



















PO Box 128 | 504 Highway 63 South | Freeburg, MO 65035 | 800-347-0438 | 573-469-4151 (fax)

Installation Guidelines for all Vinyl Quaker products with 2” structural field mull

Read these instructions completely before starting any installation. Failure to install and maintain our product according to these instructions may void any product warranty. Please visit our website at www.quakerwindows.com or call 1-800-347-0438 for additional information.

<u>Tools required by installer:</u>	<u>Materials required by installer:</u>	<u>Quaker supplied parts:</u>
Safety Glasses 	Fasteners 	2” structural Mullion (M22784) 
Utility Knife 	Sealant 	Mull Cap (M22967, JX-Anchor) (M22941, X-Anchor) 
Drill/Driver 	Flashing Tape 	2” Mull Key (D315) 
Caulk Gun 	IPA Alcohol 	Jamb Filler (1111) 
Rubber Mallet 	Backing Rod 	Drip Cap (D313) 
Tape Measure 		

WARNING

Tools

- Follow manufacturer’s instructions for safe operation of tools, and ladders/scaffolding. Always wear safety glasses. Failure to do so could result in injury, product or property damage.

Handling

- Do not store units outside, or in a hot environment. Doing so could result in product damage.
- Do not carry flat.** Doing so could result in product damage, injury, or property damage.
- Stack units as straight as possible to avoid bowing. **Do not lay flat!**

Glass

- If broken, glass can fragment causing injury. All Quaker products are available with safety glass. In many areas, local building codes require safety glass in certain locations and/or applications. Unless safety glass is ordered, Quaker windows are not provided with safety glass. Before ordering, consult your local building codes for more definitive information.

Fastening

- Metal fasteners and components could corrode when used with preservative-treated lumber. Use approved fasteners and components to fasten window or door. Failure to do so could cause a failure resulting in injury, product or property damage.
- Fastener must attach to a structural framing member with 1 1/2” minimum fastener embedment, or minimum 3 full threads with a minimum 5/16” head as products were tested with.
- Quaker does not supply anchorage/fastener calculations, and is not responsible for determining structural adequacy of the anchorage and fasteners used to install our products, or the openings into which they are installed.**
- Do not** over drive screws or nails. Doing so could result in product damage.

CAUTION**Installation**

- Always support window or door in opening until fully fastened. Failure to do so could result in the window or door falling out or causing injury, product, or property damage.
- Nailing flanges and drip caps (integral or applied) **do not** take the place of window flashing. All windows and doors must be properly flashed and sealed with material compatible sealant for protection against water and air infiltration around the entire perimeter. Failure to do so could result in product or property damage.
- **Do not** set window directly on sill plate. Place shims under the side jambs. Window or door must be properly shimmed. Failure to do so could affect operation and product performance and could result in product damage.
- Live or dead loads transferred into our product can affect functionality, damage frame joinery or cause glass failures. Dead loads such as upper levels, roof, etc. Should be constructed before window or door is installed.
- Loads shall be designed to withstand the most critical effects of load factors and load combinations as required by the building code. (Loads are including but not limited to Live, Dead, Collateral, Auxiliary, Thermally induced, Seismic, etc.)
- Maximum vertical deflection of the header under all Load combination should not exceed the Span/720 or 1/4" whichever is less.
- Windows and doors have small parts. Small parts if swallowed could pose a choking hazard to young children. Dispose of unused, loose, or easily removed small parts. Failure to do so could result in injury.
- **Do not** drill through or into window sill to install alarm wires.

Sealing

- Follow instructions of foam, sealant, and flashing manufacturers regarding safety, material application, compatibility, and periodic maintenance for continued weather resistance of their products. Failure to do so could result in product or property damage. **DO NOT** overfill between the frame and opening.
- Minimally expanding foam insulation must be compliant with AAMA 812-19.
- Quaker recommends 100% silicone (ASTM C920 compliant) neutral cure only sealant. Always clean all areas where sealant will be applied. Failure to do so could result in product or property damage.
- Flashing tape must meet ASTM-D779 performance requirements.
- Maintain a minimum of 1/4" between the window or door frame and exterior finish materials. Failure to do so could result in product or property damage.

