



# Installation and Use of Coastal Series Mullions

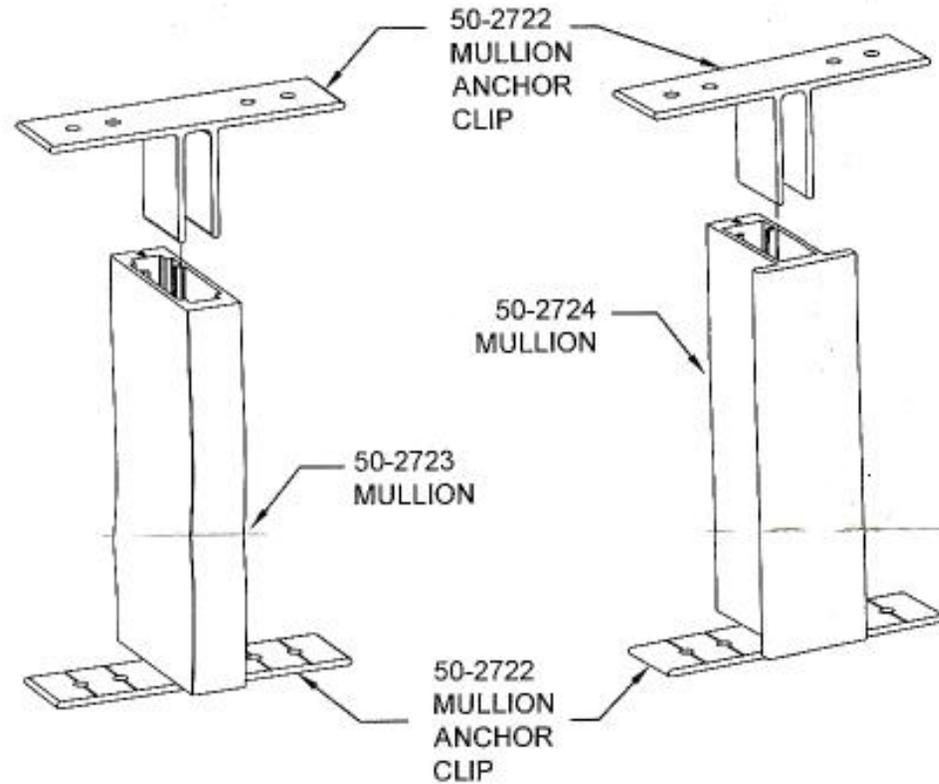
## ALUMINUM MULLION INSTALLATION INSTRUCTIONS FOR ALL SERIES IMPACT MULLIONS USED WITH ANCHOR CLIPS

1. Verify rough opening height is 1/2" higher larger than the mullion length. If mullion is too large, cut it to proper length. Remember the mullion will use length + 1/8" + 1/8" (anchor size) in rough opening.
2. Verify rough opening width is equal to 1/2" greater than the sum of the interior widths of all windows to be installed plus 1" for each mullion used.
  3. Example: If two windows are to mulled together 36" in width the rough opening formula is  $36" + 1" + 36" + 1/2" = 73 1/2"$
4. Measure the width of one window that is intended to be mulled and positioned at the side of the opening.
5. Starting from the jamb of the opening, measure to the muddle of the rough opening.
  6. Example:  $73 1/2"$  rough opening – measure to  $36 3/4"$  and make a mark. Do this on both the heads and the sill.
7. Slip the mullion anchor clips into the top and bottom of the mullion and slide the mullion assembly into the opening.
8. Align the middle of the mullions with the marks in Step 4 at the head and at the sill. To position the exterior of the mullion, make sure to position the mullion such that the exterior of the mullion will align with the flange of the window.
9. To fasten the anchor clips in wood frame construction, use 4 # 10 x 1 1/2" Phillips flat head sheet metal screws per clip.
10. Remove nailing fin from the entire side of each window that is to fastened to the mullion.
11. Following the window installation instructions, prepare the window and the rough opening as required.
12. Fasten the windows to the mullion using #10 x 1" self tapping Phillips head sheet metal screws.
13. Continue installation by following the window installation instructions.



## Installation and Use of Mullion Anchors

Insertion of Mullion Anchors into mullions.  
Anchors are then secured to the rough sill and header using 1 1/2" flat head wood screws.



