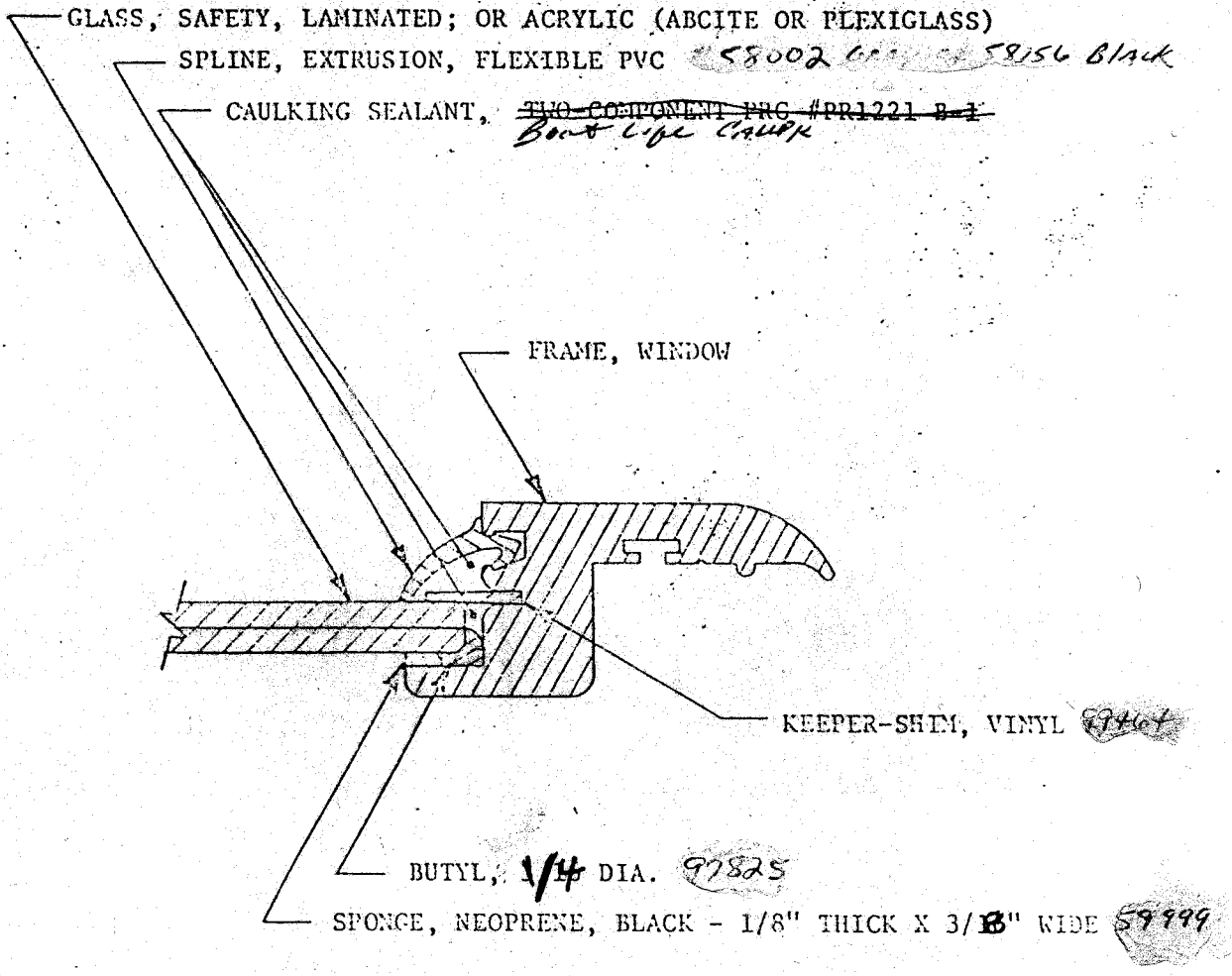
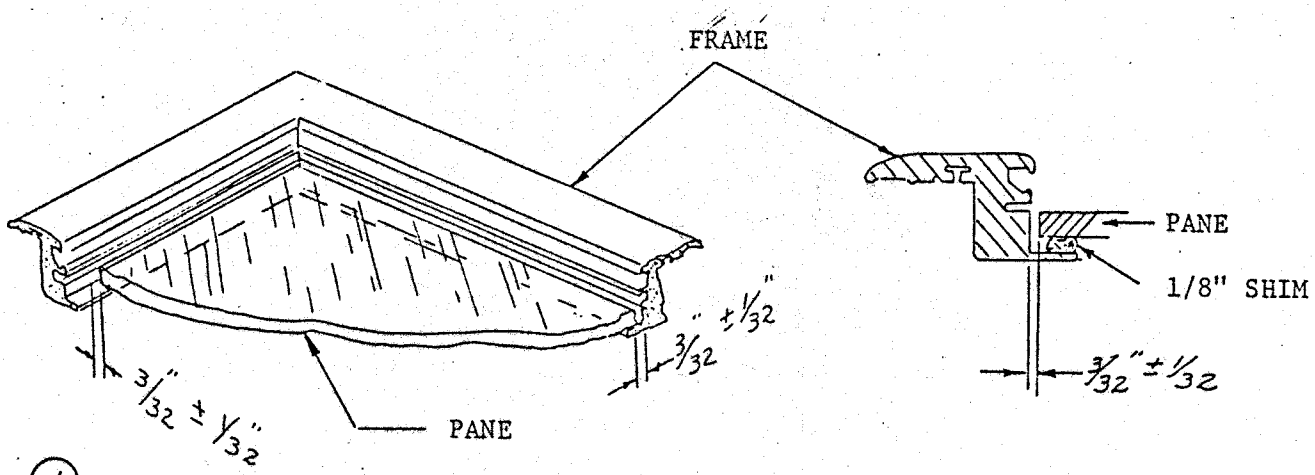
