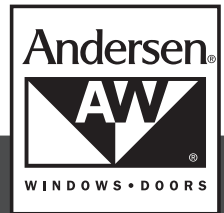


Reglazing

for Andersen® 400 Series Tilt-Wash Transom Windows Manufactured after June 2006 or
400 Series Tilt-Wash Transom Windows with Stormwatch™ Protection (Impact Resistant Glass)
Manufactured after June 2006



IMPORTANT

Read all instructions carefully before attempting this procedure. If you have any questions about your ability to complete this procedure, call Andersen at 1-888-888-7020 for further direction. Andersen WindowCare® service center hours are 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® products.

Important Safety, Assembly, and Installation Information

Every assembly and installation is different (windloads, structural support, etc.), and 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. Andersen has no responsibility in regard to the post-manufactured assembly and installation of Andersen products.

⚠ WARNING

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

⚠ 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.

Parts Included

- (1) Instruction Guide
- (1) Glass Light
- (1) Silicone Bed Glazing
(4230221) Dow Corning 791

Additional Part Required

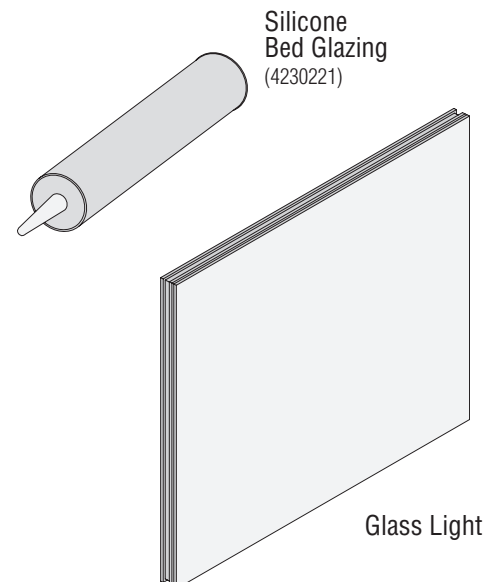
- Fillet Bead Silicone Sealant
(**DO NOT** use for bed glazing)
Dow Corning 791
(2903021) White
(2903023) Sandtone
(2903022) Terratone®
(2903026) Forest Green

Optional Parts

- Replacement Filler Pieces
- Replacement Glass Stops
- Reinforcement Stops (Impact Resistant Units Only)

Tools and Supplies

- Safety Glasses
- Nylon Putty Knife
- Vise Grips
- Phillips Screwdriver
- Window Cleaner
- Isopropyl Alcohol
- End Cutting Pliers
- 5d (1-3/4") Finish Nails
- #6 x 1-1/4" Drywall Screws
- Glass Clamps (commercial grade)
- Thin Blade Putty Knife or Fein Cutting Tool
- Hammer
- Gloves
- Caulk Gun
- Nail Set
- Utility Knife
- Duct Tape
- Small Pry Bar



