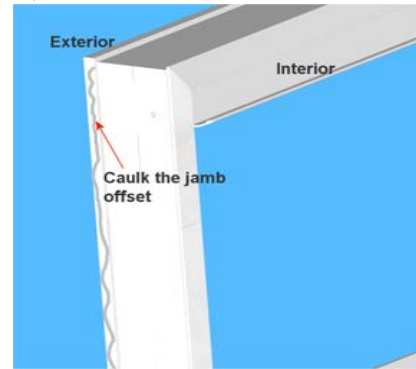


New Excalibur Mulling

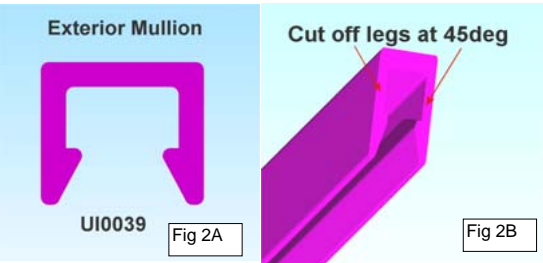
Side Mulling 0201

Step 1



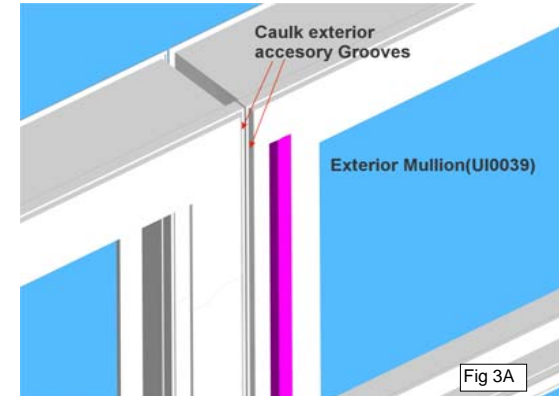
Caulk the offset leg on the jamb, as shown. Make sure caulk is applied to the whole length of the frame.

Step 2



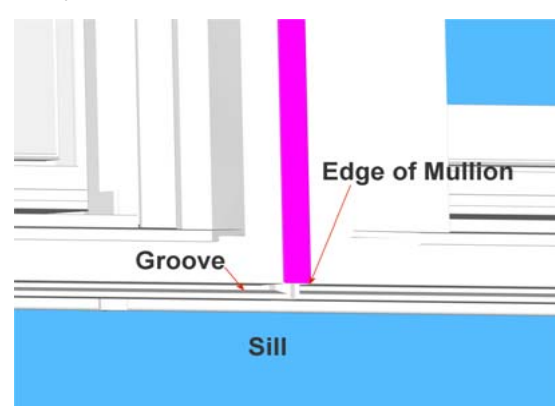
Cut a piece of UI0039 (EXTERNAL MULLION). Fig 2A. **The length is equal to frame height minus 3/16"**. Cut the legs off one edge of the mullion, at 45 deg. Cut from the edge inward. Fig 2B

Step 3



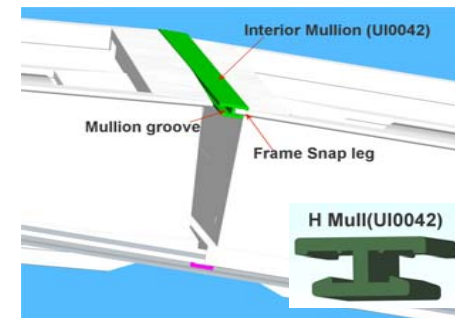
Caulk the exterior accessory grooves the entire length of the window frame. Apply the mullion with the 45 deg. edge to the head end of the window. The edge of the mullion should be flush with the top of the frame. Fig 3A. The mullion will need to be fit into place using a mallet.

Step 4



Make sure that the bottom of the Mullion at the sill is flush with the top edge of the groove. Fig 4A.

Step 5



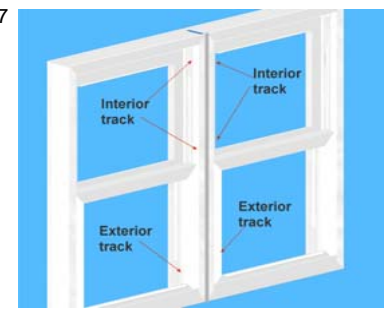
Cut the internal mullion: the length is equal to frame height or width, depending on the configuration. Lay the window down, (Interior side facing up). Lift up on the partially mullied window in the center; this will open up the area between the frames. Using the interior mullion, snap onto one frame, the Mullion groove to the Frame snap leg. Fig 5A. With the mullion snapped onto one frame; press the two frames together and snap in the other side.

