

**IMPORTANT NOTE:** Metal Window Corp's (MWC) corner units are intended to be installed by a qualified, licensed C17 glazing contractor and are to be installed following published standards of the latest versions, including but not limited to: American Society for Testing and Materials (ASTM) E2112, American Architectural Manufacturers Association (AAMA) 2400, and Glass Association of North America (GANA) Glazing Manual. All MWC provided products must be installed in accordance with the aforementioned standards and the MWC published installation instructions. Once the frames are delivered, it is the dealer (Customer) / installer's responsibility to meet the standards of the industry to supply a weather-resistive and well functioning installation. Failure to fully comply in any respect with these instructions (or with the provisions contained in this paragraph) will void the Warranty provided herein.

### Assemble Corner Unit

1. Apply bead of compatible sealant on frame at bracket attachment locations. Assemble frames using the screws supplied. Seal around the full perimeter of the bracket and at all screw heads. (See Fig. 1).

Skip this step for units that are received fully welded.

### Installation of Frame

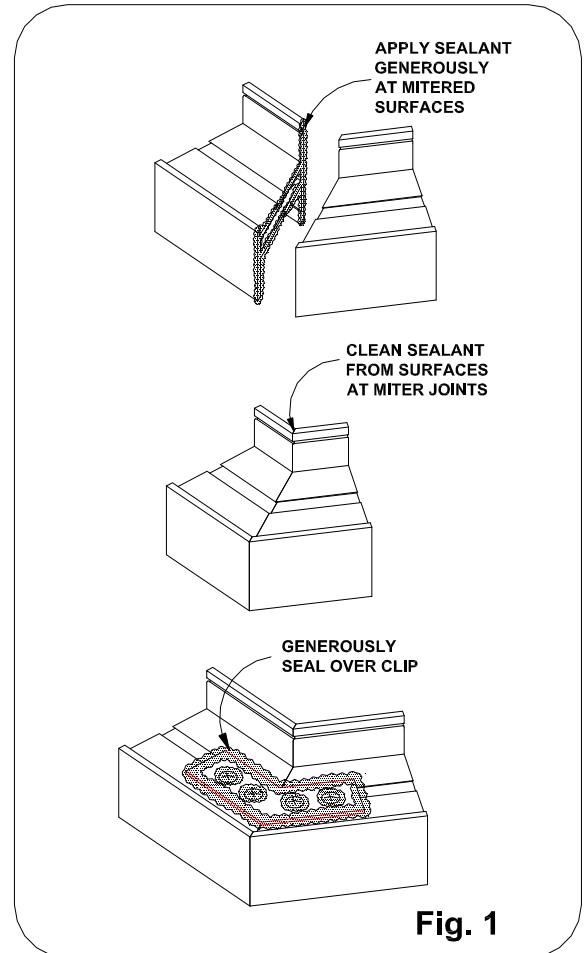
2. Install frame following instructions supplied for perimeter flashing and sealing. Note: Frame must be installed plumb, level and square. (Glass will not fit if the frame is not properly installed)

### Prepare Frame for Glazing

3. Remove glazing beads marking them so they can be reinstalled in their original position. Inspect inside corners of perimeter frame for a continuous seal. Apply compatible sealant if this seal is incomplete or absent. Install glazing tape and apply compatible sealant as shown. (See Fig. 2)

### Setting Blocks

4. Install setting blocks at locations indicated by the notched glazing beads. 3/8" setting blocks are standard for use on the 1500 Series frame, and 1/4" setting blocks are standard for use on the 2000 Series frame.

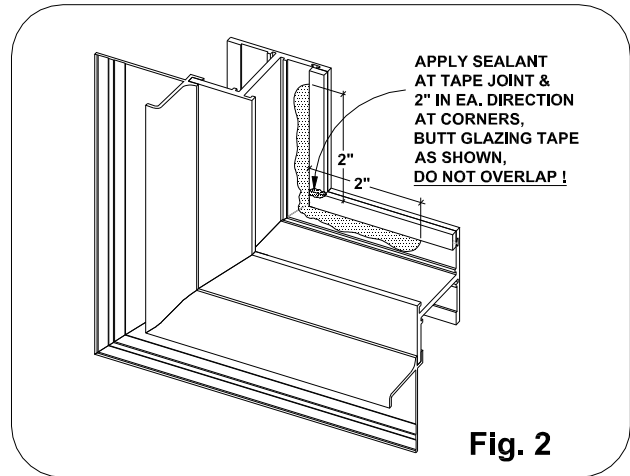


**Fig. 1**

**Install the Glass**

- Take care to position glass according to labels if present, "Glaze this side out" Starting with the bottom lite, set the glass onto the setting blocks and carefully adjust glass for proper fit and alignment prior to pressing into the glazing tape and compatible sealant. Once satisfied with the position of the glass press into tape and compatible sealant. Install both bottom lites of glass. Install sill and jamb glazing beads using short pieces of glazing vinyl to retain the glass.

Carefully install setting blocks at the top between the glass and the horizontal muntin. Ensure the setting blocks fit snug and support the muntin and the muntin is level. **This is critical.** If this step is not done properly the muntin bars will sag and the unit will have to be re-glazed (See Fig. 3) Install glazing bead at head.



