

## **New Construction Aluminum Window Installation Instructions**

1. Read all instructions thoroughly before beginning the installation of the window. These instructions are intended as a basic guide for installing new construction All Seasons aluminum windows.
2. Inspect unit for correct size, type, damage and correct installation information for your application. If a problem exists with any of these areas contact your distributor before installing. Begin by measuring the rough opening. The window should have approximately  $\frac{1}{4}$ " and no more than  $\frac{1}{2}$ " around the perimeter of the unit. Also check sill plate to ensure it is level.(Fig.A) If sill is not level make corrections at this time.
3. Nail fin of the window must be sealed with the proper grade of sealant and flashing to prevent water infiltration around the window. The proper grade will depend on the surface the nail fin will be sealed against. Always make sure that the material used is compatible.
4. Run a continuous  $\frac{3}{8}$ " bead of sealant around the inside perimeter of the nailing fin (Fig. B). After nailing the window in place and set for square-ness, a house wrap tar type flashing tape is also required to seal the nailing fin on the exterior side of the fin covering the complete fin and exposed fasteners overlapping onto the project sheeting.

Fig. A

Fig. B

Fig. C

Fig. D

Fig. E

Fig. F

5. with the window closed and locked, place temporary shims at each corner of the rough opening where the jamb meets the sill plate. With the sash closed and locked, insert the window from the outside and rest it on the shims. Make sure there is a  $\frac{1}{4}$ "

gap between the sill plate and window frame to allow for fluctuations in building materials and window unit (Fig C).

6. Using a corrosion resistant fastener that will penetrate a structural member at least 1" with a head size larger than the pre-punched hole begin by inserting fastener in the pre- punched hole in the top corner of the nailing fin. Check the window that it is centered, plumb, level, square and true in the opening, then nail the bottom opposite corner at sill. (Fig.D)
7. Measure the unit diagonally in both directions to ensure the squareness of the window (Fig E). If the window is out of square or the sill is bowed, the overlapping and interlocking meeting rail may not seal properly even if the sash locks.
8. Check the sash where they meet the jambs to be certain the reveals are even. If there are any uneven reveals (gaps), shim accordingly. Check operation and make any further adjustments. To complete the anchoring of the unit continue to attach with fasteners a minimum of every 12" on center.  
Note: If the jambs are adjusted too far in or out the sash pivot bar could bind and cause the sash to become inoperative.
9. Loosely pack insulation around the window frame, on the interior, between the frame and the opening. The use of expandable foam will bow the jambs and sill and is not recommended.
10. Finish off the exterior of the window. If applying brick, stone, stucco, etc., make sure to leave a 1/8" gap around the entire window frame to allow for fluctuation and expansion of materials and mortar. Be sure to use the proper grade of sealant to seal the entire perimeter of the window. Do not leave any gaps where water or outside elements can penetrate into the home. Seal all areas that are prone to air or water infiltration. Make certain that the weeps on the outside of the window (Horizontal Sliding Units only) are open and that water can drain from the sill and out of the weeps.
11. Finish off the interior of the window. Check the window to be sure it operates properly (Fig.G).

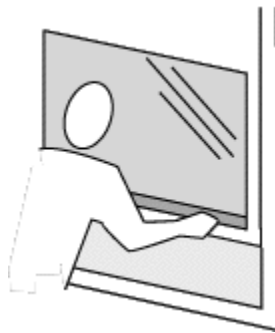


Fig. G

12. Note These Instructions are designed for operating Single Hung or Horiz. Sliding windows, and are equally applicable for fixed picture window units, with obvious exceptions concerning operation of moving sashes.