

INTEGRITY DOUBLE HUNG/GLIDER

Mullion Kit Instructions



BEFORE YOU BEGIN

Important! Read these instructions thoroughly before beginning to assemble any multiple Integrity units. Failure to assemble as recommended will void any warranty, written or implied. Refer to specific product installation instructions for proper installation methods.

WARNING: Practice safety! Wear safety glasses or goggles and appropriate hearing protection when assembling multiple Integrity window and door products.

NOTE: When specifying or considering the structural load requirements for windows and doors, it is important to consider the method of fastening the unit(s) together in addition to the method of fastening multiple assemblies into an opening. The methods contained herein may not be appropriate for all performance requirements. Selection of the appropriate fastening method(s) is the sole responsibility of the installer, contractor, structural engineer, architect, building owner and/or installer.

The construction adhesive called for in the round top over double hung instructions should meet AFG-01 specifications.

Double Hung multiple assemblies can be ordered factory mulled up to 4 units wide by 1 unit high, or 2 units wide by 2 units high as long as the following limitations are not exceeded:

Maximum RO Width: 113 1/2" (2883) not to exceed 72 1/4" (1835) in height.

Maximum RO Height: 88" (2235) not to exceed 84" (2134) in width.

Do not stack Integrity Gliders. Glider multiple assemblies can be ordered factory mulled up to 2 units wide by 1 unit high as long as the following limitations are not exceeded:

Maximum RO Width: 96 1/2" (2451) not to exceed 60 1/4" (1530) in height.

Assemblies exceeding these limitations must be field mulled and must be assembled using a structural mullion kit designed specifically for Integrity multiple assemblies. Contact your Integrity dealer for additional information.

INDEX	Page
Double Hung/Glider Vertical Mullion Kit	1
Double Hung Horizontal Mullion Kit	3
Round Top over Double Hung Mullion Kit	5
Double Hung 2-Wide x 2-High Mullion Kit	6
IRTM over IDH Mullion Kit	8
IRTM RT 2 or 6 Beside IDH Mullion Kit	10

DOUBLE HUNG/GLIDER VERTICAL MULLION KIT INCLUDING POLYGON TO DOUBLE HUNG

Parts Shipped With Kit

ILLUSTRATIONS (not to scale)	DESCRIPTION AND COLOR
	W8952 Wood mull tie 12" (304)
	W1241 Interior mull trim 120" (3048) White Interior or Bare
	Steel mull tie
	Mull sealant foam tape - 1 sided adhesive 96" (2438)
	A330 Aluminum mulling pin 71" (1803) or 150" (3810)
	#7x5/8" Phillips flat head wood screw

Parts Shipped With Kit continued

ILLUSTRATIONS (not to scale)	DESCRIPTION AND COLOR
	Nailing fin connector
	4- Structural bracket 6" (152) or 10" (254)

Parts Included with Polygon to Double Hung Kit

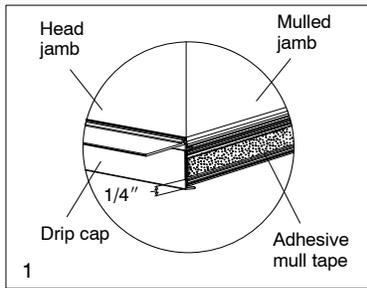
	W9295 Structural mull tie Douglas Fir 84" (2134)
	#8x 1 1/4" Phillips flat head screws

YOU WILL NEED TO SUPPLY

Safety glasses	Hearing protection
Phillips screwdriver	Hammer
Power drill	3/16" drill bit
Clamps	Hacksaw
Silicone sealant w/gun	
1/2" crown x 1" leg 16 gauge staples w/gun	
3/16" crown x 1" leg 18 gauge staples w/gun	

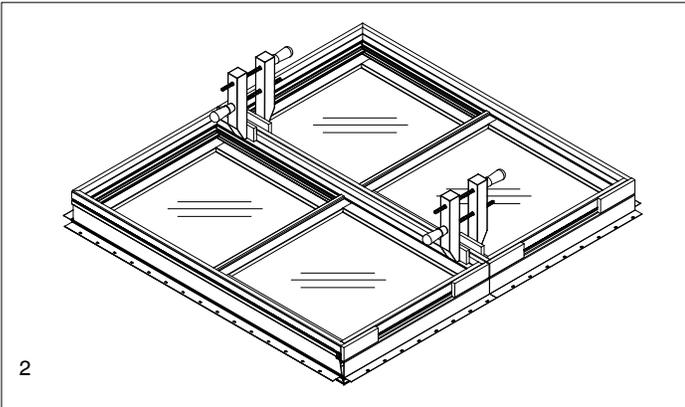
Mulling Procedures - Vertical

1. Lay frames on a flat surface in the desired mulling configuration (interior facing up). Remove nailing fin from side jambs that will be mulled together. Apply mull sealant foam tape along the entire length of one jamb to be mulled ensuring it is located $1/4''$ (6) from the exterior edge of the Ultrex frame. See illustration 1.



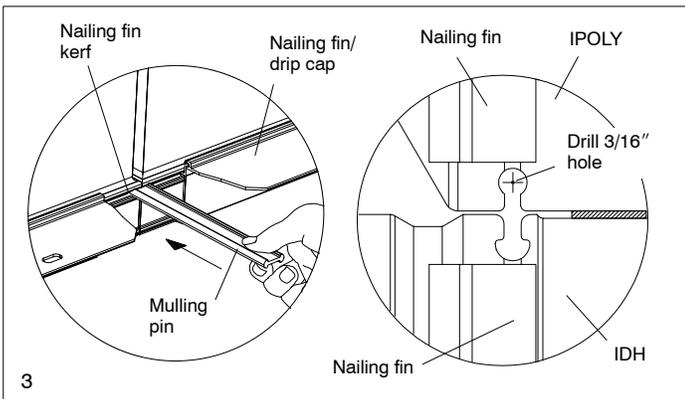
IMPORTANT: Units should be flush and square with each other.

2. Partially pull nailing fin/drip cap from head jambs at the mullion to expose side jamb nailing fin kerf and allow for mulling pin installation later.
3. Position the units together in the desired configuration. Check to be sure that the frames at both ends of the mullion are flush and the nailing fin kerfs are aligned. Lightly clamp units together on interior (use wood blocks to protect interior) near each end to hold two mulled units in place. See illustration 2.

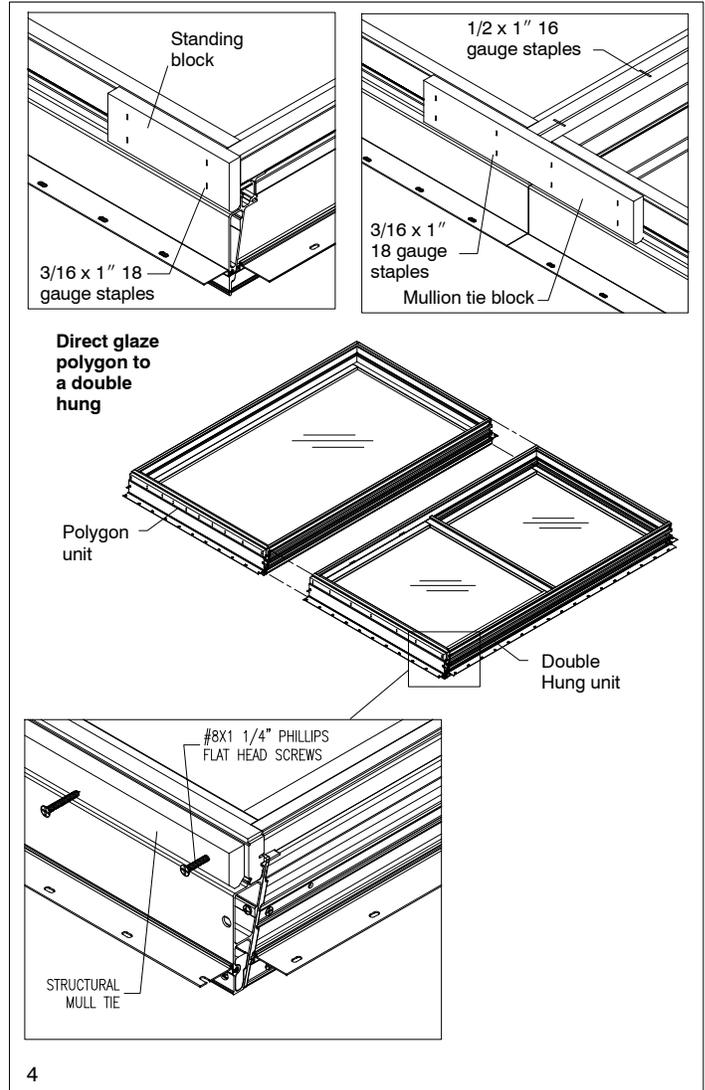


4. Slide the mulling pin in the full length of the mullion. A hammer may aid in the application of the mull pin. The mull pin ends must be recessed $1/4''$ (6) to allow sealant application later. See illustration 3.