**Fig. 2**

**Butt Joint**

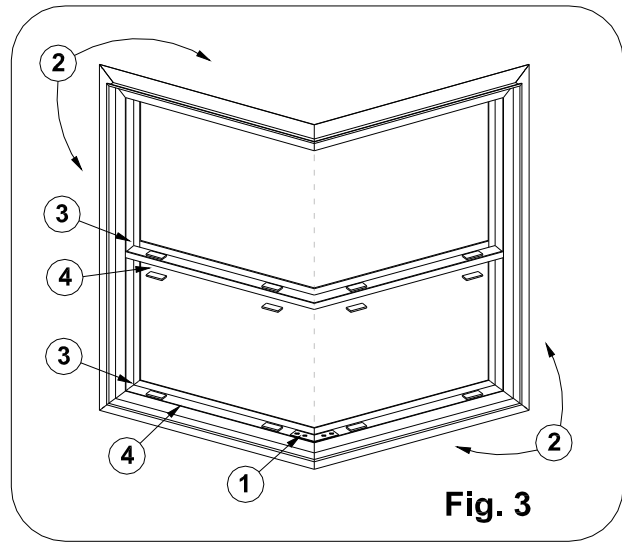
- Butt joint "leave 3/16" to 1/4" gap between the glass at the butt joint. Seal the entire length of the glass including into the glazing pocket using a compatible sealant.

**Install Glazing Vinyl**

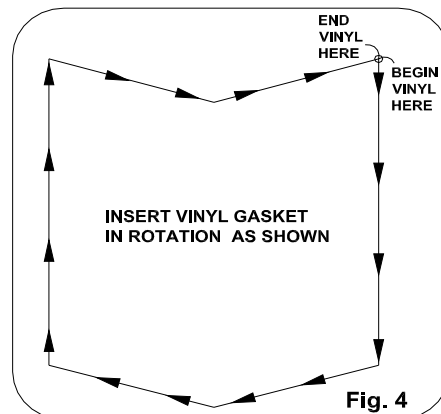
- Install glazing vinyl. Cut a piece of glazing vinyl longer than required to do the entire opening.

Press in glazing vinyl using a vinyl roller starting at one of the top corners of the glass. Run glazing vinyl around the entire perimeter of the glass. Back cut vinyl at corners. Do not stretch vinyl while installing. (See Fig. 4) Repeat Until Complete

- Repeat steps 4,5,6, & 7 for each lite of glass until the entire unit is glazed.



**Fig. 3**



**Fig. 4**

### GENERAL INSTRUCTIONS

THESE INSTALLATION INSTRUCTIONS ARE RECOMMENDATIONS ONLY. FOR MORE DETAILED INSTRUCTIONS APPLICABLE TO THE TYPE OF INSTALLATION THAT IS INTENDED FOR THIS PRODUCT, PLEASE REFER TO THE CURRENT VERSION OF AMERICAN ARCHITECTURAL MANUFACTURERS ASSOCIATION AAMA 2400, STANDARD PRACTICE FOR INSTALLATION OF WINDOWS WITH A MOUNTING FLANGE IN STUD FRAME CONSTRUCTION. THE CURRENT VERSION OF AMERICAN SOCIETY FOR TESTING AND MATERIALS INTERNATIONAL ASTM E2112; STANDARD PRACTICE FOR INSTALLATION OF EXTERIOR WINDOWS, DOORS AND SKYLIGHTS. INFORMATION MAY BE OBTAINED AT WWW.AAMANET.ORG OR WWW.ASTM.ORG.

Check that the opening is Level (in the horizontal plane), Plumb (in the vertical plane), True (across both planes), and square (across the diagonals) before proceeding with installation of this product.

Measure this product prior to installation, for sufficient clearance between product frame and opening.

The installation of the correct type of flashing and compatible sealant in the opening is critical to maintaining the weather resistant barrier. Please follow the flashing and compatible sealant manufacturer's specifications and installation details.

Sealing between this fenestration product and the flashed opening should be completed with the appropriate type of compatible sealant, recommended by the compatible sealant manufacturer for the type of application. The compatible sealant manufacturers recommended application instructions for proper joint size and sealing technique must be followed.

Making sure that sashes or operating panels are closed and locked during installation; center this product into opening checking and measuring for level, plumb, true, and square.

This product should only be secured to the opening when it is level, plumb, true, and square. Follow the appropriate fastener schedule for fastener size and spacing. Fasteners should be selected and installed to secure the weight, wind load and temperature variations of this product to meet the current building codes, applicable for the region. Projected windows are not self supporting, and require supports and bracing.

Check this unit for ease of operation immediately after installation and that it is in good working condition. It is important that all weep holes remain unobstructed. Clean using only mild detergents and non-etching cleaning agents. Do not use hydrocarbon fuels or solvents, paint removers, aggressive alkaline, acidic, or abrasive cleaners, cleaners containing trisodium phosphate, organic solvents, strong soaps or detergents to clean this product.

MANUFACTURER MAKES NO WARRANTY, EXPRESSED OR IMPLIED, WITH RESPECT TO THESE INSTRUCTIONS OR ANY THIRD PARTY INSTRUCTIONS, AND MANUFACTURER SHALL NOT BE LIABLE FOR ANY DAMAGE OR LIABILITY THAT MAY ARISE IN CONNECTION WITH THE INSTALLATION OF THIS PRODUCT NOT PERFORMED BY MANUFACTURER.

**General instructions available in Spanish upon request**  
**Las instrucciones generales disponibles en español sobre la petición**