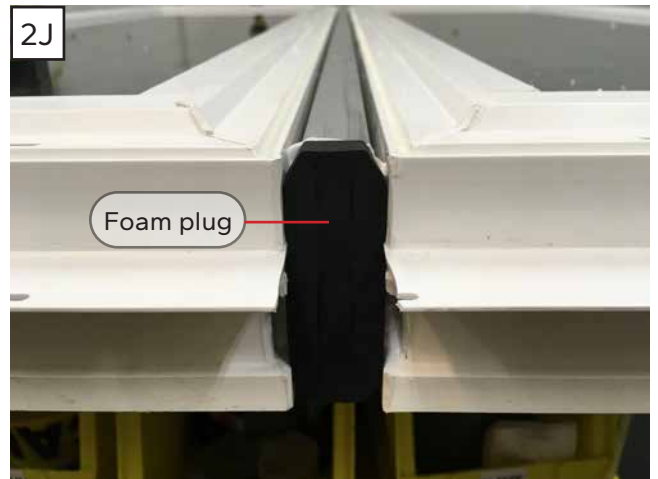
H. **Install the second window to the first window** and the mullion reinforcement.



I. **Outline each end of the mullion reinforcement** with sealant ensuring the sealant touches off on all 4 ends of tape pieces.

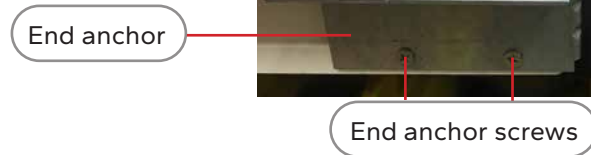


J. **Install a foam plug** on each end of the mullion against the sealant.

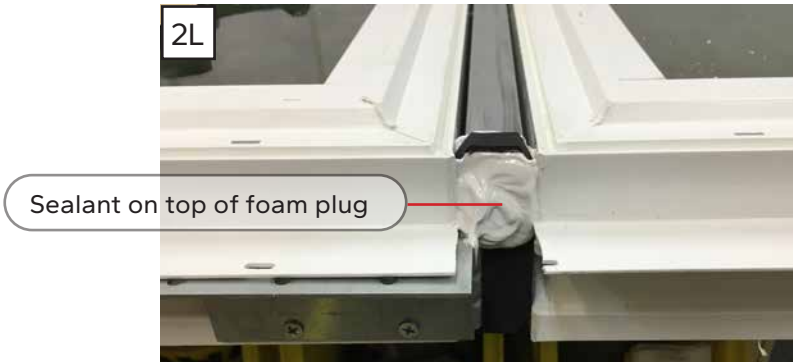


2 Exterior Mullion Assembly (continued):

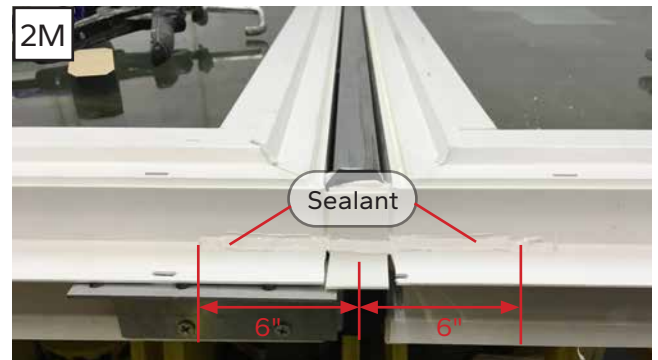
K. **Fully insert end anchor** into the foam plug slot and attach with two of the provided screws.



L. **Fill the void with sealant from the fin flush** to the exterior edge of the frame and insert the splice key as shown.

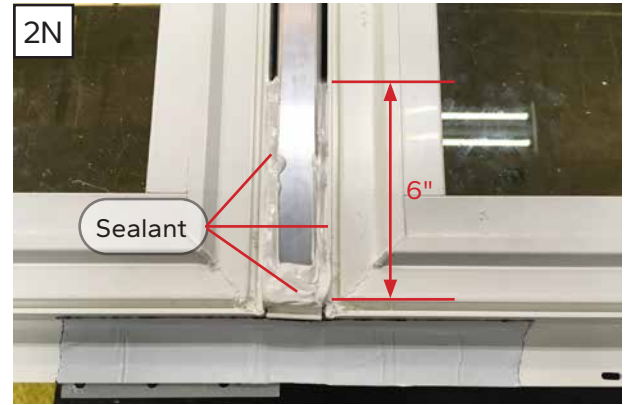
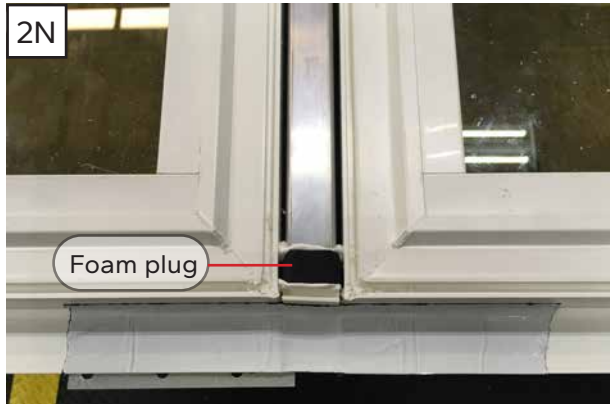


