



2600 Veneer

Installation Manual

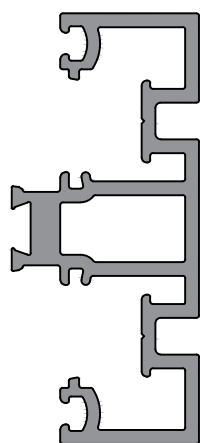
NOTES

1. Dimensions shown are in inches, bracketed [x] dimensions are in millimeters.
2. These instructions cover typical product application, fabrication, installation and standard conditions and are general in nature. They provide useful guidelines, but the final shop drawings may include additional details specific to the project. Any conflict or discrepancies must be clarified prior to execution.
3. Materials stored at the job site must be kept in a safe place protected from possible damage by other trades. Stack with adequate separation so materials will not rub together and store off the ground. Cardboard or paper wrapped materials must be kept dry. Check arriving materials for quantity and keep a record of where various materials are stored.
4. Coordinate protection of installed work with general contractor and/or other trades.
5. Coordinate sequence of other trades which affect framing installation with the general contractor (e.g. fire proofing, back up walls, partitions, ceilings, mechanical ducts, HVAC, etc.).
6. General contractor should furnish and guarantee bench marks, offset lines and opening dimensions. These items should be checked for accuracy before proceeding with erection. Make certain that all adjacent substrate construction is in accordance with the contract documents and/or approved shop drawings. If not, notify the general contractor in writing before proceeding with installation because this could constitute acceptance of adjacent substrate construction by others.
7. Isolate all aluminum to be placed directly in contact with masonry or other incompatible materials with a heavy coat of zinc chromate or bituminous paint. Fasteners attaching framing to building structure are typically not provided by Alumicor.
8. Sealant selection is the responsibility of the erector, installer and/or glazing contractor and must be approved by the sealant manufacturer with regard to application and compatibility for its intended use. All sealants must be used in strict accordance with the manufacturer's instructions and applied only by trained personnel to surfaces that have been properly prepared.
9. Sealant must be compatible with all materials with which they have contact, including other sealant surfaces. Consult the sealant manufacturer for recommendations relative to shelf life, compatibility, cleaning of substrate, priming, tooling/adhesion, etc. Recommend sealant manufacturer perform adhesion "pull test" at "wet" glazing for quality assurance.
10. This product requires clearances at the head, sill and jambs to allow for thermal expansion and contraction as well as construction tolerances. Refer to final distribution drawings for joint sizes. Joints smaller than 1/4" may be subject to failure. Consult the sealant manufacturer for proper sizing of joints.
11. All framing members, entrances and other materials are to be installed plumb, level and true with regard to established bench marks, column center lines or other working points established by the general contractor and checked by the erector, installer and/or glazing contractor.
12. Cleaning of exposed aluminum surfaces should be done per AAMA recommendations.
13. Check www.alumicor.com for any installation instruction updates.

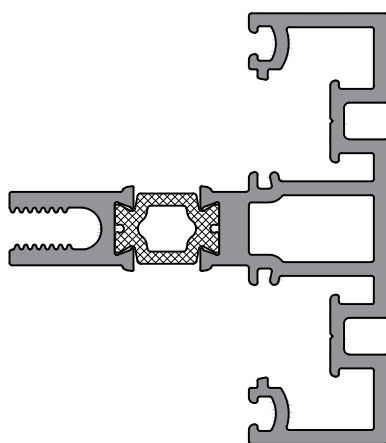
HANDLING, STORAGE AND CARE

The following precautions are recommended to protect the material against damage. Following these precautions will help ensure early acceptance of your products and workmanship.

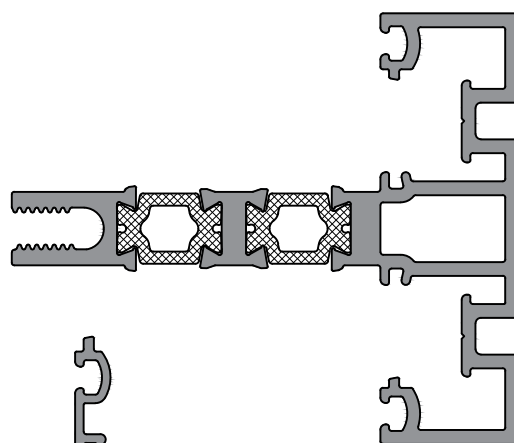
1. **HANDLE CAREFULLY.** All aluminum materials at job site must be stored in a safe place, well removed from possible damage by other trades. Cardboard wrapped or paper interleaved materials must be kept dry.
2. **CHECK ARRIVING MATERIALS.** Check all shipments from Alumicor immediately upon receipt thereof. Check for damage, count and quantities and keep records of where various materials are stored. Inform your Alumicor service representative immediately of errors, omission, questionable quality or damage.
3. **KEEP MATERIALS AWAY FROM WATER, MUD, AND SPRAY.** Prevent cement, plaster or other materials from damaging the finish.
4. **PROTECT THE MATERIALS AFTER ERECTION.** Protect erected frame with polyethylene or canvas splatter screen. Cement, plaster, terrazzo, other alkaline solutions, and acid based materials used to clean masonry are harmful to the finish. If any of these materials come in contact with the aluminum, IMMEDIATELY remove with water and mild soap.



26140
SSG Mullion



26150
Dbl Gla Rolled
Capped Mullion



26040
Mullion Snap
Cover

26160
Tpl Gla Rolled
Capped Mullion

GLASS SUPPORTS



26602
Dbl Gla Capped
Glass Support
4" long



25905
Dbl Gla SSG
Glass Support
5" long



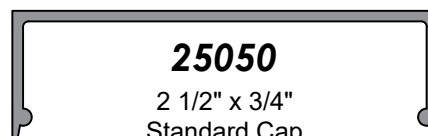
26614
Tpl Gla Capped
Glass Support
8" long



25906
Tpl Gla SSG
Glass Support
8" long

CAPS & PRESSURE PLATES

A wide variety of cap types and sizes are available. Please see the Alumaticor 2600 catalogue for details.



25050
2 1/2" x 3/4"
Standard Cap

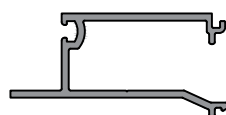


2509000
Punched Pressure Plate
(2519000 Unpunched)

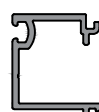
SPANDREL ADAPTORS



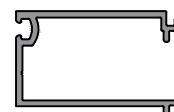
25787
Capped Spandrel
Adaptor - Dbl. Gla.



25788
Capped Spandrel
Adaptor - Tpl. Gla.



25792
SSG Spandrel
Adaptor - Dbl. Gla.



25793
SSG Spandrel
Adaptor - Tpl. Gla.

GASKETS



2681403
1/4" Silicone
Spacer Gasket

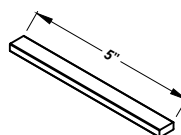


2644103
PVC Thermal
Barrier

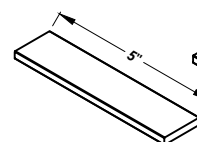


2554203
EPDM Pressure
Plate Gasket

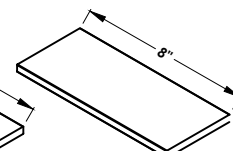
SETTING BLOCKS



2770503
EPDM Setting
Block - Sgl. Gla.

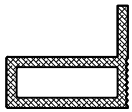


2770603
EPDM Setting
Block - Dbl. Gla.



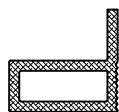
2770703
EPDM Setting
Block - Tpl. Gla.

POCKET FILLERS



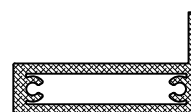
2552501

Pocket Filler - Dbl. Gla.
Rigid PVC - Grey



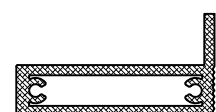
2551903

Pocket Filler - Dbl. Gla.
For use with $\frac{1}{8}$ " Exterior
Flashing and 1/16"
Membrane
Rigid PVC - Black



2554903

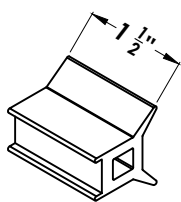
Pocket Filler - Tpl. Gla.
Rigid PVC - Black



2555501

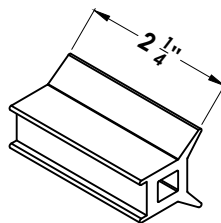
Pocket Filler - Dbl. Gla.
For use with $\frac{1}{8}$ " Exterior
Flashing and 1/16"
Membrane
Rigid PVC - Black

