



Window Installation Guide

Tools & Materials

- Installation anchor straps (provided)
- Safety glasses
- Hearing protection
- Power drill with bits 1/4" and 3/8" (if installing through frame).
- Fasteners for wood or Tapcon (for through frame installation).
- Caulking/sealant
- Low expanding foam
- Flashing material
- Weather-resistant barrier
- Level
- Soft rubber hammer
- Tape measure
- Pencil
- Shims/blocks
- Putty knife

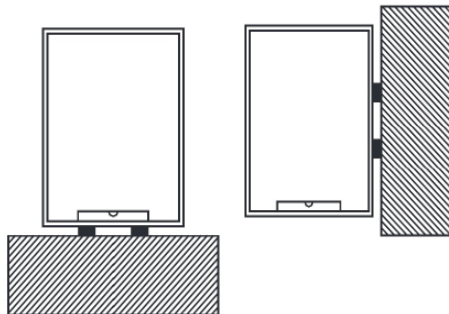
Installation

Frame Installation

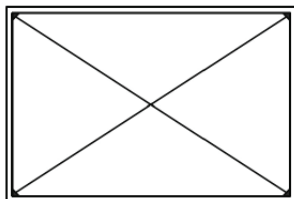
- Frame out opening with framing boards with pressure treated lumber. Slope the bottom of the framed opening toward the exterior, so that water can drain to the outside.
- Check opening for square and plumb. Rough opening should be approximately 3/4" larger than finished window size.
- Caution: Correct installation of the proper type of flashing to the opening is critical to maintaining the weather resistant barrier. Please follow the flashing manufacturer's recommended method for flashing installation.

- Remove the sash prior to window frame installation. See Sash Removal instruction

- Center window in opening. Level sill. **(This is vital to proper functioning of the unit!)** Shim sill 4 to 6 inches from each jamb.



- Verify unit is plumb and level

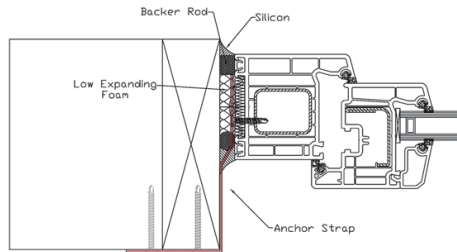


Mounting Methods

SPC Tilt N Turn can be secured to the foundation frame in two manners. Anchor straps (provided) are attached to the window frame and then secured. The alternative method is to install the window by screws through the vinyl and first wall of steel.

Anchor Straps

Anchor straps should be 6" in from top and bottom of inside frame corner on the jambs. Additional straps should be installed no more than 18" apart. Strap anchors are made of durable galvanized steel and are designed specifically for our windows.



Anchor mount installation into wood stud

The prongs are easily inserted into the wide groove channel on the edge of the frame, then turned clockwise 90 degrees to gently lock them into position.

Straps will face the inside of the installation. Anchor straps can be trimmed or bent over edge of the rough opening. Gently bend the strap so they lie flat against the sides of the wall. Secure anchor straps to the wall with fastening screws.

Place sealant under each anchor clip before driving a screw through the anchor strap.

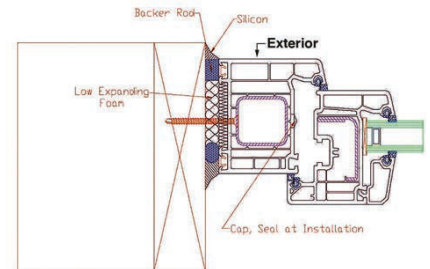
The use of anchor straps allows for mounting the window frame without penetrating the framing material.

Strap anchors provide the ability to absorb building movement, offering a small amount of flexibility, providing structural integrity.

Screw Mounting

WARNING: Screwing into the frame can leave the window vulnerable to water infiltration.

Pre-drill 3/8" holes through the vinyl and first wall of steel. When doing so, please keep in mind that there is steel inside the frame and sash. Holes should be 6" in from top and bottom of inside frame corner on the jambs. Additional holes should be drilled no more than 18" apart.



