

# SERIES 960 WALL STOREFRONT

## INSTALLATION INSTRUCTIONS



Part NO. Y005

MAY 1, 2019

WHERE WINDOWS ARE JUST THE BEGINNING®



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## Minimizing Condensation

NOTE: Please reference EFCO's "Understanding Condensation" brochure which can be obtained through your EFCO representative.

Condensation will form on any surface when unfavorable conditions (interior temperature and relative humidity and exterior temperature) are present. When the formation of excessive condensation is a concern, it is highly recommended that a design professional is utilized to perform an analysis of the shop drawings to recommend the best installation methods. Please contact EFCO representative for information on EFCO's Thermal Analysis Services.

Many current installation practices lead to an increase in the possibility of the formation of condensation. Though not all inclusive, the list of examples below illustrates conditions under which condensation is likely to occur:

1. Bridging system thermal break with non-thermally broken metal flashing or lintels that are exposed to the exterior.
2. System exposure to cold air cavities.
3. Interior relative humidity levels not maintained at recommended levels, see EFCO's "Understanding Condensation" brochure.
4. Inadequate separation between system and surrounding condition at perimeter.
5. Product combinations during the shop drawing stage that result in bridging thermal breaks of one or all products involved.

# SECTION I - GENERAL NOTES

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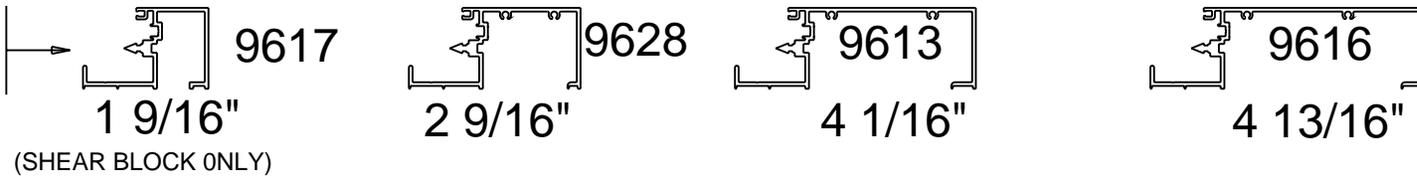
EFCO Series 960 Wall is a thermal wall system with a 1 3/4" face dimension and has system depth dimensions from 2 3/4" to 8 1/8". The system is exterior glazed with either 1/4" or 1" dry glazing. Entrance doors are an engineered part of the system.

- 1) Check the shop drawings, installation instructions, and the glazing instructions to become thoroughly familiar with the project. The shop drawings take precedence and include specific details for the project. The installation instructions are of a general nature and cover the most common conditions.
- 2) Check all materials upon arrival and be sure you have everything required to begin installation.  
(See Section II "PARTS IDENTIFICATION")
- 3) All work should start from bench marks and/or column center lines as established by the architectural drawings and the general contractor. Check construction for compliance with the contract documents.
- 4) Sealants must be compatible with all surfaces. Consult with the sealant manufacturer for recommendations regarding compatibility and adhesion.
- 5) All materials are to be installed plumb, level, and true.
- 6) Protect aluminum materials after erection. Cement, plaster, alkaline solutions, and acid based materials can be harmful to the finish.
- 7) Clean all finished aluminum surfaces with a mild detergent and water. No abrasive agent should be used.

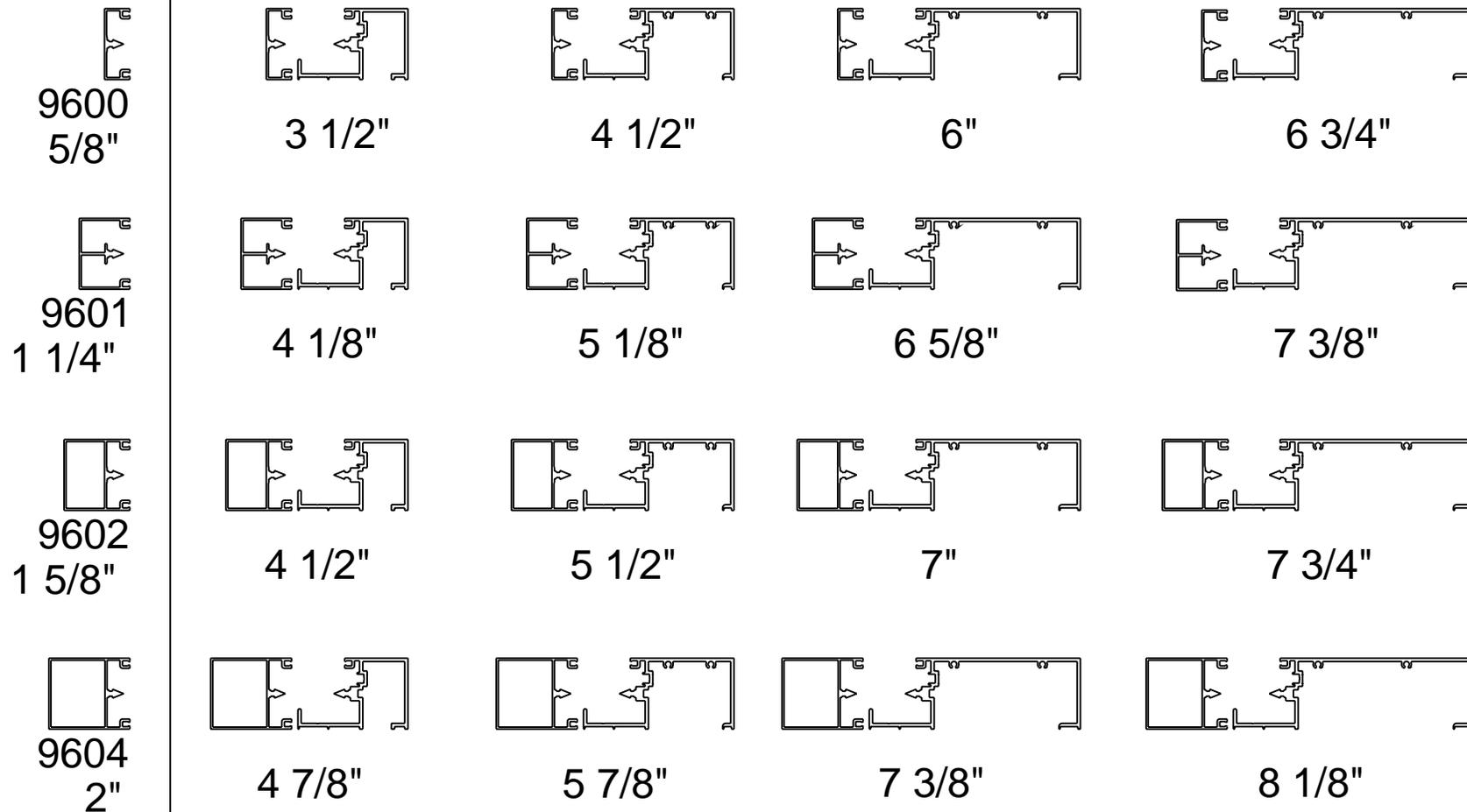
# PERIMETER COMPONENTS and COMBINATIONS

FOR 1" GLAZING  
(USE H260 ISOLATOR)

PERIMETER  
BACK MEMBERS



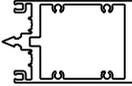
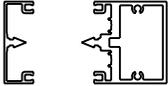
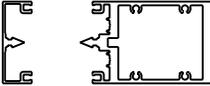
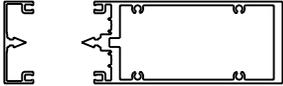
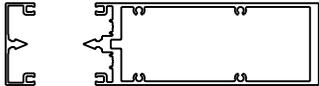
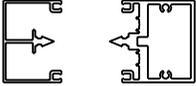
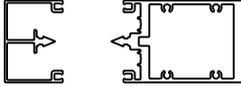
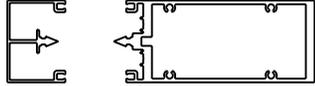
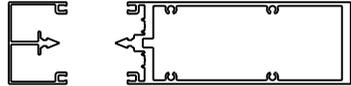
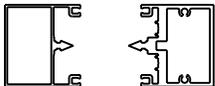
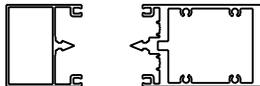
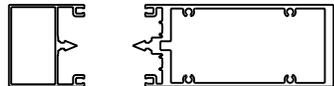
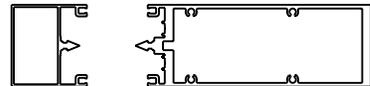
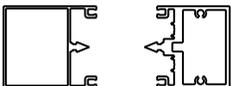
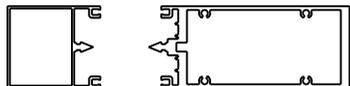
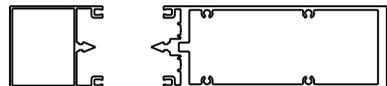
COVERS



# MULLION COMPONENTS AND COMBINATIONS

FOR 1" GLAZING  
(USE H260 ISOLATOR)

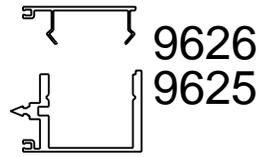
## SECTION I - PARTS IDENTIFICATION

COVERS	MULLIONS			
	 9608 1 9/16" (SHEAR BLOCK ONLY)	 9627 2 9/16"	 9610 4 1/16"	 9609 4 13/16"
 9600 5/8"	 3 1/2"	 4 1/2"	 6"	 6 3/4"
 9601 1 1/4"	 4 1/8"	 5 1/8"	 6 5/8"	 7 3/8"
 9602 1 5/8"	 4 1/2"	 5 1/2"	 7"	 7 3/4"
 9604 2"	 4 7/8"	 5 7/8"	 7 3/8"	 8 1/8"

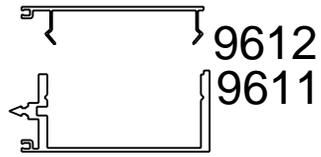
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FOR 1" GLAZING  
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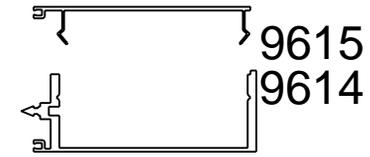
SPLIT  
MULLIONS



2 9/16"



4 1/16"

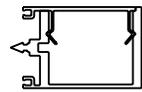


4 13/16"

COVERS



9600  
5/8"



4 1/2"



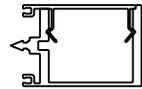
6"



6 3/4"



9601  
1 1/4"



5 1/8"



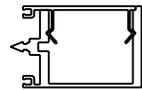
6 5/8"



7 3/8"



9602  
1 5/8"



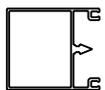
5 1/2"



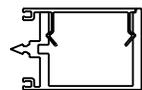
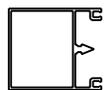
7"



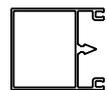
7 3/4"



9604  
2"



5 7/8"



7 3/8"



8 1/8"

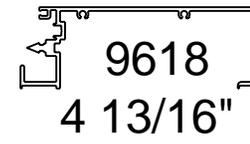
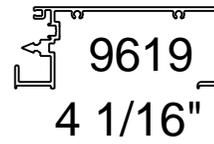
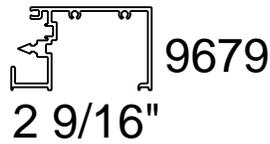
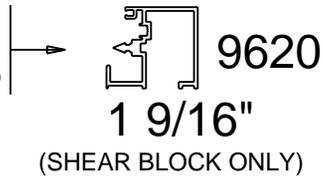
SECTION II - PARTS IDENTIFICATION

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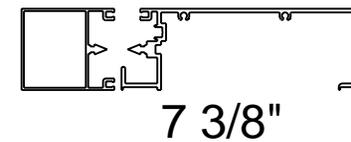
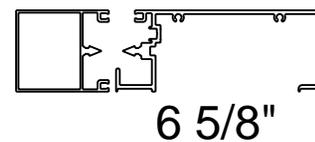
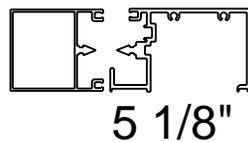
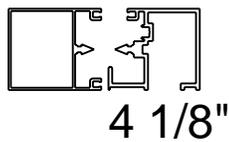
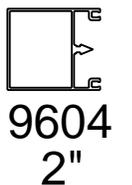
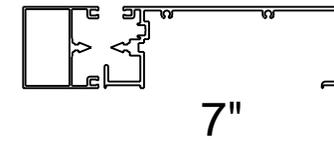
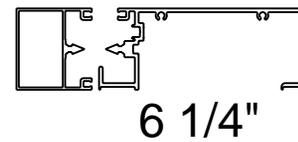
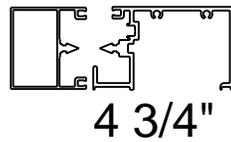
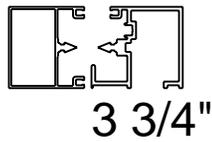
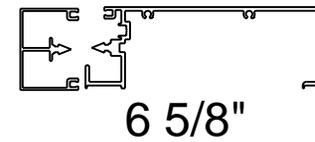
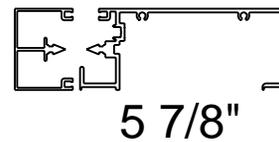
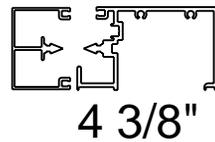
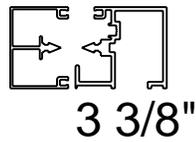
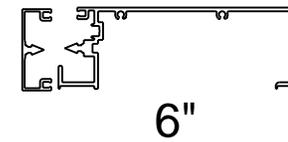
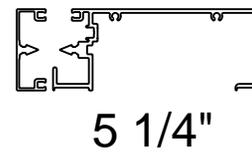
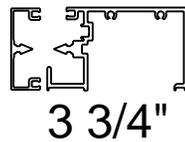
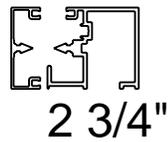
# PERIMETER COMPONENTS and COMBINATIONS

FOR 1/4" GLAZING  
(USE H261 ISOLATOR)

PERIMETER  
BACK MEMBERS



COVERS



# MULLION COMPONENTS AND COMBINATIONS

FOR 1/4" GLAZING  
(USE H261 ISOLATOR)

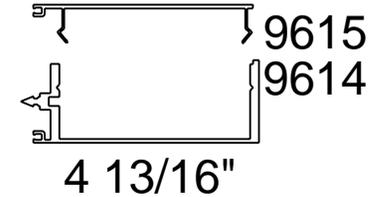
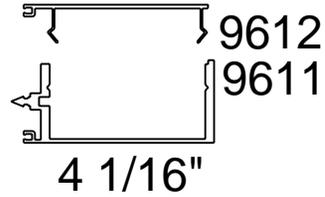
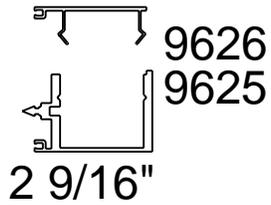
MULLIONS	9608	9627	9610	9609
<b>COVERS</b>	1 9/16" (SHEAR BLOCK ONLY)	2 9/16"	4 1/16"	4 13/16"
9600 5/8"	2 3/4"	3 3/4"	5 1/4"	6"
9601 1 1/4"	3 3/8"	4 3/8"	5 7/8"	6 5/8"
9602 1 5/8"	3 3/4"	4 3/4"	6 1/4"	7"
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CONT.

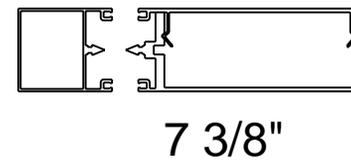
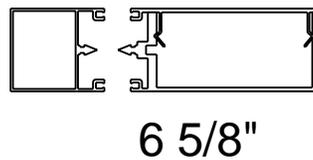
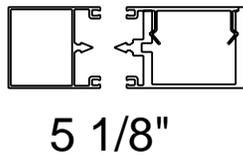
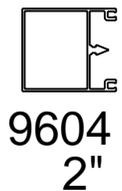
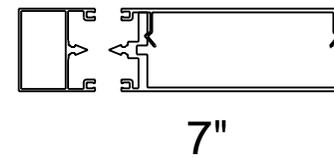
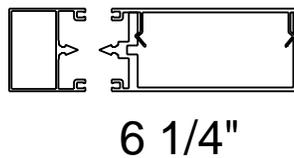
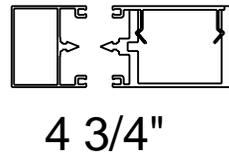
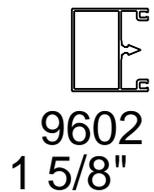
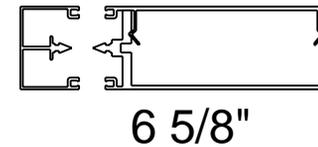
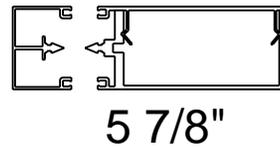
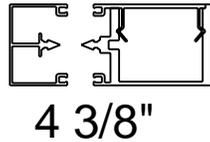
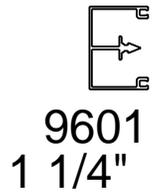
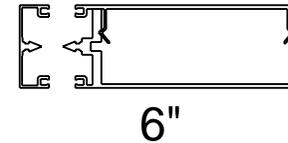
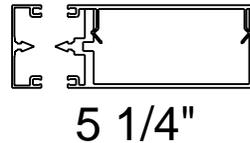
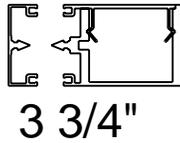
# MULLION COMPONENTS AND COMBINATIONS

FOR 1/4" GLAZING  
(USE H261 ISOLATOR)

SPLIT  
MULLIONS



COVERS

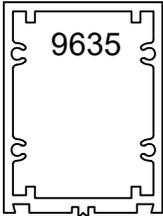
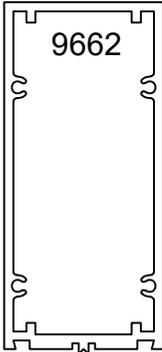
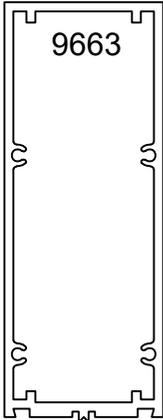
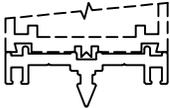
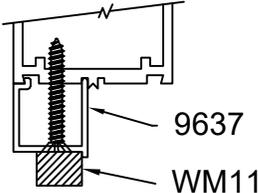
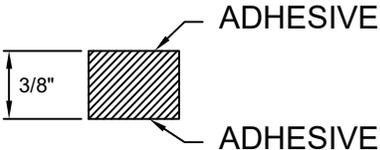


CORRESPONDING  
MULLION LENGTHS

# BUTT GLAZED MULLIONS

FOR 1/4" & 1" GLAZING

## SECTION II - PARTS IDENTIFICATION

	2 9/16" B.M.	4 1/16" B.M.	4 13/16" B.M.
			
SSG TO CAPTURED ADAPTOR			
HORIZ. TO VERT. SHEAR BLOCK	K347 CLEAR K348 BRONZE	K349 CLEAR K350 BRONZE	K351 CLEAR K352 BRONZE
1/4" GLAZING ADAPTOR  USE WM11 TAPE & SFZ4 #8-15 X 1 1/4 PL-FH-SMS 18-8 AB			
BUTT GLAZE TAPE WM11			

CONT.

# DOOR HEADERS & JAMBS

FOR 1" GLAZING

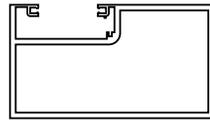
CORRESPONDING  
MULLION LENGTHS →

2 9/16"  
BACK MEMBER

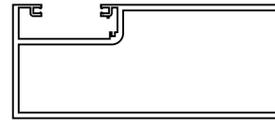
4 1/16"  
BACK MEMBER

## DOOR HEADERS

(2 1/2" SIGHT LINE)  
(w/ 5/8" COVER)



9633  
4 1/2"



9621  
6"

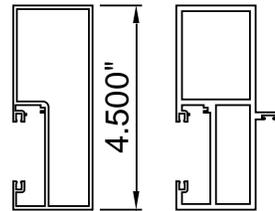
## DOOR HEADER SHEAR BLOCKS (7093)

K333 RH CLR.  
K334 LH CLR.  
K335 RH BRZ.  
K336 LH BRZ.

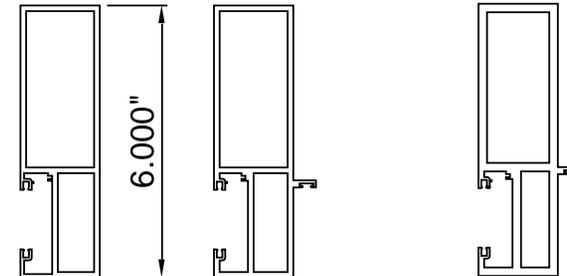
K325 RH CLR.  
K326 LH CLR.  
K327 RH BRZ.  
K328 LH BRZ.

## DOOR JAMBS

(1 3/4" SIGHT LINE)  
(w/ 5/8" COVER)



9634    9638



9623    9639    8497

## DOOR JAMB SHEAR BLOCKS (FOR HEADER APPLICATION) SURFACE CLOSER

K337 CLR.  
K338 BRZ.

K194 CLR.  
K195 BRZ.

K444 CLR.  
K445 BRZ.

## TRANSOM JAMB GLAZING

9673 / 9674



9674    9673  
EXTERIOR    INTERIOR

960 Wall

KDE 10/2002

SECTION II - PARTS IDENTIFICATION

CONT.

# DOOR HEADERS & JAMBS

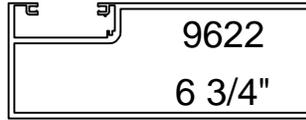
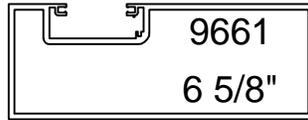
FOR 1" GLAZING

CORRESPONDING  
MULLION LENGTHS →

4 1/16"  
BACK MEMBER

4 13/16"  
BACK MEMBER

DOOR  
HEADERS  
(2 1/2" SIGHT LINE)



(w/ 1 1/4" COVER)

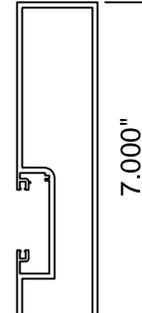
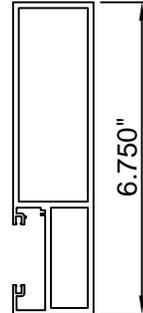
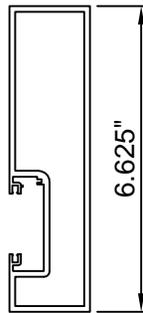
(w/ 5/8" COVER)

DOOR HEADER  
SHEAR BLOCKS  
(7093)

K325 RH CLR.  
K326 LH CLR.  
K327 RH BRZ.  
K328 LH BRZ.

K329 RH CLR.  
K330 LH CLR.  
K331 RH BRZ.  
K332 LH BRZ.

DOOR  
JAMBS  
(1 3/4" SIGHT LINE)



9660  
(w/ 1 1/4" COVER)

9624  
(w/ 5/8" COVER)

9664  
(w/ 1 5/8" COVER)

DOOR JAMB  
SHEAR BLOCKS  
(FOR HEADER APPLICATION)  
SURFACE CLOSER

K194 CLR.  
K195 BRZ.

K341 CLR.  
K342 BRZ.

K194 CLR.  
K195 BRZ.

TRANSOM  
JAMB  
GLAZING

9673 / 9674



9674  
EXTERIOR

9673  
INTERIOR

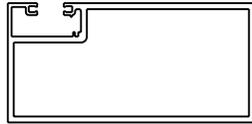
CORRESPONDING DOOR HEADERS & JAMBS  
MULLION LENGTHS

FOR 1/4" GLAZING

4 1/16" B.M.

SECTION II - PARTS IDENTIFICATION

DOOR HEADERS  
(2 1/2" SIGHT LINE)

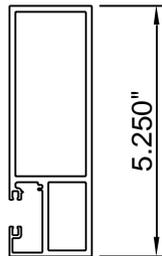


9678  
5 1/4"

(w/ 5/8" COVER)  
K369 RH BRZ.  
K370 LH BRZ.  
K371 RH CLR.  
K372 LH CLR.

DOOR HEADER  
SHEAR BLOCKS  
(7093)

DOOR JAMBS  
(1 3/4" SIGHT LINE)



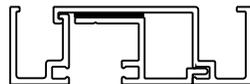
9636

(w/ 5/8" COVER)

DOOR JAMB  
SHEAR BLOCKS  
(FOR HEADER  
APPLICATION)  
SURFACE CLOSER

K194 CLR.  
K195 BRZ.

TRANSOM  
JAMB  
GLAZING



9674      9733      9673  
EXTERIOR ADAPTOR      INTERIOR

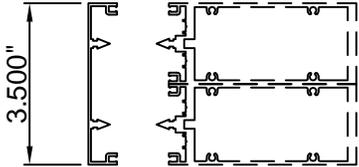
9673 / 9674

CONT.

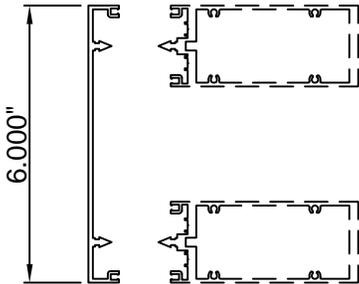
# OPTIONAL CUSTOM APPLICATION EXTRUSIONS

960 WALL

9680  
3 1/2"  
SIGHT LINE



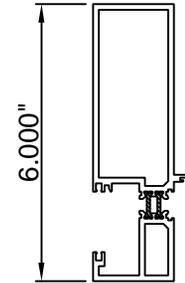
9672  
6"  
SIGHT LINE



8940/8942  
2 COLOR  
DOOR JAMB  
#1G43

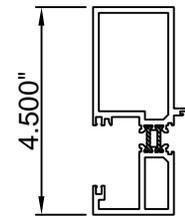
DOOR JAMB  
SHEAR BLOCK  
(FOR HEADER APPLICATION)

FOR THERMASTILE DOORS  
(2" THICK ONLY)



(w/ 5/8" COVER)

K324 - CLR  
K447 - BRZ



(w/ 5/8" COVER)

K323 - CLR  
K446 - BRZ

SECTION II - PARTS IDENTIFICATION

CONT.

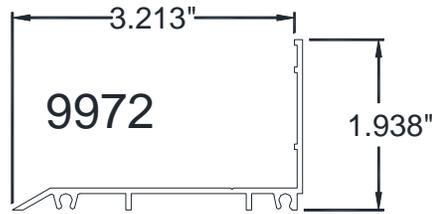
# STANDARD SILL FLASHINGS w/END CAPS

## BACK MEMBER

## SPLICE JOINT

## END CAP PKG.

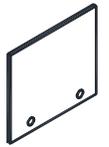
1 9/16" B.M.



# F542



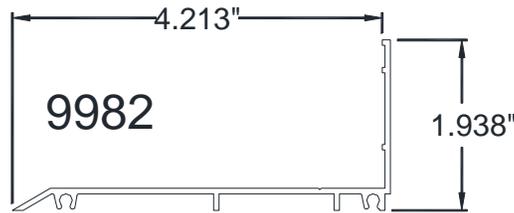
#9972 - 2 13/16" TRIMMED LEG



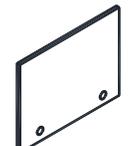
K479

(1) FT78, (2) SFP6

2 9/16" B.M.



#9982 - 3 3/4" TRIMMED LEG



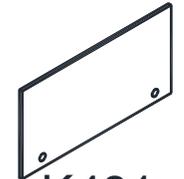
K480

(1) FT79, (2) SFP6

4 1/16" B.M.



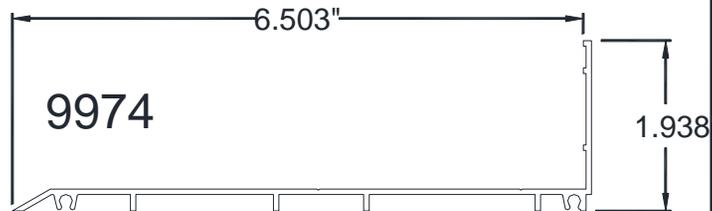
#9668 - 5 5/16" TRIMMED LEG



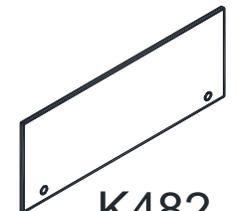
K481

(1) FT80, (2) SFP6

4 13/16" B.M.



