

# 3/4" LVL Reinforced Joining Guide (1-Way Horizontal or Vertical Joining)

for Andersen® 400/200 Series Casement, Awning, Picture, and  
400 Series Flexiframe® 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

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

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 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® 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.

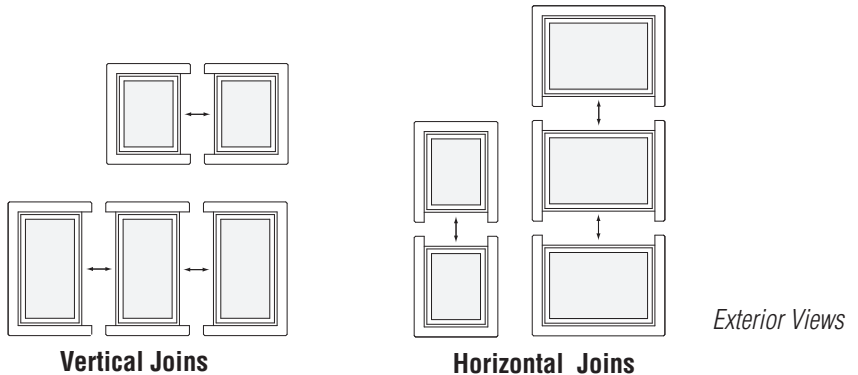
**⚠ WARNING**

Metal fasteners and components may corrode when exposed to preservative-treated and/or fire-retardant treated lumber. Obtain and use the appropriate metal fasteners and hardware as called out by the installation guide to fasten unit to any rough opening made from preservative-treated and fire-retardant treated lumber. Failure to use the appropriate materials for the installation may cause a failure resulting in injury, property or product damage.

**NOTICE**

- Use this guide to join two or more units either horizontally or vertically.

Flanges shown removed at sides being joined.



**Parts Included**

- (1) Instruction Guide
- (2) Gusset Plates
- (1) 3/4" LVL Joining Strip (4-9/16" or 6-9/16" wall construction)
- (1) Exterior Trim Strip
- (1) Installation Screw Pack

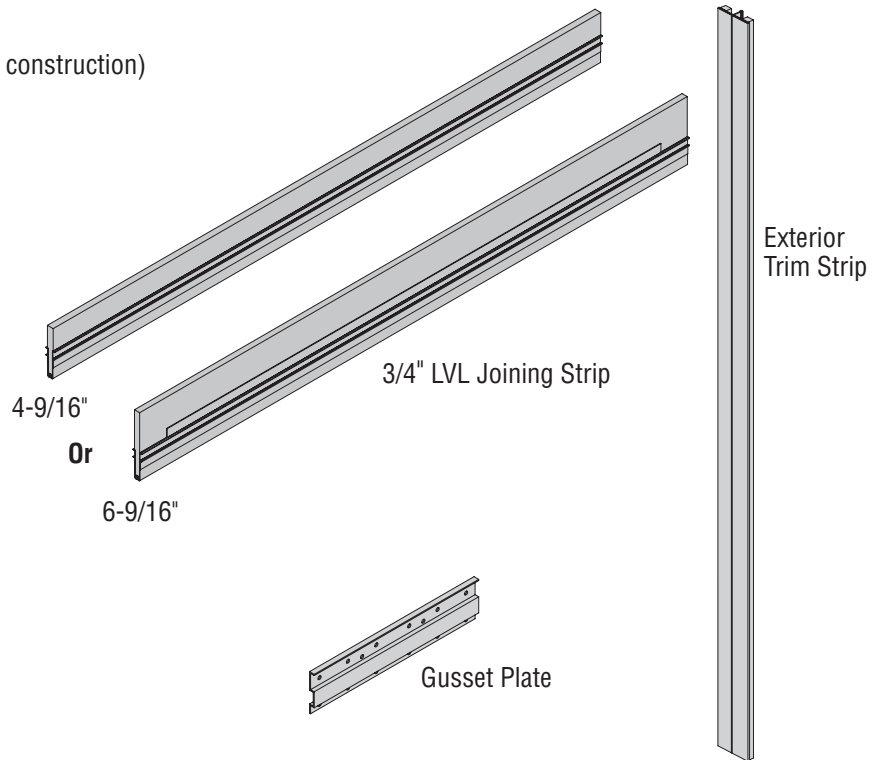
**Additional Parts Required (Sold Separately)**

- Drip Cap (full width)

**Tools and Supplies**

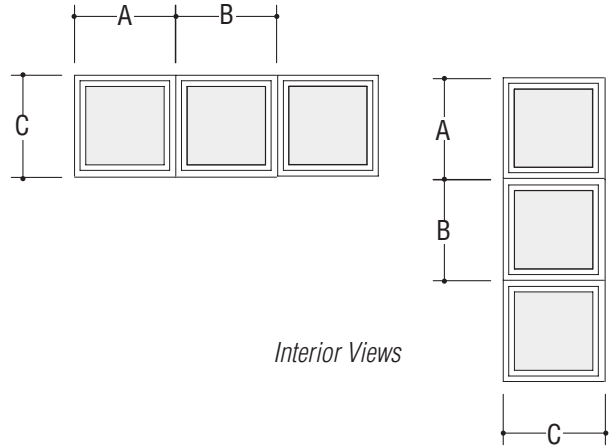
- Safety Glasses
- Tape Measure
- Pencil
- Level
- Hammer
- Deep Jaw Clamps
- Utility knife
- Power Drill
- Caulk Gun
- Sealant
- Side Cutter/Pliers
- Small Pry Bar
- Wood Shims
- Power Saw
- Backer Rod
- 3/32" Drill Bit
- #2 Phillips Bit
- 4d Finish Nails
- Wood Block
- Isopropyl Alcohol

**Component Identification**



### 1. Verify LVL is Adequate for Your Installation

- Calculate average adjacent unit dimension  $((A + B) \div 2)$ .
- Determine the mullion length (C).
- Use Wind Load chart below to cross reference the average adjacent unit dimension with the mullion length to determine the Wind Load performance of your combination.
- Make sure performance is adequate for your installation requirements.
- Refer to Combination Design section in the *Andersen® Product Guide* for further information.



**Design Wind Load PSF Table for 3/4" LVL Reinforced Joining**  
 For Combining: Casement, Awning, Picture, and Flexiframe® Windows

Type of Combination: 1-Way, 4-9/16" wall construction

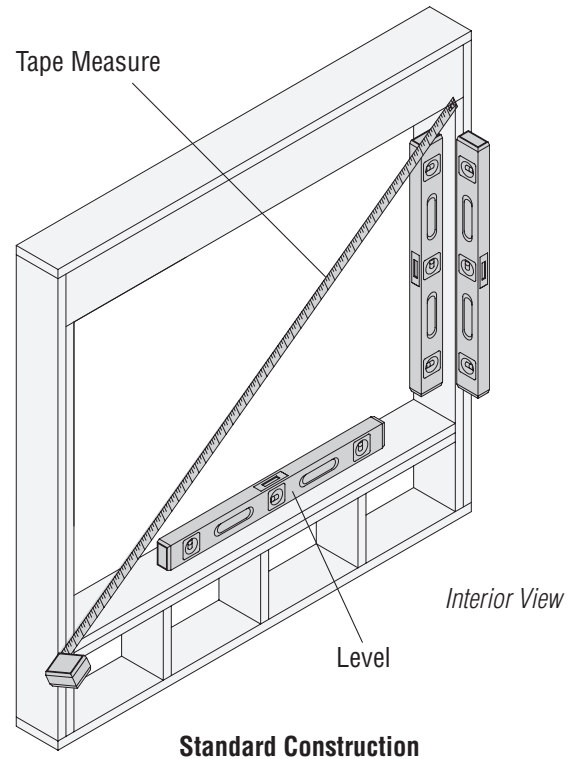
AVERAGE ADJACENT UNIT DIMENSION	$(A + B) \div 2 = 6' 1"$	82	70
	$(A + B) \div 2 = 5' 6"$	82	71
	$(A + B) \div 2 = 5' 1"$	82	72
	$(A + B) \div 2 = 4' 6"$	82	75
	$(A + B) \div 2 = 4' 1"$	82	79
	$(A + B) \div 2 = 3' 6"$	82	82
	$(A + B) \div 2 = 3' 1"$	82	82
	$(A + B) \div 2 = 2' 6"$	82	82
	$(A + B) \div 2 = 2' 1"$	82	82
	$(A + B) \div 2 = 1' 6"$	82	82
<b>C = (mullion length)</b>	<b>5'6" or less</b>	<b>6'1"</b>	

