



Installation Guidelines

For Aluminum Quaker Window Products with Pre-set Panning (Single Hung, Double Hung, Sliding Window, Fixed Window, Casement, Awning, and Hopper)

Installer:

- **Read these instructions completely before starting any installation.** Failure to install and maintain our product according to these instructions will void any warranty, written or implied.
- These instructions are consistent with AAMA IPC-08 "Standard Practice for Installation of Windows and Doors in Commercial Buildings" into common wall constructions. Contact your architect or construction professional for installation into other building designs or constructions methods.
- The installer is responsible for consulting the contractor, structural engineer, architect, or consumer, for proper installation according to local codes and/or ordinances.



Warning:

- Proper eye and hearing protection must always be worn when installing, removing or performing adjustments to Quaker window and door products.
- Use power tools properly! To avoid personal injury, always follow manufacturers' instructions for safe operation of power tools.
- 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 Quaker's stipulations dictate safety glass or safety glass is specifically ordered, Quaker windows are not provided with safety glass. Before installing, Quaker recommends consulting local building codes for more definitive information.

Caution:

- Lead-based paint may be present in older homes, and the removal of windows may cause this paint to be disturbed. In order to minimize exposure to lead-based paint dust, please consult 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.
- Some codes require the use of pressure treated lumber to line rough openings. Corrosion resistant materials, such as stainless steel or hot-dip galvanized steel, must be used for fasteners and anchors having direct contact with pressure treated lumber.

Important:

- Quaker reserves the right to change the information contained in these guidelines without notice.
- Maintain a minimum of ¼" between the exterior window frame and any trim, siding or masonry to allow for expansion.
- Window 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 around the perimeter.
- Use of Quaker products in barrier EIFS systems (synthetic stucco) is not recommended. To do so will void all warranties (written or implied) and Quaker Window Products Co., Inc. will not be held responsible for any claims or damages resulting from water infiltration.
- Do not drill through window sill to install alarm wires.
- If using muriatic acid or brick wash cleaning solutions, please follow the manufacturer's instructions found on the product label or on the manufacturer's website.

Handling and Storage:

- Do not store units outside, or in a hot environment.
- When carrying window, always keep it in a vertical position. **Do not carry flat**, doing so could result in damage to the unit.
- Stack units as straight as possible to avoid bowing. Do not lay flat!



These instructions are for installing Quaker's aluminum products into a wood or concrete/masonry wall with the use of pre-set panning & interior snap trim. Contact your Quaker window and door supplier for more information on installing units in other wall conditions. Please visit our website at www.quakerwindows.com or call at 1-800-347-0438 for additional literature and information.

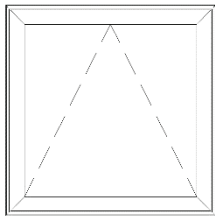
Tools required by installer:

- Safety Glasses
- Utility knife
- Drill / screwdriver
- Caulk Gun
- Level
- Tape measure
- Metal cutting saw

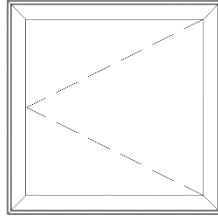


Materials required by installer:

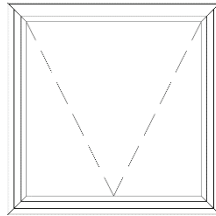
- Insulation
 - Fiberglass or similar strips
 - Minimally expanding low pressure polyurethane window and door spray foam. **(Must be compliant with AAMA 812-04)**
- Shims
 - Made of cedar or synthetic material
- Screws
 - Screw size may vary per wall/framing needs
 - Fasteners must be corrosion resistant and compatible with materials contacted and/or penetrated.
- Silicone Sealant
 - 100% silicone ASTM C920 compliant
 - Neutral cure (modified oxime) only
 - Some sub-states made need to be primed before sealing. Consult the sealant supplier.