# MULLION INSTALLATION INSTRUCTIONS WITH IMPACT SINGLE HUNG

MULLION COVER (SL# 43-2729)  
BY AMESBURY/TRUTH (VENDOR# 14013)  
(SEE DRAWING FOR ACTUAL COMPONENT)

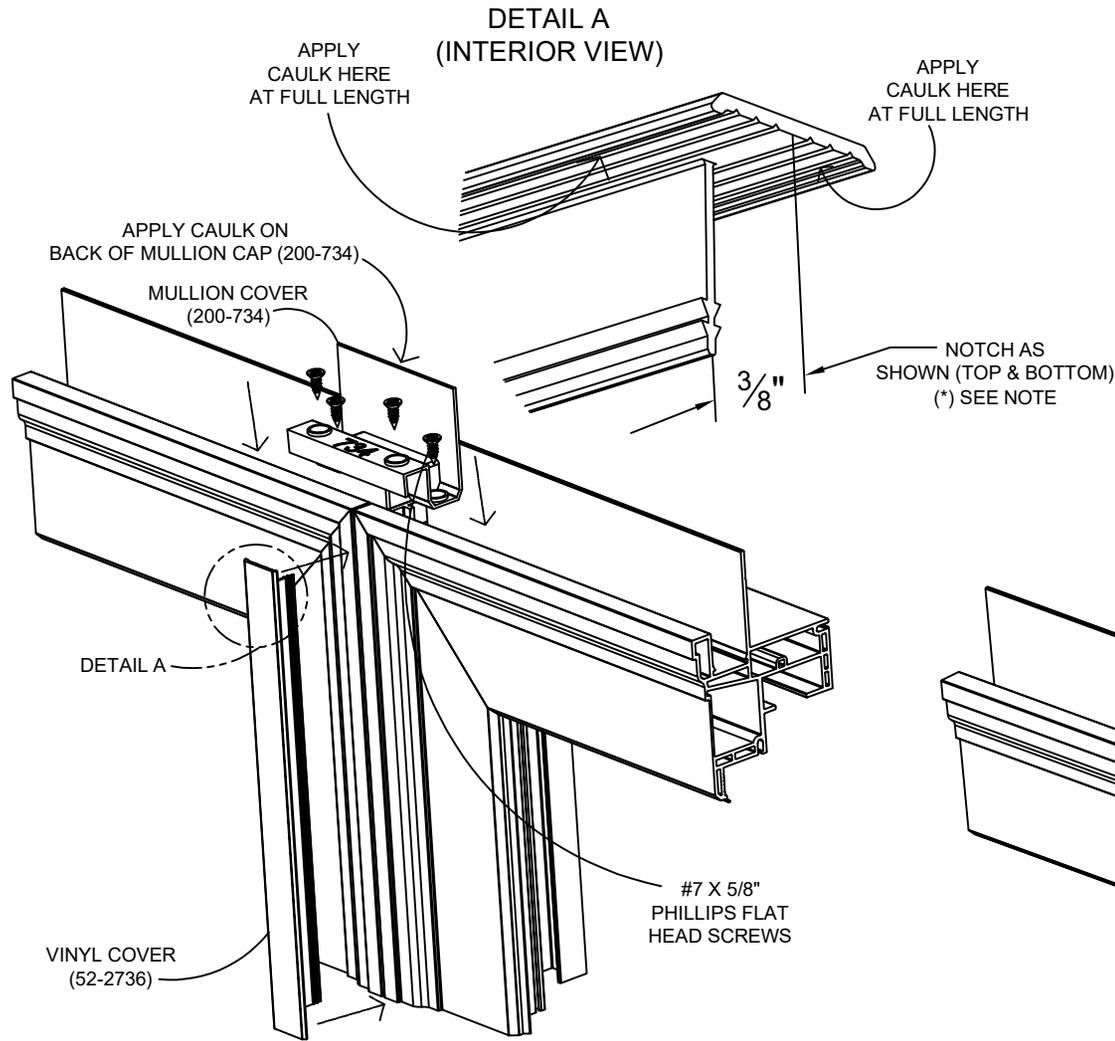
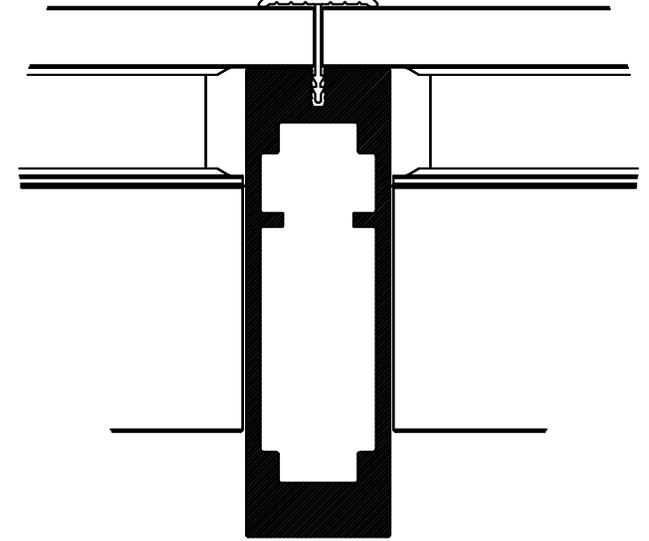