IMPORTANT

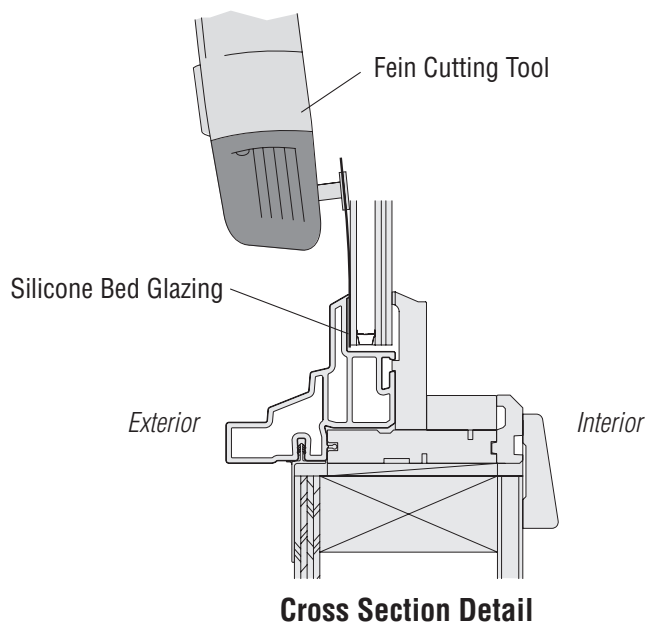
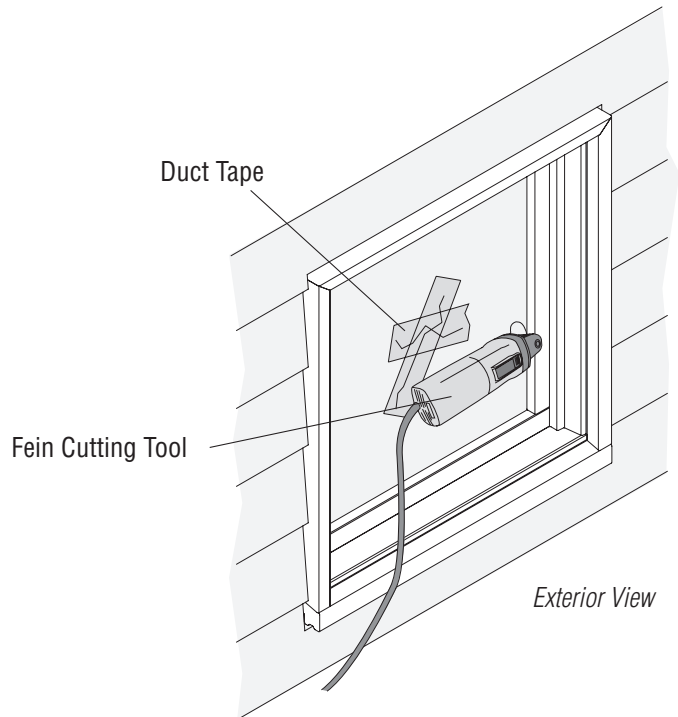
- This procedure requires a high level of construction skill. If you do not possess a high level of skill in construction, window installation or reglazing, Andersen recommends that you contact a qualified Andersen service provider to reglaze your window.
- To determine if you have the appropriate level of skill to properly and safely perform this procedure, read through the instruction manual. If you have any questions or concerns about your ability to complete this procedure, contact a professional Andersen service provider to complete this work for you.
- If your Tilt-Wash Transom unit has grilles applied to the glass, these grilles need to be removed prior to reglazing. Since specialized tools are required to remove the grilles, it is recommended that the reglazing procedure be done by a professional Andersen service provider.

1. Cut Bed Glazing

⚠ WARNING

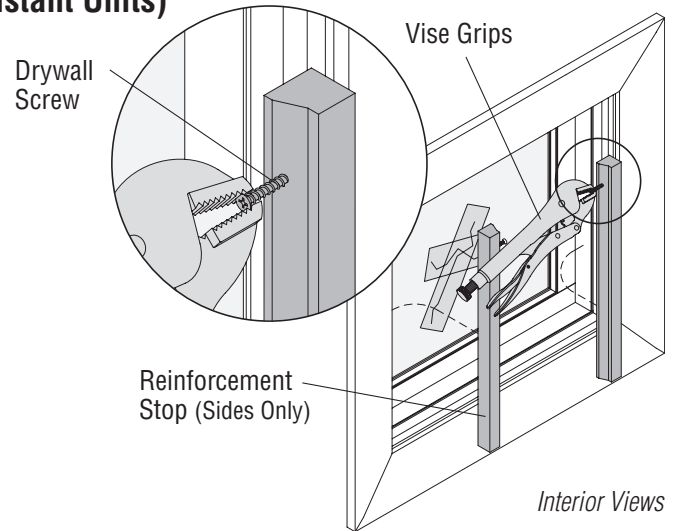
Wear gloves, safety glasses, goggles, or eye shields when handling glass. Tape broken glass with duct tape before removal to reduce glass fragmentation. Failure to do so may result in personal injury, product, and/or property damage.

- Tape broken glass with duct tape to reduce glass fragmentation.
- Cut exterior silicone bed glazing between glass and outer frame member 5/8" deep, full perimeter, using a Fein cutting tool or thin blade cutting knife, working from the exterior.
- **For Impact Resistant Units**, proceed to **Step 2**.
- **For Standard Units**, proceed to **Step 3**.