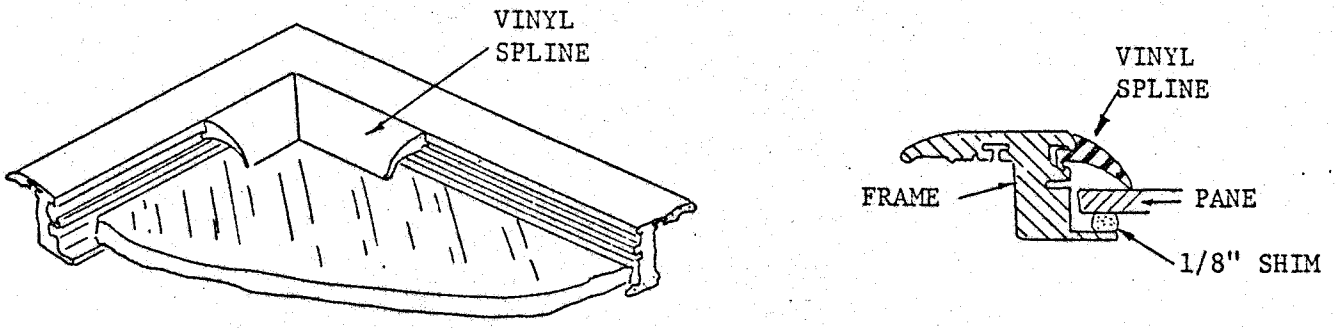