Joining

- Do not join any window or door to any window or door not designed for joining. Joined windows and doors must be individually supported in the opening. Failure to do so could affect operation and product performance and could result in product or property damage.

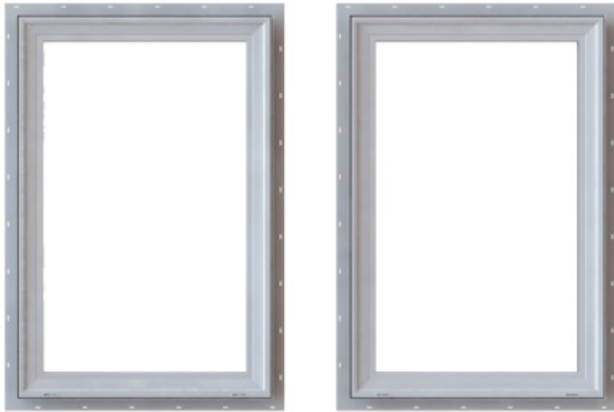
Cleaning

- Acid solutions used for cleaning will damage glass, fasteners, hardware, and metal flashing. Protect these products and follow cleaning products manufacturers instructions. If acid contacts the window or door, wash all surfaces immediately with clean water.
- **Do not** use razor blades to clean glass surface. Glass damage could result.
- Clean glass using liquid glass cleaner.
- Clean frame, sash, panels, and insect screens using mild detergent and warm water with a soft cloth or brush.

IMPORTANT

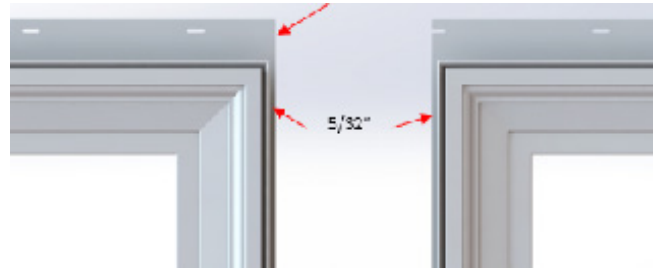
- Buildings constructed prior to 1978 could contain lead paint which could be disturbed during window or door replacement. For more information on proper management of lead paint, go to: www.epa.gov/lead
- Care must be taken to properly recycle or dispose of old materials. Any recyclable materials should be separated from non-recyclable or hazardous materials. Please consult with local or state authorities regarding proper disposal of non-recyclable or hazardous materials.
- These are generic instructions intended to cover most common situations, which may not be appropriate for all installations due to building design, construction materials, or methods used and/or building or site conditions. Consult a contractor or architect for recommendations.
- Inspect all units for any damage or defects prior to installation. Contact the nearest Quaker distributor if there are any problems.

1



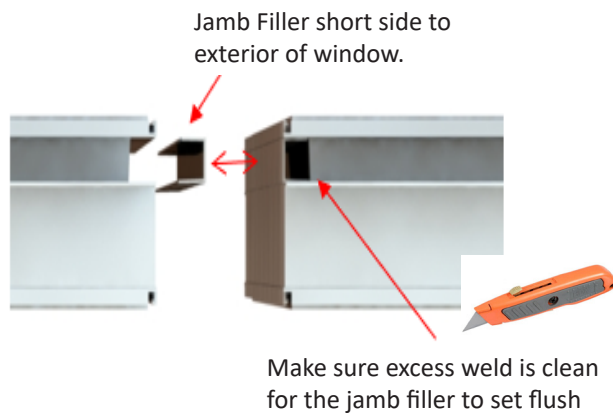
Lay the units down on a drop cloth or cardboard in the order they are to be mullied with exterior side down.

2



Using a utility knife score and remove all but 5/32" of the nailing fin from each unit where the mullion will connect them. Make sure to cut the head and sill nail fins back flush with ripped nail fin as shown above. Dry fit the mullion onto the ripped nail fins of both units. Trim down any high spots.