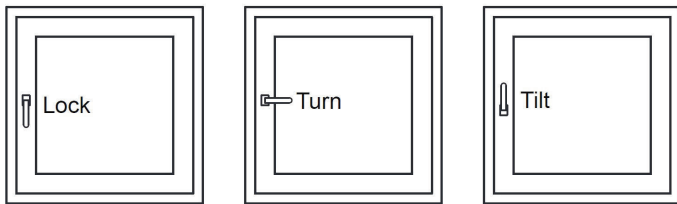
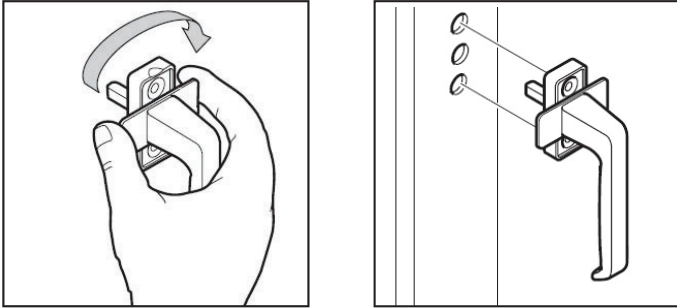
Screw mount installation into wood stud

With holes pre-drill, anchor the units through pre-drilled holes with appropriate fasteners for rough opening conditions (4-inch minimum screws for wood, Tapcon for masonry or block).

Handle Installation

Before installing handle, test the operation. Never force handle! Excessive force can damage hardware. If installation was performed correctly, the window hardware should operate smoothly.

- Place handle in down (lock) position.
- Insert handle spindle into sash handle hole and turn handle and beauty cover 90° (turn position) to access screw holes.
- Install screws. Be careful to not over tighten.
- Turn beauty cover back into position.

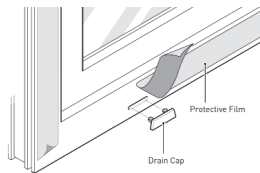


Operate Window

- Operate the sash to make sure it operates smoothly.
- If it does not operate smoothly, check unit for plumb, level and square. Make adjustments as necessary.
- To prevent the sash from rubbing against the frame, adjust cams and hinges as required.
- Install hinge covers provided in hardware package.

Weep (Drain) Holes

- Take note to not block weep holes during installation
- Drain caps are provided with accessories and must be installed in the field.



Install Hinge Beauty Caps

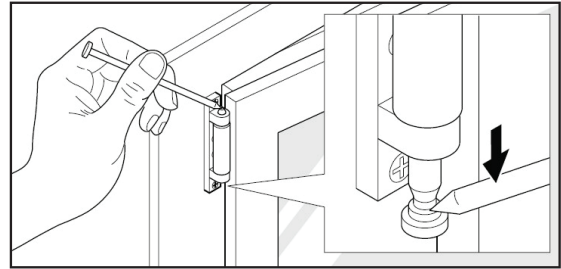
- Slide Upper Hinge Cap and Upper Band Cap onto the top hinge
- Slide Lower Band Cap and Lower Pivot Cap onto the bottom hinge



Online
Instructions

Insulate and Caulk

- Once the window is level and secured, use a low-pressure polyurethane window and door insulating foam sealant to create an interior seal around all 4 sides of the window.
- CAUTION: Over-insulating can affect operation of the window.
- CAUTION: Under-insulating can affect thermal performance of the window.
- Insert backer rod to exterior gap between window and framing.
- Then tape the window header by extending beyond the horizontal strips by 1" on each side.
- After the placement of siding or trim, apply a continuous bead of sealant around the window. Shape and clean any excess sealant.



Sash Removal

Depending upon the size of the sash, the assistance of a second installer may be required. (Please be aware that all sash and frames are steel reinforced.)

- Remove the Upper Hinge Beauty Cap
- Push in the release and pull pin down until pin clicks at lowest point (Fig. A).
- Tilt sash towards you.
- Lift sash up and off of lower pin.
- Place sash in safe place and mark sash so it is reinstalled to the correct frame!



Fig. A

Reinstall Sash (If removed)

- Install sash onto lower hinge pin. Ensure sash is in the "Turn" position.
- Set sash into the frame, connecting the hinge (Fig. B).
- Push the pin into the hinge.
- Once pin is in place, close the window and turn the handle to the "lock" position.



Fig. B



ASTM E 2112-01 Standard Practice for
Installation of Exterior Windows, Doors and
Skylights.

ASTM INTERNATIONAL

It is the responsibility of the installer and/or owner to prepare openings (barrier and flashing as required) as well as adhere to local/state/regional codes and practices.