FIELD INSTRUCTION FOR MULLING VINYL WINDOWS (ASPECT & ENDURE)

IMPORTANT INFORMATION BEFORE YOU BEGIN

**The procedure will be the same for ALL Aspect and Endure models. (The double hung window is used for illustration.)*

FIELD MULLING WILL BE REQUIRED IF:

• The size of a factory mulled unit exceeds a specific shipping size parameter. For example, a multiple window unit may ship partially mulled, requiring field mulling to complete the assembly.

OR

• All units for a mulled set are ordered to ship separate.

⚠ *Read these instructions carefully before starting installation. Product warranty does not cover damages resulting from improper installation.*

MATERIAL YOU WILL NEED:

• High Quality Silicone Caulking in accordance with ASTM C920, Class 25

MULLING KIT CONTENTS:

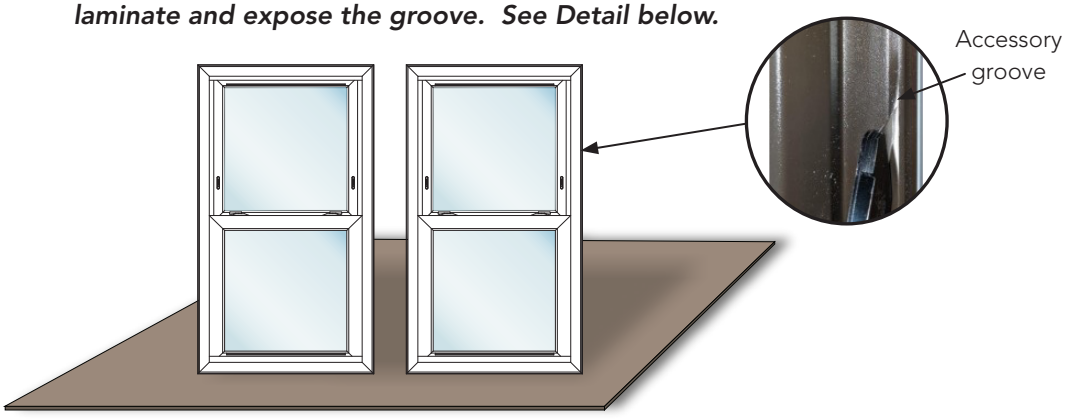
- Zero Mull Rebar, Part #: S-AE-4710-00
- Zero Snap Mulls, Part #: S-VE-4492-CC
- Stacking Plate Pack(s), Part #: S-HG-604P-00
- Head Cover:
  - #461 (For Side-By-Side Units without Nail Fin) OR
  - #462 (For Side-By-Side Units with Nail Fin)

A. FIELD MULLING

NOTE THE FOLLOWING!

• Windows with a painted exterior will ship with a protective plastic cover. On the top and mull side(s) ONLY, peel cover back to expose the accessory groove. DO NOT fully remove protective cover until after installation.

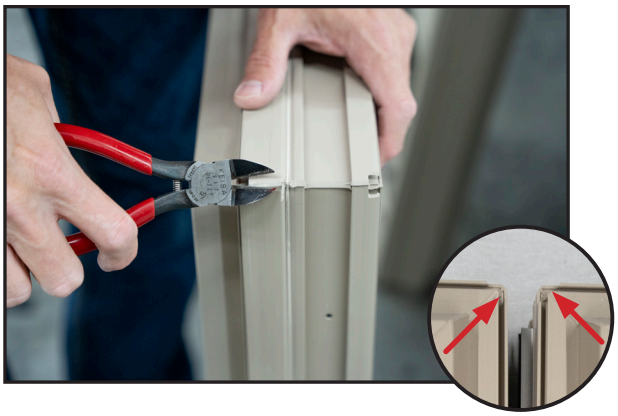
• For units with laminated exterior or interior, use a utility knife with blade angled toward the exterior to score each side of the accessory groove(s) to be utilized by snap mulls, accessories, or a head cover in order to cut laminate and expose the groove. See Detail below.



