

Narrow Joining (Horizontal)

for Andersen® 400 Series Woodwright® Transom over 400 Series Woodwright® Double-Hung or 400 Series Woodwright® Picture Window



INSTALLER: Please leave this guide with the building owner to file for future reference.

Congratulations! You have just purchased one of the many fine Andersen® products. Proper assembly, installation and maintenance are essential if the benefits of your Andersen product are to be fully attained. Therefore, please read and follow this instruction guide completely. If your abilities do not match this procedure's requirements, contact an experienced contractor. You may direct any questions about this or other products to your local Andersen dealer, found in the Yellow Pages under "Windows" or call Andersen WindowCare® service center at 1-888-888-7020 Monday through Friday, 7 a.m. to 7 p.m. Central Time and Saturday, 8 a.m. to 4 p.m. Central Time. Thank you for choosing Andersen.

Important Safety, Assembly, and Installation Information

Every assembly and installation is different (windloads, structural support, etc.). Andersen strongly recommends consultation with an Andersen supplier or an experienced contractor, architect, or structural engineer prior to the assembly and installation of any Andersen product. For installation methods not covered in this guide, (i.e. through jamb) please visit the Architect Detail File on the web (www.andersenwindows.com). Andersen has no responsibility in regard to the post-manufactured assembly and installation of Andersen products.

⚠ WARNING

Using ladders and/or scaffolding and working at elevated levels may be hazardous. Follow equipment manufacturer's instructions for safe operation. Use extreme caution when working around window and door openings. Falling from opening may result in personal injury or death.

⚠ WARNING

Improper use of hand/power tools could result in personal injury and/or product damage. Follow manufacturer's instructions for safe operation of equipment. Always wear safety glasses.

⚠ WARNING

Weight of window/door unit(s) and accessories will vary. Use a reasonable number of people with sufficient strength to lift, carry, and install window and door unit(s) and accessories. Always use appropriate lifting techniques.

⚠ 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

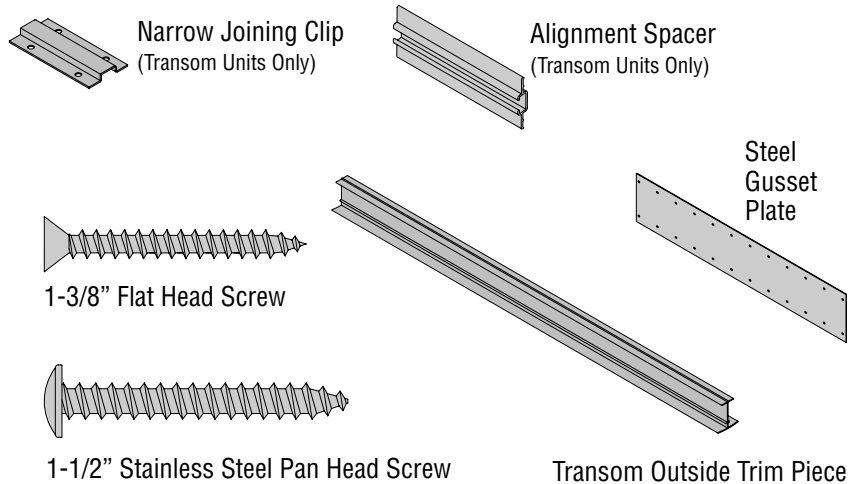
- Andersen® Head Flashing and Installation Flanges **DO NOT** take the place of standard window and door flashing. Unit must be properly flashed and sealed with silicone for protection against water and air infiltration. Use non-reflective flashings. Highly reflective flashing tapes can raise the surface 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 Required for Transom Joining

- (4) Narrow Joining Clips
- (4) Alignment Spacers
- (1) Transom Outside Trim Piece
- (2) Steel Gusset Plates
- (8) 1-1/2" Stainless Steel Pan Head Screws
- (16) 1-3/8" Flat Head Screws

Tools & Supplies

- Safety Glasses
- Hammer
- Power Drill
- Caulk Gun
- Silicone Primer
- Silicone Sealant
- 3/32" Drill Bit
- 1-1/4" (3d) Finish Nails
- 1/2" Staples
- 3/4" Staples
- Clamp
- Utility Knife
- Wood Block



1. Prepare Units

CAUTION

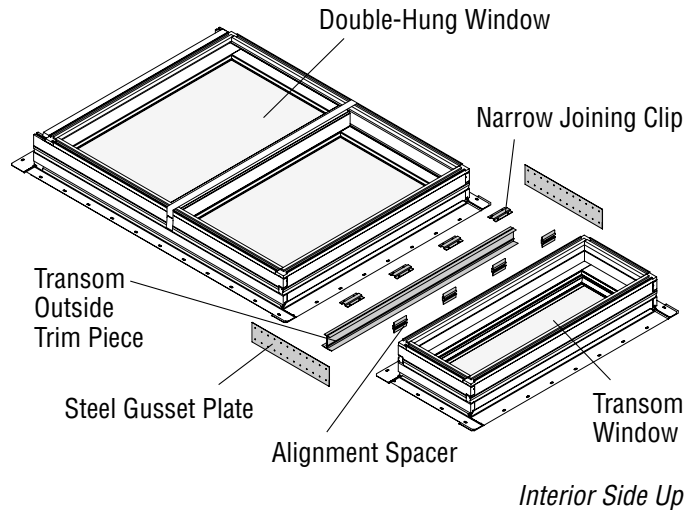
Combinations with both vertical and horizontal joins may require Andersen® narrow steel joining depending on design pressure requirements.