GLASS, SAFETY, LAMINATED; OR ACRYLIC (ABCITE OR PLEXIGLASS)
SPLINE, EXTRUSION, FLEXIBLE PVC 58002 58156 Black
CAULKING SEALANT, ~~TWO-COMPONENT PRC #PR1221 B-1~~ Boot Tape Caulk
FRAME, WINDOW
KEEPER-SHIM, VINYL 59464
BUTYL, 1/4 DIA. 97825
SPONGE, NEOPRENE, BLACK - 1/8" THICK X 3/8" WIDE 59999



(1)

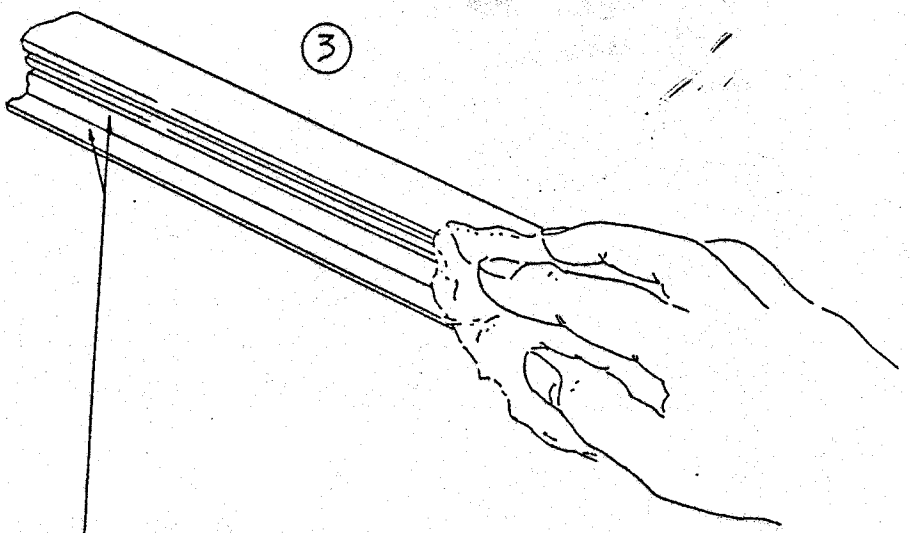
Place 1/8" soft shims along flange to prevent scratching pane. Cut window pane to fit frame. Allow 3/32" clearance between pane and frame. Flat grind and seam edges.

CAUTION: ALWAYS USE VACUUM SUCTION CUPS TO HANDLE PANE, WHERE POSSIBLE.



(2)

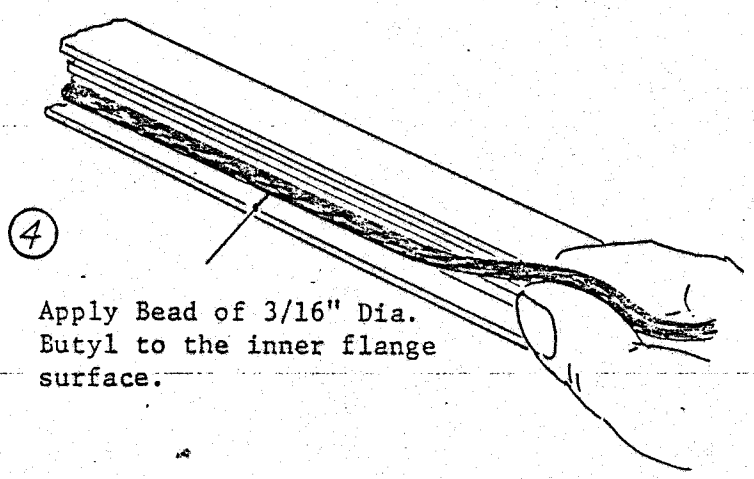
Cut vinyl spline to fit frame. Oversize 1/8" per ft. of length to allow for shrinkage of vinyl. Check miter joints for snug fit. Cut (4)- 1/8" wide sections of vinyl to be used later for Heat-Welding joints.



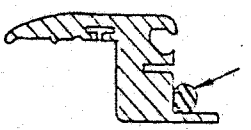
FIRST, Clean Frame with 1,1,1 - Trichloroethane. Wipe off excess.
SECOND, Clean Frame again, this time with denatured alcohol. Wipe with clean dry cloth.

CAUTION

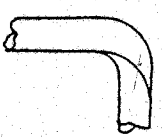
DO NOT TOUCH FLANGE OF FRAME WITH FINGERS AFTER CLEANING OR BUTYL WILL NOT ADHERE TO THE SURFACE



