Non-Reinforced Joining Guide
(2-Way Horizontal and Vertical Joining)
for Andersen® 200 Series Tilt-Wash Double-Hung and Transom Windows

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
Use caution when working at elevated heights and around unit openings. Follow manufacturer’s instructions for safe use of ladder and/or scaffolding. Failure to do so may result in injury or death.

⚠️ WARNING
Follow manufacturer’s instructions for safe operation of hand/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 for certain size windows and in specific locations. 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® Installation Flanges DO NOT take the place of standard window and door flashing. Unit must be properly flashed and sealed with sealant, and full width drip cap 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.

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Non-Reinforced Joining Guide

Parts Needed
(4) Reinforced Gusset Plate
(3) Exterior Snap-On Trim
(3) Joining Strip (2 piece)
(3) Interior Trim Piece (by Andersen or others)

Tools & Supplies
Horizontal & Vertical Joining
• Safety Glasses
• Hammer
• Clamps
• Wood Blocks
• Caulk Gun
• Utility Knife
• Putty Knife
• Power Drill
• Staple Gun
• 3/32" Drill Bit
• 11/32" Drill Bit
• 11/32" Hole Plugs (2)
• #8 x 1-1/2" Flat Head Screws
• #8 x 2" Flat Head Screws
• 1/2" x 1/2" 16-Gauge Staples or
  #8 x 9/16" Pan Head Screws
  (Included in Single Non-Reinforced Joining Kit)
• 7/16" x 1" 16-Gauge Staples or
  #8 x 1" Flat Head Screws
  (Included in Single Non-Reinforced Joining Kit)
• #8 x 9/16" Pan Head Screws
  (Included in Single Non-Reinforced Joining Kit)
• Sealant
• Adhesion Promoter or Liquid Surface Deglosser
• Premium Grade Construction Adhesive
• 2" x 4" Skid (optional for transportation only)
• 2-1/4" Screws, maximum length
  (optional for transportation only)

NOTICE

• Use this guide for joining 2-way combinations, that are
  7-6 (90°) or shorter and 6-0 (72°) or narrower overall.
  (Larger combinations are not recommended).
1. Prepare Unit for Joining

**NOTICE**

**DO NOT** remove packaging clips until unit is installed.

- Remove units from carton. Place units exterior side up on a clean, flat work surface.

2. Prepare Flanges

- Remove *Installation Flange(s)* on sides to be joined by cutting using a utility knife. Leave ends extended on *Installation Flanges* that remain.
3. Join Units Horizontally

**NOTICE**

Complete horizontal joining (transom unit to double-hung unit) before vertical joining (side to side).

- If cutting horizontal *Joining Strip* is required, use chart to cut both *Joining Strips* to length. Find unit size, then use measurement to the right of the unit.

**Joining Strip Cut Length Chart**

<table>
<thead>
<tr>
<th>UNIT</th>
<th>JOINING STRIP</th>
<th>UNIT</th>
<th>JOINING STRIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>244DH60</td>
<td>36-7/16&quot;</td>
<td>244DH36</td>
<td>21-7/16&quot;</td>
</tr>
<tr>
<td>244DH59</td>
<td>34-15/16&quot;</td>
<td>244DH34</td>
<td>20-7/16&quot;</td>
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<td>12-7/16&quot;</td>
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<tr>
<td>244DH40</td>
<td>24-7/16&quot;</td>
<td>244DH18</td>
<td>10-7/16&quot;</td>
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</tbody>
</table>

- Apply 1/4" bead of sealant along sealant receiving groove of *Joining Strip* on side to be fastened to unit.
- Apply two 1/8" beads of construction adhesive to side of each *Joining Strip* being attached to unit, as shown.

**Cross Section Detail**

*Andersen® 200 Series Transom Window to 200 Series Tilt-Wash Double-Hung Window*
3. Join Units Horizontally (Continued)

- Position one Joining Strip to sill of upper unit and one to head jamb of lower unit, with notched ends toward center of unit as shown.
- Inset square end of Joining Strip 1/4” from side jamb as shown.
- Fasten Joining Strip to frame using 7/16” x 1” 16-gauge staples or #8 x 1” Flat Head Screws. Space staples or screws 3” from ends and every 8”.
- Apply 1/4” bead of sealant along sealant receiving groove of Joining Strip on side being joined.
- Apply two additional 1/8” beads of construction adhesive to opposite side of Joining Strip, located as shown in detail.

- Slide units together interlocking Joining Strips until units are flush.
- Transom Unit’s Installation Flange must overlap Tilt-Wash Double-Hung Unit’s Installation Flange to the exterior on both sides.
3. Join Units Horizontally (Continued)

- Unlock unit, slide Upper Sash down, and brace in open position using a wood block.
- Clamp units together.
- Drill two, 3/32” diameter pilot holes, 2” deep, through Head Jamb Liner and Head Jamb as shown. Locate holes at center of unit and 3” from side to be joined.
- Enlarge holes in Head Jamb Liner using a 11/32” drill bit.
- Secure a #8 x 2” flat head screws through head jamb.
- Insert Hole Plugs into enlarged holes in Head Jamb Liner.
4. Attach Gusset Plates to Sides

- Bend center tabs on Reinforced Gusset Plate flat as shown.
- Center Reinforced Gusset Plates across joined units in frame dado. Make sure units are flat to work surface before attaching Gusset Plate.
- Fasten Reinforced Gusset Plates using (8) #8 x 9/16” pan head screws (not included).

