



Glazing Instructions

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Before starting the glazing process install your window or door as per installation instructions. Visit www.Kohltech.com/resources for a copy of the installation instructions, glazing instructions, and how-to videos for glazing. Ensure the window is level, square, and plumb. Clean any debris, dirt, or dust from the frame and sash.

Wet Glazing

Wet glazing refers to a bead of caulking on the glazing tower of the window components. A window will be wet glazed if it is a Bent Shape, Fixed Sash (over 25 sq.ft.), or a Picture Window (over 25 sq.ft.). A window will be wet glazed if it arrives on-site without glazing tape applied or if it is not a Tilt & Turn unit.

Tape Glazing

Tape glazing is completed by applying tape to the glazing tower of the window components. Windows that will be tape glazed will arrive on-site with the tape already placed. Windows that are tape glazed are Casement, Awning, Fixed Casement Sash (under 25 sq.ft.), Picture Windows (under 25 sq.ft.), Single Hung, Single Glider, and Non-Bent Shapes. See Figure 11 on Page 10 for details.

Compression Glazing

Compression glazing uses a rubber gasket on both side of the unit that acts as a seal. This rubber replaces the tape or caulking in other glazing methods. Compression glazing is used on all Tilt & Turn units. Tilt & Turn units include Bi-Fold unit, Tilt & Turn Picture Window, Tilt & Turn Fixed Sash, Hopper, and Tilt & Slide units. See Figure 17 or Figure 18 on Page 13 for details.

Setting Blocks

- Setting blocks should go every 20” along the bottom on Fixed Sash or Picture Windows.
- If a height in a unit is over 48” install setting blocks in the center of the sash as well.

- Refer to www.Kohltech.com/resources for shape setting block locations.
- Triple glazed Casement units use a red u-shaped setting block.
- Triple glazed Tilt & Turn units use a red u-shaped setting block.
- All dual glazed units and Single Hung/Single Glider units use black rectangular setting blocks.

Materials Required

- Setting blocks
- Glazing shovel
- Glazing stops
- Rubber mallet
- Clear silicon (Adfast or GE Silglaze 2070 is recommended)
- Gloves
- Wrist guards

Notes

- The **heal bead** is defined by a bead of caulking on the bottom and 6” up the sides of the installed unit. It is located at the edge of the glass and the inside vinyl glazing area. The heal bead is covered by the glazing stop.
- **Glazing ramps** are vinyl pieces that are placed into the glazing tower to level the plane for the setting blocks. Glazing ramps are used for Tilt & Turn units only.
- The **glazing tower** is where the glass unit is placed and where the glass meets the vinyl.
- A **glazing shovel** is a specialized tool that is used to shift the glass unit into the correct positioning and to help with easy installation of the setting blocks.
- A **temporary alignment spacer** is a setting block that is placed in the glazing tower but is removed before glazing is completed.
- **Setting blocks** allow movement between the glass and vinyl.

If these instructions are not followed, warranty may be void.

Wet Glazing

Instructions

1. Run clear caulking around the whole perimeter of the glazing tower (including the straight sections of shapes with bent sections). Do not cover drain holes with caulking.
2. Place the bottom setting blocks perpendicular to the glazing tower and roughly 4" from the outside edge of the frame.
3. Remove all packaging on glass unit and review the glass for imperfections.
4. Insert the glass unit in the frame on top of the setting block. Ensure the setting block is not behind the inside piece of glass.
5. Ensure everything is straight and square and that the amount of spacer seen from the outside of the window is even around the perimeter.
6. Place a dab of caulking in all other setting block locations. Install the rest of the setting blocks using the glazing shovel.
7. Turn the bottom setting block(s) underneath the glass unit.
8. Run a continuous heal bead across the bottom and 6" up each side of the window for square/rectangular windows. For circular windows run a continuous bead around the bottom third and bottom half of the unit. Be careful not to cover the drain holes along the bottom length.
9. Inspect the heal bead to ensure good contact with the glazing tower. A small hole in the heal bead will allow the window to leak.
10. Install the glazing stops. See Glazing Stop Guide on page 10.

Setting Block Locations for Wet Glazed Units

See the www.Kohltech.com/resources for Bent Shape setting block locations.

