

| STANDARD PARTS SHIPPED | | |
|---------------------------------|--|---|
| ILLUSTRATIONS (not to scale) | DESCRIPTION AND COLOR | PART/PROFILE NUMBER |
| | Clad flat casing | A2754 |
| | Clad subsill (window products only) | A246 |
| | Endcap 2 – Windows 4 – Doors | SW 18723099 BZ 18615403 PB 18615303 BN 18615203 EG 18615503 |
| | 2–Fastening clips | 18614502 |
| | 4–Foam plugs | 10500074 |
| | Connecting Barb | V087 |
| | Frame kerf weatherstrip | 15910100 |
| | Installation brackets 6" 11850048 9" 11850047 15" 11850040 | |
| | #8 x 5/8" Phillips pan head stainless steel screws | 11800498 |
| | #10 x 3/4" Phillips pan head stainless steel screws | 02050545 |
| | #8 x 1 1/2" Phillips stainless steel screws | 11808110 |
| | 1/8" Aluminum rivets with 5/8" grip range (into subsill for glider units only) | 01060757 |

YOU WILL NEED TO SUPPLY

| | |
|---|---|
| Safety glasses | Hearing protection |
| Rubber mallet | Power drill/driver w/Phillips screw bit |
| Utility knife | Screen door spline roller |
| Hacksaw | Chisel |
| Hammer | 7/64" Drill bit |
| 3/16" Drill bit | Rivet gun (clad gliders only) |
| Power miter saw | Isopropyl alcohol |
| Sealant – Grade NS Class 25 per ASTM C920 with gun. | |

ATTENTION: Specifications and technical data are subject to change without notice.

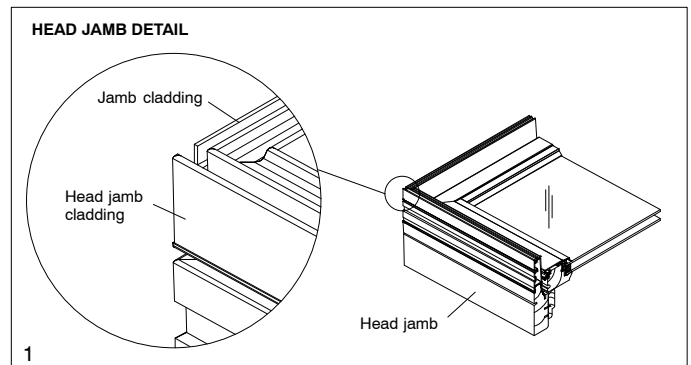
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CLAD FLAT CASING FRAME PREPARATION

1. Lay unit on a flat surface with the exterior side of the unit facing upward. *NOTE: If the window or door product was prepped at the factory, then skip to Step 4. Remove factory installed nailing fin and discard.*

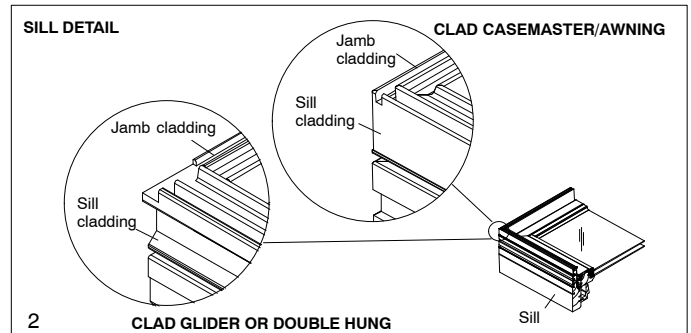
IMPORTANT: Check diagonal measurements to ensure squareness of the unit or assembly.

2. It will be necessary to notch the frame accessory kerf prior to installing the clad flat casing. This will allow head jamb casing to snap into position. Both jamb corners must be notched in a horizontal fashion along the head jamb by using a hacksaw or chisel as shown in illustration 1.



