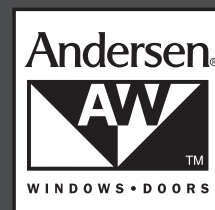


# Reglazing Guide

for Andersen® 400 Series Specialty Windows with Stormwatch® Protection (High-Performance™ Impact Resistant Glass)



**INSTALLER: This reglazing procedure is to be performed only by a professional glazier or an Andersen® service provider.**

**Replace entire unit if storm damage has broken glass, damaged the frame in any way, or resulted in any cracks and/or voids on the interior and/or exterior frame corners.**

## Important Safety, Assembly, and Installation Information

Impact Resistant Glass used by Andersen is not hurricane proof or shatter proof, and may not offer a high level of security. Proper installation of window and door units with impact resistant glass is as important to product performance as the glass. 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

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 Included

- (1) Glass Light
- (1) Bed Glazing Silicone, Dow Corning 1350 (4230229)
- (1) 3/16" x 1/8" Lateral Glass Spacer (2230012)

## Additional Parts Required (Contact Your Andersen Dealer)

- (1) Fillet Bead Silicone, Dow Corning  
White (2903008), Terratone® color (2903010),  
Sandtone (2092512), Forest Green (2903026)
- (1) Glass Stop Kit (Stops, Screws)
- #8 x 1-1/2" Screws
- 4d (1-1/2") Finish Nails

## Tools and Supplies

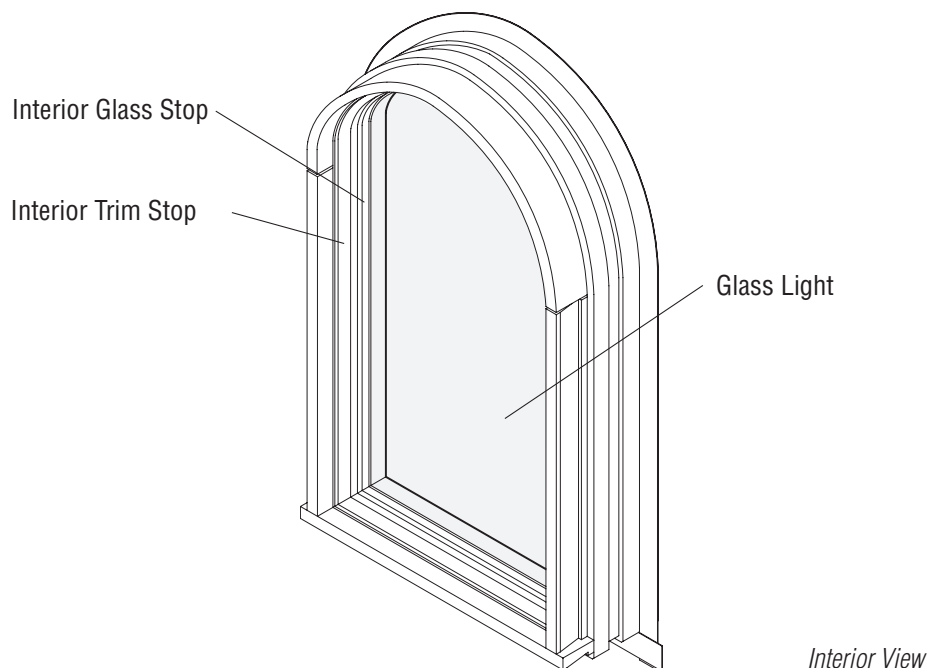
- Vise Grips
- Flat Blade Screwdriver
- 1/4" Wood Chisel
- Glass Clamps (Commercial Grade)
- Gloves
- Safety Glasses
- Utility Knife
- Caulk Gun
- Thin Blade Putty Knife
- Nylon Putty Knife
- Flat Pry Bar
- Hammer
- Nail Set
- Drill
- T-15 Torx Drive
- 5/64" Drill Bit
- Duct Tape
- Isopropyl Alcohol
- Pencil

## Optional Material

- 1/4" x 7/8" x 6" Sill Setting Block (2250105)
- 1/8" x 7/8" x 6" Head and Side Spacers (2250109) (Reuse existing sill glass spacers when possible)

## 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 this instruction guide. 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 unit has grilles applied to the glass, they need to be removed prior to reglazing. Since specialized tools are required to remove grilles, it is recommended the reglazing procedure be done by a professional Andersen service provider.

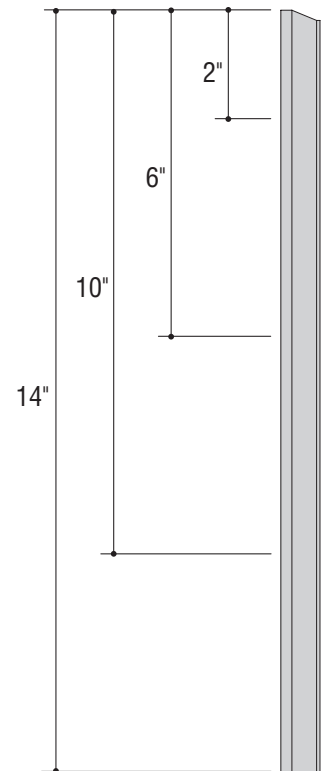
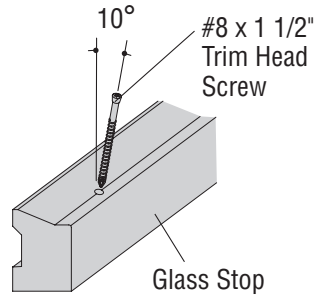


