

# Transom Joining Using Aluminum Trim Piece

## for Andersen® Flexiframe® and Double-Hung Windows



Congratulations! You have just purchased one of the many fine Andersen® products. For ease of assembly and installation and continued enjoyment of your Andersen® product please read and follow this Instruction Guide completely. You may direct any questions about Andersen® products to your local Andersen® dealer. Andersen® dealers can be found in the Yellow Pages under Windows.

Installer: Please leave the Installation Guide with the building owner to file for future reference. Thank you for choosing Andersen®.

### Importance of Proper Assembly and Installation

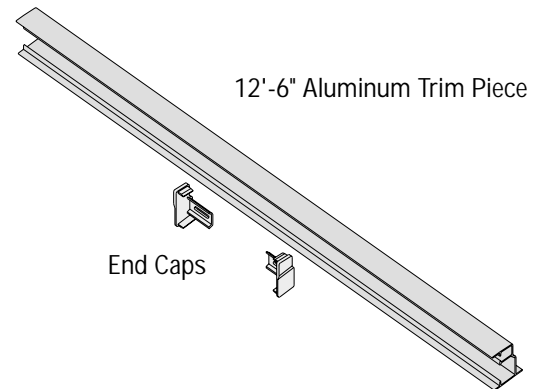
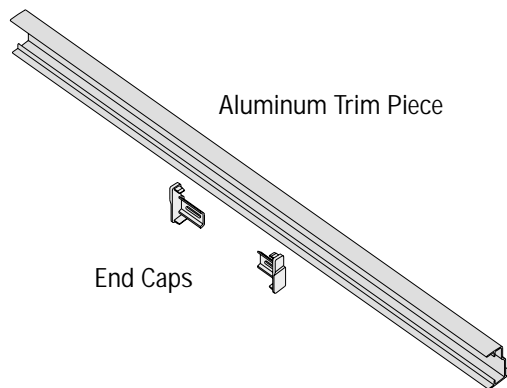
Proper assembly, installation, and maintenance of Andersen products are essential if the benefits of experienced product design and engineering, quality materials, and skilled workmanship are to be fully attained. General recommendations regarding assembly and installation are guidelines only. Every 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. Assembly and installation of Andersen products is the sole responsibility of the architect, building owner, contractor and/or consumer and Andersen has no responsibility in this regard.

#### Parts Included When Using Wood Joining Kit

- (1) Aluminum Trim Piece
- (1) Left Hand End Cap
- (1) Right Hand End Cap
- (2) Side Gusset Plates
- (5) No. 8 x 1-3/4" Screws

#### Parts Included When Using Reinforced Joining Kit

- (1) 12'-6" Aluminum Trim Piece
- (1) Left Hand End Cap
- (1) Right Hand End Cap



#### Installation Tools and Supplies Needed:

- Safety Glasses
- Metal Cutting Saw
- Electric Drill
- 5/32" Drill Bit
- Tape Measure
- Clamps
- Phillips Head Screwdriver

#### Additional Parts required for Tilt-Wash, DH Transom and DH Picture Windows

- Head Filler Piece (#1630030 - 1630036)

### ⚠ 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.

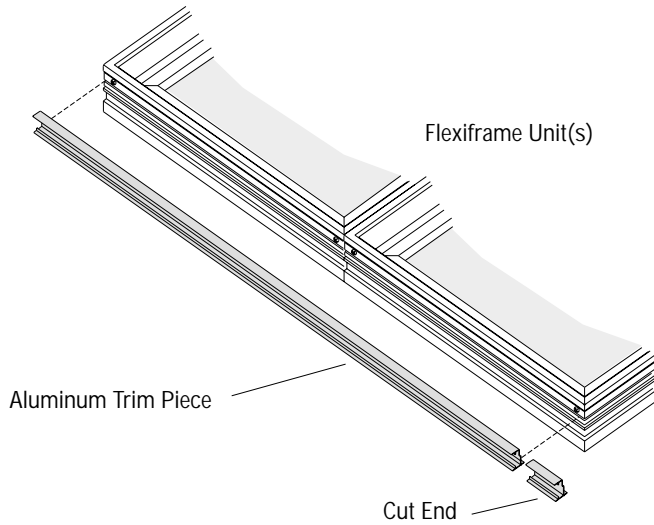
### ⚠ WARNING

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. Personal injury and/or falls could occur.