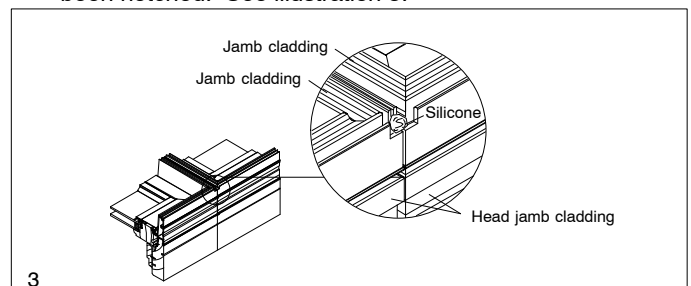
3. The jamb corners at the sill (see exceptions noted below) must be notched as shown in illustration 2, as indicated by specific product types.

NOTE: Do not notch sill jamb corners on door products. Additionally, mullled Double Hung or Glider products should not be notched on the sill at the mull joint.

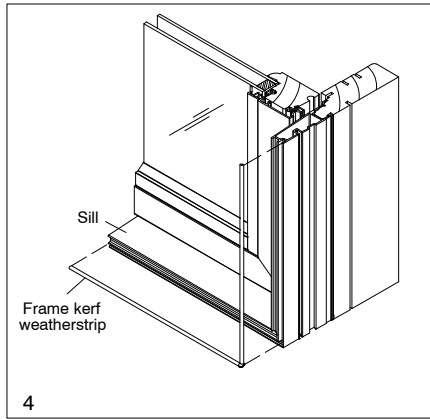


4. It will be necessary on multiple units to ensure mull cap does not extend into the kerf. Remove excess material in a horizontal fashion to open the kerf. Cut this notch using a hammer and chisel. See illustration 3. On space mullled units where A148 outside frame trim is installed, notching is not necessary. Remove outside trim from sill, head jamb, and/or jambs before proceeding.

5. Apply silicone sealant at all mull joints where cladding has been notched. See illustration 3.



6. Install frame kerf weatherstrip around frame kerf perimeter, using a screen spline roller. Make sure there is no gap at the splice. If possible, splice at top corners. Be sure not to allow any twists or creases when installing weatherstrip. See illustration 4.



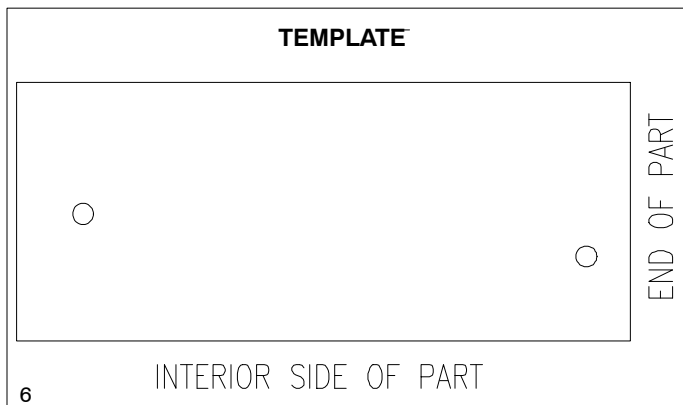
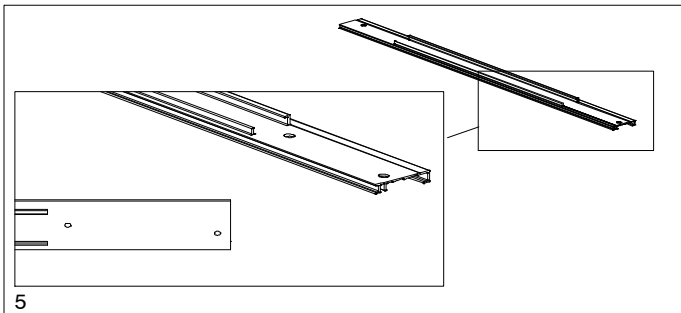
NOTE: If you are installing flat casing on a door, skip to Step 11.

7. Apply small diameter sill kerf weatherstrip in sill kerf using a putty knife. Trim flush with edge of jamb. See illustration 4.