CORNER PLUGS & END PLUGS



2571303

EPDM End Plug
Dbl. Gla. Capped



2571503

EPDM End Plug
Tpl. Gla. Capped

SSG PERIMETER TRIM



TW22863

Perimeter Trim
Tpl. Gla. SSG



TW22862

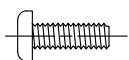
Perimeter Trim
Dbl. Gla. SSG



TW2285001

PVC Trim Anchor

FASTENERS



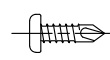
2252101

1/4"-20 x 3/4" LG
RH Machine Screw
PRESSURE PLATE SCREW



7266101

#6 x 1/2"
PHS TEK3 SELF
DRILLING/TAPPING SCREW
PVC TRIM ANCHOR SCREW



7154101

#10 X $\frac{5}{8}$ "
(#10 X 15.9mm)
PHS TEK2 SELF
DRILLING SCREW
POCKET FILLER SCREW

STEP 1

- Pre-drill the mullions for the appropriate mounting fasteners. **See Figure 1.** Frame fastener type and spacing along the mullion is to be determined by the project Engineer, considering the project requirements and mounting substrate. The maximum recommended mounting fastener diameter allowable in this system is $\text{Ø}1/4"$. Exceeding this fastener size may result in the fastener snap covers and glass chairs interfering with the mounting fasteners. **See Figure 2.**
- Cut mullions to size as per site measurements and/or shop drawings. This product is designed to be installed as a **vertical-through** framing system only, with horizontals always running between vertical frames. Failure to install this system in this manner could result in air/water breeches and drainage problems which Alumicor is not responsible for. **See Figure 3.**

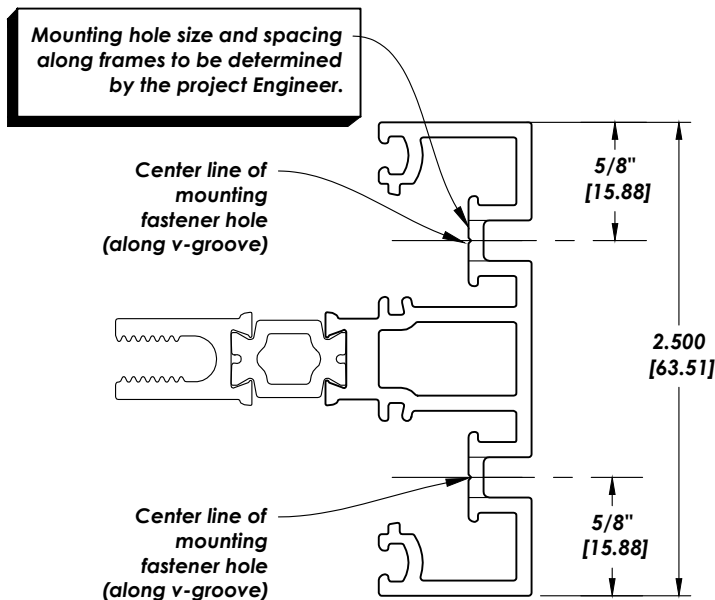


Fig. 1 Pre-drill mullions in the locations shown for the specified mounting fasteners.

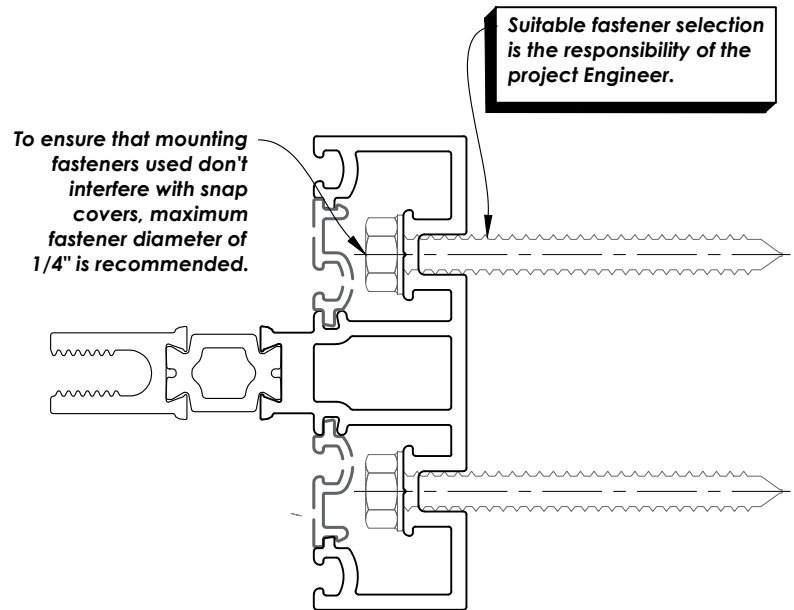


Fig. 2 Maximum 1/4" fastener diameter recommended. (#12 fasteners shown)

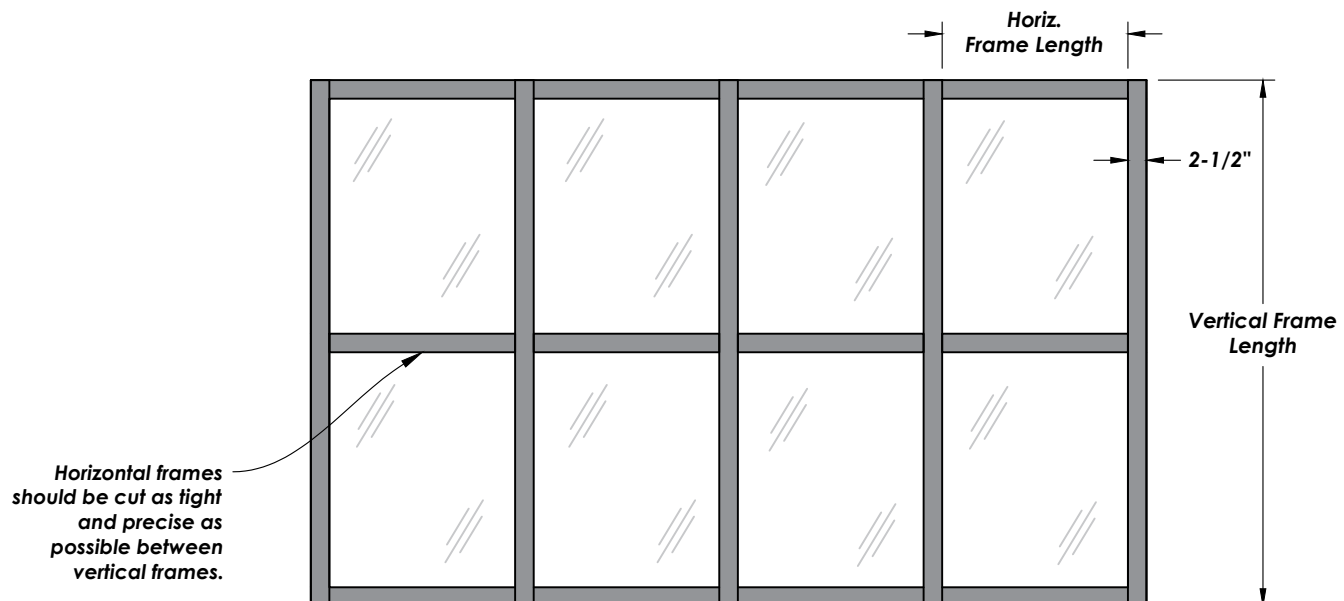


Fig. 3 This framing system is designed to be mounted in **vertical-through configuration only** for optimum system drainage and performance.

STEP 2

- Cut the pre-punched pressure plates to size as per shop drawings or site measurements. Vertical pressure plates are cut the the same length as vertical mullions and require no additional preps. Horizontal pressure plates are cut to the length of the horizontal frames minus 1/8".
- Drill drainage slots into both ends of the horizontal pressure plates only as shown below, an additional center drainage slot is required if the pressure plate exceeds 48" length.
- Drill spandrel vent holes into the horizontal pressure plates if required. **See Figure 4.**