Step 6

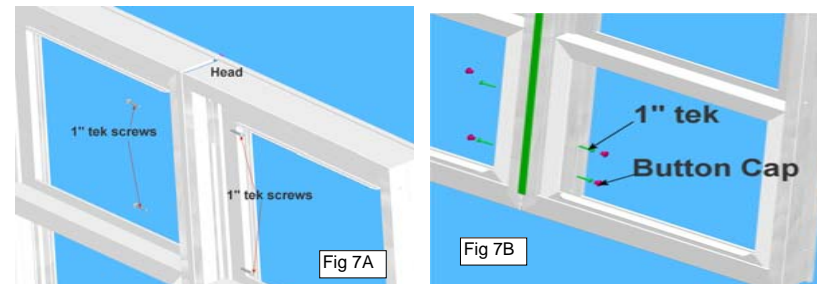


Cut the current excalibur reinforcement, **the length is equal to window height minus 1/2"**. Note: the cut length is the same for any configuration. Insert reinforcement into the Mullied opening. Fig 6A

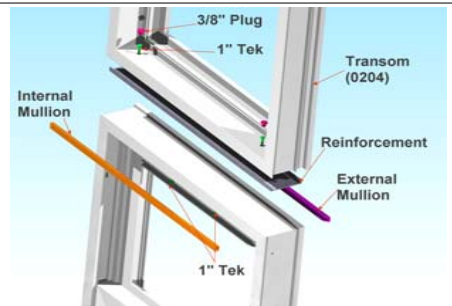
Step 7



Shown to left is the proper orientation for fastening the mullied unit.



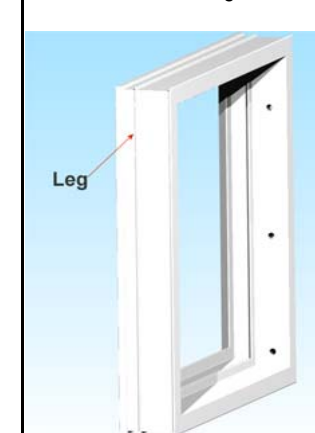
Head Approximately 3" from the top of the head, on the *interior track*, Screw in 1" Tek head screw into the jamb. Stagger 1" below on the opposite window. Fig 7A
Mid-Span: Approximately 1" from the top of the balance case Screw in 1" Tek head screw into the jamb, on the *interior track*. Stagger 1" above on the opposite window. Fig 7A
Sill: Counterbore through the first wall of the extrusion in the *exterior track* (use a 3/8" counterbore with 5/32" pilot. Do this for both windows. Drill approximately 3" from the Bottom of the Sill and stagger 1" above on the opposite window *there are four connection as shown*. Fig 7B. Silicone and apply 3/8" button cap. Complete the process by using narrow joint sealant on the exterior mullion. Package unit using replacement packaging instructions.



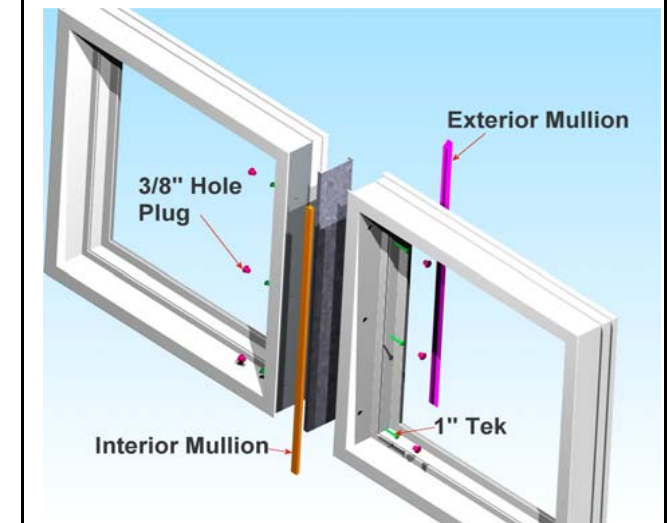
Exploded view of the Stacked Mull assembly. Cut the Internal and external mullion the width of the window. The external mullion in the case will have two 45 deg mitred ends. The reinforcement is equal to length minus 1/2". When inserting reinforcement into the above assembly make sure the "U" side of the reinforcement is facing up, because of the leg on the picture window. Assemble Mullions and caulk the assembly.

Counterbore through the **first wall of the extrusion** on the picture window ,0204 (use a 3/8" counterbore with 5/32" pilot. Do this for both windows. Drill approximately 2" from either side of the picture window jambs. Assemble mullions and reinforcements onto window.
 1. Install 1" Tek head screw into the holes and through the reinforcement. Apply Silicone (**Important make sure that the screw is completely covered with silicone**). Install 3/8" button cap.
 2 For the Hung unit: Remove head Insert and install 1" tek screw into head and into reinforcement. Windows over 40" should have a 3 up 3 down screw hole pattern staggered equally.
 Note: If the unit has a picture window and a double hung be side mullied. 1. Follow double hung side mulling procedures for the double hung side and follow the Picture window side mulling procedures for the Picture window side(See picture window side mulling below).Windows over 40" use 3-3 screw pattern. Follow up with narrow joint sealant to complete the mulling.

Picture Window Mulling



Mulling Side by Side 0204. Shown to the left is a picture window with leg. Remove the leg using router and edge guide. This leg needs to be removed from each side of the adjoining windows.



Exploded view of the side by side Mull assembly for picture windows.
 Cutting exterior Mull. See Step 2; perform the same processing operation.
 Counterbore through the first wall of the extrusion on the picture window ,0204 (use a 3/8" counterbore with 5/32" pilot. Do this for both windows. Drill approximately 2" from either side of the picture window jambs
 Install 1" Tek head screw into the holes and into the reinforcement. Apply Silicone (Important make sure that the screw is completely covered with silicone). Install 3/8" button cap.

Windows over 40" should have a 3 by 3 screw hole screw pattern staggered equally.
 Note: if this combination is a picture window over picture window, It is the same procedure except rotated 90 degrees and the external mullion is cut with 2 mitred ends the entire width of the window.. Windows over 40" use 3-3 screw pattern. Follow up with narrow joint sealant to complete the mulling.