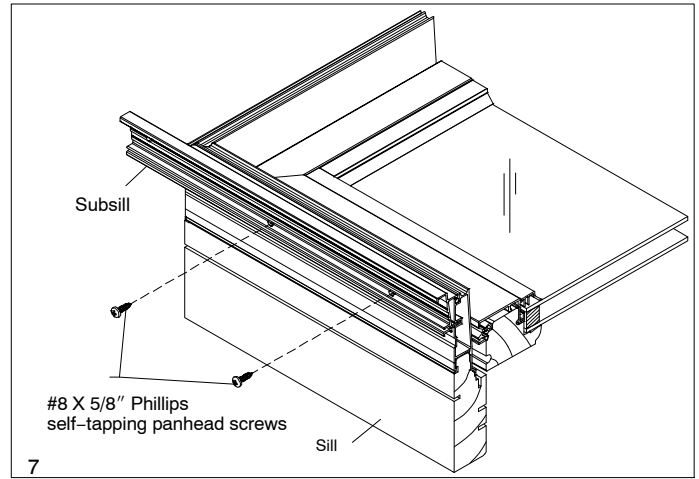
FABRICATION PROCEDURES

CAUTION: To avoid binding and risk of possible injury, place a shim under Clad Flat Casing (CFC) while cutting to provide support, while positioned in the power miter saw. This applies to all steps below that involve cutting on a power saw. Always wear proper eye and ear protection while cutting.

8. Measure outside width of unit and add 6" (152). Using a power miter saw or hacksaw cut subsill to the calculated length. Measure and mark 3 3/16" (81) from the ends of the subsill. Remove ridged material with a hacksaw or chisel as shown in illustration 5. Using the template in illustration 6 mark ends of subsill and drill pilot holes with a 7/64" drill bit through top of subsill.

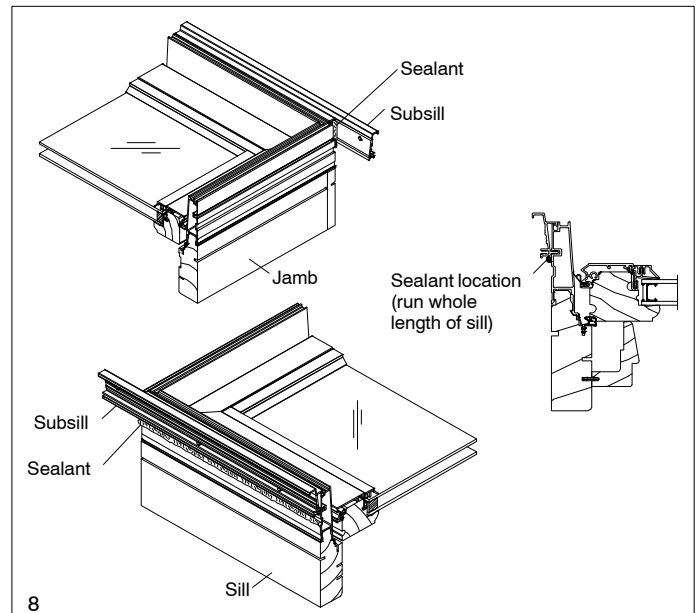


9. Place subsill into sill kerf, ensuring subsill extends past the jambs an equal distance on each side. Secure with #8 x 5/8" self tapping pan head screws every 6-8" (152-203). Use driver with Phillips bit. See illustration 7.

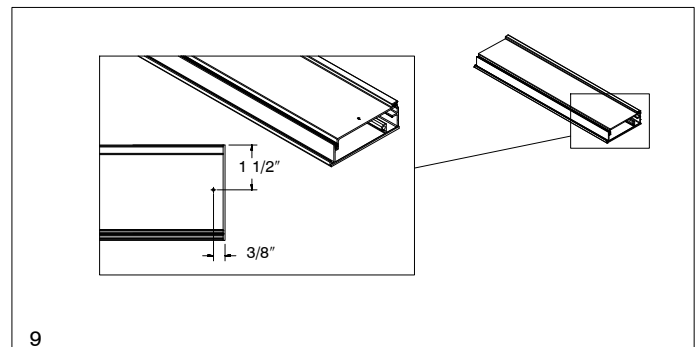


NOTE: If applying subsill to a clad Glider unit do not use #8 x 5/8" screws. Instead, attach with 1/8" aluminum rivets.

