



Installation Instructions: Mulling Two or More ProLine® Units

IMPORTANT! Read thoroughly before beginning. Failure to install as recommended will void any warranty, express or implied.

Tools Required:

Utility knife
Wedges (2)- optional
Wood block
Hammer or rubber mallet
Hack saw
Drill
3/32" drill bit
#2 Phillips screwdriver
Pliers

Other Materials Required:

High-quality urethane sealant

Mullion Kit Contents:

Foam tape
Exterior mullion cover
Interior mullion cover
Staples
Fin splices (2)
Head drip fin splice (1)

Note: These instructions describe three different mulling situations: mulling units side by side, mulling a Transom over a unit and mulling a Circlehead over a unit. The first two situations are addressed below. Start on step 17 for instructions on mulling a Circlehead over a unit.

MULLING UNITS SIDE BY SIDE OR MULLING A TRANSOM OVER A UNIT:

1. Remove the flexible fin corners from the joining sides of the two units to be mulled together (two fin corners per unit).
2. If mulling a transom over a unit *and* the lower unit has a head drip fin installed, remove the drip part of the head drip fin by bending it on the score line and breaking it off with a pliers as shown. **NOTE:** This step is not necessary when mulling units side by side.
3. Use a utility knife to cut the foam tape to the length of the windows to be joined.



4. Foam tape must be applied to just one of the units, on the side where it is to be joined to the other unit. Make sure the surface where the foam tape is to be applied is free of dirt and debris. Peel back the release paper from the foam tape and apply it to the aluminum cladding $\frac{1}{4}$ " from the front edge as shown. To ensure a proper seal, do not stretch the tape.



5. Position the units together, cladding side up, on a clean, flat work surface. (The foam tape should be between the units.)
6. If necessary, use a hacksaw to cut the exterior mullion cover $\frac{3}{8}$ " less than the length of the joining side of the units.
7. Center the exterior mullion cover on the joint between the units, making sure it lines up with the grooves in the units. When mulling units side by side, the mullion cover should be placed just below the accessory groove at the head of the unit, so this groove is kept clear.



8. Install the mullion cover using a wood block with a hammer or rubber mallet. (The block of wood will prevent damage to the cladding.) HINT: To help install the mullion cover, place small wedges under the outside edge of the units to tilt them in slightly.



9. Turn the units over carefully, making sure the units stay together. Secure the interior of the windows with the staples provided. (Corrugated fasteners—not included—may be used instead of staples.) HINT: When using the staples provided, install them at a slight angle, alternating the angle with each staple.

Repeat steps 1-8 if joining additional units. Consult your local Pella representative before joining units that would exceed ten feet in total frame width or frame height.



10. Fold installation fins out to at least 90 degrees. Do not under-bend.



STEPS 12 and 13 ARE FOR MULLING UNITS *SIDE BY SIDE ONLY*....SKIP TO STEP 14 IF MULLING A TRANSOM OVER A UNIT.

11. Carefully turn the units back over so the cladding side is face up. Remove the release paper from the head drip fin splice.



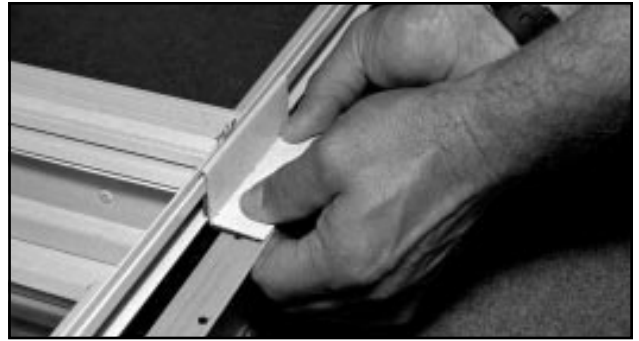
12. Install the head drip fin splice across the gap at the mullion joint, at the head of the units as shown. Press the splice into place. NOTE: If the units do not have a head drip fin, then a traditional fin splice can be used at the head of the units.



13. Remove the release paper from one of the fin splices (you will only use one of these when mulling units supplied with head drip fins in a side by side application).



14. When mulling units side by side, install the fin splice across the gap at the mullion joint, at the sill of the unit as shown. Press the fin splice into place.



15. When mulling a transom over a unit, install the fin splice across the gap at the mullion joint at the side of the composite. Press the fin splice into place. Repeat at the other side of the composite.



16. When the composite is ready for job-site installation, remove the release paper from the flexible fin corners. Apply sealant as directed in the window installation instructions on the back of the window label. Save the interior wood mullion cover to use when trimming out the windows.

MULLING A CIRCLEHEAD OVER UNIT(S):

17. Remove the flexible fin corners from the joining sides of the units to be mulled together (two fin corners per unit).



18. If a head drip fin is installed on the rectangular unit(s) the Circlehead will be mulled to, remove the drip part of it by bending it on the score line and breaking it off with a pliers as shown.



19. Cut the foam tape to the width of the windows to be joined.



20. Make sure the surface where the foam tape is to be applied is free of dirt and debris. Peel back the release paper from the foam tape and apply it to the aluminum cladding $\frac{1}{4}$ " from the front edge of the rectangular unit(s). To ensure a proper seal, do not stretch the tape.



21. Position the units together, cladding side up, on a clean, flat work surface. (The foam tape should be between the units.)

22. Use a hacksaw to cut the exterior mullion cover $\frac{3}{8}$ " less than the frame width of the composite.



23. Center the exterior mullion cover on the joint between the units, making sure it lines up with the grooves in the units. Install the mullion cover using a wood block with a hammer or rubber mallet. (The block of wood will prevent damage to the cladding.)

24. Turn the units over carefully, making sure the units stay together. Secure the interior of the units with the #8 x 2" flat-head screws provided with the Circlehead. Drill two $\frac{3}{32}$ " pilot holes, 1- $\frac{1}{2}$ " from the interior edge and 6" from each side of the frame of the Circlehead. Take care to not drill into the unit below the Circlehead. Install two of the five screws at the pilot locations. Install the remaining screws evenly spaced between the two pilot locations.



25. Carefully turn the units back over so the cladding side is face up. Fold installation fins out to at least 90 degrees. Do not under-bend. Align with the Circlehead fin.

26. Two pieces of water-proof tape are included with the Circlehead. Remove the adhesive backing and apply the tape over the gaps between the Circlehead fin and the rectangular unit's fins on both sides of the composite.



27. Apply a $\frac{3}{8}$ " bead of sealant between the water-proof tape and the edge of the window as shown.

28. Apply sealant and install the windows as described in the installation instructions on the back of the labels. Save the wood interior mullion cover for later use when trimming out the windows.