FIG. 1

(\* 52-2736 VINYL COVER CUT LENGTH = WINDOW HEIGHT + 1/4"



CROSS - SECTION VIEW

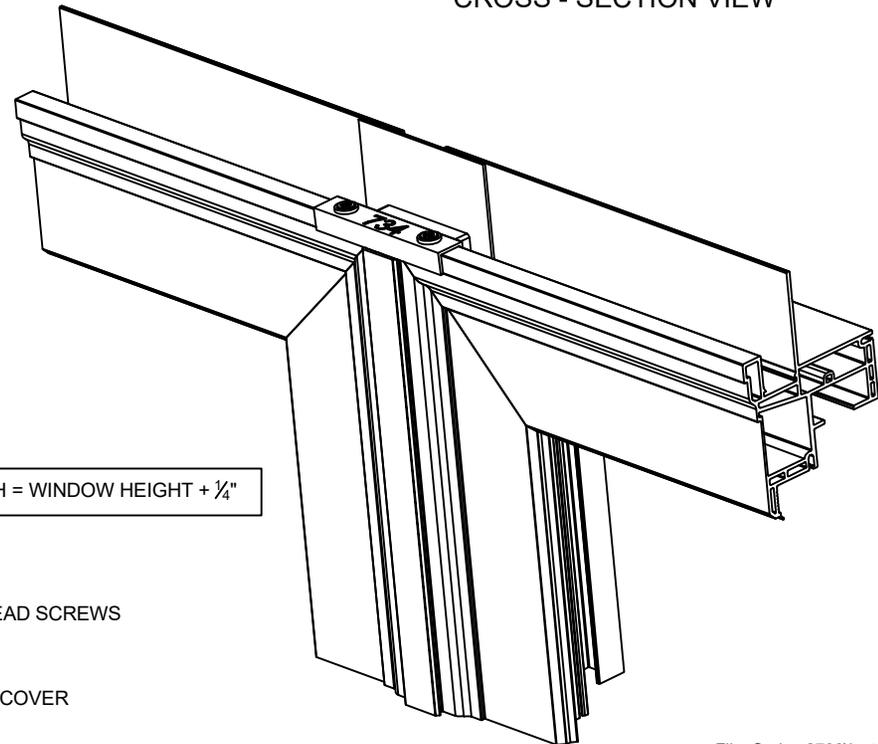
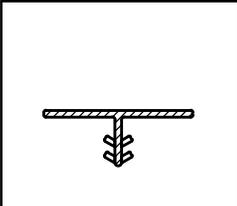
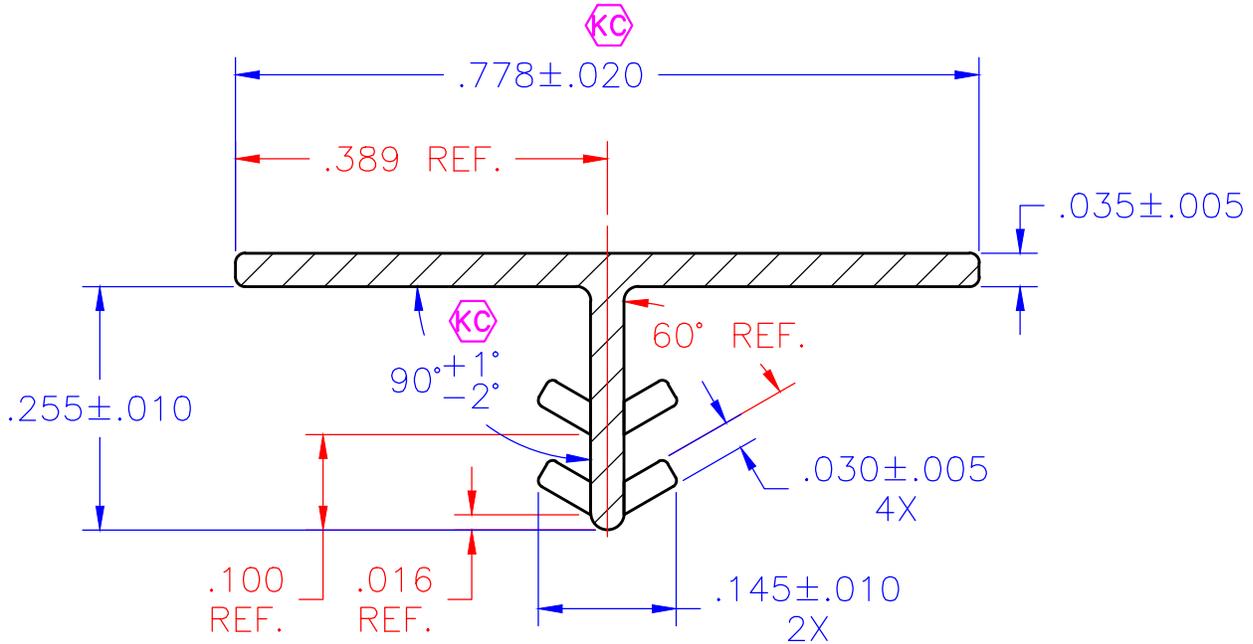