- Remove units/parts from packaging and place interior side up on a clean, flat work surface.

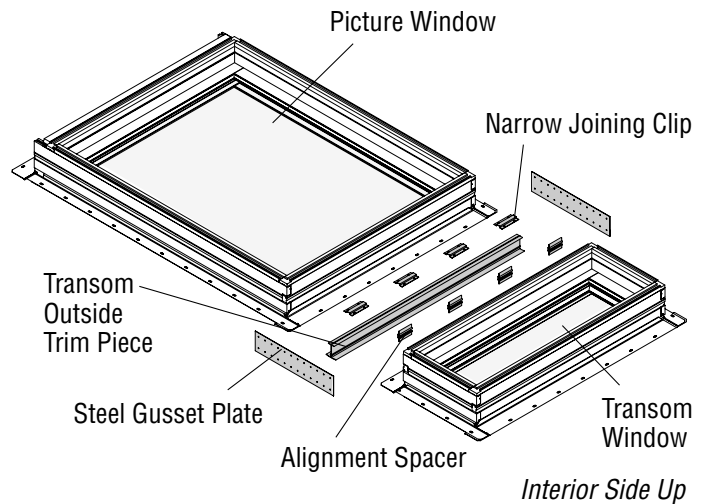
NOTICE

DO NOT remove banding tape and packaging clips on Double-Hung units until assembled combination is installed.

- Remove packaging material, except *Banding Tape* and *Packing Clips* on *Double-Hung* units.



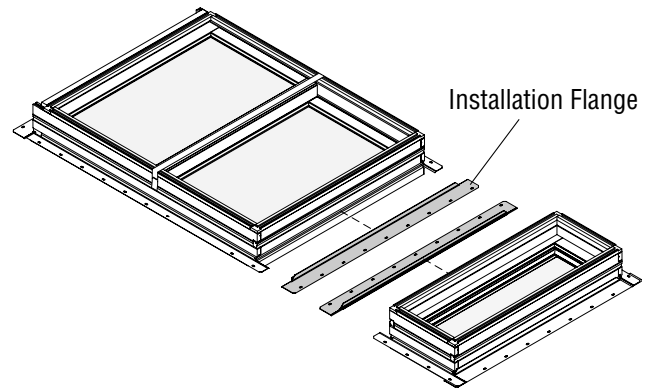
Transom to Double-Hung



Transom to Picture Window

2. Remove Flanges

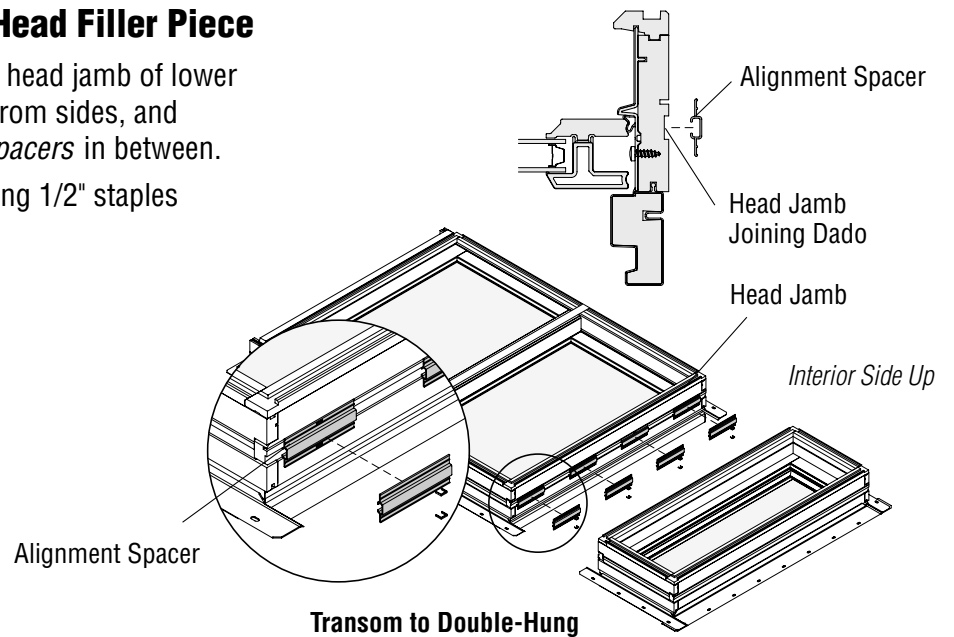
- For **Double-Hung, Picture, and Transom Units**, remove *Installation Flange(s)* on sides to be joined, as shown.