10. Apply silicone sealant at the point where the subsill and jamb meet and continue under the sill running a bead the full length of the sill. See illustration 8.

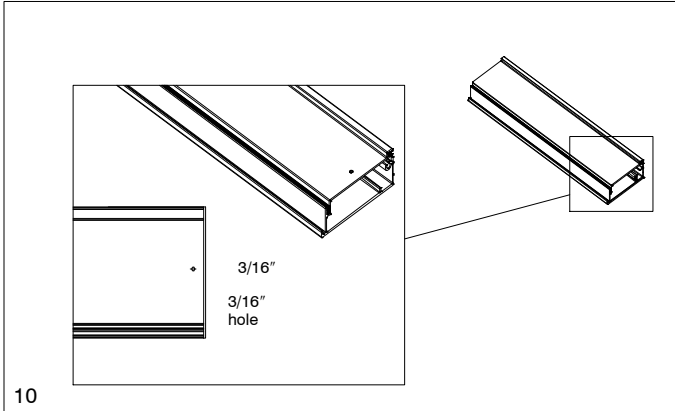


11. Using the width of the subsill as a guide, cut head jamb clad flat casing to length. Measure and mark on the back side of head jamb casing 1 1/2" (38) from the top and 3/8" (10) from the ends. drill a pilot hole with a 7/64" drill bit at mark. See illustration 9.

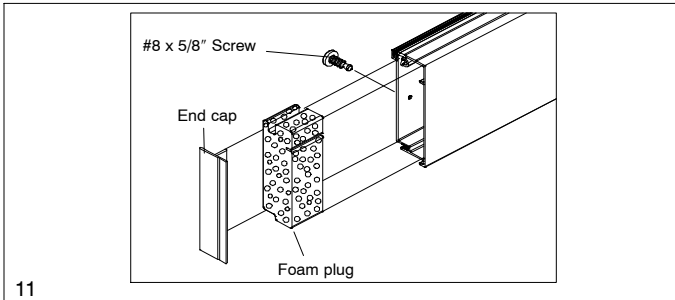


NOTE: It may be desirable to remove approximately 1/16" (2) off the back side of the head jamb casing ends. This will allow the end caps to recess at the end of the casing. This is easiest done by placing a block of wood between the casing (back side up) and the fence on a chop saw. Be careful not to cut through the face of the casing.

12. Measure and mark 3/16" (5) from the end of the head jamb casing below the accessory kerf. drill a 3/16" hole through the first wall of the casing. This will allow for sealant application later. See illustration 10.

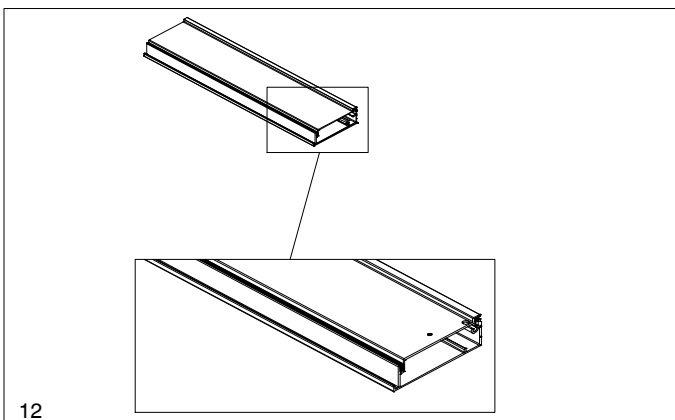


13. Insert foam plugs and end caps into head jamb casing as shown in illustration 11. Attach end caps to head jamb casing with #8 x 5/8" screws. Use the holes drilled in step 11.