*Interior View*

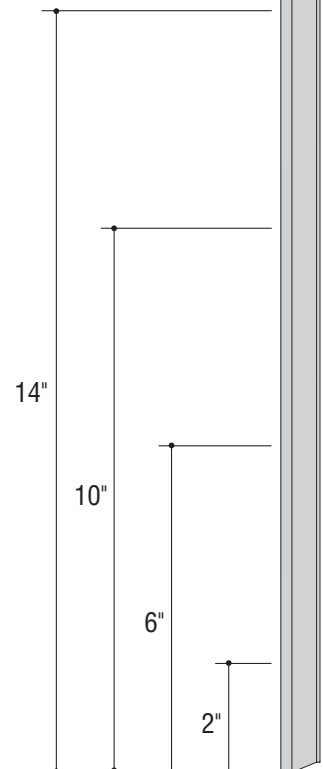
Springline™ Window Shown

## 1. Prepare New Glass Stops

- Determine the number of #8 x 1-1/2" trim head screws based on unit size from tables on **Pages 3-8**.
- Mark screw locations on *Glass Stop* 2", 6", 10", and 14" from each end (as length applies). Locate remaining screws every 12" in between (as length applies).
- Drill 5/64" holes, at a 10° angle, at marked screw locations.



Screw Locations



### Flexiframe® Window

UNIT SIZE (SQ FT)	TOTAL SCREWS
0 to 10 SQ FT	32
10 to 20 SQ FT	38
20 to 30 SQ FT	40
30 to 40 SQ FT	46
40 to 50 SQ FT	48



### Oval Window

UNIT	SCREWS PER ARCH	TOTAL SCREWS
OVL1820	8	16
OVL4060	13	26
OVL3040	11	22
OVL2030	9	18



### Circle Window

UNIT	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
CIR 2-0	12 R	4	8
CIR 2-4	14.2 R	5	10
CIR 3-0	18 R	6	12



### Full Round Window

UNIT	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
FR40	24 R	7	14



### Octagon Window

UNIT	RAIL LENGTH	SCREWS PER RAIL	TOTAL SCREWS
OC30	24"	3	24
OC24	28"	3	24
OC20	36"	3	24

**Quarter Round Window** 

UNIT	RAIL LENGTH	SCREWS PER RAIL	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
QR40	48"	7	48R	7	21

**Elliptical Window** 

UNIT	RAIL LENGTH	SCREWS PER RAIL	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
ET6	71-1/4"	9	71-1/4"	9	18
ET8	95-1/4"	11	95-1/4"	11	22

**Circle Top™ Quarter Window** 

UNIT	RAIL LENGTH	SCREWS PER RAIL	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
CTQA3	32-5/8"	8	52-3/8"	9	25
CTQCX1	28-1/8"	7	45-7/16"	9	23
CTQCW1	25"	7	40-1/2"	8	22
CTQC1	20-3/4"	5	33-13/16"	8	18

**Full Cord Window** 

UNIT	RAIL LENGTH	SCREWS PER RAIL	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
FCD28	33-5/8"	6	18.75R	6	12
FCD30	37-5/8"	6	24R	6	12
FCD34	41-5/8"	6	24R	6	12
FCD38	46-5/8"	7	32.25R	6	13
FCCXW	36-1/2"	6	18.75R	6	12
FCC2	48"	7	32.25R	6	13
FCCW2	56-1/2"	8	36R	6	14
FCFW50	59-3/4"	8	36R	6	14
FCFW60	71-3/4"	9	48R	7	16

**Circle Top™ Window - Double-Hung** 

UNIT	RAIL LENGTH	SCREWS PER RAIL	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
CTN 20	20-5/8"	5	38-3/16"	8	13
CTN 24	24-5/8"	6	44-1/2"	8	14
CTN 28	28-5/8"	7	50-3/4"	9	16
CTN 30	32-5/8"	7	57-1/16"	9	16
CTN 34	36-5/8"	8	63-5/16"	10	18
CTN 28-2	62-5/16"	10	103-11/16"	13	23
CTN 30-2	70-5/16"	11	116-1/4"	14	25

Circle Top™ Window - Casement/Awning 

UNIT	RAIL LENGTH	SCREWS PER RAIL	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
CTC1	19-15/16"	5	36"	8	13
CTCW1	24-3/16"	6	42-11/16"	9	15
CTCX1	27-5/16"	7	47-5/8"	9	16
CTCXW1	31-3/4"	8	54-9/16"	10	18
CTC2	43-13/16"	9	73-1/2"	11	19
CTCW2	52-5/16"	9	86-7/8"	12	21
CTCX2	58-9/16"	10	96-11/16"	13	23
CTC3	67-11/16"	11	111"	14	24

Gothic Window 

UNIT	RAIL LENGTH	SCREWS PER RAIL	STILE LENGTH	SCREWS PER STILE	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
GT2036	24-1/8"	5	16-27/32"	4	32.25R	6	25
GT2440	28-3/8"	5	21-9/32"	5	32.25R	6	27
GT3046	35-15/16"	6	22-27/32"	5	36R	6	28
GT4056	48"	7	24-7/16"	5	48R	7	31

