ECO WINDOWS LLC dba DRUTEX USA
4960 VISTA BLVD, SUITE 100
SPARKS, NV 89436
PHONE: 775-636-8138
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WWW.DRUTEX.US

ECO WINDOWS

GLAZING INSTRUCTIONS

1. General Information

The quality of a completed window unit depends on the correct installation of the glass in the sash/ frame.

NOTE: If site glazing is preformed, please follow ECO's shimming recommendations, to provide proper placement of shims to meet the static requirement long- term performance of the window unit.

All ECO Windows are dry glazed utilizing EPDM splines on the exterior as well as glazing stops with co- extruded flexible seals on the interior. For glazing splines not supplied by ECO, proper performance cannot be assured.

Before Glazing:

Check the glass unit for damage, specifically the edges.

ATTENTION: Avoid Glazing below 5°C (41° F) as the PVC is more brittle at lower temperatures.

Remove the weld sprue from the glazing spline groove as well as from the internal side of the glazing up- stand to avoid any pressure points on the glass edges.

During Glazing:

For proper ventilation of the glazing rebate, the distance between the glass and the rebate should be at least 5mm (0.2'').

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Installation of the Glazing Spline

Install the spline with an overlap of about 1 percent to avoid gaps due to shrinkage of the spline during the first few months of use.
Both ends of the spline are butted and glued together on the upper horizontal rail of the window.

Installation of Glazing Stops

Stops should be mitered.

To avoid stress cracks in the corners, stops have to be cut precisely and installed without over- length.

Use a plastic mallet for proper installation.

For very small unit sizes, stops have to be butt cut. The overlapping stops have to be mitered at an angle.

To De- Glaze

Insert a 1” to 2” wide, putty knife, between frame (or sash) and glazing stop, then pry stop from frame (or sash). See detail below.

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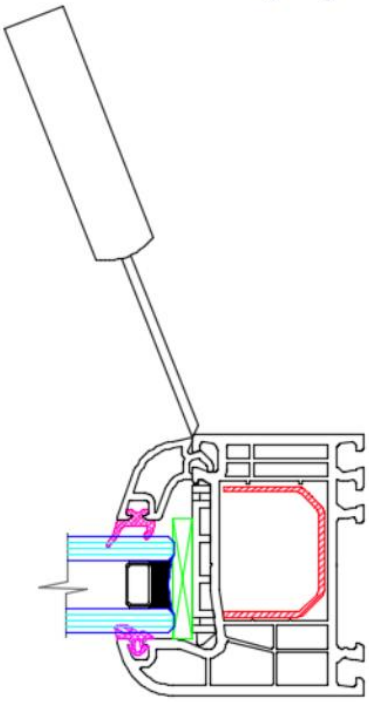
WINDOW PREPARATION:

1. De- glaze one of the windows, using 1'' rigid flat tool.
(1-1 ½ '' chisel putty knife, shown, is available at The Home Depot. Store SKU: 720808)

2. Start from the middle of the longest glaze bead and work your way towards the corners.



Place the glass in safe place. Ensure the edges of the glass are supported or are sitting on soft material like rigid foam or wood. **DO NOT PLACE GLASS DIRECTLY ON CONCRETE OR AGAINST METAL STUDS.**