FIG. 2

## INSTRUCTIONS

1. APPLY CAULK ON BACK OF MULLION COVER (200-734) AS SHOWN IN FIG. 1. THEN INSERT MULLION COVER (200-734) ON HEAD END USING (4) #7 X 5/8" PHILLIPS FLAT HEAD SCREWS AS SHOWN IN FIG. 1.
2. APPLY CAULK ON BACK OF VINYL COVER (52-2736) AS SHOWN IN DETAIL A. THEN INSERT INTO ALUMINUM MULLION 50-2723 AS SHOWN IN FIG. 1. MAKE SURE THE VINYL COVER REACHES THE MULLION GROOVES AS SHOWN IN CROSS - SECTION VIEW.
3. REPEAT STEP 1 ON SILL END.
4. FINAL ASSEMBLY SHOWN IN FIG. 2.

REV	DESCRIPTION	DATE	ECO#	BY
1	SEE ECN	2/24/04	035-04	BJV
2	SEE ECN	9/9/04	131-04	DA
3	SEE ECN	8/24/10	085-10	AA
4	CHANGED LINE SPEED FROM 64 TO 70	7/21/11	116-11	JN
5	ADDED COLOR 42 SUEDE	1/29/16	002-16	JN
6	REMOVED TOOLING FROM PROD PAGE	7/17/18	455-109	JN



REFER TO CAD DRAWING FOR ALL DIMENSIONS NOT FULLY CONSTRAINED.

1:1 ACTUAL SIZE



INTERPRET PER:  
SAME Y14.5M-2009

UNITS: INCH

TOLERANCE UNLESS OTHERWISE SPECIFIED

- 1 PL ± .100
- 2 PL ± .010
- 3 PL ± .005
- ANGULAR TOL ± 1°

**KC** CRITICAL DIMENSIONS

DRAWING TITLE:

- CUSTOMER PAGE -

DRAWN BY: BJV

CHECKED BY: DA

SCALE: 5:1

SHEET: 1 OF 3

CAD TYPE: AUTOCAD

SIZE: A

DRAWING #: 14013

REV: 6

THE INFORMATION CONTAINED IN THIS DRAWING IS CONFIDENTIAL AND PROPRIETARY. THIS DRAWING IS NOT TO BE COPIED OR REPRODUCED IN WHOLE OR IN PART WITHOUT EXPRESS WRITTEN CONSENT.