Interior Side Up

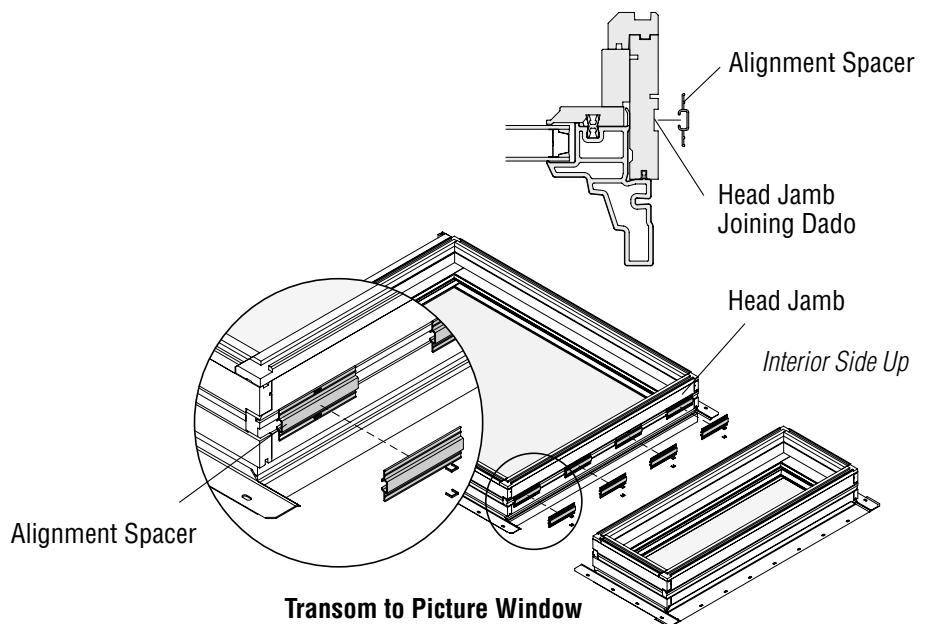
3. Apply Alignment Spacers or Head Filler Piece

- Apply *Alignment Spacers* to dado on head jamb of lower unit. Locate *Alignment Spacers* 3" from sides, and evenly space remaining *Alignment Spacers* in between.
- Fasten *Alignment Spacers* to unit using 1/2" staples or nails.



Interior Side Up

Transom to Double-Hung



Interior Side Up

Transom to Picture Window

4. Apply Outside Trim Strips

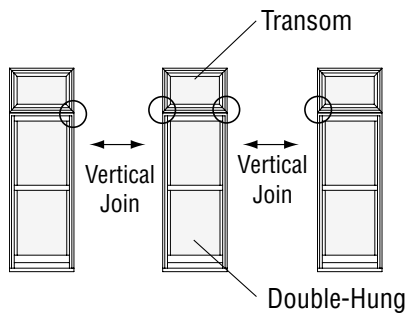
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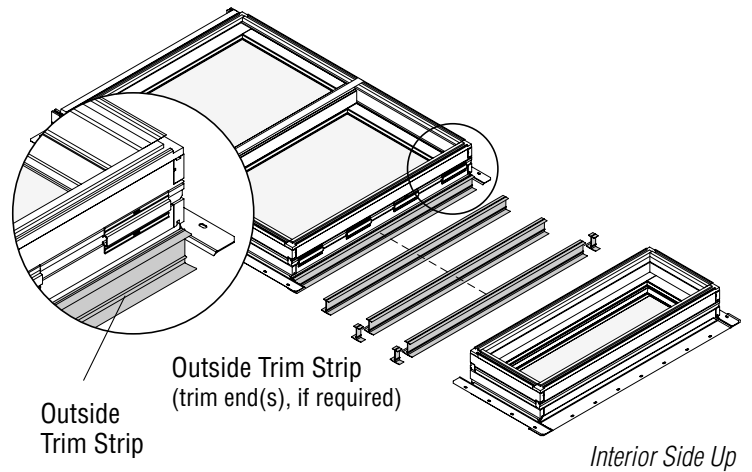
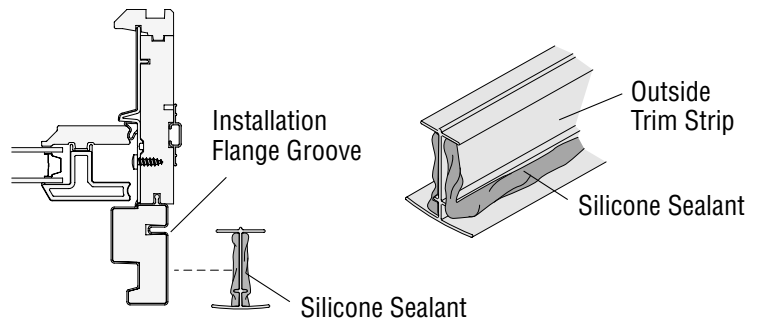
- Measure width of unit and cut *Outside Trim Piece* to length, if required.