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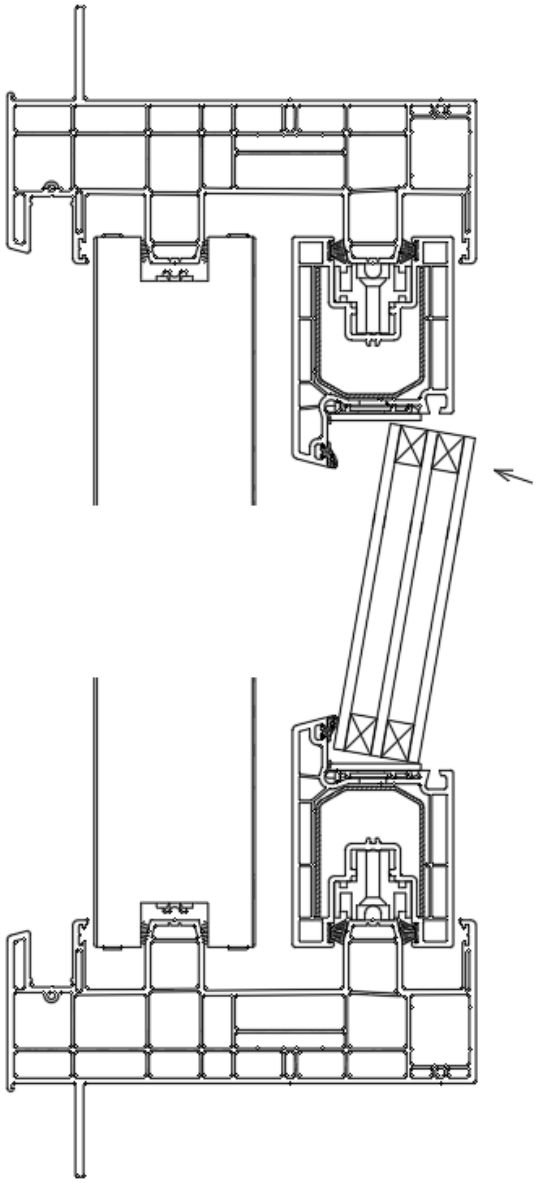
Re-Glazing Instructions

Step 1: Replace the bottom bridge shims and spacer shims into the frame.

Step 2: Place the glass back into the frame bottom first and tilt glass towards the top of the frame. Please make sure that the glass is placed back with low-e side facing out.



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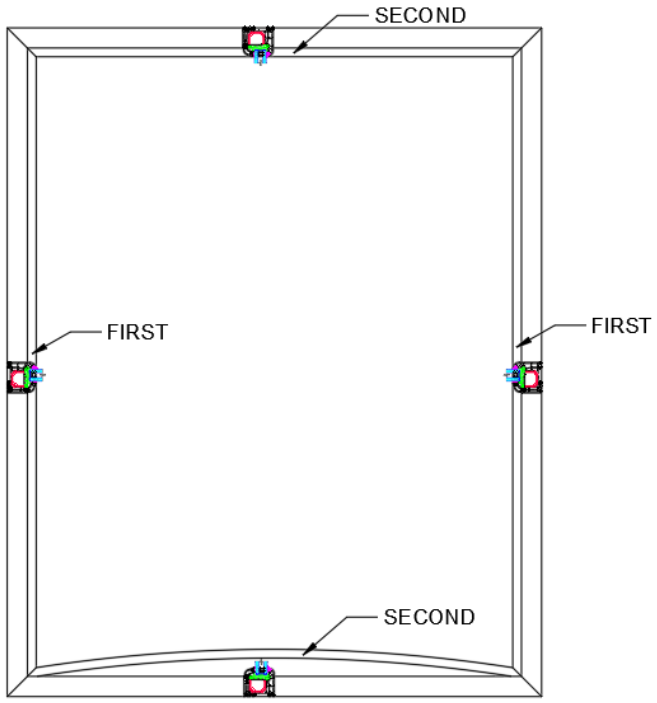
Step 3: Replace the rest of the spacer shims per glass shimming guidelines included below.

Step 4: Re-install glaze beads starting with the longest glaze beads first and shortest second. The second set of glaze beads will fit tight, so please insert the two outside corners first with the middle of the bead arching away from the frame.



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Tap the glaze bead using a 12-ounce double-face soft hammer (available at Home Depot, store SKU: 806699)

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GLASS SHIMMING GUIDELINES

Shimming:

- Shimming assures the correct distribution of glass weight to the frame/ sash. It also supports ease of operation for operable units.
- The glass weight is transferred to the "load bearing setting blocks."
  The "spacers" are used to keep the minimum distance between the glass edge and the PVC Profile.
- Polymer setting blocks the shore hardness 80 are normally used for shimming because they are compatible with the surrounding materials.

Sizes:

- The shims should be 2mm (1/8 ") wider than the overall glass thickness to fully supports the edges of each glass pane.
- A width of 80 mm to 100 mm (3" to 4") is recommended.
- The positioning of the shims is determined by the opening style of the window.

After Shimming:

- After shimming, the proper operation of the window has to be confirmed or the shimming has to be re- done.
- For operating sashes, the distance of the shims from the internal corner of the unit is the length of the shim.
- For fixed glazed units, the distance from the unit corners can be between 150mm (6") and the quarter points of the glass width.
- The load bearing setting blocks should be located above the lower rail anchoring points.
- For large fixed glazed units, two shims can be placed beside each other.