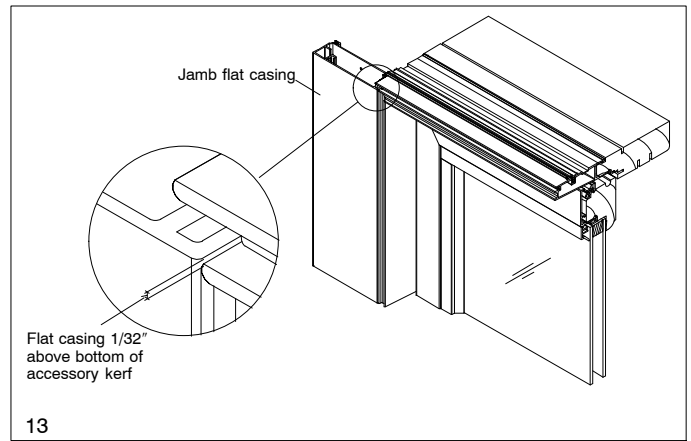


NOTE: If installing flat casing on a door product skip to step 15.

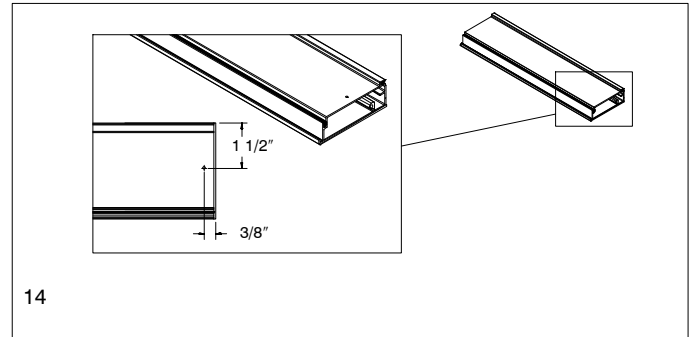
14. Using a power miter saw, cut an 8 degree bevel in one end of both jamb casings where they will contact the subsill. The long side of the bevel will always be to the exterior side as shown in illustration 12.



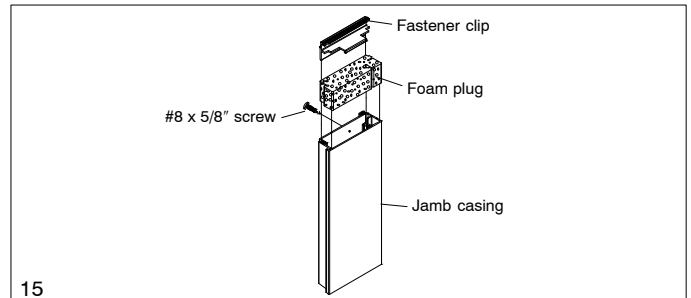
15. Lay one of the casings along the jamb kerf ensuring the bottom is snug against the subsill of the window product or flush with sill on door products.
16. Using the bottom of the accessory kerf as a reference point, mark 1/32" (1) above this point. See illustration 13. Remove casing from frame and cut jamb casing at 90 degrees. Repeat this procedure for the other jamb casing as well.



17. Measure and mark on the back side of jamb casing 1 1/2" (38) from the side and 3/8" (10) from the top. Drill a pilot hole with a 7/64" drill bit at mark. See illustration 14.

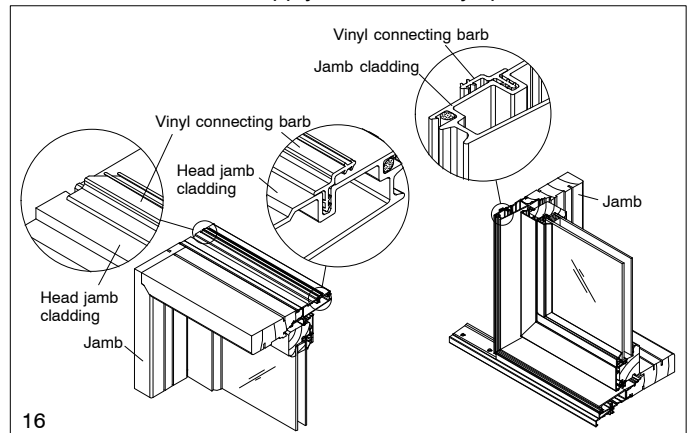


18. Insert foam plugs and fastener clips in top of jamb casing as shown in illustration 15. Attach fastener clip with #8 x 5/8" screws using holes drilled in step 17.