M. **Place a bead of sealant** approximately 6" long in the position shown and cover with flashing tape.



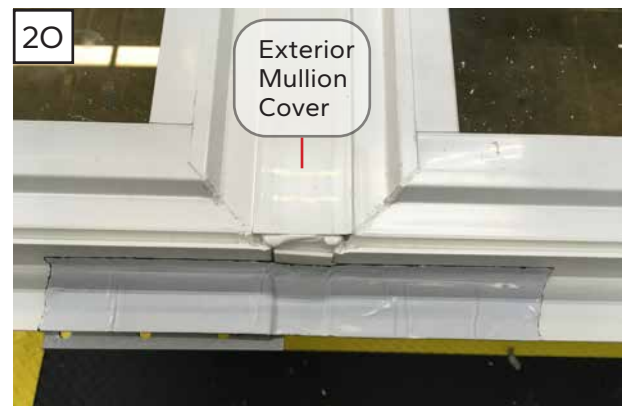
2 Exterior Mullion Assembly (continued):

N. **Place 2 six inch (6") lines of sealant** on each end of the mullion. Sealant goes on each side of the mullion reinforcement. Tie together the two lines of sealant so the foam plug is completely covered with sealant.



O. **Install the mullion cover.** Use a mallet to seat the cover into the window accessory grooves. Clamps may also be used to help draw the mullion joint together.

P. **Clean any excess sealant squeeze-out** with Isopropyl Alcohol and a rag.



3 Interior Mullion Assembly:

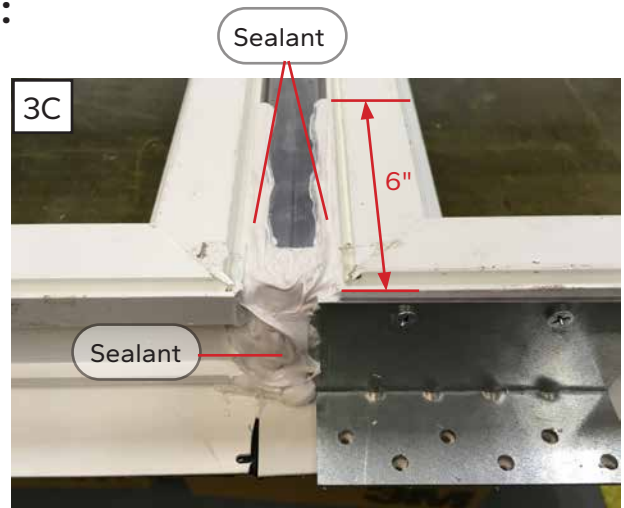
A. **Carefully turn the combination** over so the interior side is up.

B. **For nail fin units**, drill through the end anchor holes into the fin so they can be found during installation.

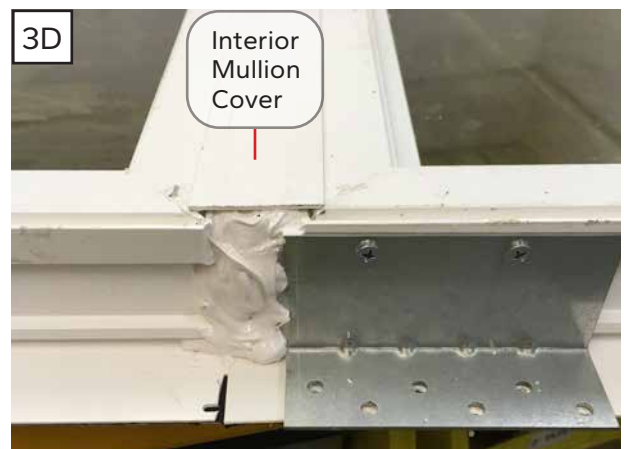


3 Interior Mullion Assembly (continued):

C. Place 2 six inch (6") lines of sealant on each end of the mullion. Sealant goes on each side of the mullion reinforcement. Tie together the two lines of sealant so that the foam plug is completely covered with sealant.



D. Install the mullion cover. Use a mallet to seat the cover into the window accessory grooves.



E. Cover exposed joint with flashing tape. Make sure the tape closely follows the contours of the frame profile.



F. Place a mullion truss plate centered on each end of the mullion and attach with the provided screws. Do not over-tighten the screws. For vertical mulls, use VHB tape to attach truss plate at the sill.



G. Clean any excess sealant squeeze-out with Isopropyl Alcohol and a rag.