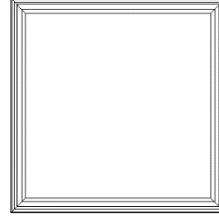
Awning



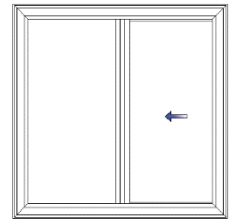
Casement



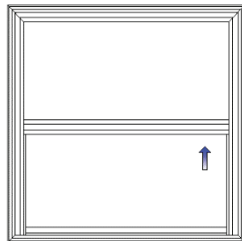
Hopper



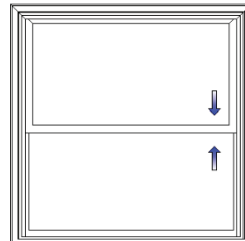
Picture window



Sliding window



Single Hung



Double Hung



Typical pre-set panning material is shipped factory cut to size and assembled to fit the exact window dimensions.
The perimeter flange of the panning may need to be field trimmed to fit the masonry opening.

Step 1: Inspect unit and pre-set panning before installation

- A. Match up the pre-set panning with the correct window unit. Panning will be labeled to match sales order & line number of the window unit.
- B. Remove all shipping packaging material (blocks, pads, protectors, stretch wrap) and dispose/recycle properly.
- C. Inspect unit for any damage or defects, and make sure the unit operates properly.
- D. Verify that the window unit is the correct size and configuration.
- E. Contact the nearest Quaker distributor if there is a problem. Provide the sales order number on the warranty sticker (see <http://quakerwindows.com/wp-content/uploads/2013/04/Warranty-sticker-locations01-30-2015.pdf> for sticker locations).

Step 2: Prepare rough opening

- A. The material/lumber quality and fasteners must be structurally adequate for design load requirements.
- B. Measure and verify the size of the rough opening. See shop drawings for the proper opening sizes per panning system being used.
- C. Verify the rough opening is flat, plumb, level, and square. (Fig. 1)
 - Take diagonal measurements to check for square.
 - The sill beneath the unit must be level for proper unit operation.
- D. Check the fit of the panning making sure the conditions are level, the installer can pre-apply the shims to the sill condition prior to installation of the pre-set panning. (Fig. 2)



Note: Take measurements at three locations (head, middle, sill for width and left, middle, right for height). Use the smallest of the three measurements to ensure the replacement window can be installed square, level, plumb in both directions, and with a straight sill.