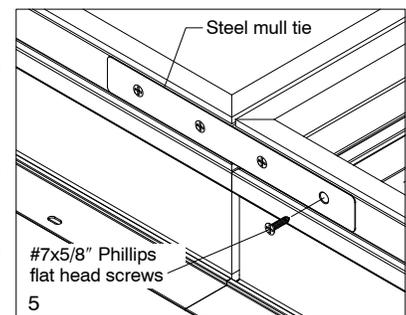
NOTE: If mulling a direct glaze polygon to a double hung unit, drill out the nailing fin/drip cap kerf on the head jamb of the polygon with a $3/16''$ drill bit. This will ease the installation of the aluminum mulling pin. Clean away any fibers or filings from the kerf area.



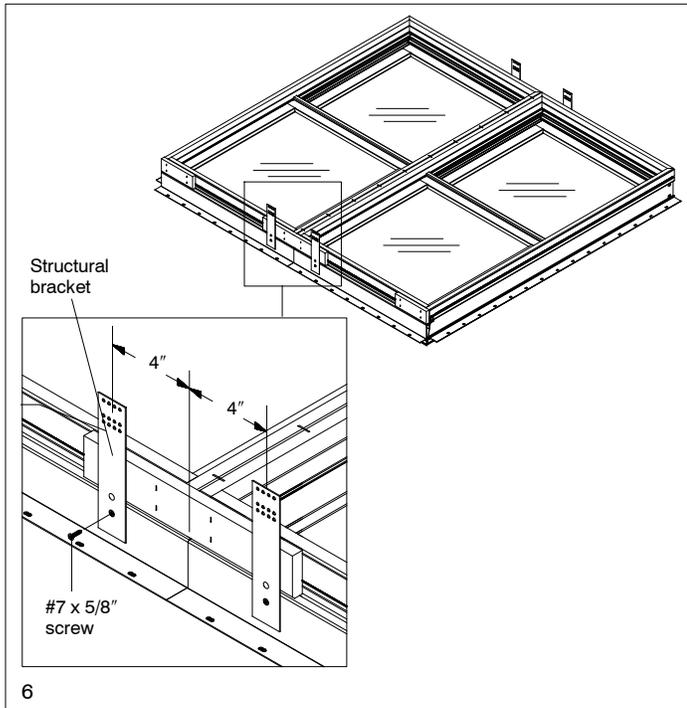
5. Remove the wood standing blocks at the sills near the mullion. Center mull tie block over mull at sill and attach with four $3/16'' \times 1''$ 18 gauge staples into each unit (double hung to double hung only). If mulling a direct glaze polygon to a double hung unit, install a structural mull tie (W9295) to the full length of the sill of the double hung unit. Attach with #8 x $1/4''$ Phillips Head screws. See illustration 4.
6. Join the wood frame members along the interior of the mullion. Apply a third clamp and wood blocks to interior as needed. Make sure mulled units are flush and square at the sill and jamb liners. Fasten interior of mulled units with $1/2'' \times 1''$ 16 gauge staples spaced every 4'' (102). See illustration 4.



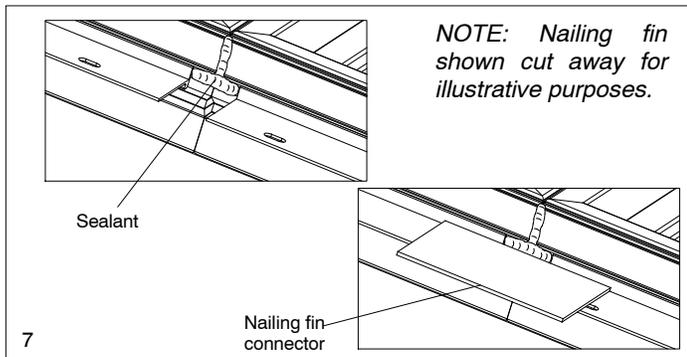
7. Install a steel mullion tie across the head jambs and fasten with two #7 x $5/8''$ Phillips flat head wood screws into each unit. See illustration 5. If mulling a direct glaze polygon to a double hung unit, attach steel mull tie to the sills as well as the head jambs.



8. Install structural brackets 4" (102) from the mull on both sides. Attach each of the brackets with the #7 x 5/8 screws provided. Follow the instructions provided with the brackets for more detailed installation. See illustration 6.



9. Apply silicone sealant at the mullion from the frame exterior edge to the drip cap/nauling fin kerf and across the kerf over the mulling pin as shown in illustration 6. Apply nauling fin connector at the head jamb and sill by removing the paper backing from the connector and pressing into place. See illustration 7.



10. If applicable, jamb extension can now be installed. Follow installation instructions for installing unit into rough opening or masonry opening.

NOTE: Interior mull trim should be applied after unit is completely installed and interior trim is applied.

DOUBLE HUNG HORIZONTAL MULLION KIT

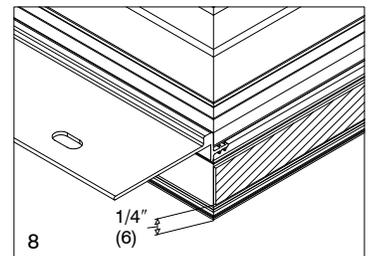
Parts Shipped With Kit		
ILLUSTRATIONS (not to scale)	DESCRIPTION AND COLOR	PART/PROFILE NUMBER
	W8952 Mull filler (length varies)	See Parts Manual
	W1242 Interior mull trim 120" (3048) White Interior Bare	39249199 32249199
	A330 Aluminum mulling pin 150" (3810)	11103250
	Mull sealant foam tape-one sided 96" (2438)	11869508
	Nailing fin connector	10500213
	#7x5/8" Phillips flat head wood screw	11800758
	Steel mull tie	11040358
	4- Structural bracket 6" (152) 10" (254)	11860014 11860009

YOU WILL NEED TO SUPPLY

- | | |
|---|--------------------|
| Safety glasses | Hearing protection |
| Phillips screwdriver | Hammer |
| Power drill | 3/16" drill bit |
| Clamps | Hacksaw |
| Silicone sealant w/gun | |
| 1/2" crown x 1" leg 16 gauge staples w/gun | |
| 3/16" crown x 1" leg 18 gauge staples w/gun | |

Mulling Procedures - Horizontal

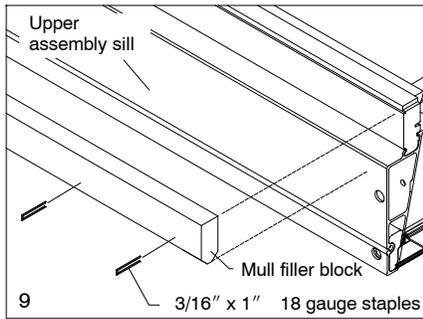
- Lay frames on a flat surface in the desired mulling configuration (interior facing up). Remove nauling fin from the head jambs and sills that will be mulled together. Apply the mull sealant foam tape along the entire length of the



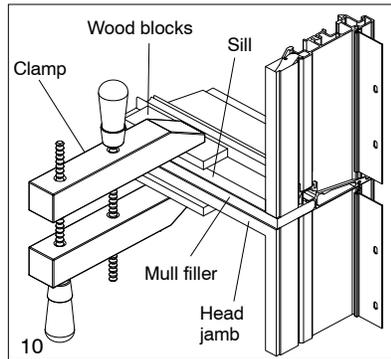
head jamb of the lower unit. Mull tape should be located 1/4" (6) from the exterior edge of the Ultrex frame. See illustration 8.

IMPORTANT: Units should be flush and square with each other.

- Remove standing blocks from the sill of the upper unit. Install the mull filler block (W8952) to the full length of the sill of the upper unit with 3/16" x 1" 18 gauge staples as shown in illustration 9.

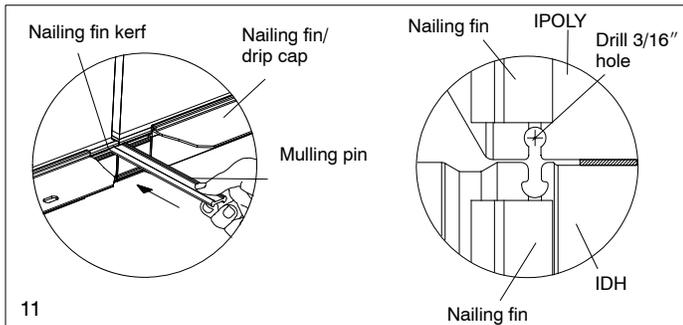


- Position the units together in the desired configuration. Check to be sure that the frames at both ends of the mullion are flush and the nailing fin kerfs are aligned. Lightly clamp units together on interior (use wood blocks to protect interior) near each end to hold two mullied units in place. See illustration 10.