Springline™ Window 

UNIT	RAIL LENGTH	SCREWS PER RAIL	STILE LENGTH	SCREWS PER STILE	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
SP802	96"	11	6"	2	48"	7	22
SP801	96"	11	12"	2	48"	7	22
SP8006	96"	11	24"	5	48"	7	28
SP406	48"	7	71-7/8"	9	24"	5	30
SP4055	48"	7	64-13/16"	8	24"	5	28
SP405	48"	7	59-7/8"	8	24"	5	28
SP4045	48"	7	52-13/16"	8	24"	5	28
SP404	48"	7	48"	7	24"	5	26
SP4035	48"	7	40-13/16"	7	24"	5	26
SP403	48"	7	35-15/16"	6	24"	5	24
SP402	48"	7	24-1/8"	5	24"	5	22
SE602	72"	9	24-1/8"	5	36"	6	25
SE603	72"	9	35-15/16"	6	36"	6	27
SE6035	72"	9	40-13/16"	7	36"	6	29
SE604	72"	9	48"	7	36"	6	29
SE6045	72"	9	52-13/16"	8	36"	6	31
SE605	72"	9	59-7/8"	8	36"	6	31
SE6055	72"	9	64-13/16"	9	36"	6	33
SE606	72"	9	71-7/8"	9	36"	6	33
SE601	72"	9	12"	2	36"	6	19
SE6006	72"	9	6"	2	36"	6	19
SE582	68-1/2"	9	24-1/8"	5	34-1/4"	6	25

## Springline™ Window (continued)

UNIT	RAIL LENGTH	SCREWS PER RAIL	STILE LENGTH	SCREWS PER STILE	ARCH LENGTH/RAD	SCREWS LENGTH/RAD	TOTAL SCREWS
SE583	68-1/2"	9	35-15/16"	6	34-1/4"	6	27
SE5835	68-1/2"	9	40-13/16"	7	34-1/4"	6	29
SE584	68-1/2"	9	48"	7	34-1/4"	6	29
SE5845	68-1/2"	9	52-15/16"	8	34-1/4"	6	31
SE585	68-1/2"	9	59-7/8"	8	34-1/4"	6	31
SE5855	68-1/2"	9	64-13/16"	9	34-1/4"	6	33
SE586	68-1/2"	9	71-7/8"	9	34-1/4"	6	33
SE581	68-1/2"	9	12"	2	34-1/4"	6	19
SE5806	68-1/2"	9	6"	2	34-1/4"	6	19
SE546	64-1/2"	9	24-1/8"	5	32-1/4"	6	25
SE5455	64-1/2"	9	35-15/16"	6	32-1/4"	6	27
SE545	64-1/2"	9	40-13/16"	7	32-1/4"	6	29
SE5445	64-1/2"	9	48"	7	32-1/4"	6	29
SE544	64-1/2"	9	52-13/16"	8	32-1/4"	6	31
SE5435	64-1/2"	9	59-7/8"	9	32-1/4"	6	33
SE543	64-1/2"	9	64-13/16"	9	32-1/4"	6	33
SE542	64-1/2"	9	71-7/8"	9	32-1/4"	6	33
SE541	64-1/2"	9	12"	2	32-1/4"	6	19
SE5406	64-1/2"	9	6"	2	32-1/4"	6	19
SE316	37-1/2"	6	24-1/8"	5	18-3/4"	4	20
SE3155	37-1/2"	6	35-15/16"	6	18-3/4"	4	22
SE3155	37-1/2"	6	40-13/16"	7	18-3/4"	4	24
SE3145	37-1/2"	6	48"	7	18-3/4"	4	24
SE314	37-1/2"	6	52-13/16"	8	18-3/4"	4	26
SE3135	37-1/2"	6	59-7/8"	9	18-3/4"	4	28
SE313	37-1/2"	6	64-13/16"	9	18-3/4"	4	28
SE312	37-1/2"	6	71-7/8"	9	18-3/4"	4	28
SE311	37-1/2"	6	12"	2	18-3/4"	4	14
SE3106	37-1/2"	6	6"	2	18-3/4"	4	14
ELFW6006	71-1/4"	9	6"	2	36"	6	19
ELFW601	71-1/4"	9	12"	2	36"	6	19
ELFW602	71-1/4"	9	24-7/8"	5	36"	6	25
ELFW8006	95-1/8"	9	6"	2	48"	7	20
ELFW801	95-1/8"	9	12"	2	48"	7	20
ELFW802	95-1/8"	9	24-7/8"	5	48"	7	26