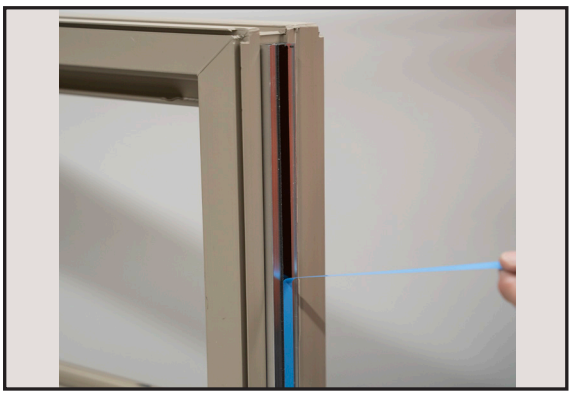
1. Prepare a flat and well supported surface. Place product's cardboard box or other protective cover over prepared surface to protect window frames.

2. If window units are ordered factory mulled with additional window units to be field mulled, factory installed stacking plates may need removed in order to install a zero mull rebar. *Example, a set of factory mulled side-by-side units to be stack mulled in the field.* If there are no stacking plates to be removed, proceed to next step.

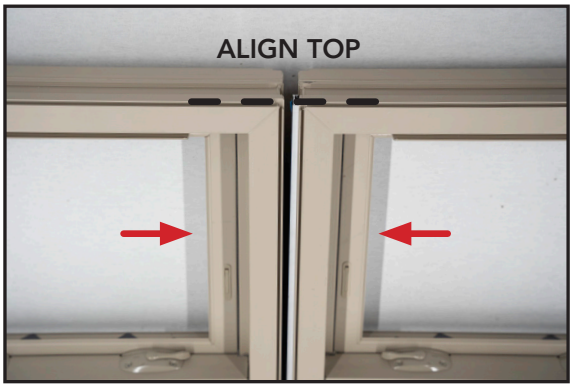
A. FIELD MULLING *(CONTINUED)*



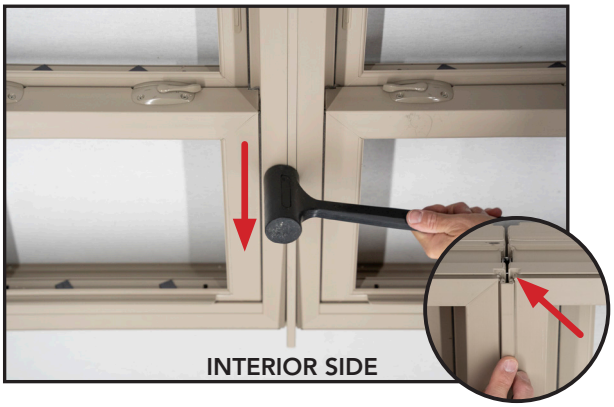
3 Remove extra weld flashing at miters and within the exterior accessory groove corners to allow for a clean tight mull and/or the accessory to lay flat. Set units together to test before following step.



4 Remove backing from the reinforcement glazing tape that will be factory applied to a unit. If reinforcement ships loose, remove one side of backing and apply centered within frame notch.



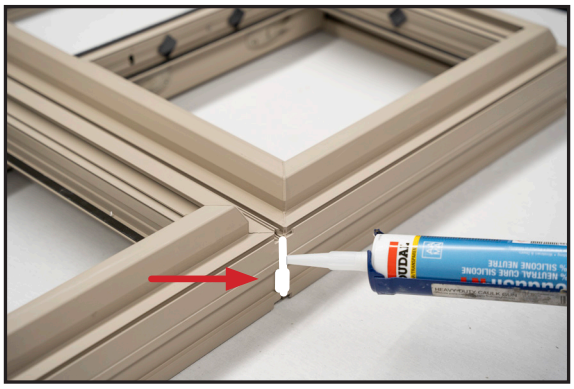
5 Align units to be mulled and firmly press together. Make sure edges are flush and tape is fully adhered. *Note, if a header cover is to be utilized, align units starting from the top.*



6 Lay mulled set flat on protective surface with the **INTERIOR** side face up. Place the INTERIOR zero snap mull just below the top accessory groove. Use a rubber mallet to tap the zero snap mull in place working from top down or across.