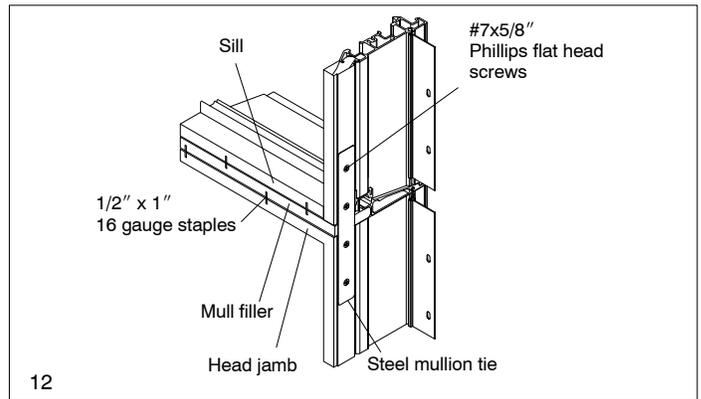


- Slide the mulling pin in the full length of the mullion. A hammer may aid in the application of the mull pin. The mull pin ends must be recessed 1/4" to allow sealant application later. See illustration 11.

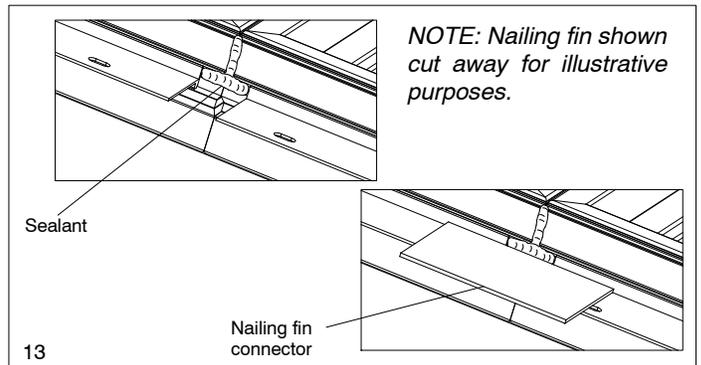
NOTE: If mulling a direct glaze polygon to a double hung unit, drill out the nailing fin/drip cap kerf on the sill of the polygon with a 3/16" drill bit. This will ease the installation of the aluminum mulling pin. Clean away any fibers or filings from the kerf area.



- Apply a third clamp and wood blocks to interior as needed. Make sure mullied units are flush and square at the sill and jamb liners. Fasten interior of mullied units with 1/2" x 1" 16 gauge staples spaced every 4" (102). See illustration 11. Fasten the jambs at each end with steel mullion ties and two #7 x 5/8" Phillips flat head wood screws into each unit. See illustration 12.



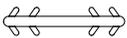
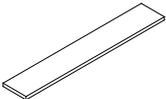
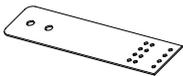
- Apply silicone sealant at the mullion from the frame exterior edge to the drip cap/nailing fin kerf and across the kerf over the mulling pin as shown in illustration 6. Apply nailing fin connector at the jambs by removing the paper backing from the connector and pressing into place. See illustration 13.



- If applicable, jamb extension can now be installed. Follow installation instructions for installing unit into rough opening or masonry opening.

NOTE: Interior mull trim should be applied after unit is completely installed and interior trim is applied.

ROUND TOP OVER DOUBLE HUNG MULLION KIT

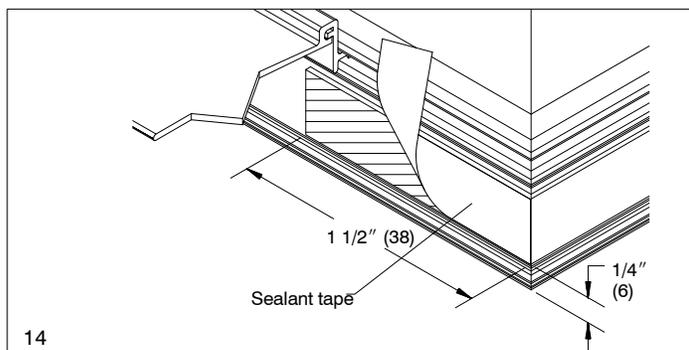
Parts Shipped With Kit		
ILLUSTRATIONS (not to scale)	DESCRIPTION AND COLOR	PART/PROFILE NUMBER
	1-W1241 Mull trim 120" (3048) White Interior Bare	39249099 32249099
	1-V803 Connecting barb fastener 96" (2438)	15812008
	2 - Mulling tin 3 1/2" x 16" (64x406)	02070302
	1-Mull sealant foam tape 96" (2438)	11406227
	2-Nailing fin connector	10500213
	6-#8x3/8" Phillips panhead wood screw	05050423
	4- Structural bracket 6" (152) 10" (254)	11860014 11860009

YOU WILL NEED TO SUPPLY

Safety glasses
Phillips screwdriver
Clamps
Silicone sealant w/gun
AFG-01 spec. (or equivalent) sealant/adhesive w/gun
1/2" crown x 1" leg 16 gauge staples with gun
3/16" crown x 1" 18 gauge staples w/gun
1/2" x 1/2" leg 16 gauge staples w/gun

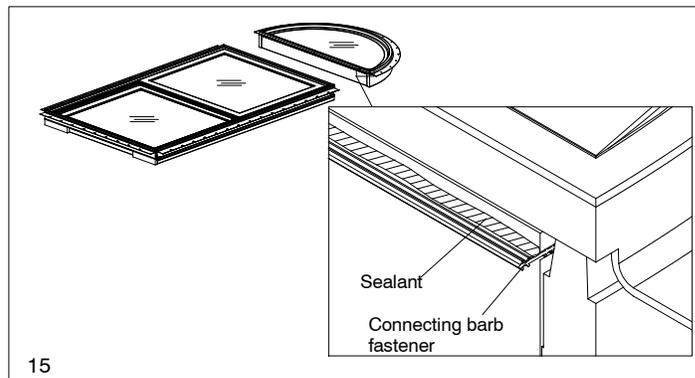
Hearing protection
Hammer
Utility knife

- Secure double hung unit in a rigid standing position and remove nailing fin from head jamb. Apply double sided mull sealant foam tape along the entire length of the double hung head jamb ensuring that it is located 1/4" (6) from the exterior edge of the Ultrex frame. Leave approximately 1 1/2" (38) excess to wrap around each jamb. **Do not remove the paper backing from the tape at this time.** See illustration 14.



14

- Insert the vinyl connecting barb fastener into the sill kerf on the round top unit. Apply an 1/8" (3) bead of APA rated AFG-01 sealant/adhesive to the exterior side of the connecting barb as shown in illustration 15.



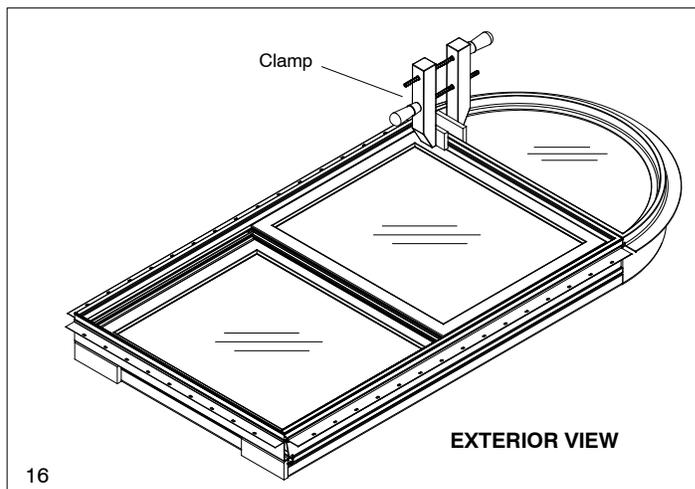
15

- Align round top flush with side jambs and exterior of the double hung unit, align and press barb into double hung head jamb drip cap kerf to mull.

NOTE: Before proceeding make sure that vinyl connecting barb is fully seated in the kerfs of both units and that both units are flush and square.

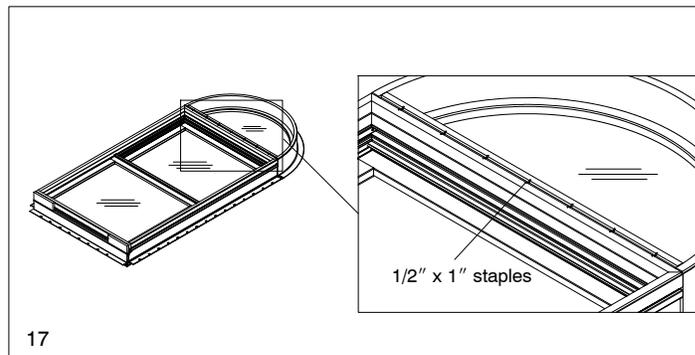
- Remove the protective backing from the foam tape. Use wood blocks and clamp on exterior to press together. Start on one side and clamp every 2" (51) until completely joined. See illustration 16.

CAUTION: DO NOT USE EXCESSIVE PRESSURE ON EXTERIOR CLAMP, DAMAGE MAY RESULT TO ULTREX.