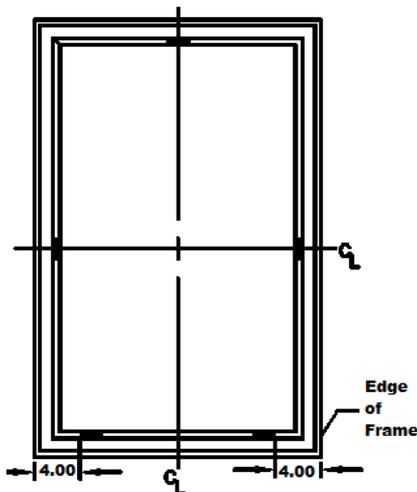


Figure 1: Picture Window/Fixed Sash (over 25 sq.ft.)

Tape Glazing

Instructions

1. Remove the blue backing from the glazing tape that is attached to the glazing tower. If there is no tape go to wet or compression glazing instructions.
2. Place caulking in all four corners where the glazing tape connects and at any breaks in the tape. Do not cover drain holes on the bottom width with caulking.
3. Place the bottom setting blocks perpendicular to the glazing tower and roughly 4" from the outside edge of the frame.
4. Remove all packaging on glass unit and review the glass for imperfections.
5. Insert the glass unit in the frame on top of the setting block. Ensure the setting block is not behind the inside piece of glass.
6. Ensure everything is straight and square and that the amount of spacer seen from the outside of the window is even around the perimeter.
7. Place a dab of caulking in all setting block locations.
8. Install the rest of the setting blocks using the glazing shovel.
9. Remove the temporary alignment spacer and glazing shovel.
10. Turn the bottom setting block(s) underneath the glass unit
11. Run a continuous heal bead across the bottom and 6" up each side of the unit. Be careful not to cover the drain holes on the bottom length.
12. Inspect the heal bead to ensure good contact with the glazing tower. A small hole in the heal bead will allow the window to leak.
13. Install the glazing stops. See Glazing Stop Guide on page 10.