#9974 - 6 1/16" AS SUPPLIED



K482

(1) FT81, (2) STC7

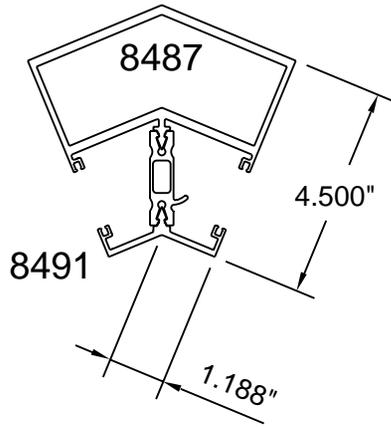
# 135 DEGREE INSIDE AND OUTSIDE CORNER MULLIONS

FOR 1" GLAZING  
(USE H260 ISOLATOR)

## SECTION II - PARTS IDENTIFICATION

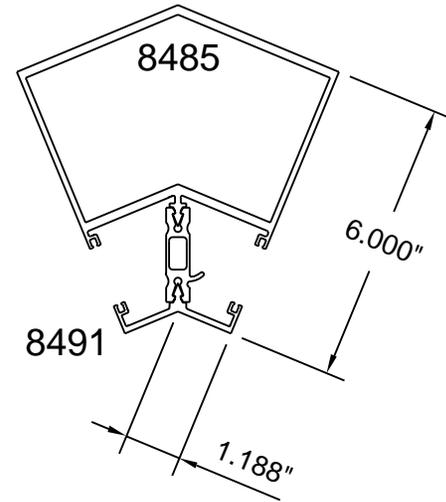
4 1/2" SYSTEM DEPTH

8487 / 8491  
135°  
INSIDE

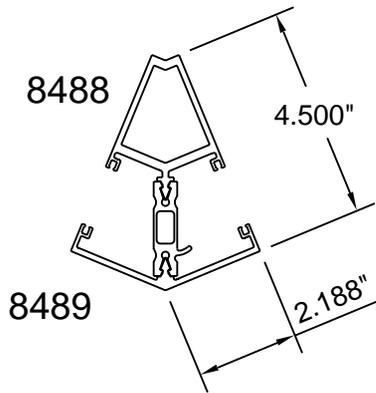


8485 / 8491  
135°  
INSIDE

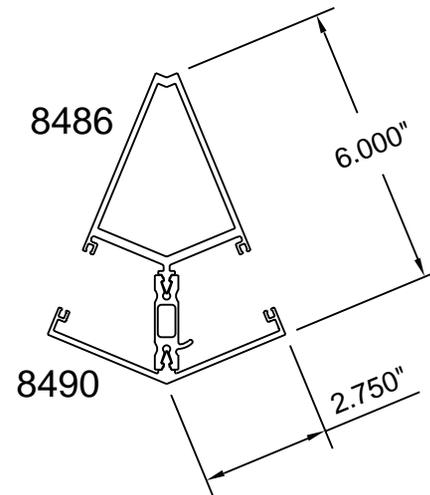
6" SYSTEM DEPTH



8488 / 8489  
135°  
OUTSIDE



8486 / 8490  
135°  
OUTSIDE

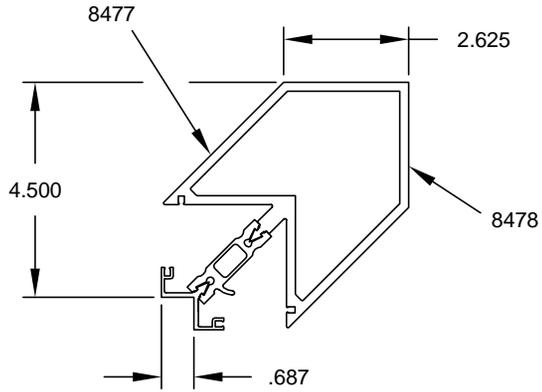


CONT.

# 90 DEGREE INSIDE AND OUTSIDE CORNER MULLIONS FOR 1" GLAZING USE H260 ISOLATOR

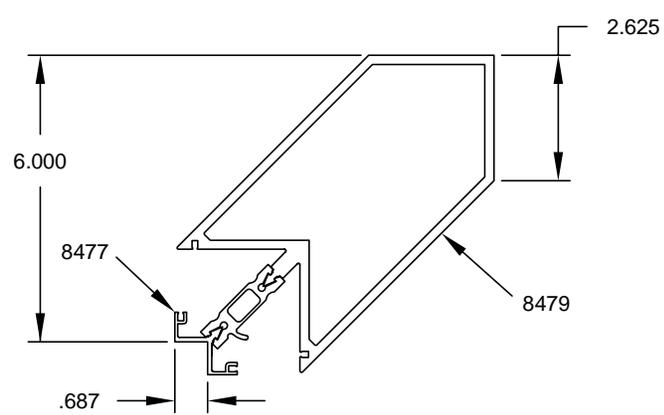
960 WALL

4 1/2" SYSTEM DEPTH  
8477 / 8478 90° INSIDE CORNER MULLION



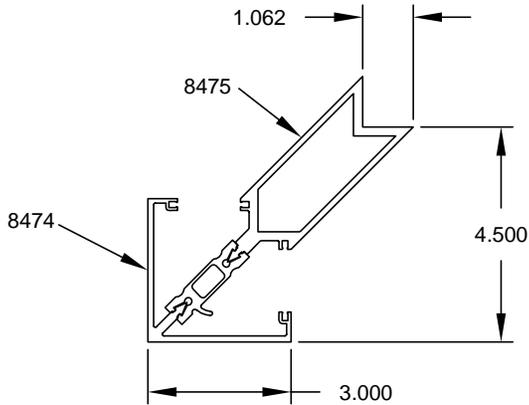
SHEAR BLOCK REQ'D = K477

6" SYSTEM DEPTH  
8477 / 8479 90° INSIDE CORNER MULLION



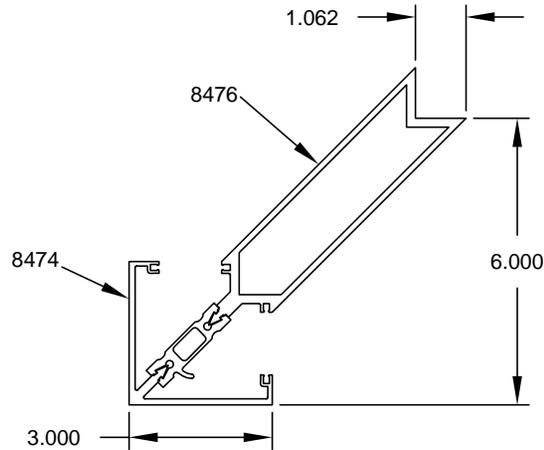
SHEAR BLOCK REQ'D = K478

4 1/2" SYSTEM DEPTH  
8474 / 8475 90° OUTSIDE CORNER MULLION



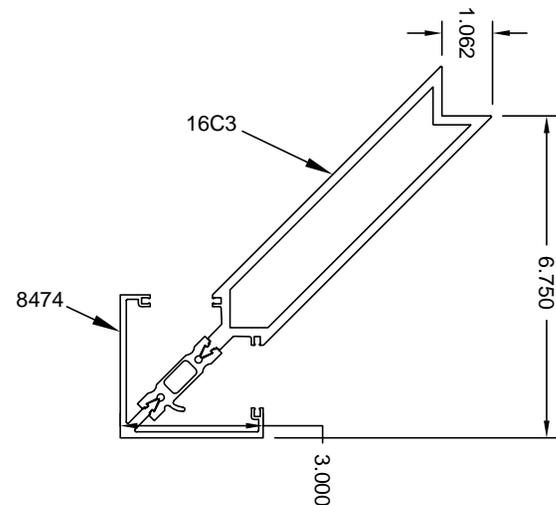
SHEAR BLOCK REQ'D = K477

6" SYSTEM DEPTH  
8474 / 8476 90° OUTSIDE CORNER MULLION



SHEAR BLOCK REQ'D = K478

6 3/4" SYSTEM DEPTH  
8474 / 16C3 90° OUTSIDE CORNER MULLION



SHEAR BLOCK REQ'D = K478

CONT.

SECTION II - PARTS IDENTIFICATION

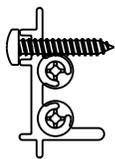
MDM 04/06

PAGE 15

# SECTION II - PARTS IDENTIFICATION

## SYSTEM 960 WALL ACCESSORIES LIST

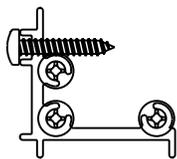
CONT.



**K150**

1 9/16"

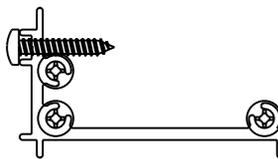
BACK MEMBERS



**K170**

2 9/16"

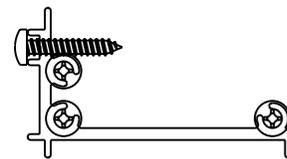
BACK MEMBERS



**K147**

4 1/16"

BACK MEMBERS

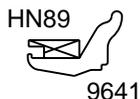


**K147**

4 13/16"

BACK MEMBERS

### SETTING BLOCK & CHAIR



**K148**

1/4" GLAZING



**K149**

1" GLAZING

SETTING BLOCKS ARE TO BE ATTACHED

### SETTING BLOCKS



**HN80**

1/4" OR 1/2" GLAZING @ DOOR HEADER



**HEP1**

1" SETTING BLOCK @ DOOR HEADER



**H157**

1" SETTING BLOCK @ 1G42 & 1G43 AS TRANSOM BAR

### FRAME

#### GLASS ADAPTORS



**9649**

1/4" GLASS ADAPTOR

AT VERTICALS & SIDELITES



**9667**

1/4" GLASS ADAPTOR

w/ L129



**9666**

1/2" GLASS ADAPTOR

w/ L129

AT HORIZONTALS w/ WATER DEFLECTORS

### THERMAL ISOLATOR CLIPS



**H261**

1/4" GLAZING



**H260**

1" GLAZING

### POCKET FILLERS

1" GLAZING



**9646**

1/4" GLAZING



**9642**

### DOOR FRAME GLASS ADAPTORS

1/4" GLASS ADAPTOR FOR DOOR FRAMES



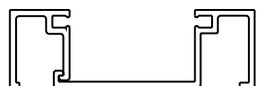
**9733**

1/2" GLASS ADAPTOR FOR DOOR FRAMES



**9734**

### TRANSOM JAMB GLAZING ADAPTOR



**9674**  
EXTERIOR

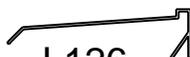
**9673**  
INTERIOR

### WATER DEFLECTORS



**L129**

1/4" GLASS & 1/2" GLASS USE w/ ADAPTORS



**L126**

FOR 1" GLAZING w/ H260



**L130**

FOR 1/4" GLAZING w/ H261

# SECTION II - PARTS IDENTIFICATION

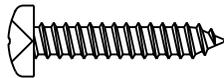
## SYSTEM 960 WALL ACCESSORIES LIST

CONT.

ABCD ○	B ○	CD ○
ABCD ○	B ○	CD ○
ABCD ○		
ABCD ○		
ABCD ○	B ○	CD ○
ABCD ○	B ○	CD ○

**H457** SCREW SPLINE &  
SHEAR BLOCK  
DRILL FIXTURE

HORIZ. TO SHEAR BLOCK



STT7 #10-12 X 1  
PL-PH-SMS 18-8 AB

1/4" & 1/2" GLAZING ADAPTOR



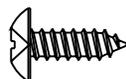
SPP8 #8-15 X 3/4  
PL-PH-SMS 18-8 AB  
W/.240HD @ 9666 & 9667

1/4" & 1/2" GLAZING ADAPTOR  
FOR JAMBS & TRANSOMS



STU8 #10-16 X 3/8  
PL-FH-SMS 18-8 B UC  
USED W/ 9733 & 9734  
TRANSOM ADAPTOR

TRANSOM GLZ. JAMB ADAP FAST.



SFP6 #8-15 X 1/2  
PL-TH-SMS 18-8 AB  
USED W/ 9673 & 9674  
TRANSOM ADAPTOR

 **W115** BULB GASKET

 **W125** @ UNDERSIZED GLASS  
.875" TO .906" THICK

 **W143** @ OVERSIZED GLASS  
or GRID BOTH SIDES

 **W127** WEDGE GASKET  
(DOOR FRAME-EXT.)

 **WM11** BUTT GLAZE SPACER  
3/8" x 1/2" TAPE

SCREW SPLINE FASTENERS



S108 #8-18 X 1  
SL-HW-SMS B-LEAD POINT

SHEAR BLOCK FASTENERS

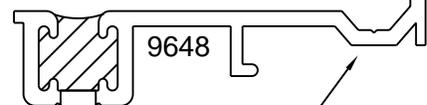
MRF8 #10-24 X 1 3/4  
PL-PH-SMS 410 F



SYSTEM II ADAPTOR

W104 WEATHERING

WINDOW SIZE FORMULA:  
D.L.O. - 5/8"



SFP5 #8-15 X 3/4  
PL-FH-SMS 18-8 AB  
WINDOW ADAP. SCREW  
USED W/ 9648



## SECTION III - SCREW SPLINE FABRICATION

The screw spline system is a fabrication and erection method that permits the preassembly of single units in the shop or at the job site. These units are then erected by mating the male mullion with the female mullion counterparts.

When an entrance is required, shear block joinery must be used to attach the side lite horizontals to the immediate door frame. The other side of the side lite will be fabricated for screw spline joinery as usual.

**NOTE: DUE TO THE SCREW TENSIONS REQUIRED FOR CORRECT INSTALLATION, IT WILL BE NECESSARY TO 'WAX' THE FRAME ASSEMBLY SCREWS TO PREVENT GALLING AND BREAKAGE.**

**STEP 1)** Measure the opening to determine the cut length of the frame components.

**NOTE:** Allow a minimum 1/2" shim and caulk space around the perimeter.

**NOTE:** Allow extra clearances, if necessary, to accommodate building tolerances.

**STEP 2)** Cut the verticals and vertical face caps to the frame size.

**NOTE:** Verticals must run through. If the opening has an entrance, see the appropriate frame and door fabrication and installation sheets.

**NOTE:** Door jambs run to the floor and are cut longer than other verticals.

**STEP 3)** Drill holes for the assembly screws on the vertical members. See the drilling template on page 19 or the drill jig guide on page 20.

**STEP 4)** Cut the horizontal members to the day lite openings (between the vertical mullions).  
Cut the horizontal face caps to day lite openings minus 1/16".  
(D.L.O. - 1/16")

# SECTION III - SCREW SPLINE FABRICATION

## DRILLING TEMPLATE

CONT.

### VERTICAL DRILLING-

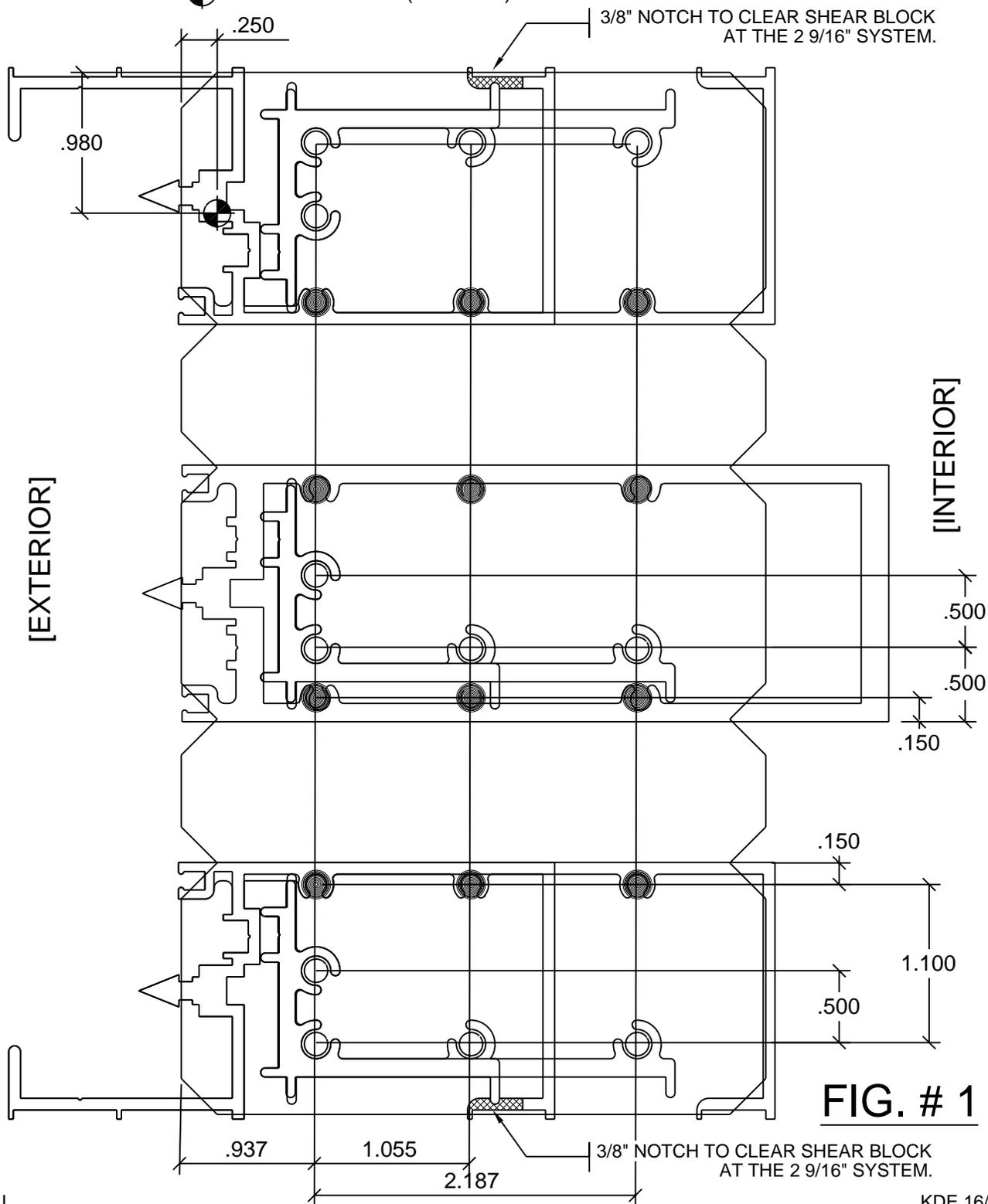
● = SCREW SPLINE # 16 DRILL (.177 DIA.)

○ = SHEAR BLOCK # 21 DRILL (.159 DIA.)

### HORIZONTAL DRILLING-

◐ = SHEAR BLOCK (.187 DIA.)

SET EDGE OF TEMPLATE FLUSH WITH GLAZING SIDE (VERT.)

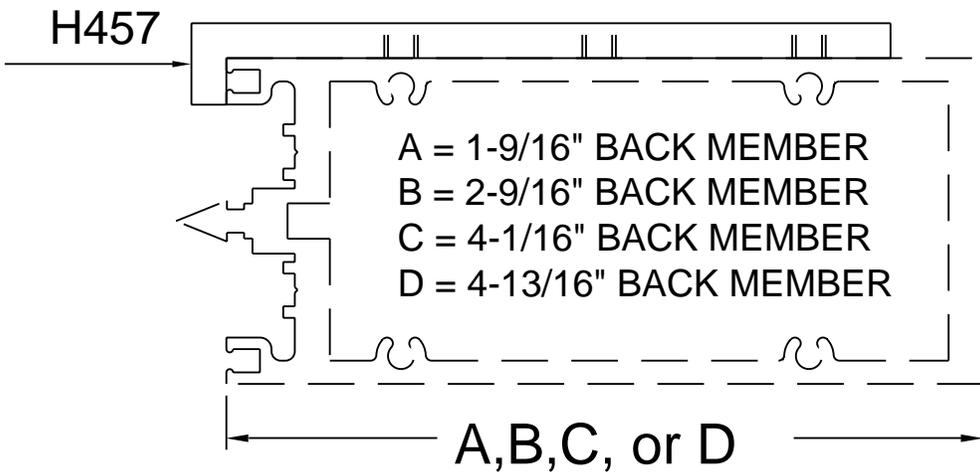
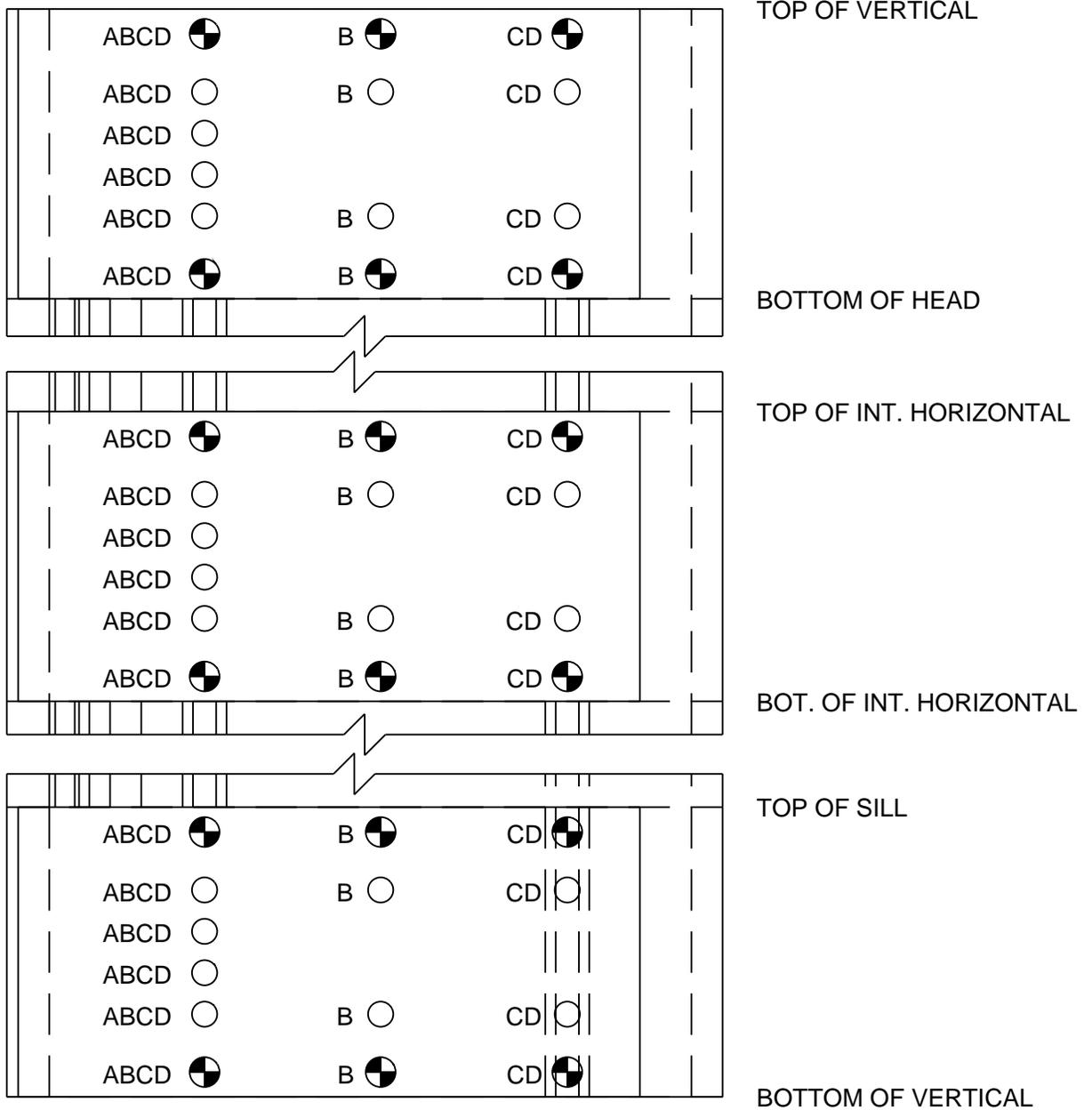


**FIG. # 1**

# SECTION III - SCREW SPLINE FABRICATION

## DRILL JIG

CONT.



.177" DIA. (#16) DRILL

 = SCREW SPLINE

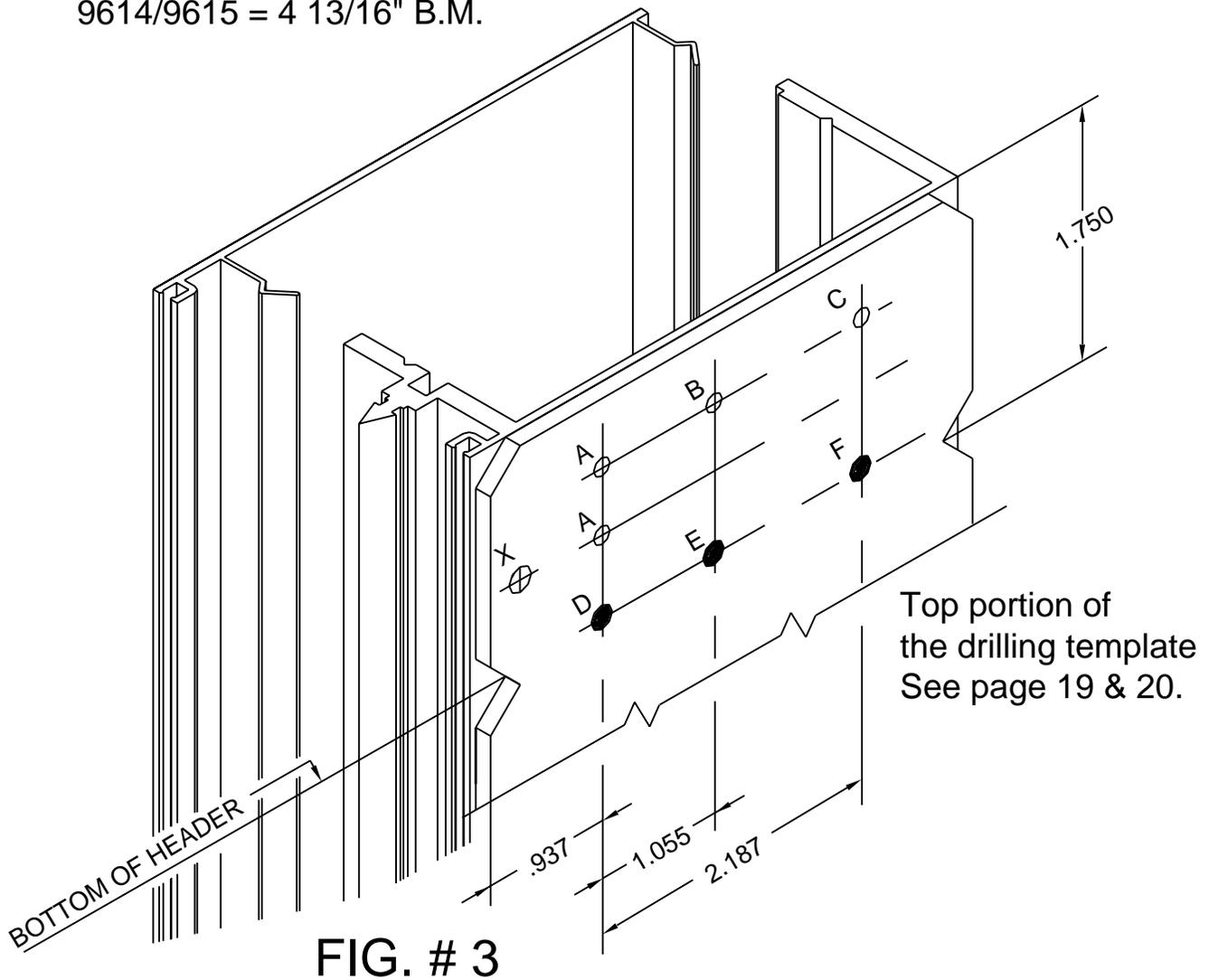
USE THESE HOLES FOR SCREW SPLINE ATTACHMENT

**FIG. # 2**

# SECTION III - SCREW SPLINE FABRICATION

(CONT.)

9625/9626 = 2 9/16" B.M.  
 9611/9612 = 4 1/16" B.M.  
 9614/9615 = 4 13/16" B.M.