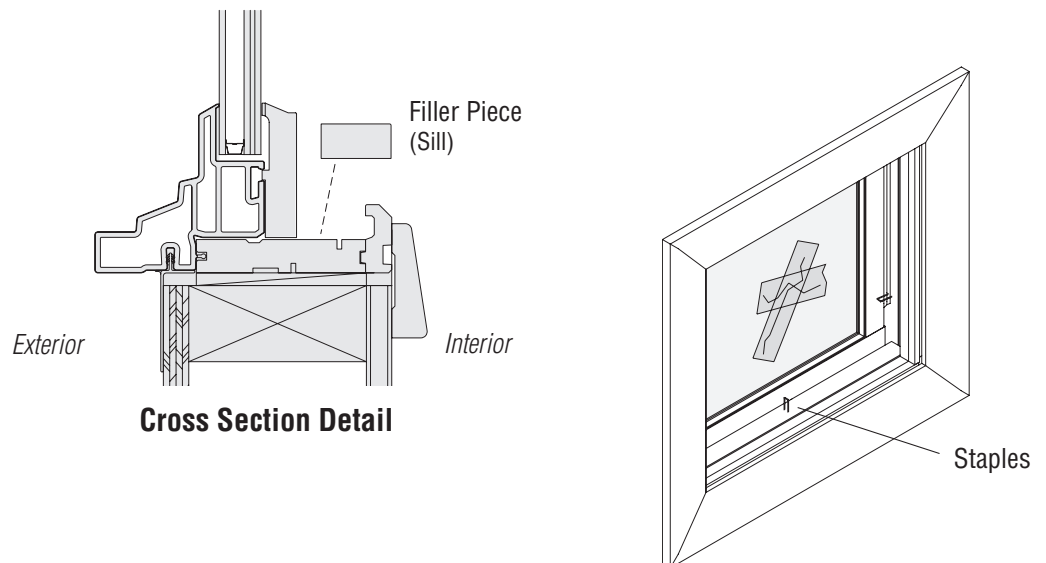
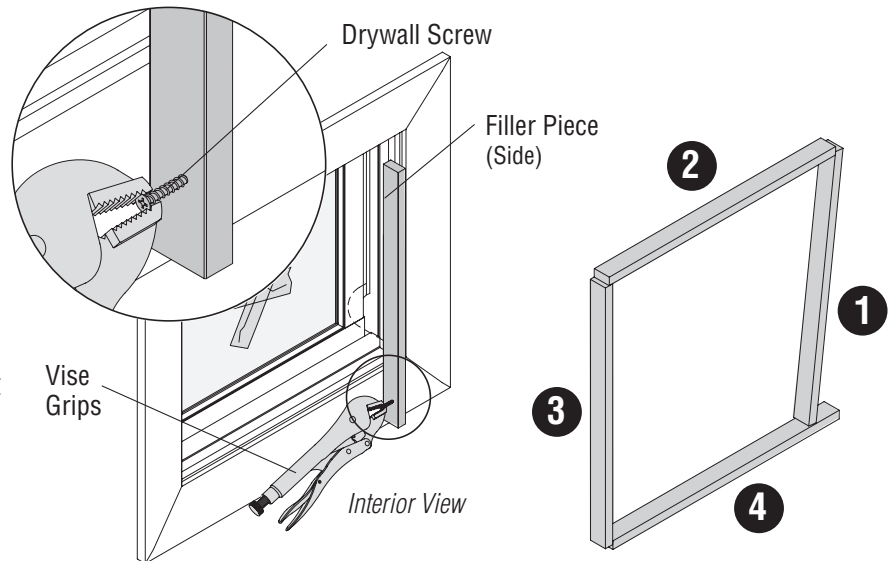
2. Remove Side Reinforcement Stops (Impact Resistant Units)

- Fasten a drywall screw into end of side *Reinforcement Stop* 1/2" deep, to the upper right corner and lower left corner.
- Pull inward on screw using a vise grips to remove *Reinforcement Stop*.
- Record original location on back side of *Reinforcement Stop* and retain for reuse.
- Repeat for opposite side *Reinforcement Stop*.



3. Remove Filler Pieces

- Fasten drywall screw into one end of side *Filler Piece* 1/2" deep.
- Pull inward on screw using a vise grips to remove *Reinforcement Stop*.
- Record original location on back side of *Filler Piece* and retain for reuse.
- Repeat for top, opposite side, and bottom *Filler Pieces*.
- Retain *Filler Pieces* for reuse Replacement *Filler Pieces* are available.
- Remove remaining staples using a wire cutter.



Cross Section Detail

4. Remove Interior Glass Stops and Glass

⚠ WARNING

Support Glass Panel at all times once removal of Interior Glass Stops begins. Glass Panel may fall inward resulting in personal injury, product, and/or property damage.