Setting Block Locations for Tape Glazed Units

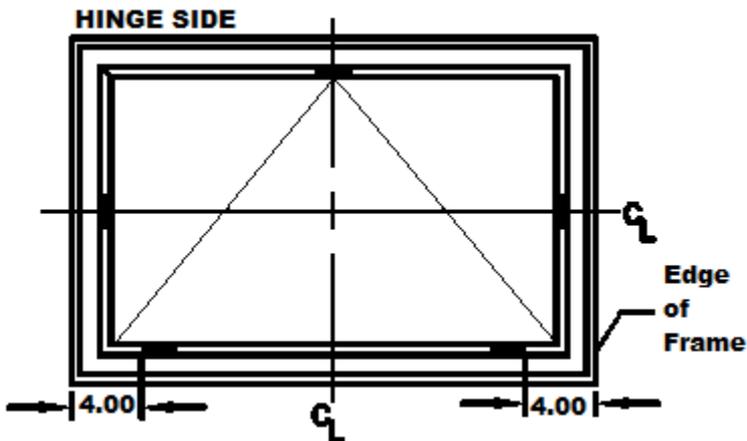


Figure 2: Awning Window

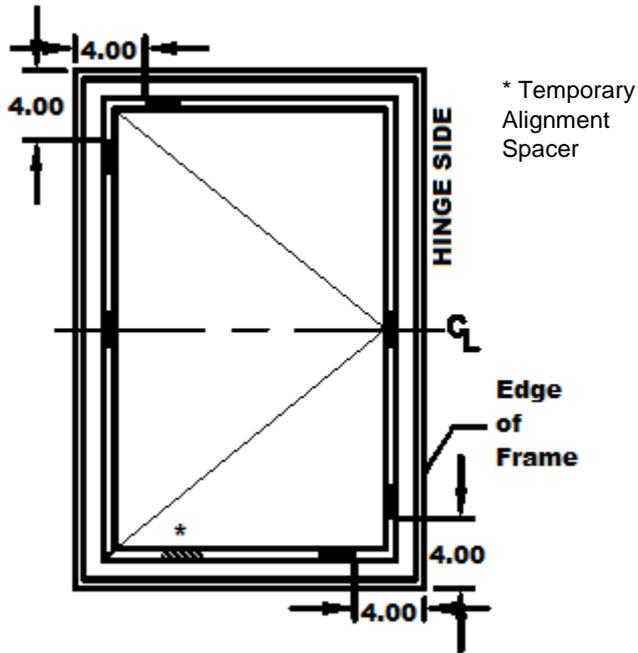


Figure 3: Casement Window

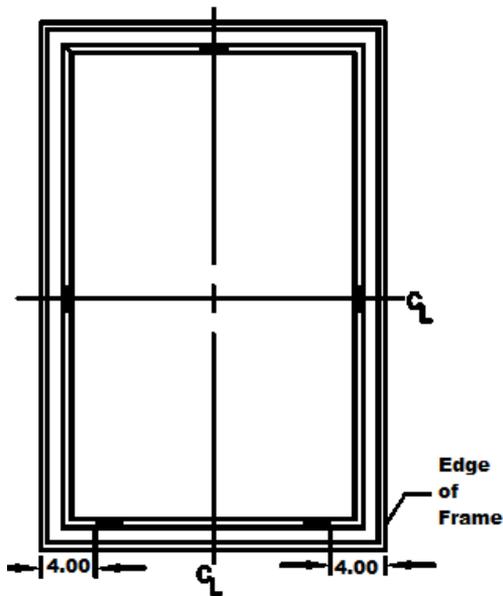


Figure 4: Picture Window/Fixed Sash (under 25.ft.)

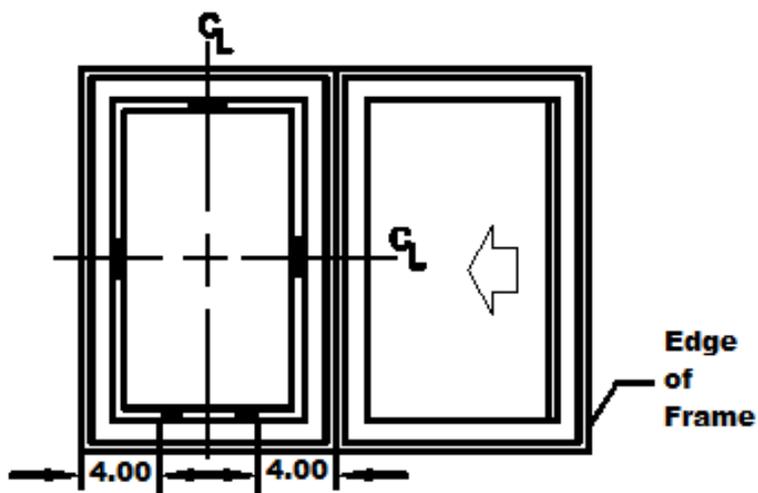


Figure 5: Single Glider

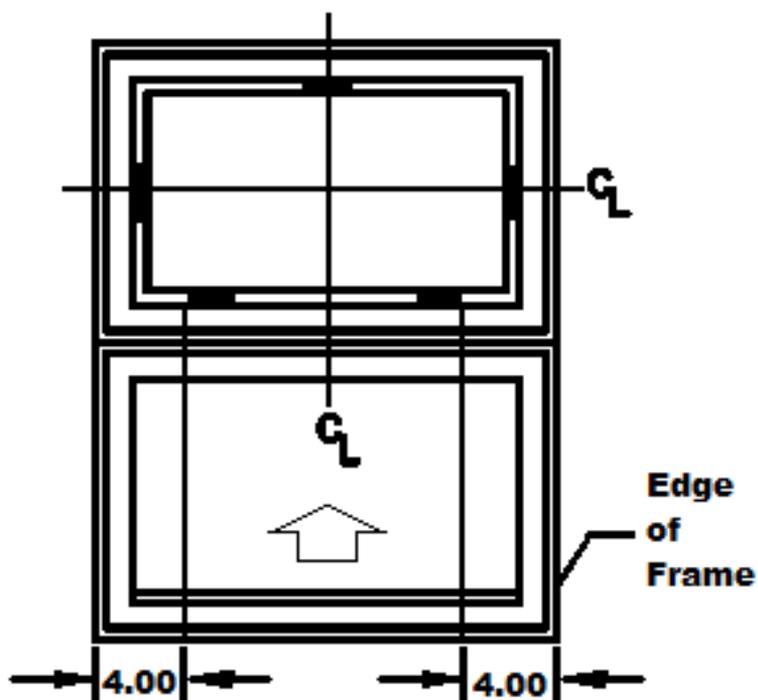


Figure 6: Single Hung

Compression Glazing

Instructions

1. Place glazing ramps in the glazing tower at setting block locations.
2. Secure ramps on the heights and top width with caulking.
3. Set the bottom setting blocks on the glazing ramps perpendicular to the glazing tower. They should be roughly 4" from the edge of the frame.
4. Remove all packaging on glass unit and review the glass for imperfections.
5. Insert the glass unit in the frame on top of the setting block. Ensure the setting block is not behind the inside piece of glass.
6. Ensure everything is straight and square and that the amount of spacer seen from the outside of the window is even around the perimeter.
7. Place a dab of caulking in the rest of the setting block locations.
8. Install the rest of the setting blocks using the glazing shovel.
9. Remove the temporary alignment spacers.
10. Turn the bottom setting block(s) underneath the glass unit.
11. Install the glazing stops. See Glazing Stop Guide on page 10.