NOTICE

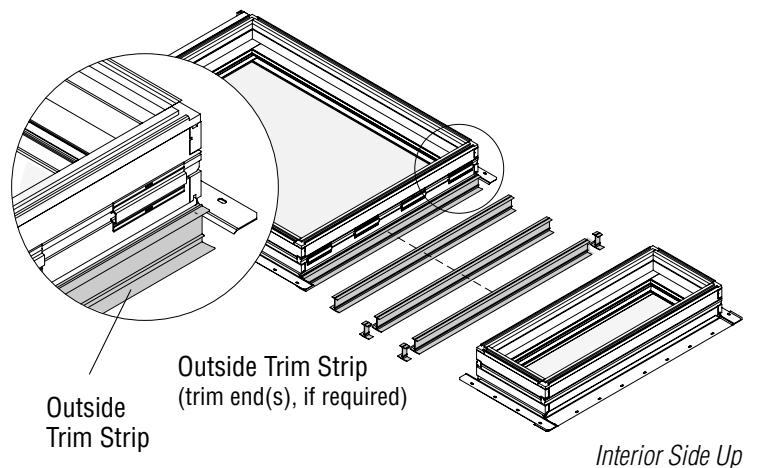
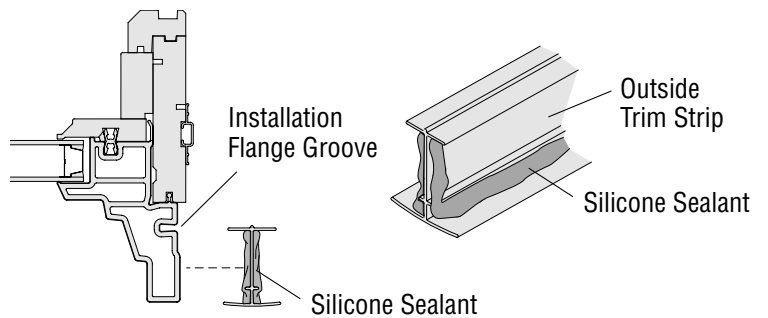
Outside Trim Strip must be trimmed if unit combination will be vertically joined.



- For combinations that will be vertically joined, cut 11/16" from *Outside Trim Strip* if one side will be joined, and 1-3/8" if both sides will be joined.
- Apply a 3/16" bead of silicone sealant, full length to both sides and at each end of *Outside Trim Strip*, as shown.
- Position *Outside Trim Strip*, to head jamb with attached *Alignment Spacers* or *Head Filler Piece*, inserting leg into *Installation Flange* groove. For combinations that will be vertically joined, keep end of *Outside Trim Strip* 11/16" from edge of side jamb.



Transom to Double-Hung



Transom to Picture Window

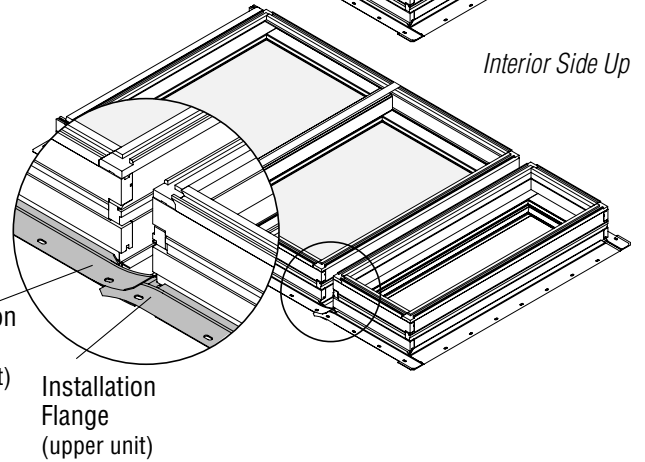
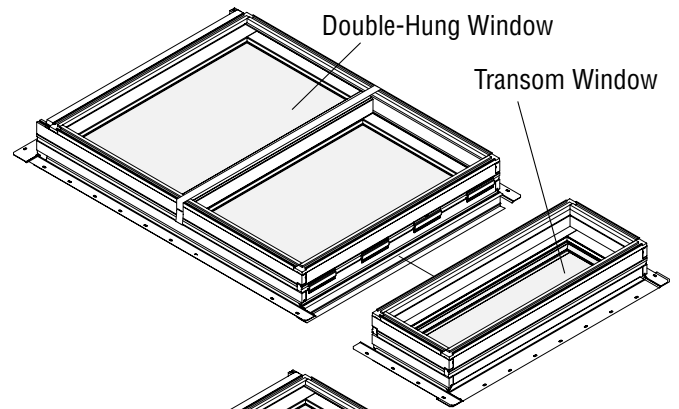
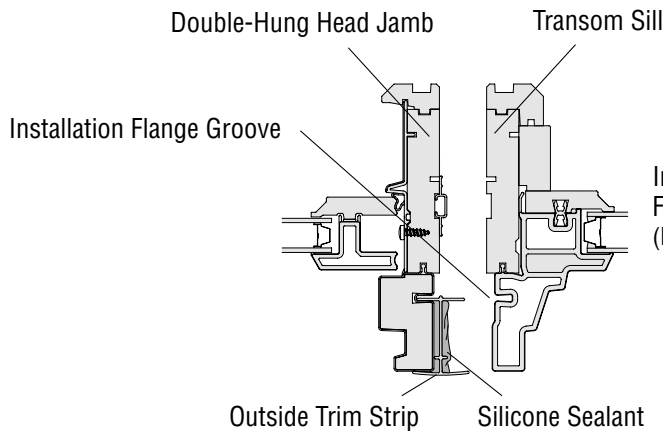
5. Position units for Joining