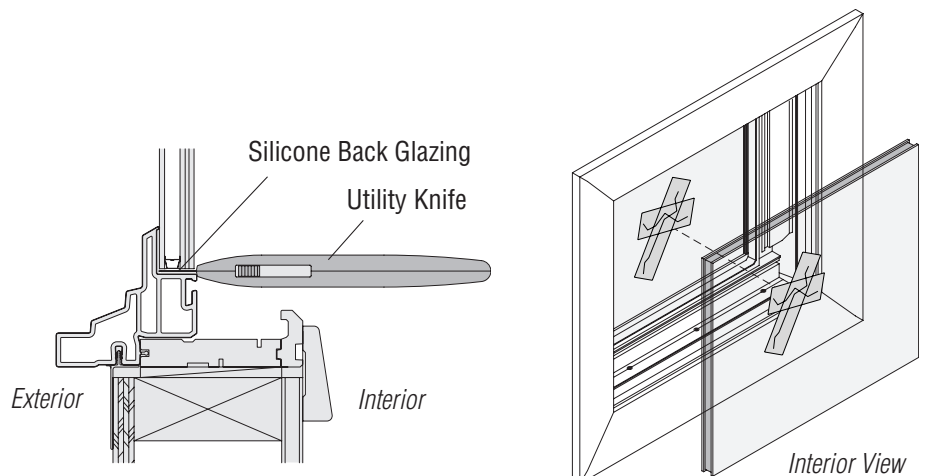
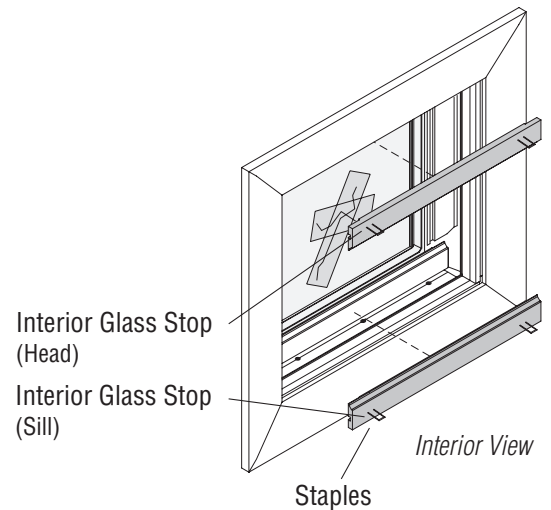
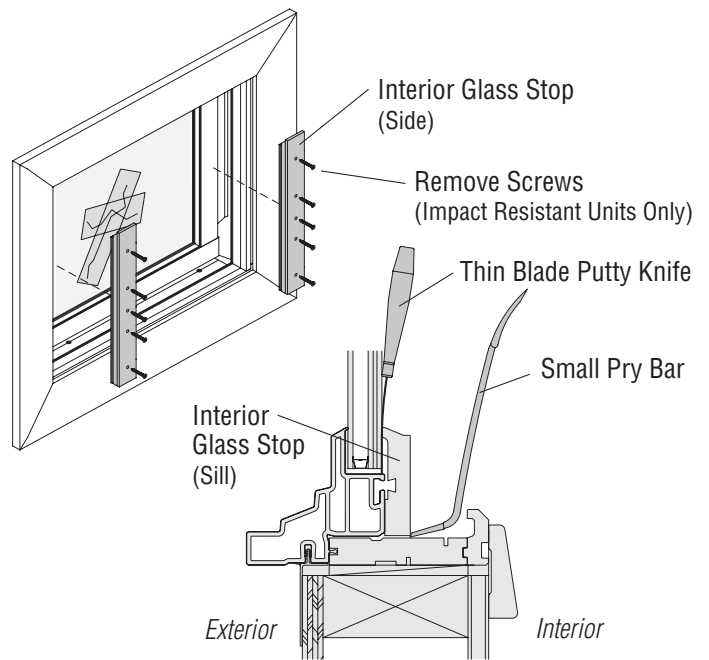
⚠ WARNING

Use extreme care when working around window opening. Never leave a window opening unattended, especially when children are present. Falling from window opening may result in personal injury or death.