Type of Combination: 1-Way, 6-9/16" wall construction

AVERAGE ADJACENT UNIT DIMENSION	$(A + B) \div 2 = 10' 1"$	82	75	63	56	48	44	37	31	24
	$(A + B) \div 2 = 9' 6"$	82	75	63	56	48	44	37	31	24
	$(A + B) \div 2 = 9' 1"$	82	75	63	56	48	44	37	31	24
	$(A + B) \div 2 = 8' 6"$	82	75	63	56	48	44	37	31	25
	$(A + B) \div 2 = 8' 1"$	82	75	63	56	48	44	37	31	25
	$(A + B) \div 2 = 7' 6"$	82	75	63	56	48	44	38	32	26
	$(A + B) \div 2 = 7' 1"$	82	75	63	56	49	45	39	33	26
	$(A + B) \div 2 = 6' 6"$	82	75	63	57	50	46	40	34	28
	$(A + B) \div 2 = 6' 1"$	82	75	64	58	51	47	41	35	29
	$(A + B) \div 2 = 5' 6"$	82	77	66	60	54	50	44	37	30
	$(A + B) \div 2 = 5' 1"$	82	79	68	63	56	52	46	39	32
	$(A + B) \div 2 = 4' 6"$	82	82	73	67	60	56	50	43	35
	$(A + B) \div 2 = 4' 1"$	82	82	77	71	64	60	53	46	38
	$(A + B) \div 2 = 3' 6"$	82	82	82	79	71	67	60	51	42
	$(A + B) \div 2 = 3' 1"$	82	82	82	82	78	74	66	57	47
	$(A + B) \div 2 = 2' 6"$	82	82	82	82	82	82	78	68	56
$(A + B) \div 2 = 2' 1"$	82	82	82	82	82	82	82	79	66	
$(A + B) \div 2 = 1' 6"$	82	82	82	82	82	82	82	82	82	
<b>C = (mullion length)</b>	<b>6'1" or less</b>	<b>6'6"</b>	<b>7'1"</b>	<b>7'6"</b>	<b>8'1"</b>	<b>8'6"</b>	<b>9'1"</b>	<b>9'6"</b>	<b>10'1"</b>	

## 2. Prepare Rough Opening

- Determine rough opening width for multiple units using the formula: **rough opening width = 3/8" (shim) + total unit width(s) + 3/4" for each join (LVL Joining Strip) + 3/8" (shim)**.
- Determine rough opening height for multiple units using the formula: **rough opening height = 3/8" (shim) + total unit heights + 3/4" for each join (LVL Joining Strip) + 3/8" (shim)**.
- Check rough opening for plumb and level. If rough opening is **not** plumb or level, correct as necessary.
- Check opening for square by measuring diagonally, upper left to lower right and upper right to lower left corner. If measurements are within 1/8", opening is square. If rough opening is **not** square, correct as necessary.



## 3. Prepare Units

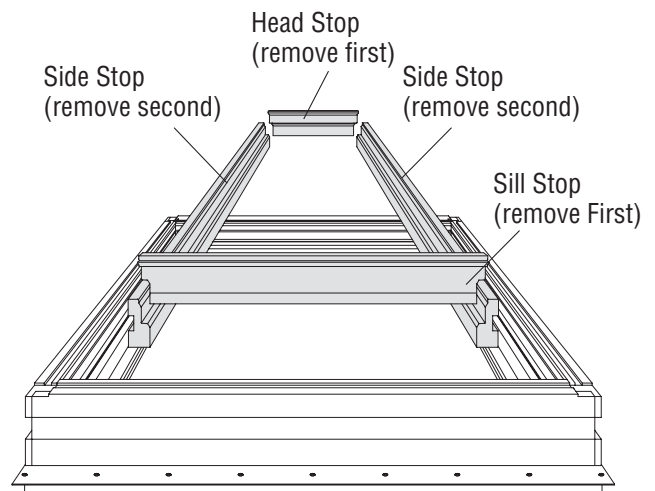
- Place units interior side up on a clean, flat work surface.
- For extension jamb application see Step 20.

## 4. Remove Inside Stops

### CAUTION

Side Stop on lock side of tandem lock Casement Units has an underlying Lock Mechanism. Use caution when removing Side Stop on lock side to avoid damage to Lock Mechanism and/or Side Stop.

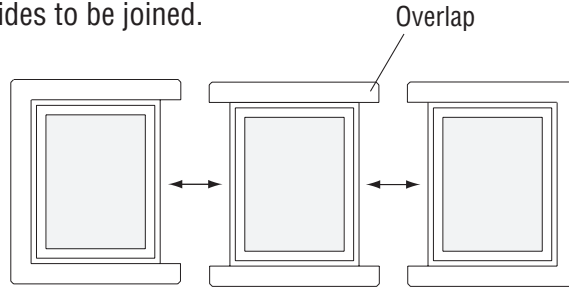
- Remove all *Inside Stop* nails using a hammer and wood block.
- Remove head and sill *Inside Stops* before side *Inside Stops*. Insert a small pry bar between frame and stops and gently pry outwards.



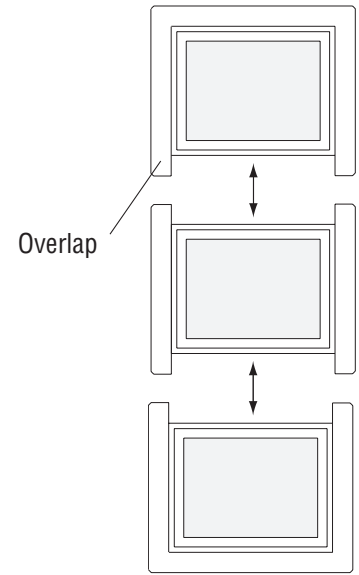
Interior Side Up

## 5. Prepare Flanges

- For **Casement/Awning/Picture Units**, cut *Installation Flange(s)* on head, sill, or sides to be joined, as appropriate for joined combination. See diagram. Cut *Installation Flange* flush to jamb. For **Horizontal Joins**, leave overlap side *Installation Flanges*. For **Vertical Joins**, leave overlap head and sill *Installation Flanges*.
- For **Flexiframe® Units**, remove *Installation Flange(s)* on head, sill, or sides to be joined.

