

# Non-Reinforced Horizontal Joining Guide

for Andersen® Narroline® Circle Top® over 400 Series Tilt-Wash Double-Hung, Woodwright® Double-Hung, Woodwright® Picture, Tilt-Wash Picture or 200 Series Narroline Double-Hung; 400 Series Tilt-Wash Transom (TWT) over 400 Series Tilt-Wash Double-Hung, or Tilt-Wash Picture; 200 Series Narroline® Transom over Narroline® Double-Hung; Flexiframe® over 400 Series Tilt-Wash Double-Hung, Tilt-Wash Picture; Architectural Window over 400 Series Tilt-Wash Double-Hung or 200 Series Narroline® Double-Hung Window

## Thank you for choosing Andersen.

Instructions are for typical, new wood-framed wall construction with weather protection in place.

Instructions may not be right for all installations due to building design, construction materials or methods used and/or building or site conditions. Consult a contractor or architect for recommendations.

Flanges on the unit alone will not properly flash and seal the window. Follow these instructions carefully.

For questions call 1-888-888-7020. For more information and/or guides visit [andersenwindows.com](http://andersenwindows.com).

**Please leave this guide with building owner.**

- ▶ **Read guide from beginning to end before starting installation. Read all warnings and cautions during unit installation.**
- ▶ **Check with your local building code official to identify and confirm compliance with local building code requirements.**

### ⚠ WARNING

Use caution when working at elevated heights and around unit openings. Follow manufacturers' instructions for ladders and/or scaffolding. Failure to do so may result in injury or death.

### ⚠ WARNING

Follow manufacturers' instructions for hand or power tools. Always wear safety glasses. Failure to do so may result in injury and/or product damage.

### ⚠ WARNING

Windows and doors can be heavy. Use safe lifting techniques and a reasonable number of people with enough strength to lift, carry and install window and door products to avoid injury and/or product damage.

### ⚠ WARNING

Unless specifically ordered, Andersen windows and doors are not equipped with safety glass, and if broken, could fragment causing injury. Many laws and building codes require safety glass in locations adjacent to or near doors. Andersen windows are available with safety glass that may reduce the likelihood of injury when broken. Information on safety glass is available from your local Andersen dealer.

### CAUTION

- Andersen® Head Flashing and Installation Flanges DO NOT take the place of standard window and door flashing. Unit must be properly flashed and sealed with a material compatible sealant for protection against water and air infiltration. Use non-reflective flashings. Highly reflective flashing tapes can raise the surface temperature of the vinyl to the point where vinyl deformation and product damage may occur.
- Do not apply any type of film to glass. Thermal stress conditions resulting in glass damage could occur.
- Use of movable insulating materials such as window coverings, shutters, and other shading devices may damage glass and/or vinyl. In addition, excessive condensation may result causing deterioration of windows and doors.

## Parts Included

- (1) Exterior Trim Strip (Wide or Narrow)
- (2) Gusset Plates
- (8) No. 8 x 2" Flat Head Screws
- (2) Spacer Blocks (Narroline® Transom Window Only)

## Additional Parts Required

- Head Filler Piece (Tilt-Wash, Woodwright® and Picture Windows Only)

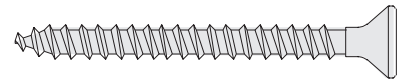
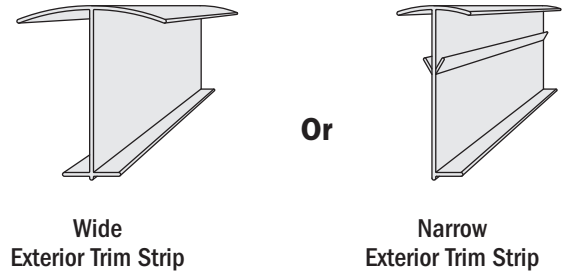
## Tools Needed

- Safety Glasses
- 3/32" Drill Bit
- Drill/Driver
- Phillips Screwdriver
- Clamps
- Utility Knife
- Sealant
- Caulk Gun
- Tacks or Glue
- 1/2" Fasteners
- 3/4" Fasteners
- Wood Block