Arch Window



UNIT	RAIL LENGTH	SCREWS PER RAIL	STILE LENGTH	SCREWS PER STILE	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
AFFW1206	143"	12	6"	2	192"	14	30
AFFW1201	143"	12	12"	2	192"	14	30
AFFW1202	143"	12	24"	5	192"	14	36
AFC106	24-1/8"	5	6"	2	24"	5	14
AFC11	24-1/8"	5	12"	2	24"	5	14
AFC12	24-1/8"	5	24"	5	24"	5	20
AFC13	24-1/8"	5	35-15/16"	6	24"	5	22
AFC135	24-1/8"	5	40-13/16"	6	24"	5	22
AFC14	24-1/8"	5	48"	7	24"	5	24
AFC145	24-1/8"	5	52-13/16"	7	24"	5	24
AFC15	24-1/8"	5	59-7/8"	8	24"	5	26
AFC155	24-1/8"	5	64-13/16"	8	24"	5	26
AFC16	24-1/8"	5	71-7/8"	9	24"	5	28
AFC18	24-1/8"	5	96"	11	24"	5	32
AFCW106	28-3/8"	6	6"	2	24"	5	15
AFCW11	28-3/8"	6	12"	2	24"	5	15
AFCW12	28-3/8"	6	24"	5	24"	5	21
AFCW13	28-3/8"	6	35-15/16"	6	24"	5	23
AFCW135	28-3/8"	6	40-13/16"	6	24"	5	23
AFCW14	28-3/8"	6	48"	7	24"	5	25
AFCW145	28-3/8"	6	52-13/16"	7	24"	5	25
AFCW15	28-3/8"	6	59-7/8"	8	24"	5	27
AFCW155	28-3/8"	6	64-13/16"	8	24"	5	27
AFCW16	28-3/8"	6	71-7/8"	9	24"	5	29
AFCW18	28-3/8"	6	96"	11	24"	5	33
AFCP3006	35-15/16"	6	6"	2	36"	6	16
AFCP301	35-15/16"	6	12"	2	36"	6	16
AFCP302	35-15/16"	6	24"	5	36"	6	22
AFCP303	35-15/16"	6	35-13/16"	6	36"	6	24
AFCP3035	35-15/16"	6	40-13/16"	6	36"	6	24
AFCP304	35-15/16"	6	48"	7	36"	6	26
AFCP3045	35-15/16"	6	52-13/16"	7	36"	6	26
AFCP305	35-15/16"	6	59-7/8"	8	36"	6	28
AFCP3055	35-15/16"	6	64-13/16"	8	36"	6	28
AFCP306	35-15/16"	6	71-7/8"	9	36"	6	30
AFCP308	35-15/16"	6	96"	11	36"	6	34
AFC206	48"	7	6"	2	48"	7	18
AFC21	48"	7	12"	2	48"	7	18
AFC22	48"	7	24"	5	48"	7	24
AFC23	48"	7	35 15/16"	6	48"	7	26
AFC235	48"	7	40 13/16"	6	48"	7	26
AFC24	48"	7	48"	7	48"	7	28
AFC245	48"	7	52 13/16"	7	48"	7	28

## Arch Window (continued)

UNIT	RAIL LENGTH	SCREWS PER RAIL	STILE LENGTH	SCREWS PER STILE	ARCH LENGTH/RAD	SCREWS PER ARCH	TOTAL SCREWS
AFC25	48"	7	59 7/8"	8	48"	7	30
AFC255	48"	7	64 13/14"	8	48"	7	30
AFC26	48"	7	71 7/8"	9	48"	7	32
AFC28	48"	7	96"	11	48"	7	36
AFCW206	56-1/2"	7	6"	2	60"	8	19
AFCW21	56-1/2"	7	12"	2	60"	8	19
AFCW22	56-1/2"	7	24"	5	60"	8	25
AFCW23	56-1/2"	7	35-16/16"	6	60"	8	27
AFCW235	56-1/2"	7	40-13/16"	6	60"	8	27
AFCW24	56-1/2"	7	48"	7	60"	8	29
AFCW245	56-1/2"	7	52-13/16"	7	60"	8	29
AFCW25	56-1/2"	7	59-7/8"	8	60"	8	31
AFCW255	56-1/2"	7	64-13/16"	8	60"	8	31
AFFW5006	56-1/2"	7	6"	2	60"	8	19
AFFW501	56-1/2"	7	12"	2	60"	8	19
AFFW502	59-1/4"	8	24"	5	60"	8	26
AFFW503	59-1/4"	8	35-15/16"	6	60"	8	28
AFFW5035	59-1/4"	8	40-13/16"	6	60"	8	28
AFFW504	59-1/4"	8	48"	7	60"	8	30
AFFW5045	59-1/4"	8	52-13/16"	7	60"	8	30
AFFW505	59-1/4"	8	59-7/8"	8	60"	8	32
AFFW6006	59-1/4"	8	6"	2	72"	9	21
AFFW601	59-1/4"	8	12"	2	72"	9	21
AFFW602	59-1/4"	8	24"	5	72"	9	27
AFFW603	59-1/4"	8	35-15/16"	6	72"	9	29
AFFW6035	59-1/4"	8	40-13/16"	6	72"	9	29
AFFW604	59-1/4"	8	48"	6	72"	9	29
AFFW6045	59-1/4"	8	52-13/16"	7	72"	9	31
AFFW8006	95-5/8"	11	6"	2	96"	11	26
AFFW801	95-5/8"	11	12"	2	96"	11	26
AFFW802	95-5/8"	11	24"	5	96"	11	32
AFFW803	95-5/8"	11	35-15/16"	6	96"	11	34