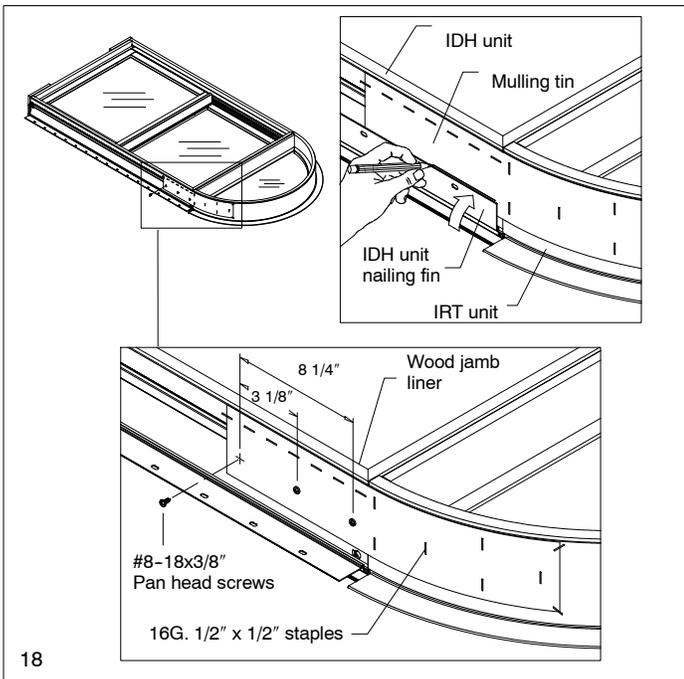
16

- Lightly clamp units together on interior (use wood blocks to protect interior near each end to hold two mull units in place). Fasten interior of mull units with 1/2" x 1" 16 gauge staples spaced every 4" (102). See illustration 17.

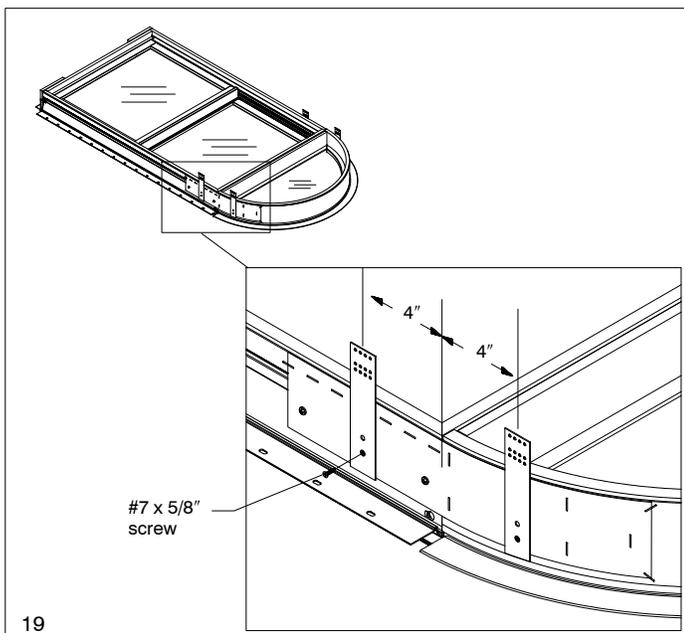


17

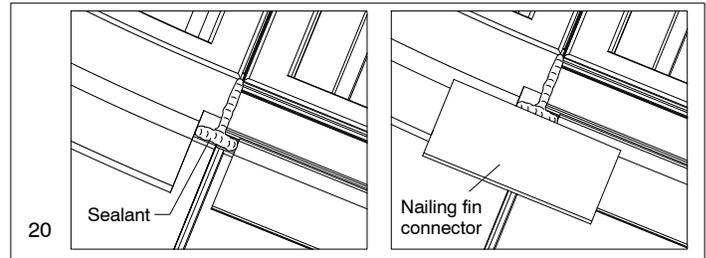
6. Center mulling tin over mullion 3/8" (10) from interior and fasten to IRT unit and wood jamb liner of IDH unit with 1/2"x1/2" staples following the pattern shown in illustration 18. Fold the jamb nailing fin over the mulling tin and mark a line with a pencil as shown. Using the pencil line as a reference, pre-drill at screw locations indicated with a 7/64" drill bit through the first layer of the double hung Ultrex jamb as shown. Fasten with 3/8" pan head screws.



7. Install structural brackets 4" (102) from the mull on both sides. Attach each of the brackets with the #7 x 5/8 screws provided. Follow the instructions provided with the brackets for more detailed installation. See illustration 19.



8. Apply silicone sealant at the mullion from the frame exterior edge to the drip cap/nailing fin kerf and across the kerf as shown in illustration 20. Apply nailing fin connector at the jambs by removing the paper backing from the connector and pressing into place. See illustration 18. If applicable, jamb extension can now be installed. Follow installation instructions for installing unit into rough or masonry opening.



NOTE: It is important that care be exercised when moving a mullied assembly from the mullion area to the rough opening. Interior mull trim should be applied after unit is completely installed and interior trim is applied.

2 WIDE x 2 HIGH MULLION KIT

Parts Supplied With Kit:

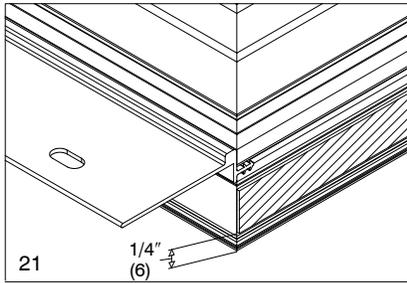
ILLUSTRATIONS (not to scale)	DESCRIPTION AND COLOR	PART/PROFILE NUMBER
	W9425 Structural mull tie Douglas Fir 96" (2430)	31509496
	W1241 Vertical interior mullion trim 120" (3048) White Interior Bare	39249099 32249099
	W1242 Horizontal interior mullion trim 120" (3048) White Interior Bare	39249199 32249199
	W8952 Wood mullion tie (length varies)	See Parts Manual
	A330 Mullion pin 150" (3810)	11103250
	Mullion sealant foam tape 1 sided adhesive 96" (2438)	11869508
	Integrity structural masonry bracket 6" 10"	11860014 11860009
	Nailing fin connector	10500213
	#7 x 5/8" Phillips flat head screws	11800758

YOU WILL NEED TO SUPPLY

Safety glasses	Hearing protection
Phillips screwdriver	Hammer
Power drill	3/16" (5) drill bit
Tape measure	1/4" (6) drill bit
Clamps	Pieces of wood
Hacksaw	3/32" drill bit
1/2" crown x 1" leg 16 gauge staples with gun	
3/16" crown x 1" 18 gauge staples with gun	
Silicone sealant w/gun	

Mulling Procedures - Upper 2 Wide Assembly

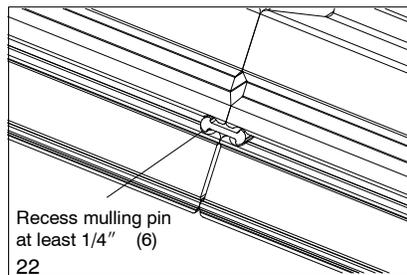
1. Lay the two in sash transoms that will be mulled above the two double hung units on a flat surface in the desired mulling configuration (interior facing up). Remove nailing fin from sill and side jambs that will be mulled together.



Apply mull sealing tape along the full length of one jamb to be mulled ensuring it is located 1/4" (6) from the exterior edge of the Ultrex frame as shown in illustration 21.

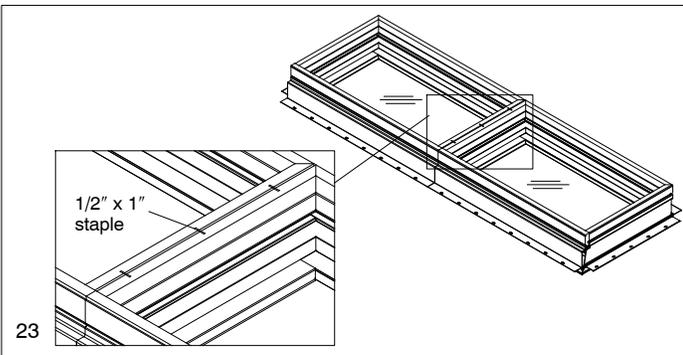
IMPORTANT: Units should be flush and square with each other.

2. Apply clamps on the interior near each end of the mullion (use pieces of wood to protect interior). Slide aluminum mulling pin into nailing fin drip cap kerf. Make sure mulling pin is recessed at least

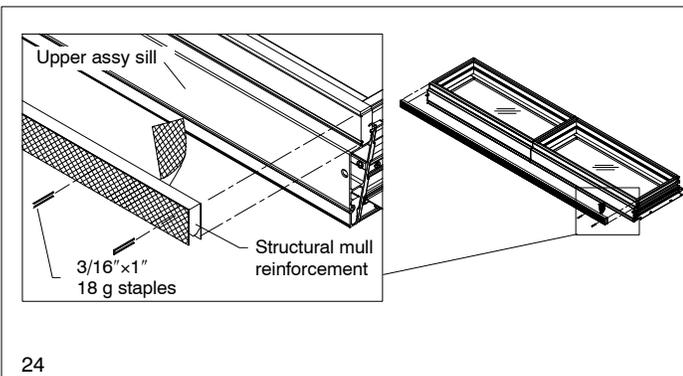


1/4" (6) on each end to allow for sealant placement and horizontal mulling pin application later. See illustration 22.

3. Fasten interior with 1/2" x 1" 16 gauge staples every 4" (102). Clamp and fasten along the entire length of the mullion. See illustration 23.