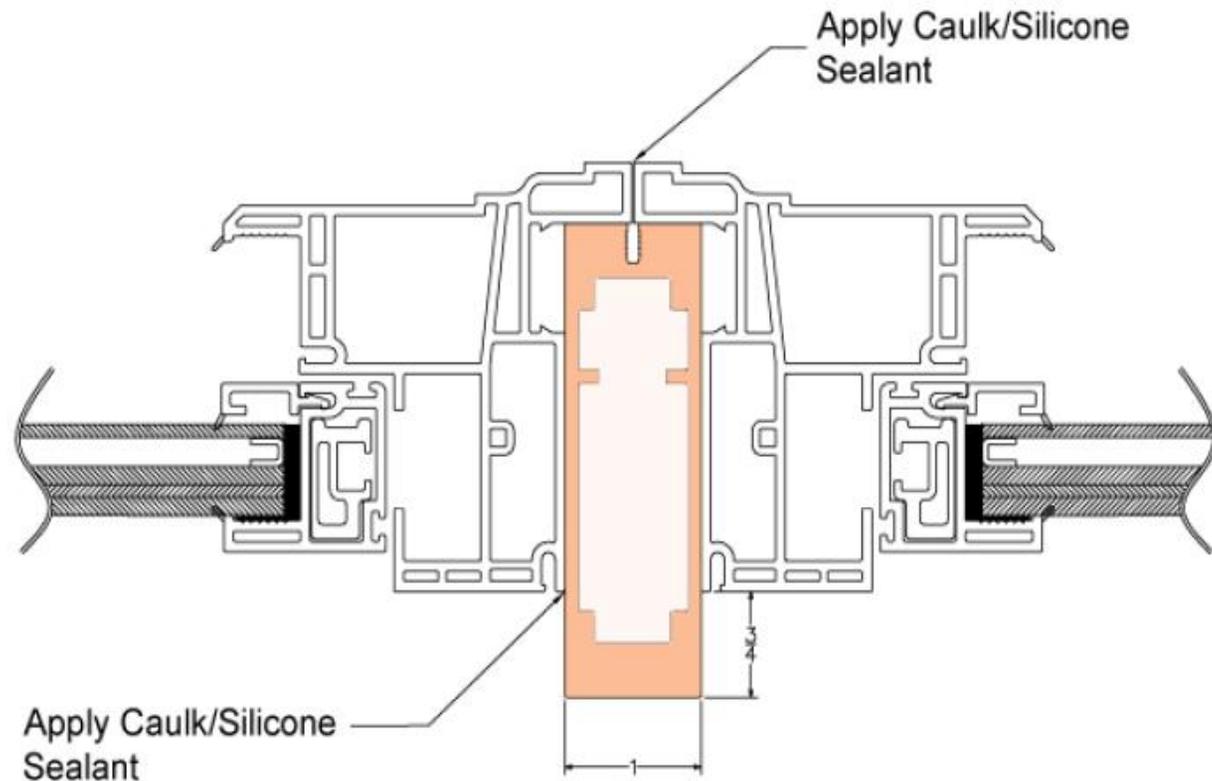
THIRD ANGLE PROJECTION





# Installation and Use of Mullions with Single Hungs

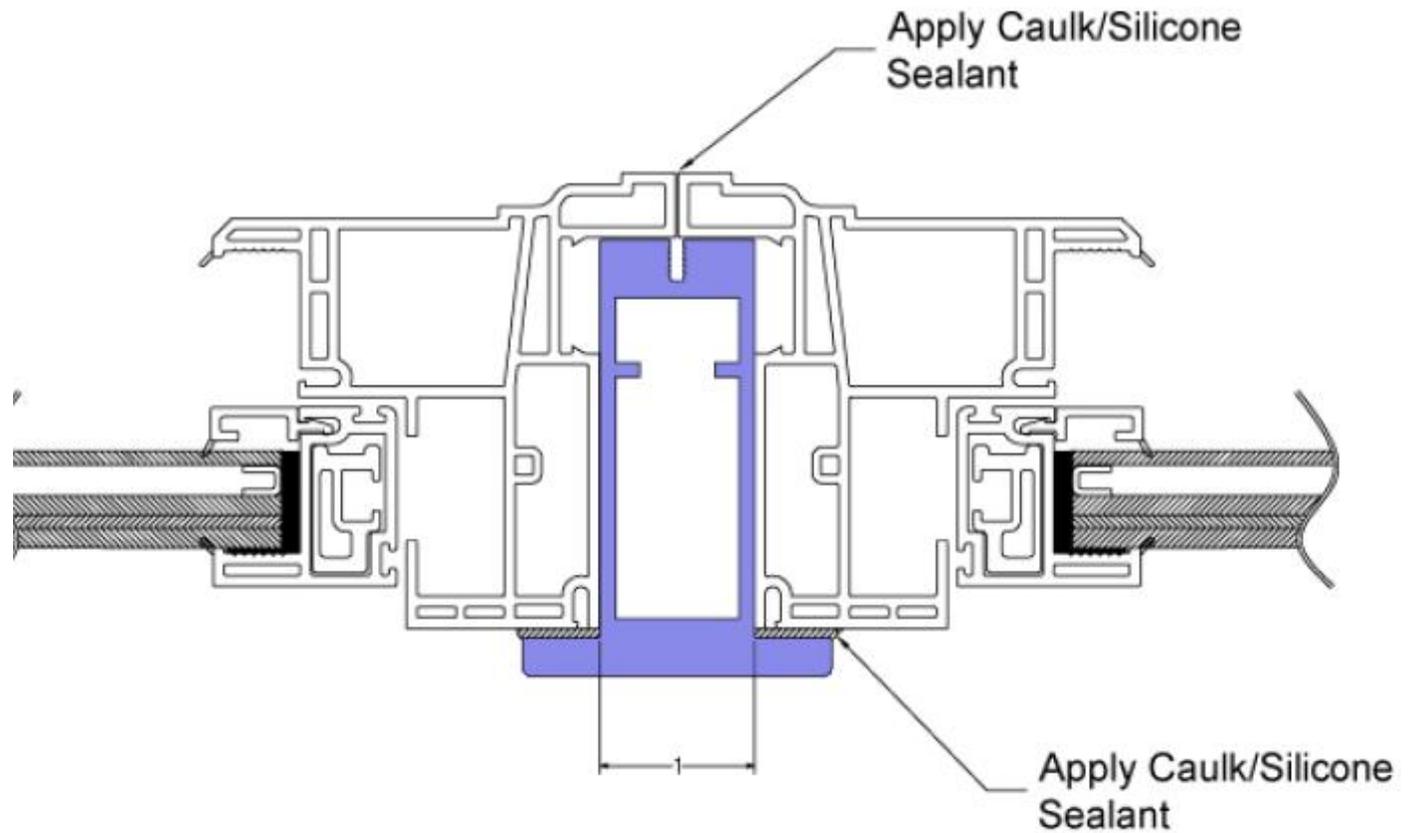
2900 TO 2900  
2723 MULLION  
SIDE BY SIDE