Setting Block Locations for Compression Glazed Units

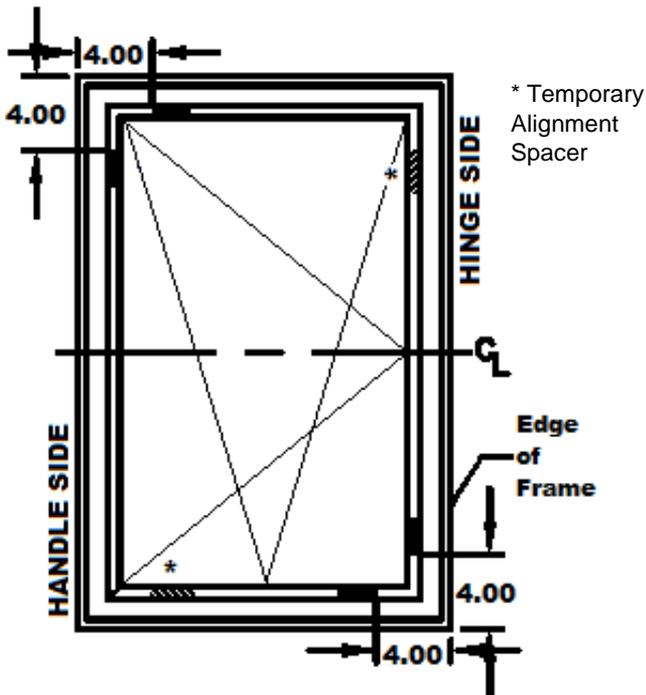


Figure 7: Tilt & Turn/Bi-Fold Unit

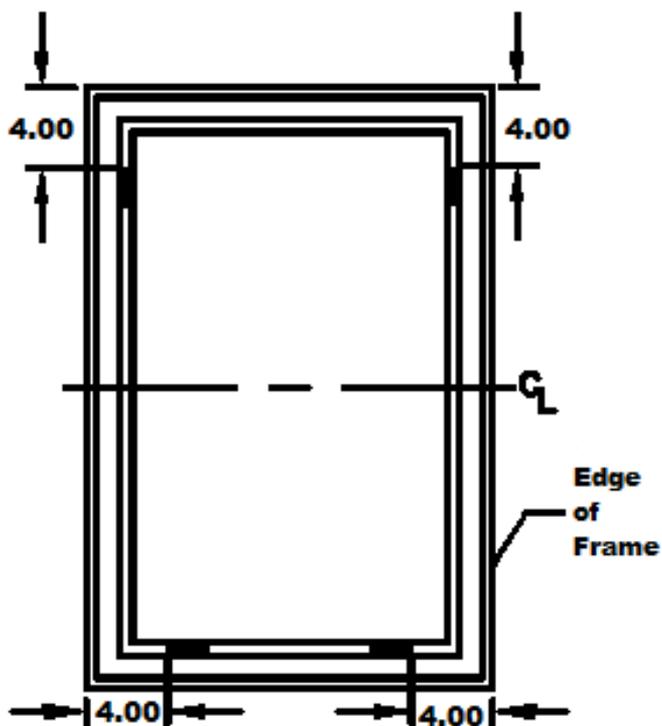


Figure 8: Tilt & Turn Fixed Sash

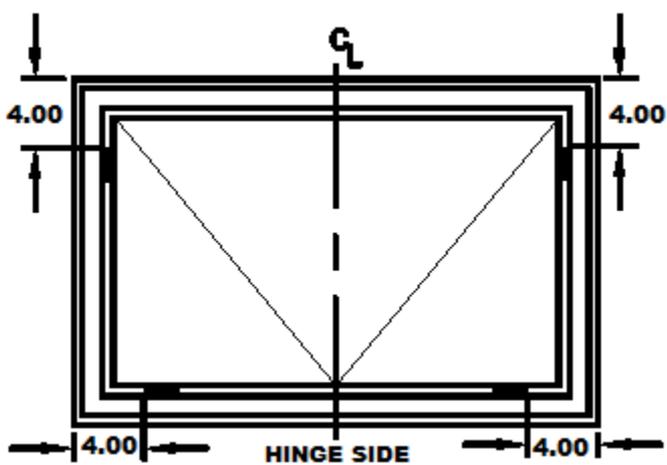


Figure 9: Tilt & Turn Hopper

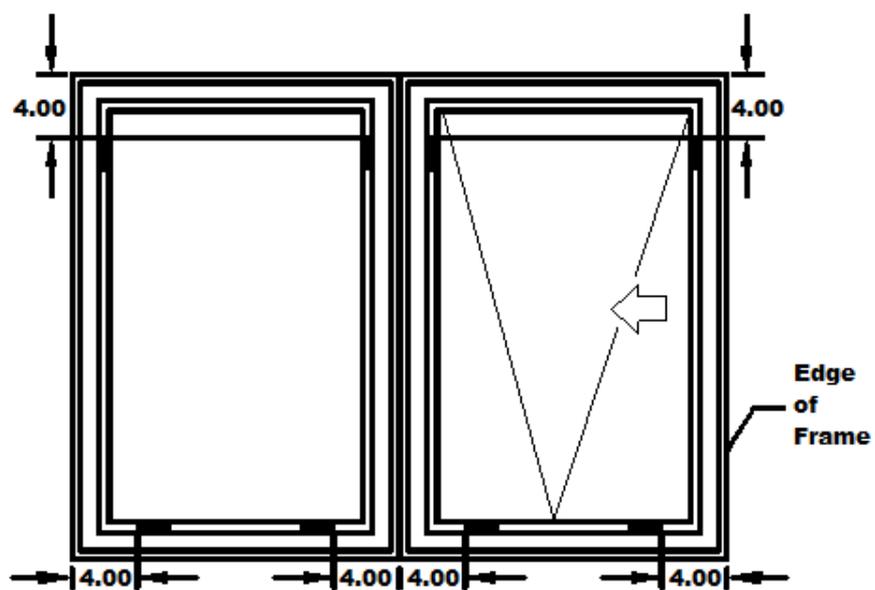