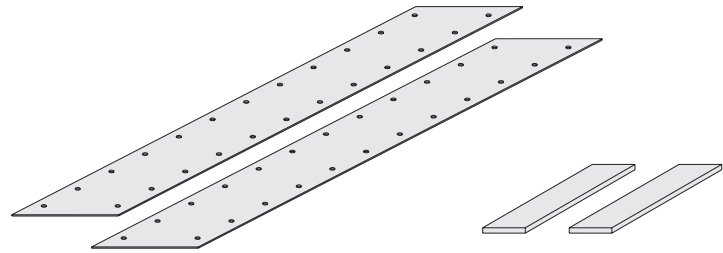
## NOTICE

A specific Exterior Trim Strip must be used when Joining Flexiframe® Units over Narroline® Units. Refer to Instruction Guide #0005322.

## Component Identification



#8 x 2" Flat Head Screws



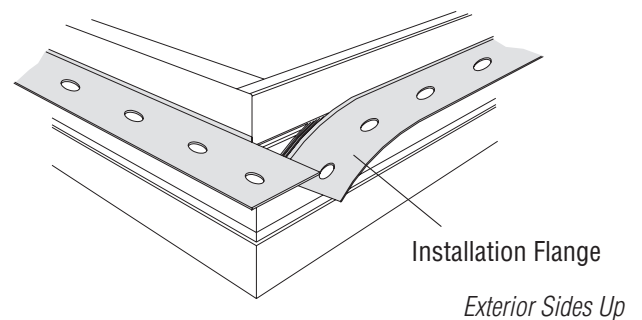
Gusset Plates

Spacer Blocks  
(Narroline® Transom Windows Only)

## 1. Remove Installation Flanges from Head and Sill to Be Joined

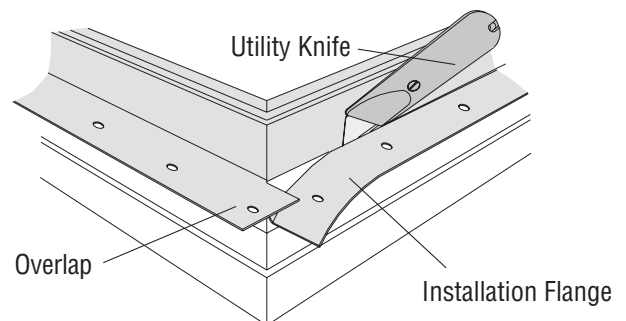
### Tilt-Wash, Narroline®, Flexiframe®, Architectural, or Picture Window

- Remove *Installation Flange* from the head of Tilt-Wash or Double-Hung Picture Window by pulling outwards.
- Place units, interior side up, on clean flat work surface.



### Double-Hung Circle Top™ Window

- Use a sharp utility knife to cut and remove *Installation Flange* at sill of Circle Top™ Unit. Leave an overlap at sides as shown.
- Place units, interior side up, on clean flat work surface.



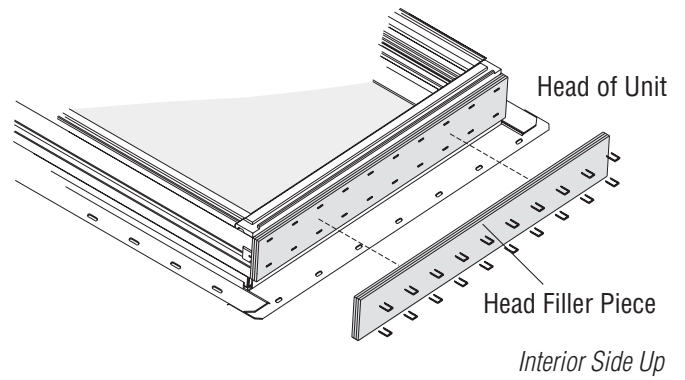
## 2. Prepare Units For Joining

### NOTICE

Follow procedures for the specific unit being joined.