- Position upper unit to lower unit, flush at side jambs. Make sure *Outside Trim Strip* remains in position on first unit and enters installation flange groove on second unit.

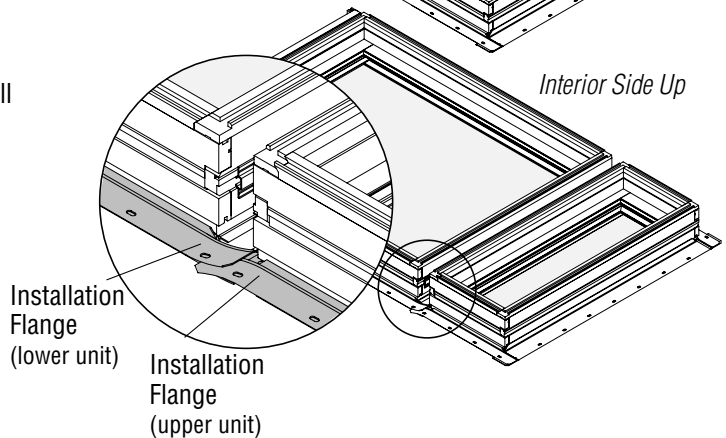
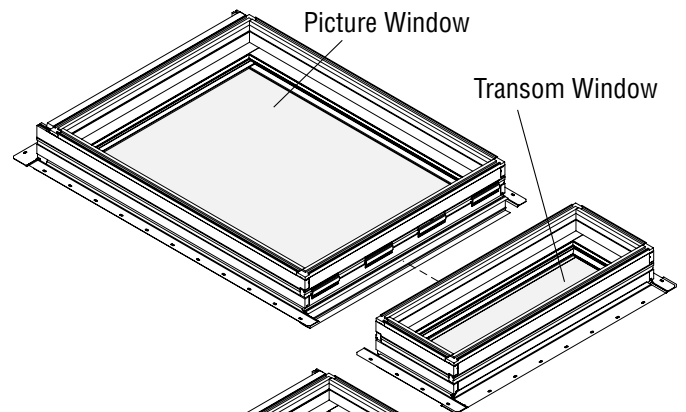
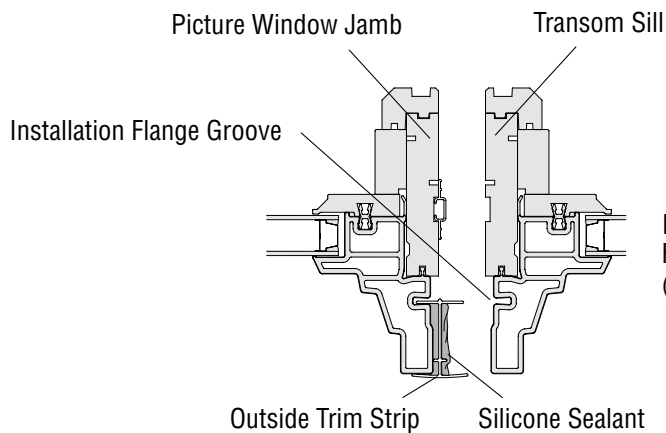
⚠ CAUTION

Upper unit side *Installation Flange* must overlap lower unit side *Installation flange* to the exterior to prevent water infiltration.

- Overlap upper unit side *Installation Flange* over lower unit side *Installation Flange* to the exterior.