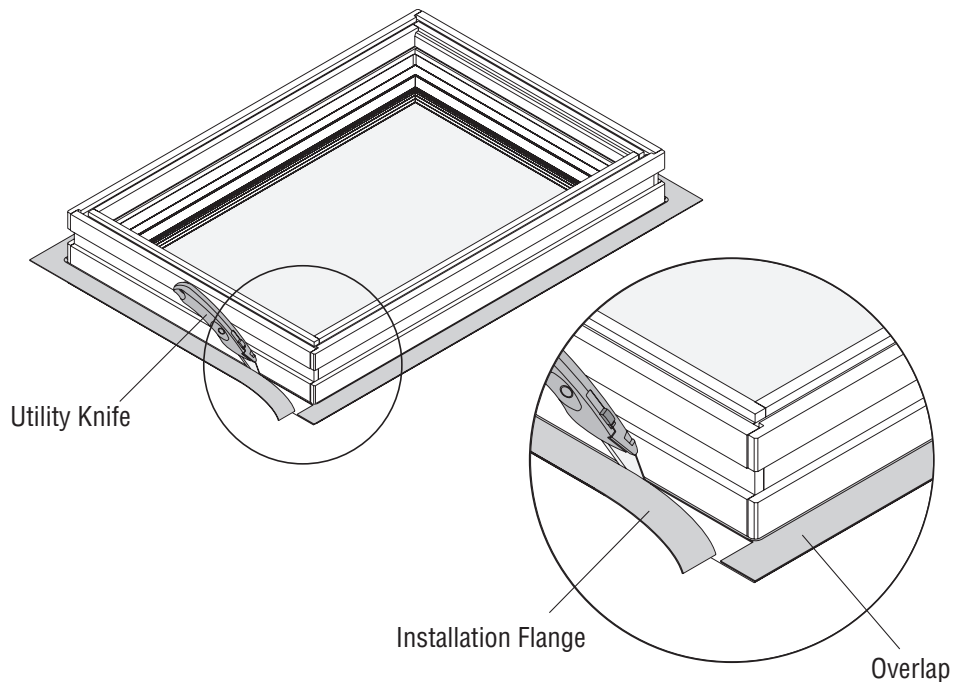


Vertical Joins



Horizontal Joins

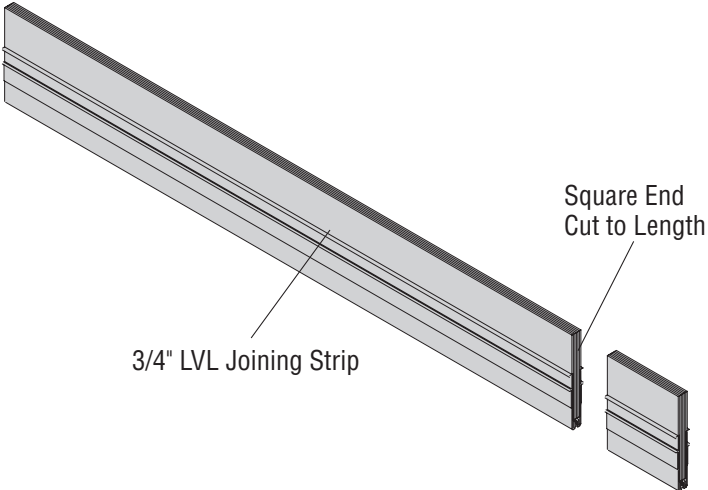
*Exterior Views*



*Interior Side Up*

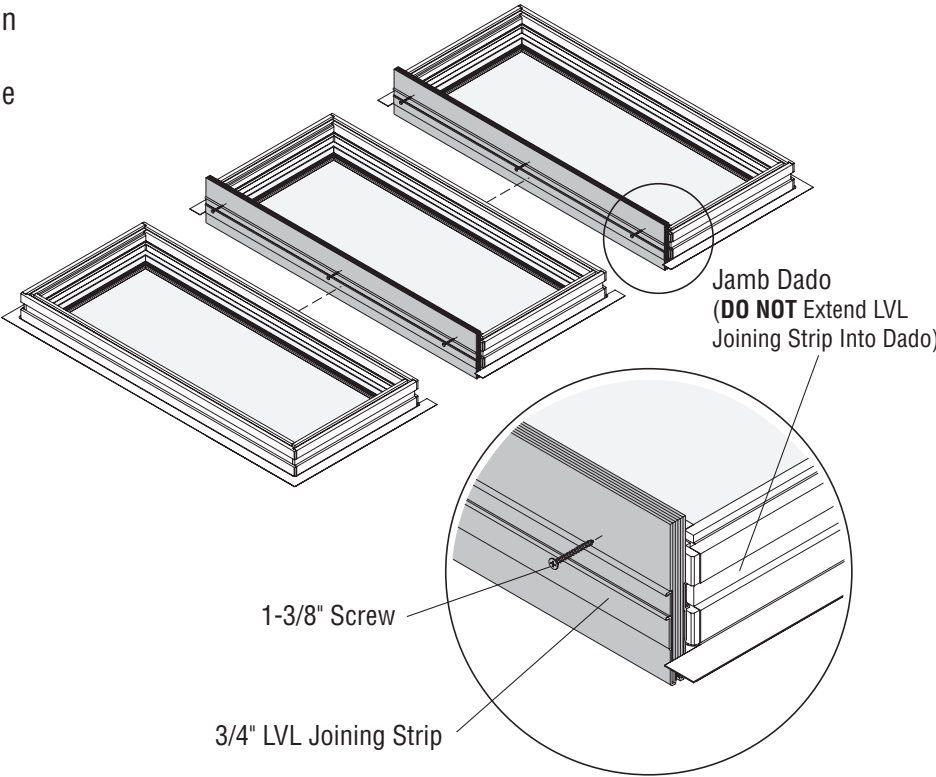
**6. Prepare 3/4" LVL Joining Strip(s)**

- Square end cut 3/4" LVL Joining Strip 5/8" shorter than length of units being joined.



**7. Attach 3/4" LVL Joining Strip**

- Place 3/4" LVL Joining Strip in dado on jamb and center on unit. 3/4" LVL Joining Strip must not extend into side jamb dados.
- Fasten using three 1-3/8" screws located at 1/3 points.



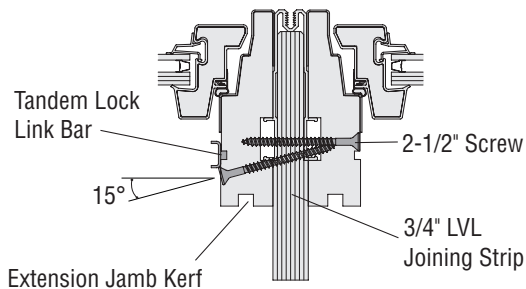
## 8. Join Units

### CAUTION

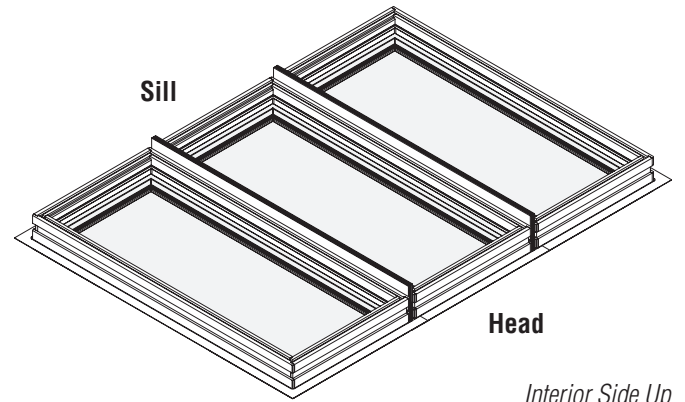
- Exterior nose of units and side jambs must be flush full length. If not flush, there will not be a proper seal and water infiltration may result.
- DO NOT over tighten clamps, excess tightening of clamps may mar surface.
- Upper unit Installation Flange must overlap lower unit Installation Flange to the exterior on horizontal joins. Failure to do so may adversely affect product performance.

### CAUTION

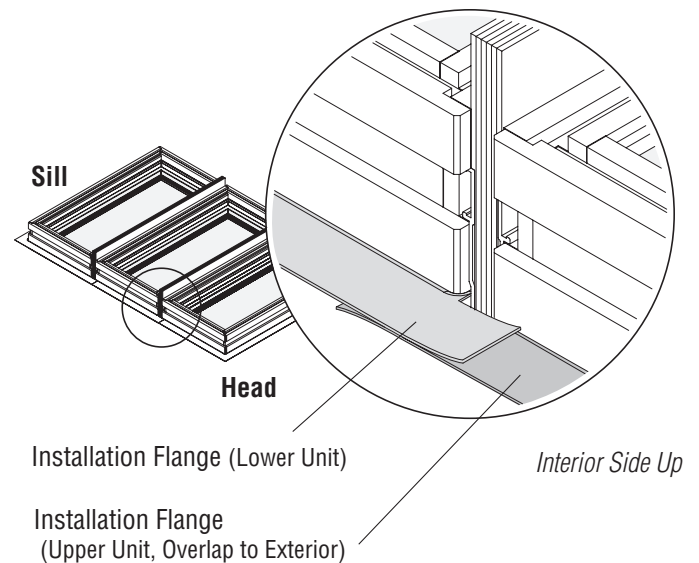
When installing venting units, install 2-1/2" screws to the interior side of Tandem Lock Link Bar. Failure to do so may result in improper function of lock.



- Slide units together. Exterior nose of units and side jambs must be flush full length. For **Horizontally Joined Units**, overlap upper unit *Installation Flange* over lower unit *Installation Flange* to the exterior.