5. Apply Outside Snap-On Trim

**NOTICE**

Initial positioning of Exterior Trim Strip is important because it is very difficult to remove once inserted.

- Clean and prepare inside surface of Outside Snap-On Trim and exterior surface of jambs where Outside Snap-On Trim will be applied. An adhesion promoter or liquid surface deglosser is required. Apply as shown.
5. Apply Exterior Snap-On Trim (continued)

- Measure and cut horizontal Exterior Snap-On Trim.
- Apply two, 1/4” minimum diameter, continuous beads of sealant to back side of Exterior Snap-On Trim as shown.
- Position horizontal Exterior Snap-On Trim and tap into place using a hammer and wood block until it fully seated.
- Repeat for all horizontal Exterior Snap-On Trim.
- Clean sealant squeeze out from exterior.

6. Apply Sealant

- Apply sealant to completely fill void between joined units.
7. Join Units Vertically

**NOTICE**
Vertical Joining Strip overlap must be at least 16” below horizontal join.

- Cut Joining Strips to length if needed. Joining Strip overlap must be at least 16” below horizontal join.
- Apply 1/4” bead of sealant along sealant receiving groove of Joining Strip on side being fastened.
- Apply two 1/8” beads of construction adhesive to side of each Joining Strip being attached to unit as shown.
- Apply one Joining Strip on each jamb, positioning notched ends of Joining Strip toward center of unit as shown. Square end of Joining Strip must be inset 1/4” from head and sill jamb, as shown.
- Fasten Joining Strips to frame using 7/16” x 1” 16-gauge staples or #8 x 1” Flat Head Screws. Space staples or screws 3” from ends and every 8”.

**Excess Material**

**Joining Strip Measurement**
(each piece)

**Cross Section Detail**
Tilt-Wash Double-Hung to Tilt-Wash Double-Hung

**Vertical Joining Strip Overlap**

**16’ Minimum**

**Exterior Side Up**

**Side Jamb**

**Joining Strip**

**7/16’ x 1’ 16-Gauge Staples**

or #8 x 1” Flat Head Screws
7. Join Units Vertically (continued)

- Apply 1/4" bead of sealant along sealant receiving groove of Joining Strip on side being joined.
- Slide units together overlapping Joining Strips until units are flush.

- Clamp units together.
- Insert a small putty knife between Primary Weatherstrip and jamb liner and pry toward the interior to detach Primary Weatherstrip, as shown.
- Repeat for opposite tilt-wash double-hung unit.
7. Join Units Vertically (continued)

- Drill two, 3/32" diameter pilot holes, 1" deep, through Side Jambs as shown. Locate holes 1-1/2" and 4-1/2" from head jamb on one side and 3" and 6" from the head jamb on the other side.
- Secure side jambs using four (4) #8 x 1-1/2" flat head screws.
- Reapply Primary Weatherstrips.
8. Attach Head and Sill Gusset Plates

- Clamp jambs together as shown.
- Bend center tabs on Reinforced Gusset Plate flat as shown.
- Center Reinforced Gusset Plates across joined units in frame dado. Make sure units are flat to work surface before attaching Gusset Plate.
- Fasten Reinforced Gusset Plates using eight (8) #8 x 9/16” pan head screws (not included).

9. Apply Vertical Exterior Snap-On Trim

- Measure and cut vertical Exterior Snap-On Trim to fit from top edge to bottom edge of joined units.

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</tr>
</tbody>
</table>

- Clean and prepare inside surface of Exterior Snap-On Trim and exterior surface of jambs where Exterior Snap-On Trim will be applied. An adhesion promoter or liquid surface deglosser is required. Apply as shown.
9. Apply Vertical Exterior Snap-On Trim (Continued)

- Apply two, 1/4" minimum diameter, continuous beads of sealant to back side of *Exterior Snap-On Trim* as shown.
- Insert *Exterior Snap-On Trim* into space between joined units and snap into position against unit frames.
- Repeat for all vertical *Exterior Trim Strips*.
- Clean sealant squeeze out from exterior.
10. Apply Sealant

- Apply sealant to completely fill void between joined units.
- Joined units are now ready for installation. Please refer to unit installation guide. If unit is being transported to a job site, proceed to **Step 11. Apply Interior Trim Strip** (sold separately) after unit has been installed and trimmed out.
- Proceed to full width drip cap application step in the unit installation guide for full width drip cap, flashing and insulation steps.

11. Apply Skid to Sill (Units Being Transported Only)

- If joined units are being transported to a job site, apply a 2" x 4" skid to head and sill using 2-1/4" (maximum) screws for protection. Remove 2" x 4" skids before installing units.