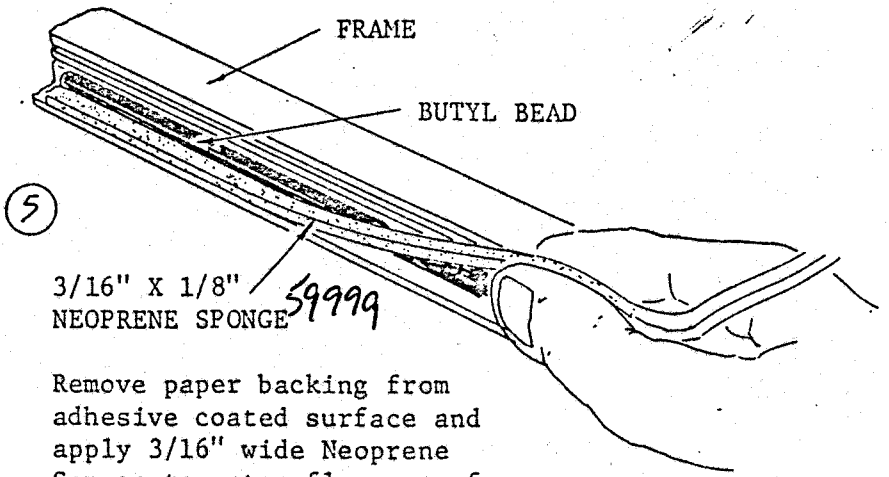
Apply Bead of 3/16" Dia. Butyl to the inner flange surface.

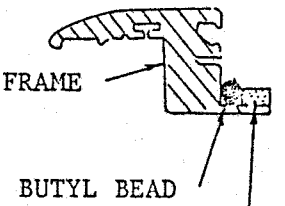


NOTE: Join successive beads using scarf joint.



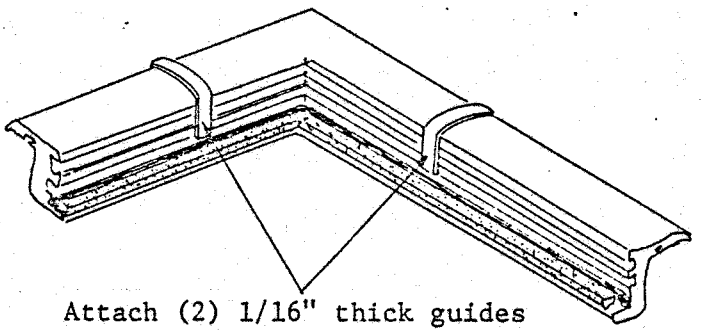
(5)





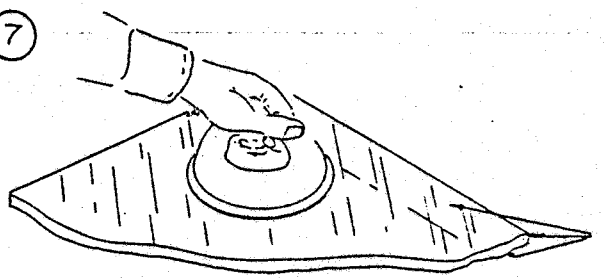
Remove paper backing from adhesive coated surface and apply 3/16" wide Neoprene Sponge to outer flange surface.

(6)



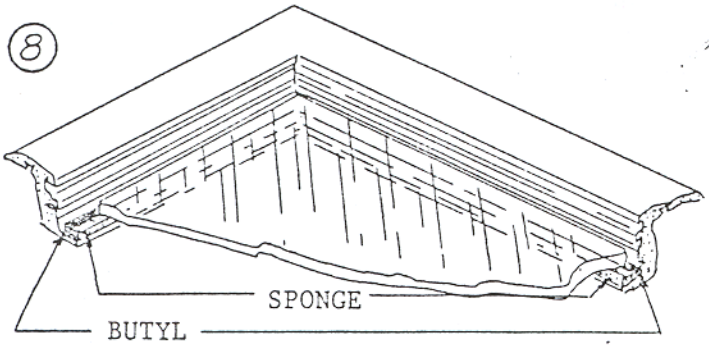
Attach (2) 1/16" thick guides to each corner of frame

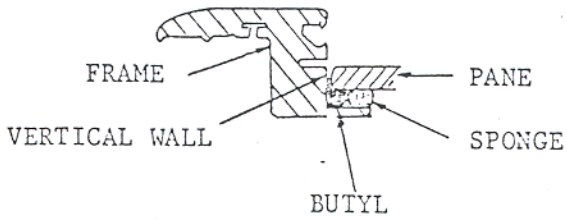
(7)



Clean pane with alcohol on both sides (Approx 2" from edge) and edge. DO NOT TOUCH SURFACE OF PANE WITH FINGERS AFTER CLEANING.