#### Tilt-Wash, Woodwright® or Picture Window Units ONLY

- Determine if joining a Narroline® Circle Top™ window over one of these units. If so execute step below; if joining other units over these, skip step below and proceed to next unit prep operation appropriate for the specific unit to be joined.
- Position *Head Filler Piece* (sold separately) flush with interior of frame. Attach with 3/4" fasteners every 8".

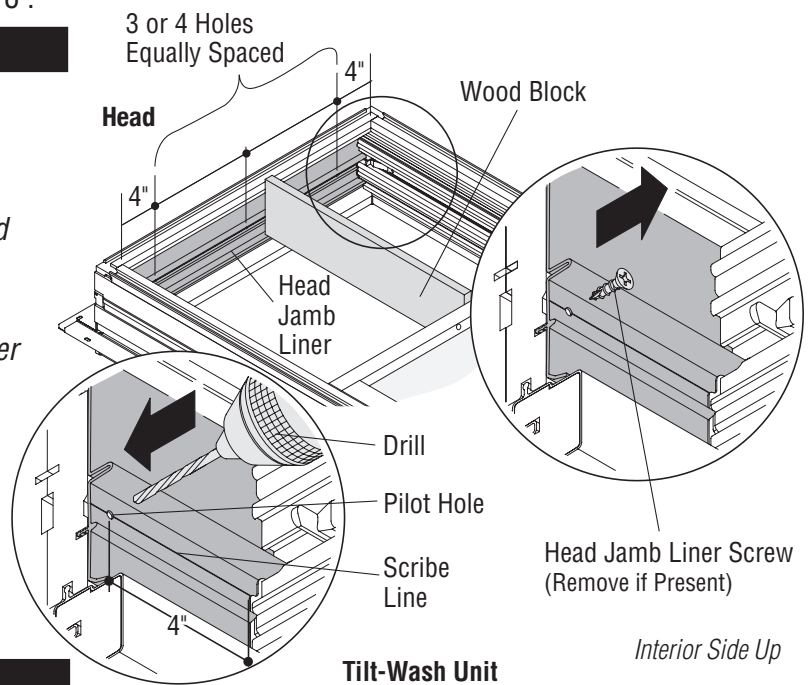


Narroline® Circle Top Joined to Tilt-Wash, Woodwright® or Picture Window Only

#### Tilt-Wash Units ONLY

- Brace *Upper* and *Lower Sash* away from *Head Jamb* with a wood block.
- Remove screws from *Head Jamb Liner* if present and drill completely through existing holes in *Head Jamb* using a 3/32" drill bit.
- If *Head Jamb Liner Screws* are not present, use 3/32" drill bit to drill pilot holes on *Head Jamb Liner* scribe line 4" from each end and equally spaced between as shown. See table below for total quantity of holes required.

Unit Width	Total Holes Required
TW38 & TW34	4
All Others	3



Tilt-Wash Unit

#### Double-Hung Picture Window ONLY

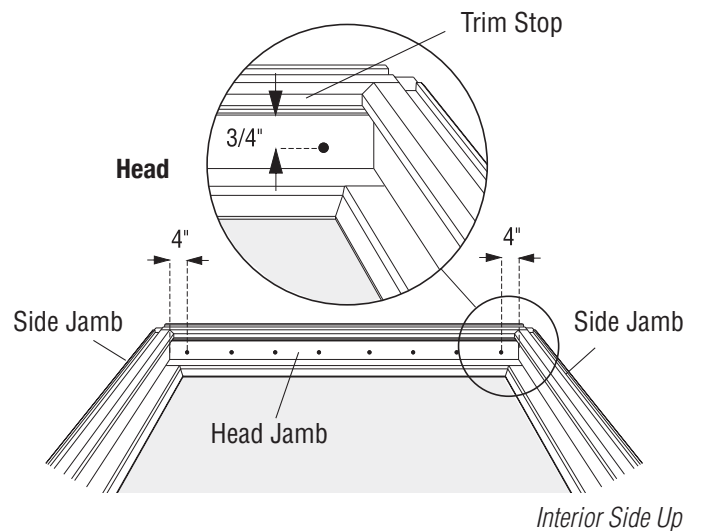
- Refer to *Double-Hung Picture Window Installation Guide* included with unit for instructions on removing *Jamb Liners*.