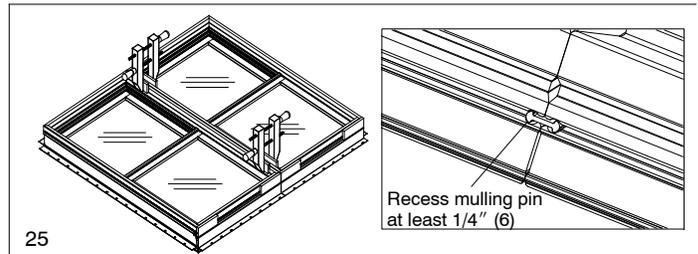


4. Remove paper backing from adhesive tape on one side of structural mull tie and carefully install on sill of upper two wide assembly. **Do not remove paper backing from tape on bottom side of mull reinforcement at this time.** Attach reinforcement to wood sill liner with 3/16" x 1" 18 gauge staples spaced every 6" (152). Carefully set upper unit aside. See illustration 24.

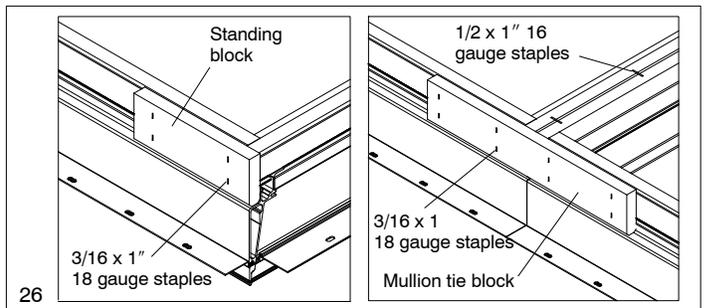


Lower 2 Wide Assembly

5. Lay the lower double hung frames on a flat surface in the desired mulling configuration (interior facing up). Remove nailing fin and drip cap from head jambs and side jambs that will be mulled together. Apply mull sealing tape along the entire length of one jamb to be mulled ensuring it is located 1/4" (6) from the exterior edge of the Ultrex frame as shown in illustration 25.
6. Lightly clamp units together on interior on each end of the mullion (use pieces of wood to protect interior). Slide aluminum mulling pin into nailing fin/drip cap kerf. Make sure mulling pin is recessed at least 1/4" (6) on each end to allow for sealant placement and horizontal mulling pin application later. See illustration 25.

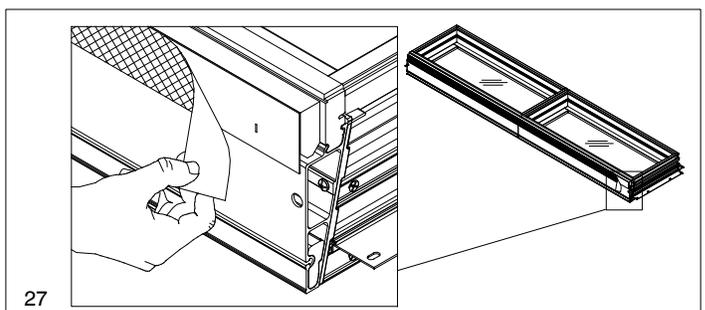


7. Apply a third clamp and wood blocks to interior as needed. Make sure mulled units are flush and square at the sill and jamb liners. Fasten interior of mulled units with 1/2" x 1" 16 gauge staples spaced every 4" (102). Remove the wood standing blocks at the sills near the mullion. Replace with a wood mullion tie block (W8952) and attach with 3/16" x 1" 18 gauge staples. See illustration 26.

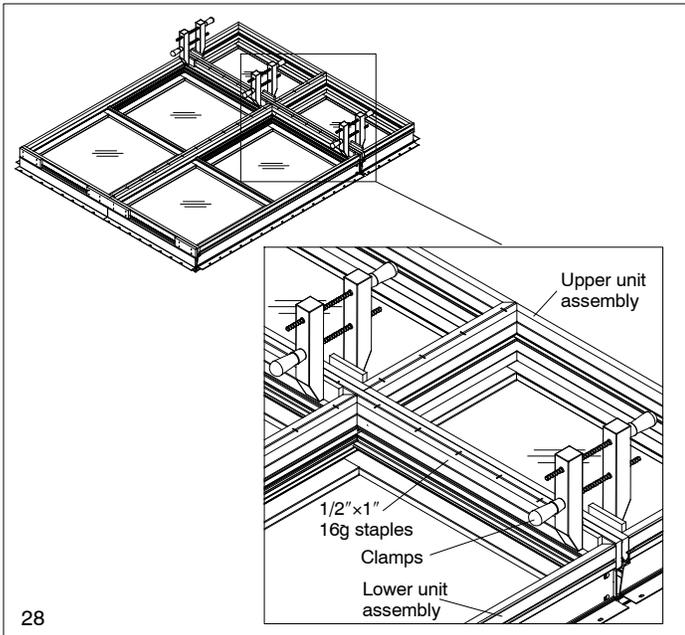


2 Wide 2 High Unit Assembly

8. Position upper and lower mulled units in the desired mulling configuration (interior facing up). Apply mull sealing tape along the entire length of the head jamb of mulled lower assemblies ensuring that it is located 1/4" (6) from the exterior edge of the Ultrex frame.
9. Remove paper backing from two sided adhesive tape on structural mull tie. See illustration 27. Set the upper and lower assemblies together in the desired configuration so they are flush and square with each other. Lightly clamp unit assemblies together on interior at each end of the mullion (use pieces of wood to protect interior). Slide horizontal aluminum mulling pin into nailing fin/drip cap kerf. Make sure mulling pin is recessed at least 1/4" (6) on each end to allow for sealant placement later.

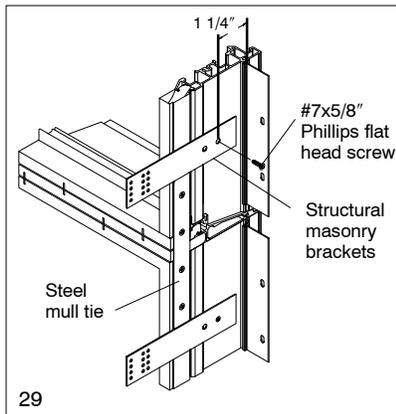


10. Apply a third clamp and wood blocks to interior as needed. Make sure mullied assemblies are flush and square at the sill and jamb liners. Fasten interior of mullied assemblies with 1/2" x 1" 16 gauge staples spaced every 4" (102). See illustration 28.



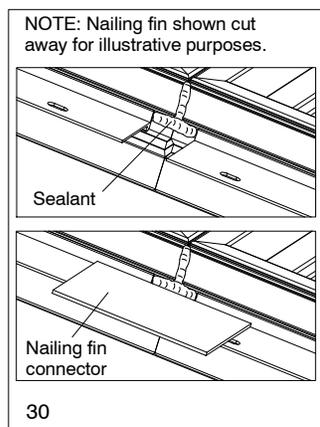
11. Apply steel mullion ties at mullion junctions on side jambs and head jamb with two #7 x 5/8" Phillips flat head wood screws into each unit. See illustration 29.

12. Measure and mark on head jambs, sills, and jambs on both sides of steel mullion ties 1 1/4" (32) from extended nailing fin and carefully drill a 3/32" (2) pilot hole through the first layer of the Ultrex frame. Install structural masonry brackets on both sides of steel mullion tie and attach with one #7 x 5/8" Phillips flat head screw as shown in illustration 29.



NOTE: Interior mullion trim should be applied after unit is completely installed and interior trim is applied

13. Apply silicone sealant at all mullions from frame exterior edge to the drip cap/nailing fin kerf and across the kerf over the mulling pin as shown in illustration 30. Apply nailing fin connectors by removing the paper backing from the connector and pressing into place. See illustration 30. If applicable, jamb extension can now be installed. Follow installation instructions for installing unit into rough or masonry opening.