### ⚠ WARNING

Weight of window and 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.

### 1. Cut Aluminum Trim Piece

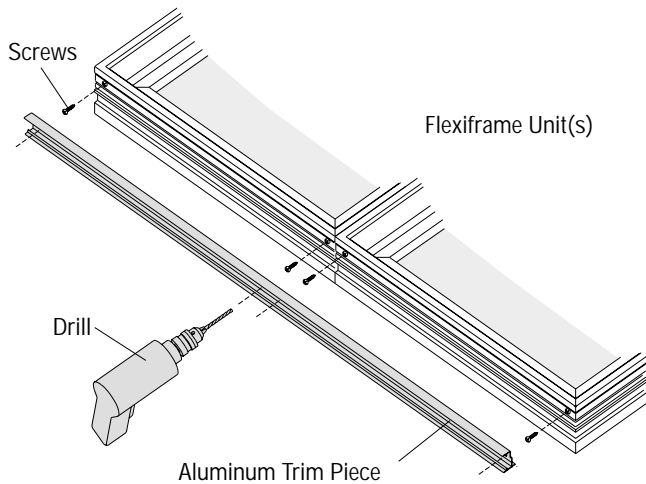


### ⚠ CAUTION

Multiple Flexiframe units must be mullion joined before proceeding. Following directions in Flexiframe Narrow Mullion Instruction Guide (#0004344).

- Place Flexiframe Unit(s) exterior side up on a clean flat worksurface.
- Measure width of sill on Flexiframe Unit(s). Subtract 9/32" from measurement.
- Cut *Aluminum Trim Strip* to above measurement.

### 2. Drill Holes in Aluminum Trim Piece

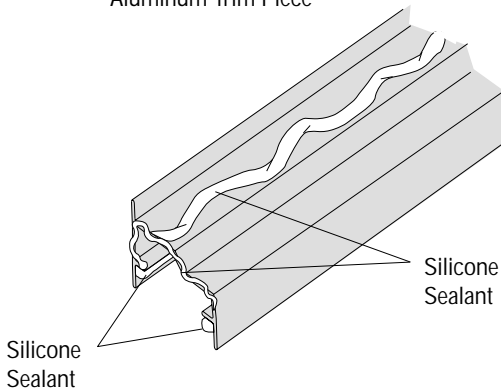


- Remove all screws from bottom of sill on Flexiframe Unit(s).
- Measure and mark on *Aluminum Trim Piece* the position of holes on the sill of the Flexiframe Unit(s). Keep in mind that the *Aluminum Trim Piece* is 9/32" shorter than width of sill and is centered on unit(s).
- Drill 5/32" holes in *Aluminum Trim Piece* on marks.

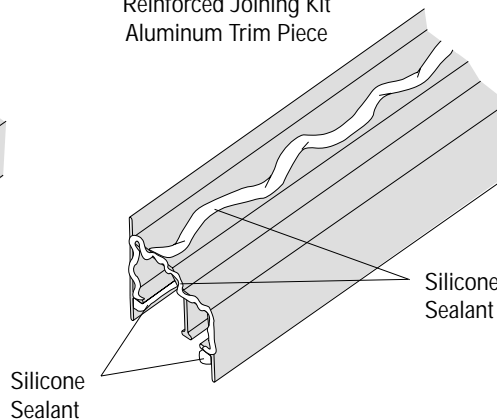
### 3. Apply Silicone to Aluminum Trim Piece

- Apply silicone sealant full length to the three areas shown on the *Aluminum Trim Piece*.
- Apply silicone sealant to the ends of *Aluminum Trim Piece*.