### CAUTION

#### Double-Hung Picture Window to Flexiframe® Window Only

Drill holes at a 10° downward angle to make certain screws enter frame of unit. (see detail on page 5) Failure to do so may compromise structural integrity of joined units.

- Drill eight holes through *Head Jamb* using a 3/32" drill bit. Holes should be equally spaced along *Head Jamb* and located 3/4" from *Trim Stop*. **DO NOT** drill within 4" of side jambs.

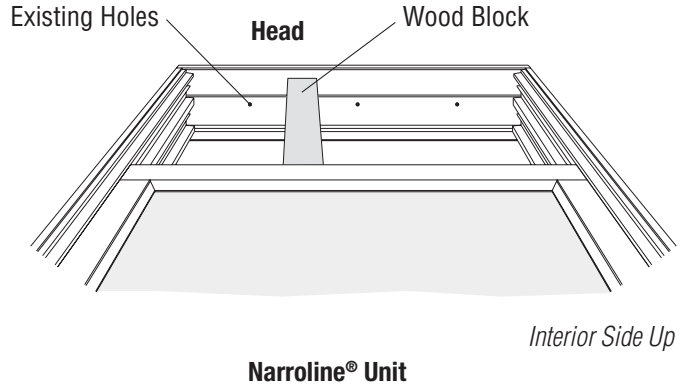


Double-Hung Picture Window

## 2. Prepare Units For Joining (Continued)

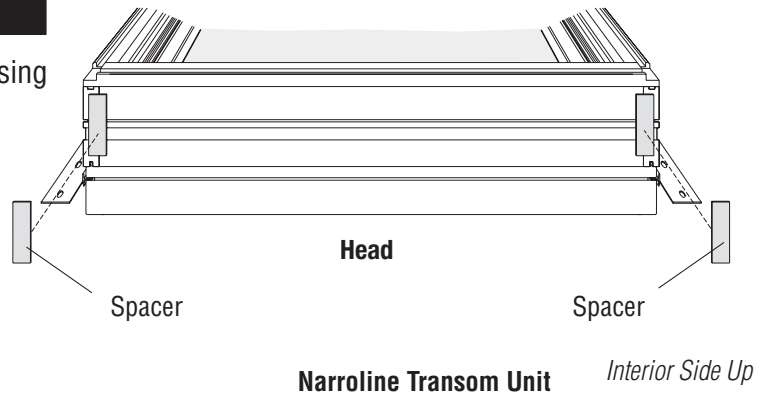
### Narroline® Units ONLY

- Brace *Upper* and *Lower Sash* in full open position using a wood block.
- Remove *Head Jamb Liner Screws*.
- Drill completely through existing holes in *Head Jamb* using a 3/32" drill bit.



### Narroline® Transom Units ONLY

- Attach *Spacers* to head of *Narroline Transom* unit using tacks or glue.