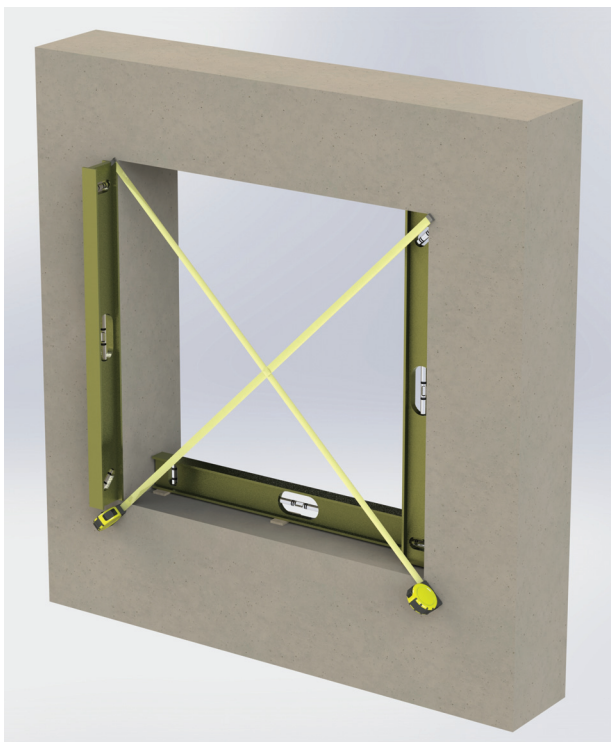


Fig. 1

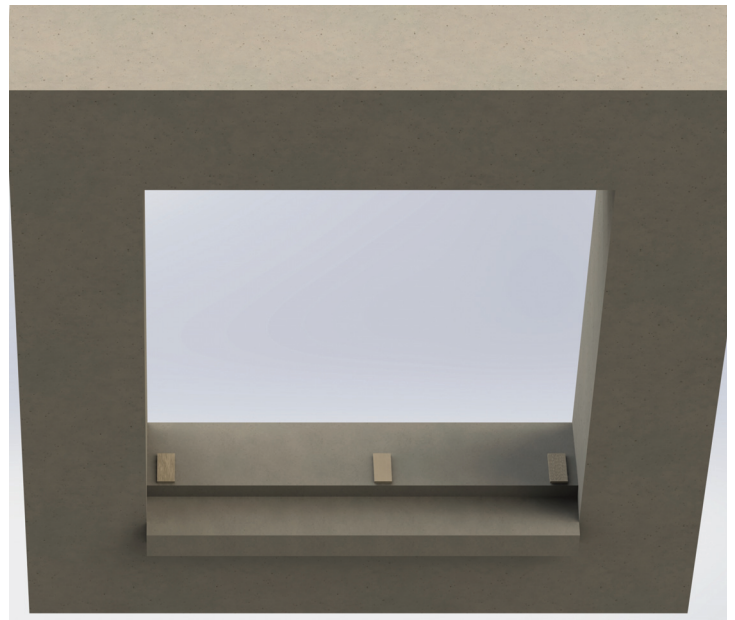


Fig. 2

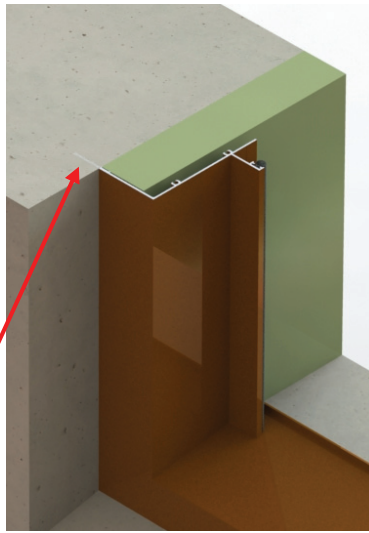
Step 3: Installation of Pre-set panning

- A. Measure the Masonry opening and trim panning legs as needed to fit openings. (Fig. 3 & 4)
- B. Install a continuous bead of sealant around the perimeter of the window opening where the panning will rest if applicable. (Fig. 5)
- C. Pull the panning frame into the opening from the exterior.
 - Square, plumb, and level the panning into the opening shimming as needed. (Fig. 6)
 - Fasten the panning with screws by others per shop drawings or anchorage calculations. Typically 3" from the corners and 12" on center. (Fig. 7)
 - Always follow the fastener/anchor manufacture's guidelines for proper edge distance, load capacity and installation techniques.



Sill cross section view

Fig. 3



Jamb cross section view

Fig. 4



Fig. 5



Fig. 6

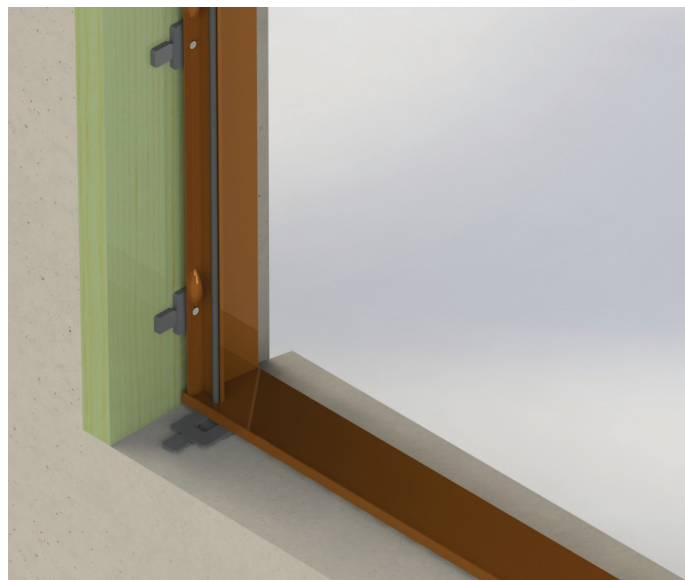


Fig. 7

Step 4: Sealing the panning

- A. Apply sealant to the perimeter of the panning system to the surrounding masonry opening, and all seams in the panning system. (Fig. 8 & 9)
- B. Apply a continuous bead of sealant along the sill panning where the exterior window leg will rest. (Fig. 10)
- C. Back bed the panning vinyl with sealant just before insertion of the window, or cap seal the window to the panning frame joint from the exterior after the window is installed. Whichever method is used, the **window must be wet sealed to the panning**. The panning vinyl is not an adequate weather seal. (Fig. 11)
- D. Insulate around perimeter between the panning and wall system.