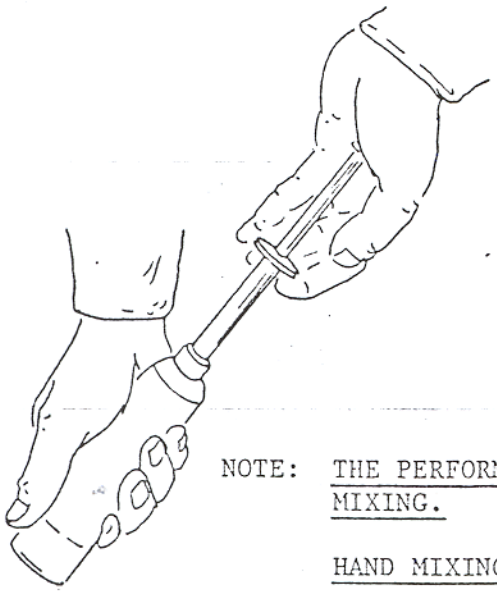
(8)





Carefully lower pane into frame making contact with Butyl. Check alignment of pane with frame for proper 1/16 - 1/8" clearance. Then apply gentle pressure along edge of pane, forcing the Butyl to "Wet" the pane and flow into and fill the space between the Neoprene Sponge and the vertical wall of the frame. The pane is to make contact with the sponge along entire surface of sponge. Damp wipe pane with alcohol, but do not puddle or allow solvent to contact Butyl. Remove guides from corners.

(9)



Mix 2 Part Polysulfide Sealant
(PR-1221 B1 Semkit, PRC Corp.)
Instructions on Kit.

CAUTION

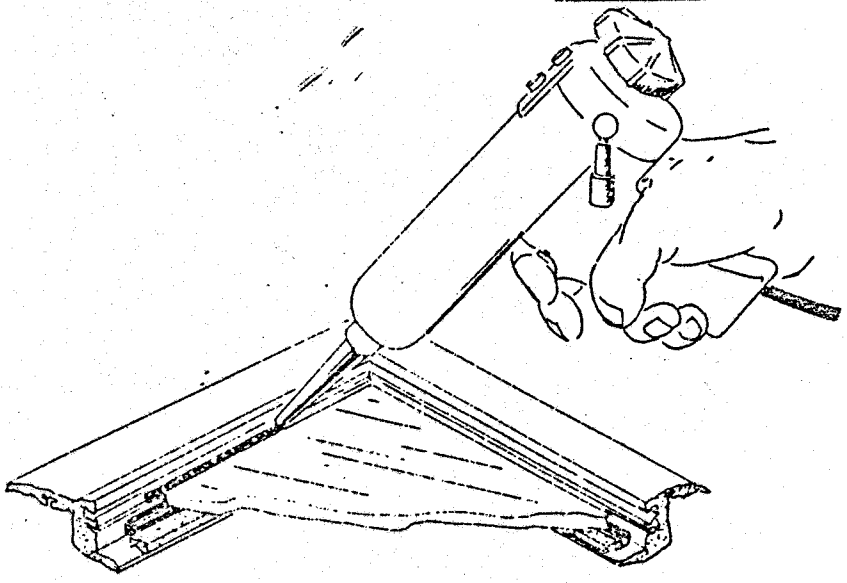
This material has the "B1" designation meaning that, once mixed, it will begin to setup in one hour. Step 13 MUST be completed one hour from the time mixing in Step 9 has begun.

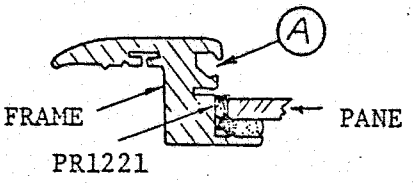
NOTE: THE PERFORMANCE OF THIS SEALANT DEPENDS UPON THOROUGH MIXING.

HAND MIXING: To assure adequate mixing, exceed the recommended number of strokes (50) such that the mixed material leaves the cartridge as a uniform brown material (no streaks).