For 2 9/16" back member -  
 top screw spline holes drill the  
 marked "D" & "E" locations  
 0.177 dia. (# 16 Drill) (2 Holes)

For 4 1/16" & 4 13/16" back members -  
 top screw spline holes drill the marked  
 "D" & "F" locations 0.177 dia.  
 (# 16 Drill) (2 Holes)

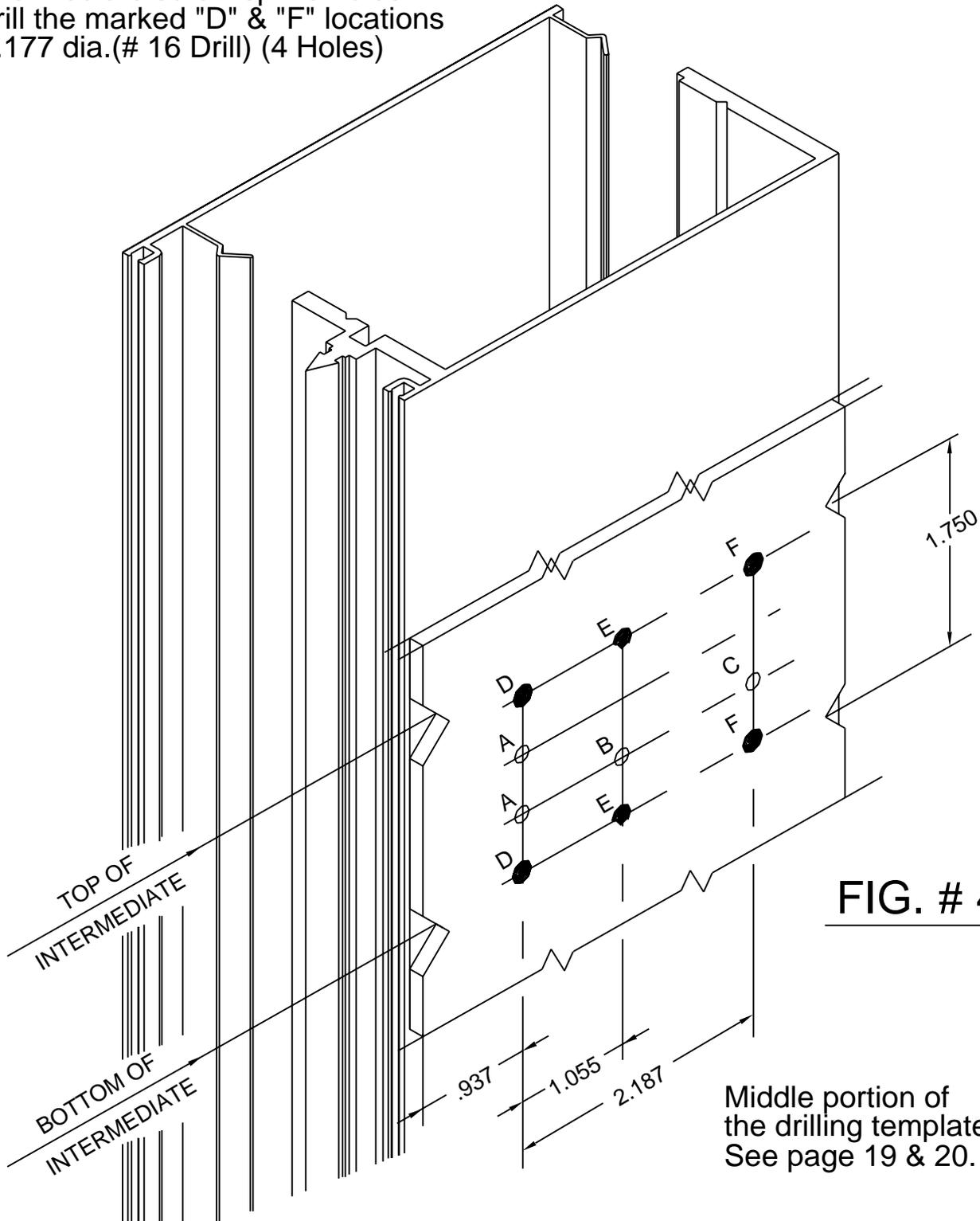
# SECTION III - SCREW SPLINE FABRICATION

(CONT.)

For 2 9/16" back member -  
intermediate screw spline holes  
drill the marked "D" & "E" locations  
0.177 dia. (# 16 Drill) (2 Holes)

9625/9626 = 2 9/16" B.M.  
9611/9612 = 4 1/16" B.M.  
9614/9615 = 4 13/16" B.M.

For 4 1/16" & 4 13/16" back members -  
intermediate screw spline holes  
drill the marked "D" & "F" locations  
0.177 dia. (# 16 Drill) (4 Holes)



Middle portion of  
the drilling template  
See page 19 & 20.

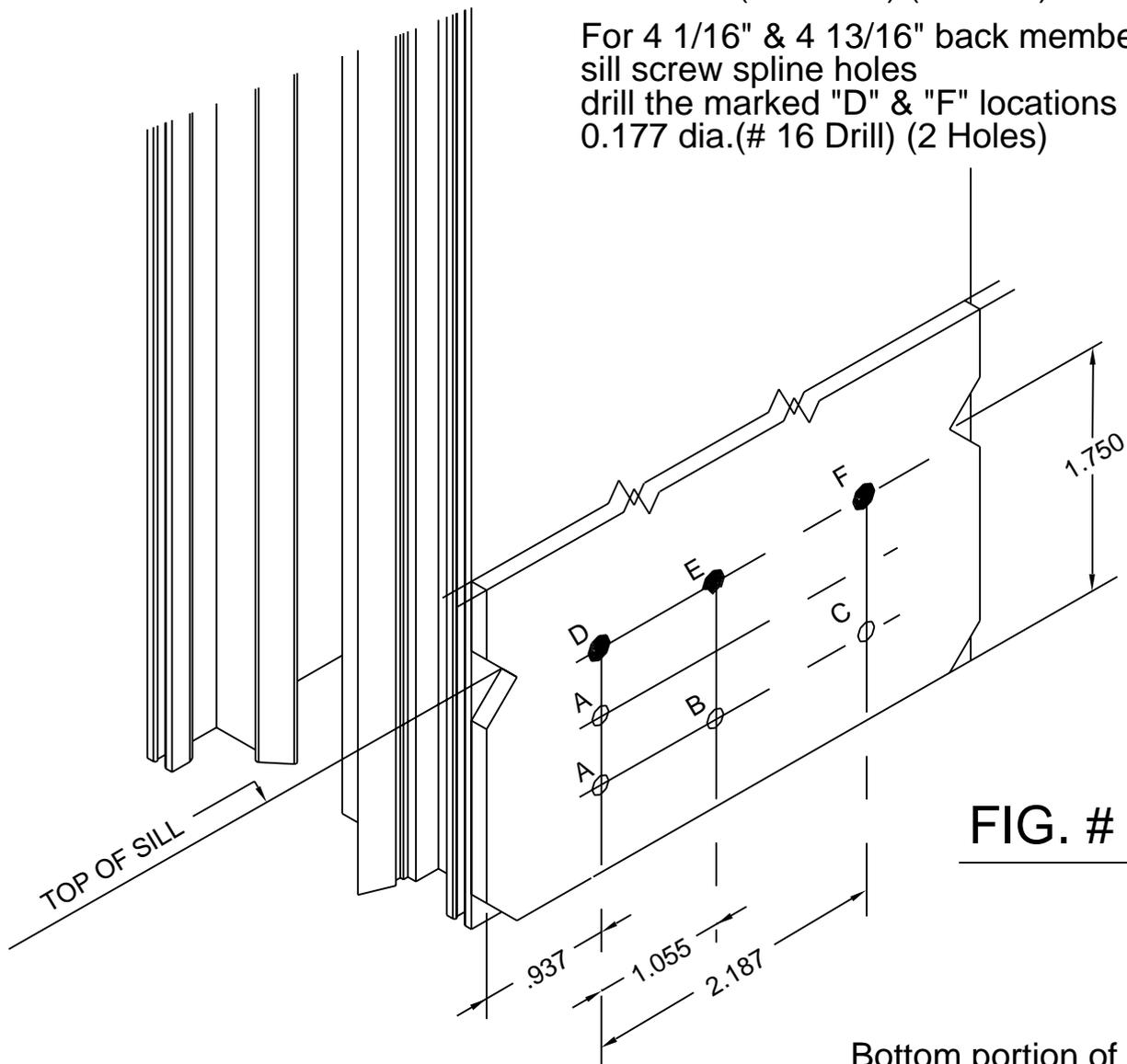
# SECTION III - SCREW SPLINE FABRICATION

(CONT.)

9625/9626 = 2 9/16" B.M.  
 9611/9612 = 4 1/16" B.M.  
 9614/9615 = 4 13/16" B.M.

For 2 9/16" back member -  
 sill screw spline holes  
 drill the marked "D" & "E" locations  
 0.177 dia. (# 16 Drill) (2 Holes)

For 4 1/16" & 4 13/16" back members -  
 sill screw spline holes  
 drill the marked "D" & "F" locations  
 0.177 dia. (# 16 Drill) (2 Holes)

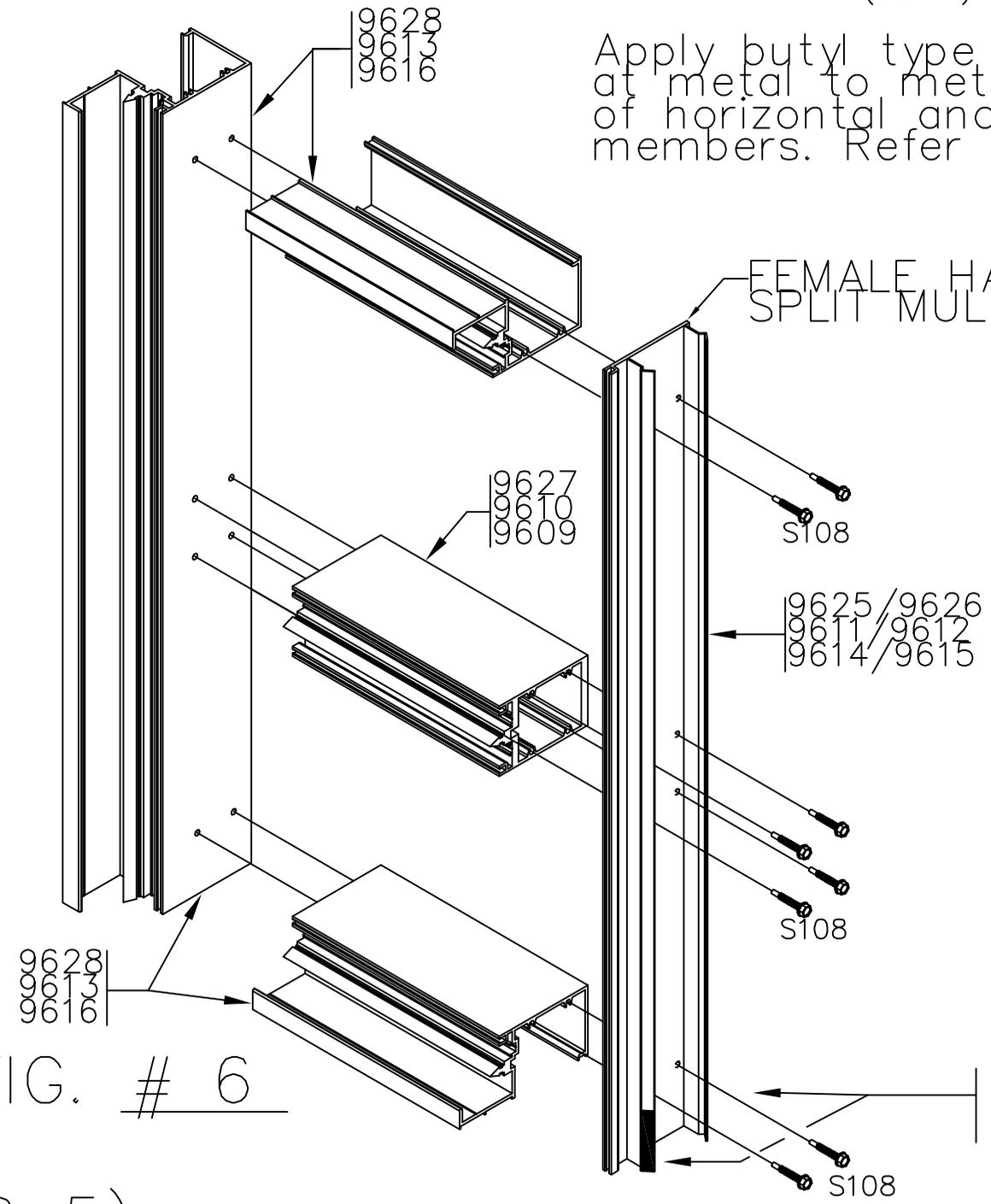


**FIG. # 5**

Bottom portion of  
 the drilling template  
 See page 19 & 20.

# SECTION III — SCREW SPLINE FABRICATION

(CONT.)



Apply butyl type sealant at metal to metal joints of horizontal and vertical members. Refer to page 26.

FIG. # 6

Apply sealant 6" up from sill on all 2-PC mullions

STEP 5) Apply butyl type sealant to the ends of all horizontals before assembling the units. See Fig. # 8 thru Fig. # 11 on page 26.

STEP 6) Assemble the units as shown in Fig. # 6 above and in Fig. # 7 on page 25.

# SECTION III - SCREW SPLINE FABRICATION

(CONT.)

NOTE:

1 9/16" BACK MEMBER SYSTEM  
CANNOT BE SCREW SPLINE  
ASSEMBLED.

MALE HALF OF  
SPLIT MULLION

9625/9626  
9611/9612  
9614/9615

9628  
9613  
9616

9627  
9610  
9609

S108

S108

S108

Apply butyl type sealant  
at metal to metal joints  
of horizontal and vertical  
members. Refer to page 26.

**FIG. # 7**

9628  
9613  
9616

**STEP 7)** Snap together the assembled female and male units, then install into the opening.

# SECTION III - SCREW SPLINE FABRICATION

(CONT.)

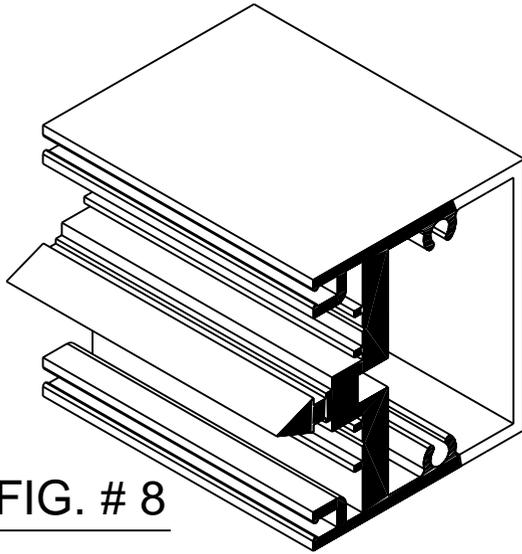


FIG. # 8

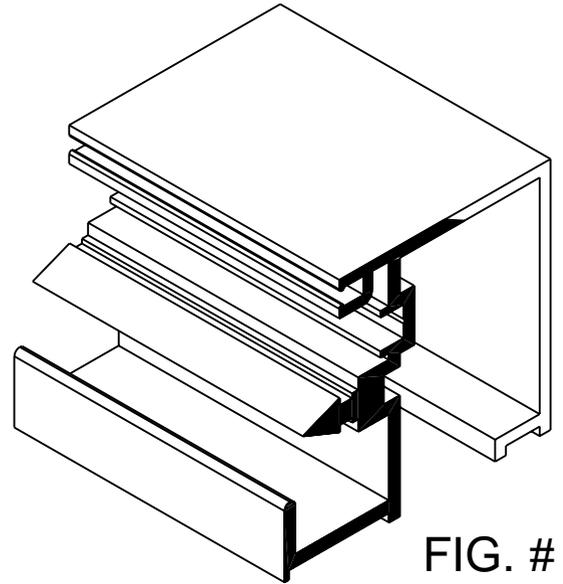


FIG. # 9

FIG. #6 THRU # 9 SHOW THE SHADED AREAS WHERE A BUTYL TYPE SEALANT MUST BE APPLIED TO THE ENDS OF THE HORIZONTALS, AT METAL TO METAL JOINTS.

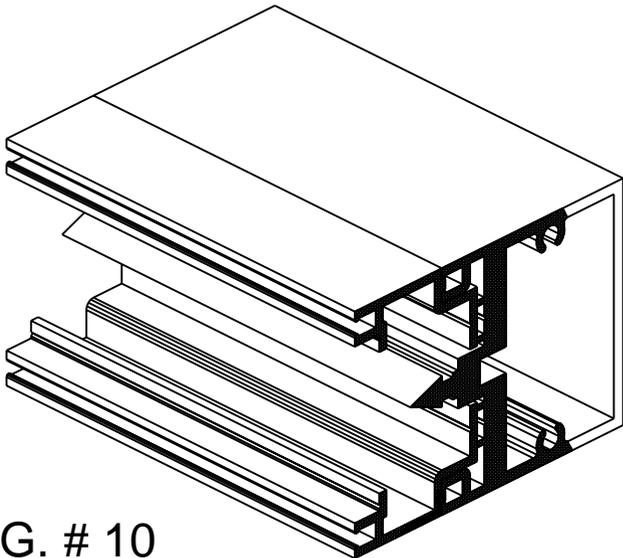


FIG. # 10

# 9667 ADAPTOR - 1/4" GLZ.  
 # 9666 ADAPTOR - 1/2" GLZ.

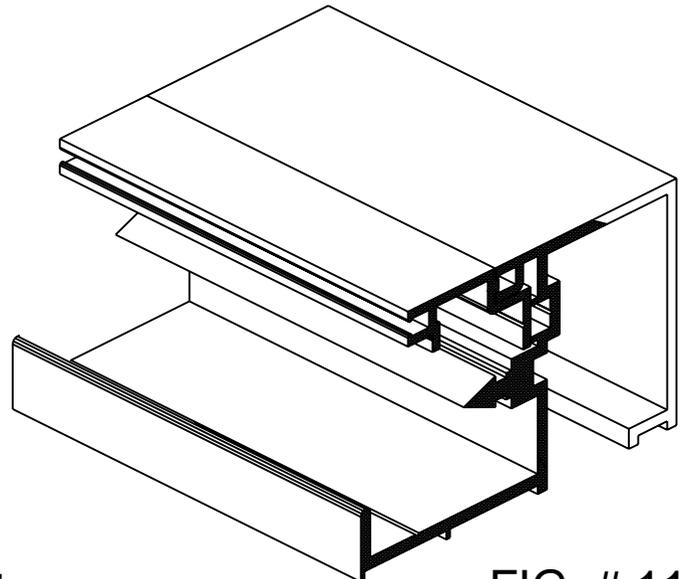


FIG. # 11

Adaptors are available to convert 1" glazing systems to 1/4" and 1/2" glazing. Refer to Fig. # 10 and # 11 above.

## SECTION IV - SHEAR BLOCK FABRICATION

### STEP 1)

Measure the opening to determine the cut length of the frame components.

NOTE: Allow a minimum 1/2" shim and caulk space around the perimeter.

NOTE: Allow extra clearances, if necessary, to accommodate building tolerances.

### STEP 2)

Cut the verticals and vertical face caps to the frame size.

NOTE: Verticals must run through. If the opening has an entrance, see the appropriate frame and door fabrication and installation sheets.

NOTE: Door jambs run to the floor and are cut longer than other verticals.

### STEP 3)

Drill mounting holes for the shear blocks on the vertical members. See the drilling template on page 28 or the drill jig guide on page 29. Also refer to pages 30 through 32 for drilling information.

### STEP 4)

Cut the horizontal members to the daylite openings (between the vertical mullions).

Cut the horizontal face caps to daylite openings minus 1/16".  
(D.L.O. - 1/16")

### STEP 5)

Drill the holes in the horizontals for attachment to the shear blocks. Refer to Fig. # 14 and # 15 on page 33.

# SECTION IV - SHEAR BLOCK FABRICATION

CONT.

## DRILLING TEMPLATE

VERTICAL DRILLING-

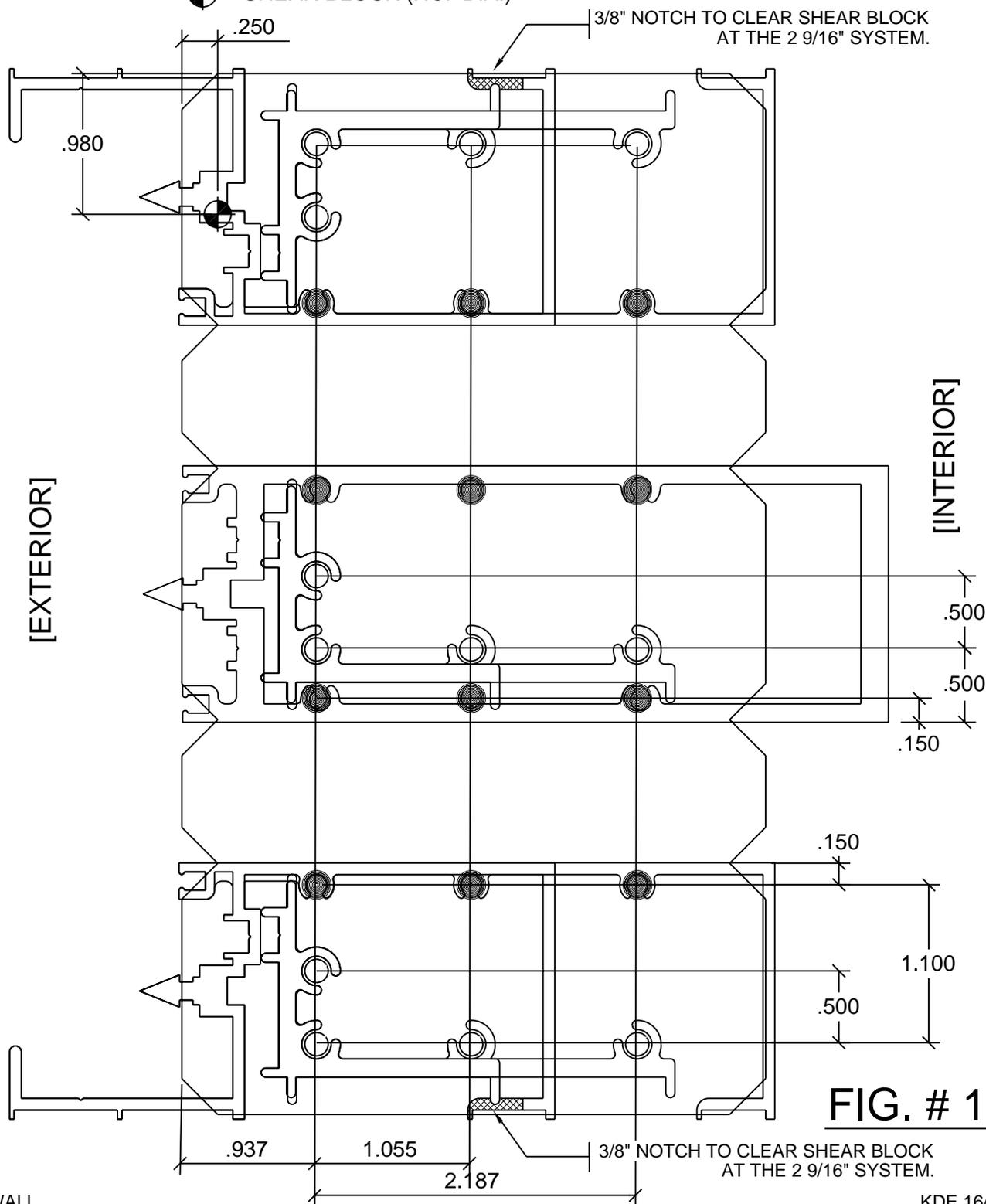
● = SCREW SPLINE # 16 DRILL (.177 DIA.)

○ = SHEAR BLOCK # 21 DRILL (.159 DIA.)

HORIZONTAL DRILLING-

◐ = SHEAR BLOCK (.187 DIA.)

SET EDGE OF TEMPLATE FLUSH WITH GLAZING SIDE (VERT.)

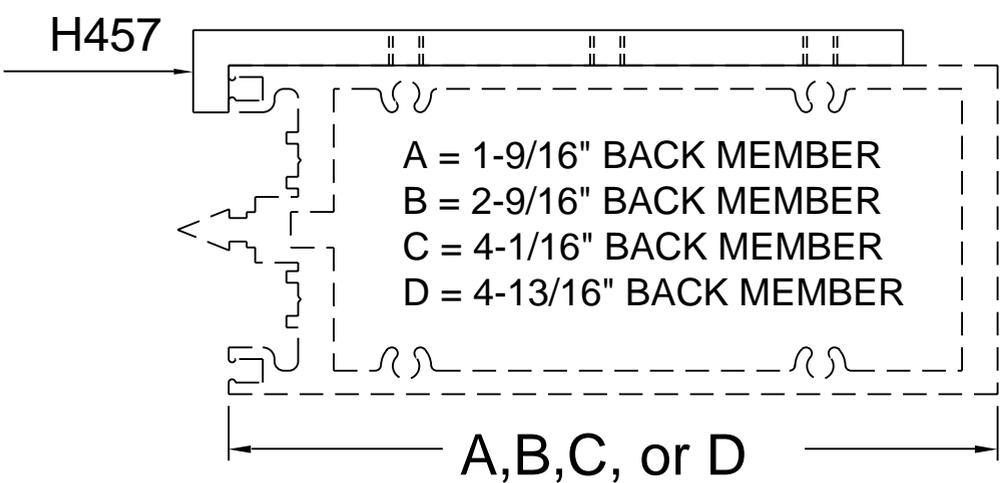
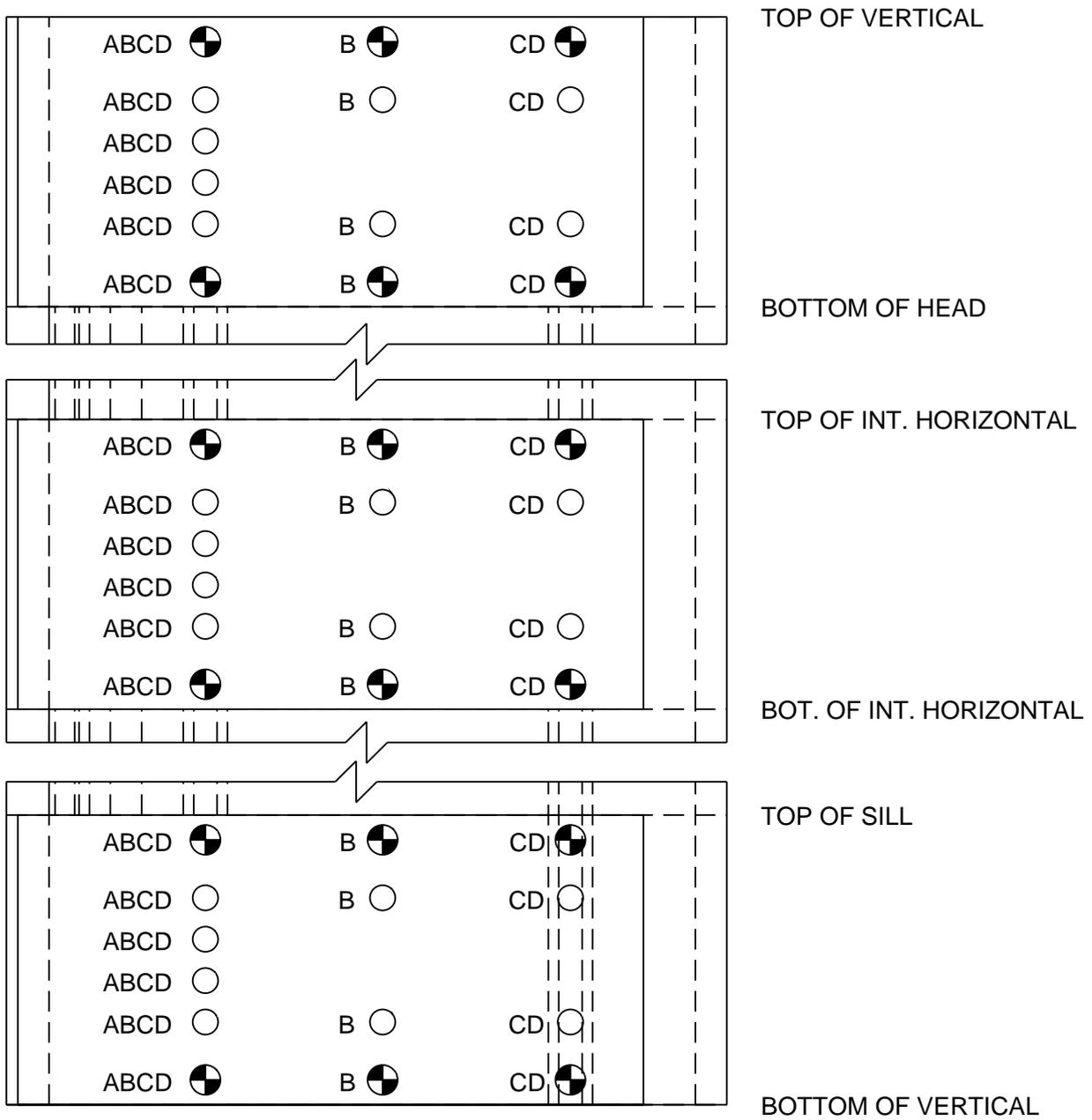


**FIG. # 12**

# SECTION IV - SHEAR BLOCK FABRICATION

## DRILL JIG

CONT.