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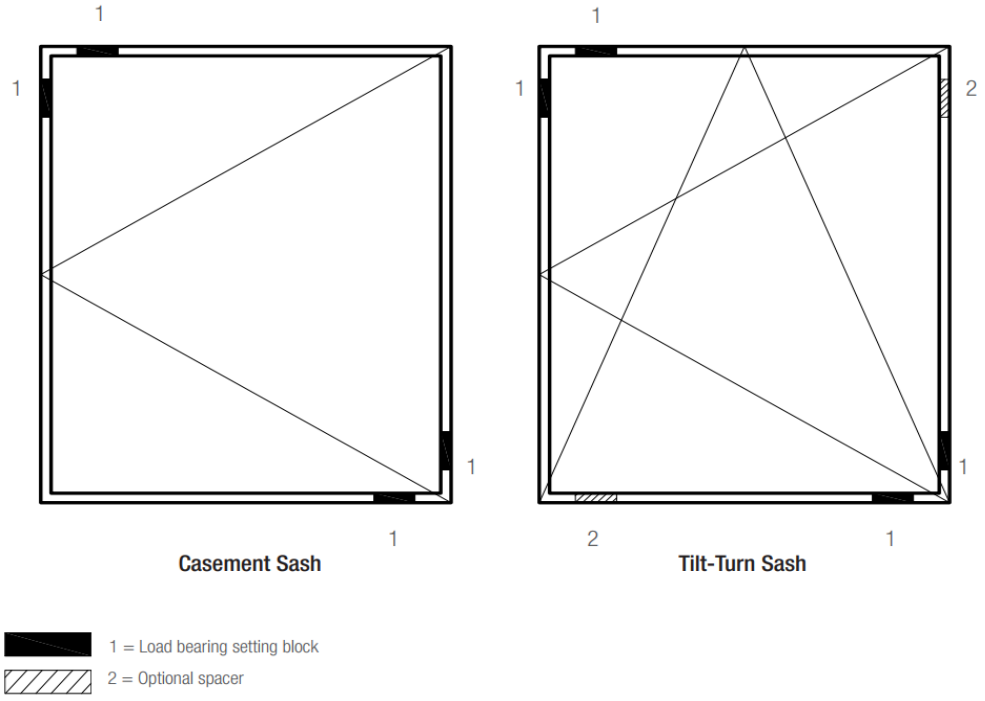
Casement and tilt and turn shimming details



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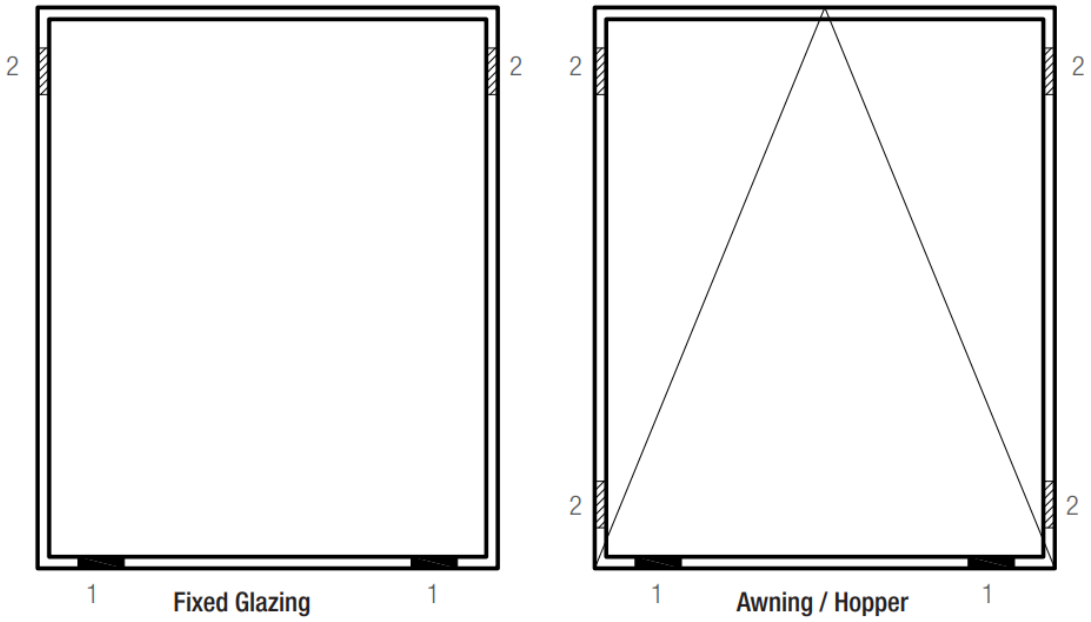

For sash with width or height of more than 1300 mm (51”), additional spacers should be inserted (i.e. where the handle or the locking points are located).