NOTICE

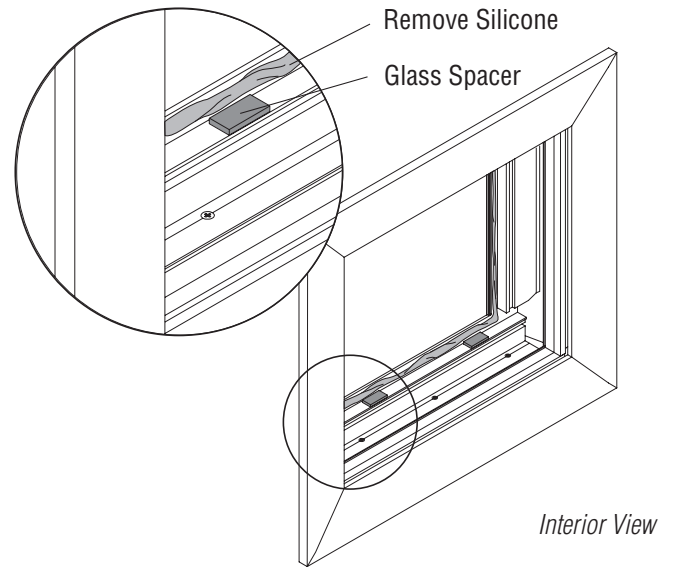
Glass Stops may have a silicone bond with the glass and may be difficult to remove.

- **For Impact Resistant Units**, remove 1-3/4" screws from *Side Glass Stops* and retain for reuse.
- Insert a thin blade putty knife between side *Interior Glass Stop* and glass. Pry *Glass Stop* away from glass.
- Repeat for opposite side *Interior Glass Stop*.
- Insert small pry bar between jamb and *Interior Sill Stop* at each end. Pry *Glass Stop* away from jamb.
- Remove remaining staples using a wire cutter.
- Repeat for head *Interior Glass Stops*.
- Retain *Glass Stops* for reuse. Optional *Glass Stops* are available.
- Cut silicone back glazing using a utility knife.
- Carefully remove and dispose of broken glass.



5. Clear and Clean Window Opening

- Mark location of sill *Glass Spacers* for reapplication.
- Remove *Glass Spacers* and old silicone from glazing lip on perimeter of frame.
- Clean glazing lip using isopropyl alcohol and air dry.
- Remove old silicone from *Glass Spacers* and retain spacers for reuse.

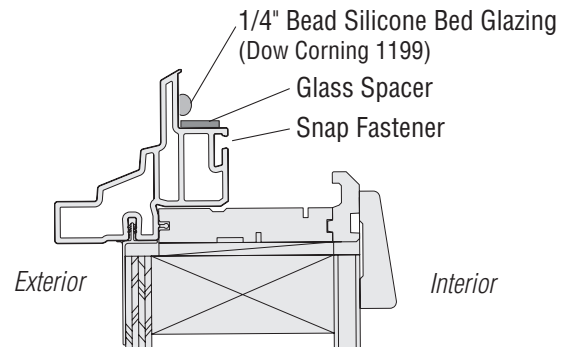
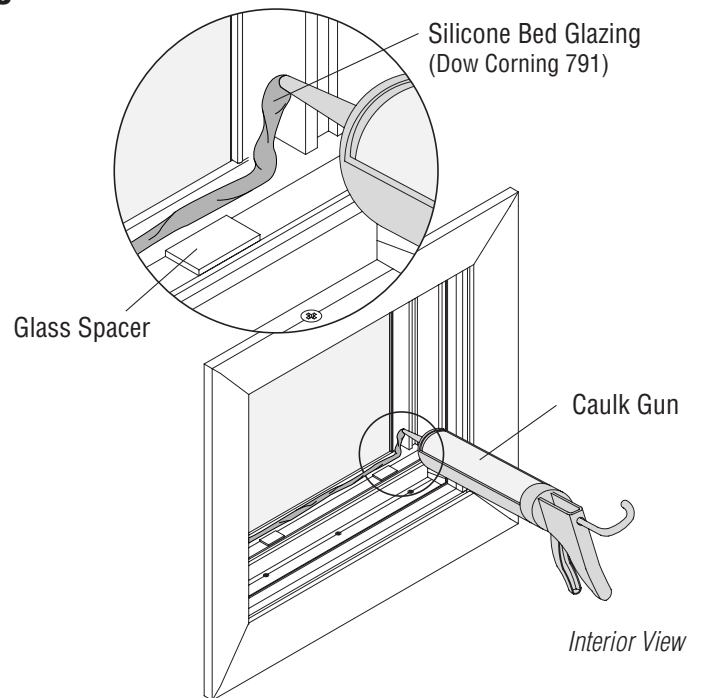


6. Apply Silicone Bed Glazing and Glass Spacers

NOTICE

Follow silicone manufacturer's instructions for surface conditioning, application temperature, and cure time.