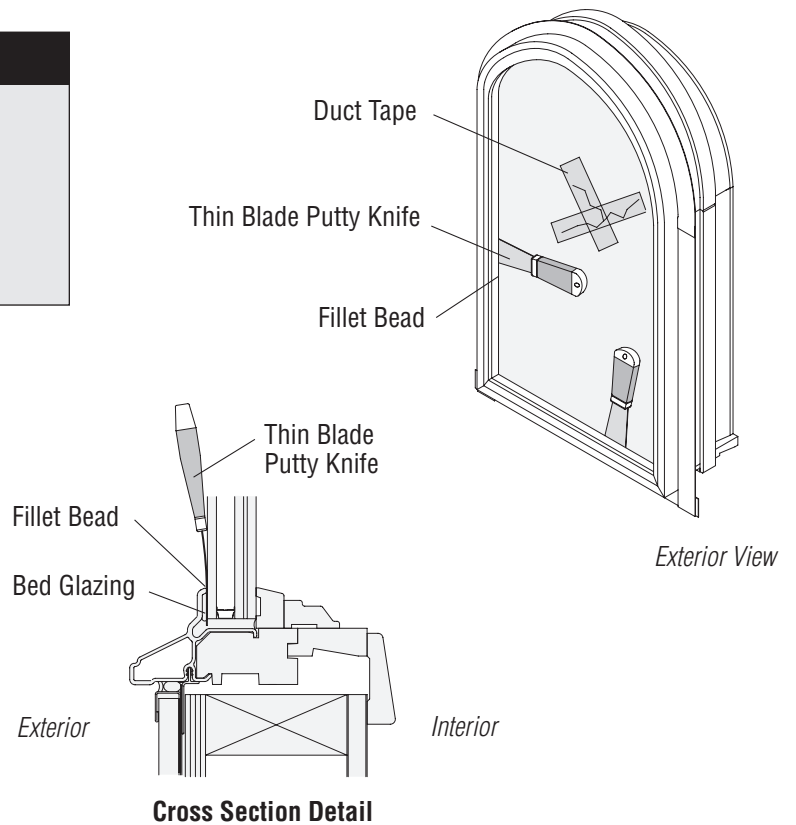


## 2. Tape Glass and Cut Fillet Bead

### ⚠ WARNING

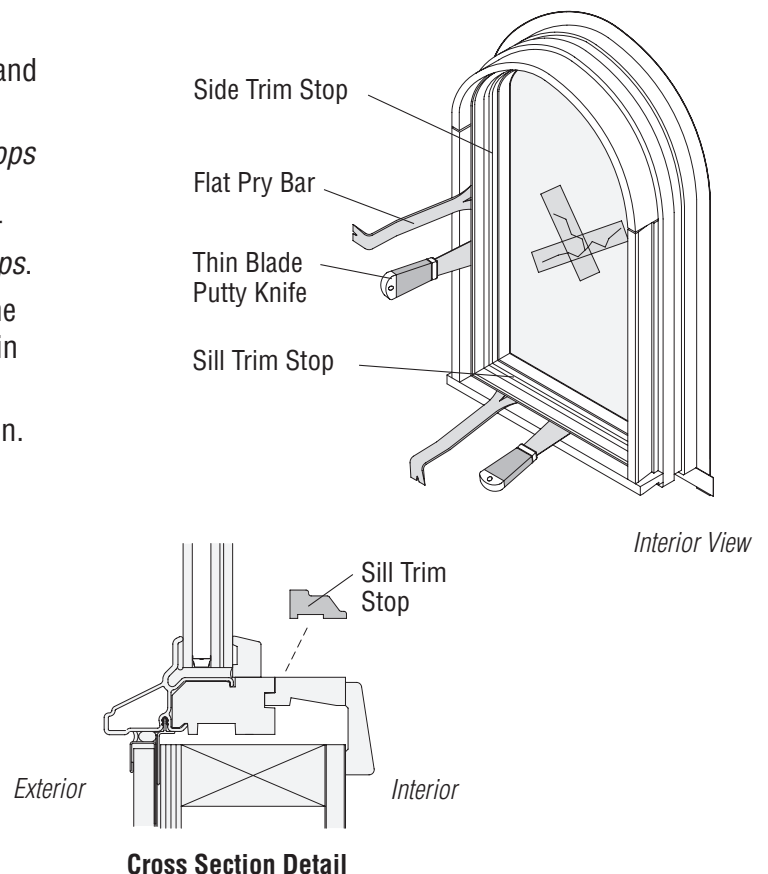
Wear gloves and safety glasses when handling glass. Tape broken glass with duct tape before removal to reduce glass fragmentation. Failure to do so may result in personal injury, product, and/or property damage.

- Tape damaged glass using duct tape.
- Working from the exterior, cut *Fillet Bead* and *Bed Glazing* the full perimeter of unit using a thin blade putty knife. Knife blade should penetrate through *Fillet Bead* 5/8" to reach *Bed Glazing*.



## 3. Remove Wood Trim Stops

- Break varnish/paint seal between *Wood Trim Stops* and glass using a thin blade putty knife.
- Insert a flat pry bar between one of the side *Trim Stops* and frame, from the interior. Carefully pry side *Trim Stop* toward exterior along entire length. Repeat for opposite side *Trim Stop*, then head and sill *Trim Stops*.
- Remove nails from *Trim Stops* by pulling through the backside using a vise grip pliers. Remove nails left in trim stop area on frame.
- Mark location on back of *Trim Stops* for reinstallation.



#### 4. Remove Glass Stops and Damaged Glass

- Remove head, sill, and side *Glass Stops* from unit using a small pry bar and putty knife. *Glass Stops* may have a silicone bond with glass and may be difficult to remove.
- Retain *Glass Stops* for future use. *Glass Stops* will be reused as temporary stops when installing replacement glass.
- Mark location of *Glass Spacers* for reinstallation.

### ⚠ WARNING

Support Glass Panel at all times once cutting of back glazing begins. Glass Panel may fall inwards. Handle broken glass with extreme caution. Failure to do so may result in injury.