.159" DIA. (#21) DRILL

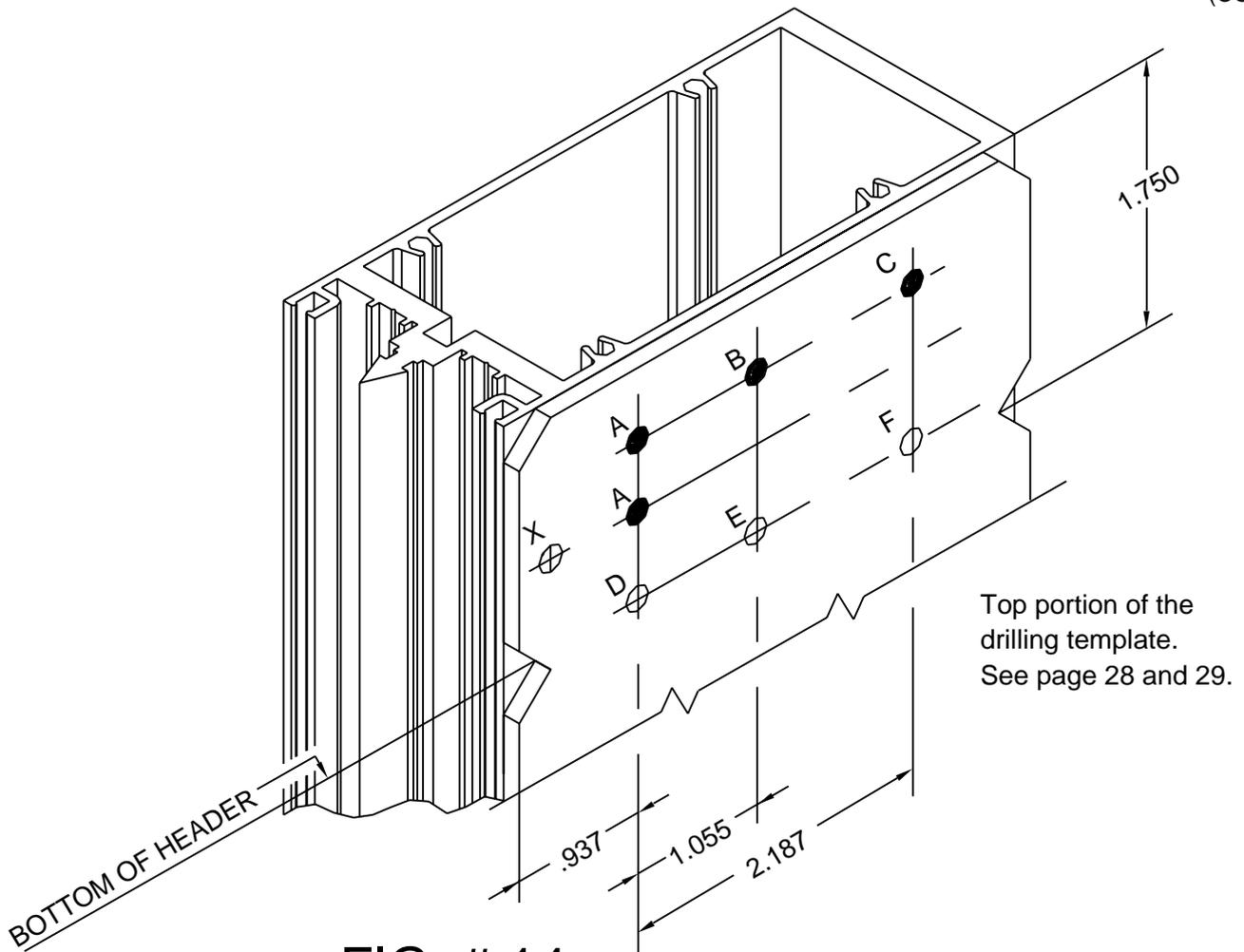
○ = SHEAR BLOCK

USE THESE HOLES FOR SHEAR BLOCK ATTACHMENT

**FIG. # 13**

# SECTION IV - SHEAR BLOCK FABRICATION

(CONT.)



**FIG. # 14**

For 1 9/16" back member -  
top shear block holes  
drill the marked "A" locations  
.159 dia. (# 21 Drill) (2 places).

For 2 9/16" back member -  
top shear block holes  
drill the marked "A" & "B" locations  
.159 dia. (# 21 Drill) (3 places).

For 4 1/16" & 4 13/16" back members -  
top shear block holes  
drill the marked "A" & "C" locations  
.159 dia. (# 21 Drill) (3 places).

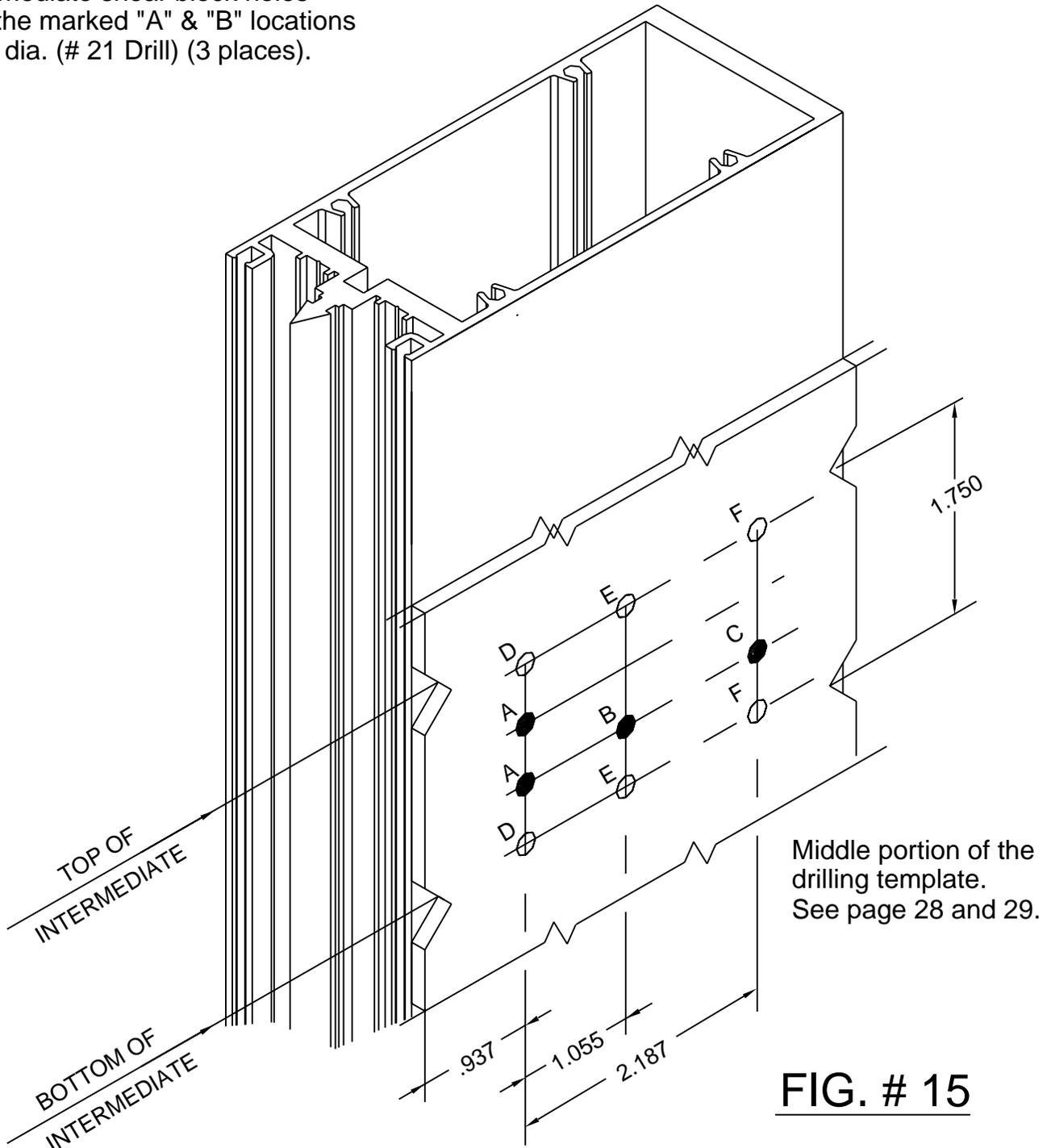
# SECTION IV - SHEAR BLOCK FABRICATION

(CONT.)

For 1 9/16" back member -  
intermediate shear block holes  
drill the marked "A" locations  
.159 dia. (# 21 Drill) (2 places).

For 4 1/16" & 4 13/16" back members -  
intermediate shear block holes  
drill the marked "A" & "C" locations  
.159 dia. (# 21 Drill) (3 places).

For 2 9/16" back member -  
intermediate shear block holes  
drill the marked "A" & "B" locations  
.159 dia. (# 21 Drill) (3 places).



**FIG. # 15**

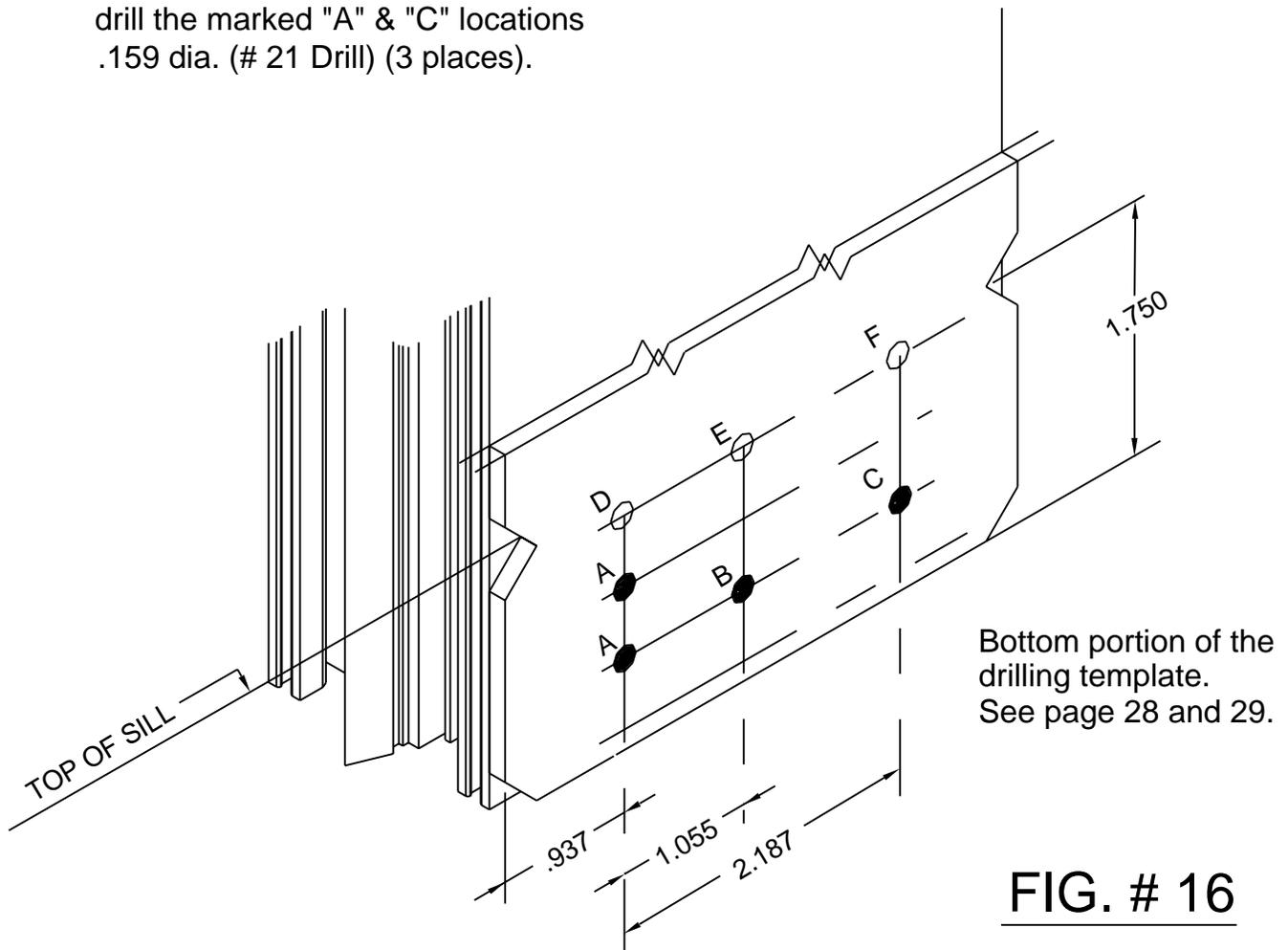
# SECTION IV - SHEAR BLOCK FABRICATION

(CONT.)

For 1 9/16" back member -  
bottom shear block holes  
drill the marked "A" locations  
.159 dia. (# 21 Drill) (2 places).

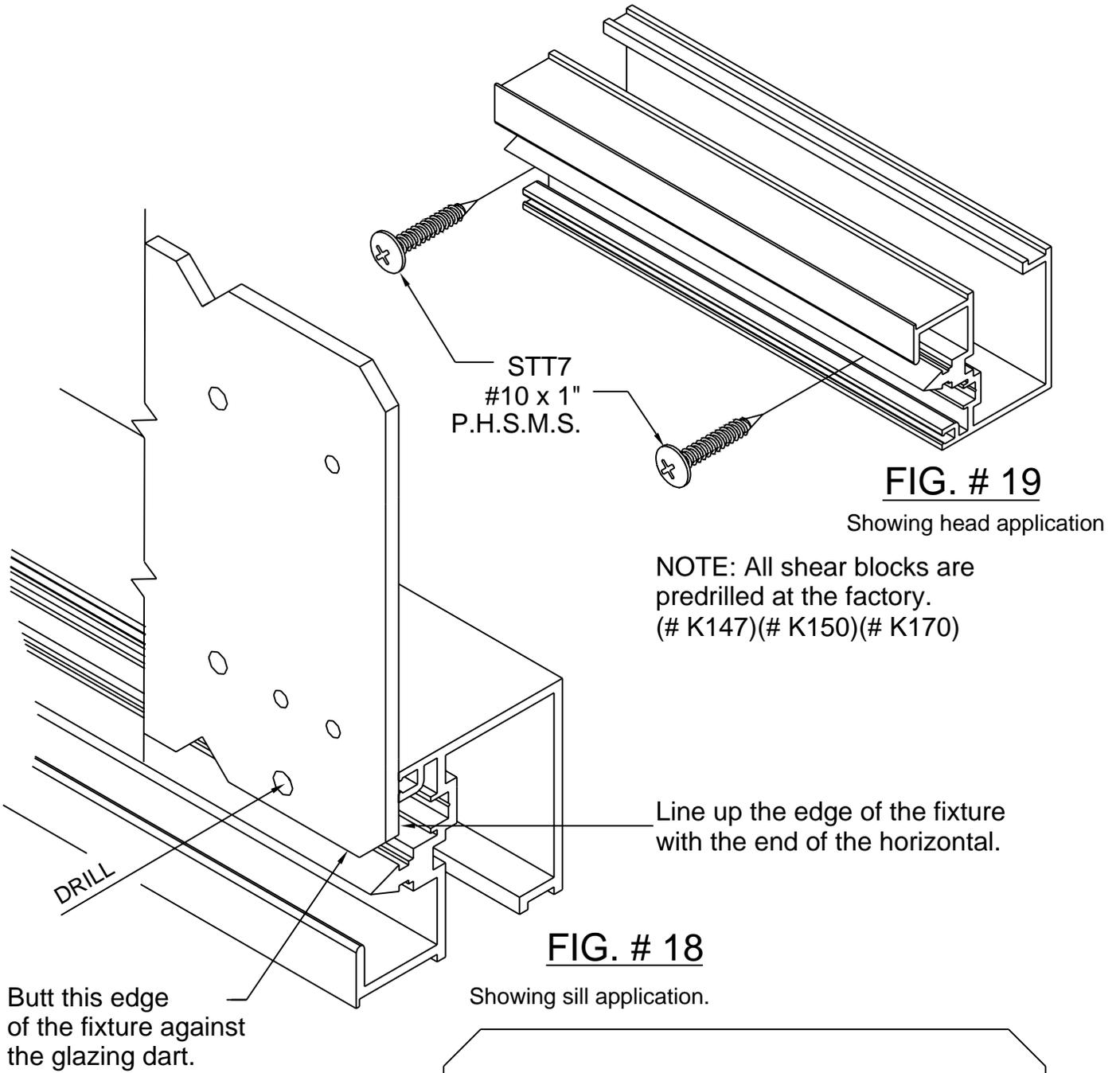
For 2 9/16" back member -  
bottom shear block holes  
drill the marked "A" & "B" locations  
.159 dia. (# 21 Drill) (3 places).

For 4 1/16" & 4 13/16" back members -  
bottom shear block holes  
drill the marked "A" & "C" locations  
.159 dia. (# 21 Drill) (3 places).

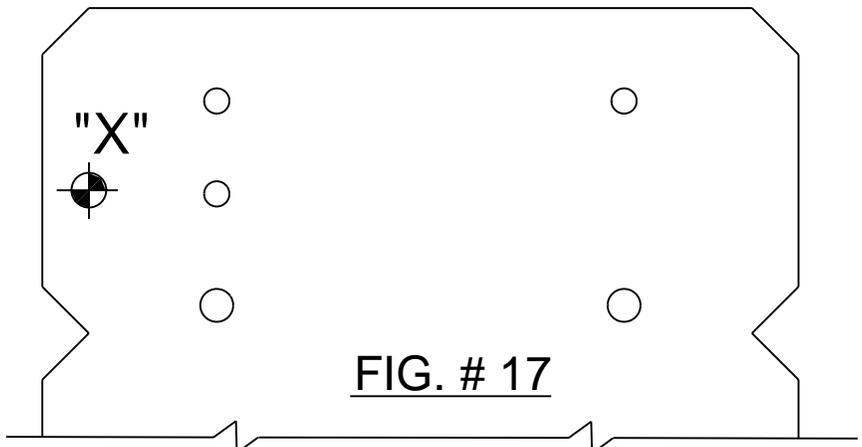


# SECTION IV - SHEAR BLOCK FABRICATION

(CONT.)

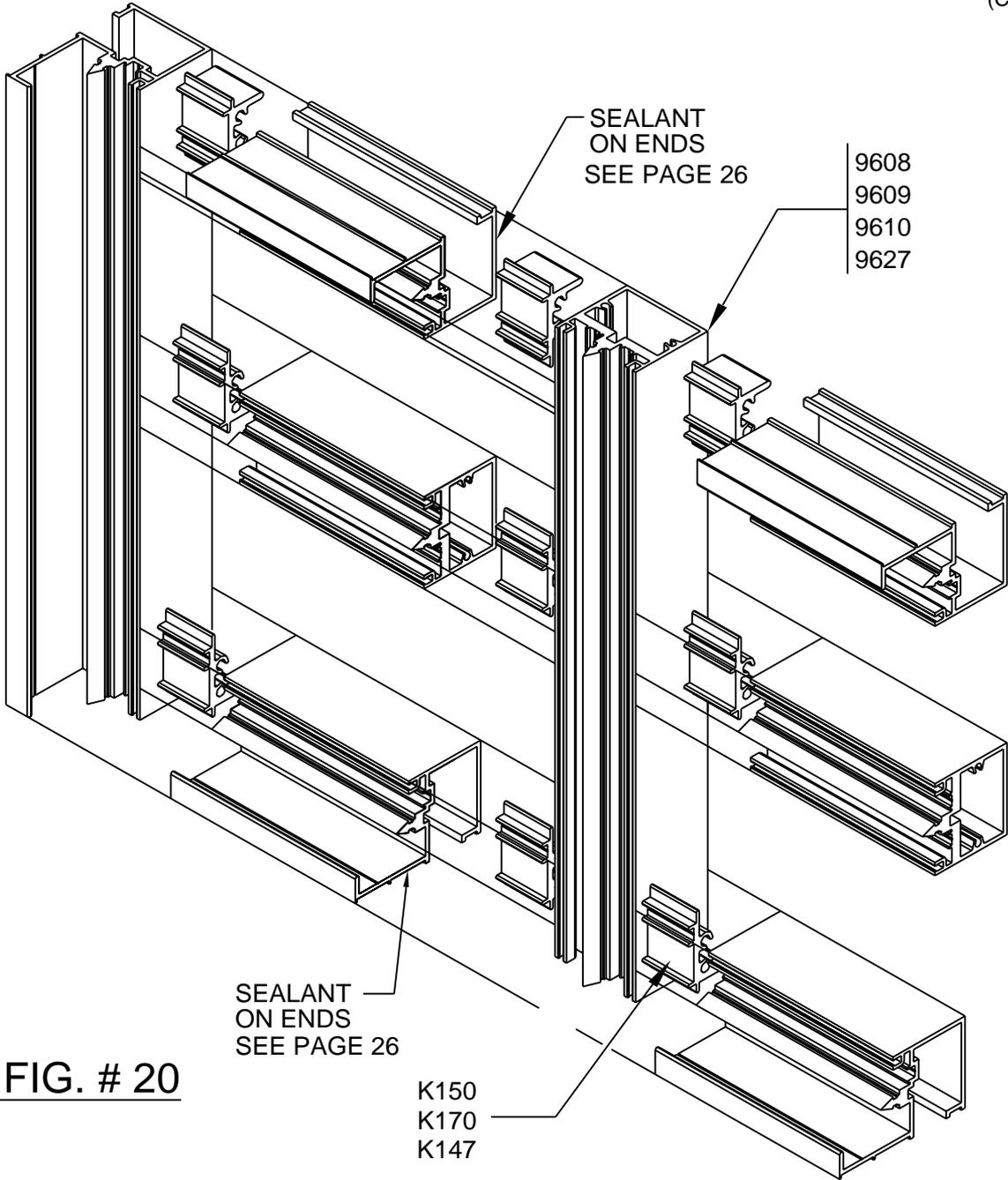


Drill hole "X"  
.187 dia. (# 13 Drill)  
to clear for the horizontal  
attachment screw.



# SECTION IV - SHEAR BLOCK FABRICATION

(CONT.)



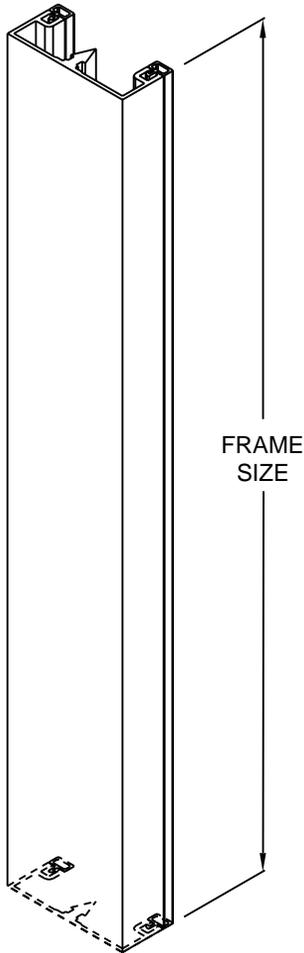
**STEP 6)** Apply a butyl type sealant to the ends of all horizontals before assembling the units as shown in Fig. #20 above. See page 26 for sealant application guidance.

**STEP 7)** Assemble the units as shown in Fig. # 20 above.

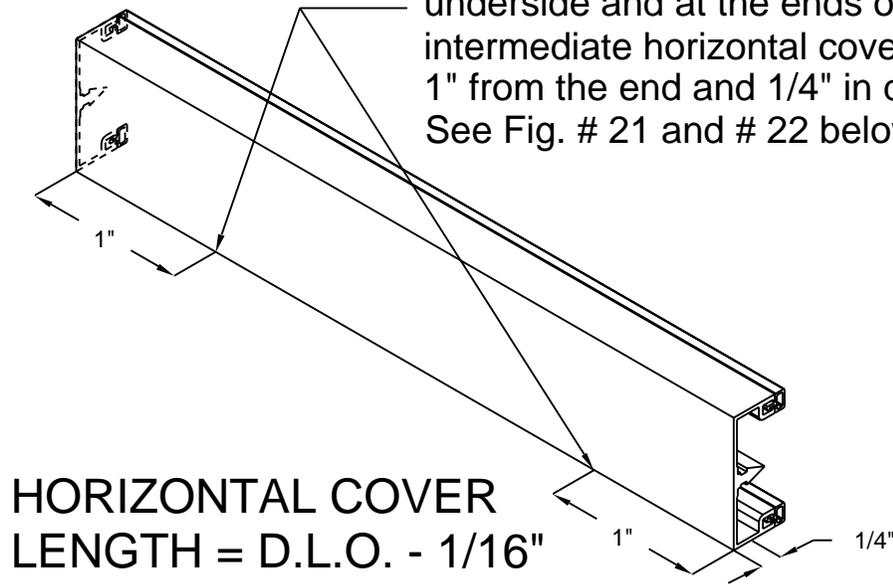
# SECTION V A - SCREW SPLINE / SHEAR BLOCK FABRICATION

## SNAP ON COVERS AND WEEP HOLES

The vertical covers are installed first. The length is the same as the frame size.



The weep holes are located in the underside and at the ends of the intermediate horizontal cover, 1" from the end and 1/4" in diameter. See Fig. # 21 and # 22 below.



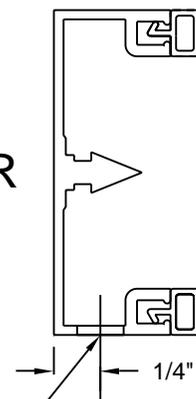
HORIZONTAL COVER LENGTH = D.L.O. - 1/16"

FIG. # 21

VERTICAL COVER LENGTH = FRAME SIZE

HORIZONTAL COVER

The horizontal covers are installed after the vertical covers. The cut length is D.L.O. - 1/16".