- Apply a 1/4" bead of *Dow Corning 791 Silicone Bed Glazing* to glazing lip, full perimeter on frame.
- Apply a small amount of *Silicone Bed Glazing* on bottom of each sill *Glass Spacer*.
- Position sill *Glass Spacers* on locations marked in **Step 4**.



7. Apply Glass and Interior Glass Stops

⚠ WARNING

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

⚠ WARNING

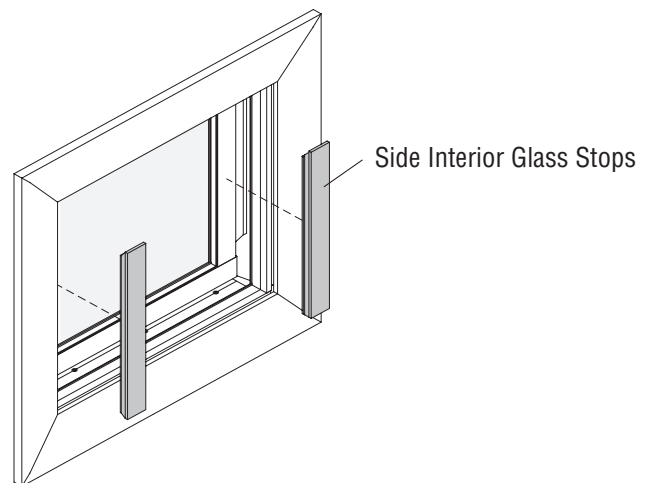
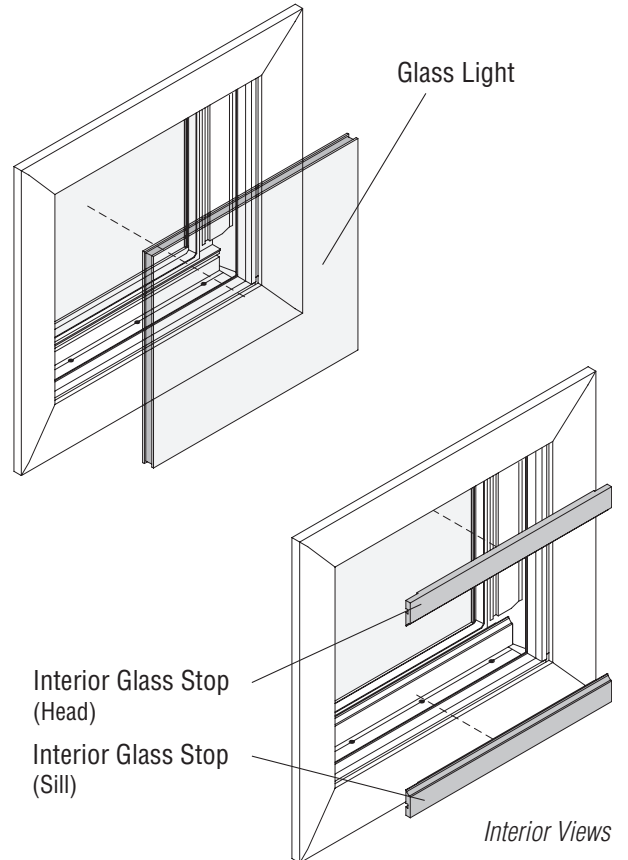
Support Glass Panel at all times once removal of Interior Glass Stops begins. Glass Panel may fall inward resulting in personal injury, product, and/or property damage.

⚠ CAUTION

- Use caution when handling glass, protect glass edges, and **DO NOT** roll glass on edges or corners to avoid breakage or damage.
- For high altitude glass, make sure breather tube (located at the top of the glass) is not plugged or pinched during procedure.
- **DO NOT** use a metal knife and/or metal objects against glass surface to avoid scratching or chipping.

Standard Units

- Remove glass from crating, clean glass edge with isopropyl alcohol, and air dry.
- Lift glass into opening, setting bottom edge of glass on *Sill Glass Spacers*. Push top portion of glass into *Silicone Bed Glazing*. Glass logo must be located in the bottom left corner of unit, legible from the interior. Glass logo is critical for glass limited warranty information and Low-E coating orientation.
- Center glass horizontally in opening using a **nylon** putty knife.
- Reapply *Head* and *Sill Interior Glass Stops* and fasten using 1-3/4" finish nails, 1/2" from each end and every 8" in between.
- Reapply *Side Interior Glass Stops* and fasten using 1-3/4" finish nails, 1/2" from each end and every 8" in between.