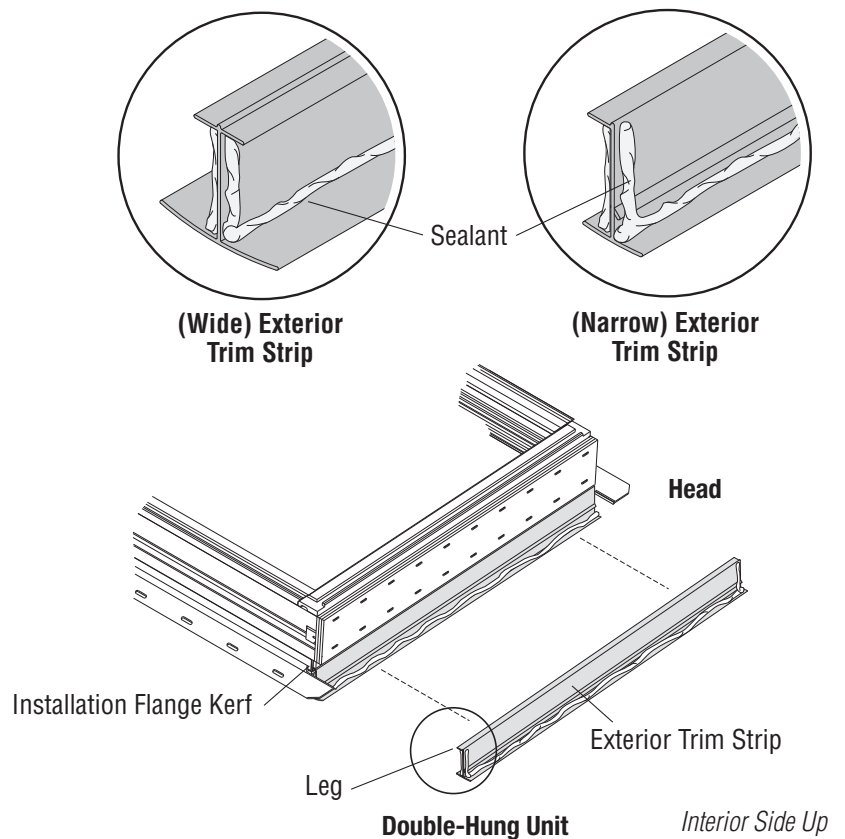


## 3. Attach Exterior Trim Strip

### NOTICE

For **Architectural & Flexiframe Window Joining**, use **Narrow Exterior Trim Strip**.

- Apply a 1/8" bead of sealant, full length, to both ends, both sides and at each end of *Exterior Trim Strip*, as shown.
- Position leg of the *Exterior Trim Strip* into the *Installation Flange Kerf* on the outer frame member of the *Double-Hung* unit or *Picture Window*.

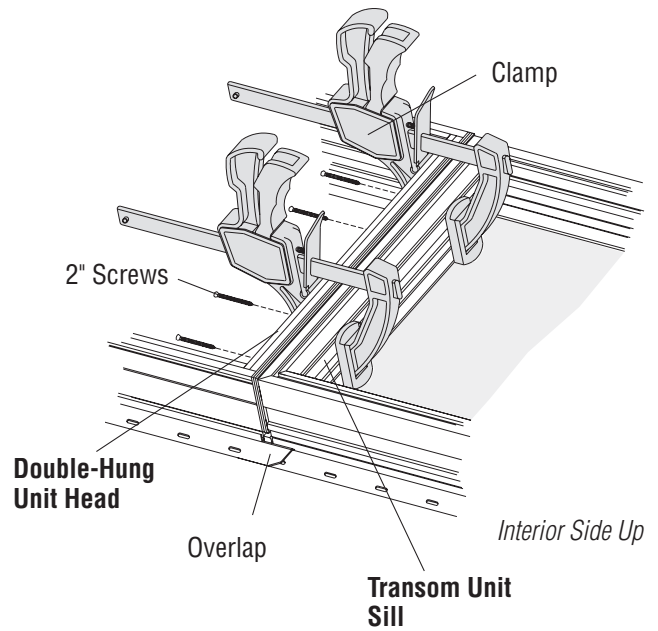


**4. Fasten Units Together**

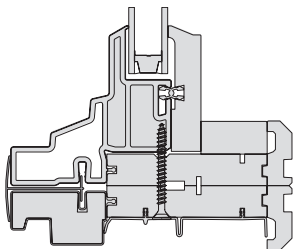
**CAUTION**

Side Installation Flanges from transom unit must overlap Side Installation Flanges of Double-Hung unit to the exterior to prevent water infiltration.

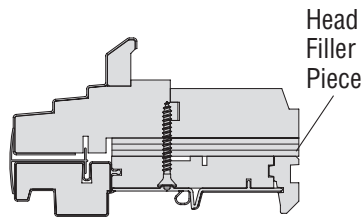
- Position the Circle Top™, Narroline® Transom, Tilt-Wash Transom (TWT) or Flexiframe® unit over the Double-Hung unit. *Side Installation Flanges* from transom unit must overlap *Side Installation Flanges* of Double-Hung unit to the exterior.
- Center and clamp units together at *Head* and *Sill*.
- Fasten with 2" screws through the predrilled holes in the Double-Hung *Head Jamb*. Seat screws only until snug to avoid damage to the *Head Jamb Liner*.