1/4" DIA. WEEP

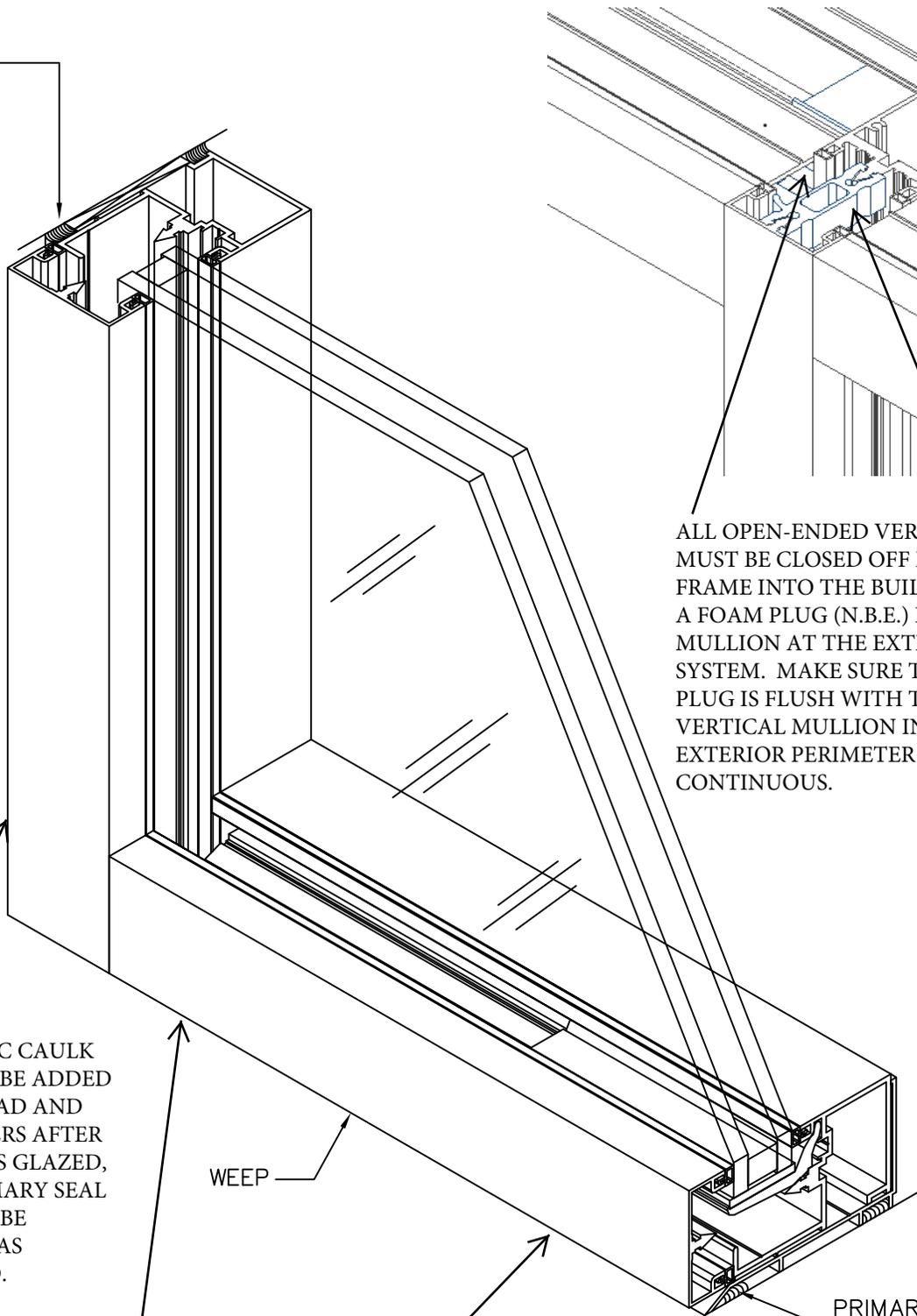
FIG. # 22

SECTION V A — SCREW SPLINE / SHEAR BLOCK  
FABRICATION

CONT.

SNAP ON COVERS AND WEEP HOLES

PRIMARY SEAL



ALL OPEN-ENDED VERTICAL FRAME MEMBERS MUST BE CLOSED OFF BEFORE INSTALLING THE FRAME INTO THE BUILDING OPENING. INSERT A FOAM PLUG (N.B.E.) INTO THE TOP OF THE MULLION AT THE EXTERIOR SIDE OF THE SYSTEM. MAKE SURE THAT THE TOP OF THE PLUG IS FLUSH WITH THE TOP OF THE VERTICAL MULLION IN ORDER TO KEEP THE EXTERIOR PERIMETER JOINT SEAL CONTINUOUS.

A COSMETIC CAULK JOINT CAN BE ADDED TO THE HEAD AND JAMB COVERS AFTER THE UNIT IS GLAZED, BUT A PRIMARY SEAL WILL STILL BE REQUIRED AS INDICATED.

WEEP

DO NOT SEAL FRONT EDGE, LEAVE OPEN FOR DRAINAGE. WEEP HOLES ARE HIDDEN.

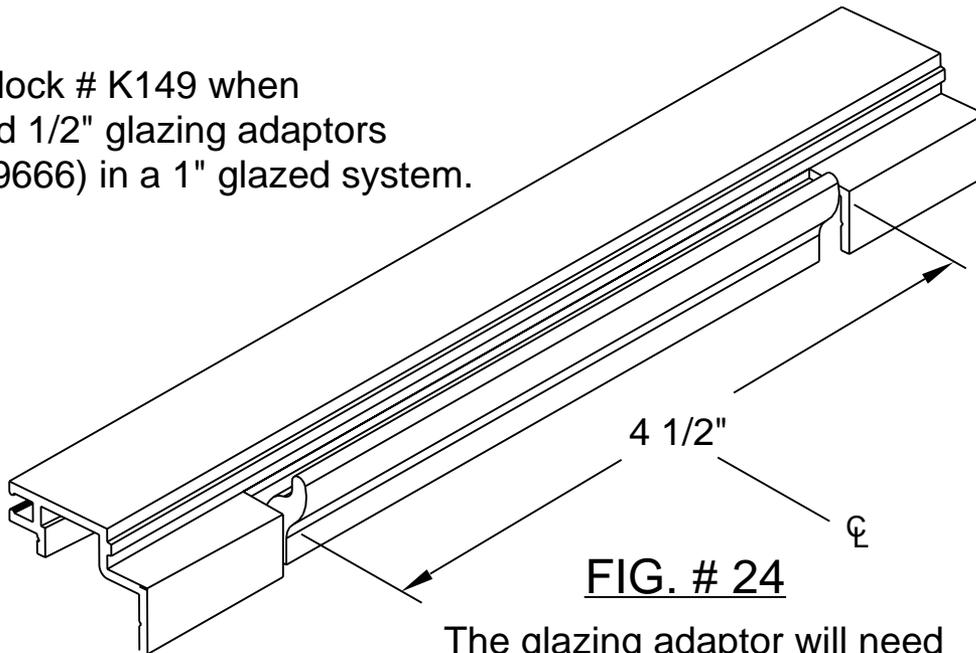
PRIMARY SEAL

FIG. # 23

**SECTION V B - SCREW SPLINE / SHEAR BLOCK FABRICATION** CONT.

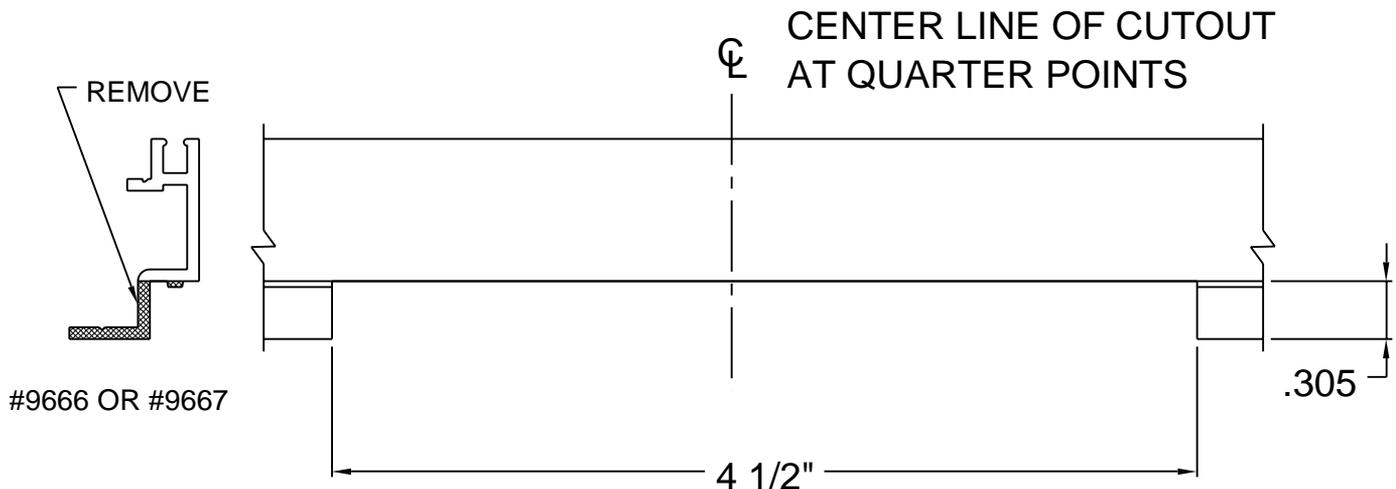
**GLASS SETTING CHAIR AND GLAZING ADAPTORS**

Use setting block # K149 when using 1/4" and 1/2" glazing adaptors (# 9667 or # 9666) in a 1" glazed system.



**FIG. # 24**

The glazing adaptor will need to be notched to clear the setting chair/block at quarter point locations, as shown in Fig. # 24 and # 25.



**FIG. # 25**

**FULL SIZE**

# SECTION V C - SCREW SPLINE / SHEAR BLOCK FABRICATION CONT.

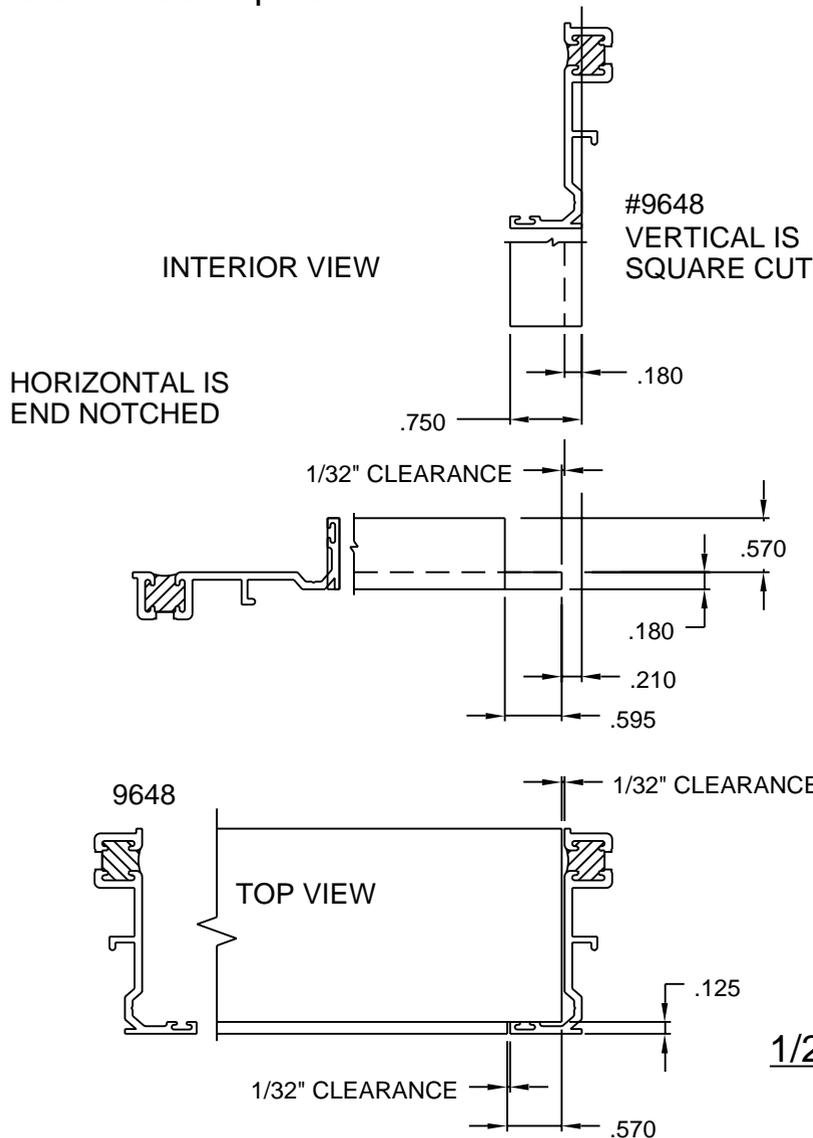
## SYSTEM II ADAPTOR FOR P.O. / P.I. & CASEMENTS

The vertical SYSTEM II adaptor runs through and is square cut. The cut length formula is frame D.L.O. - 1/6".

The horizontal adaptor requires notching to match the vertical. The cut length formula for the horizontal adaptor is frame D.L.O. - 7/16", then notch the vertical leg back 9/16" x 1/8" at each end. These dimensions allow 1/32" clearance per end.

Install the weathering in each piece and attach the adaptors with #SFP5 screws, 3" from the ends and 12" on center.

Seal the ends with a nonhardening sealant completely. Then install the System II window tight against the weathering leg of the adaptor. Use appropriate blocking and fasteners as required.



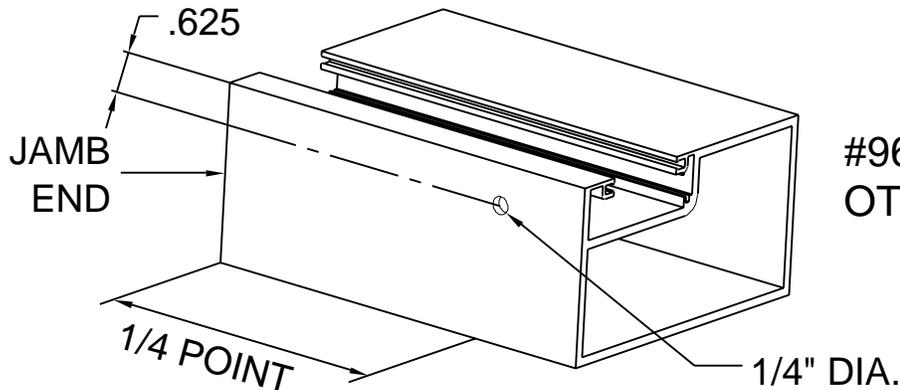
**FIG. # 26**

1/2 SIZE

# SECTION VI - DOOR FRAME INSTALLATION

NOTE: If an entrance frame is required, it must be installed first.  
 NOTE: If NO entrance frame is required, proceed to Section VII.

WEEP THE TRANSOM BAR WITH (2) 1/4" DIA. HOLES, 5/8" DOWN FROM THE TOP AND AT 1/4 POINTS.



#9633 SHOWN,  
OTHERS SIMILAR.

FIG. # 27

- STEP 1) Correctly locate the entrance frame in the opening.
- STEP 2) Set the assembled door frame in the opening, plumb and level.
- STEP 3) Anchor the door frame as indicated below in Fig. # 27A.  
Also see Fig. # 28 thru Fig. # 30 on page 40.

NOTE:  
The door jambs run to the floor and are cut longer than other verticals.

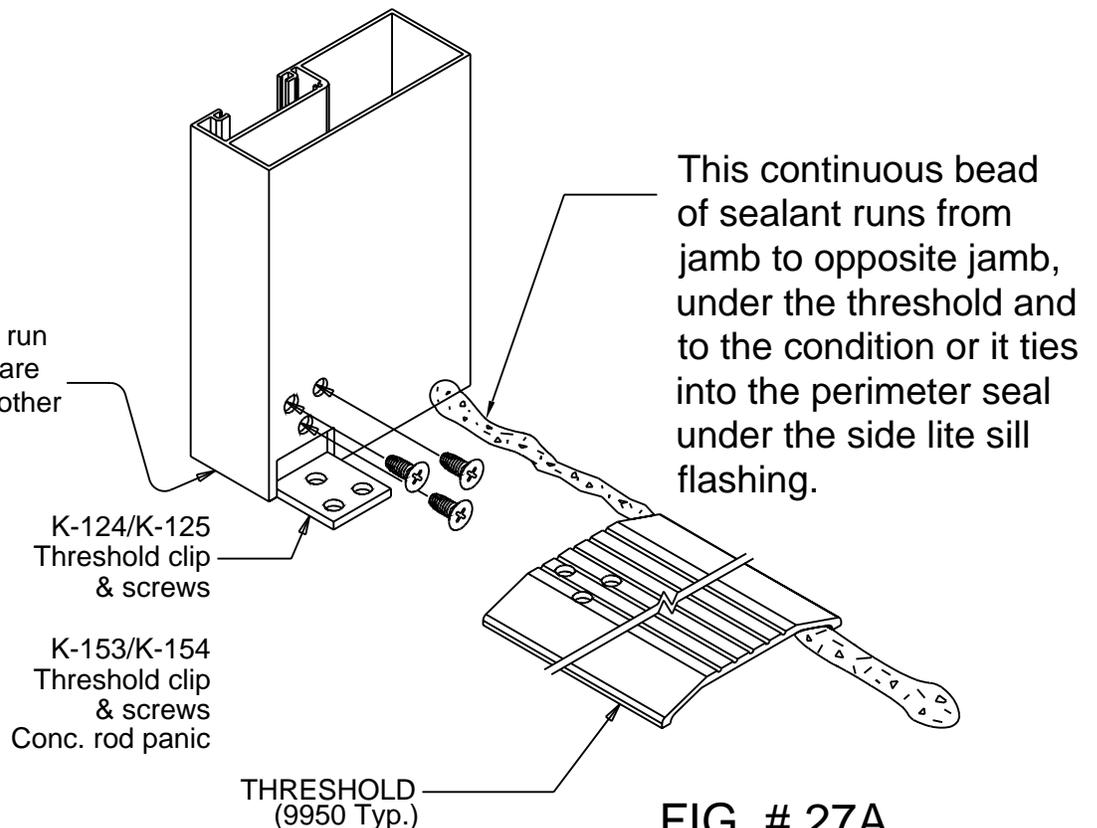
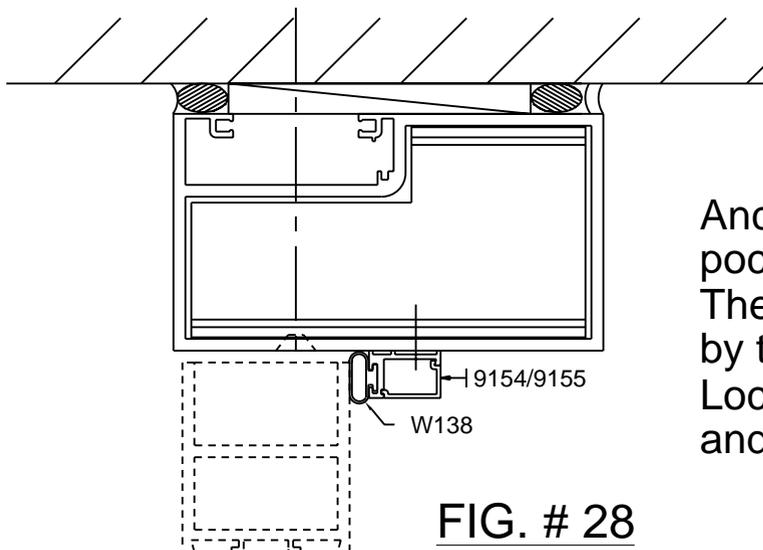


FIG. # 27A

# SECTION VI - DOOR FRAME INSTALLATION

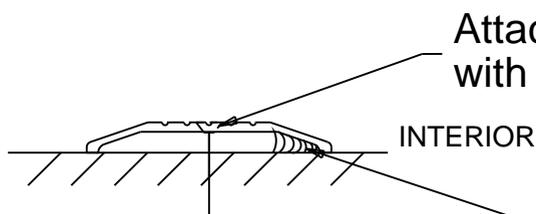
(CONT.)

SEE PAGES 10 THRU PAGE 12 FOR DOOR HEADER AND DOOR JAMB IDENTIFICATION.



**FIG. # 28**

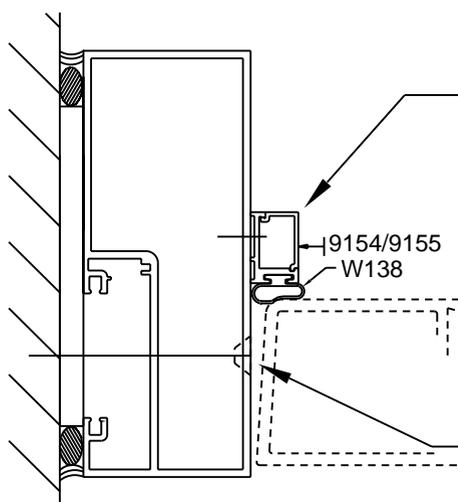
Anchor through the header glazing pocket with flat head screws. The fastener will be concealed by the closed door. Locate the fastener 6" from the ends and 24" on center maximum spacing.



**FIG. # 29**

Attach through the threshold with flat head screws.

Apply a continuous bead of sealant from door jamb to door jamb.



**FIG. # 30**

Install the door stop after the jambs are plumb and anchored.

Anchor through the glazing pocket at the jambs with flat head screws. The fastener will be concealed by the closed door.

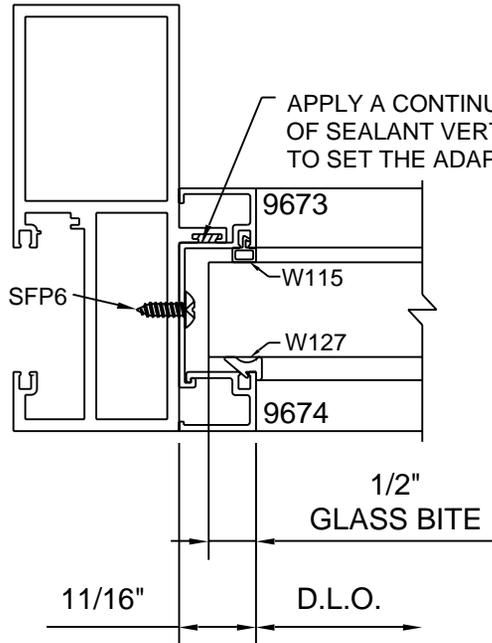
SEE THE DOOR SHIPPING CARTON FOR DOOR INSTALLATION INSTRUCTIONS.

# SECTION VI - DOOR FRAME INSTALLATION

## TRANSOM LITE GLAZING ADAPTOR

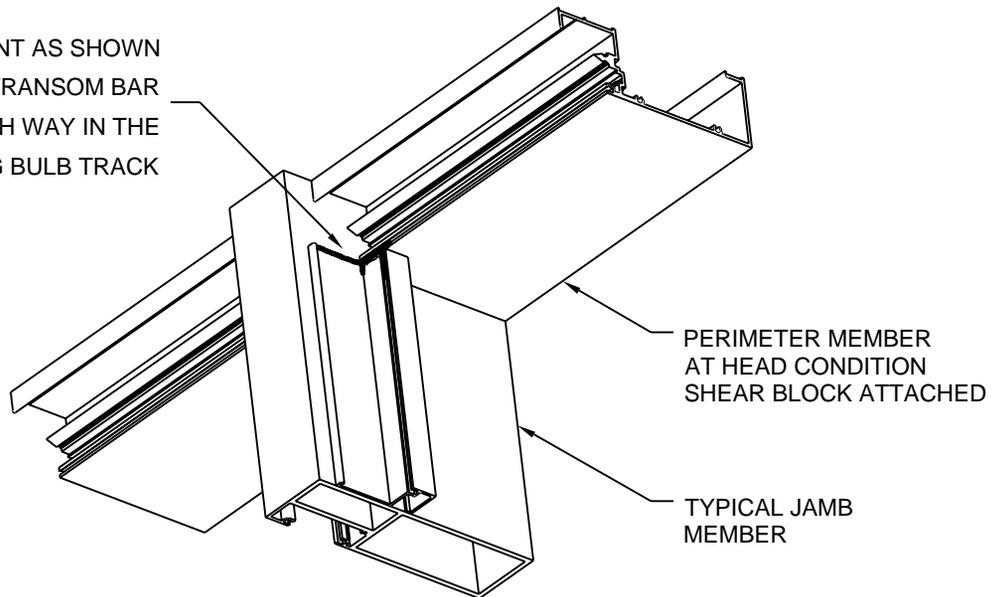
(CONT.)

CUT LENGTH FORMULA FOR TRANSOM  
APPLIED GLAZING = D.L.O. - 1/16"



**FIG. # 31**

APPLY SEALANT AS SHOWN  
AT HEAD AND TRANSOM BAR  
AND 1" EACH WAY IN THE  
GLAZING BULB TRACK



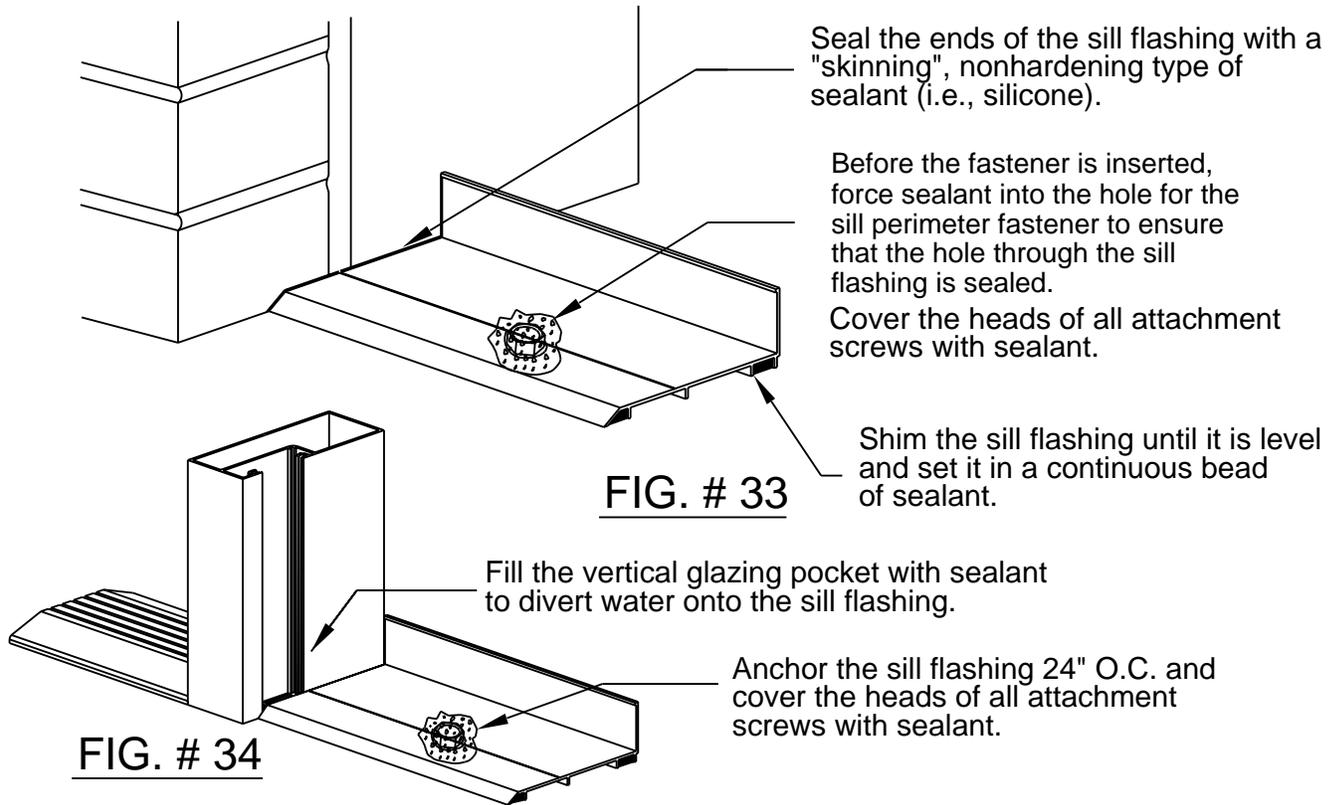
PERIMETER MEMBER  
AT HEAD CONDITION  
SHEAR BLOCK ATTACHED  
  
TYPICAL JAMB  
MEMBER

**FIG. # 32**

IT IS NOT REQUIRED TO REMOVE THE EXTRUDED  
DOOR STOP IN THE TRANSOM AREA TO APPLY THE  
TRANSOM GLAZING ADAPTOR. THE ADAPTOR WILL  
APPLY OVER THE FIN STOP.  
THE FIN STOP WILL HAVE TO BE NOTCHED AT THE TRANSOM BAR.

# SECTION VII - SILL FLASHING INSTALLATION

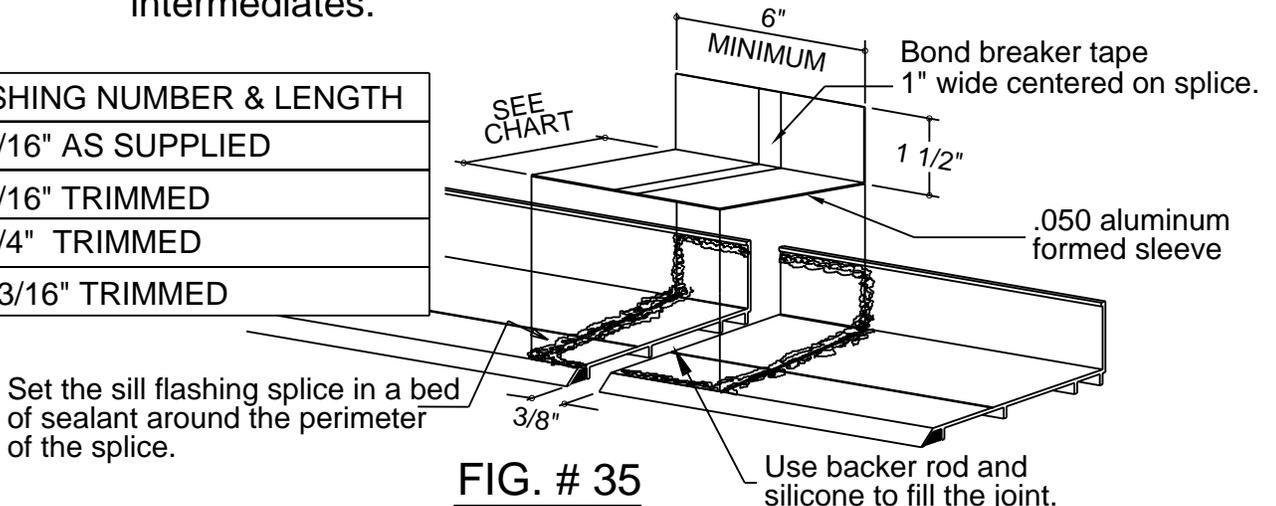
**STEP 1)** Install the sill flashing continuously between the masonry jambs or door frame to masonry. Refer to Fig. # 33 & # 34 below.