MACHINE MIXING: To assure adequate mixing, machine mix a minimum of four (4) minutes with a minimum of 50 strokes per cartridge.

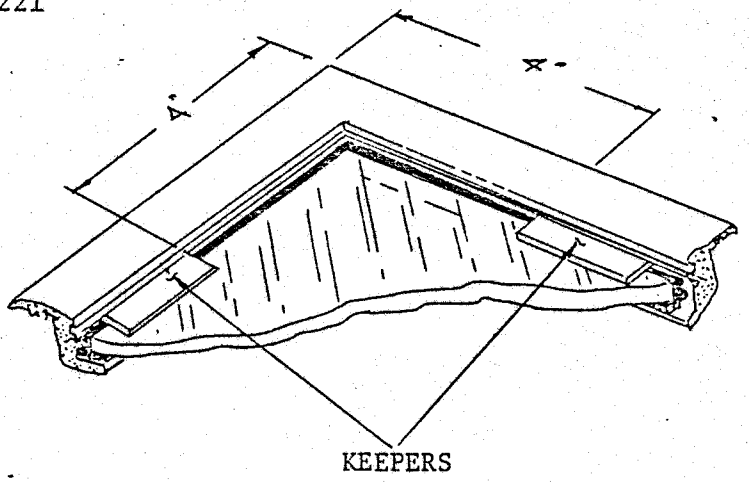
(10)



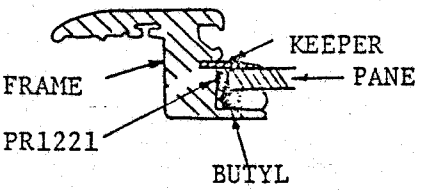


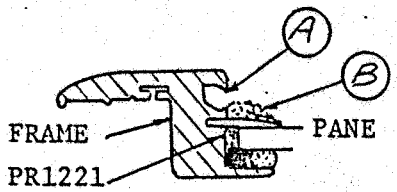
Fill gap between pane and frame with PR-1221: CAUTION DO NOT ALLOW PR-1221 TO ENTER GROOVE FOR SPLINE (A)

(11)



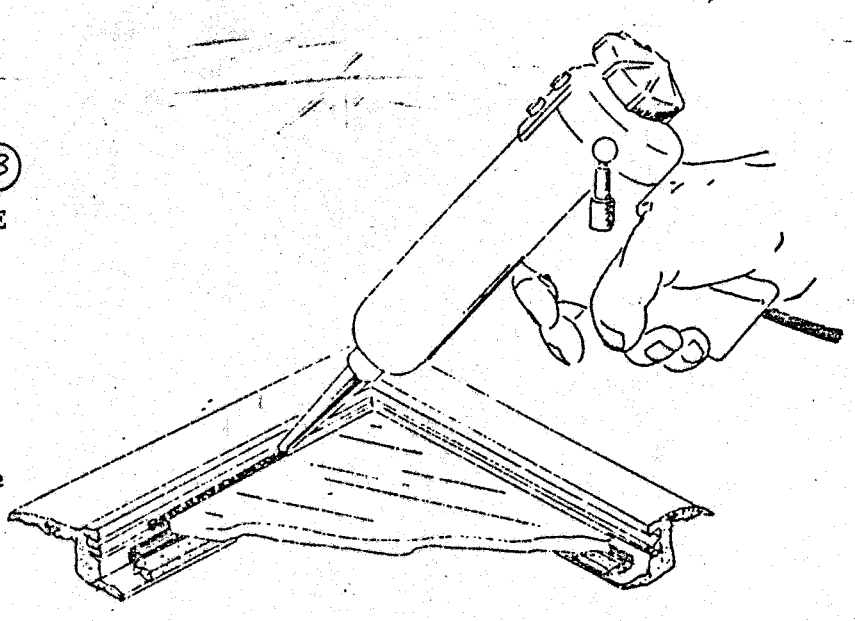
Insert Keeper (Vinyl Shim) 4" from corner. Each corner to have two Keepers.

