

# SEALCRAFT

Architectural Window Systems

STANDARD PROCEDURE

No. I-123

***Window Installation Instructions:  
Fixed Light Window Systems with Front Flange***

Examined, Accepted and Approved

By: D. Ray VanNess

Title: President

## 1.0 INTRODUCTION:

- 1.1 The purpose of this standard procedure is to establish the procedures required for the successful installation of Seal Craft window systems utilizing front flange (integral or applied) into construction that incorporates metal or wood framing, masonry, existing window perimeter frames and/or various exterior construction elements.
- 1.2 Front flange is a system that allows for the installation of windows into an opening where certain existing frame members need to be covered, panned or jumped over. Front flange is an installation system or technique that adds to the exterior width and height of a window, while maintaining the original window dimension on the interior. When front flanges are utilized, an interior trim may be required.
- 1.3 Front flange systems are also sometimes used as an attachment or flashing method. Special thought and consideration should be exercised to ensure the weather tightness of such installations. The procedure described herein details the more common application of using the front flange system to pan over existing elements within retrofit applications.
- 1.4 Front flange may sometimes be referred to as an exterior flange, front fin or mini-pan, but all refer to the front flange system as described herein.
- 1.5 The guidelines set forth herein are based on standard industry practices AAMA Publication IPCB-08 which can be located at [www.seal-craft.com](http://www.seal-craft.com) and Seal Craft specific recommendations coupled with our understanding of job site conditions and requirements.
- 1.6 This procedure does not purport to address all of the safety problems that may be associated with its use. It is the responsibility of whomever uses this procedure to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

## 2.0 INSTALLER QUALIFICATIONS AND RESPONSIBILITY:

- 2.1 The window installation subcontractor should be an experienced mechanic in the field with at least five continuous years of successful experience installing similar window systems into projects of similar scope, magnitude and design.
- 2.2 The basic function of the window installation subcontractor is to ensure that all windows are installed per the approved manufacturers written instructions and job specific Shop Drawings as approved by the Architect or Owner's Representative.
- 2.3 The window installation subcontractor shall be responsible to ensure that all openings are correctly prepared and ready to accept new window units. Any problems found should be reported to the General Contractor or approving authority promptly and the window installation should not be initiated until all opening deficiencies are

corrected.

- 2.4 The window installation subcontractor shall then be responsible to ensure that all windows are properly installed, adjusted and ready for use by the Owner, with the exception of final glass washing, which is to be preformed by the pre-occupancy clean-up subcontractor.

### 3.0 RESPONSIBILITIES:

- 3.1 The window installation subcontractor is responsible to gain a full and complete understanding of pertinent information relating to his/her scope of work including but not limited to this document, approved submittals, shop drawings, working construction drawings, project specifications and job site requirements.
- 3.2 The window installation subcontractor is responsible to train his/her workforce in proper material handling, erection and safety procedures, and pursuant with and including OSHA and Prime Contractor safety requirements.
- 3.3 Window installation subcontractor shall ensure that a qualified window installation superintendent is designated and on site during all window installation activities.
- 3.4 To provide all sealants, caulk, fasteners, shims, backer rod, bond breaker and/or machinery as required by this Project and sufficient qualified workmen to perform the installation professionally, safely and on time.
- 3.5 To ensure that all materials are of the type and quality required for this Project and that they are safely stored and protected prior to and during installation.

### 4.0 DUTIES

- 4.1 The window installation subcontractor shall attend all required job site progress and safety meetings.
- 4.2 Maintain open communication and foster a harmonious relationship with General Contractor and other related trades.
- 4.3 Receive all window material shipments, verifying quality and quantity and that those products are fit for installation, immediately reporting any deficiencies directly to Seal Craft as well clearly listing any such problems the Bill of Laden.
- 4.4 General Contractor is responsible to ensure that rough openings in new construction are dimensionally accurate, plumb, square, true and not obstructed, allowing window installer free access to each opening.

### 5.0 FRONT FLANGE ASSEMBLY PROCEDURES

- 5.1 Inspect all openings scheduled for window installation for accuracy of dimension and squareness. All front flange window systems to be anchored into openings plumb,

square and without rack or warp - plan for shims as required.

- 5.2 Front flange pan frames are shipped to the job site with the head and jamb flanges attached. Sill flanges are not shipped attached to the window because they can't be successfully handled, shipped or stored, when assembled, without damage. The attachment of the sill flange takes less than two minutes.
- 5.2 Orient the window on a worktable so that the workman has access to the bottom of the sill and select the appropriate sill flange for application.
- 5.3 The sill flange will have two short legs that incorporate one hook on each leg that must be snapped into corresponding legs on the underside of the window's sill.
- 5.4 Check the rough opening dimension, width and height, and trim the pan flange as needed prior to installation.
- 5.5 Apply a back seal of the specified sealant to the unexposed (back side) of the flange corner connections. Nail fin / flanges are an installation aid, not a weather barrier.