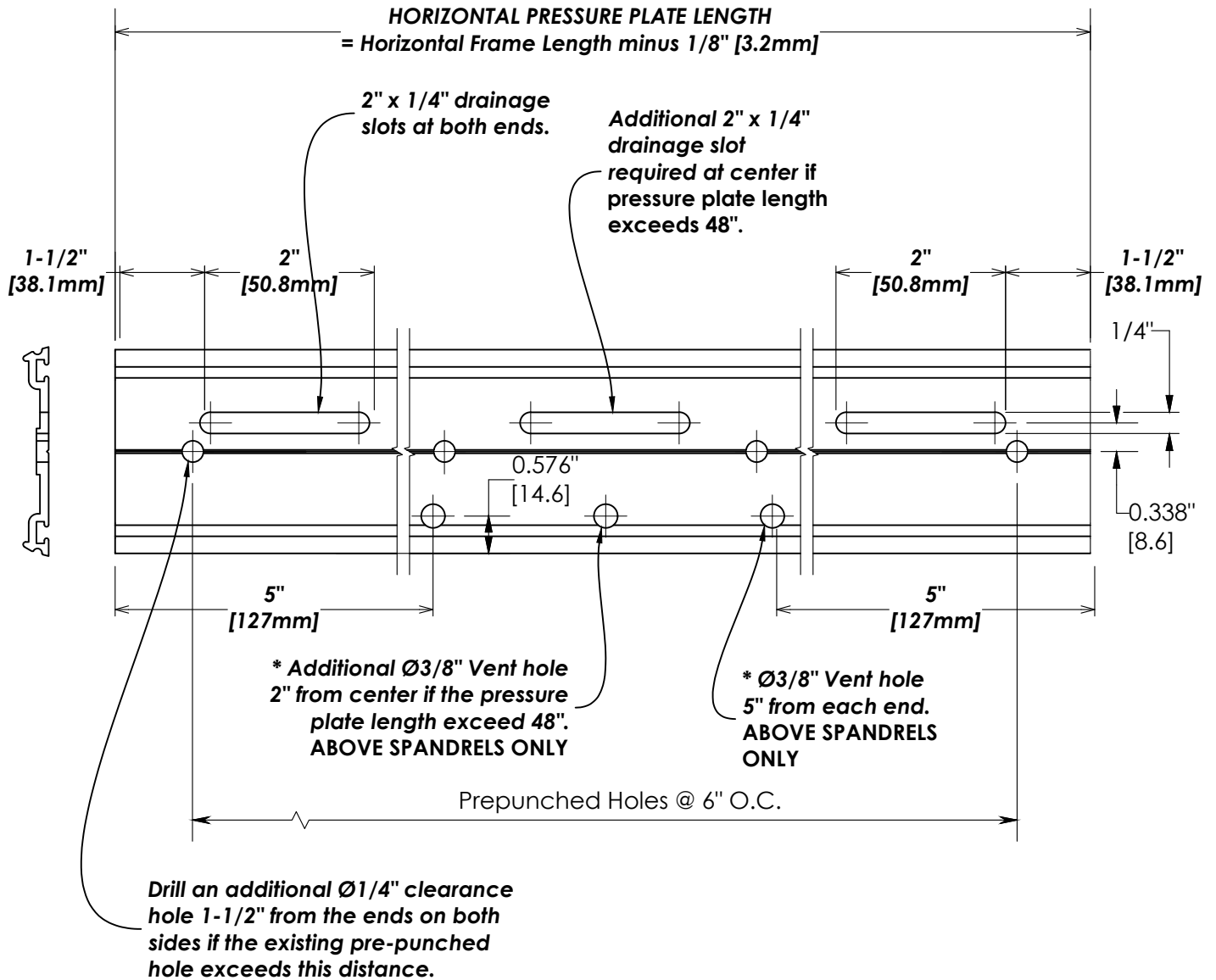
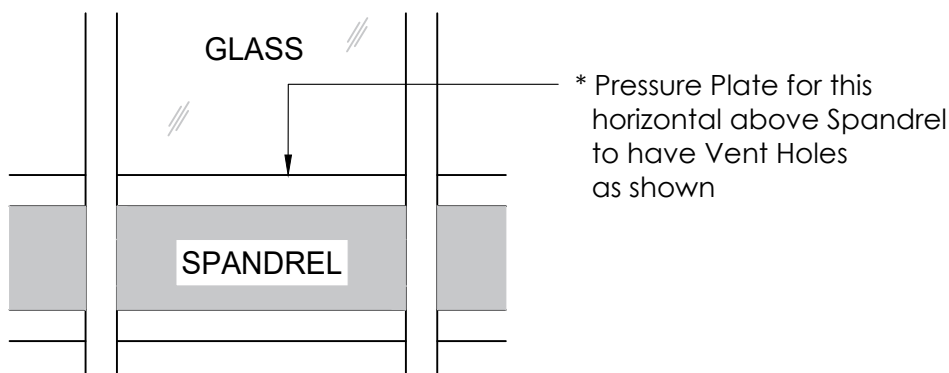


Fig. 4

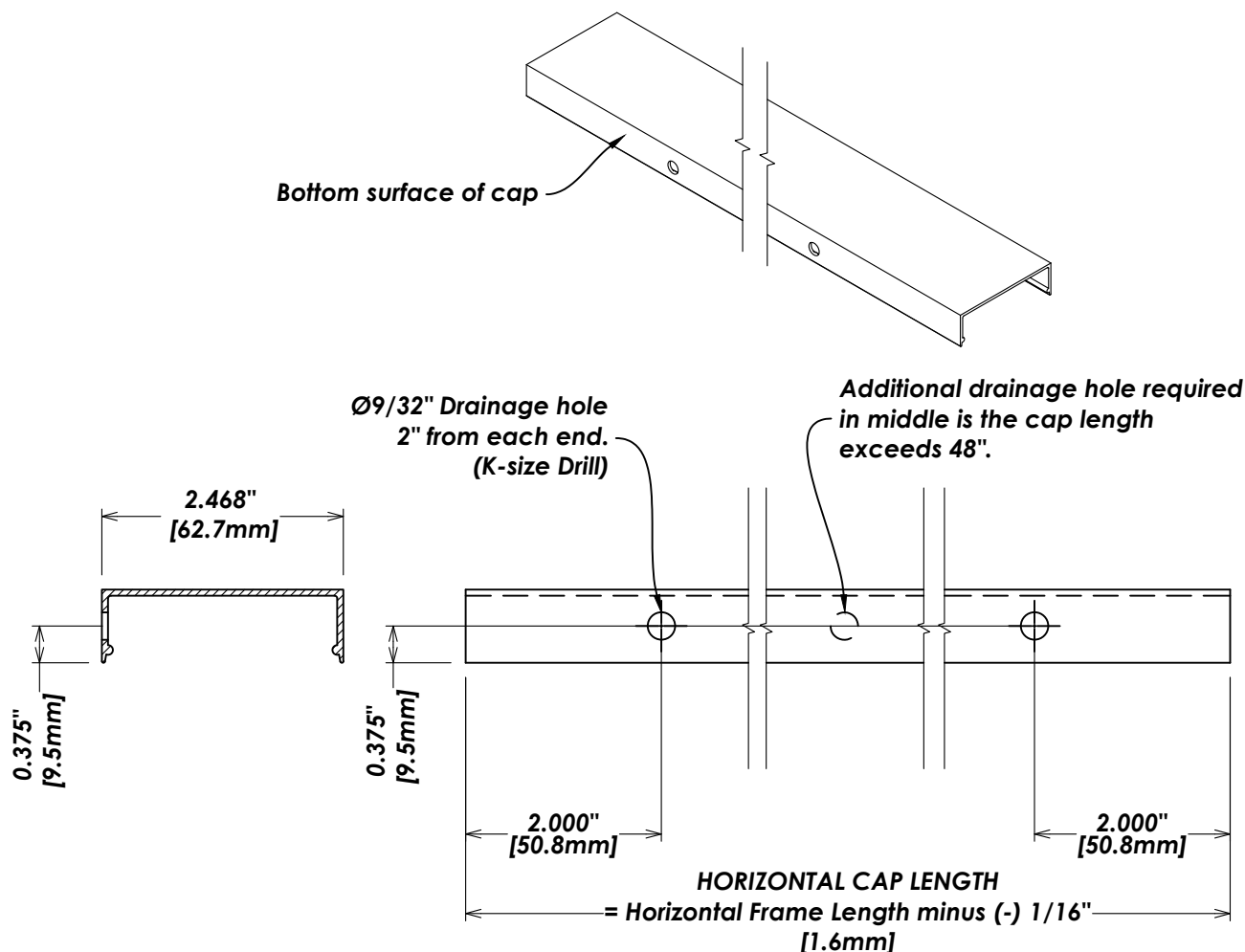


2509000

Punched Pressure Plate
(2519000 Unpunched)

STEP 3

- Cut the caps to size as per shop drawings or site measurements. Vertical caps are cut the the same length as vertical mullions and require no additional preps. Horizontal caps are cut to the length of the horizontal frames minus 1/16".
- Drill drainage holes into both ends of the horizontal caps only as shown below. An additional drainage hole is required at the middle if the cap exceeds 48" length.



A wide variety of special cap sizes are available. Please see the Alumicor 2600 catalogue for details.



25050
2 1/2" x 3/4"
Standard Cap

STEP 4

- Using the appropriate fasteners as specified by the project engineer, fasten the vertical frames to the substrate.
- Dry fit the horizontal frames between the verticals to ensure they fit tightly and there are no gaps.
- Immediately before installing the horizontal frames, clean the ends of the horizontals and the intersection area of the vertical using the IPA 2 wipe method. Place a liberal amount of sealant around the profile at each end. This seal must be done diligently and is critical to ensuring the air and water tightness of the frames. Tool any excess sealant along the joint. **See Figure 5.**
- Seal around all mounting fastener heads to ensure air/water tightness and to prevent breeches behind the mullions.