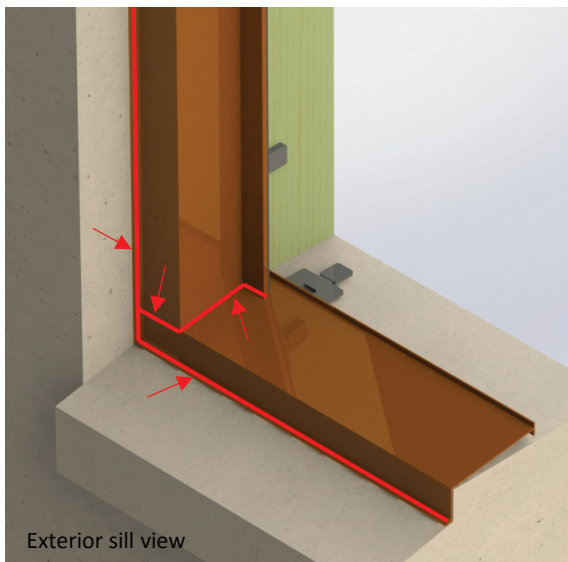


Fig. 8

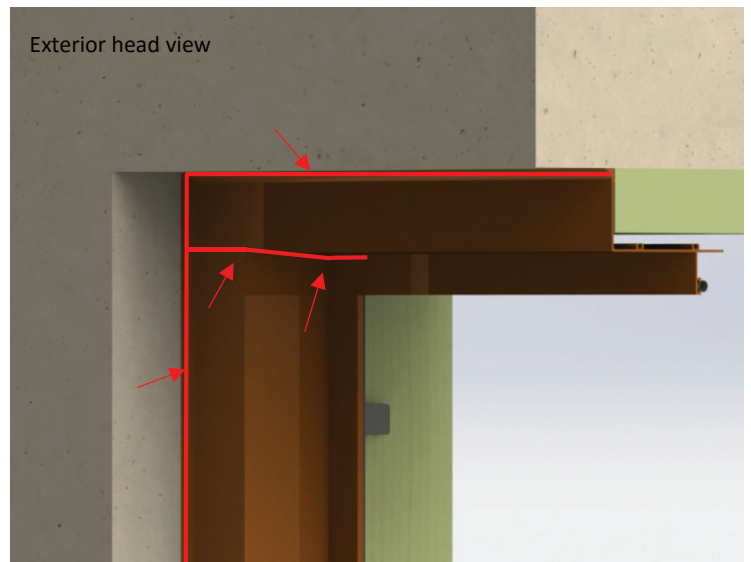


Fig. 9

All red lines = sealant

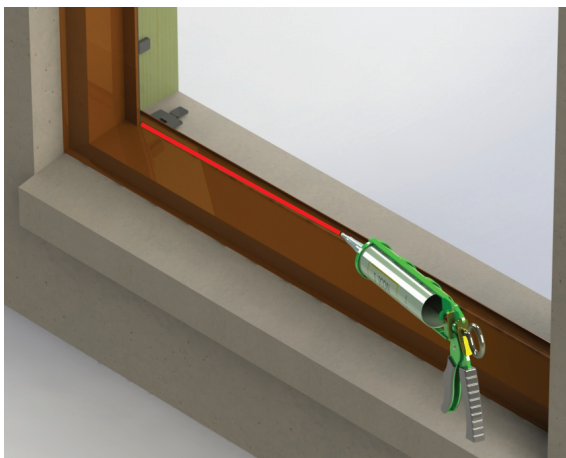


Fig. 10



Fig. 11

Step 5: Window installation

- A. Set the exterior leg of the window onto the sill panning frame. Then push the window head and jamb in against the panning head and jamb. Make sure that the window head and jamb legs snap-in securely behind panning crimps.
The window must be pushed tight against the panning. (Fig. 12)
- B. Place a level on the window sill to verify that the sill is level. Adjust the shims as needed to ensure a level condition.
- C. Check the head, sill and jambs with a level again to make sure the window is setting plumb, level, and square within the opening. Measure across the diagonals to determine if the window is square. (Fig. 13)
- D. Add shims around the entire window as needed to ensure a plumb, level, and square installation.
- E. Install base clips around the window per shop drawings and or anchorage calculations. Typically 3" from the corners and 12" on center. Keep base clips tight against the window and wall/framing system. (Fig. 14)
 - Minimum one screw into the window frame, and one screw into the wall/framing system per base clip.
 - Use caution when attaching the clips to the frame – be sure not to interrupt the travel of the sash by penetrating the track.
 - Always follow the fastener/anchor manufacturer's guidelines for proper edge distance, load capacity and installation techniques.
- F. For casement windows, add blocking and anchors at the hinge locations. For sliding windows, add support blocking behind the jamb condition at the locking point.
- G. Check the installed product to ensure that it operates properly and that the reveal is equal between the sash and frame.