Vertically Joined

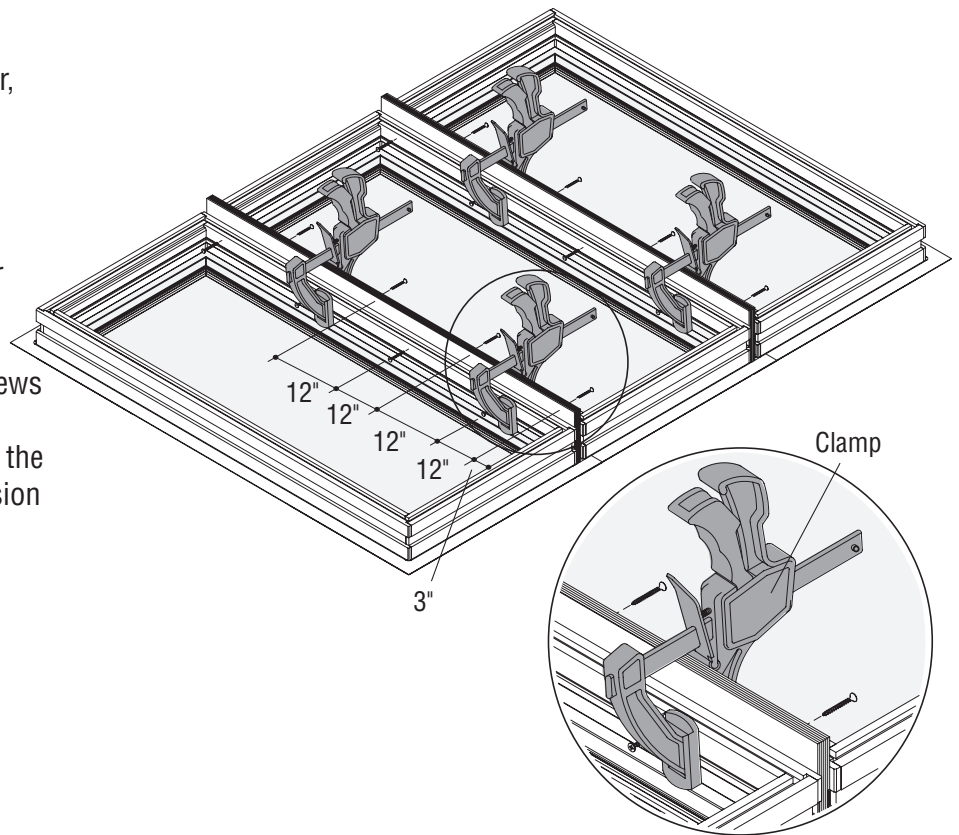


Horizontally Joined



## 8. Join Units (Continued)

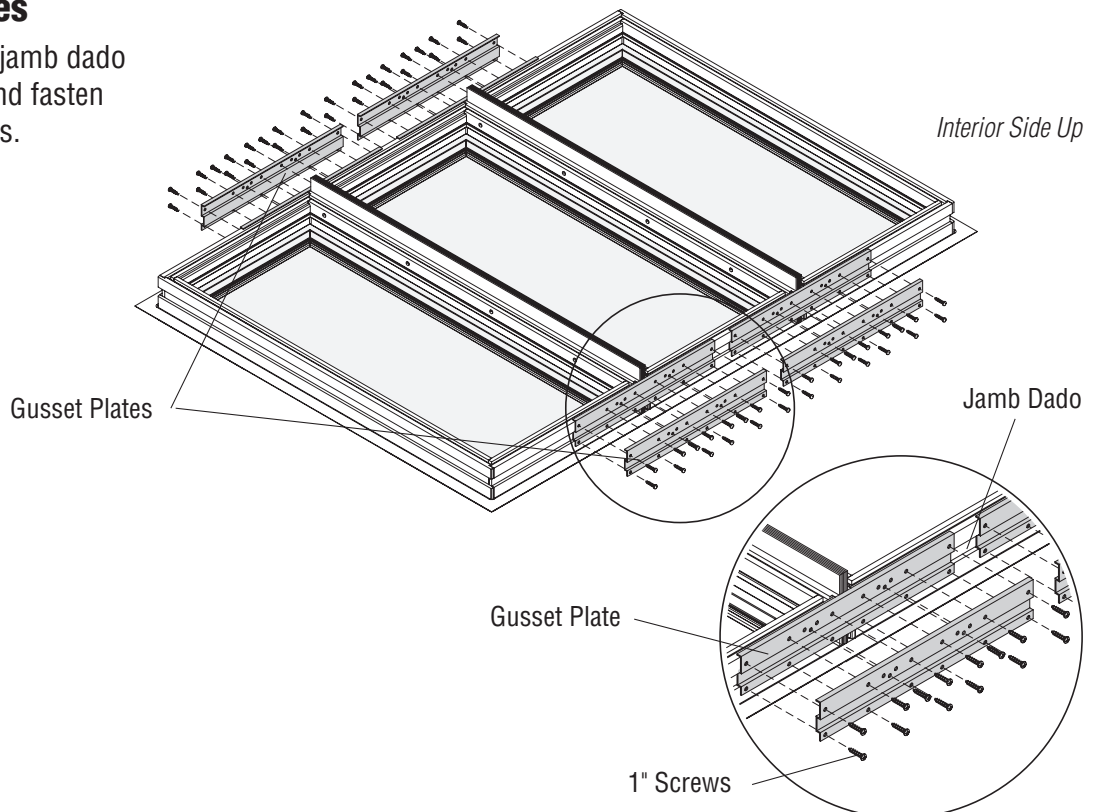
- Clamp units together, from the interior, using two clamps and surface protectors.
- Fasten Unit side jambs to 3/4" LVL Joining Strip using 2-1/2" screws. Locate one screw 3" from each corner and additional screws every 12", alternating between adjacent units. For **Vertical Joins**, avoid locating screws near Tandem Lock Link Bar. Screws must be located to the interior side of the Lock Link Bar at a 15° to avoid extension jamb kerf.
- Repeat **Step 6-8** for remaining joins.



Interior Side Up

## 9. Attach Gusset Plates

- Position *Gusset Plate* in jamb dado centered over unit join and fasten using (14) #8 x 1" Screws.



Interior Side Up



## 10. Apply Trim Strips

### ⚠ WARNING

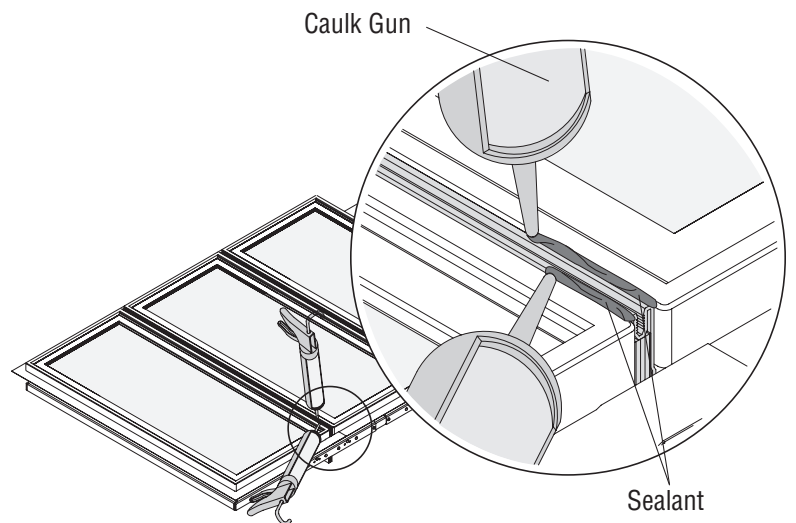
Windows and doors can be heavy. Use safe lifting techniques and a reasonable number of people with enough strength to lift, carry and install window and door products to avoid injury and/or product damage.

- Turn units exterior side up.
- Clean surface of *Trim Strip Receivers* and vinyl surface of unit for proper adhesion using isopropyl alcohol.
- Apply a continuous 1/4" bead of sealant along joins of *Trim Strip Receivers* and jambs.

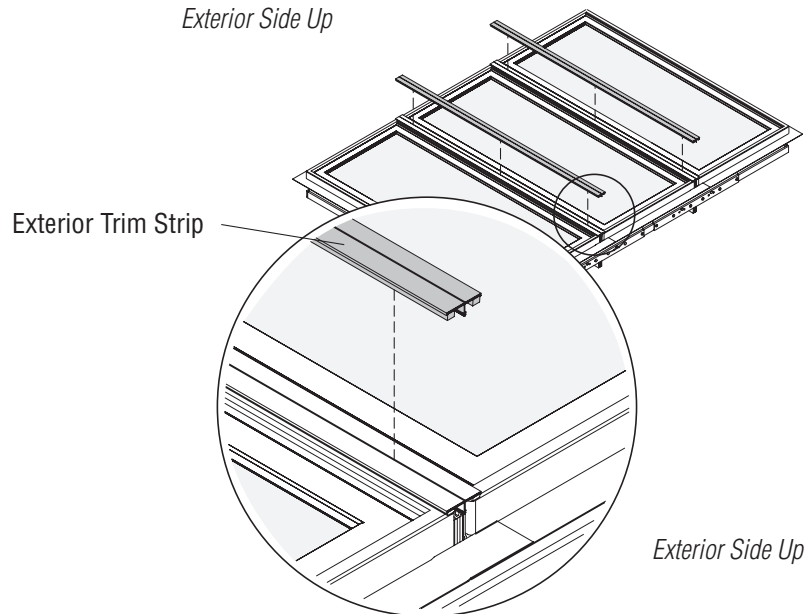
### NOTICE

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

- Position edge of *Exterior Trim Strip* flush with unit edge and press in with thumbs from one end to the other. Pound in place using a hammer and wood block.



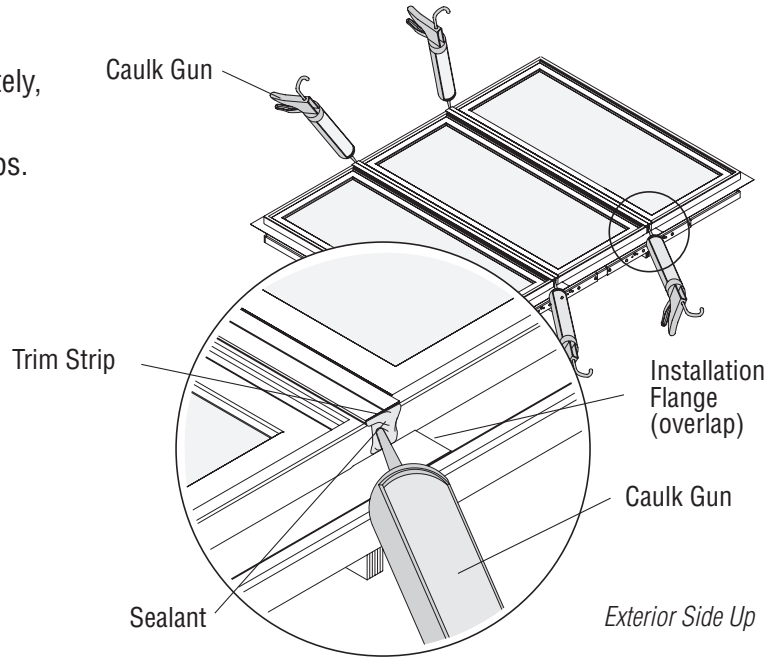
Exterior Side Up



Exterior Side Up

## 11. Apply Sealant

- Apply sealant to ends of *Trim Strip Receivers* filling void on each side of the *Installation Flange* completely, as shown.
- Apply sealant between all *Installation Flange* overlaps.

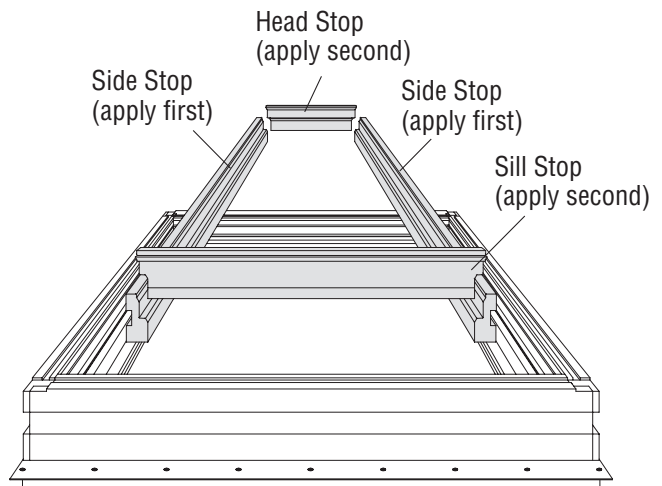


## 12. Reapply Inside Stops

### CAUTION

When reapplying Side Stop on the lock side of tandem lock Casement Units, nail through existing holes. Failure to do so could result in damage to underlying Lock Mechanism.

- Turn units interior side up.
- Position side *Inside Stops* first, then head and sill *Inside Stops* in frame groove and reapply by tacking into place using 1-1/2" (4d) finish nails. Leave approximately 1/8" of nail head exposed to assist in removal of *Inside Stops* when finishing.