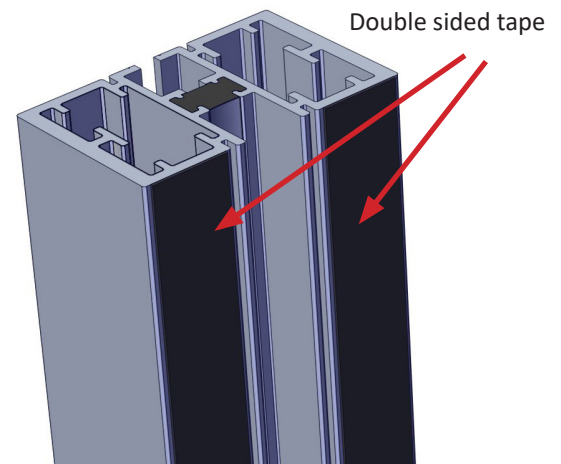
3



Use a utility knife to clean the excess weld at the corners of the windows.

If the units have J-channels, install the J-channel filler on the sides to be mullied of the exterior of each window. Cut the filler short of head and sill J-channel slots so as not to obstruct those channels.

4

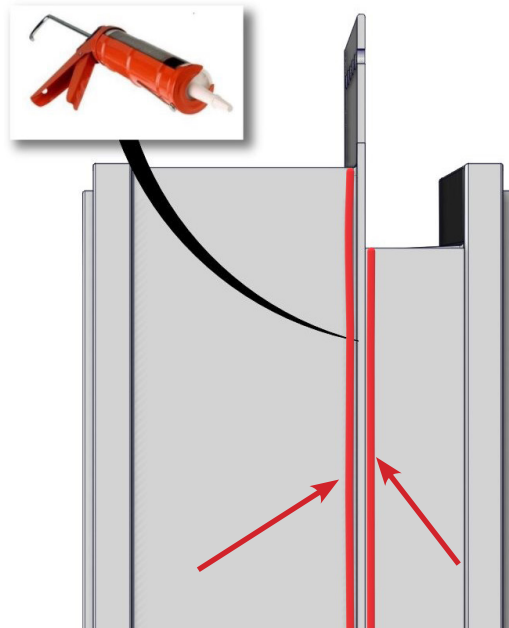


For units WITHOUT J-channel, cut the structural mull 1/4" less than window unit height or width to be mullied.

For units WITH J-channel, cut the structural mull 1 5/8" less than window unit height or width to be mullied.

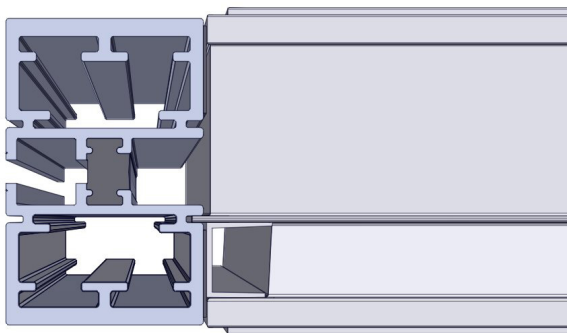
Clean structural mull with 99% alcohol to remove any oil and apply double-sided tape to one side of mull.

5

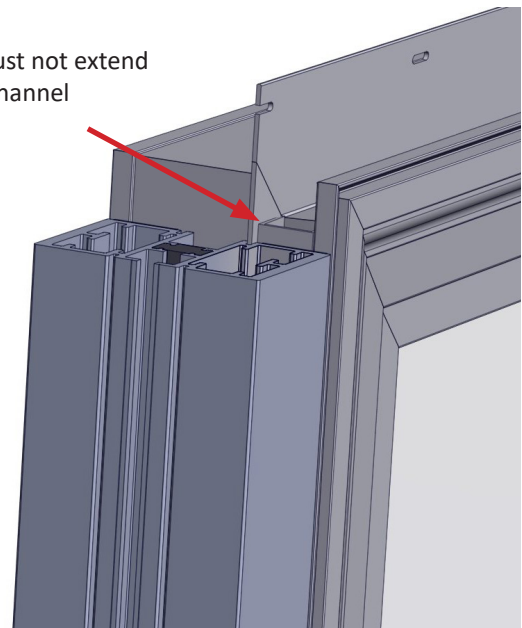


Wipe down the face of the vinyl window that connects to the structural mull with 99% alcohol to ensure a solid bond to sealant. Apply a continuous 1/8" bead of sealant along on each side of the ripped nail fin.