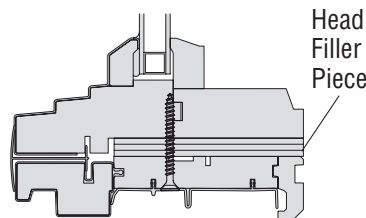
**Cross Section Details**



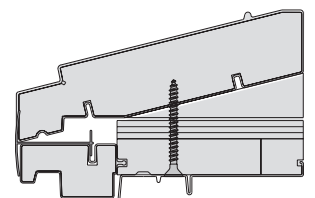
**Tilt-Wash Transom (TWT) Window over Tilt-Wash Window**  
(Use Wide Trim Strip)



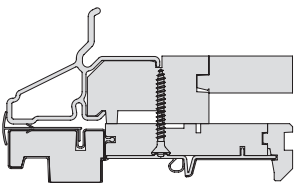
**Narroline® Circle Top™ Window over Woodwright® Double-Hung Window**  
(Use Wide Trim Strip)



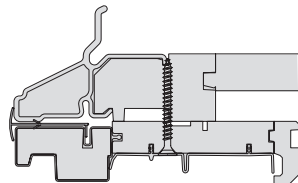
**Narroline® Circle Top™ Window over Tilt-Wash Window**  
(Use Wide Trim Strip)



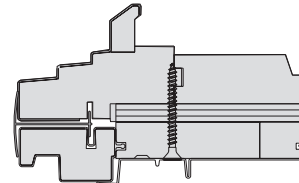
**Narroline® Transom Window over Narroline® Window**  
(Use Wide Trim Strip)



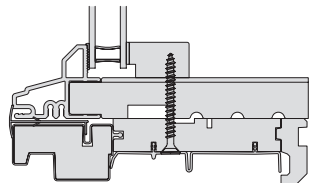
**Flexiframe® Window over Woodwright® Double-Hung Window**  
(Use Narrow Trim Strip)



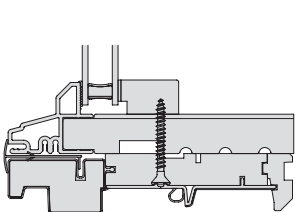
**Flexiframe® Window over Tilt-Wash Window**  
(Use Narrow Trim Strip)



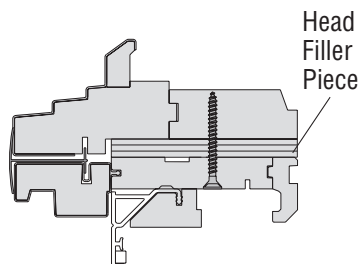
**Narroline® Circle Top™ Window over Narroline® Window**  
(Use Wide Trim Strip)



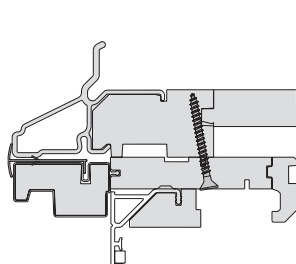
**Architectural Window over Tilt-Wash Window**  
(Use Narrow Trim Strip)



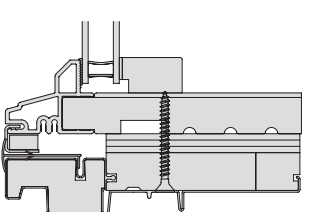
**Architectural Window over Woodwright® Double-Hung Window**  
(Use Narrow Trim Strip)



**Narroline® Circle Top™ Window over Double-Hung Picture Window**  
(Use Wide Trim Strip)



**Flexiframe® Window over Double-Hung Picture Window**  
(Use Narrow Trim Strip)



**Architectural Window over Narroline® Window**  
(Use Narrow Trim Strip)

## 5. Apply Gusset Plates

- Place *Gusset Plates* on side jambs 3/4" down from interior edge and in center of joint.
- Secure with two rows of 1/2" staples.
- Proceed to specific unit Installation Guide for instructions on installing unit.