IRTM DOUBLE HUNG HORIZONTAL MULLION KIT

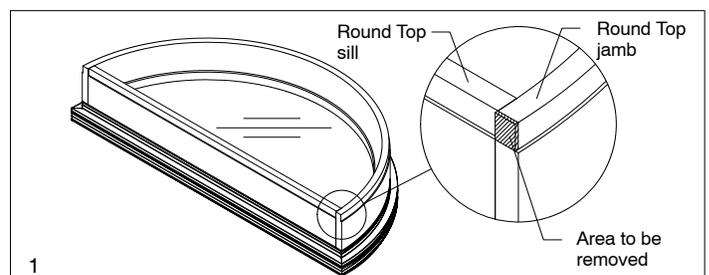
Parts Shipped With Kit		
ILLUSTRATIONS (not to scale)	DESCRIPTION AND COLOR	PART/PROFILE NUMBER
	2 - W9295 Structural Mull Tie 84" (2134)	31510984
	2 - Pieces Mulling Tin 3 1/2" x 16" (64x406)	02070302
	2 - Foam nailing fin connectors	10500213
	1 - Mull sealant foam tape one sided adhesive 96" (2438)	11869508
	1 - A330 Aluminum mulling pin 71 1/2" (1816)	15344273
	1 - W1242 Mull trim 96" (2438) Bare White	31501296 39201296
	4 - Structural brackets For RT2 or RT6 over IDH 6" 10"	11860014 11860009
	4 - #7 x 5/8" Phillips flat head screws	11800758
	6 - #8x3/8 Phillips pan head wood screws	05050423

YOU WILL NEED TO SUPPLY

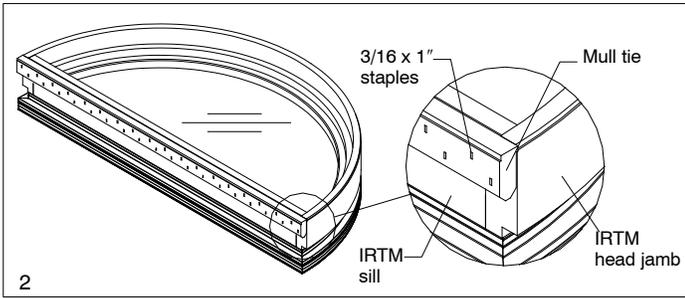
Safety glasses	Hearing protection
Hammer	Clamps
Hacksaw	Silicone sealant w/gun
1/2"x1/2" 16 gauge staples	3/16" drill bit
Power drill/driver w/ #2 Phillips head bit	
1/2" crown x 1" leg 16 gauge staples w/gun	
3/16" crown x 1" leg 18 gauge staples w/gun	

Mulling Procedures

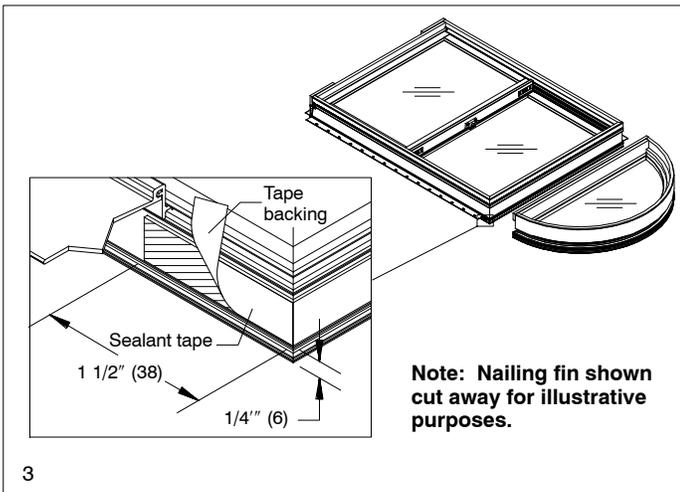
1. Lay frames on a flat surface in the desired mulling configuration (interior facing up). Remove nailing fin /drip cap and any shipping blocks from mullion locations. Using a wood saw, cut the ends of the jambs on the IRTM so that it is flush with the sill. See illustration 1.



2. Attach mull structural mull tie to the ends of the IRTM sill, flush to the interior, with 3/16" x 1" staples. See illustration 2.

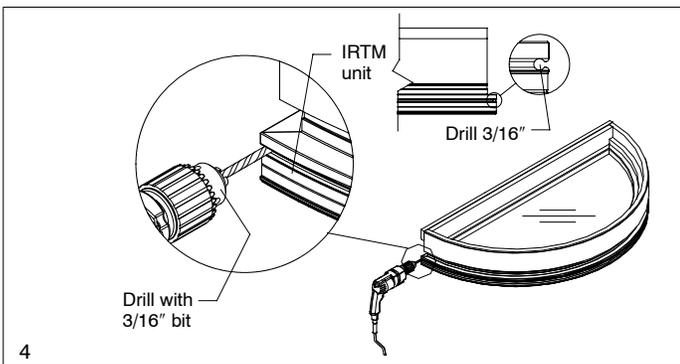


3. Apply mull sealing tape to the full length of the mullion on the double hung unit head jamb, ensuring that it is located 1/4" (6) from the exterior edge of the Ultrex frame. Wrap tape approximately 1 1/2" around ends. See illustration 3. Remove paper backing from mull tape.

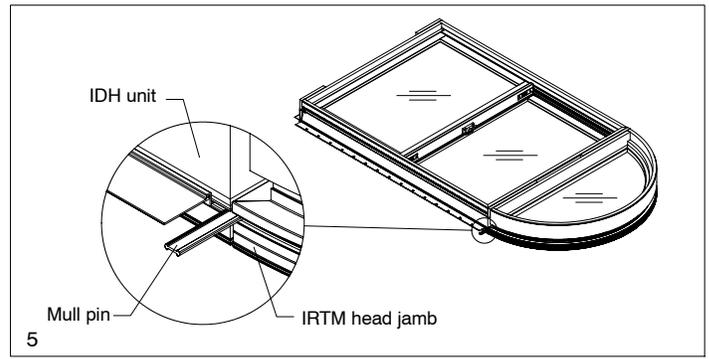


4. Drill out end of nailing fin/drip cap kerf on IRTM units with a 3/16" drill bit. This will allow the installation of the mulling pin. See illustration 4.

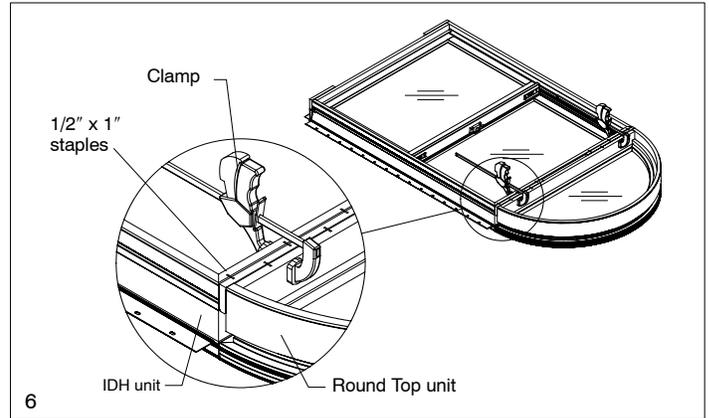
NOTE: If mulling a direct glaze polygon to an IRTM, drill out the polygon nailing fin/drip cap kerf as well.



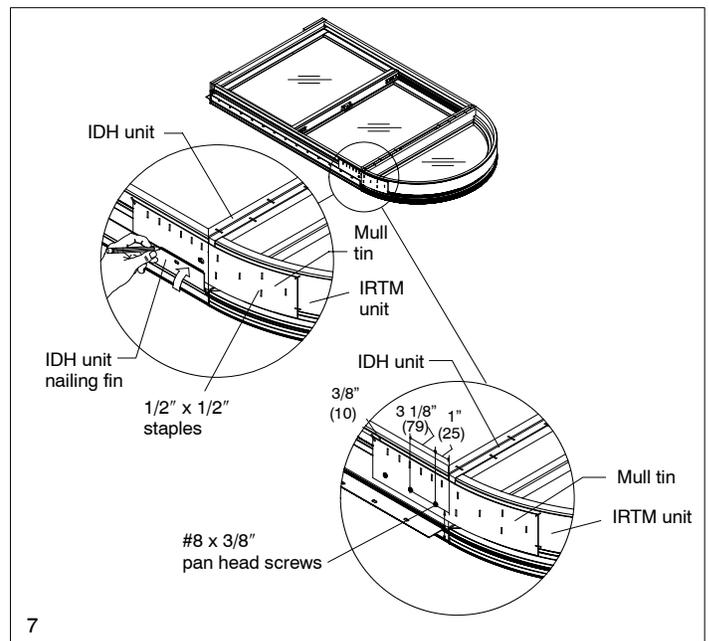
5. Measure the width of the mullion and cut mulling pin 1/2" (13) shorter with a hacksaw. Place frames together and slide aluminum mulling pin into the nailing fin/drip cap kerf. A hammer may aid in the application of the mull pin. The mull pin ends must be recessed 1/4" (6) to allow sealant application later. See illustration 5.



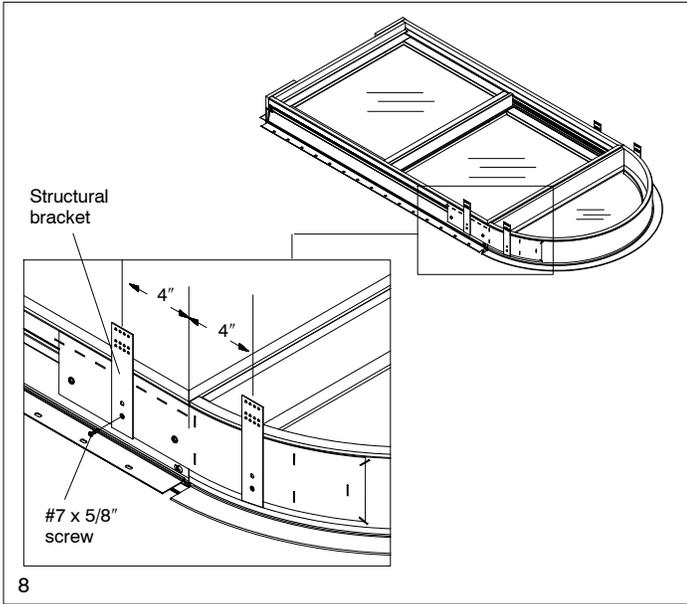
6. Lightly clamp units together at the ends of the mullion. Fasten interior of mullied units with 1/2" x 1" 16 gauge staples 1" from edge of jamb and spaced every 4" (102). See illustration 6.