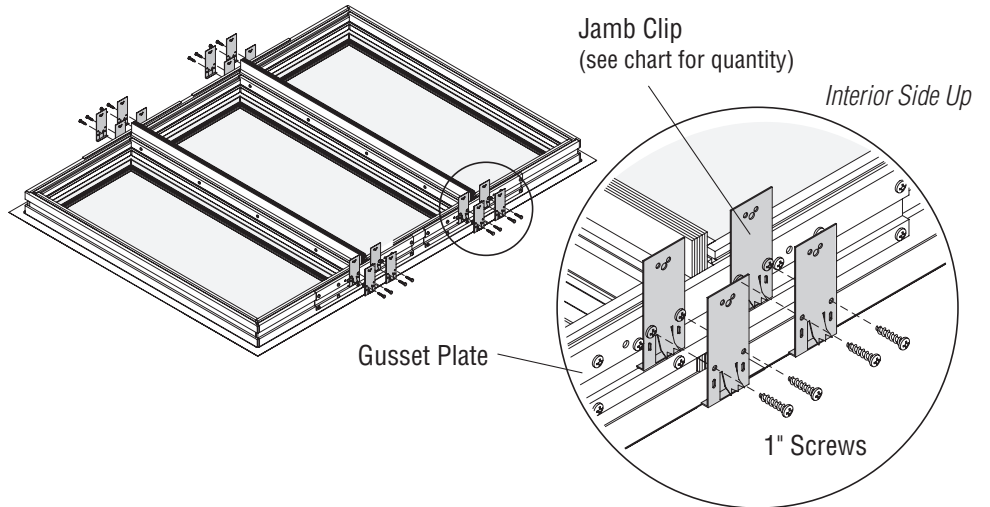
Interior Side Up

### 13. Apply Jamb Clips at Gusset Plates

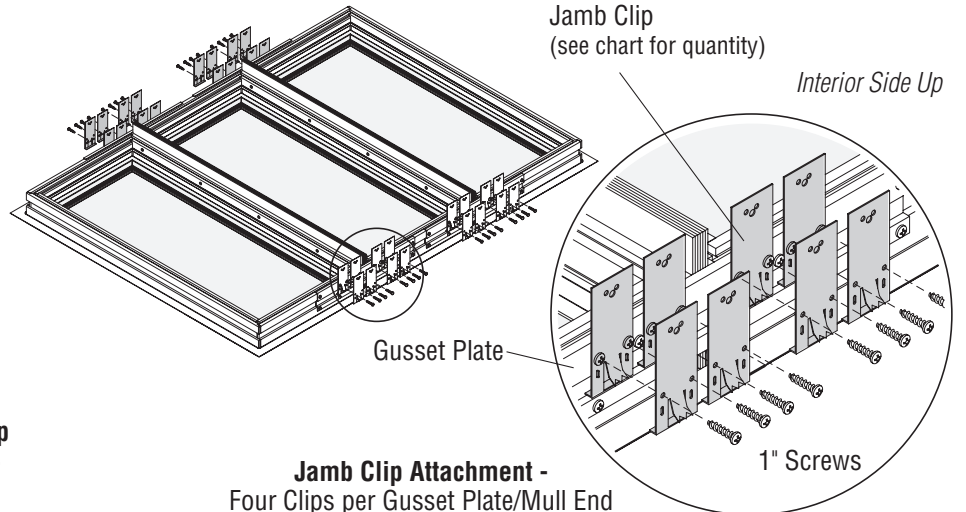
#### CAUTION

Number of Jamb Clips is based on a maximum unit design pressure rating. Use correct number of Jamb Clips. Failure to do so may result in a lower rating.

- Determine number of clips per Gusset Plate using chart below.
- Position *Jamb Clips* in dado at each *Gusset Plate* long leg to interior, extending 1-1/8" above jambs, and fasten using two #8 x 1" screws.



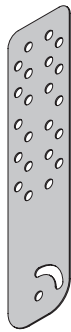
**Jamb Clip Attachment -**  
Two Clips per Gusset Plate



**Jamb Clip Attachment -**  
Four Clips per Gusset Plate/Mull End



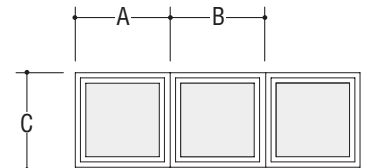
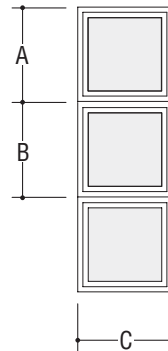
**Standard Jamb Clip**



**Optional Jamb Clip (Sold Separately)**

#### Installation Clip Application at Mull Ends (clips per end)

(A + B) ÷ 2 = 10' 1"	4	4	4	4	4	4	4	4	4	4	4
(A + B) ÷ 2 = 9' 6"	4	4	4	4	4	4	4	4	4	4	4
(A + B) ÷ 2 = 9' 1"	4	4	4	4	4	4	4	4	4	4	4
(A + B) ÷ 2 = 8' 6"	4	4	4	4	4	4	4	4	4	4	4
(A + B) ÷ 2 = 8' 1"	4	4	4	4	4	4	4	4	4	4	4
(A + B) ÷ 2 = 7' 6"	4	4	4	4	4	4	4	4	4	4	4
(A + B) ÷ 2 = 7' 1"	4	4	4	4	4	4	4	4	4	4	4
(A + B) ÷ 2 = 6' 6"	4	4	4	4	4	4	4	4	4	4	4
(A + B) ÷ 2 = 6' 1"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 5' 6"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 5' 1"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 4' 6"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 4' 1"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 3' 6"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 3' 1"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 2' 6"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 2' 1"	2	2	2	2	2	2	4	4	4	4	4
(A + B) ÷ 2 = 1' 6"	2	2	2	2	2	2	2	2	2	2	4
<b>C = (mullion length)</b>	<b>1'1"</b>	<b>1'6"</b>	<b>2'1"</b>	<b>2'6"</b>	<b>3'1"</b>	<b>3'6"</b>	<b>4'1"</b>	<b>4'6"</b>	<b>5'1"</b>	<b>5'6"</b>	<b>6'1" - 10'1"</b>



14. Apply Additional Jamb Clips to Unit Sides Next to Rough Opening

**⚠ WARNING**

A minimum of one clip at head and sill is required for each glass light on single, double, and triple units. Failure to properly anchor using clips will adversely affect design pressure rating, product performance and may result in personal injury, product and/or property damage.

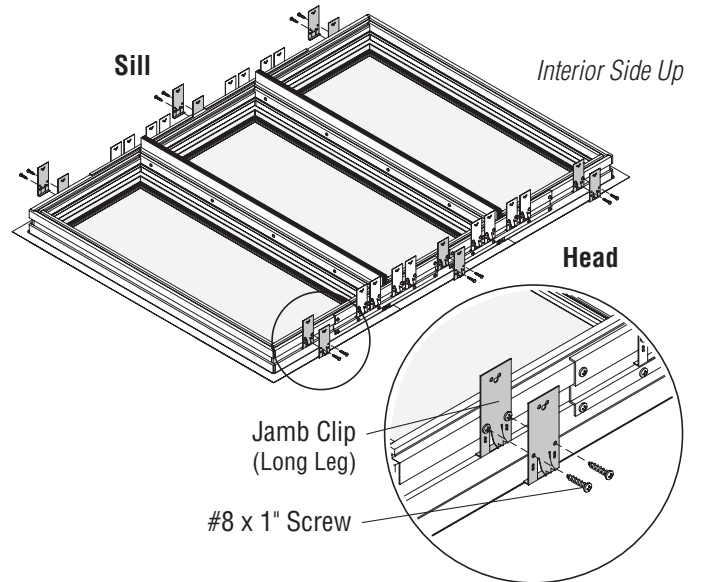
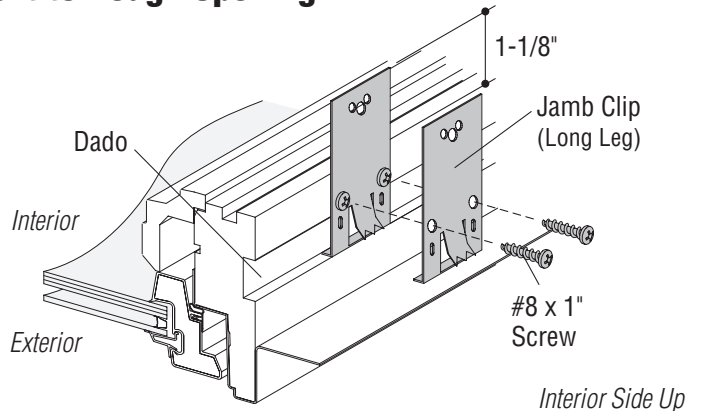
**CAUTION**

Number of Jamb Clips and/or Screws is based on a maximum unit structural performance Design Pressure Rating. Use correct number of Jamb Clips and/or Screws. Failure to do so may result in lower rating.

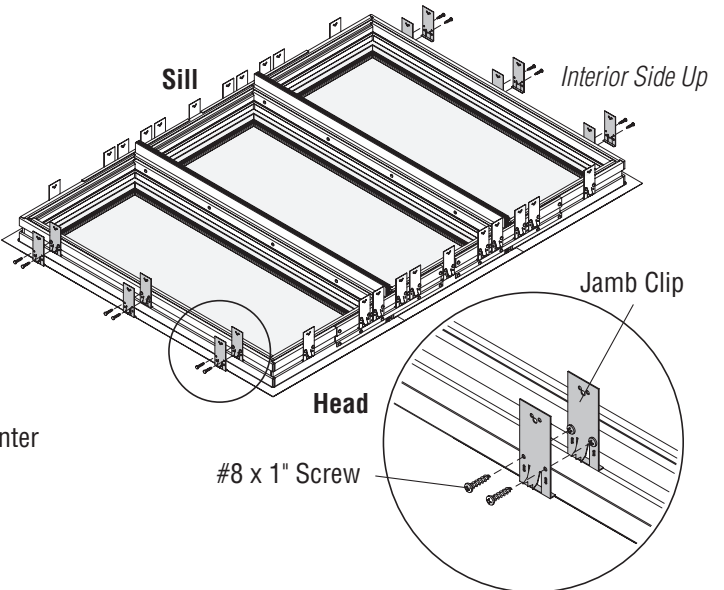
- For **Picture/Transom Window Units**, go to **Page 13**.