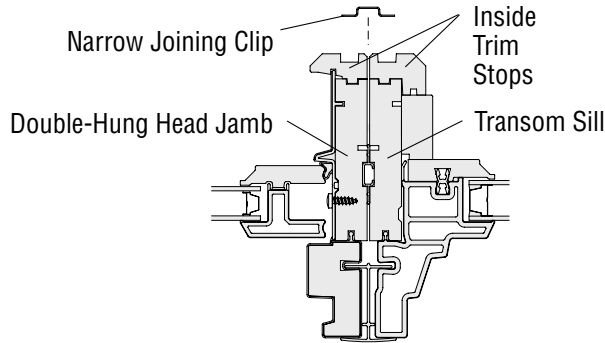
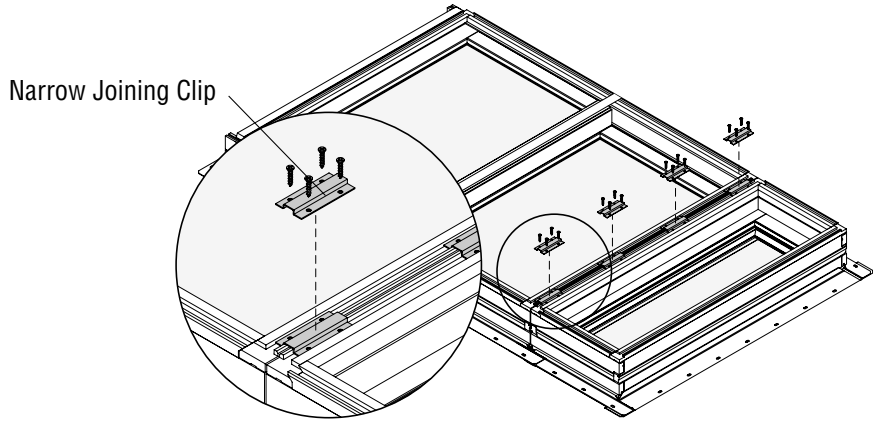
Transom to Double-Hung



Transom to Picture Window

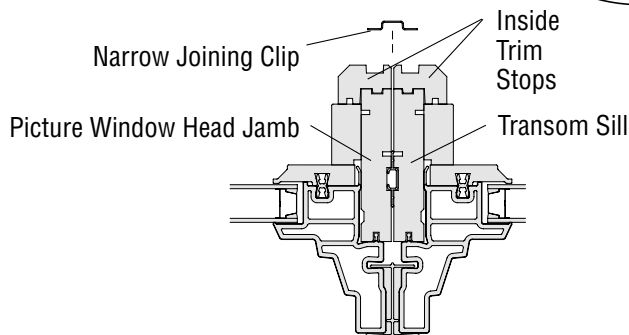
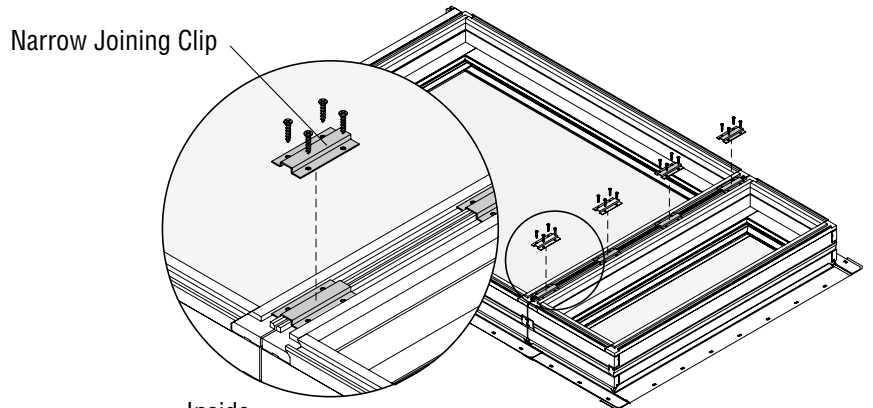
6. Attach Narrow Joining Clips

- Position *Narrow Joining Clips* into grooves on adjacent *Inside Trim Stops*. Locate clips 1"-3" from sides and every 14" (maximum) in between.
- Drill 3/32" holes into *Inside Trim Stops* using *Narrow Joining Clips* as templates.
- Fasten *Narrow Joining Clips* using four #8 x 1-3/8" flat head screws per clip.