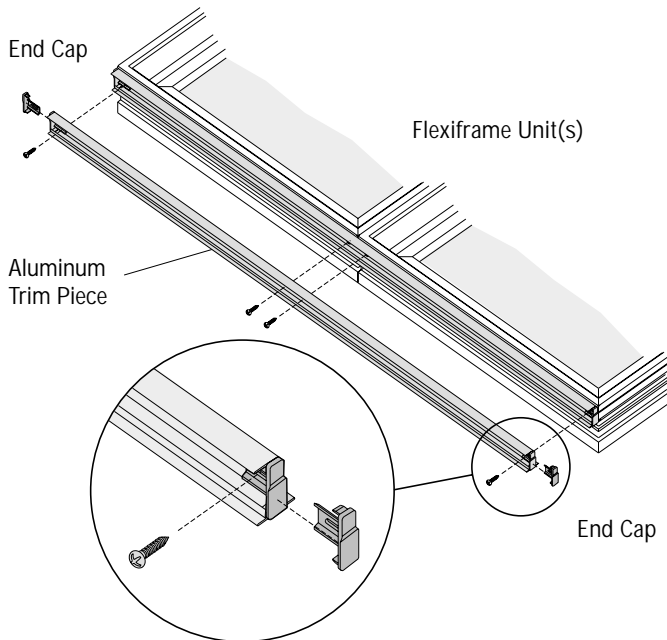
Wood Joining Kit  
Aluminum Trim Piece



Reinforced Joining Kit  
Aluminum Trim Piece



#### 4. Attach Aluminum Trim Piece



- Insert *End Caps* into *Aluminum Trim Piece*.
- Position *Aluminum Trim Piece* on Flexiframe Sill and insert #8 x 1-3/4" screws through *End Caps* and into holes. Secure in place.
- Replace removed screws from Flexiframe(s) sill and secure.
- Remove excess silicone sealant from end of *Aluminum Trim Piece*.

### ⚠ WARNING

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

- Turn Flexiframe Unit(s) over interior side up.

### NOTICE

If the reinforced joining kit Aluminum Trim Strip is being used, proceed to the Steel Reinforced Joining Guide (#0005172) Flexiframe to Double-Hung horizontal joining section.

#### 5. Prepare Double-Hung Units

- Place Double-Hung Unit(s) interior side up on a clean flat worksurface.
- Remove *Head Flange* from Double-Hung unit(s) by pulling outwards.
- Lower the top sash on Double-Hung Unit(s) and brace in open position with a block of wood.

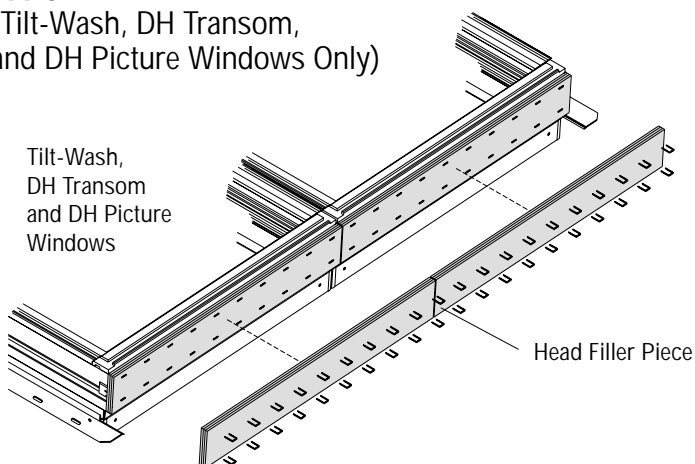
### NOTICE

#### Tilt-Wash Units Only

A Head Filler Piece must be attached to the head of Tilt-Wash and Picture Windows before joining. Narroline units proceed to **Step 6**.