6

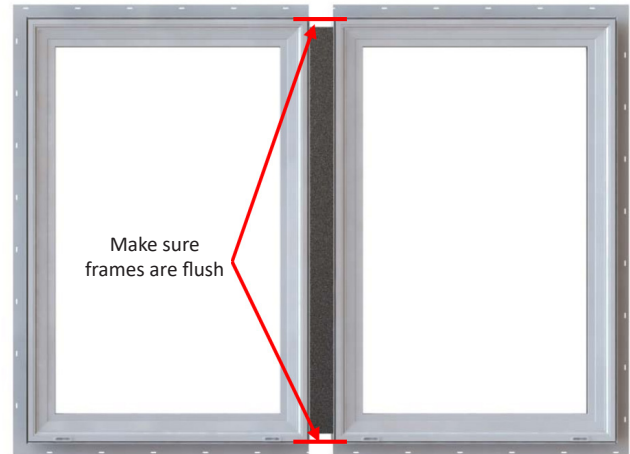
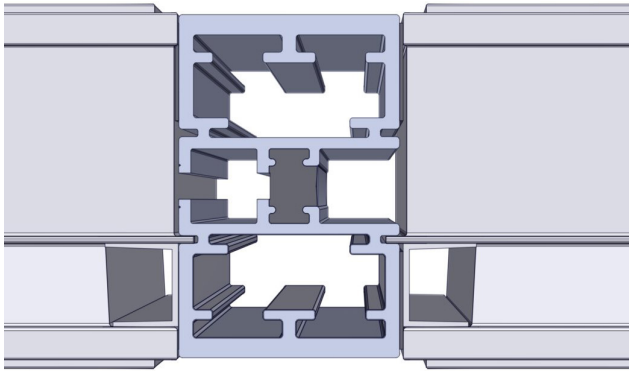


Mull must not extend past J-channel



Peel the backing off the double-sided tape on the side of the mullion. Center and apply the mullion to the side of the window, inserting the ripped nail fin into the groove of the mullion. Make sure the mullion doesn't stick past the J-channel pocket on either end. Press firmly to engage the double-sided tape and make sure there is wet out of sealant where mull and nail fin nub connect together.

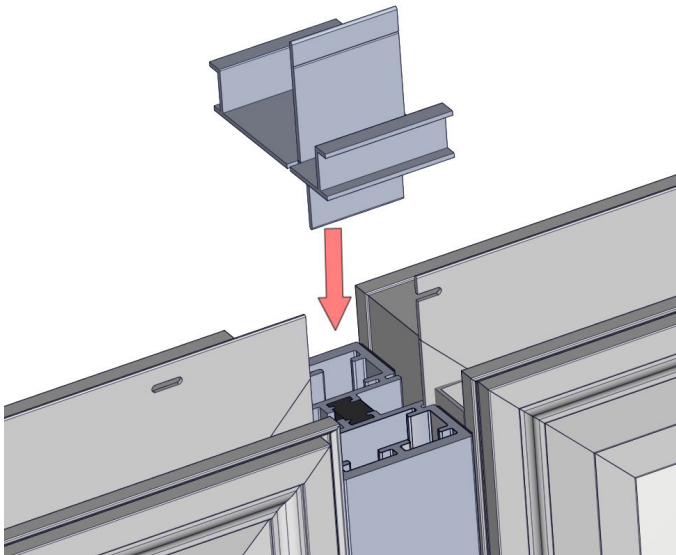
7



Repeat steps 5 and 6 for the next window.

Ensure the window frames are flush as shown above when mulling.