**STEP 2)** Splice the sill flashing every 20'-0" as shown in Fig. # 35 below. F-542 splice sleeve is supplied for use with the 4 13/16" back member. Trim F-542 to the correct length for the particular system depth being used.

If the elevation's configuration consists of verticals through, for best performance, locate the sill flashing splice 6" from vertical intermediates.

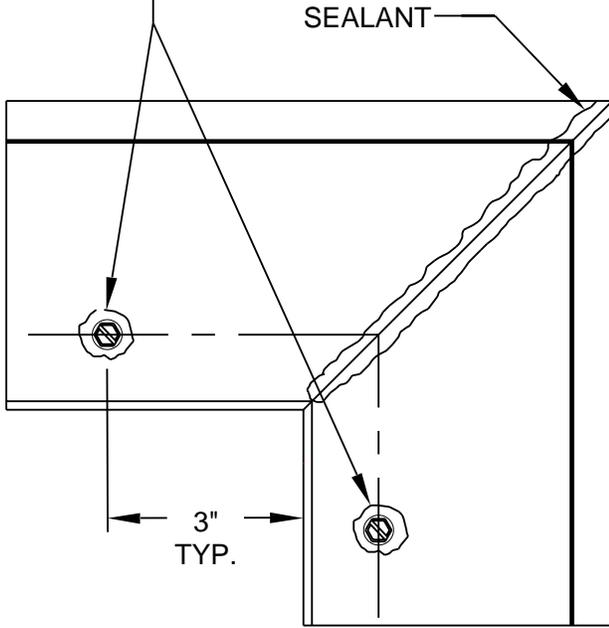
SILL FLASHING NUMBER & LENGTH
9974 - 6 1/16" AS SUPPLIED
9668 - 5 5/16" TRIMMED
9982 - 3 3/4" TRIMMED
9972 - 2 13/16" TRIMMED



# SECTION VII - SILL FLASHING INSTALLATION

(cont.)

Cover the heads of all attachment screws with sealant.  
The flashing attachment screws are located in the opening of the back member.



**FIG. # 36**

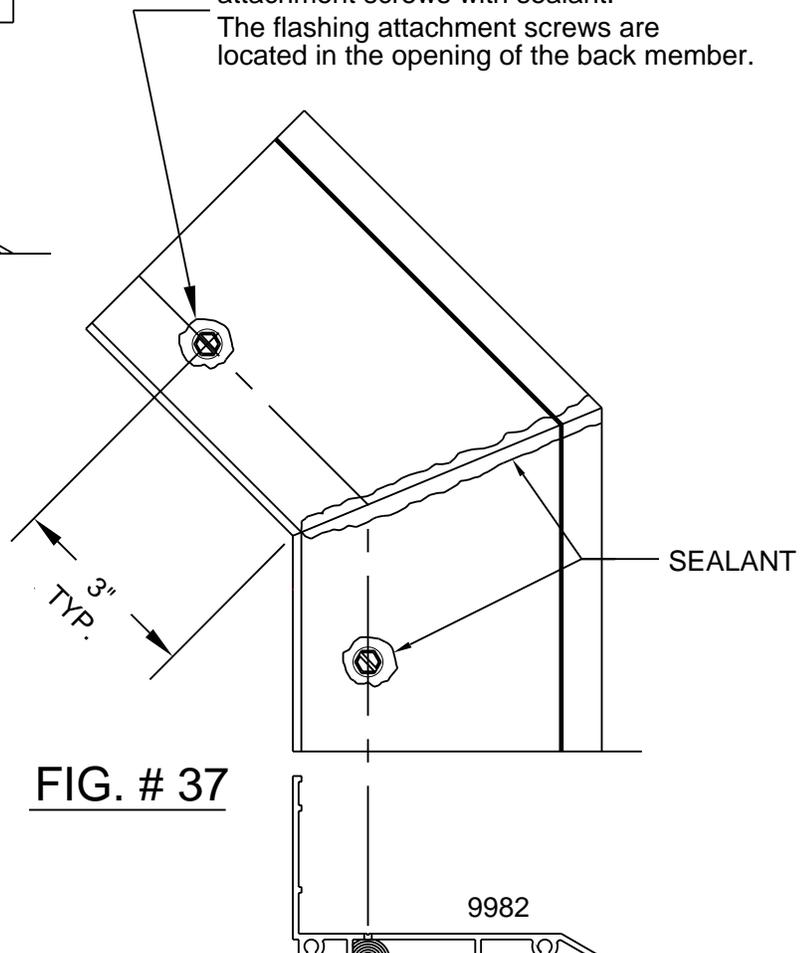
Before the fastener is inserted, force sealant into the hole for the sill perimeter fastener to ensure that the hole through the sill flashing is sealed.

When corners are required, miter the flashing to the required angle and install as shown in Fig. # 36 and # 37.

## SILL FLASHINGS AVAILABLE:

- 9972 - 1 9/16" B.M.
- 9982 - 2 9/16" B.M.
- 9668 - 4 1/16" B.M.
- 9974 - 4 13/16" B.M.

Cover the heads of all attachment screws with sealant.  
The flashing attachment screws are located in the opening of the back member.



**FIG. # 37**



# SECTION VIII A — SCREW SPLINE / SHEAR BLOCK INSTALLATION

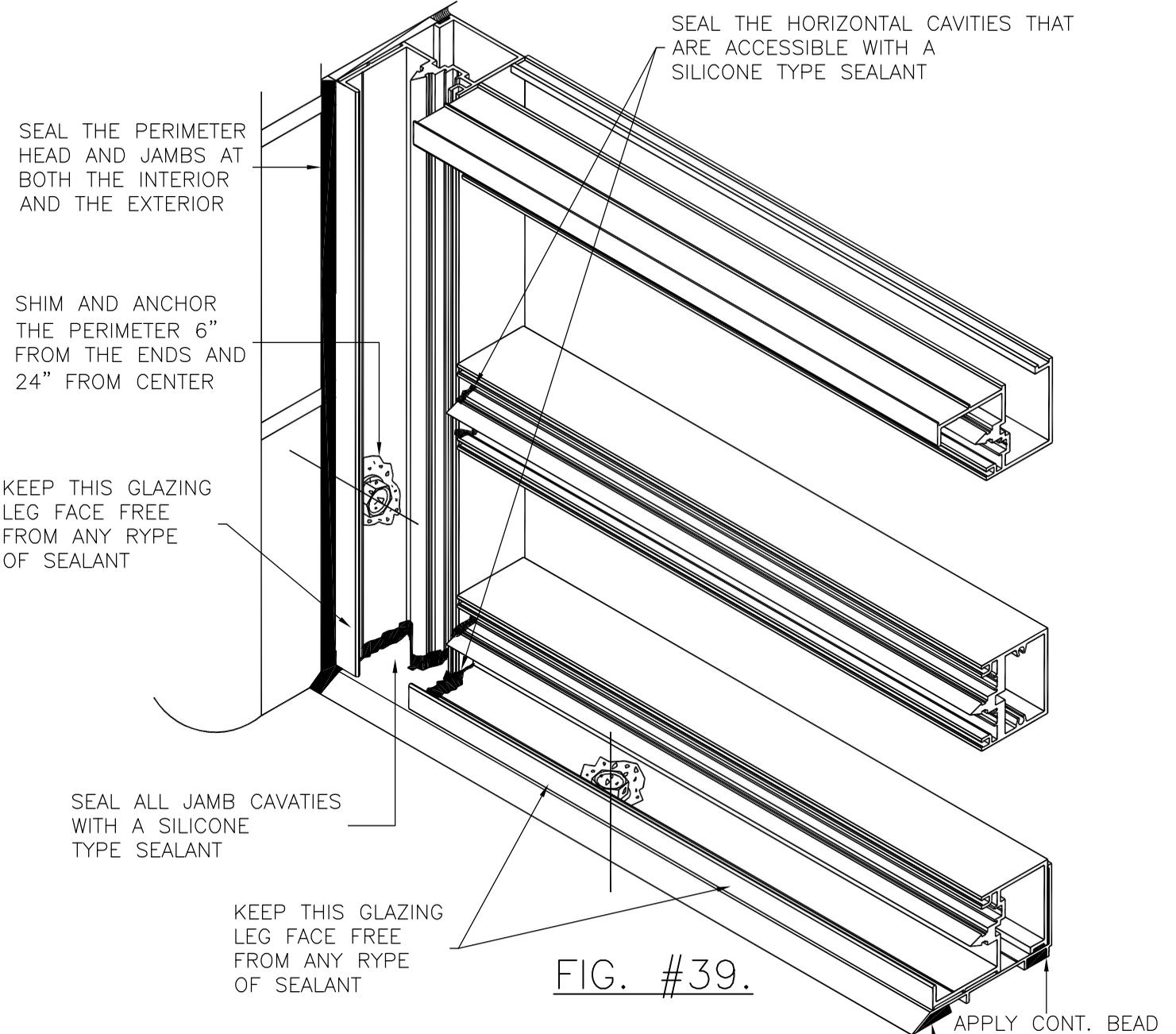
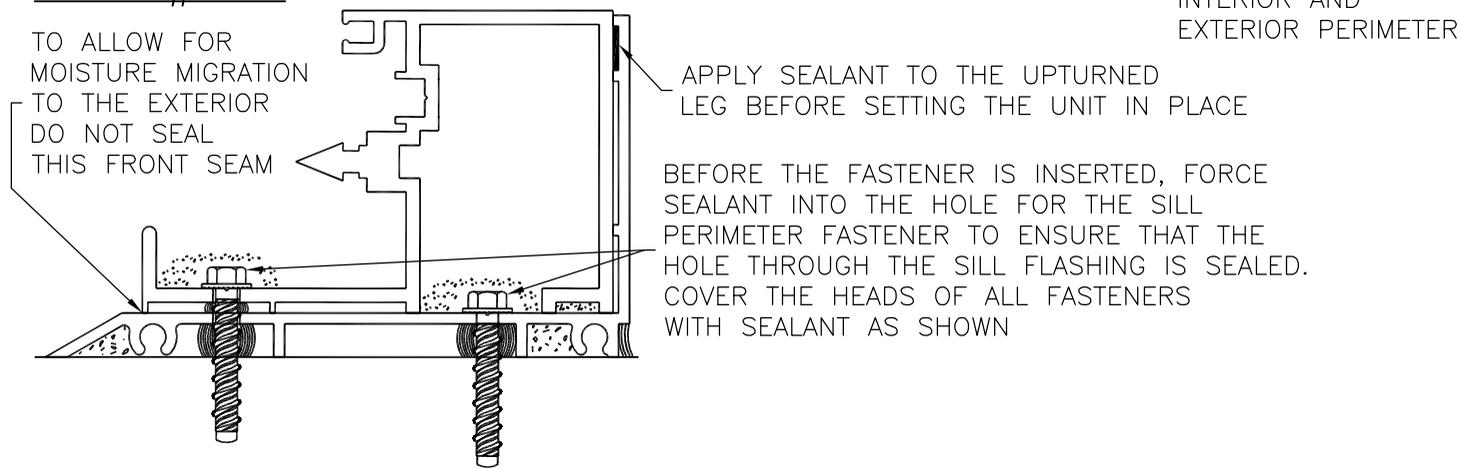


FIG. #39.

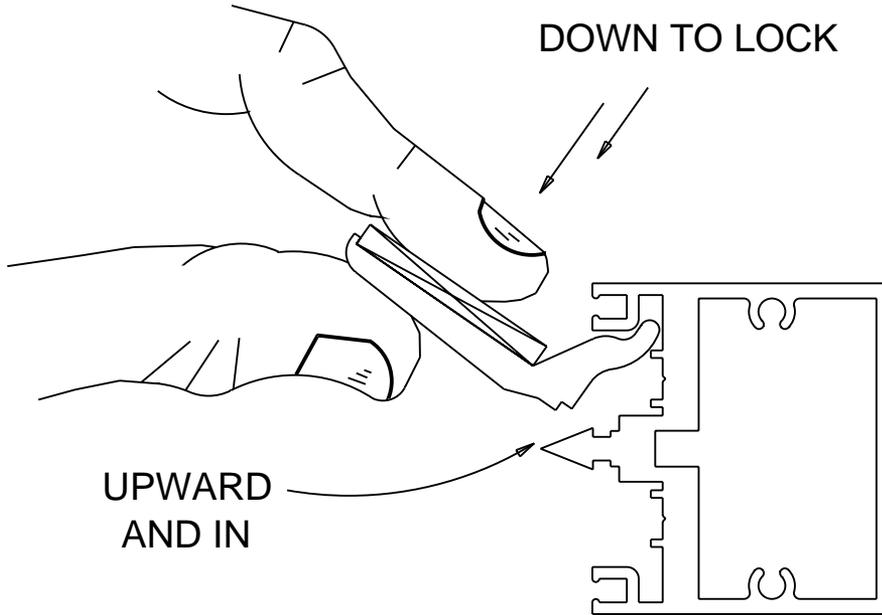
FIG. #40.



# SECTION VIII B - SCREW SPLINE / SHEAR BLOCK INSTALLATION

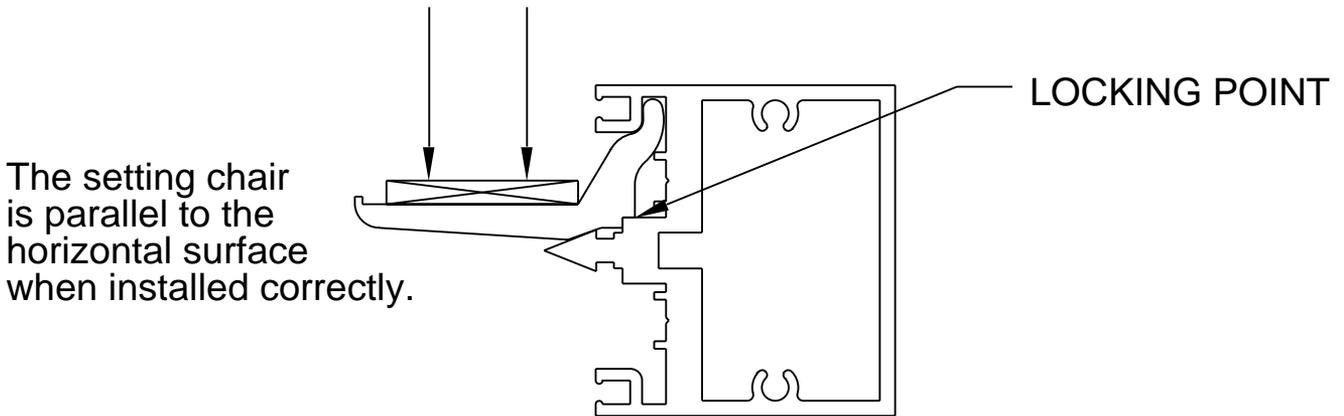
## GLASS SETTING CHAIR ASSEMBLY INSTALLATION

**STEP 1)** The glass setting chair/block can be installed by rotating upward and in, then push down to lock in place. See Fig. # 41 below.



**FIG. # 41**

**STEP 2)** To insure proper installation of the setting chair/block, press down until locked into position. See Fig. # 42 below.

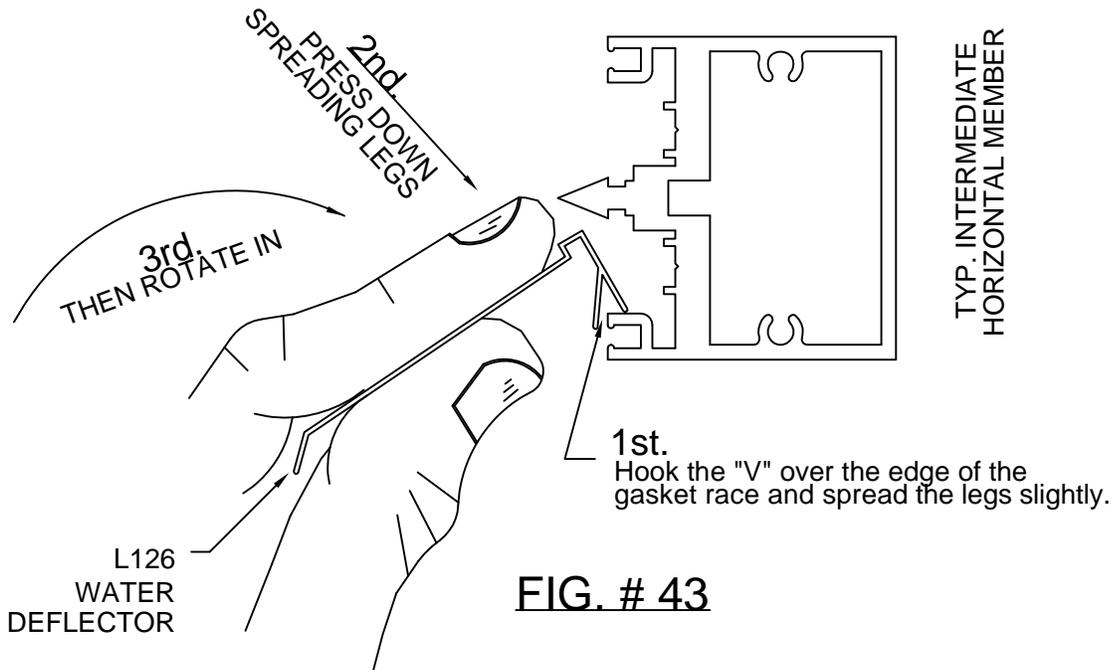


**FIG. # 42**

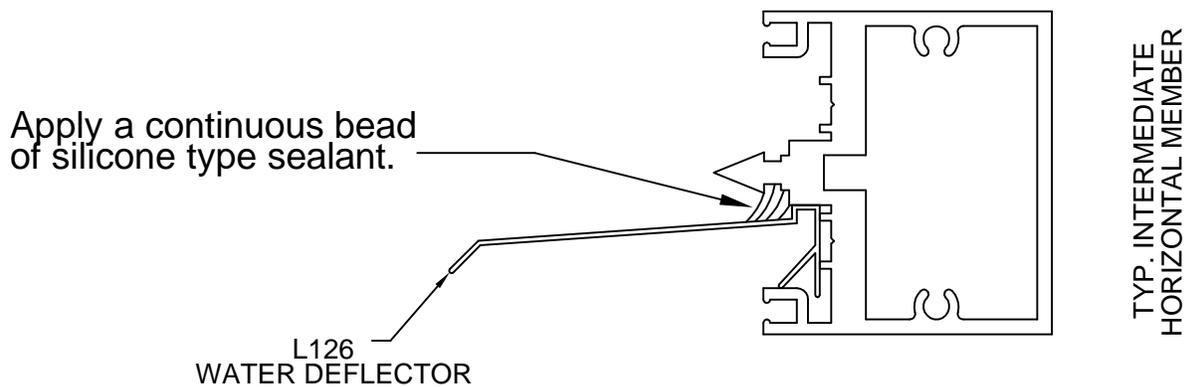
# SECTION VIII C - SCREW SPLINE / SHEAR BLOCK INSTALLATION

## INSTALLATION OF WATER DEFLECTOR AND SETTING CHAIR / BLOCK [1" Glazing]

**STEP 3)** With the exception of the head and sill, all intermediate horizontals must include a continuous water deflector to divert any water to the verticals or to the weep holes. See Fig. # 46 on page 48 for the deflector end notching.



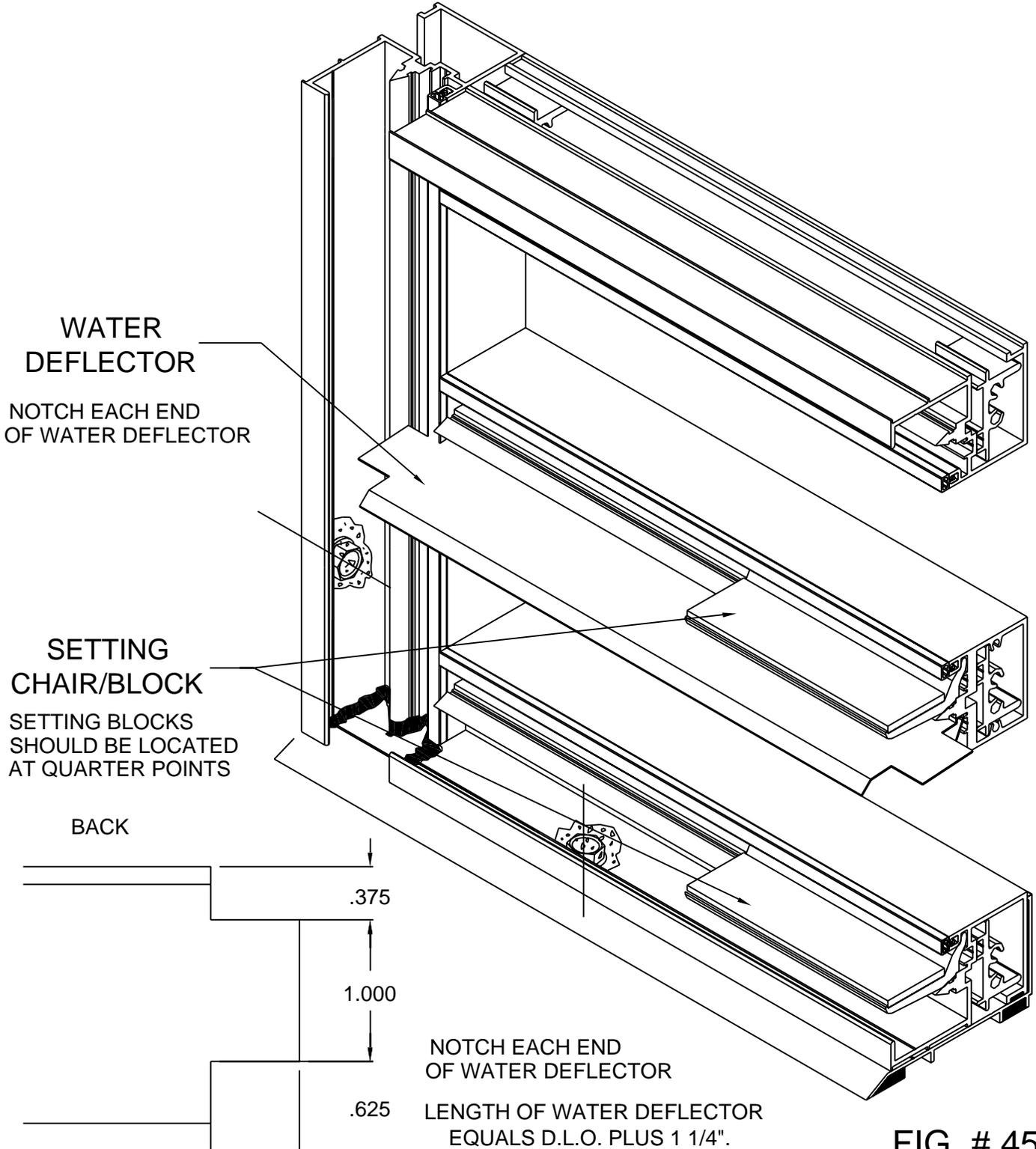
**STEP 4)** A silicone type sealant should be applied after the continuous water deflector is installed.



**FIG. # 44**

# SECTION VIII C - SCREW SPLINE / SHEAR BLOCK INSTALLATION CONT.

## INSTALLATION OF WATER DEFLECTOR AND SETTING CHAIR / BLOCK [1" Glazing]

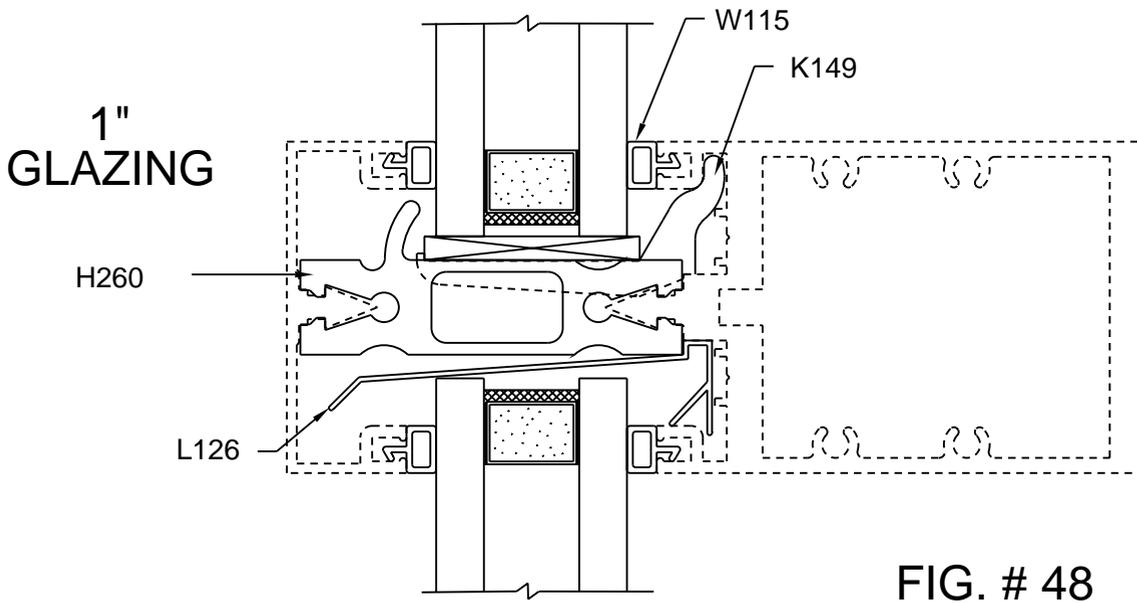
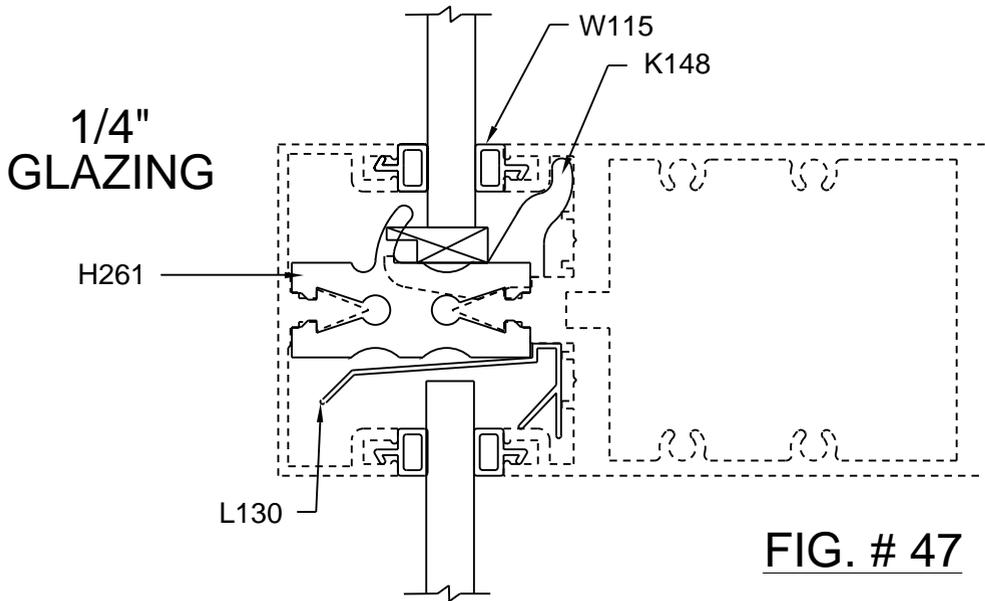


**FIG. # 46**

**FIG. # 45**

# SECTION VIII D - SCREW SPLINE / SHEAR BLOCK INSTALLATION

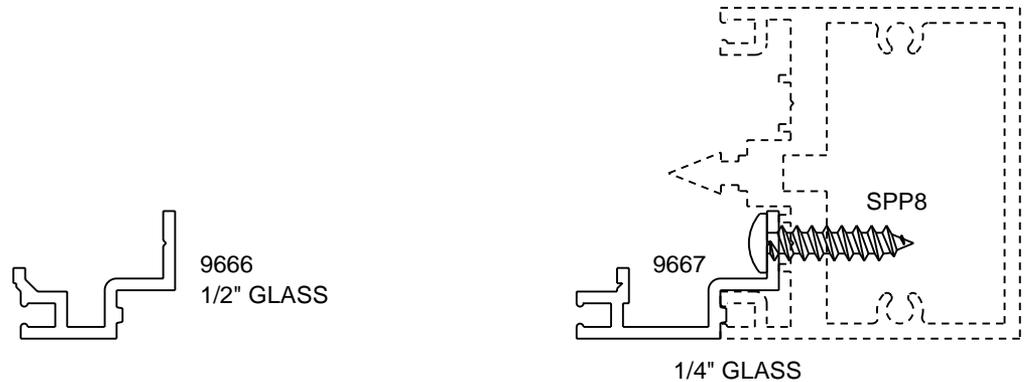
DETAILS SHOWING TYPICAL GLAZING CONDITIONS  
AND THE RELATIONSHIP OF PARTS TO EACH OTHER.