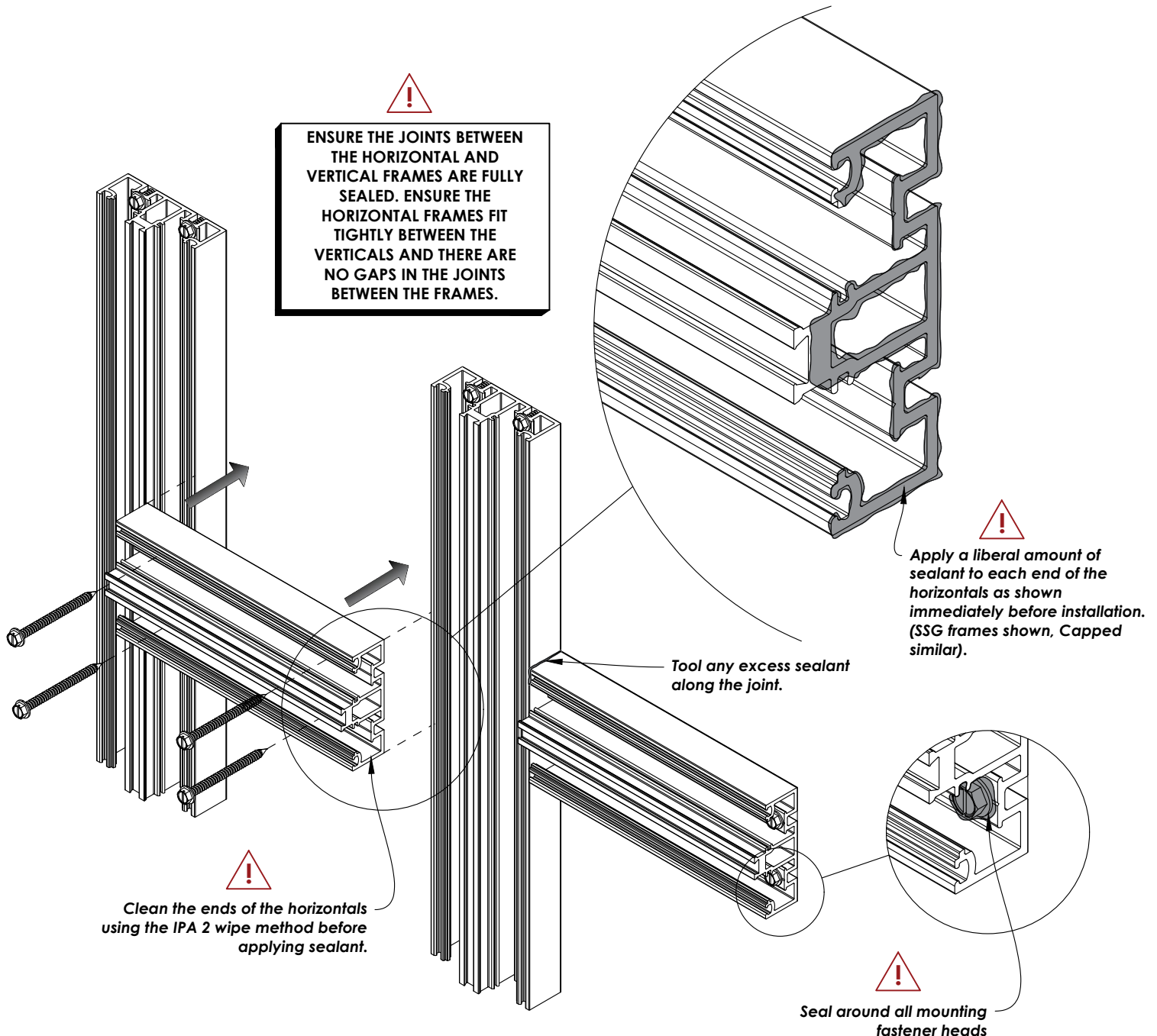
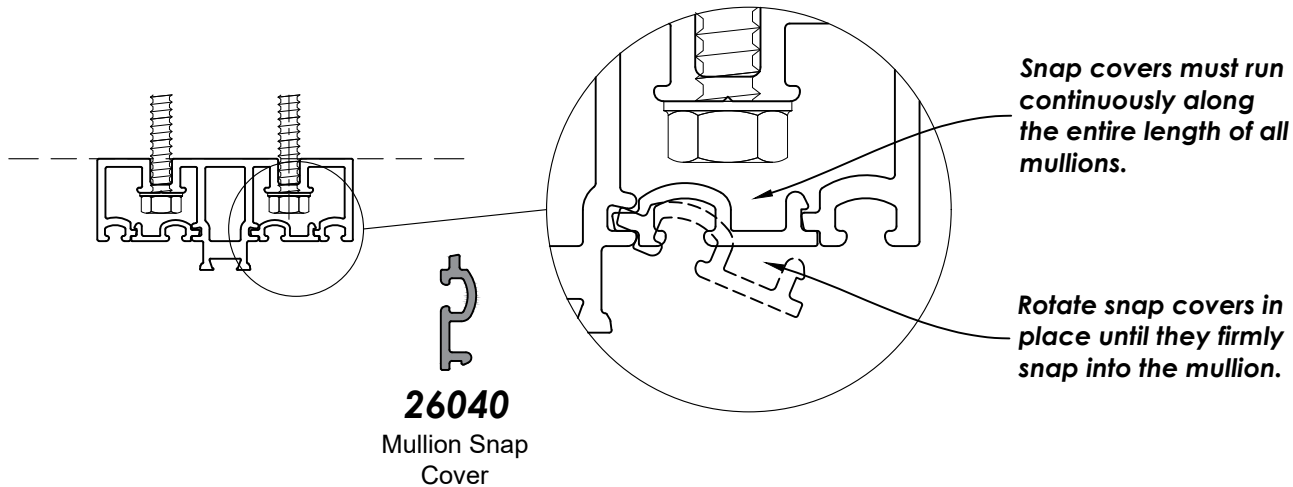


Fig. 5 Sealing joints between horizontal and vertical frames.

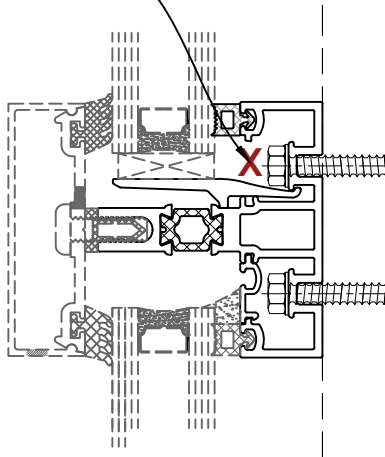
STEP 5

- Cut the snap covers to size. Snap covers are to be applied continuously along the mullions and should be cut to the same length as the mullions they are going to be installed into.
- Install the snap covers into the mullions by hooking one side and rotating the cover into the mullion until it firmly snaps. Snap covers are to be applied continuously on all mullions (SSG and Capped) except on the upper fastener chamber on horizontal capped mullions or any location which requires spandrel adaptors. The snap covers interfere with spandrel adaptors and the capped glass support.

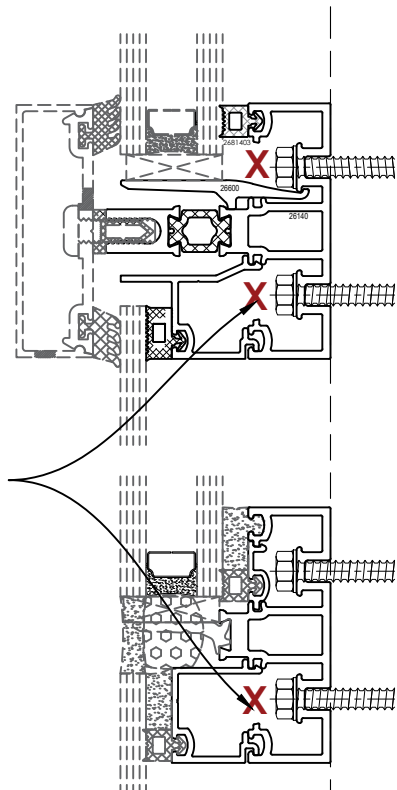


DO NOT INSTALL SNAP COVERS AT THE LOCATIONS NOTED BELOW:

Upper chamber of all Horizontal Capped Mullions.

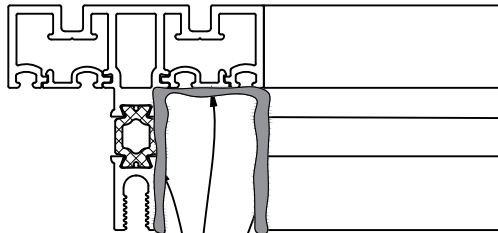


All Spandrel Adaptor locations (Capped & SSG - Horiz. & Vertical)