#### 6.0 WINDOW INSTALLATION PROCEDURE:

- 6.1 Ensure that all windows are installed in accordance with ASTM E 2112 and with the AAMA 2400-02. The following step-by-step instructional procedure is provided for the convenience of the installing subcontractor.
- 6.2 Remove existing windows from openings without damage to surrounding finishes at the opening exterior and interior. This typically requires the removal of the glass and all horizontal and vertical frame members. The existing window mainframe head, jamb and sill are typically left intact in the openings' perimeter. Remove all debris.
- 6.3 Plan for installation fasteners to penetrate the existing window mainframe, which had been structurally attached to the building frame.
- 6.4 Set windows into the openings (from the exterior) and shim as required to ensure that the new window is centered, plumb and square in the opening (4 sides).
- 6.5 Install interior trim clips fastening the clip to the window mainframe perimeter and to the adjacent construction or existing window frame. Fastener types and frequencies shall be according to the project specific engineer stamped fastener calculations. The AAMA 2501-06 Voluntary Guideline for Engineering Analysis of Window and Sliding Glass Door Anchorage Systems is the appropriate standard for fastener calculations. Shim as required.
- 6.6 Install interior trim covers at head, jamb and sill. Interior trim members to be square cut to a nominal tolerance to provide a finished trim with minimal gaps at corners.
- 6.7 Sealants to be as specified by architect or equal and applied around the full exterior and interior perimeter of newly installed windows. Follow sealant manufacturer's application instructions.

## 7.0 ADJUSTMENTS

- 7.1 Inspect all exposed finished surfaces for scratches, abrasions and dents and correct. Scratches and abrasions should be wet sanded with 400 grit emery cloth, wiped clean and painted with manufacturer provided touch up paint.
- 7.2 Remove all labels or stickers from glass surface.

## 8.0 INSTALLATION TIPS

- 8.1 Where fasteners are used at header locations; if conditions require penetrating steel lenthil, ensure that masonry flashing above is not penetrated.
- 8.2 When applying interior trim covers and mullion covers use a mallet and wooden block to apply pressure at the edge of part for ease of snap and to reduce the occurrence of dents.

## 9.0 MANUFACTURERS DISCLAIMER

- 9.1 Seal Craft is a manufacturer of quality commercial window systems and as such is compensated for the delivery of the same, per architectural specifications, unto the job site. Seal Craft is not compensated for, and therefore assumes no responsibility for, building design, interface of its products with other building elements or any area of accountability other than the manufacture and delivery of quality window systems as required under each contract.
- 9.2 The qualifications and procedures as set forth herein are recommendations of Seal Craft as the manufacturer and are intended as a minimum guideline for the successful installation of its products and must be adhered to in order for the Seal Craft warranty to be in effect.
- 9.3 Upon review of the contract documents, shop drawings and manufacturers installation instructions, final architectural determination should be made as to any further requirements for flashing, sealant or any other detail that may need to be added or addressed to ensure proper interface with the new fenestration and the desired performance of the same.
- 9.4 The qualifications and procedures as set forth herein must be reviewed and approved prior to commencement of installation activities by a duly authorized and accountable owner's representative or agent.
- 9.5 Flashing and/or an appropriate method of sealing shall be designed as part of an overall weather resistant barrier system. It is not the responsibility of Seal Craft to

design or recommend a weather resistant barrier system appropriate for each job.

- 9.6 Seal Craft assumes no responsibility for any liability on account of the presence or growth of black mold or any other bacteriological growth in any building or structure in which its window systems are installed.
- 9.7 For building construction which incorporates EIFS; the EIFS Industry Manufacturers Association (EIMA) guidelines must be adhered to in order for Seal Craft's product warranty to be valid.
- 9.8 By stamping and/or signing or by any other means affixing a 'mark' to the submittal booklet that contains these instructions, both architect and contractor demonstrate complete agreement and accept full responsibility for these installation procedures. Further, both architect and contractor agree that the manner in which the windows are installed is beyond the control of the manufacturer and as such, Seal Craft has no responsibility for any liabilities that may arise from the improper installation of its products.
- 9.7 Should field testing be a Project requirement, installing window contractor shall cooperate fully, preparing window unit(s) as requested by the Architect and/or Independent Laboratory personnel, but in no case participate in an unofficial "garden hose tests". Any field testing shall be pursuant with the current AAMA 502 Standard and Seal Craft shall be afforded the opportunity to attend any and all such testing and given a minimum of 15 work days notice in advance of any field testing.