### ⚠ WARNING

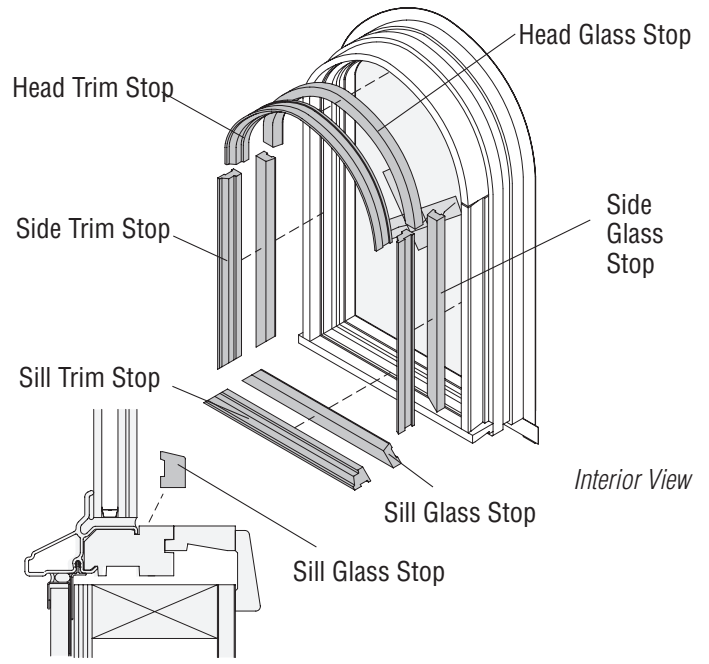
Weight of glass will vary. Use a reasonable number of people with sufficient strength to lift, carry, and install glass. Always use appropriate lifting techniques. Failure to do so may result in injury.

- Cut silicone *Back Glazing* around full perimeter of unit. Trim *Back Glazing* as close to frame as possible using glazing cutting tool.

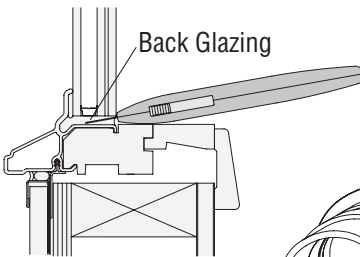
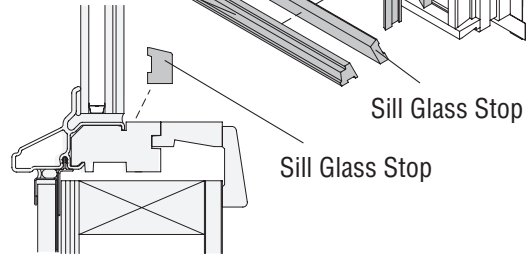
### ⚠ WARNING

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 severe personal injury or death.

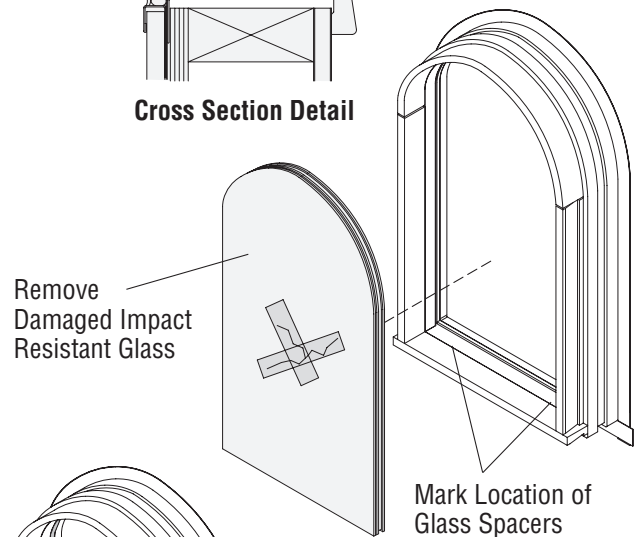
- Carefully remove and properly dispose of damaged *Impact Resistant Glass*.
- Remove and retain *Glass Spacers* for reinstallation.
- Remove silicone from *Glazing Lip* and frame (around full perimeter of unit) using putty knife or wood chisel. Clean surface with isopropyl alcohol and air dry.
- Cut retained *Glass Stops* into 6" sections. A 6" section is required for every 12" of glass side edge.



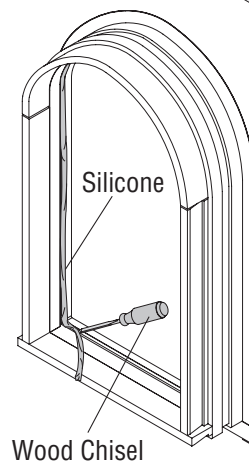
Interior View



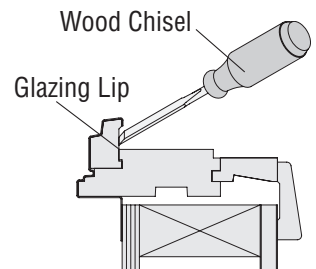
Cross Section Detail



Interior View



Wood Chisel



Cross Section Detail

## 5. Install Replacement Glass

### ⚠ 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. Failure to do so may result in injury.

### ⚠ CAUTION

- Remove all obstructions from glazing area that could chip glass and lead to breakage. Use caution when handling glass. Protect glass edges, and **DO NOT** roll glass on edges or corners. Breakage or damage may occur.
- For high altitude glass, make sure breather tube (located at the top of the glass) is not plugged or pinched during procedure. Plugging or pinching of breather tube may result in collapsed or damaged glass.
- **DO NOT** use a metal knife and/or metal objects against glass surface to avoid scratching or chipping.