## Installation and Use of Mullions with Single-Hungs

2900 TO 2900  
2724 MULLION  
SIDE BY SIDE

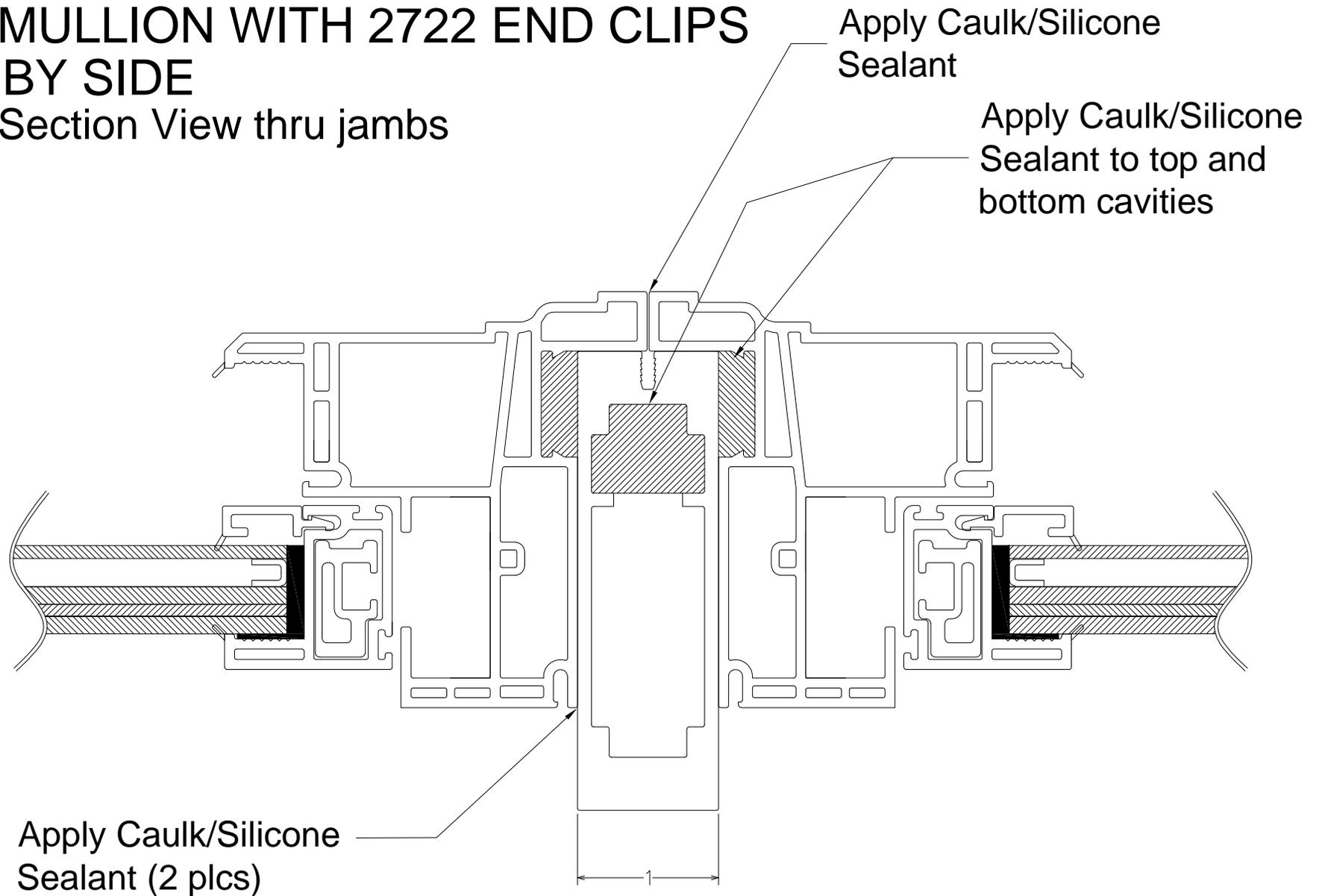


2900 TO 2900 (IMPACT)

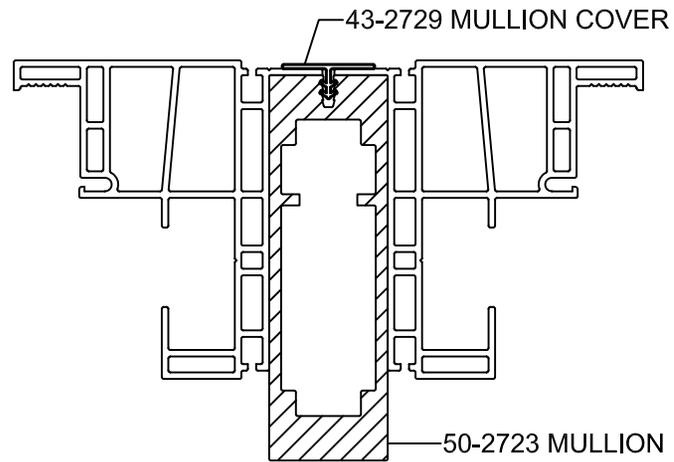