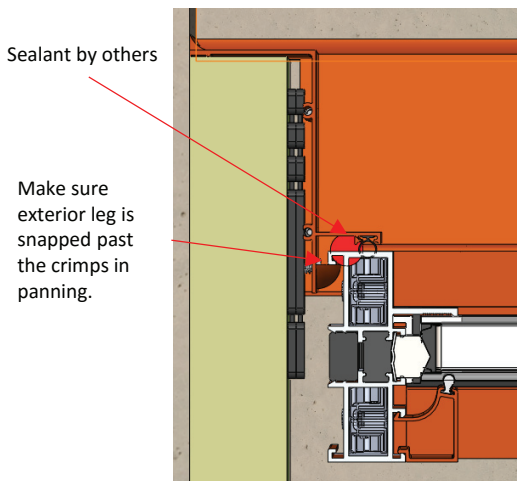


Fig. 12

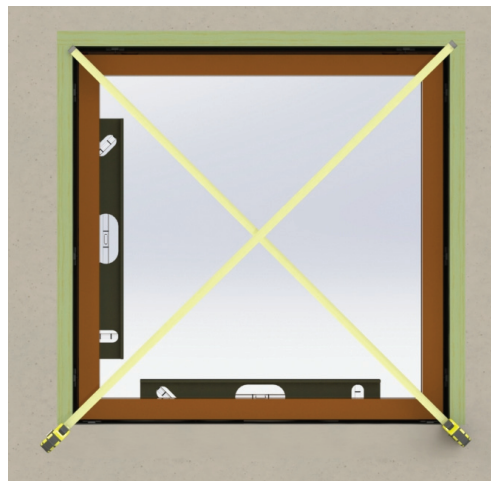
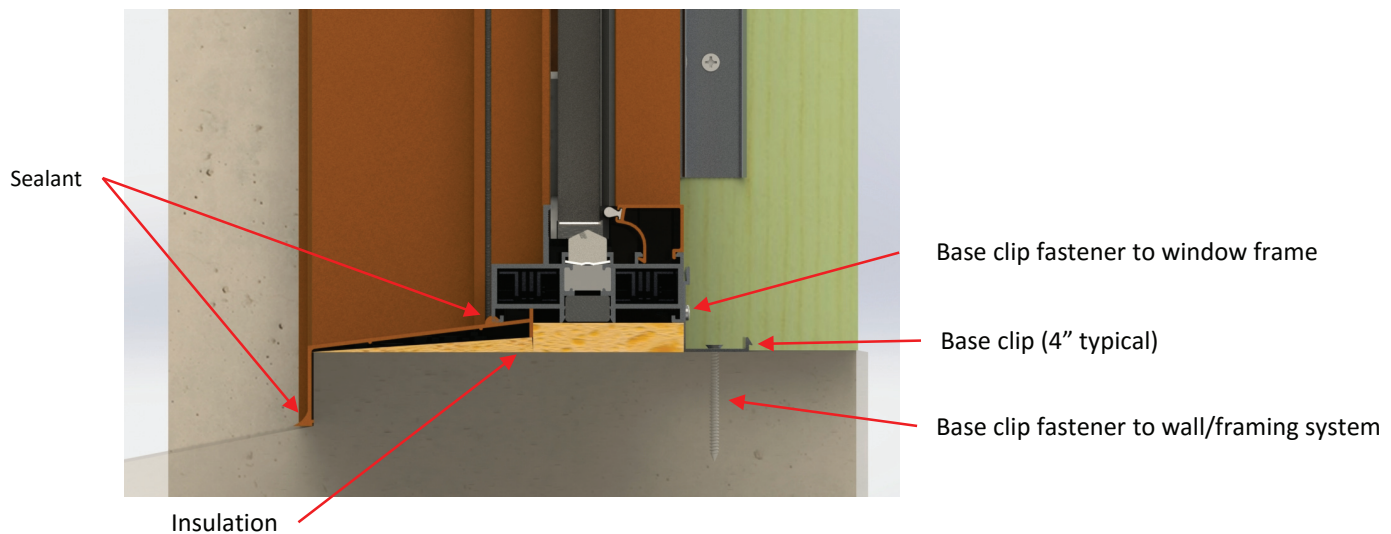