STEP 6

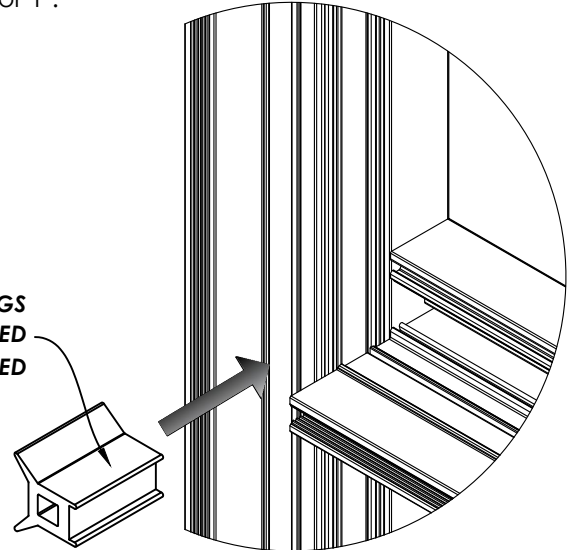
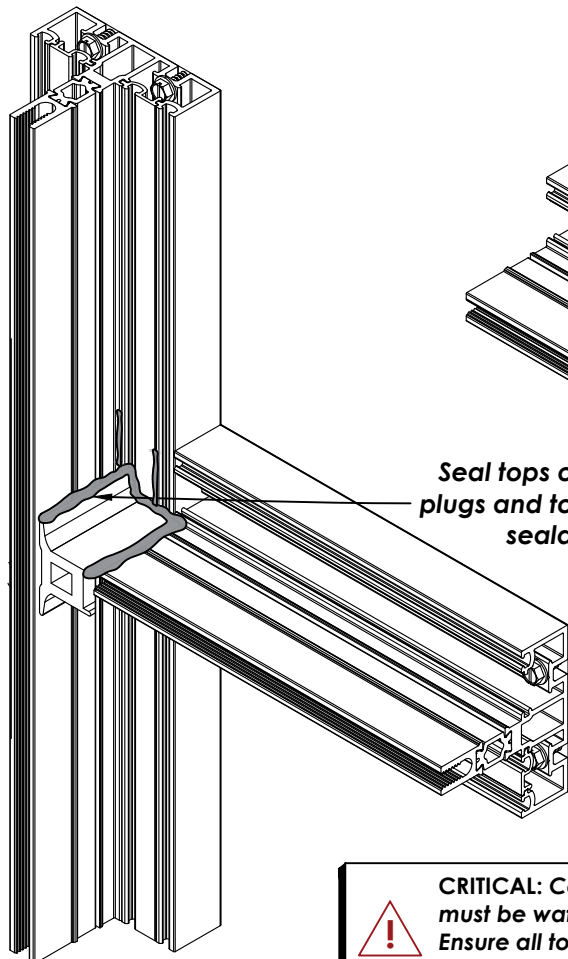
- Apply sealant to the three (3) contact surfaces that receive the corner plug.
- Push the appropriate corner plug into the gap between the front of the horizontal and vertical frames. This is a pressure fit; the corner plug should fit over the jaw of the horizontal frame as shown.
- Seal over the top of the corner plug where it overlaps the jaw of the horizontal. Apply a bead of sealant up the seams of the snap cover right above the plug for 1".



PLAN VIEW

Apply sealant to the three contact surfaces that receive corner plug prior to installing plug.

INSERT CORNER PLUGS
2571303 DBL GLAZED
2571503 TPL GLAZED



Seal tops of corner plugs and tool excess sealant.

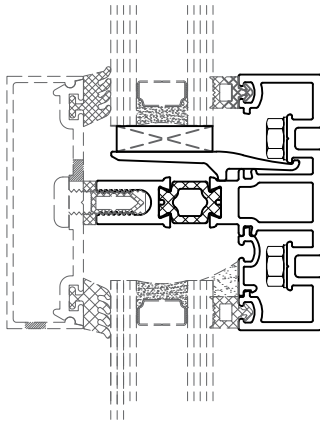
Apply a bead of sealant up the seams of the snap cover from the end plug up 1" to prevent water penetrating the snap cover at this location.



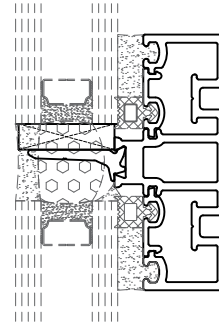
CRITICAL: Corner plug seal must be water-tight. Ensure all top edges are sealed.

STEP 7

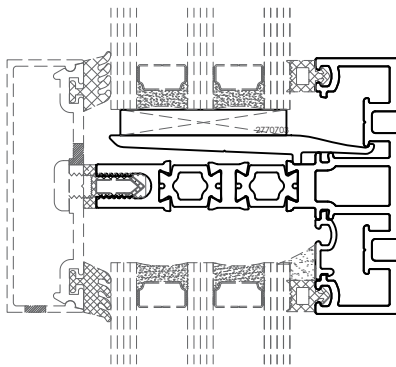
- Install two glass supports and setting blocks appropriate for the glass thickness at quarter points or as indicated on approved shop drawings. Hook the glass support into either the upper fastener shoulder (for capped) or the jaw of the mullion (SSG) as shown below.
- Apply a light bead of sealant across the top of the glass support and stick the appropriate setting block to it.



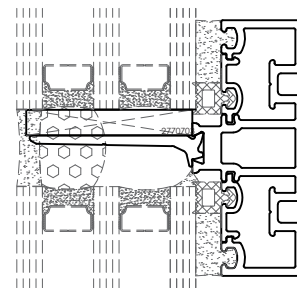
26602
Dbl Gla Capped
Glass Support
4" long



25905
Dbl Gla SSG
Glass Support
5" long



26614
Tpl Gla Capped
Glass Support
8" long

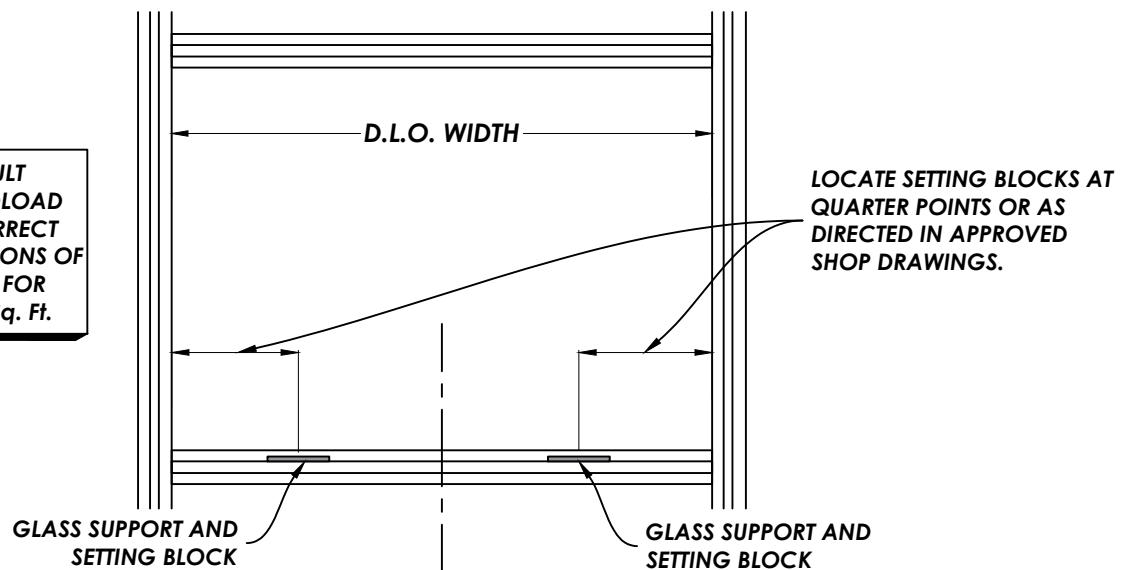


25906
Tpl Gla SSG
Glass Support
8" long

CAPPED GLASS SUPPORTS

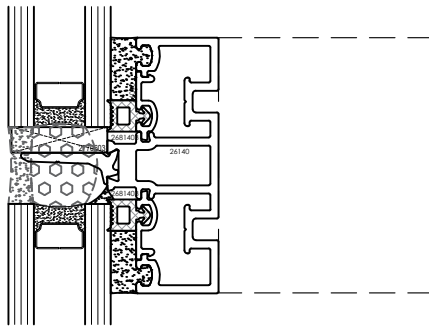
SSG GLASS SUPPORTS

CRITICAL: CONSULT ALUMICOR DEADLOAD CHARTS FOR CORRECT QTY AND LOCATIONS OF GLASS SUPPORTS FOR GLASS OVER 40 Sq. Ft.

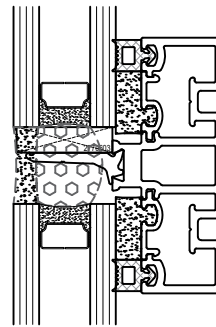


SSG Frame Configurations

The 2600 Veneer can be used in two different SSG configurations depending on the substrate and access to the SSG pockets. The spacer gaskets can be placed to the interior or exterior of the mullions, allowing structural silicone to be pumped from the sides of the mullion or from the front. Please refer to the project shop drawings for the specific SSG configuration to be installed.



SSG Configuration with spacer gaskets on the interior races.



SSG Configuration with spacer gaskets on the exterior races.

(Recommended if there is continuous substrate behind the veneer frames blocking access to the sides of the mullions - ie. Masonry walls)

STEP 8 (SSG)

- Using a clean brush, clean off any debris inside the gasket race. Clean using IPA method if needed.
- Insert the pre set gaskets continuously into the mullion races (refer to shop drawings for gasket configuration). Crowd the gaskets towards the center of the frame to avoid gaps forming as the gasket relaxes. Gaskets must run the entire length of the frames.
- Fold back the ends of the gaskets at each frame intersection.
- At each corner, apply sealant into the horizontal and vertical gasket races 1" long covering the frame joint at the same time.
- Install the vertical gasket into the race. Apply a small bead of sealant at the end of the horizontal gasket and install it into the race pushing it towards the vertical gasket. Clean excess sealant off of the gasket joint surface.
- Check to ensure the gaskets are seated into the race firmly. Apply a 2 inch bead of sealant around the gasket corner and tool into place, tooling the frame joint at the same time. Clean excess sealant on the gasket face. **See Figure 6.**



Apply a small bead of sealant at the end of the horizontal gaskets and press the gasket down into the race. Push the gasket towards the vertical gasket.