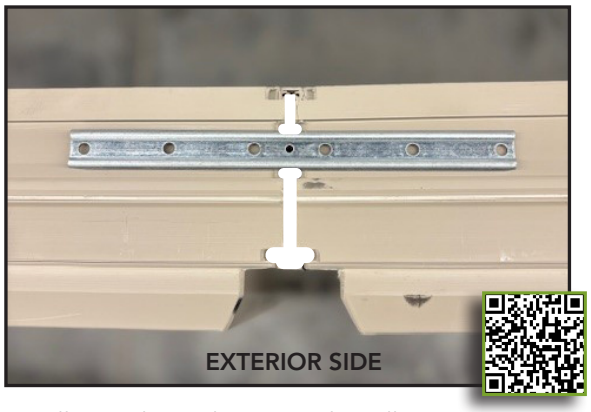


7 Trim off any excess that extends beyond inboard edge of bottom accessory groove.

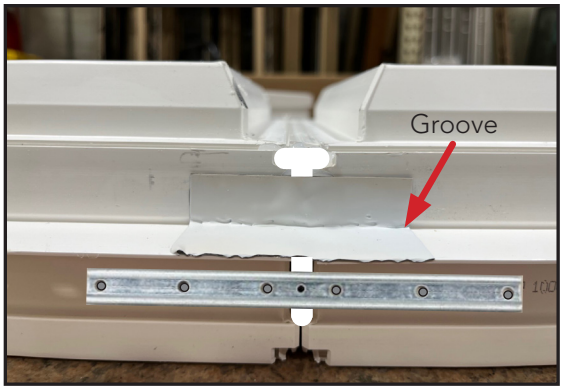


8 Apply sealant along the TOP and BOTTOM mull joint(s) for the full width of the surface. Make sure sealant fills the small void and extends down to the reinforcement.

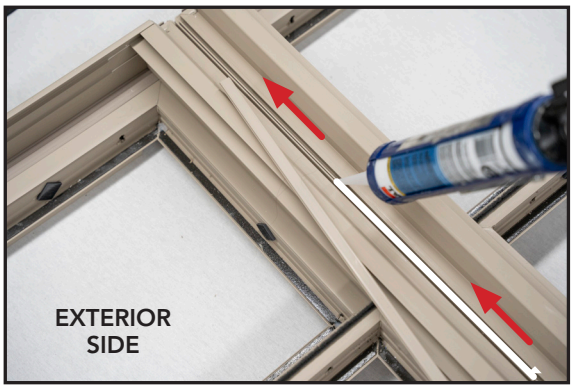
A. FIELD MULLING *(CONTINUED)*



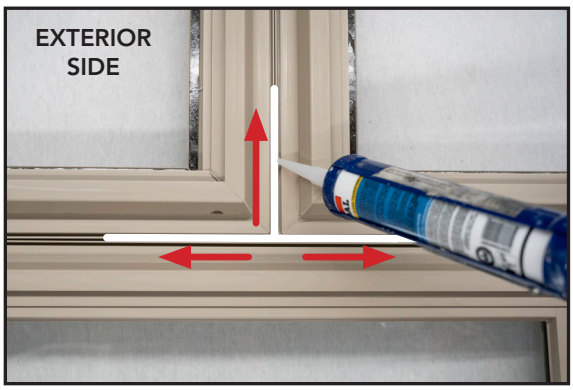
9 Install a stacking plate at each mull joint per instruction included in the Stacking Plate Pack (S-HG-604P-00). Also available by scanning/tapping the QR code. *Note, casement and awning windows will have factory applied tape at the stacking plate location.*



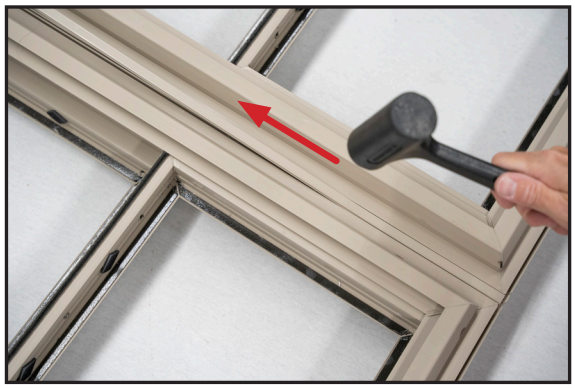
10 For nail fin units only, place butyl tape (included in the Stacking Plate Pack) across the top and bottom mull joint to the exterior side of the nail fin as shown. Wrap fin and press tightly into the frame groove.