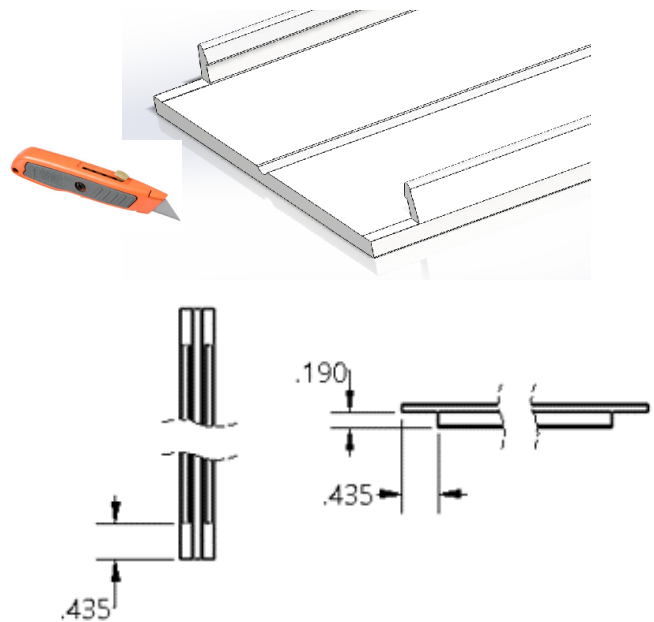
8



Remove the protective backing from the mull cap (JX-Anchor, or X-Anchor) and insert into the end of the mullion, aligning the tab of the mull cap with the nail fins. Repeat for opposite side of mullion.

Note: Units with J-channel use the JX-Anchor (M22967), units without J-channel use the X-Anchor (M22941).

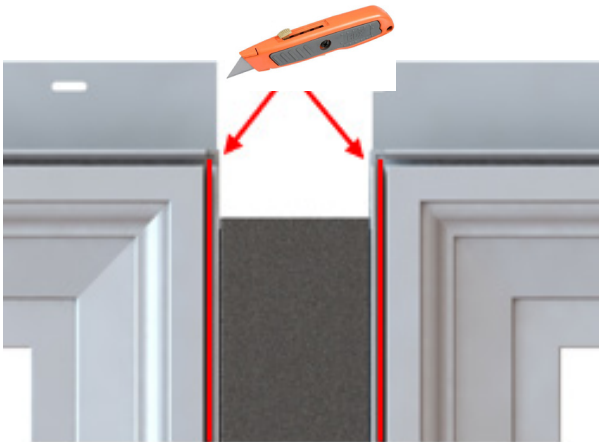
9



Cut the mull keys to the length of the unit (width or height) to be mullied.

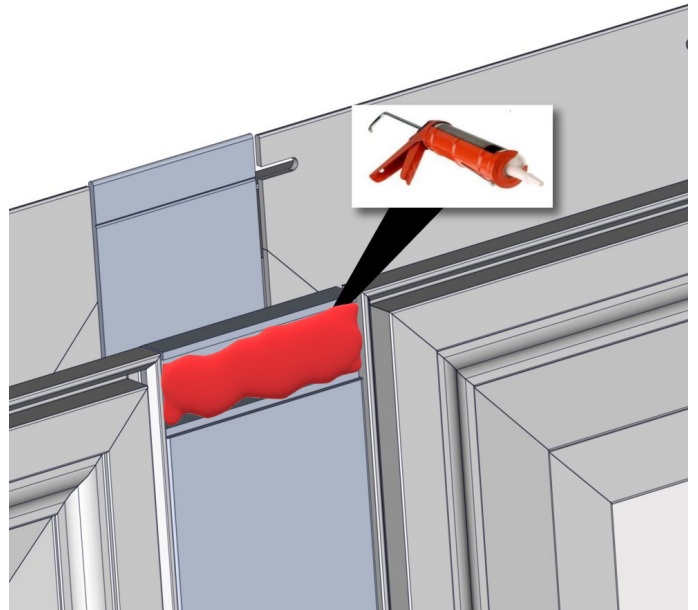
Notch both ends of each mull key with a utility knife or chisel per dimension shown above.

10



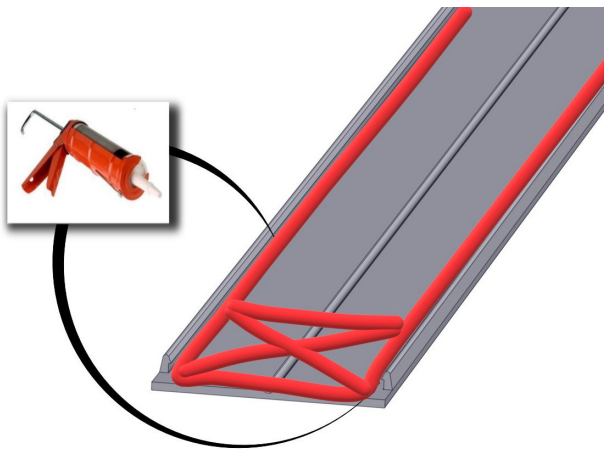
If the unit has a laminate applied, score the laminate through the mull track and remove material to allow the mull key to snap into place.