**Casement/Awning Units**

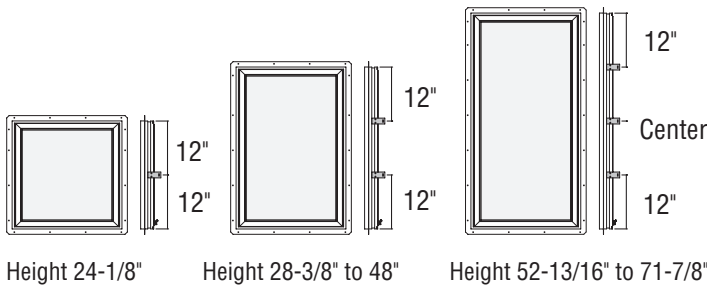
- For head and sill of Casement Units and side jambs of Awning Units, apply one *Jamb Clip*, long leg to the interior, into dado on the backside of jambs. Position *Jamb Clips* on center and 1-1/8" above jamb, as shown. Fasten using two #8 x 1" screws.
- For head and sill of Awning Units and side jambs of Casement Units, apply *Jamb Clips* in the quantity and locations, as shown, based on unit size. Apply *Jamb Clips*, long leg to the interior, into kerf on the backside of the jambs. Position *Jamb Clips* on center and 1-1/8" above jamb, as shown. Fasten using two #8 x 1" screws.



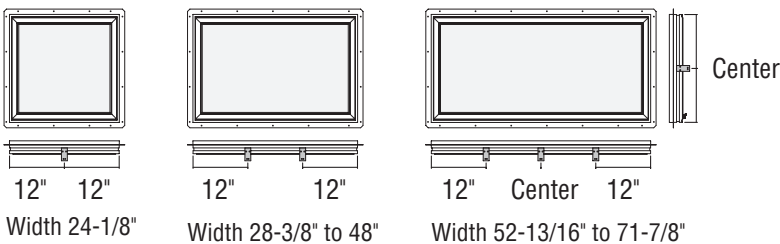
**Jamb Clip Attachment at Head and Sill**  
Triple Casement Combination



**Jamb Clip Attachment at Sides**  
Triple Casement Combination



**Jamb Clip Locations - Casement Side Jambs**

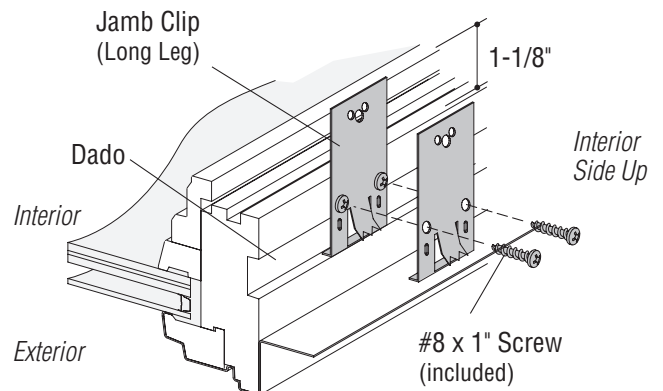
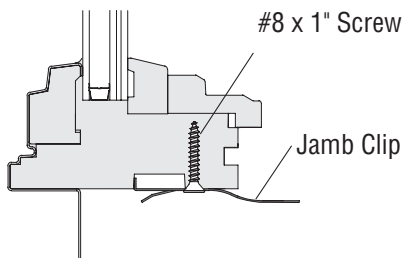
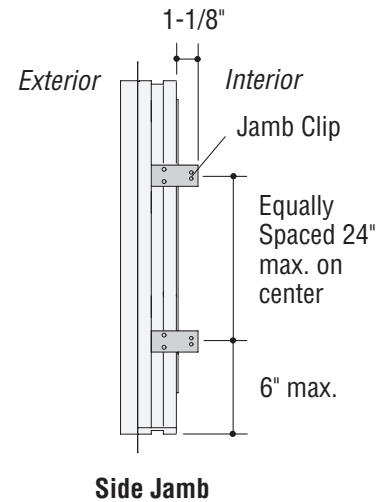
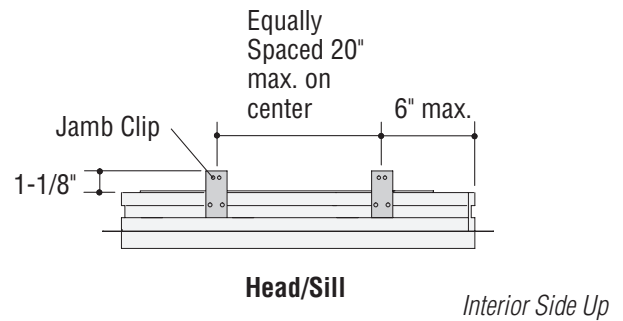


**Jamb Clip Locations - Awning Head, Sill and Side Jambs**

14. Apply Jamb Clips (continued)

Picture/Transom Window Units

- Determine *Jamb Clip* quantity based on unit size from tables on **Page 14**.
- Position *Jamb Clips* in dado on back side of jambs, long leg to interior, extending 1-1/8" above jambs, as shown. Equally space *Jamb Clips*, according to unit dimension height/width, and fasten to unit using two #8 x 1" Screws.



Picture/Transom Window Units

**14. Apply Jamb Clips (continued)**

Picture Window Dimensions & Jamb Clip Chart

UNIT DES.	DIM. WIDTH	DIM. HEIGHT	CLIPS PER HEAD/SILL	CLIPS PER SIDE JAMB
P5060	59 7/8"	71 7/8"	4	4
P4560	52 13/16"	71 7/8"	4	4
P4060	48"	71 7/8"	3	4
P3560	40 13/16"	71 7/8"	3	4
P3060	35 15/16"	71 7/8"	3	4
P5055	59 7/8"	64 13/16"	4	4
P4555	52 13/16"	64 13/16"	4	4
P4055	48"	64 13/16"	3	4
P3555	40 13/16"	64 13/16"	3	4
P3055	35 15/16"	64 13/16"	3	4
P6050	71 7/8"	59 7/8"	4	3
P5550	64 13/16"	59 7/8"	4	3
P5050	59 7/8"	59 7/8"	4	3
P4550	52 13/16"	59 7/8"	4	3
P4050	48"	59 7/8"	3	3
P3550	40 13/16"	59 7/8"	3	3
P3050	35 15/16"	59 7/8"	3	3
P6045	71 7/8"	52 13/16"	4	3
P5545	64 13/16"	52 13/16"	4	3
P5045	59 7/8"	52 13/16"	4	3
P4545	52 13/16"	52 13/16"	4	3
P4045	48"	52 13/16"	3	3
P3545	40 13/16"	52 13/16"	3	3
P3045	35 15/16"	52 13/16"	3	3
P6040	71 7/8"	48"	4	3
P5540	64 13/16"	48"	4	3
P5040	59 7/8"	48"	4	3
P4540	52 13/16"	48"	4	3
P4040	48"	48"	3	3
P3540	40 13/16"	48"	3	3
P3040	35 15/16"	48"	3	3
P6035	71 7/8"	40 13/16"	4	3
P5535	64 13/16"	40 13/16"	4	3
P5035	59 7/8"	40 13/16"	4	3
P4535	52 13/16"	40 13/16"	4	3
P4035	48"	40 13/16"	3	3
P3535	40 13/16"	40 13/16"	3	3
P3035	35 15/16"	40 13/16"	3	3
P6030	71 7/8"	35 15/16"	4	2
P5530	64 13/16"	35 15/16"	4	2
P5030	59 7/8"	35 15/16"	4	2
P4530	52 13/16"	35 15/16"	4	2
P4030	48"	35 15/16"	3	2
P3530	40 13/16"	35 15/16"	3	2
P3030	35 15/16"	35 15/16"	3	2

Transom Window Dimensions & Jamb Clip Chart

UNIT DES.	DIM. WIDTH	DIM. HEIGHT	CLIPS PER HEAD/SILL	CLIPS PER SIDE JAMB
CTR1510	17"	12"	2	1
CTR1810	20 1/2"	12"	2	1
CTR2010	24 1/8"	12"	2	1
CTR2410	28 3/8"	12"	2	1
CTR2810	31 1/2"	12"	2	1
CTR2910	33 3/4"	12"	3	1
CTR/PTR3010	35 15/16"	12"	3	1
CTR3410	40 3/4"	12"	3	1
CTR3510	40 13/16"	12"	3	1
CTR/PTR4010	48"	12"	3	1
PTR4510	52 13/16"	12"	4	1
CTR4810	56 1/2"	12"	4	1
PTR5010	59 7/8"	12"	4	1
CTR5210	62 3/4"	12"	4	1
PTR5510	64 13/16"	12"	4	1
CTR51110	71 5/8"	12"	4	1
CTR/PTR6010	71 7/8"	12"	4	1