# SECTION VIII E - SCREW SPLINE / SHEAR BLOCK INSTALLATION

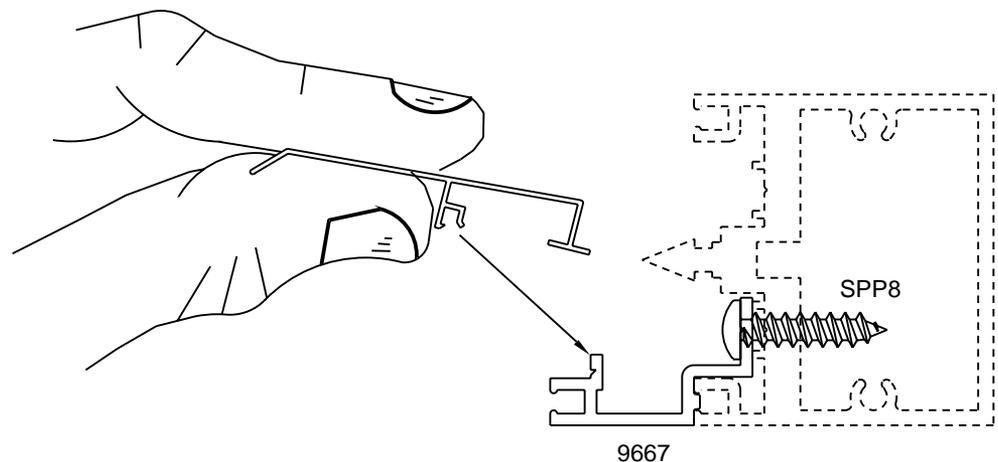
## 1/4" AND 1/2" GLAZING ADAPTORS w/ L129 WATER DEFLECTOR

**STEP 1)** Screw attach the glazing adaptor to the back mullion using the SPP8 screw, 3" from the end and 12" on center. Refer to Fig. # 49 below.



**FIG. # 49**

**STEP 2)** Set the water deflector's heel end first, then snap the outer leg onto the leg of the adaptor. Refer to Fig. # 50 below.



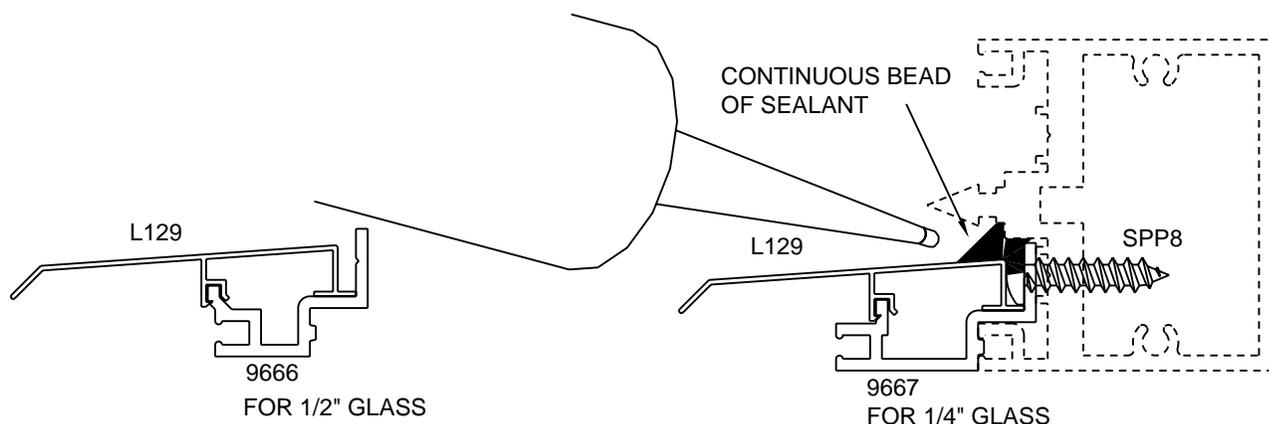
**FIG. # 50**

# SECTION VIII E - SCREW SPLINE / SHEAR BLOCK INSTALLATION

CONT.

## 1/4" AND 1/2" GLAZING ADAPTORS w/ L129 WATER DEFLECTOR

- STEP 3)** Apply a bead of sealant across the length of the deflector, and across the bulb gasket, and the end of the deflector at the vertical member's pocket. Refer to Fig. # 51 below and to Fig. #53 on page 52.

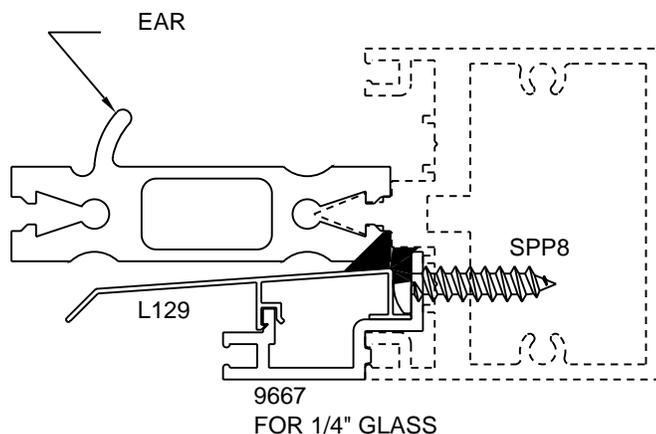


**FIG. # 51**

- STEP 4)** The clips H260 or H261 should be installed as soon as possible before the sealant from step # 3 can setup. Care should be taken to not disengage the water deflector when setting the glass unit below.

### NOTE AT HORIZONTAL INTERMEDIATES ONLY:

The clips H260 or H261 need to be installed with the 'ear' up as shown to accommodate setting the lower glass unit.

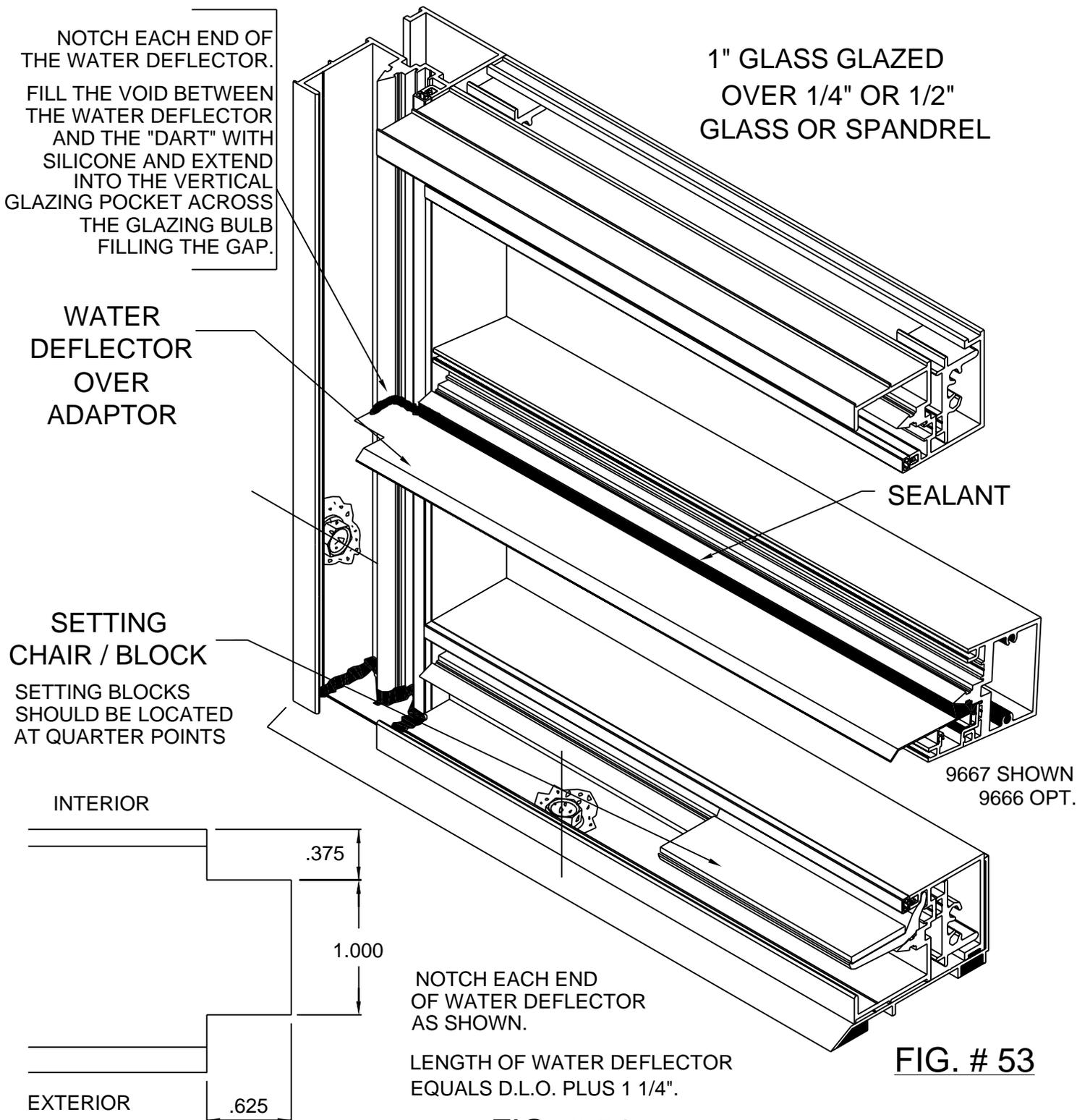


**FIG. # 52**

# SECTION VIII E - SCREW SPLINE / SHEAR BLOCK

CONT.

## INSTALLATION OF WATER DEFLECTOR, 1/4" AND 1/2" GLAZING ADAPTORS



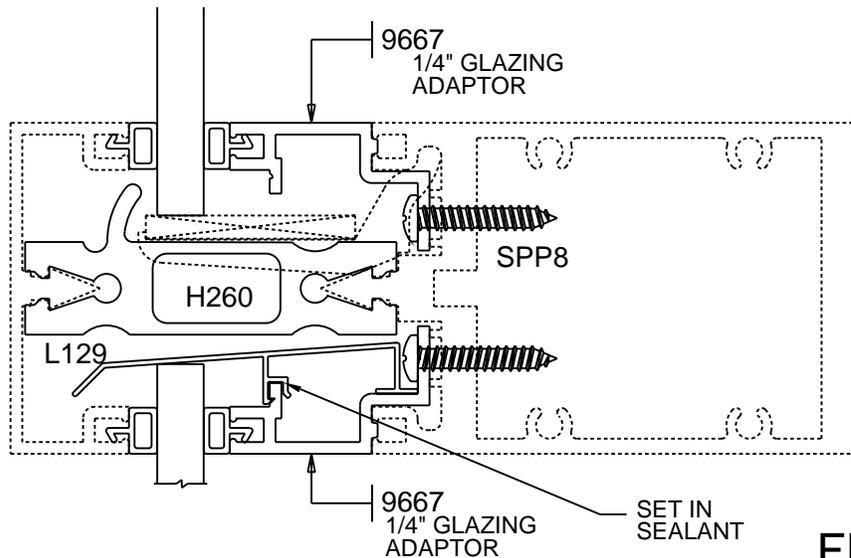
**FIG. # 53**

**FIG. # 54**

# SECTION VIII F - SCREW SPLINE / SHEAR BLOCK INSTALLATION

DETAILS SHOWING THE RELATIONSHIP OF THE GLAZING ADAPTORS AND OTHER PARTS AT HORIZONTAL INTERMEDIATES

1/4" ADAPTOR  
(FOR 1" GLAZED SYSTEM)

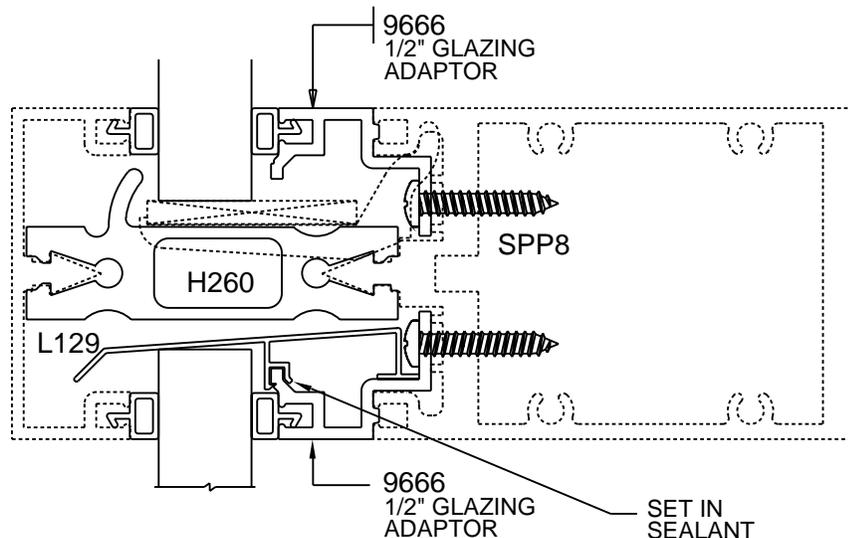


**FIG. # 55**

Elevations without horizontal intermediates may use #9649 1/4" glazing adaptor throughout as an alternate to the #9667 adaptor. The glazing adaptors with a water deflector locating leg must be used with a horizontal intermediate.

See page 52 for the notching of # 9667 and # 9666 glazing adaptors for setting chair clearance.

1/2" ADAPTOR  
(FOR 1" GLAZED SYSTEM)



**FIG. # 56**

# SECTION VIII F - SCREW SPLINE / SHEAR BLOCK INSTALLATION

CONT.

## DETAILS SHOWING THE RELATIONSHIP OF THE GLAZING ADAPTORS AND OTHER PARTS AT THE SILL

1/4" ADAPTOR  
(FOR 1" GLAZED  
SYSTEM)

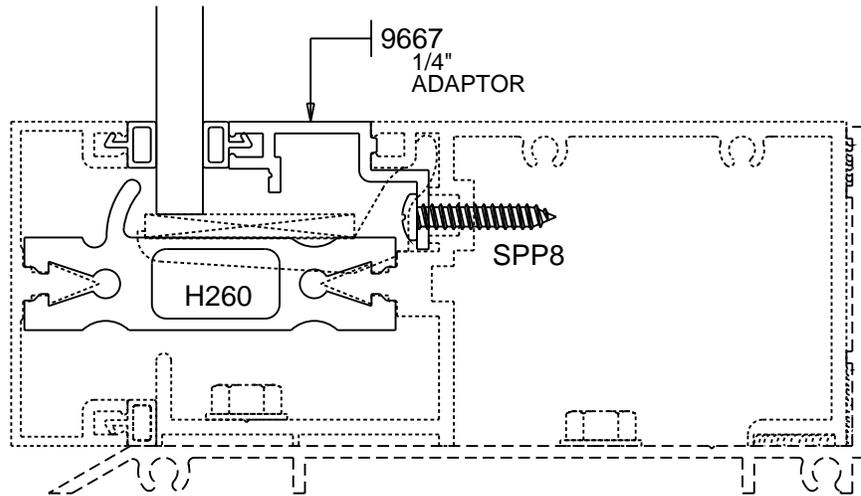


FIG. # 57

See page 52 for the notching of  
# 9667 and # 9666 glazing adaptors for  
setting chair clearance.

1/2" ADAPTOR  
(FOR 1" GLAZED  
SYSTEM)

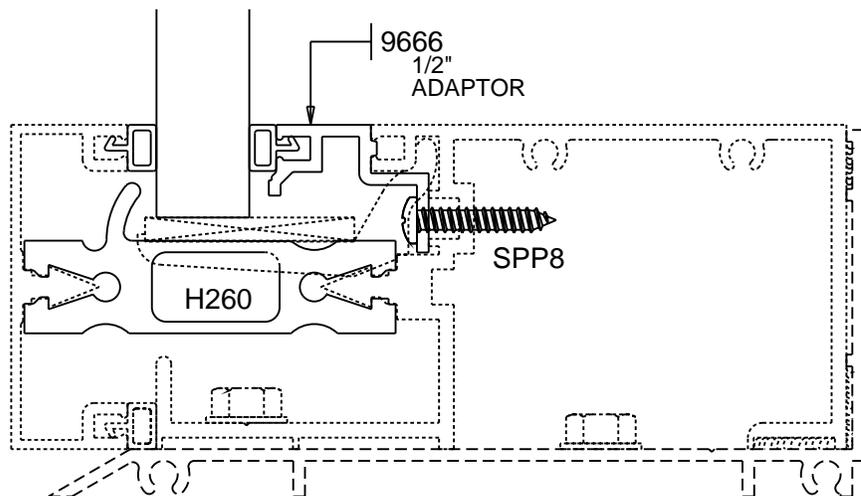
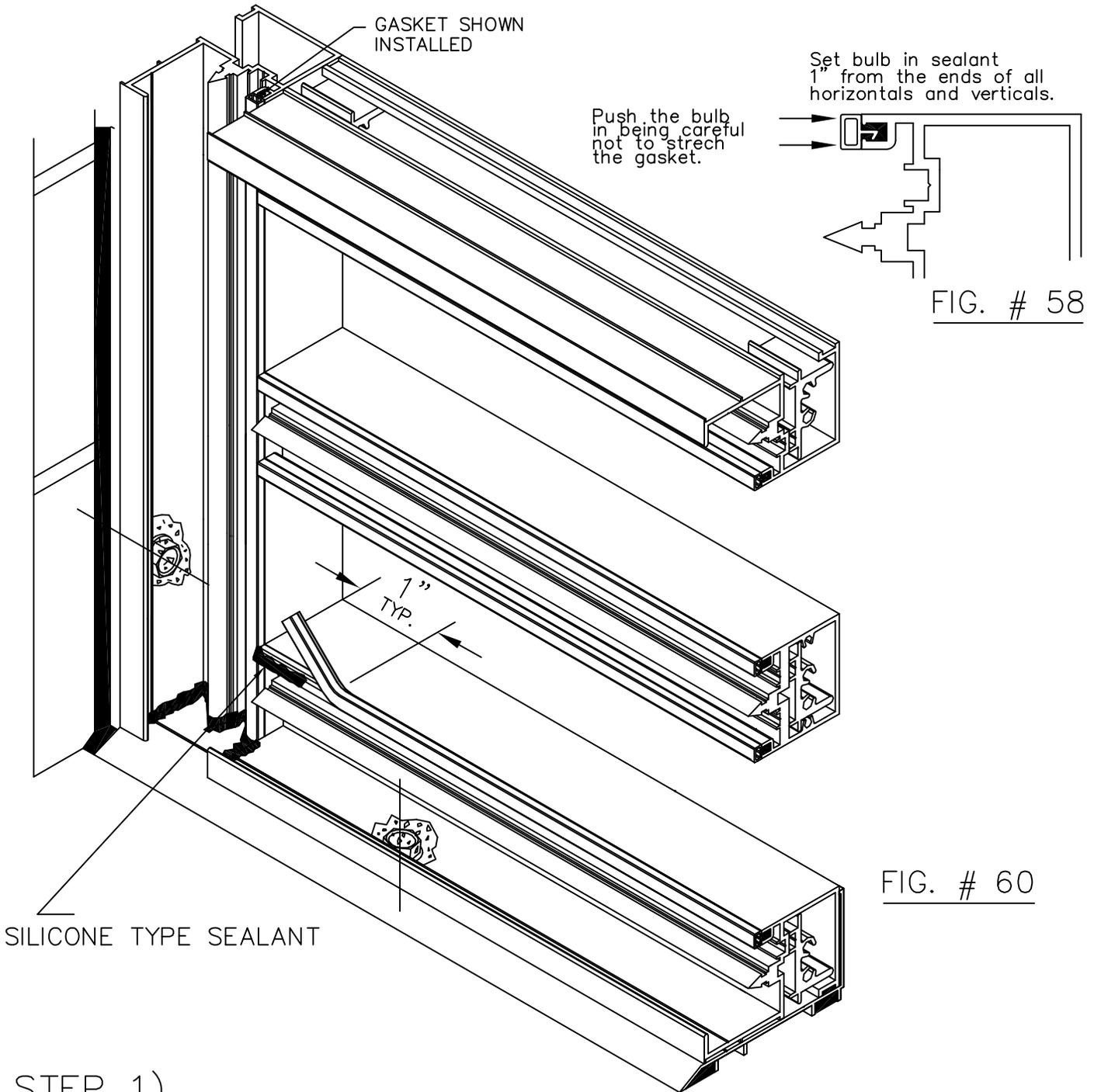


FIG. # 58

SECTION VIII G — SCREW SPLINE / SHEAR BLOCK  
BULB GASKET INSTALLATION

STEP 1)

Push in all VERTICAL glazing gasket, being careful not to stretch the gasket. Apply sealant in the glazing bulb cavity 1" from the ends, and push the bulb gasket into the sealant. Refer to the figures below.



STEP 1)

Push in all HORIZONTAL glazing gasket, being careful not to stretch the gasket. Apply sealant in the glazing bulb cavity 1" from the ends, and push the bulb gasket into the sealant. Refer to the figures above.

# SECTION VIII H - SCREW SPLINE / SHEAR BLOCK INSTALLATION

## SYSTEM II WINDOW ADAPTOR FOR PROJECT OUT, PROJECT IN, AND CASEMENTS

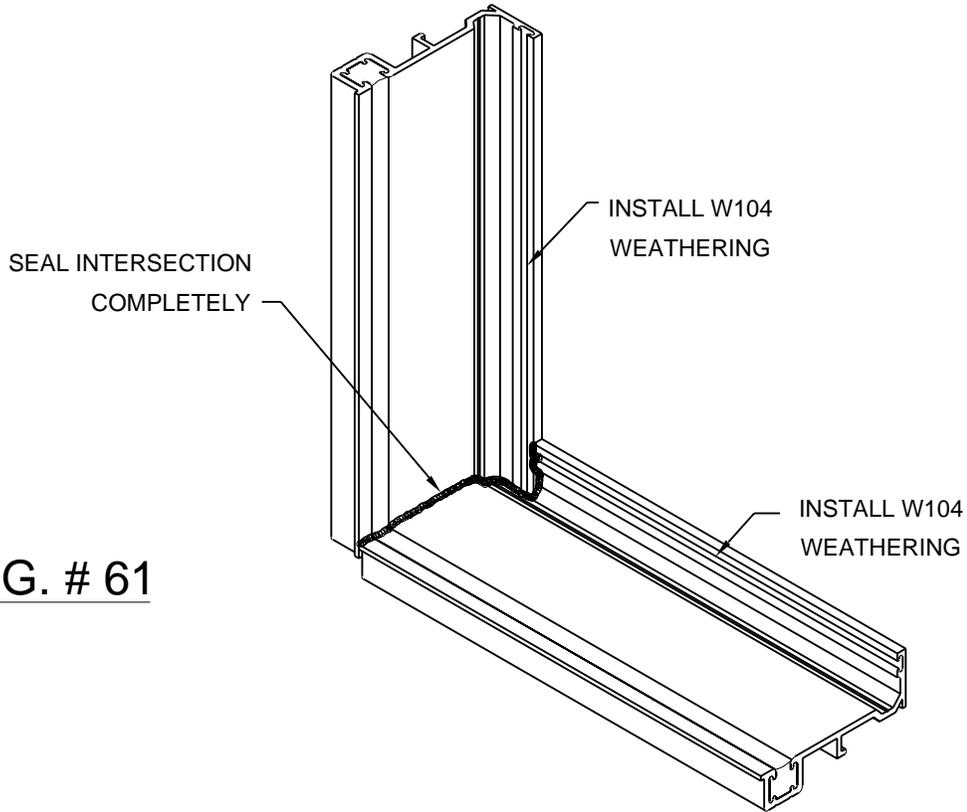


FIG. # 61

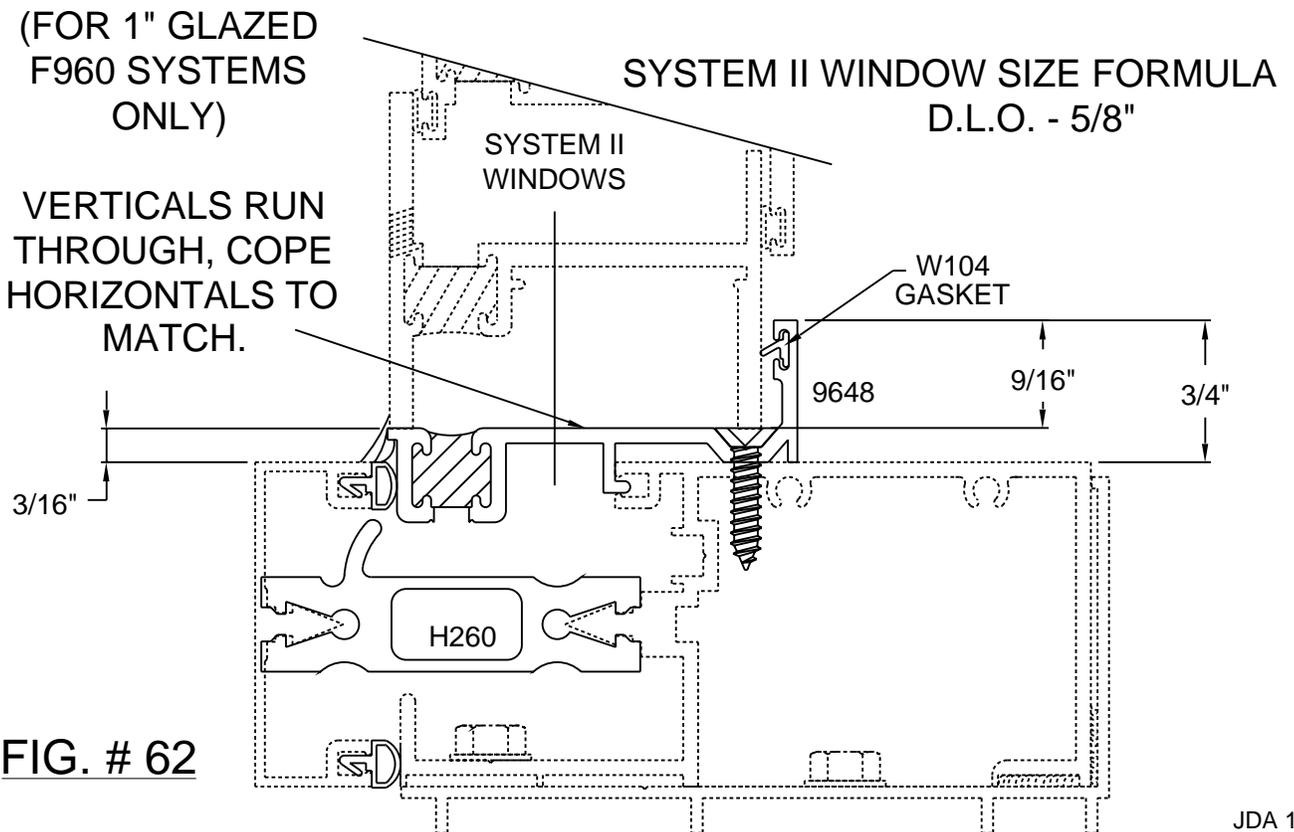


FIG. # 62

## SECTION IX - STRUCTURAL SILICONE GLAZED MULLION

- STEP 1)** Cut the S.S.G. mullion to frame D.L.O. and screw spline attach the mullion to the perimeter members using the S108 screw spline screws. See page 59.  
Set the assembled unit in place on the sill flashing, and anchor as directed previously. Refer to Section VIII.
- STEP 2)** Install the butt glaze spacer tape to the butt glaze mullion as shown in Fig. #63 on page 58. The spacer tape will run the full length of the vertical butt glaze mullion. Peel back ONLY 2" of the exterior film of the spacer tape at the head or the sill. DO NOT remove all of the exterior film until the glass unit is installed and positioned correctly.
- STEP 3)** Install the setting chairs at 1/4 points in the sill members. Set the glass units in place and install (2) glazing clips side by side 3" from the vertical mullion and a single clip at 9" on center from the pair, at the head and sill. Be sure the 'ears' of the clips are toward the glass unit at the head and sill, and jambs. Also, it must be facing up at the horizontal intermediates. Refer to page 61.
- STEP 4)** Set the glass unit and position it with the correct glass bite all around.
- NOTE:** Review the 'temporary' glazing procedure presented on page 62, and apply these steps accordingly, if required. If incorporating this procedure, set the temporary glazing covers, leaving access to the vertical glass edges for the application of the structural silicone at the vertical butt glaze mullion.
- STEP 5)** Peel off the exterior film of the butt glaze spacer tape and press the glass onto the spacer tape. Install the 12" temporary cover pieces at the head and sill to hold the glass units while the interior silicone is applied. Refer to page 59.
- STEP 6)** Repeat the previous steps at other butt glaze mullions in the elevation.