Once the gaskets are seated firmly in the race, apply a bead of sealant around the gasket joint. Clean off any excess sealant on the gasket face.

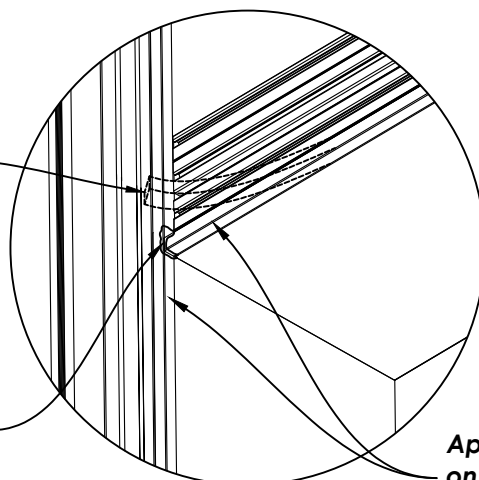


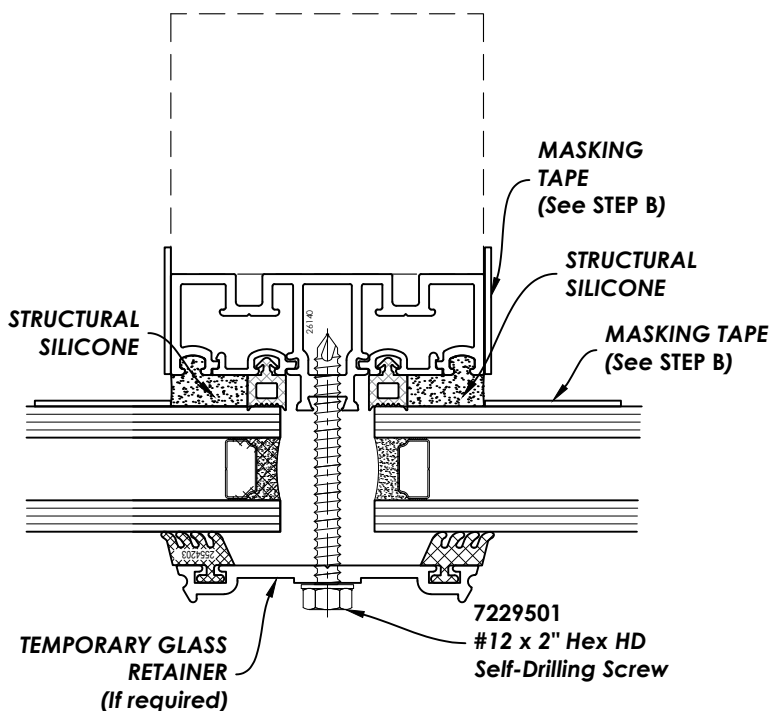
Fig. 6 Sealing joints between horizontal and vertical spacer gaskets.

CRITICAL: If a 1" spandrel unit is being used, it is recommended that two (2) 1" inch vent holes be cut out of the vertical gaskets 2" from the top. A drainage hole should also be cut out of the sill gasket 1" long at each corner. Any vision units below the spandrel area must have a ramp bead of sealant applied across the head length.

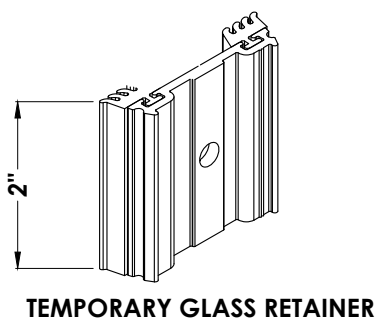
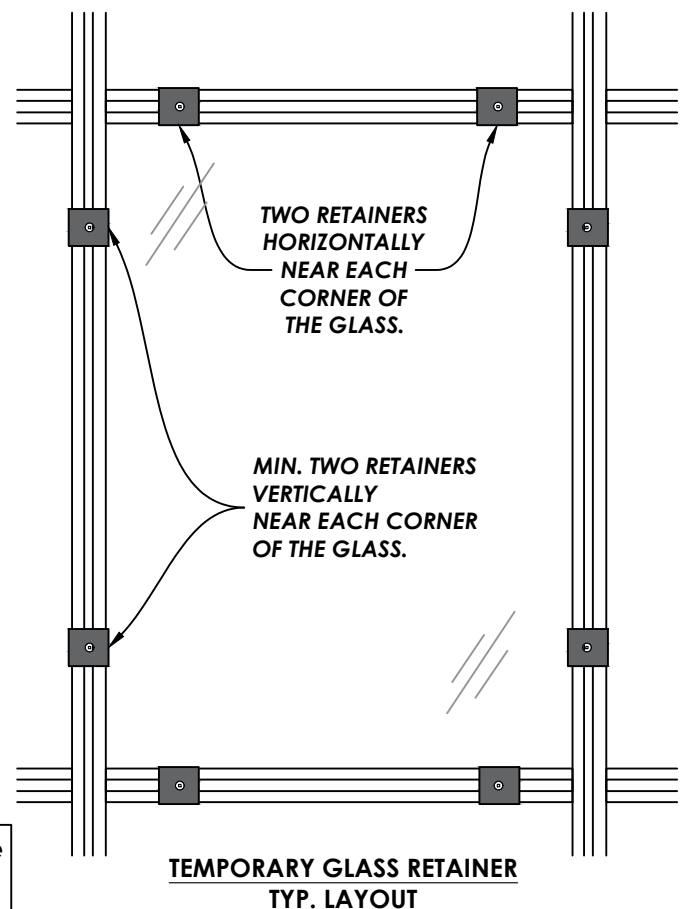
Apply sealant bead into the gasket races 1" long on both horizontal & vertical at the corners before the gaskets are installed.

STEP 9 (SSG)

- Check to ensure that the spacer gaskets are in the correct configuration as per shop drawings.
- Apply a piece of masking tape vertically on the glass, with the inside edge of the masking tape in line with the sides of the mullions. (Only if Silicone is being applied from the sides of the mullions.)
- Apply a piece of masking tape vertically along the edge of the mullion nearest to the glass.
- Prior to applying the structural silicone, clean all surfaces using an approved cleaner.
- Apply an approved structural silicone from the bottom to the top of the joint. Use positive pressure to completely fill the cavity between the glass and mullion.
- Using a nylon spatula or other non-scratching implement, tool the silicone immediately after sunning the vertical bead. Exert positive pressure while tooling to ensure that the silicone completely fills the cavity.
- Be careful not to remove too much silicone. The silicone should make complete contact with the glass and aluminum surfaces. The finish joint should be flush with the edge of the vertical.



SSG PLAN DETAIL
(Gaskets on Interior)



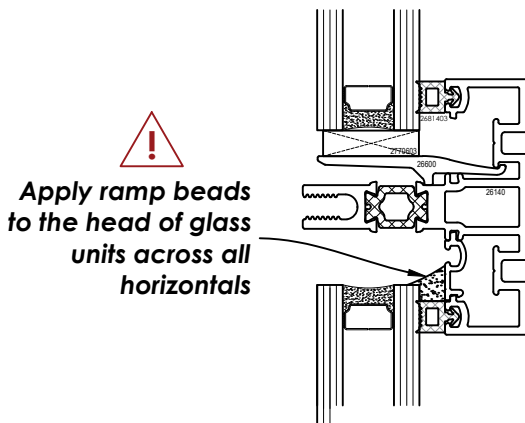
TEMPORARY GLASS RETAINER
TYP. LAYOUT



CRITICAL: Do not allow the silicone to skin over before it is tooled. Immediately remove the masking tape after tooling the silicone.

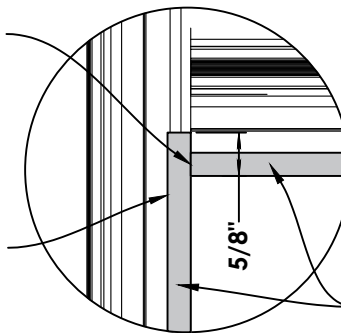
STEP 9 (Capped)

- Install the spacer gaskets and thermal barrier gaskets continuously into all mullions. Vertical spacer gaskets terminate at each horizontal joint - extend the vertical gaskets 5/8" beyond the DLO.
- A. Fold back the ends of the gaskets at each frame intersection.
- B. At each corner, apply sealant into the horizontal and vertical gasket races 1" long covering the frame joint at the same time.
- C. Install the vertical gasket into the race. Apply a small bead of sealant at the end of the horizontal gasket and install it into the race pushing it towards the vertical gasket. Clean excess sealant off of the gasket joint surface.
- b. Check to ensure the gaskets are seated into the race firmly. Apply a 2 inch bead of sealant around the gasket corner and tool into place, tooling the frame joint at the same time. Clean excess sealant on the gasket face. **See Figure 7.**
- c. Put the glass into position on top of the setting blocks and against the spacer gaskets.
- d. Temporarily hold the glass in place using glass retainers (2" cut lengths of pressure plate and gaskets). Locate retainers near each corner of the glass and at mid points horizontally.