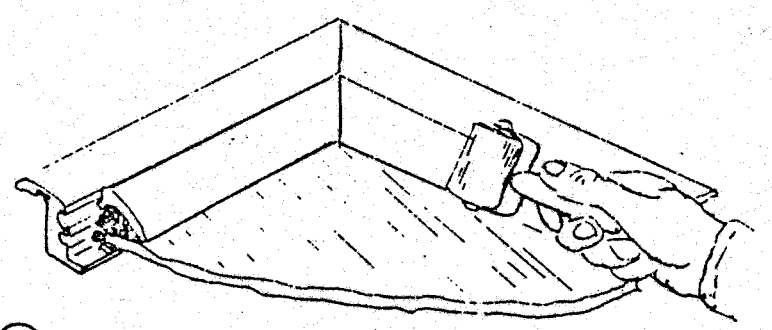


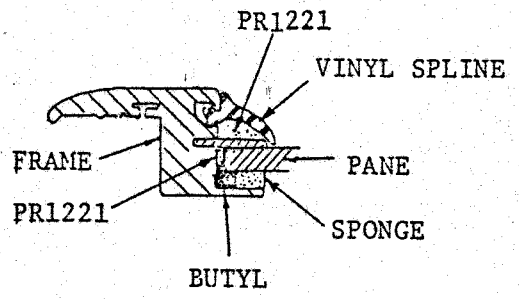


DETAIL C

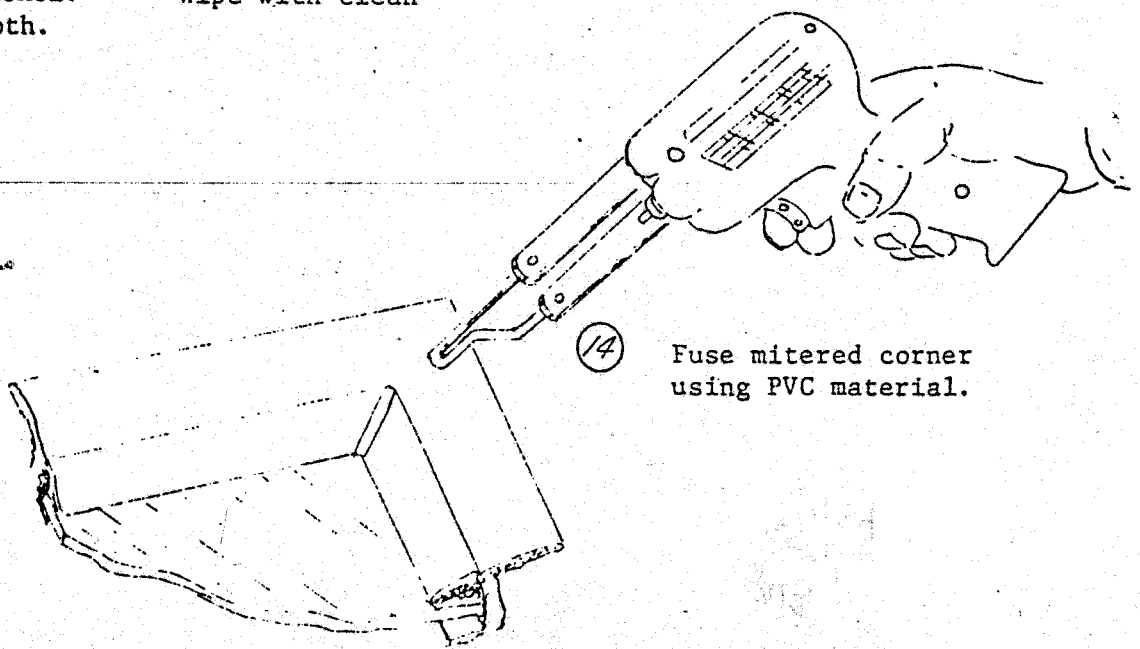
(12) Fill in Area (B) Detail C approx. 3/8" on glass keeping PR1221 out of, but aligned with, spline groove (A).







(13) Reinstall spline and roll out excess PR1221. Clean up excess first with 1, 1, 1 - Trichloroethane, followed by alcohol. Wipe with clean dry cloth.



(14) Fuse mitered corner using PVC material.