# SECTION IX - STRUCTURAL SILICONE GLAZED MULLION

CONT.

- STEP 7)** Install the interior structural silicone to the glass/spacer tape/mullion, as shown below. This step will require an overnight cure.
- STEP 8)** The next day remove the temporary covers and replace any clips that are broken in this process.
- STEP 9)** Install the exterior structural silicone to the glass joint. Clean any excess sealant from the glass surface, presenting a clean professional appearance. This step will also require an overnight cure for the silicone.
- STEP 10)** Install the W115 bulb gasket in the full length covers, allowing approximately 2% extra per length, to minimize gasket shrinkage. Install the full length covers at the head, sill, and jambs.

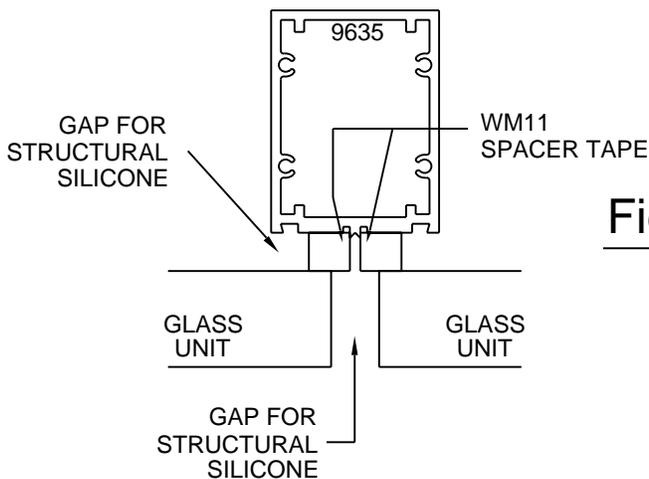
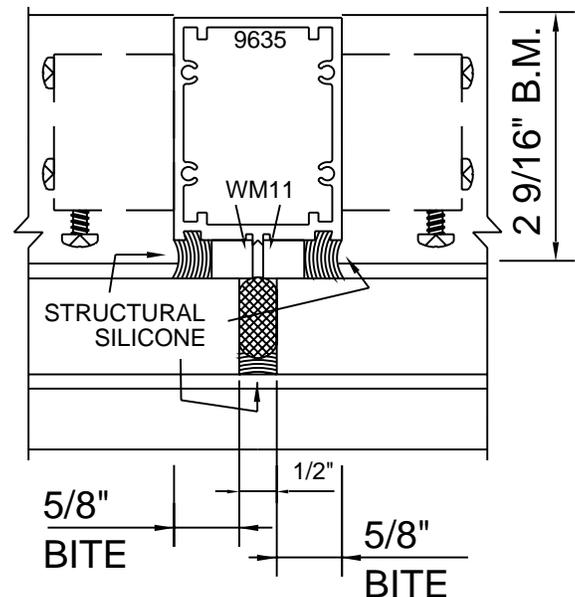


Fig. # 63

H260 CLIP - 1" GLAZING  
H261 CLIP - 1/4" GLAZING

Fig. # 64



# SECTION IX -

# STRUCTURAL SILICONE GLAZED MULLION

CONT.

## ASSEMBLY PROCEDURE FOR STRUCTURAL SILICONE GLAZED VERTICAL MULLIONS

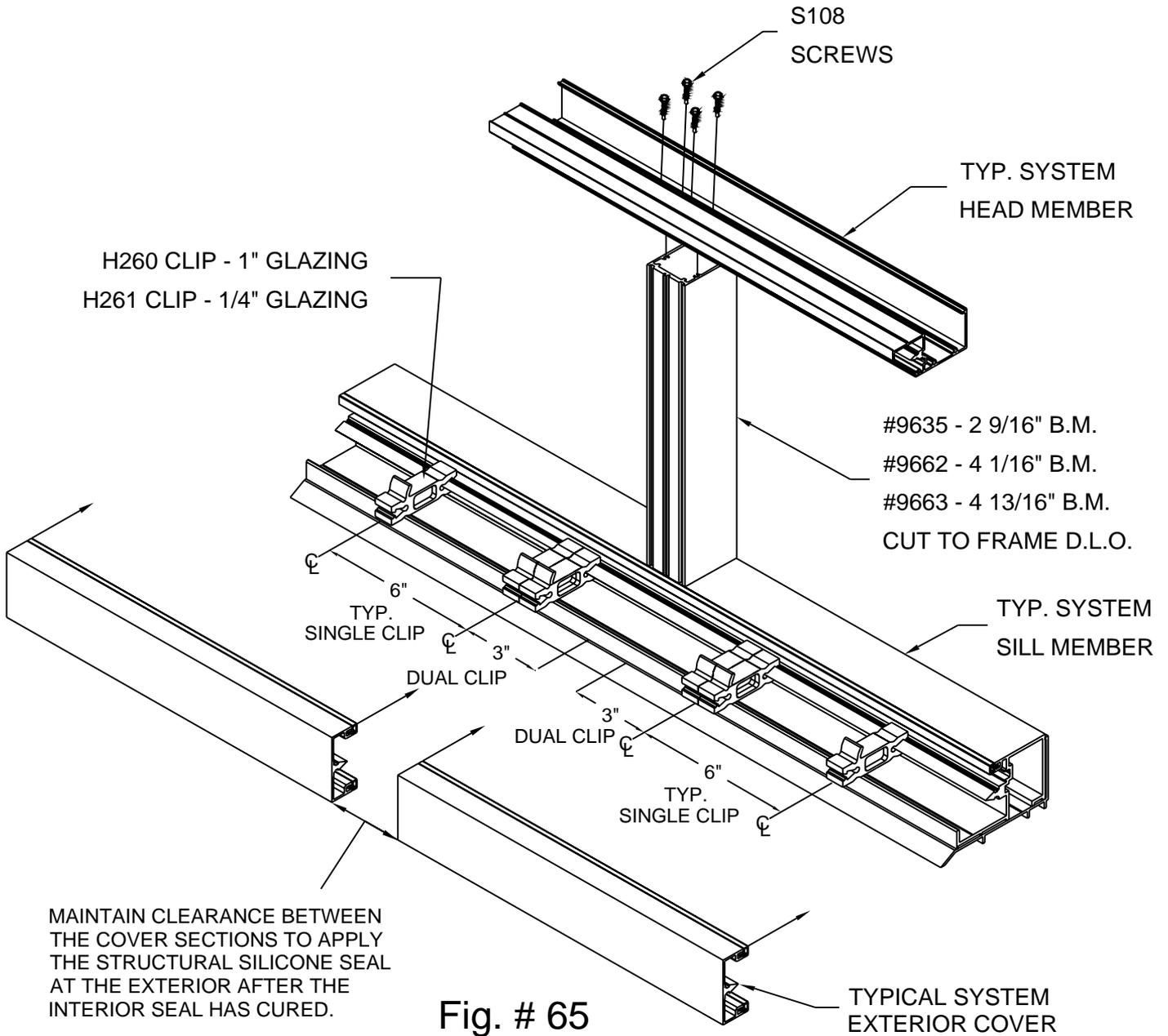


Fig. # 65

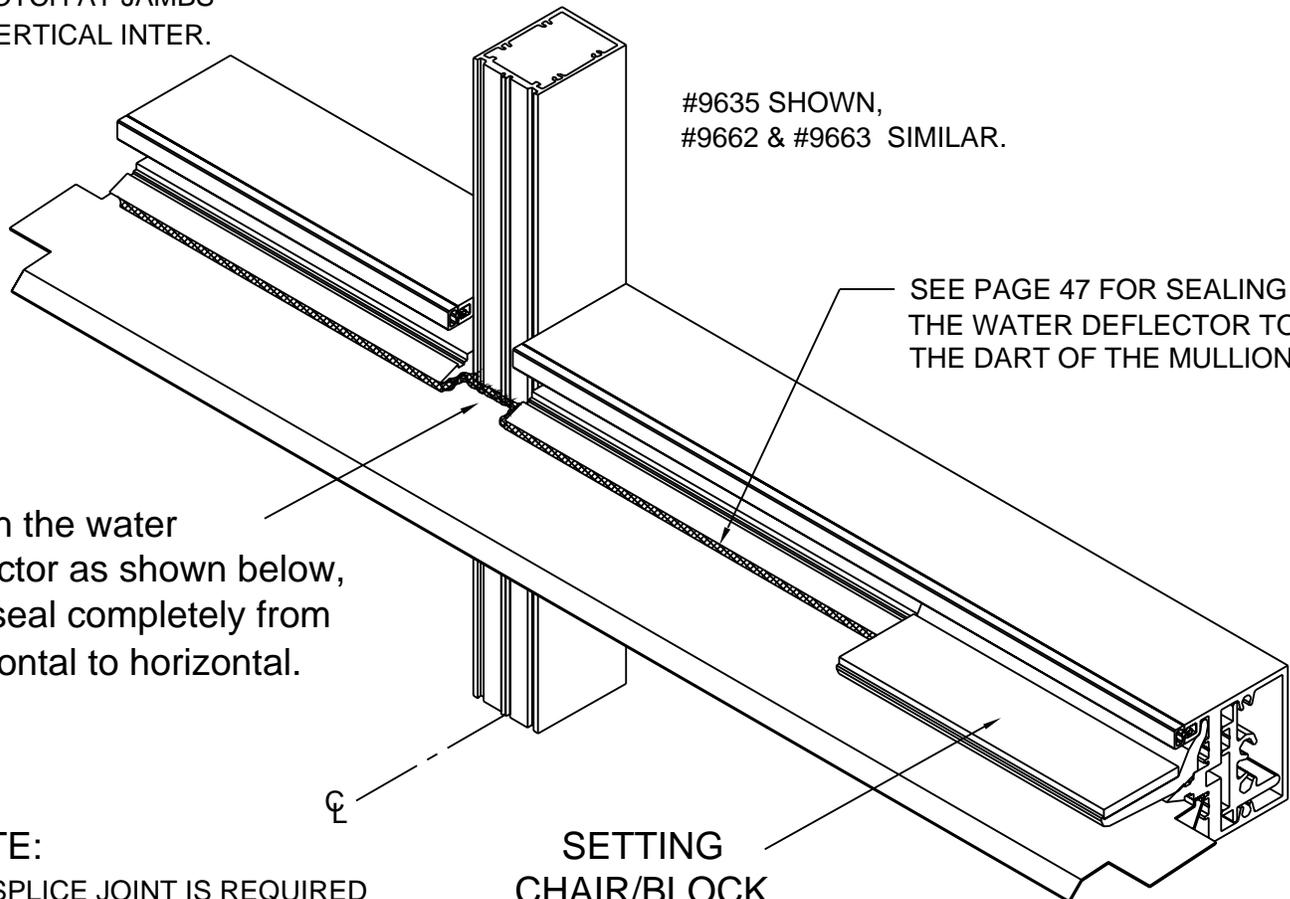
CLIPS & COVERS NOT SHOWN AT THE  
HEAD FOR CLARITY.

# SECTION IX - STRUCTURAL SILICONE GLAZED MULLION

CONT.

## INSTALLATION OF THE WATER DEFLECTOR AT A S.S.G. MULLION THE WATER DEFLECTOR RUNS THROUGH AT THE MULLION.

SEE PAGE 48 FOR  
END NOTCH AT JAMBS  
AND VERTICAL INTER.



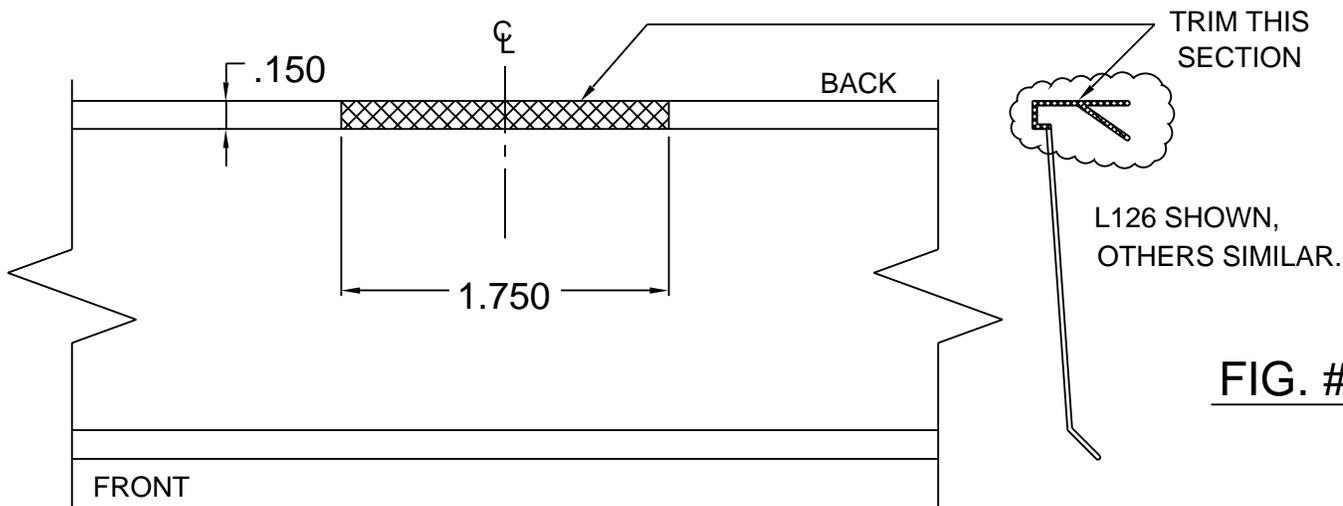
Notch the water deflector as shown below, and seal completely from horizontal to horizontal.

**NOTE:**

IF A SPLICE JOINT IS REQUIRED  
LOCATE IT 6" AWAY FROM THE  
S.S.G. MULLION AND SEAL  
THE ENDS COMPLETELY.

**SETTING  
CHAIR/BLOCK**  
SETTING BLOCKS  
SHOULD BE LOCATED  
AT QUARTER POINTS

**FIG. # 66**



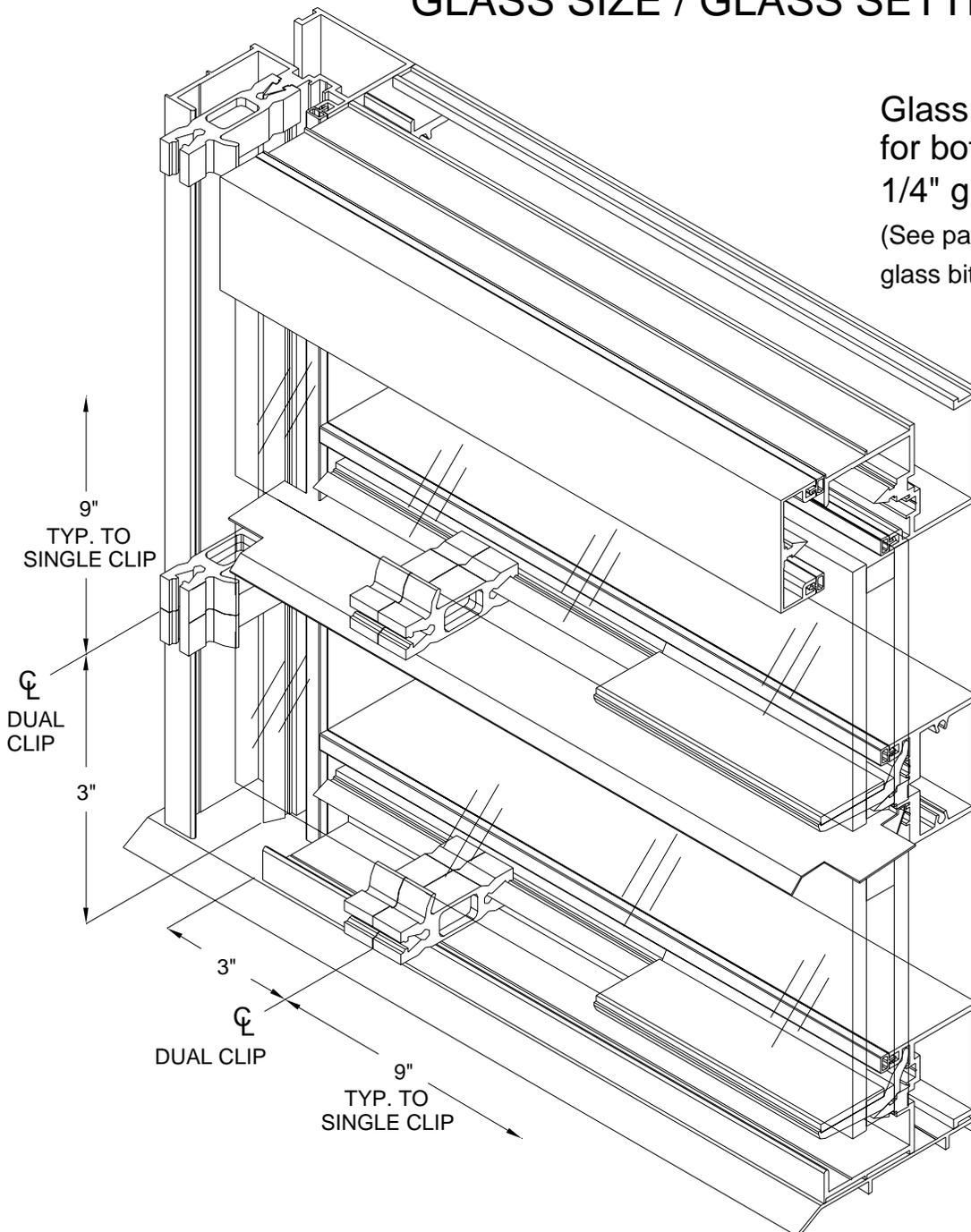
**FIG. # 67**

# SECTION X A - GLAZING

## GLASS SIZE / GLASS SETTING

Glass size = D.L.O. + 1"  
for both 1" glazing and  
1/4" glazing systems.

(See page 59 for butt glaze mullion  
glass bite requirements.)



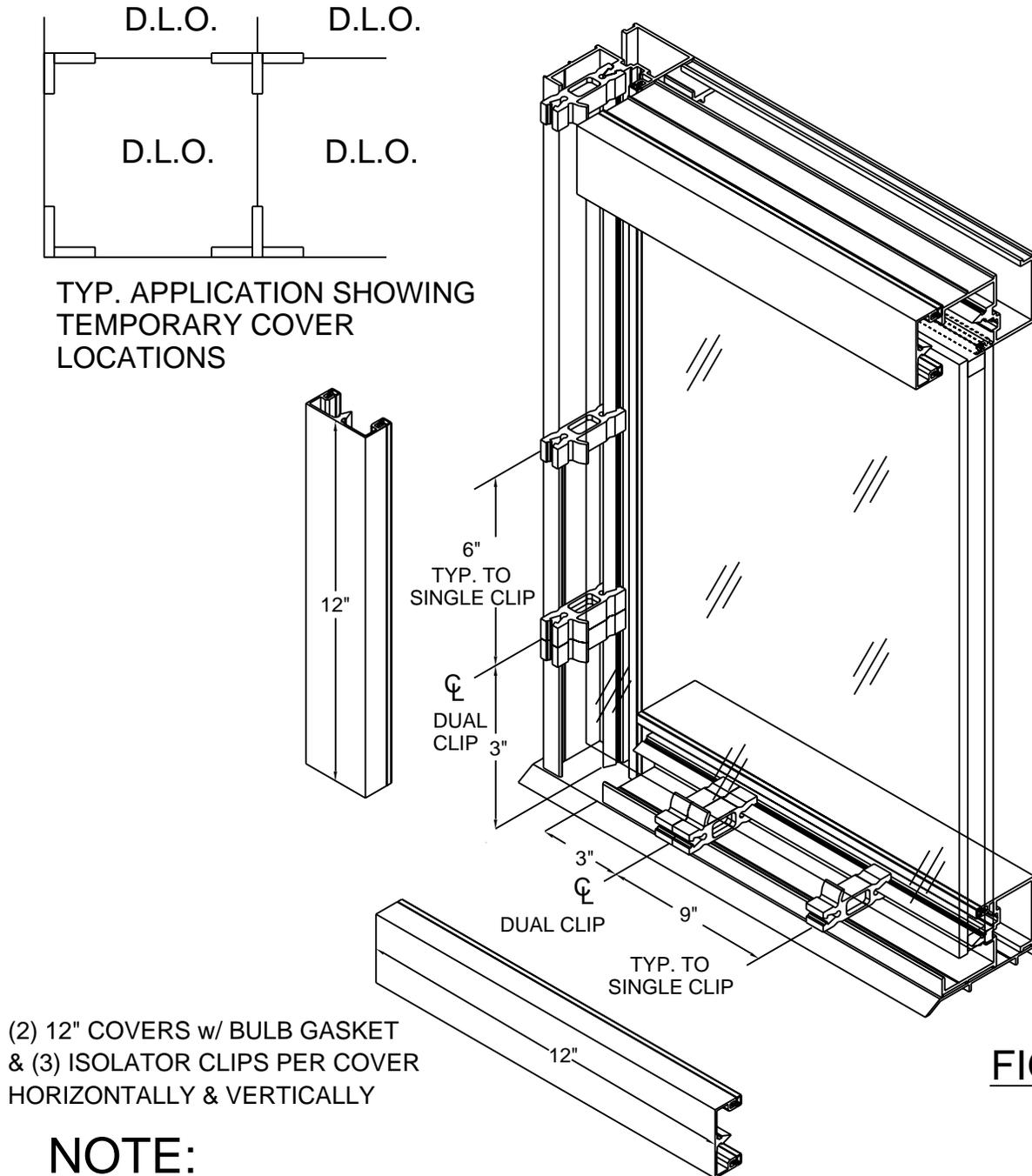
Be sure the "ears"  
of the clips face  
toward the glass  
at the head, jamb,  
and sill. Also, up  
at the horizontal  
intermediates.

**FIG. # 68**

**STEP 1)** The glass must be installed prior to the installation of the remaining isolator clips. After the glass is installed and properly positioned in the opening, locate and install the isolator clips as shown in figure # 68 above. The isolator clips are located: side by side pairs, 3" from each vertical or horizontal intersection and single clips 9" on center.

**NOTE:** The isolator clips alone are not suitable for temporary glazing. At no time should set glass or panels be left unattended with only the isolator clips holding the units in place. Prompt installation of the snap covers is required to obtain the full structural capability of the system. If temporary glazing is required, please refer to the Temporary Glazing instructions on pages 62 and 63.

# SECTION X B - TEMPORARY GLAZING USING CLIPS & COVERS



**FIG. # 69**

## NOTE:

If temporary glazing is required, EFCO recommends the use of (2) 12" lengths of the snap cover and (3) clips min. per cover piece, snapped in place as shown above, at the corners of the horizontals and verticals to retain the glass until the full length covers can be installed. This temporary clipping should be installed at every corner of each daylight opening resulting in 8 pieces of snap cover per daylight opening. This is a temporary application only and is not to be used for a structural application. This system will not meet structural performances until full length covers and the required quantity of clips have been installed.

# SECTION X C - TEMPORARY GLAZING

## FOR STRUCTURAL BUTT GLAZED SYSTEMS USING CLIPS AND COVERS

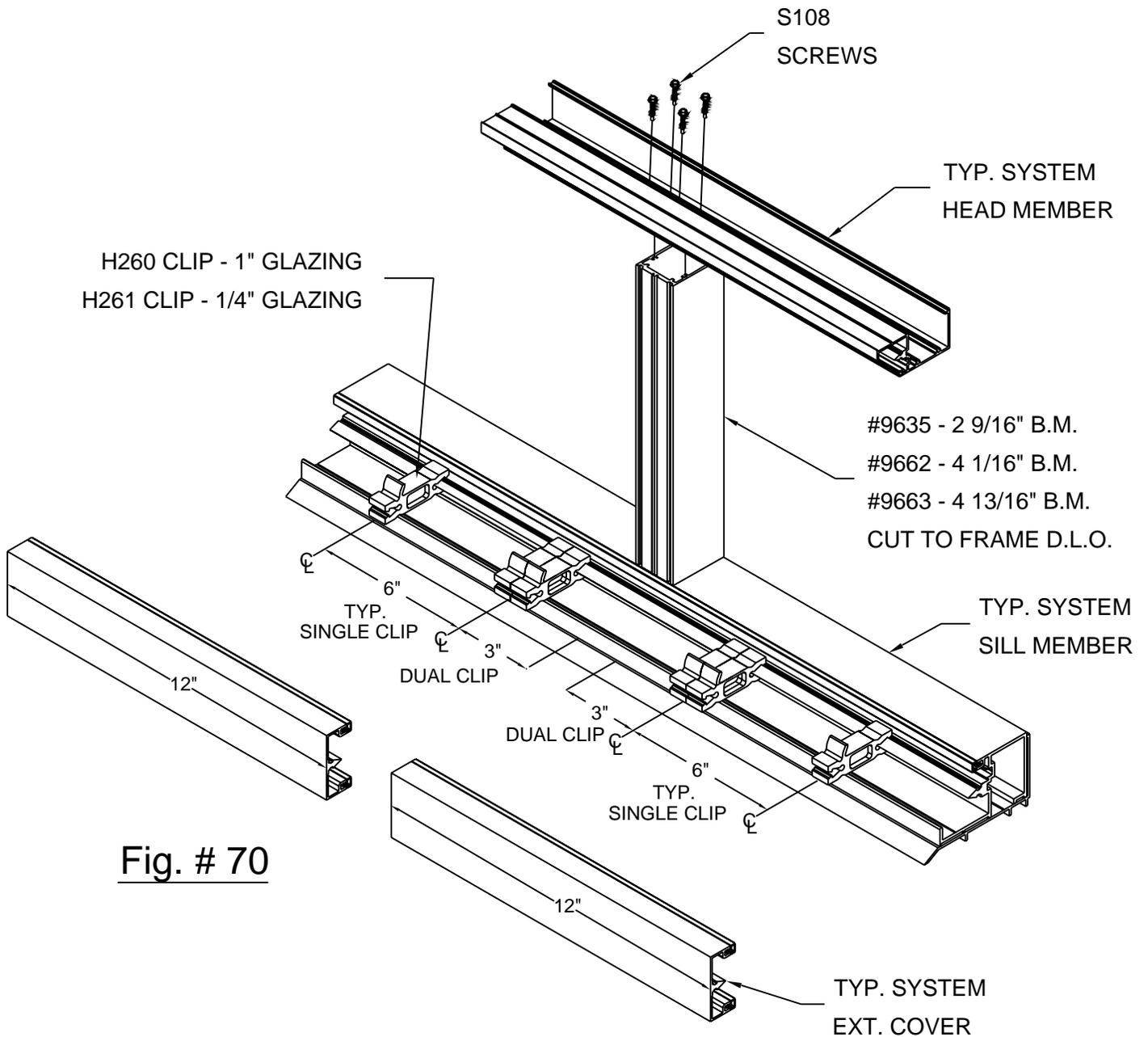


Fig. # 70

CLIPS & COVERS NOT SHOWN AT THE  
HEAD FOR CLARITY, BUT THEY MUST BE USED.