Apply a small bead of sealant at the end of the horizontal gaskets and press the gasket down into the race. Push the gasket towards the vertical gasket.

Extend the vertical gaskets 5/8" beyond the DLO at the head, sill and intermediate joints.

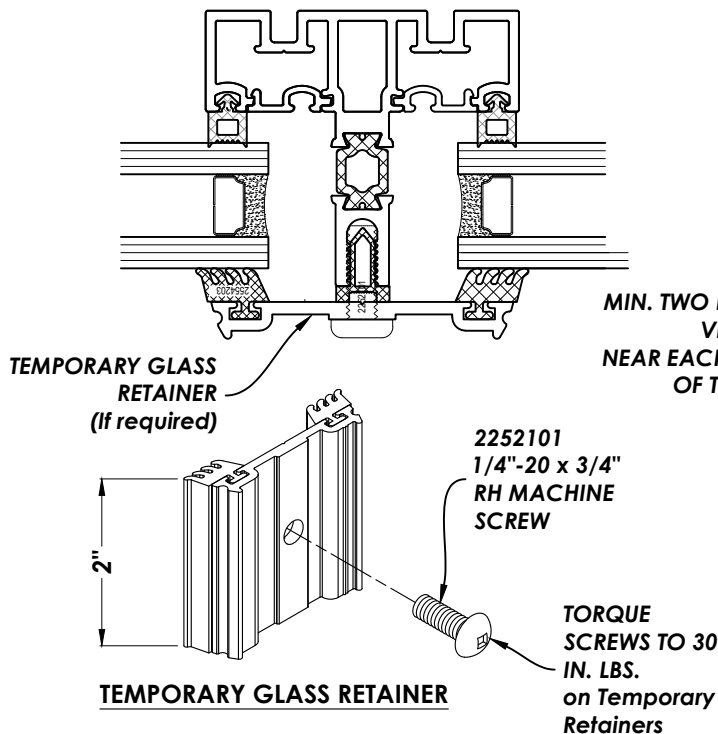


Apply sealant bead into the gasket races 1" long on both horizontal & vertical at the corners before the gaskets are installed.

Fig. 7 Sealing joints between horizontal and vertical spacer gaskets.

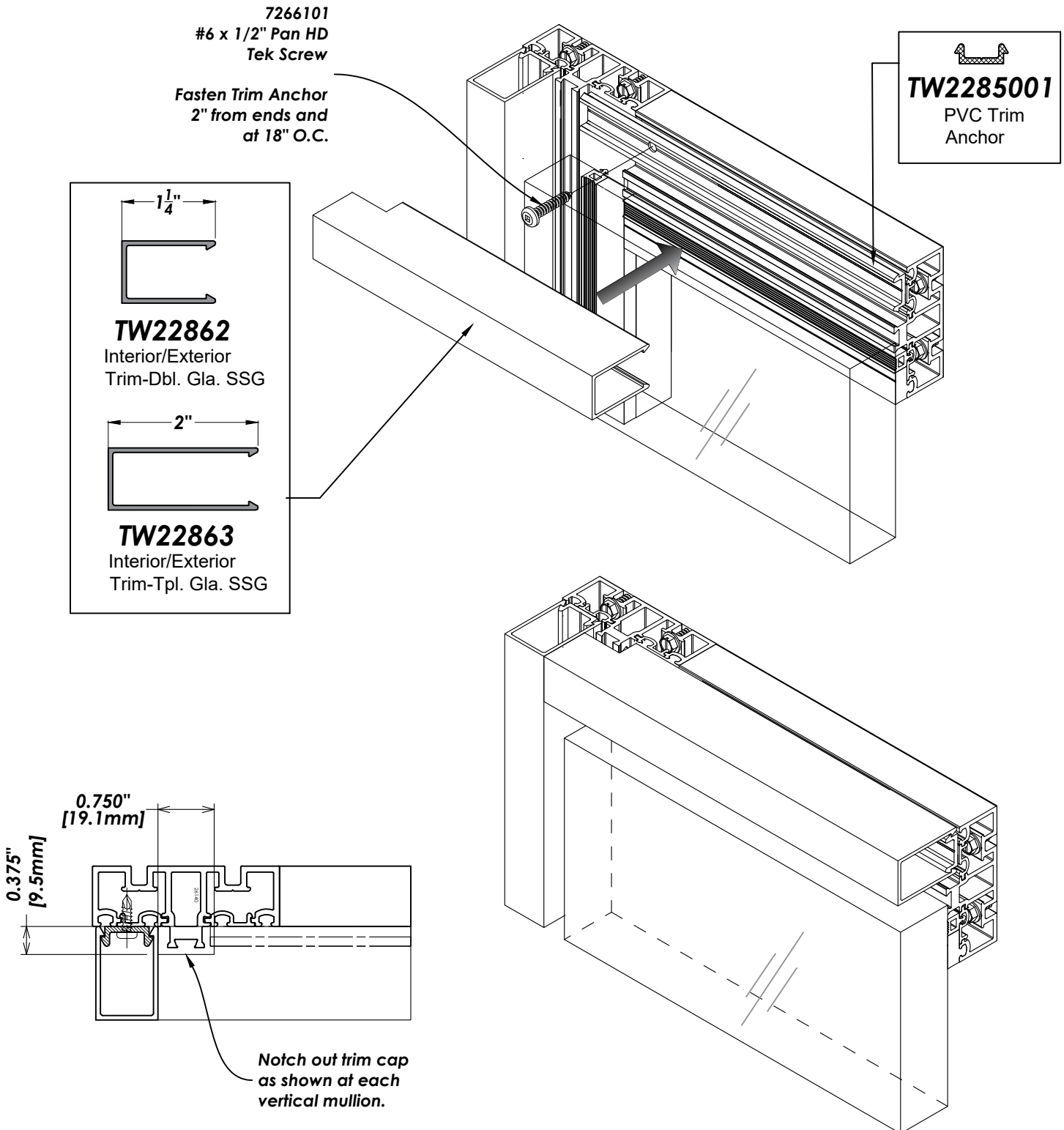


CRITICAL: Temporary glass retainers are intended for short term use only. Additional retainers or full length pressure plates may be required if high windload pressures are anticipated before the installation is complete.



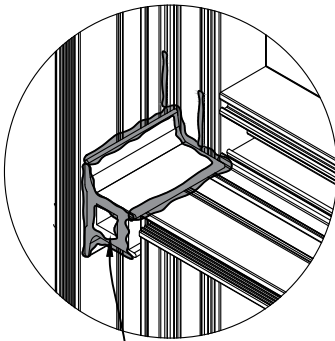
STEP 10

- Attach trim anchors to perimeter sides of the SSG mullions using **7266101** fasteners @ 18" O.C. Attach vertical anchors first - then horizontals.
- Snap on perimeter trim covers. The horizontal trim covers will need to be notched around the jaws of the vertical mullions to allow the trim cover to fit snug against the vertical trim.



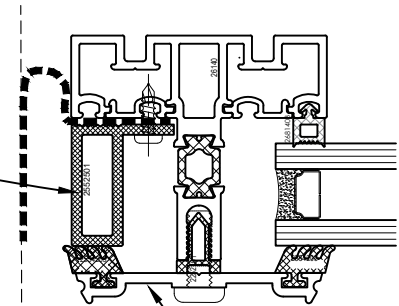
STEP 10 (Capped)

- Remove temporary glass retainers from vertical frames as required.
- Vertical pressure plates must be installed first. Prior to installing, apply sealant to the face of each corner plug. Insert perimeter pocket fillers as required.
- Install the vertical pressure plates using **2252101** screws - torque screws to 90 in. lbs. When using cordless drill with a torque limiter, check torque periodically against a torque wrench. Install the horizontal pressure plates after the verticals are installed.
- Ensure that there are screws in the pressure plates 2" max from the ends and 2" max from each horizontal/vertical intersection to maintain proper compression on the glass. Drill extra holes as required.
- Seal the joints between the pressure plates. Tool the sealant.
- Ensure that there are screws in the pressure plates 2" max. from the ends and 2" max. from each horizontal/vertical intersection to maintain proper compression on the glass. Drill extra holes in the pressure plate as required.



CRITICAL: Apply sealant to faces of corner plugs immediately before installing vertical pressure plates.