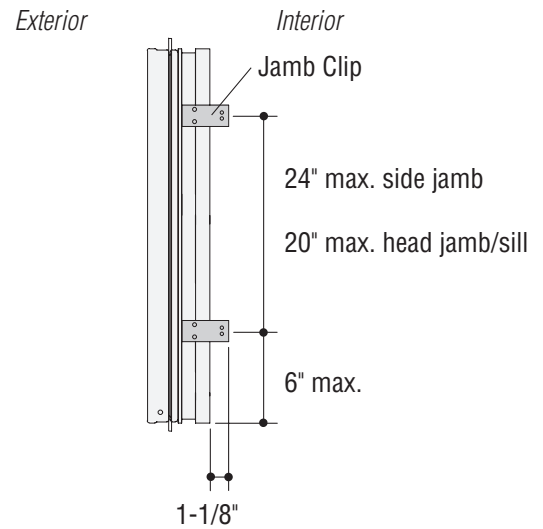
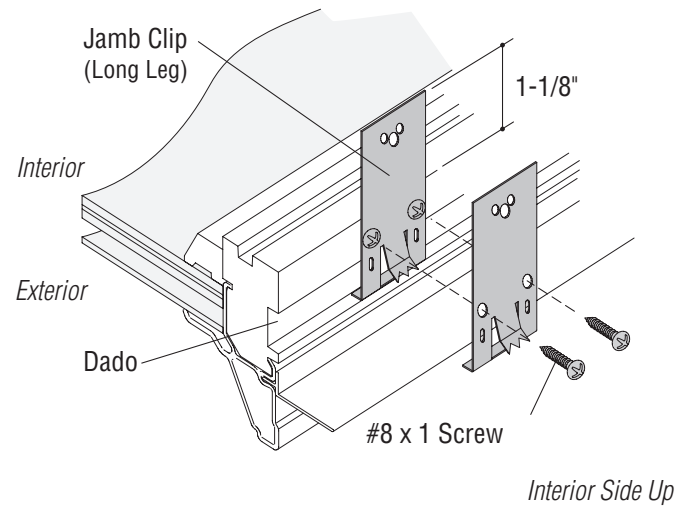
## 14. Apply Jamb Clips (continued)

### Flexiframe® Units

#### ⚠ WARNING

Use one clip at head and at sill for each glass light on single, double, and triple units. Failure to do so will adversely affect design pressure rating, product performance, and may result in injury, product and/or property damage.

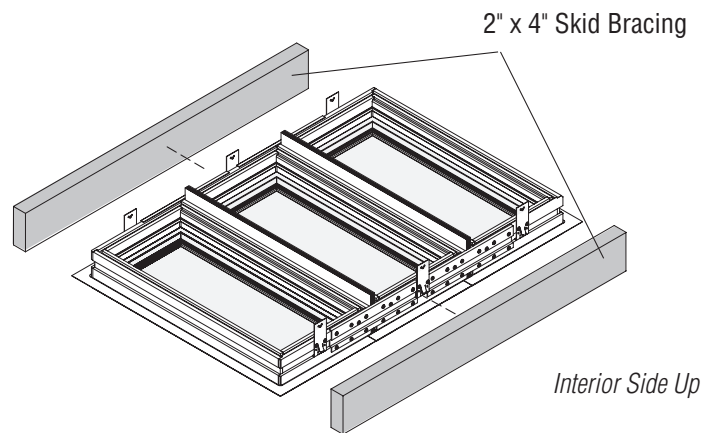
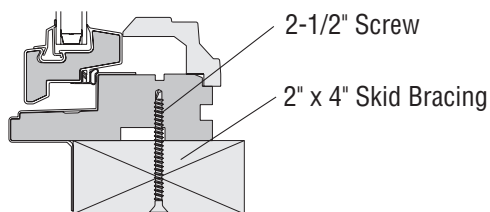
- Determine *Jamb Clip* locations from diagrams.
- Position *Jamb Clips* in dado on back side of jambs, long leg to interior, extending 1-1/8" above jambs, and fasten using two #8 x 1 Screws.



### Flexiframe® Units

## 15. Apply Bracing

- If joined units are being transported to a job site, apply 2" x 4" skid bracing to joined ends using 2-1/2" (maximum) nails or screws centered on a 2" x 4" skid bracing for protection. Remove 2" x 4" skid before installing units.





## 16. Install Window Unit

- Apply a 1/4" bead of sealant to backside of *Installation Flange* if flanges are used.

### ⚠ WARNING

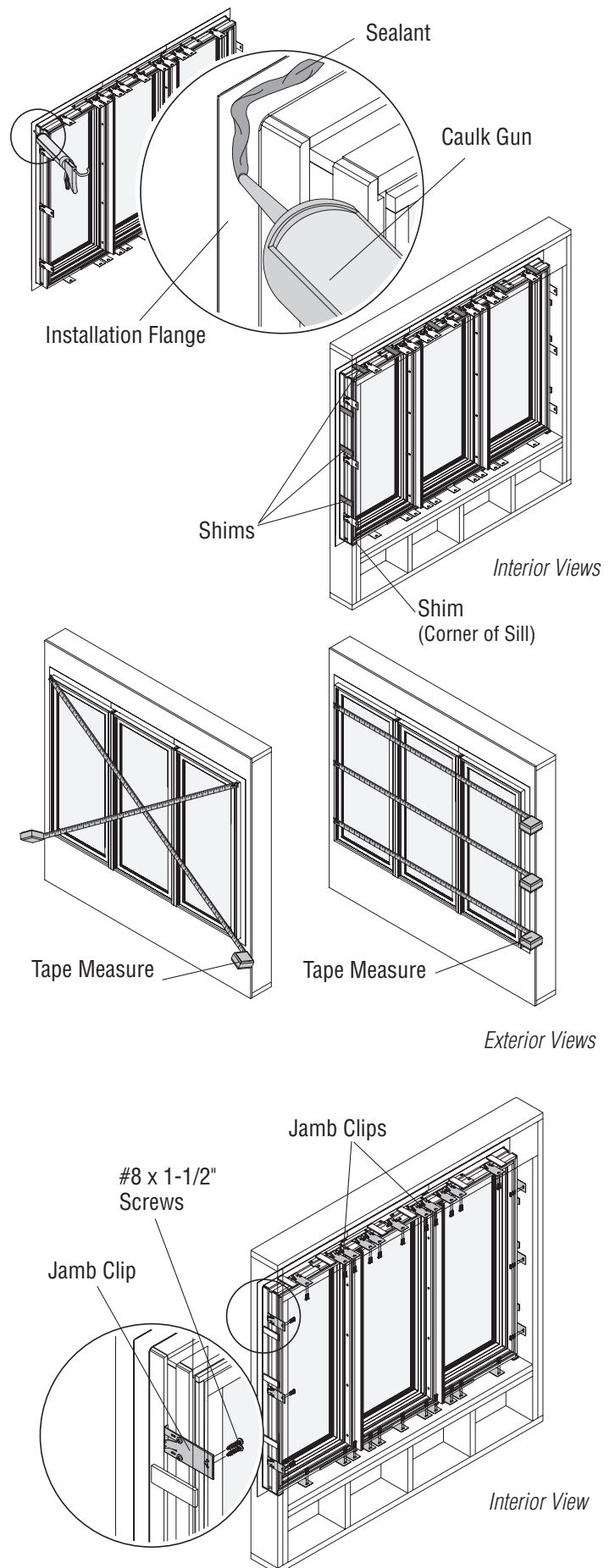
Windows and doors can be heavy. Use safe lifting techniques and a reasonable number of people with enough strength to lift, carry and install window and door products to avoid injury and/or product damage.

- Lift unit into rough opening from the exterior supporting unit at all times until fully secured. Center units in opening.
- Shim at quarter points between unit and rough opening on all sides to keep unit plumb, level and square. Shim at corners of sill under *Side Jambs*, from the interior, to level and center unit.
- Measure diagonally across window, upper left to lower right and upper right to lower left corners. If measurements are within 1/8", unit is square. If unit is not square, correct as needed using shims.
- Measure across head, center, and sill of the window unit. Center dimensions should be within 1/8" of head and sill dimensions. Shim or block to straighten *Side Jamb* if necessary. Insert shims at midpoint behind *Side Jamb*, between unit frame and rough opening. Insert and fasten shims every 18" on lock side of venting units.

### ⚠ WARNING

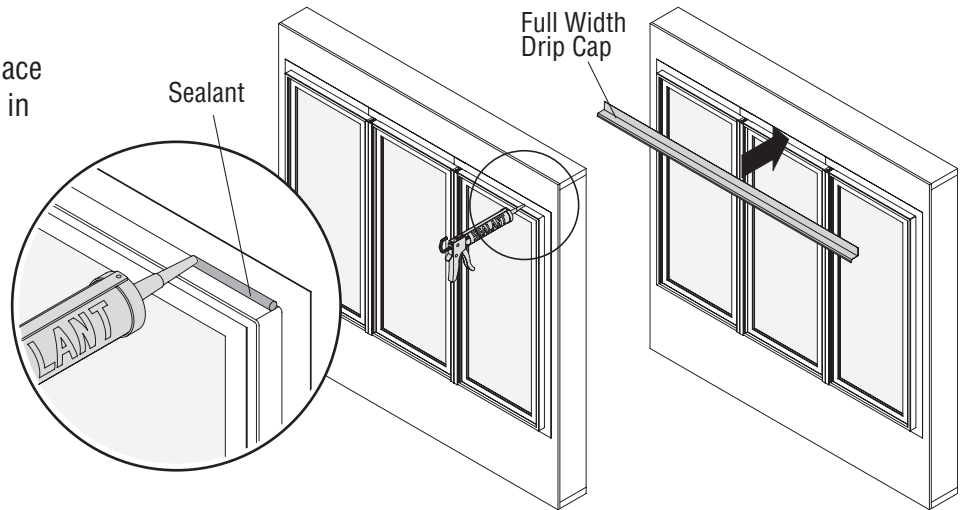
Metal fasteners and components may corrode when exposed to preservative-treated and/or fire-retardant treated lumber. Obtain and use the appropriate metal fasteners and hardware as called out by the installation guide to fasten unit to any rough opening made from preservative-treated and fire-retardant treated lumber. Failure to use the appropriate materials for the installation may cause a failure resulting in injury, property or product damage.