2723 MULLION WITH 2722 END CLIPS

SIDE BY SIDE

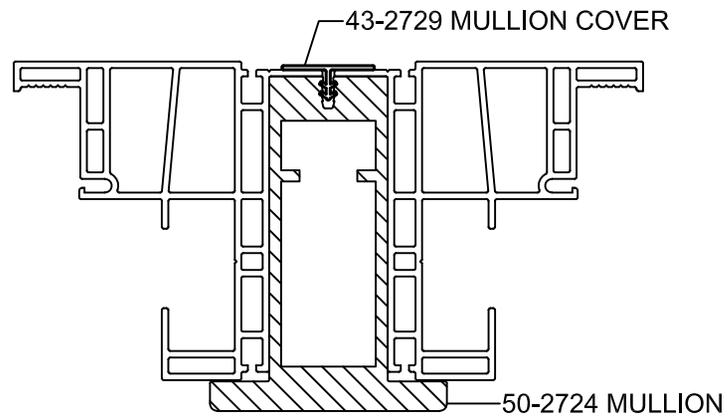
Cross Section View thru jambs



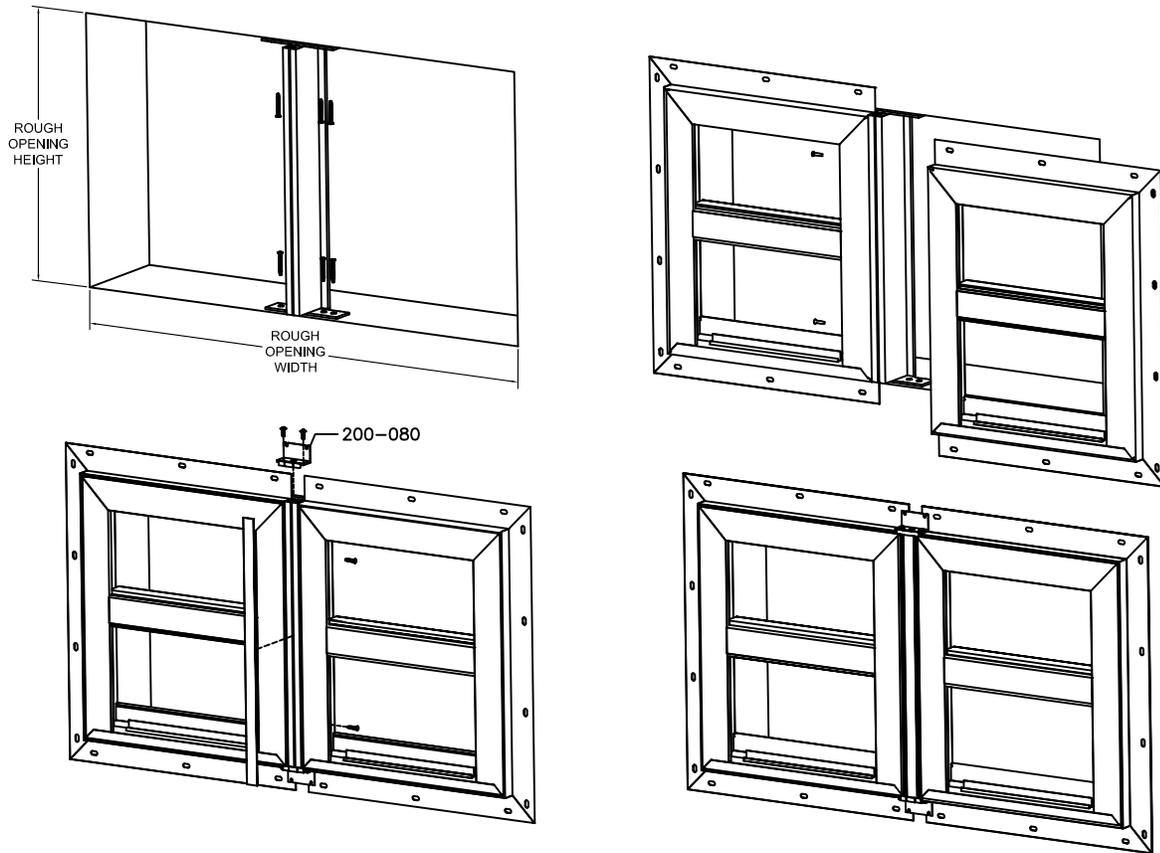
## 2127 SH - (FLANGE) MULLED WITH 50-2723 MULLION