11 Carefully flip set over so **EXTERIOR** side is face up. Place a bead of sealant on the ridge between the accessory grooves for the full length of the horizontal and/or vertical mull joint.



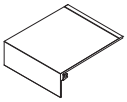
12 If mulled units are stacked to create either a T-joint or a cross joint, the exterior accessory groove must be caulked at the intersection 6" minimum in each direction. Apply the stacking plate at new mull point.



13 Start the EXTERIOR zero snap mull next to the accessory groove to allow head cover or accessory to lay flat. Use a rubber mallet to tap the snap mull in place. Trim off any excess that extends beyond the edge of the opposite accessory groove.

- **For ALL SIDE-BY-SIDE mulled sets**, continue as follows for installation of the head cover.
  - Non-Nail Fin Units, refer to Section B
  - Integral Nail Fin Units, refer to Section C

- **If NO head cover was received**, mull set is complete.



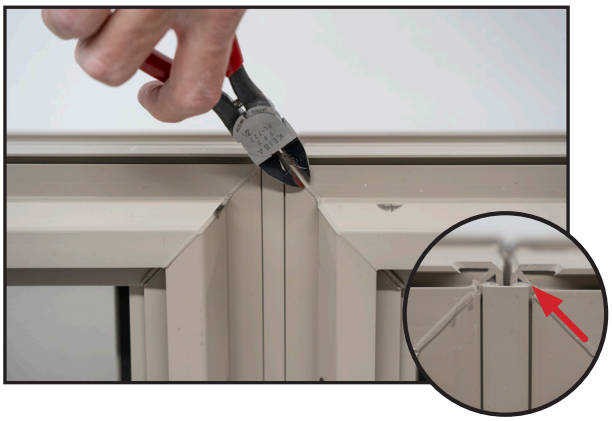
B. INSTALL HEAD COVER FOR NON FIN UNITS

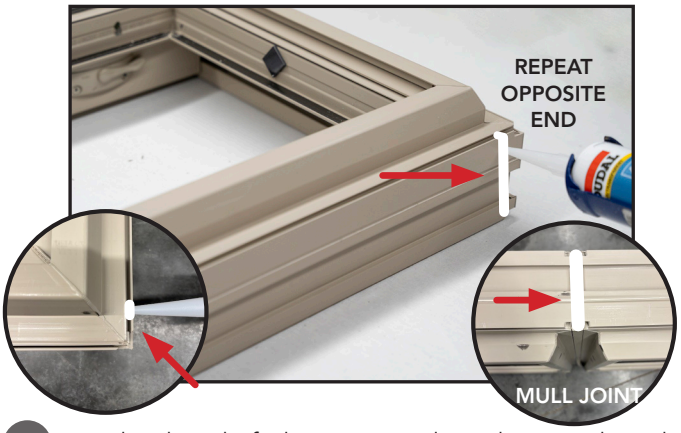
⚠ IMPORTANT!

The 461 flat head cover is intended to provide extra protection at the top mull joint(s) for side-by-side mulled windows.

IF the decision is made to wrap cladding with termination into the unit's top accessory groove and the header cover is NOT installed, or the factory installed cover is removed, it is then the responsibility of the installer to provide the adequate protection required to avoid any leakage issues at mulled joint location(s). Joint(s) MUST BE fully sealed.

Recommendation: *If a* ***head expander*** *is to be used, cut the expander in half lengthwise. Only use the interior half, as needed. Discard the exterior portion. This will allow the FLAT header cover to be installed as instructed.*

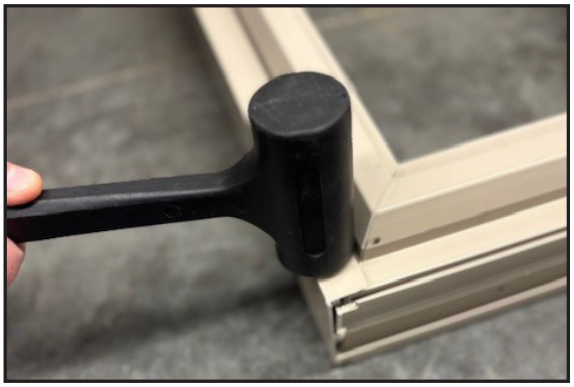




1. **Check to BE SURE the front accessory groove is CLEAR of any obstructions. Clear away extra vinyl in welds.** The previously installed exterior zero snap mull must be located just below groove to prevent header cover from lifting at mull joint. Trim or remove any excess weld material as required.