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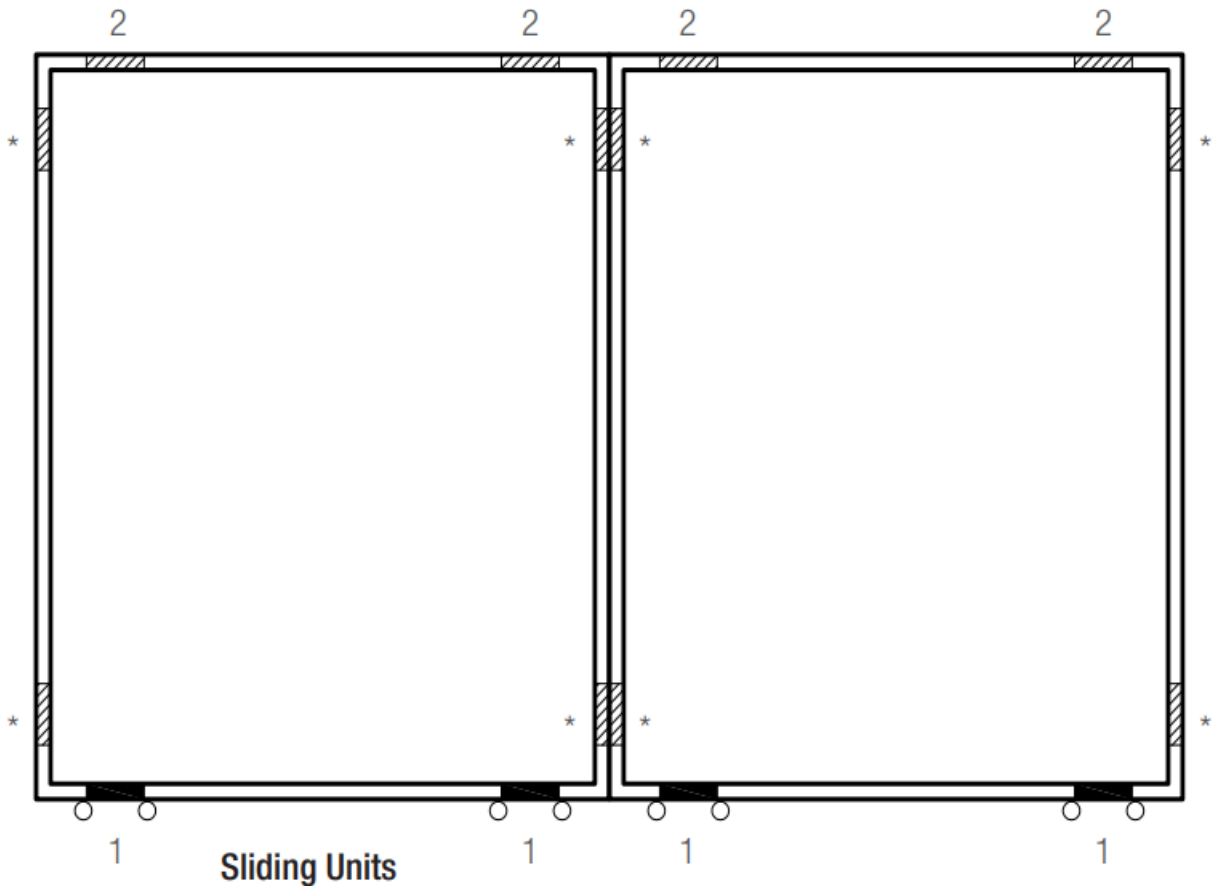

1 = Load bearing setting block

2 = Optional spacer

The load bearing setting blocks should be positioned right above the rollers which are positioned at the appropriate distance from the corner.

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Shimming details for specialty glazing