INSERT POCKET FILLERS AT PERIMETERS



**2509000
PUNCHED PRESSURE
PLATE**

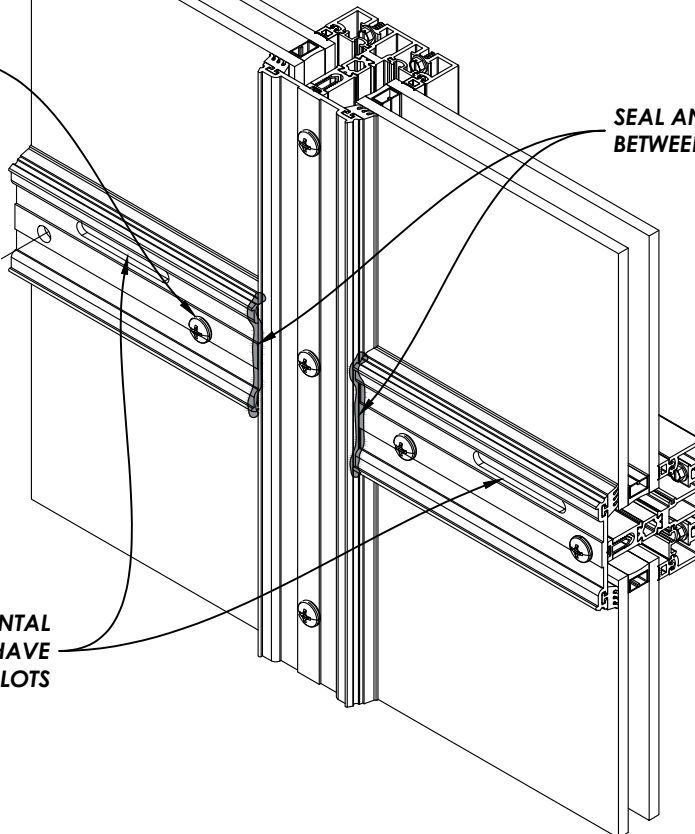
MAX. 2" FROM ENDS

TORQUE
SCREWS TO
90 IN. LBS.

**2252101
1/4"-20 x 3/4"
RH MACHINE
SCREW**

ENSURE HORIZONTAL
PRESSURE PLATES HAVE
DRAINAGE SLOTS

SEAL AND TOOL THE JOINTS
BETWEEN PRESSURE PLATES.

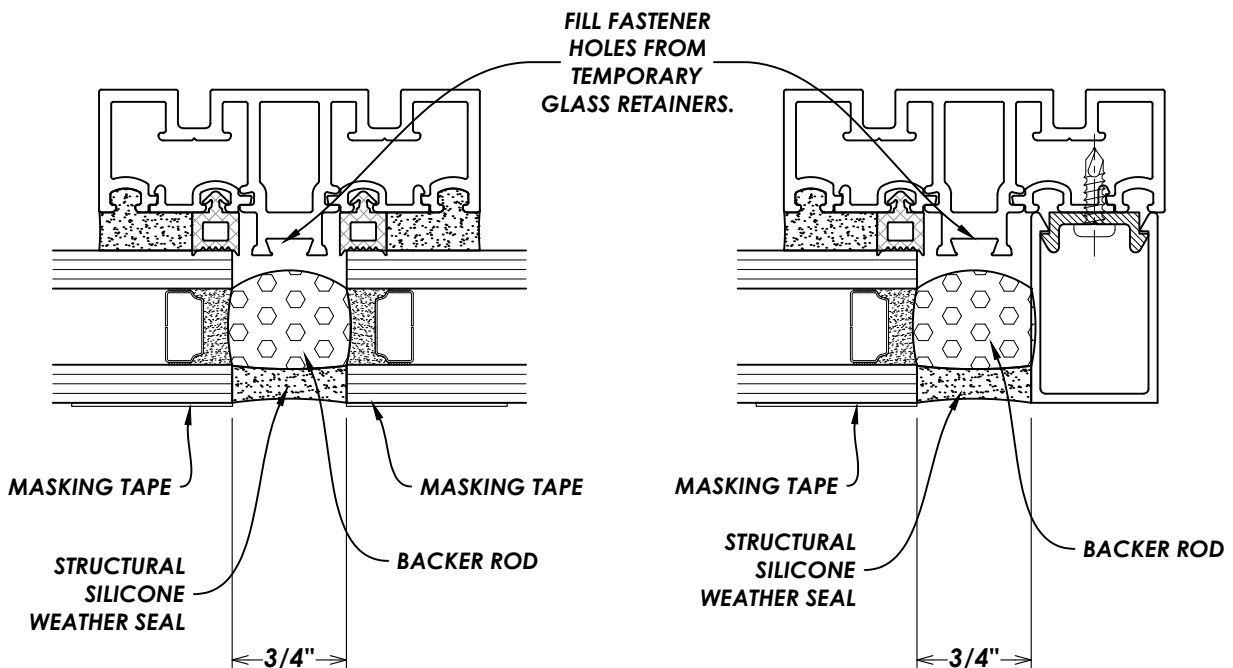


STEP 11 (SSG)

- Once the interior of structural silicone has cured, it is necessary to seal the exterior joint between the panes of glass. Please consult sealant manufacturer for recommended cure time.
- Remove the temporary glass retainers, fill fastener holes with sealant, and insert an approved, open cell polyurethane backer rod into the joint between the panes of glass.
- Clean all contact surfaces with an approved cleaner and apply masking tape to both vertical edges of the glass.
- Starting at the bottom of the lite, pump an approved structural silicone into the joint between the lites of glass. Apply moderate pressure so that the void is completely filled.
- Using a nylon spatula or other non-scratching implement, tool the silicone immediately after running the vertical bead. Exert positive pressure while tooling to ensure that the silicone completely fills the cavity.
- Be careful not to remove too much silicone. The silicone should make complete contact with both glass surfaces.

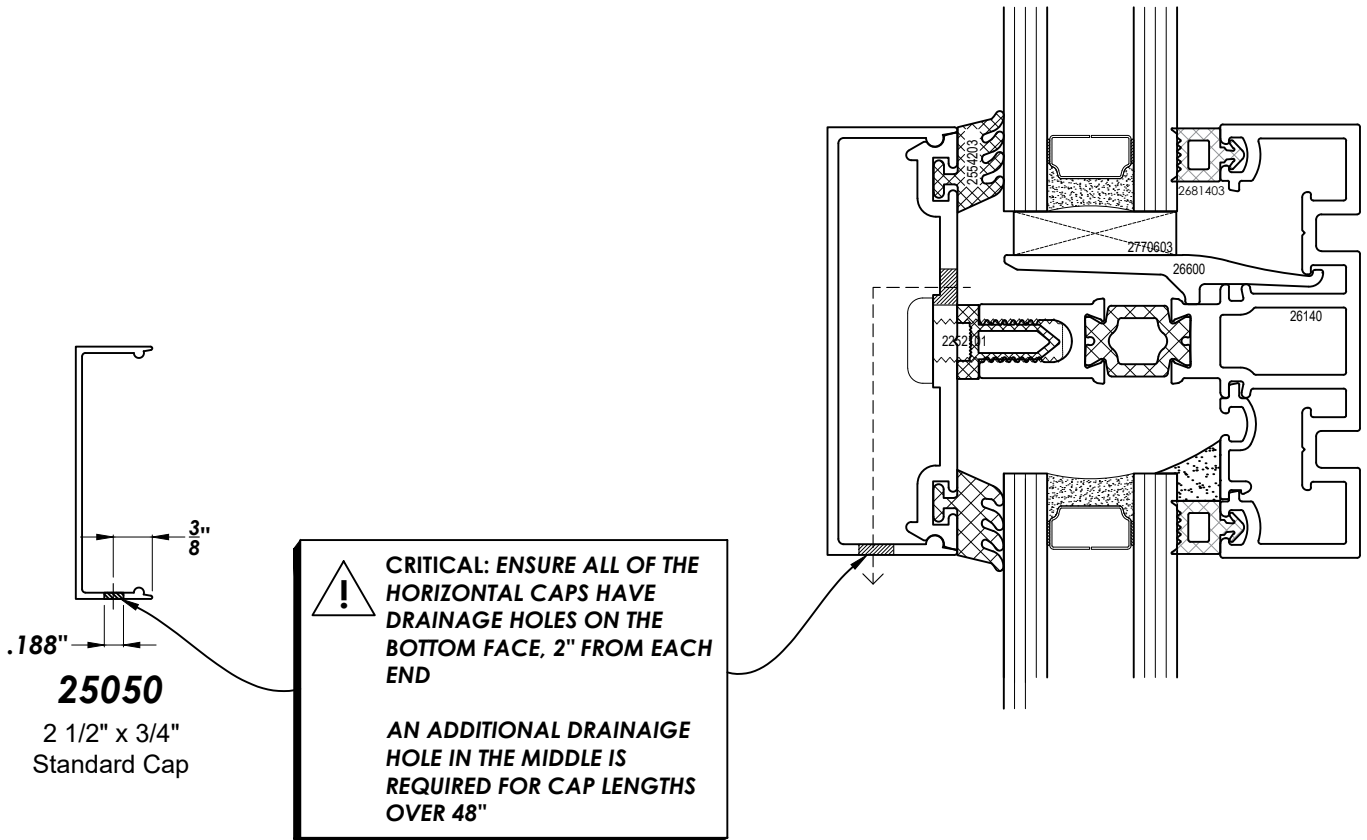


CRITICAL: Do not allow the silicone to skin over before it is tooled. Immediately remove the masking tape after tooling the silicone.



STEP 11

- Install caps using a soft pine wood block with cloth cover and tap onto cap with a soft dead blow mallet to protect the face cover. Do not hammer on caps.
- Install vertical caps first, then horizontal caps.
- Install caps with equal gaps on each end. Ensure the horizontal caps are installed with the weep holes facing down.



A wide variety of special cap sizes are available. Please see the Alumicor catalogue for details.