11



On units with J-Channel, fill the exterior void of the mull caps (JX-Anchor) with sealant.

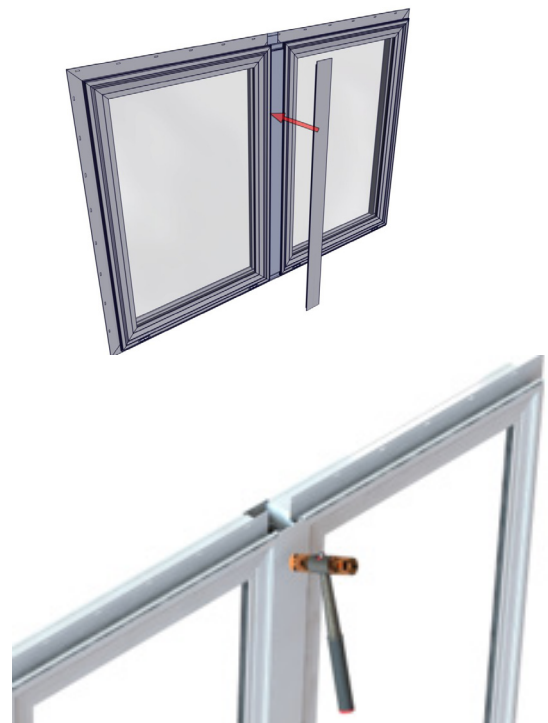
12



Apply a continuous 1/8" bead of sealant along the inside legs of the mull key as shown above.

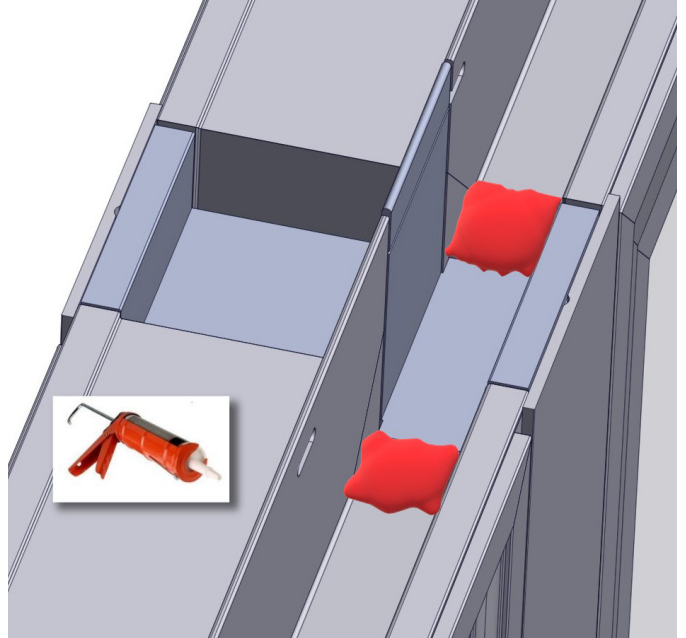
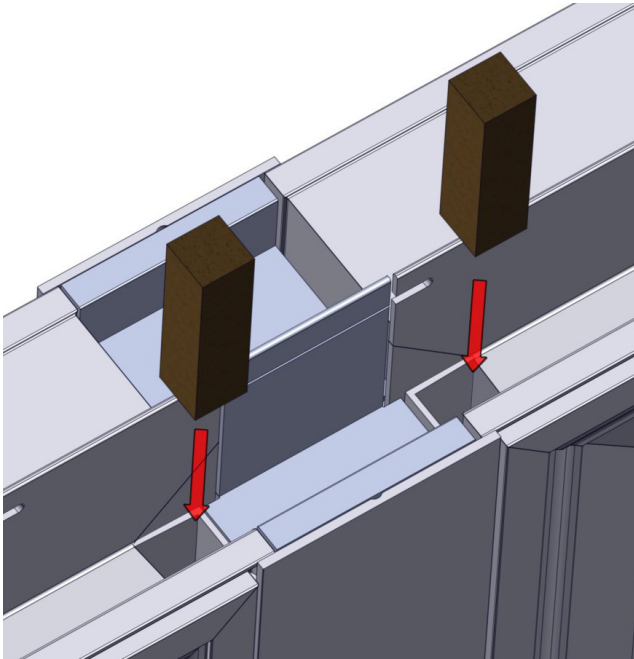
Apply additional sealant to each end of the mull key to ensure proper seal, as shown above in the "X" pattern.