Fig. 13



Fig. 14





Step 6: Insulate and finish

- A. Insulate between the window frame and the rough opening using minimally expanding window and door spray foam or fiberglass insulation that is compliant with AAMA 812-04. Read and follow the manufacturers' recommendations for application and use. (Fig. 15)
- B. Operate window unit to ensure proper operation. Sash will not operate correctly if window is out of square, over-shimmed or over-insulated.
- C. Allow foam to fully cure before installing interior trim.
- D. Install interior snap trim over the base clips. (Fig. 16)

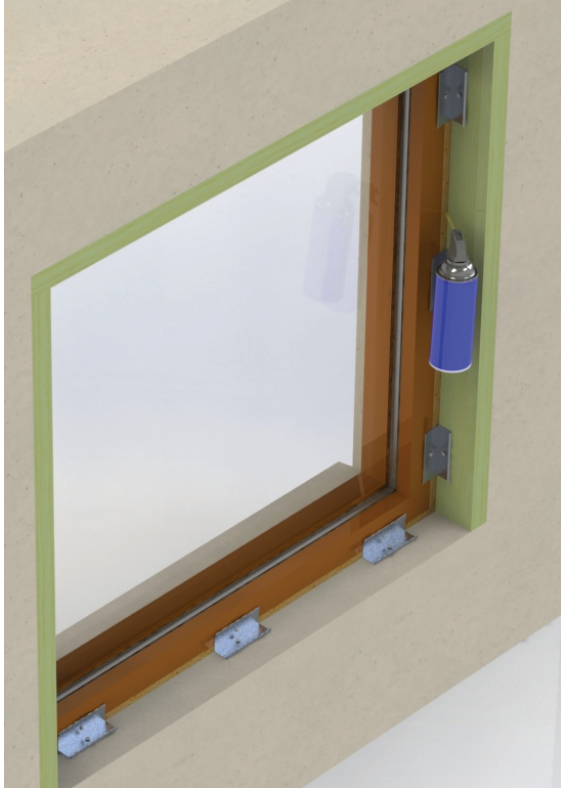


Fig. 15

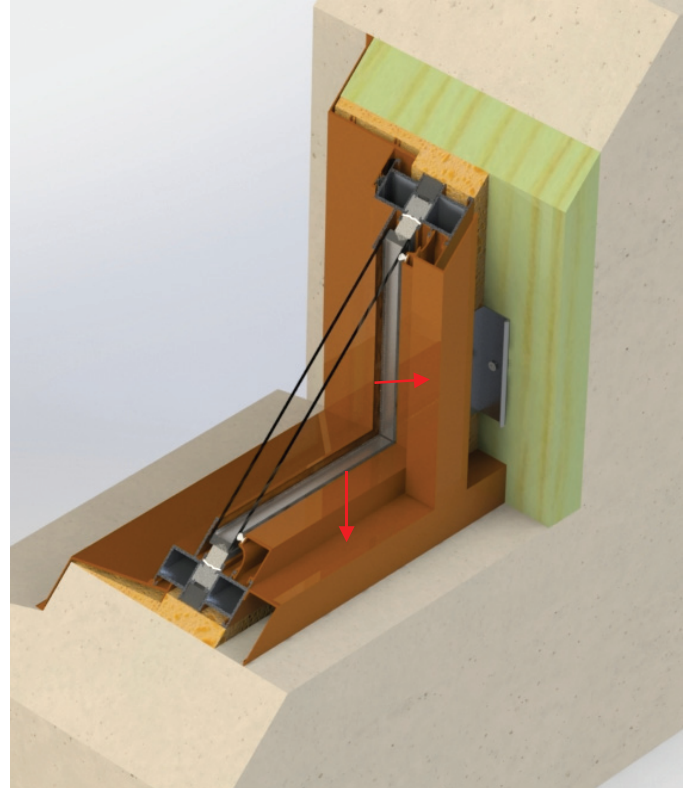


Fig. 16

Care and Use

An inspection of your windows should be made annually. Visit the Quaker website <http://quakerwindows.com/wp-content/uploads/2013/05/Quaker-Window-Care-Maintenance.pdf> or contact your local independent Quaker distributor for information on the care and use of your product. Ask for the Window Care & Maintenance Guide.