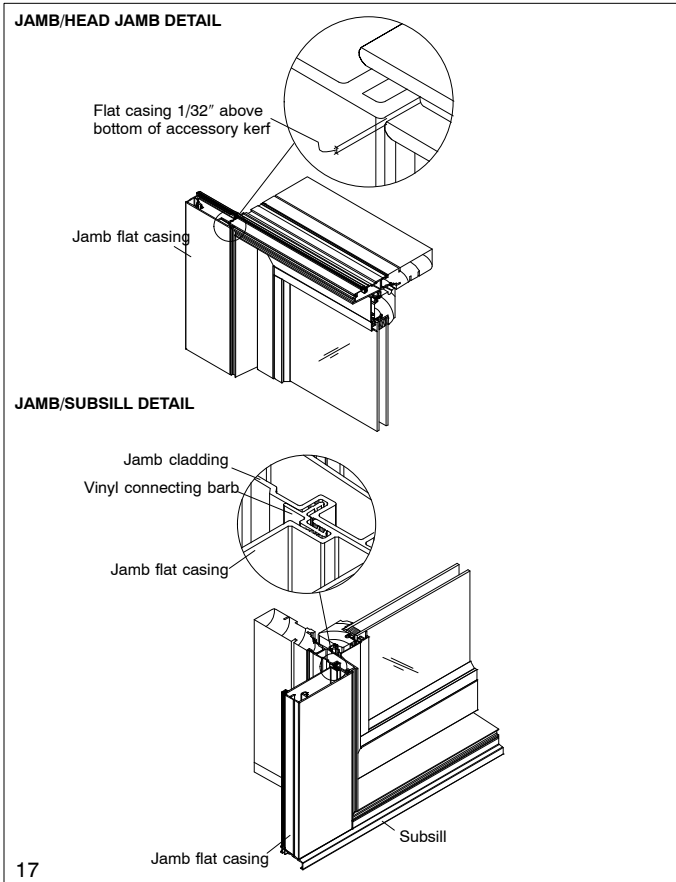
ATTENTION: When installing flat casing on door products, it may be desirable to cap off the sill end of the jamb casing. To do this, repeat steps 12 and 13 (foam plug not required).

19. Apply connecting barb to the jambs and head jamb in jamb kerf as shown in illustration 13. Push into position approximately 1/8" (3) from corner of frame. The connecting barb should be mitered to 45 degrees on the ends. Be sure to apply sealant at any splice.

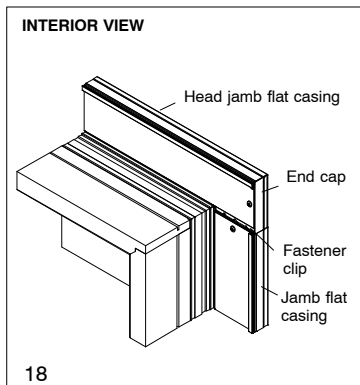


INSTALLATION PROCEDURES

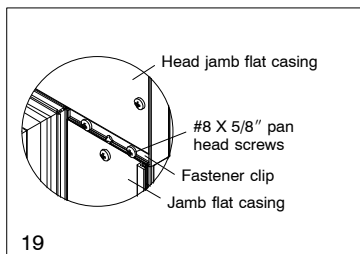
20. Snap flat casing jamb assemblies (with fastener clip at top) into position in frame kerf ensuring top of flat casing is $1/32''$ above bottom of accessory kerf as shown in illustration 17. Make sure connecting barb seats into place.