13



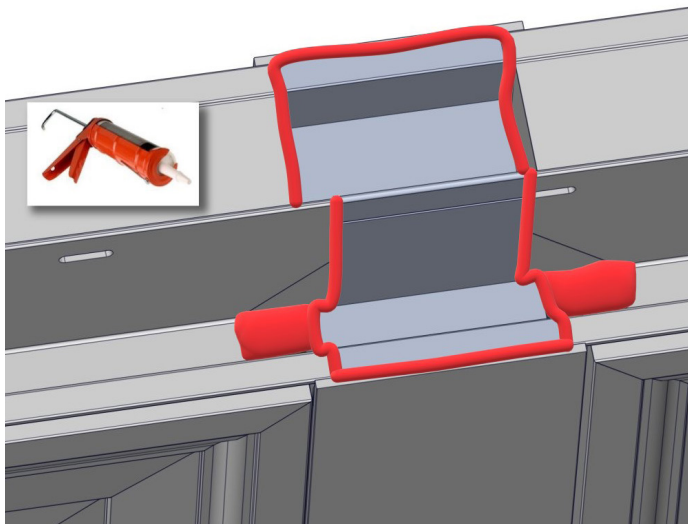
Install the mull key flush with one side of unit and hammer into place with rubber hammer. Flip units over and repeat steps 12 and 13 for the other side.

14



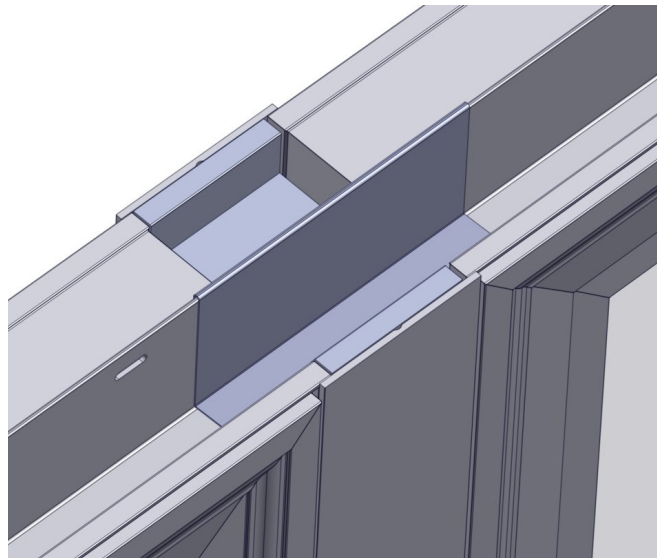
For units with J-channel, insert foam plugs or backer rod into the voids at both ends of J-channel. Cover the foam entirely with sealant to seal the voids.

15



Apply sealant to the perimeter of the mull cap as shown, filling all gaps between the metal and vinyl. "Trace" up the gap between the tab of the mull cap and the nail fins.

16



Apply self-adhesive flashing tape over the top side of mull cap and over nail fin.

Clean up any excess sealant on the interior and exterior faces of the mull cap.

17

Install unit per standard nail fin install procedures.

18

After unit is installed in wall, install drip cap over the nail fin the full length of mullied units at the head. Notch the drip cap ends if necessary for standard J-channel installation practices.



QWP part # IG-048

Installation Guidelines For All Vinyl Quaker Products With Vinyl 2" Structural Field Mull

If this set of instructions doesn't match your installation method or wall conditions please check our website listed below for other options, or call the office.

Scan here for a digital version of these guidelines in English



Scan here for a digital version of these guidelines in Spanish



Or go to: <https://www.quakercommercialwindows.com/resources/installation-instructions-english/>

Or go to: <https://www.quakercommercialwindows.com/installation-instructions-spanish/>