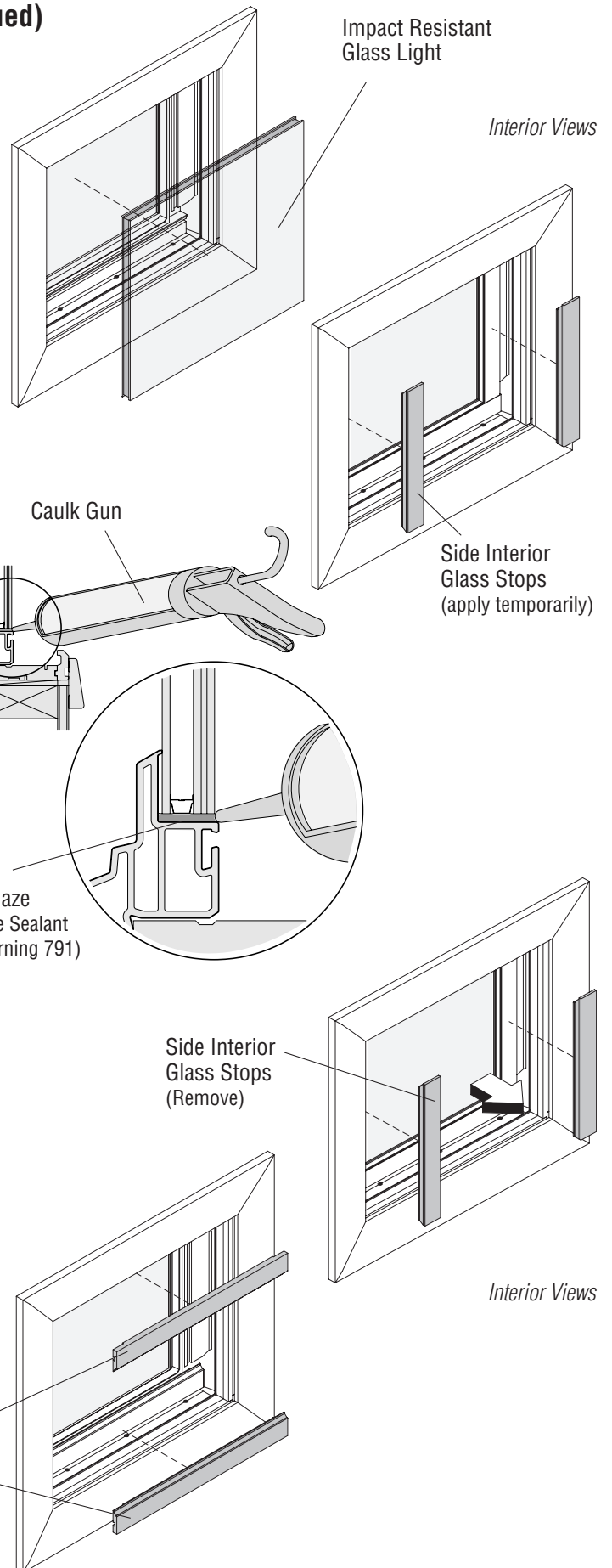
7. Apply Glass and Interior Glass Stops (continued)

Impact Resistant Units

⚠ WARNING

Failure to back glaze between glass and frame may result in personal injury, product and/or property damage.