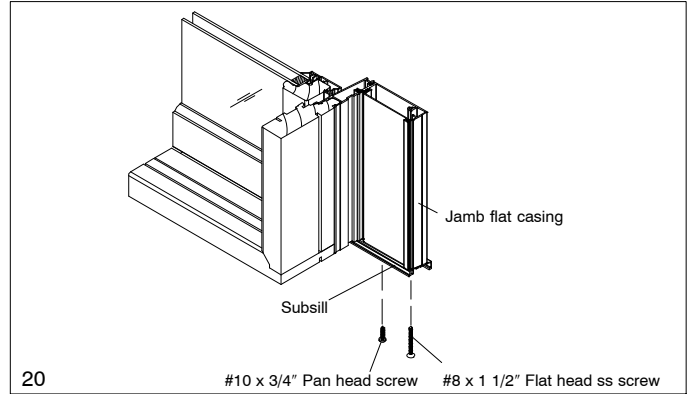
21. Next apply head jamb flat casing to frame and jamb casing assembly. Ensure head jamb casing is flush on both ends with side of jamb casing. Push firmly down onto the connecting barb and twist upward slightly on the outside edge of jamb casing assembly to allow the fastener clip to seat properly into the head jamb casing kerf. See illustration 18.



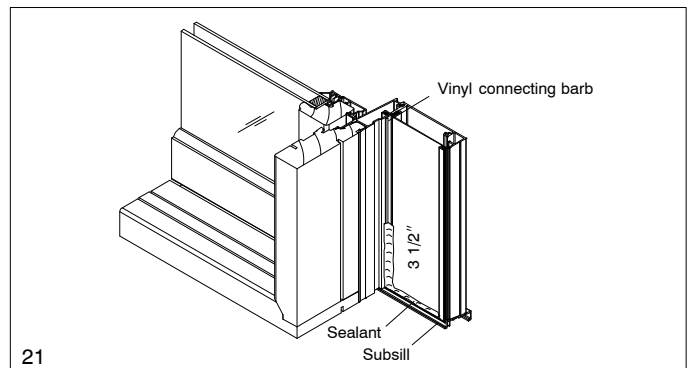
22. Install $\#8 \times 5/8''$ pan head screws into fastener clips to secure butt joint firmly together. See illustration 19.



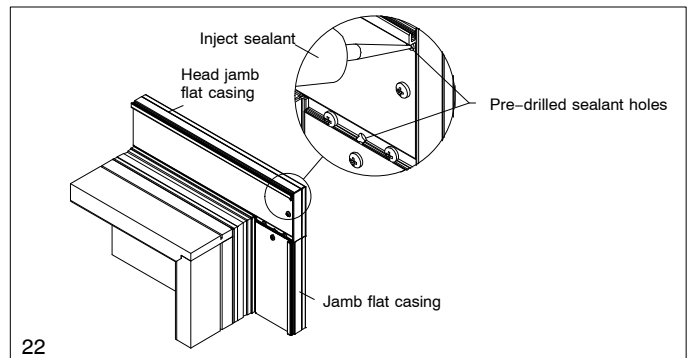
23. Secure subsill to bottom of jamb flat casing (window products only) fastening with the $\#10 \times 3/4''$ screw (closest to the unit frame) and the $\#8 \times 1 1/2''$ screw. See illustration 20.



24. Apply and tool out a $3 1/2''$ (89) long bead of sealant along the subsill and jamb flat casing as shown in illustration 21.



25. Inject sealant into predrilled hole in fastener clip and head jamb casing to seal the butt joint. When back pressure or squeeze out is evident you have applied adequate sealant. See illustration 22. Remove excess sealant with isopropyl alcohol.



NOTE: Units must be installed using installation brackets. Clad flat casing *is not intended* to be used to fasten the unit in the opening.

26. Apply installation brackets per supplied instructions if not applied at factory. Install door or window product into rough opening per supplied installation instructions.

IMPORTANT: Apply drip cap purchased from your Marvin dealer or supplied by others.