- Fasten Jamb Clips to rough opening using two #8 x 1-1/2" screws per jamb clip.



## 17. Apply Full Width Drip Cap

- Apply sealant at top only. Quickly place full width drip cap (sold separately) in sealant, centering over unit(s).



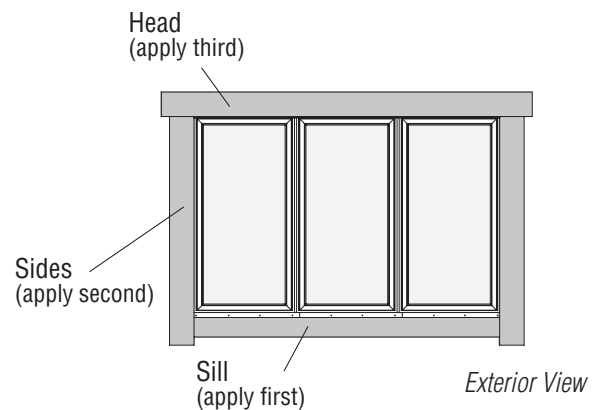
Exterior View

## 18. Apply Flashing Tape

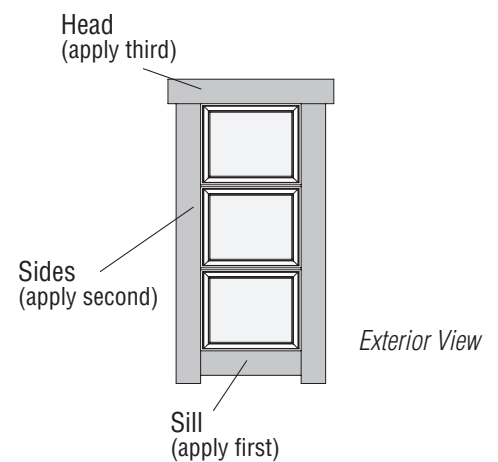
### NOTICE

- This instruction step depicts one of many options for proper flashing.
- Moisture infiltration problems in any type of building can be reduced by properly flashing and/or sealing around all building openings, including windows and doors. Proper flashing under and around window and door openings can reduce moisture problems, but the performance of any building system depends upon the design and construction of the building system in its entirety, which should address local environment, climate, building codes and product and material limitations. The design and installation of flashing and sealing systems are the responsibility of the architect, contractor, installer, and/or the manufacturer of the building exterior specified for the project.

- Apply flashing tape over *Installation Flange* at sill.
- Apply flashing tape over *Installation Flange* at sides, overlapping flashing tape at sill.
- Apply flashing tape over *Installation Flange* at head, overlapping flashing tape at sides.



Vertically Joined



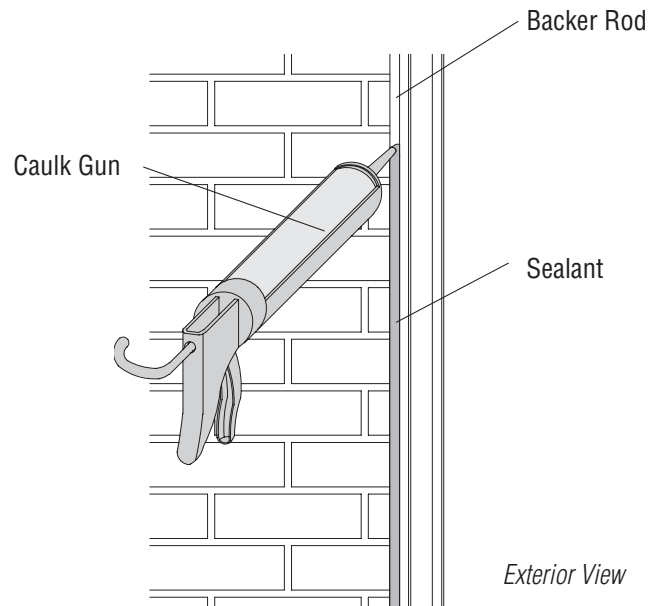
Horizontally Joined

## 19. Insulate and Seal Unit

### ⚠ CAUTION

- When insulating between the unit frame and rough opening, **DO NOT** over pack batt insulation or overfill with expandable foam. Bowed jambs may result causing product performance problems and/or incorrect operation of unit.
- A minimum space of 1/4" is required around exterior perimeter of unit between the frame and exterior finish material to allow for material expansion.
- Masonry/Brick Veneer installations require a minimum 1/2" space along the sill and a minimum 1/4" space around remaining perimeter to allow for settling and expansion.

- Insulate between frame and rough opening on all sides. **DO NOT** over pack batt insulation or overfill with insulation. Bowed jambs may result.
- Clean and prime around outside of unit where sealant will be applied. Apply backer rod and silicone sealant around exterior perimeter of window after siding (or other finish) is applied.



## 20. Apply Extension Jambs and Interior Trim Stops

### NOTICE

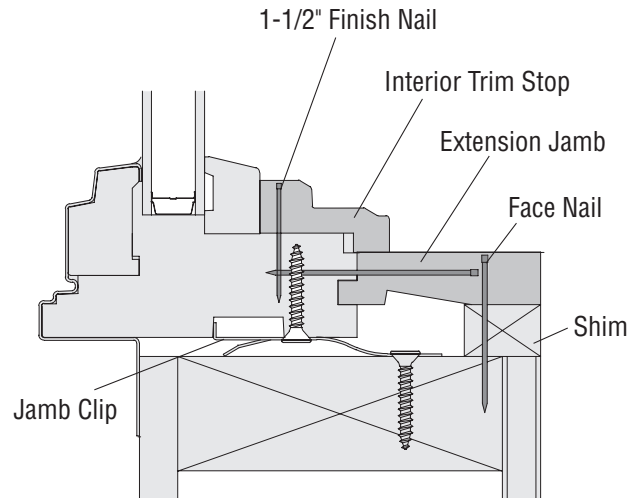
Ripping of Extension Jambs may be required to fit nonstandard wall depths. Contact your Andersen dealer for further information.

- Position *Extension Jamb* tongue into groove on frame. Hold *Extension Jamb* firmly to avoid tipping and drill 3/32" drill holes at fastener locations, (6-9/16" *Extension Jambs* are predrilled).
- Fasten *Extension Jamb* in place using appropriate length nail or screw, see chart. *Extension Jambs* can also be shimmed and face nailed.

### CAUTION

When insulating between the unit frame and rough opening, **DO NOT** over pack batt insulation or overfill with expandable foam. Bowed jambs may result causing product performance problems and/or incorrect operation of unit.

- Apply insulation between *Extension Jambs* and rough opening. **DO NOT** overpack batt insulation or overfill with insulation.
- Position *Interior Trim Stops* against *Glass Stops* or *Sash*. Drill 3/32" holes 2" from corners and every 12" in between.
- Hold *Interior Trim Stops* in position and fasten using 1-1/2" (4d) finish nails or pneumatic fastener equivalent.



Cross Section Detail - Casement Picture Window

Wall Dimension	Fastener Size
4-9/16"	3" (10d) Finish Nail or 3" Trim Screw
5-1/4"	3" (10d) Finish Nail or 3" Trim Screw
6-9/16" & 7-1/8"	3-1/2" (16d) Casing or Galvanized Nail or 3-1/2" Trim Screw

## Finishing, Cleaning, and Maintenance Instructions

### CAUTION

- **DO NOT** expose unfinished wood to high moisture conditions, excessive heat or humidity. Finish interior wood surfaces immediately after installation. Unfinished wood surfaces will discolor, deteriorate, and/or may bow and split.
- **DO NOT** stain or paint weatherstrip, silicone beads, vinyl, glass, or hardware. Damage to product may occur and unit operation may be impaired.
- Acid solutions used to wash masonry/concrete will damage glass, fasteners, hardware, and metal flashing. If these solutions are used, follow the acid solution manufacturer's instructions carefully. Protect and/or cover Andersen products during the cleaning process to prevent acid contact. If acid does come in contact with unit, immediately wash all surfaces with clean water.

### INTERIOR FINISHING

**Read and follow finishing manufacturer's instructions and warnings on each container of finish material for priming, painting, staining, and varnishing.**

### CLEANING

Clean exterior frame, sash members, and insect screens using a mild detergent-and-water solution and a soft cloth or brush. **DO NOT** use abrasive cleaners or solutions containing corrosive solvents. For persistent dirt or grime, use a nonabrasive cleanser or a mixture of water and alcohol or ammonia.

### MAINTENANCE

Immediately sand and refinish any interior wood that becomes stained or mildewed to prevent further discoloration and/or damage. For further information, contact your local Andersen dealer. Dealers can be found in the Yellow Pages under Windows.