- Remove replacement *Impact Resistant Glass* from crating and clean perimeter using surface conditioner.
- Prepare caulk gun with *Dow Corning 1350 Bed Glazing Silicone*.
- For **Arch Units**, apply *Lateral Spacers* 1/4" from end of arch and at arch quarter points. For **Springline™ Units**, apply *Glass Spacers* at quarter points of the arch and sill. Equally space and apply remaining *Glass Spacers* along perimeter of frame.
- Apply a 3/8" diameter bead of *Dow Corning 1350 Bed Glazing Silicone* to entire perimeter of *Glazing Bed* and place sill *Glass Spacers* at marked sill locations.

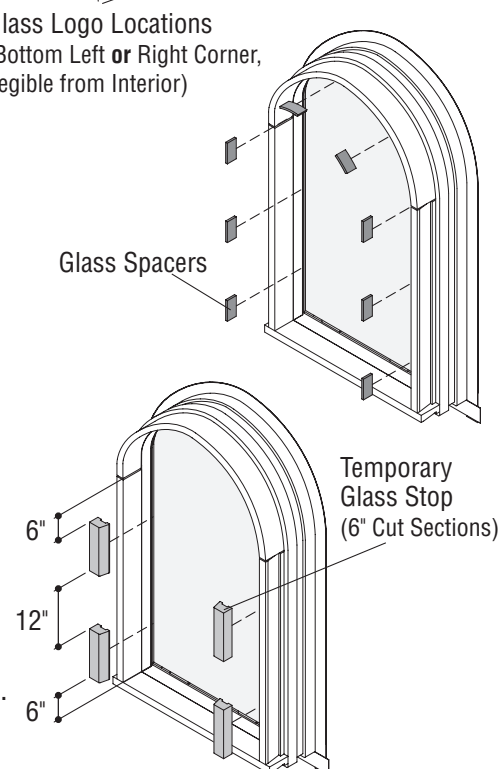
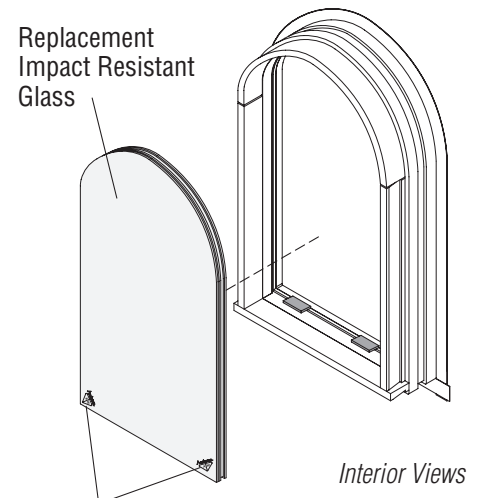
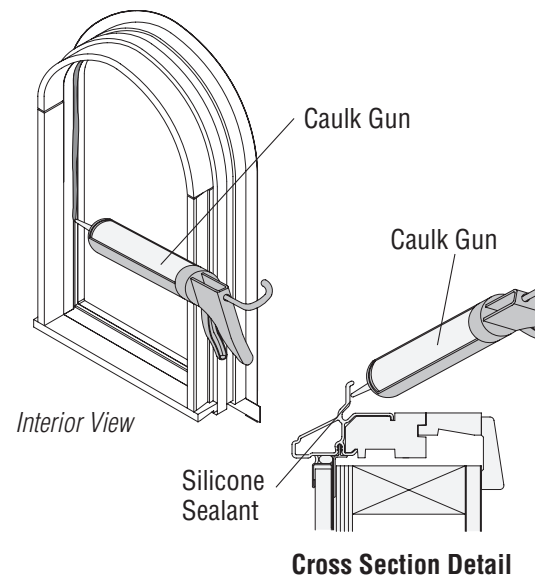
### NOTICE

Glass logo must be located in bottom left or right corner of unit, legible from the interior. Glass logo is critical for glass warranty information and Low-E coating orientation.

### ⚠ WARNING

Support Glass Panel until glass stops are screwed in. Glass Panel may fall inward resulting in personal injury, product, and/or property damage.

- Set bottom edge of glass on *Sill Glass Spacers* using glass clamps. Tip top of glass into glazing bed and center horizontally in opening.
- Apply previously removed and shortened, temporary, *Glass Stops* to remaining sides and **press glass outwards** to fully seat glass tight against *Glazing Lip*.
- Space first 6" section of temporary *Glass Stop* 2" from glass edge. Secure to frame using #8 x 1-1/2" screw centered on stop. Repeat for opposite side.
- Space additional *Temporary Glass Stops* 12" apart and fasten as previously described.