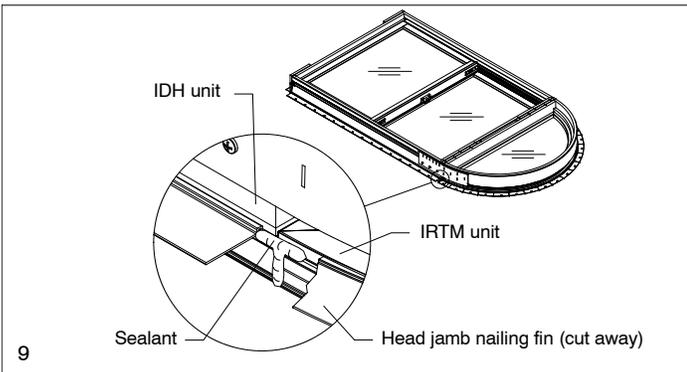
7. Center mulling tin over mullion 3/8" (10) from interior and fasten to IRTM unit and wood jamb liner of IDH unit with 1/2"x1/2" staples following the pattern shown in illustration 7. Fold the jamb nailing fin down over the mulling tin and mark a line with a pencil as shown. Using the pencil line as a reference, pre-drill at screw locations with a 7/64" drill bit through the first layer of the double hung Ultrex jamb as shown. Fasten with #8 x 3/8" pan head screws.



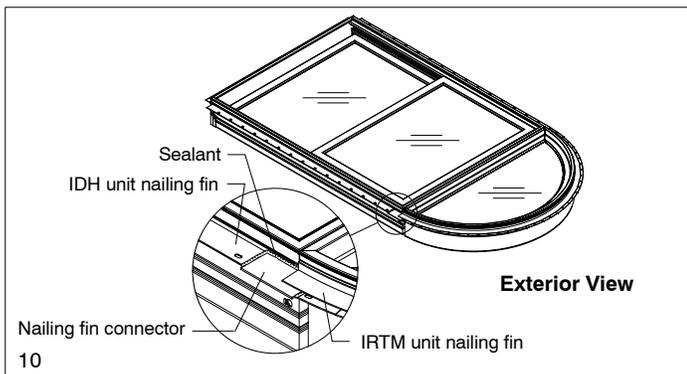
8. On configurations with RT2 or RT6 shapes, apply structural mull brackets 4" from each side of mullion. Attach each of the brackets with the #7 x 5/8" screws provided. Follow instructions provided with brackets. See illustration 8.



9. Apply silicone sealant at the mullion frame exterior edge to the drip cap/nauling fin kerf and across the kerf over the mulling pin as shown in illustration 9. Apply nauling fin connector at the jambs by removing the paper backing from the connector and pressing into place.



10. Seal around the edge of the connectors as shown in illustration 10. If applicable, jamb extension can now be installed. Follow installation instructions for installing unit into rough or masonry opening.



NOTE: It is important that care be exercised when moving a mulled assembly from the mullion area to the rough opening. Interior mull trim should be applied after unit is completely installed and interior trim is applied.

RT 2 OR RT 6 BESIDE IDH MULLION KIT

Parts Shipped With Kit

ILLUSTRATIONS (not to scale)	DESCRIPTION AND COLOR	PART/PROFILE NUMBER
	1 - W8952 Mull splice block 12" (305)	33732917
	2 - Pieces Mulling Tin 3 1/2" x 16" (64x406)	02070302
	2 - Foam nailing fin connectors	10500213
	1 roll - Mull sealant foam tape One sided adhesive 96" (2438)	11869508
	1 - A330 Aluminum mulling pin 71 1/2" (1816)	15344273
	1 - W1241 Mull trim 120" (3048) Bare White	32249099 39249099
	4 - Structural brackets For RT2 or RT6 over IDH	11860014
	4 - #7 x 5/8" Phillips flat head screws	11800758
	6 - #8x3/8 Phillips pan head wood screws	05050423

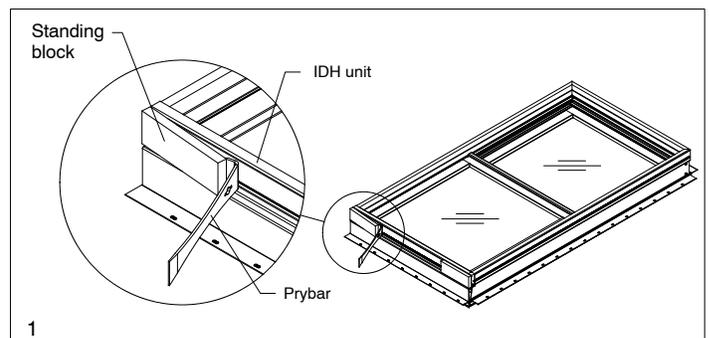
YOU WILL NEED TO SUPPLY

Safety glasses
Hammer
Hacksaw
Pry bar
Power drill/driver w/ #2 Phillips head bit
1/2" crown x 1" leg 16 gauge staples w/gun
3/16" crown x 1" leg 18 gauge staples w/gun
1/2"x1/2" 16 gauge staples

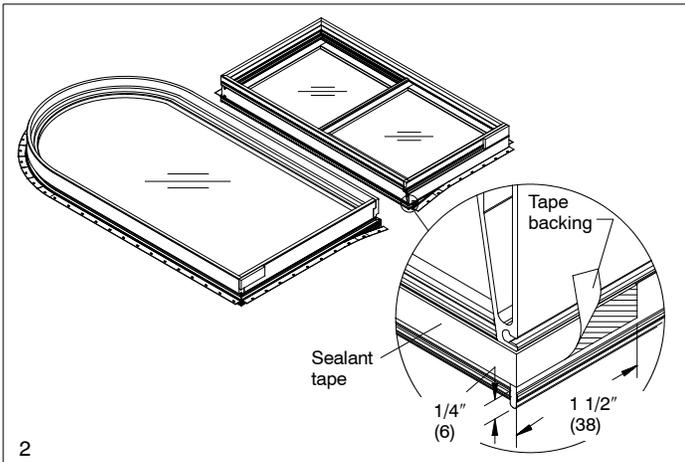
Hearing protection
Clamps
Silicone sealant w/gun
3/16" drill bit

Mulling Procedures

1. Remove the wood standing blocks at the sills where the units will be mulled. See illustration 1.



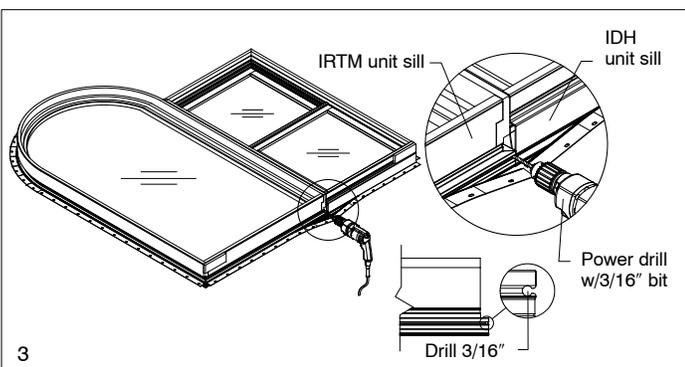
- Lay frames on a flat surface in the desired mulling configuration (interior facing up). Remove nailing fin from mullion locations. Apply mull sealing tape along the entire length of the IDH unit ensuring it is located 1/4" (6) from the exterior edge of the Ultrex frame. Wrap tape around approximately 1 1/2" (38) and remove paper backing. See illustration 2.



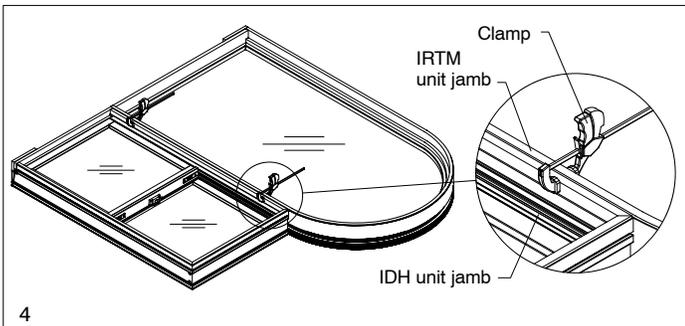
- Partially pull nailing fin/drip cap from sills at mullion to expose side jamb nailing fin kerf and allow for mulling pin installation later.

NOTE: If mulling a direct glaze polygon to an IRTM, drill out the polygon nailing fin/drip cap kerf as well.