Interior Side Up

Transom to Double-Hung

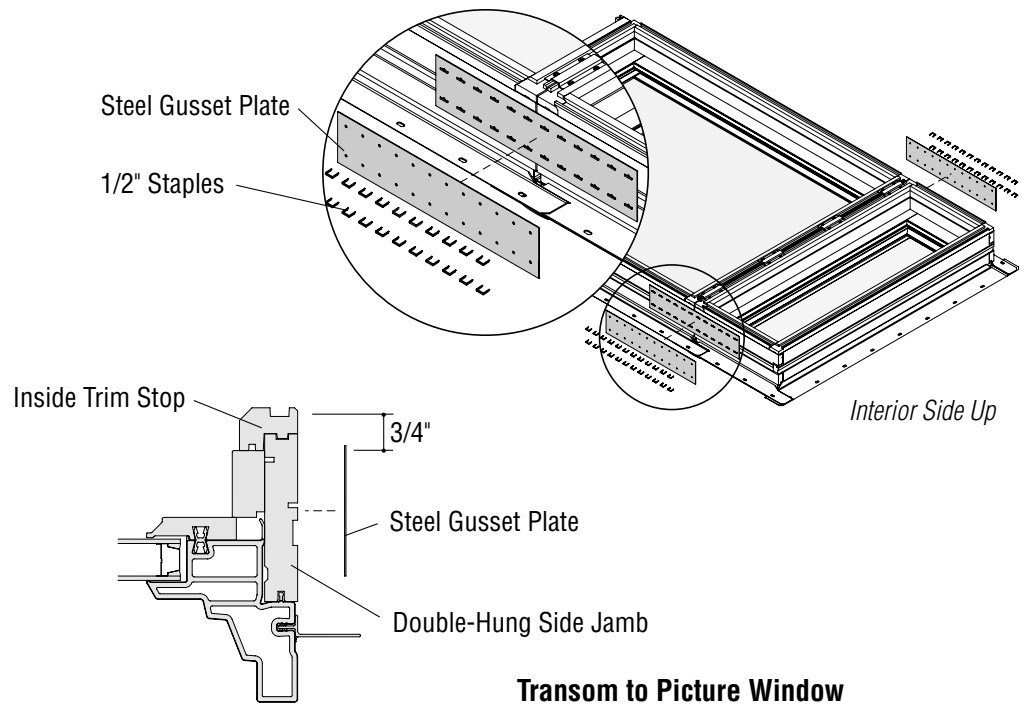
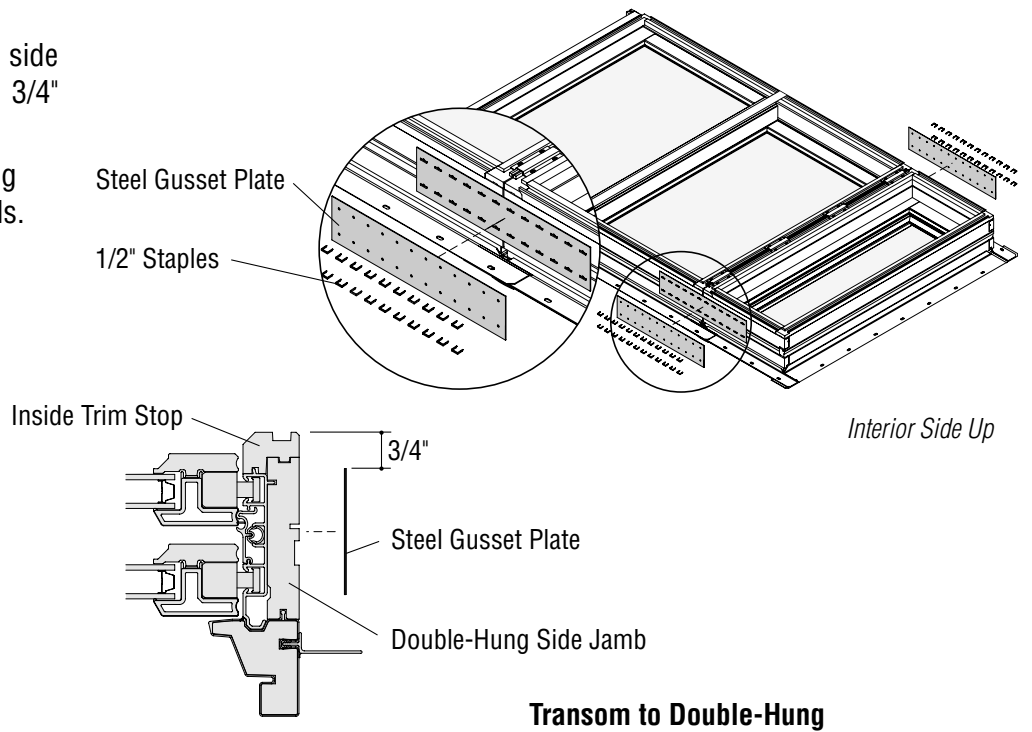


Interior Side Up

Transom to Picture Window

7. Apply Gusset Plates

- Position *Steel Gusset Plate* on side jambs, centering over join and 3/4" below *Inside Trim Stop*.
- Fasten *Steel Gusset Plate* using twenty four 1/2" staples or nails.