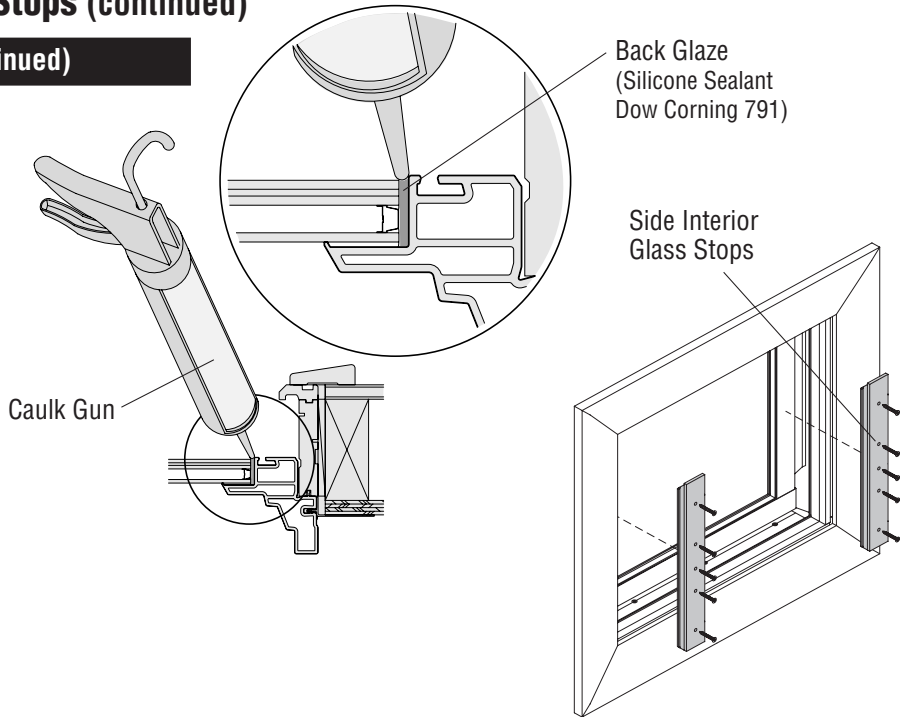
- Remove glass from crating, clean glass edge with isopropyl alcohol, and air dry.
- Lift glass into opening, setting bottom edge of glass on *Sill Glass Spacers*. Push top portion of glass into *Silicone Bed Glazing*. Glass logo must be located in the bottom left corner of unit, legible from the interior. Glass logo is critical for glass limited warranty information and Low-E coating orientation.
- Center glass horizontally in opening using a **nylon** putty knife.
- Temporarily reapply *Side Interior Glass Stops* using screws.
- Back glaze completely the void between the glass and frame at head and sill using *Dow Corning 791 Silicone Sealant* (provided).
- Remove *Side Interior Glass Stops* and retain for reuse.
- Reapply *Head and Sill Interior Glass Stops* and fasten using 1-3/4" finish nails, 1/2" from each end and every 8" in between.



7. Apply Glass and Interior Glass Stops (continued)

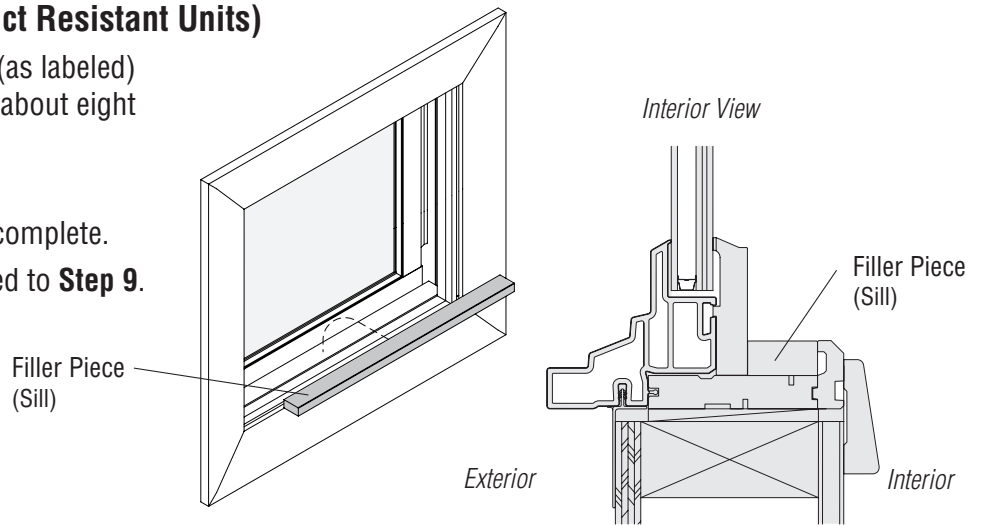
Impact Resistant Units (continued)

- Back glaze completely the void between the glass and frame at sides using *Silicone Sealant* (provided).
- Reapply *Side Interior Glass Stops* and fasten using 1-3/4" finish nails, 1/2" from each end and every 8" in between.
- Reapply 1-3/4" screws into *Interior Glass Stops*.



8. Reapply Filler Pieces (Impact Resistant Units)

- Reapply head and sill *Filler Pieces* (as labeled) and fasten using 1-3/4" finish nails about eight inches apart.
- Repeat for side *Filler Pieces*.
- **For Standard Units**, installation is complete.
- **For Impact Resistant Units**, proceed to **Step 9**.



9. Reapply Side Reinforcement Stops (Impact Resistant Units)

- Reapply side *Reinforcement Stops* and fasten using 1-3/4" finish nails about eight inches apart.
- Repeat for opposite side *Reinforcement Stop*.