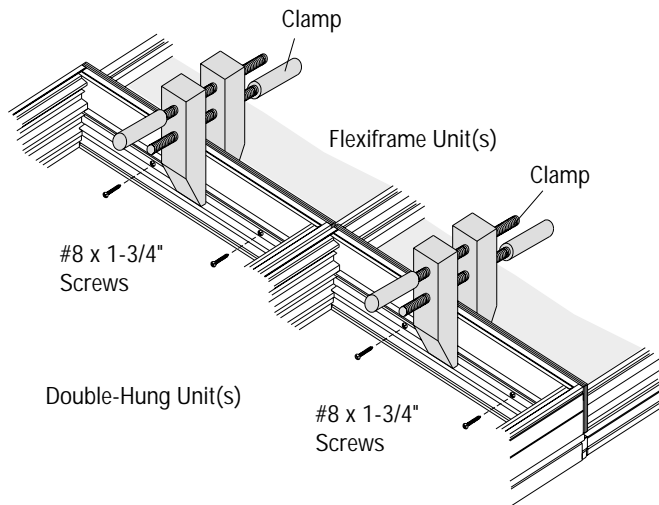
#### Apply Head Filler Piece

(Tilt-Wash, DH Transom, and DH Picture Windows Only)



- Attach *Head Filler Piece* to Tilt-Wash or DH Picture Window flush to Head Jamb using 3/4" nails or staples located every 6". 3/4" staples or nails are not included in kit.

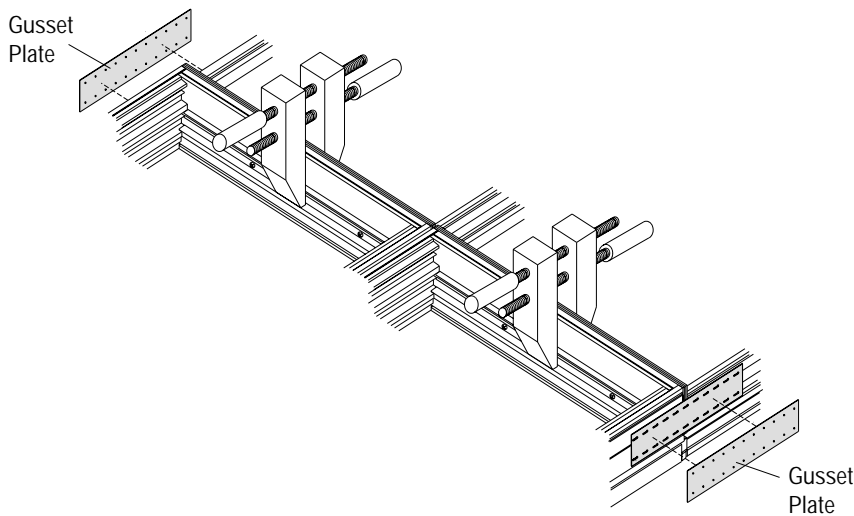
## 6. Join Units



- Place Double-Hung Unit(s) and Flexiframe Unit(s) together, flush at both ends. Clamp in place.
- Remove *Head Jamb Liner Screws* from Double-Hung Unit(s).
- Predrill through holes in Head Jamb using a 3/32" drill bit to accommodate longer screws. Do not predrill any deeper than 1-3/4".
- Insert #8 x 1-3/4" screws into holes and secure. Do not over-tighten screws to prevent damage to Head Jamb Liner.

## 7. Attach Gusset Plates

- Attach *Gusset Plates* using 1/2" nails or staples.



## 8. Seal Joining Area

- Apply appropriate colored silicone sealant around end of *Aluminum Trim Piece* and Double-Hung Outer Frame Member.
- Proceed to Unit Installation Guide (#0005134) for installation instructions.