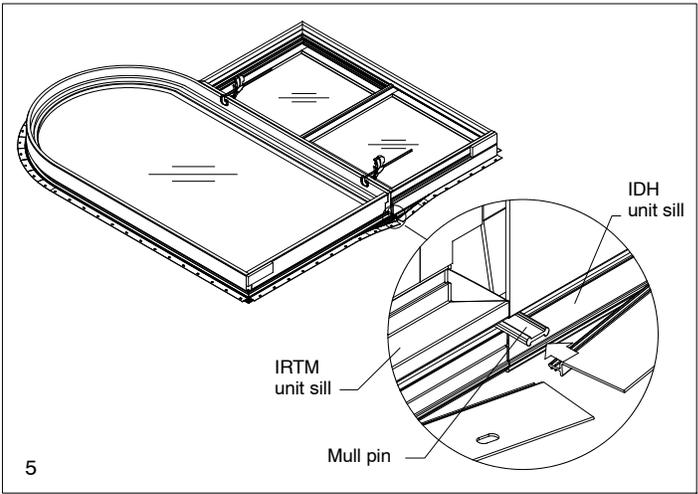
- Drill out end of nailing fin/drip cap kerf on IRTM units with a 3/16" drill bit. This will ease the installation of the mulling pin. See illustration 3.



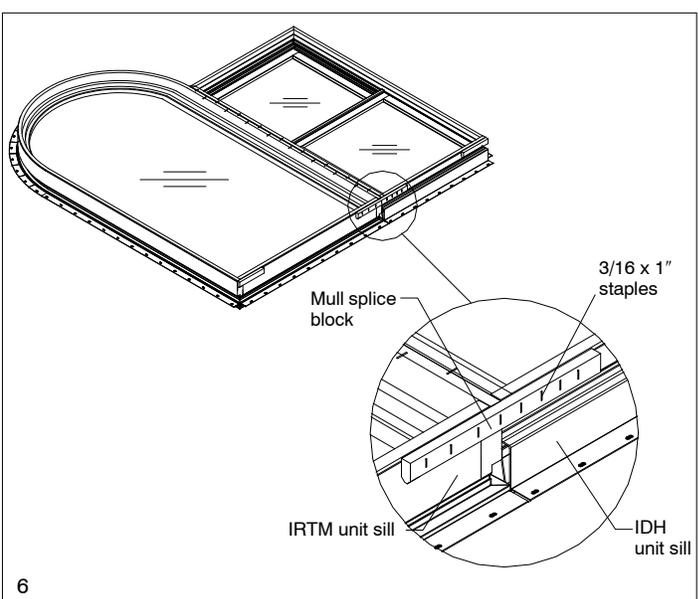
- Position the units together in the desired configuration. Check to be sure that frames at both ends of the mullion are flush and the nailing fin kerfs are aligned. Lightly clamp units together on interior near each end to hold two mullied units in place. See illustration 4.



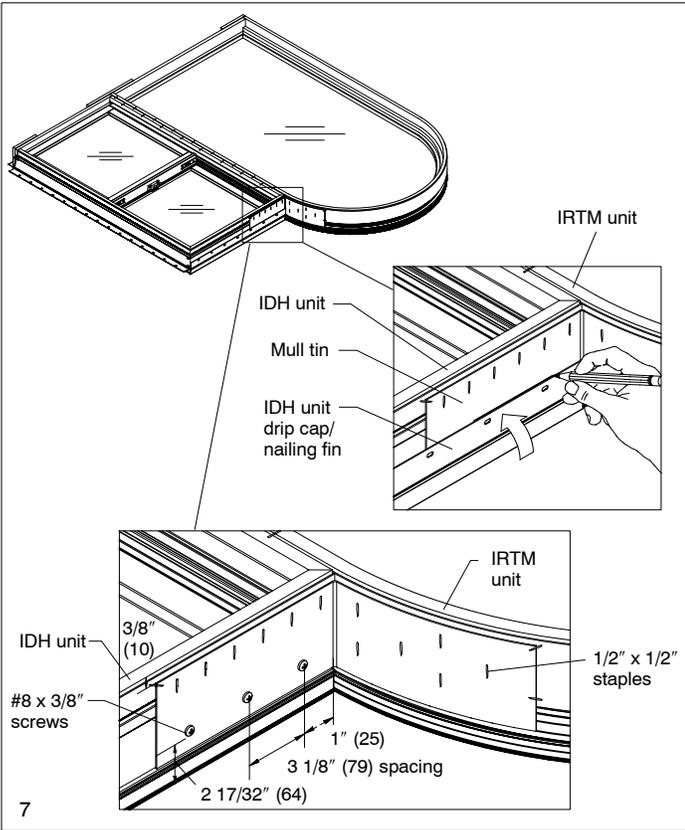
- Measure length of mullion at exterior, subtract 1/2" (13) and cut mulling pin to size with a hacksaw. Slide the mulling pin in the full length of the mullion. A hammer may aid in the application of the mull pin. The mull pin ends must be recessed 1/4" (6) to allow sealant application later. See illustration 5.



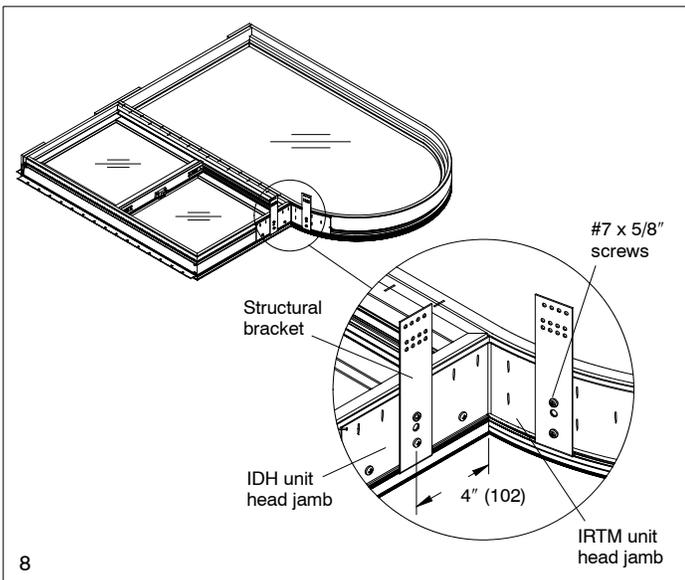
- Join the wood frame members along the interior of the mullion. Apply additional clamps as needed. Make sure mullied units are flush and square at the sill and jamb liners. Fasten with 1/2" x 1" 16 gauge staples spaced every 4" (102). Center the mull splice block over the mullion at the sill and attach with 3/16" x 1" 18 gauge staples. See illustration 6.



8. Center and attach mulling tin over mullion and fasten securely with 1/2" x 1/2" 16 gauge staples to jamb of round top unit. (For ease of installation, crease the mulling tin in half prior to installing.) Fold the jamb nailing fin down over the mulling tin and mark a line with a pencil as shown. Using the pencil line as a reference, pre-drill at screw locations with a 7/64" drill bit through the first layer of the double hung Ultrex jamb as shown. Fasten with #8 x 3/8" pan head screws. See illustration 7.

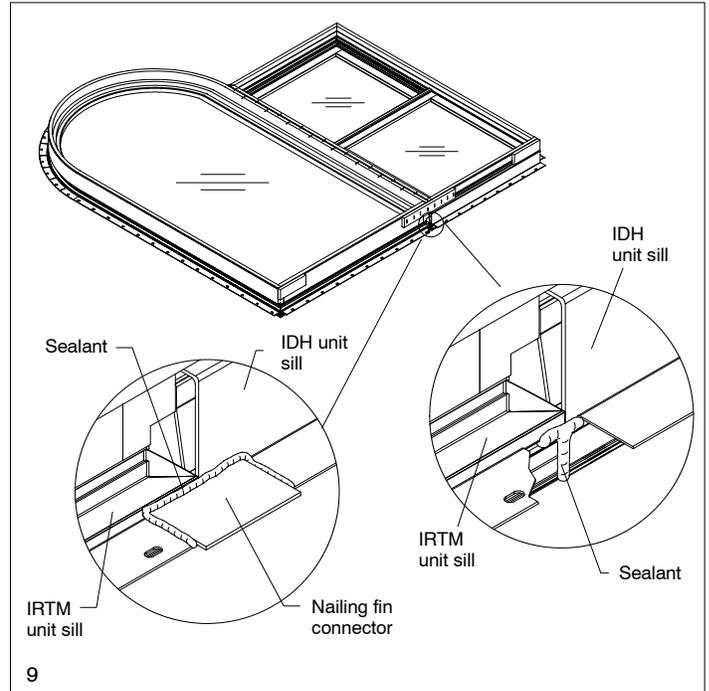


9. Install structural brackets 4" from each side of mullion on both jambs. Attach each of the brackets with the #7 x 5/8" screws provided. Follow instructions provided with brackets. See illustration 8.



8

10. Apply silicone sealant at the mullion from the frame exterior edge to the drip cap/nailing fin kerf and across the kerf as shown in illustration 9. Apply nailing fin connectors to nailing fin at mullion and seal around the edge of the installed connectors.



9

11. If applicable, jamb extension can now be installed. Follow installation instructions for installing unit into rough or masonry opening. Interior mull trim should be applied only after unit is completely installed and interior trim is applied.

NOTE: It is important that care be exercised when moving a mulled assembly from the mullion area to the rough opening.