

# Mulling Instructions for Series 1200/4000/8500/9500

**Equipment, Materials and Safety Conditions:** Personal protective equipment must be used as required.

**Tools:** Table Saw or Circular Saw, Screw Gun, Caulk Gun, Rubber Mallet, End Cutter

**Materials:** Two pieces of 1/4" Plywood (optional) ripped to 1-7/8" wide and cut to 1" less than the window height, 085-12-0005 "H" Brackets, 2020 Mullion, Silicone Caulk, #8 x 1/2" Phillips Pan Head Screws (14), #8 x 1 5/8" Phillip Pan Head Screws (6).

**Note:** The application of Plywood is for the purpose of maintaining Structural DP Rating of DP45. The omission of this step will result in a lesser DP rating.



Begin the process by removing the sashes, foam insulation and jamb adjusters from the sides intended on being mullied together. (Jamb adjusters are removed by backing out the screw from middle pre-punched hole in jamb.)

\* Cut plywood to size and fasten to one window jamb making sure it is aligned at the top and bottom by using three #8 x 1/2" Phillips Pan Head Screws. Repeat this step on mating window.



Next, apply a bead of caulk along the interior edges of the 2020 Mullion "I" beam legs.

Place the mullion onto the jamb of the first window and position it so that mullion is aligned with the top and bottom of the window.



Nest the second window into the mullion and squeeze together making sure the frames are completely seated into the mullion. Use a putty knife to guide the jamb into the mullion if necessary.

With the assembly standing upright, check and align the mullion with the windows. If necessary, use a rubber mallet to align.



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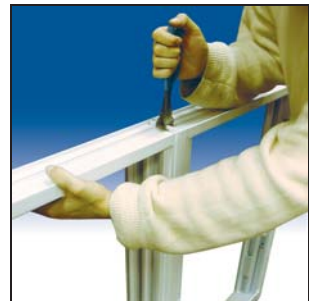
Starting with the upper installation holes, screw windows into mullion using #8 x 1 5/8" Phillips Pan Head Screws.

Repeat the previous step by screwing through the installation holes at the bottom of the frame.



Fasten windows to mullion at center points by inserting #8 x 1 5/8" Phillips Pan Head Screws through the jamb adjuster hole. Again, angle the screws so that they do not interfere with one another.

Notch the 2020 mullion where it extends beyond the head and sill so that it is flush with the top of the windows.



Using silicone caulk, seal open cavities completely on both ends of mullion so there are no voids for water to penetrate assembly.

Using #8 x 1/2" Phillips Pan Head Screws, fasten the "H" Bracket across the center of the mullied joint at the head and sill so it is closest to the interior flange on both top and bottom of the unit.



**You can now install the  
mullied window unit.**