8. Fasten Head/Sill

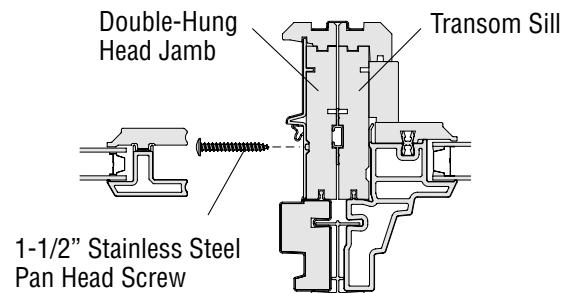
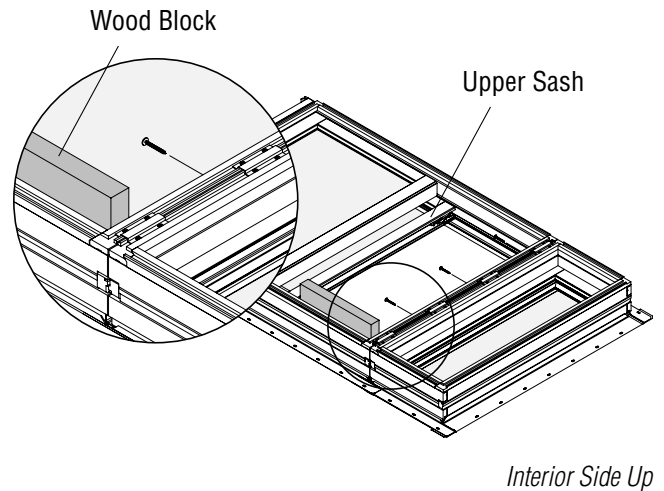
Transom to Double-Hung

- Brace *Upper* and *Lower Sash* away from *Head Jamb* using a wood block.
- Remove existing screws from *Head Jamb Liner*.
- Drill completely through existing holes in *Head Jamb* using a 3/32" drill bit.
- Fasten through *Head Jamb* of Double-Hung Unit into Sill of Transom Unit using 1-1/2" Stainless Steel Pan Head Screws. **DO NOT** over tighten screws to prevent damage to *Head Jamb Liner*.
- Remove wood block, allowing *Upper Sash* to slowly move to *Head Jamb*.
- Remove wood block, allowing sash to slowly move to head jamb.

⚠ WARNING

Weight of joined windows and accessories will vary. Use a reasonable number of people with sufficient strength to lift, carry and install joined windows and accessories. Always use appropriate lifting techniques.

- Carefully turn joined units over, exterior side up.



Transom to Double-Hung

8. Fasten Head/Sill (continued)

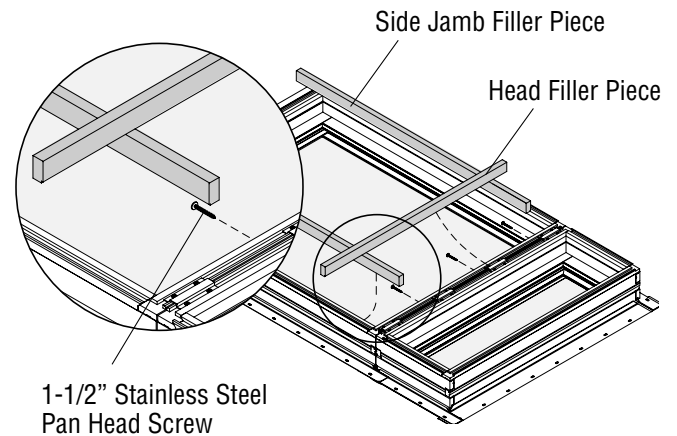
Transom to Picture Window

- Remove *Side Jamb Filler Pieces* from Picture Window Unit by grasping extended nail head with pliers and pull inward.
- Remove *Head Filler Piece* from Picture Window Unit by grasping extended nail head with pliers and pull downward.
- Drill holes through *Head Jamb* of Picture Window Unit using 3/32" drill bit. Locate holes 3" from each end and spaced evenly no more than 9" apart.
- Fasten through *Head Jamb* of Picture Window Unit into *Sill* of Transom Unit using 1-1/2" Stainless Steel Pan Head Screws.
- Reapply *Head Jamb Filler Piece* and *Side Jamb Filler Pieces* on Picture Window using 1-1/4" finish nails.

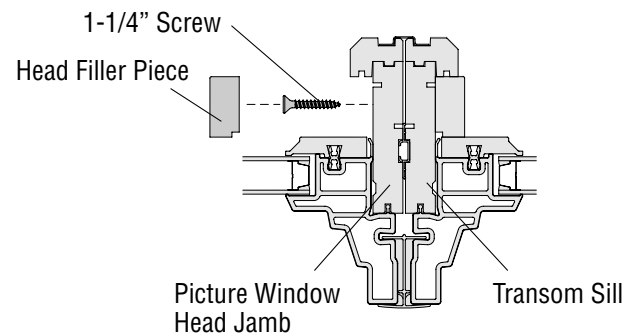
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- Carefully turn joined units over, exterior side up.



Interior Side Up



Transom to Picture Window

9. Apply Silicone Sealant

- Seal ends of *Exterior Trim Strips* with silicone sealant and tool smooth.
- Apply silicone sealant between *Installation Flange* lap joints as shown.
- Proceed to units installation guide for installation procedures.