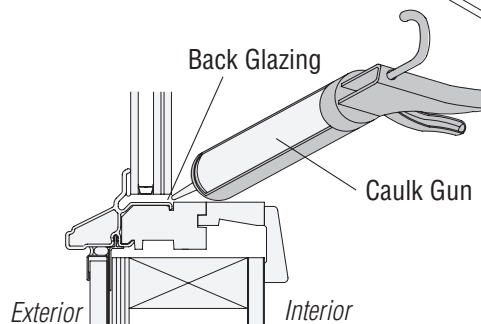
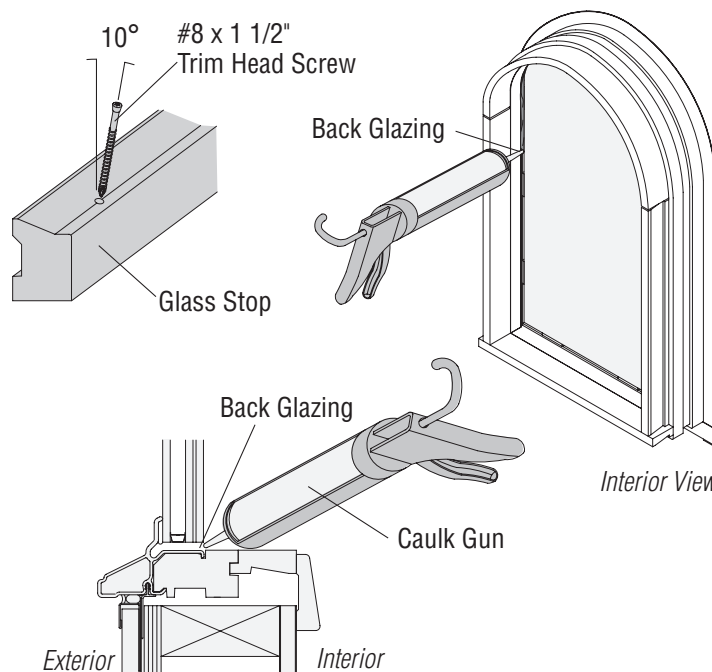
## 6. Back Glaze and Install Stops

- Back glaze head of unit using *Dow Corning 1350 Silicone* (use only silicone provided) while applying pressure to glass. Fill void completely between edge of glass and frame.
- Apply replacement *Head Glass Stop* to unit.

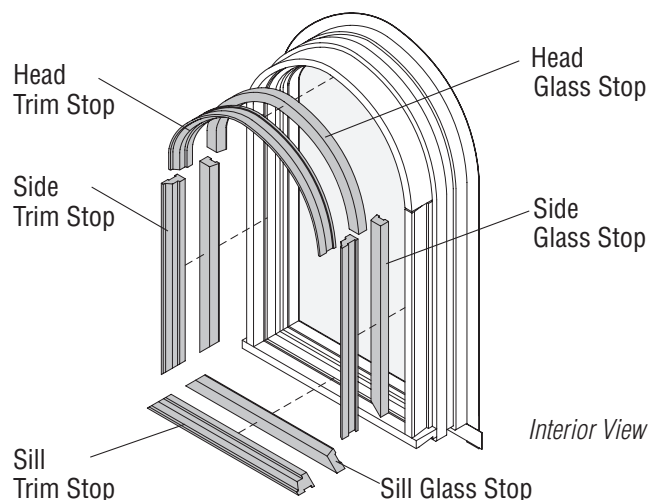
### CAUTION

Fasten flat portion of Glass Stops at no more than a 10° angle to glass surface as shown. Failure to do so could result in glass edge damage and/or glass breakage.

- Apply outward pressure on *Glass Stop* to seat glass in bed glazing before fastening. Fasten *Glass Stop* using #8 x 1-1/2" Trim Head Screws at no more than a 10° angle at predrilled locations. While fastening, continue to push on *Glass Stop* to make sure glass is tight against frame.
- Repeat back glazing at sill, apply replacement *Sill Glass Stop*, and fasten *Sill Glass Stop* as in previous step.
- Remove temporary *Side Glass Stops*.
- Back glaze sides of unit, apply replacement *Side Glass Stops*, and fasten *Side Glass Stops* as previously described.
- Apply *Trim Stops* to unit and fasten using 1-1/2" (4d) finish nails. Use same nail spacing as original nails, nailing next to original holes
- Set nail heads in *Glass Stops* and *Trim Stops* approximately 1/16".



Cross Section Detail



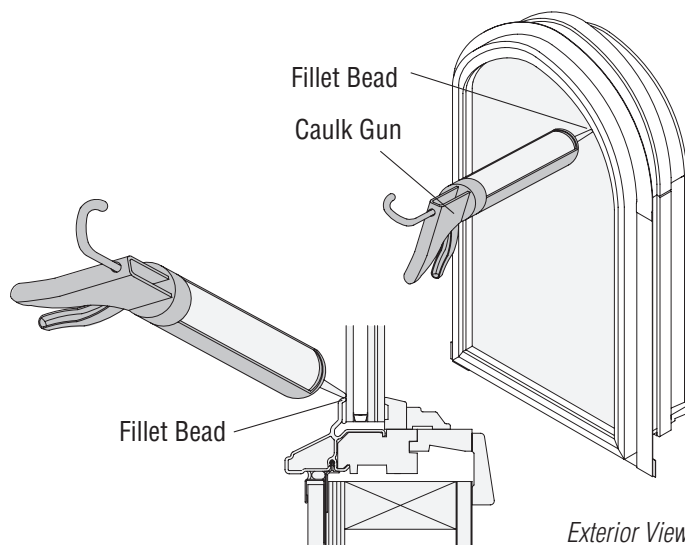
## 7. Apply Silicone Fillet Bead

- Clean *Fillet Bead* area using a clean cloth and isopropyl alcohol.
- Apply a 3/16" *Fillet Bead* of color matching *Silicone Sealant* to exterior seal between glazing lip and glass, (full perimeter), using a caulk gun.

### NOTICE

Wait until Silicone cures before removing it from glass. Use a nylon knife to scrape off and when scraping, apply a liberal amount of window cleaner to keep area lubricated.

- Clean excess *Silicone Sealant* around *Fillet Bead*, if needed.



Cross Section Detail