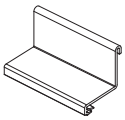
2. Apply a bead of silicone or sealant along each end of the mulled set header and mull joint(s) for the frame width. At each location, continue over front face and into the front accessory groove as shown in detail above.





3. Place the head cover on top of the mulled set, aligning the ends. Snap the header cover leg into the exterior accessory groove. Use a soft mallet to tap into position. Ensure the cover is properly seated in the accessory groove and bedded in the silicone or sealant. Re-check for proper end-to-end alignment. Remove any excess sealant from each end.

Mulling is COMPLETE. PROCEED TO THE MAIN WINDOW INSTALLATION INSTRUCTION.



C. INSTALL HEAD COVER FOR INTEGRAL NAIL FIN

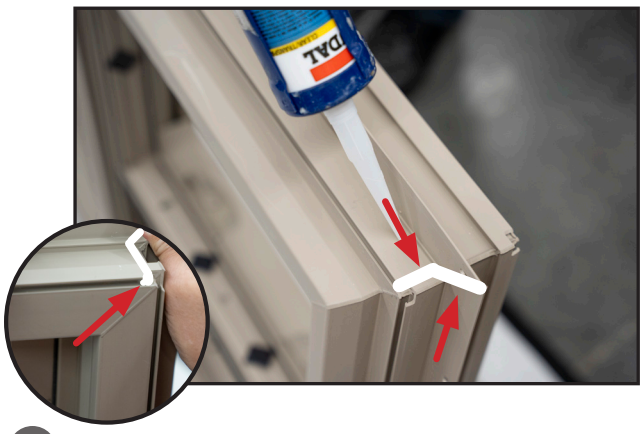
⚠ IMPORTANT!

The 462 flat head cover with nail fin is to provide extra protection at the top mull joint(s) for side-by-side mulled windows.

IF the decision is made to wrap cladding with termination into unit's top accessory groove and the header cover is NOT installed, or factory installed cover is removed, it is then the responsibility of the installer to provide the adequate protection required to avoid any leakage issues at mulled joint location(s). Joint(s) MUST BE fully sealed.



1 **Check to BE SURE front accessory groove is CLEAR of any obstructions. Clear away extra vinyl in welds.** The previously installed exterior zero snap mull must be located just below groove to prevent header cover from lifting at mull joint. Trim or remove any excess weld material as required.



2 Apply a bead of silicone or sealant along each integral nail fin miter, mull joints, and nail fin joint(s). At each location, continue sealant for width of the surface, over the front face, and into the front accessory groove as shown in detail above.



3 Place head cover on top of the mulled set, aligning mitered ends with frame miters. Snap into the exterior accessory groove. Slightly roll nail fin forward to allow the cover's fin to slide up and over nail fin. Use a soft mallet to tap into position. Ensure the cover is properly seated in the accessory groove and bedded in the silicone or sealant. Re-check end-to-end alignment. Remove any excess sealant.



4 From the interior side (back side) of the top nail fin, drill or punch an approx. 3⁄16" hole through all existing integral nail fin holes and through the head cover nail fin. This will locate all nail hole locations for installation. Be sure to elongate each hole to match the nail fin slot, allowing for installation adjustments.

Mulling is COMPLETE. PROCEED TO THE MAIN WINDOW INSTALLATION INSTRUCTION.

REFERENCES & ADDITIONAL INFO

Please call Customer Support for additional installation inquiries at 1-800-669-4711.

SCAN or TAP the QR Code

For additional information and helpful videos, visit our INSTALLATION SUPPORT HOMEPAGE

Installation Instruction Vinyl Window Stacking Plate #604
(Referenced on page 3)

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