## 2127 SH - (FLANGE) MULLED WITH 50-2724 MULLION



## 2724 MULLION ASSEMBLY INSTRUCTIONS



### ALUMINUM MULLION INSTALLATION INSTRUCTIONS MODEL 2724 MULLIONS USED WITH 2722 ANCHOR CLIPS

1. VERIFY ROUGH OPENING HEIGHT IS  $\frac{1}{2}$  INCH LARGER THAN MULLION LENGTH.  
IF MULLION IS TOO LARGE, CUT IT DOWN TO PROPER SIZE.
2. VERIFY ROUGH OPENING WIDTH IS EQUAL TO  $\frac{1}{2}$  INCH GREATER THAN THE SUM OF THE INTERIOR WIDTHS OF ALL WINDOWS TO BE INSTALLED PLUS 1 INCH FOR EACH MULLION USED.  
EXAMPLE:  
IF YOU INTEND TO MULL TWO WINDOWS TOGETHER OF 36 INCHES IN WIDTH, THE ROUGH OPENING WOULD NEED TO BE  $73 \frac{1}{2}$  INCHES WIDE TO ACCOMMODATE THE MULLED WINDOW ASSEMBLY.
3. MEASURE THE WIDTH OF ONE WINDOW THAT IS INTENDED TO BE MULLED AND POSITIONED AT THE SIDE OF THE OPENING.
4. STARTING FROM THE JAMB OF THE OPENING OF WHICH THE WINDOW MEASURED IN STEP 3 WILL BE POSITIONED, MEASURE AT BOTH THE HEAD AND SILL TO THE WINDOW WIDTH PLUS  $\frac{3}{16}$  OF AN INCH AND MARK THOSE POINTS.
5. SLIP THE MULLION ANCHOR CLIPS INTO THE TOP AND BOTTOM OF THE MULLION AND SLIDE THE MULLION ASSEMBLY INTO THE OPENING.
6. ALIGN THE MULLIONS WITH THE MARKS (STEP 4) AT THE HEAD, SILL AND THE EXTERIOR OF THE SUBSTRATE.
7. FASTENING ANCHOR CLIPS:
  - a. WOOD FRAME INSTALLATION: A (2723 AND 2724)  
INSTALL THE ANCHOR CLIPS TO 2X FRAME USING (4)#10 x  $1 \frac{1}{2}$  INCH PHILLIPS FLAT HEAD SHEET METAL SCREWS PER CLIP.
8. REMOVE NAILING FIN FROM THE ENTIRE SIDE OF EACH WINDOW WHICH WILL BE FASTENED TO THE MULLION.
9. FOLLOWING THE WINDOW INSTALLATION INSTRUCTIONS, PREPARE WINDOW AND ROUGH OPENING AS REQUIRED.
10. FASTEN THE WINDOWS TO THE MULLION USING THE SELF-TAPING SCREWS PROVIDED, AS SHOWN.
11. CONTINUE INSTALLATION BY FOLLOWING THE WINDOW INSTALLATION INSTRUCTIONS.
12. INSERT CENTER CAP STRIP INTO RECEPTOR AS SHOWN IN ILLUSTRATION.