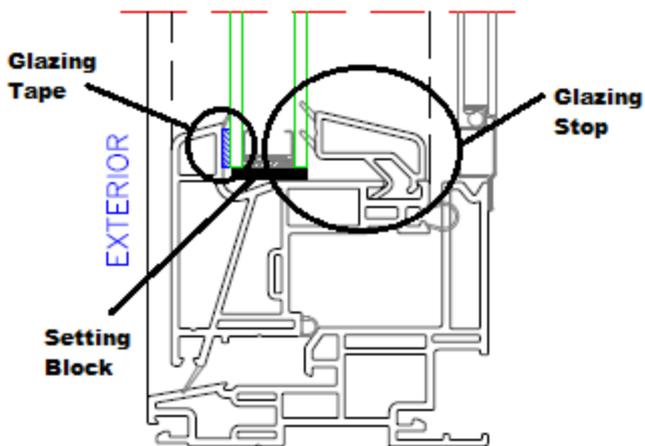


Figure 10: Tilt & Slide

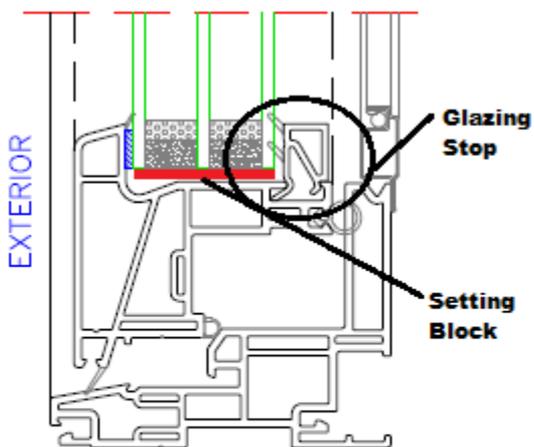
Glazing Stop Guide

Cross Sections



OPERATOR/FIXED DUAL
GLAZING OPTION ($\frac{3}{4}$ " OA)

Figure 11: Dual Glazed Supreme Casement



OPERATOR/FIXED TRIPLE
GLAZING OPTION ($1\frac{3}{8}$ " OA)

Figure 12: Triple Glazed Supreme Casement

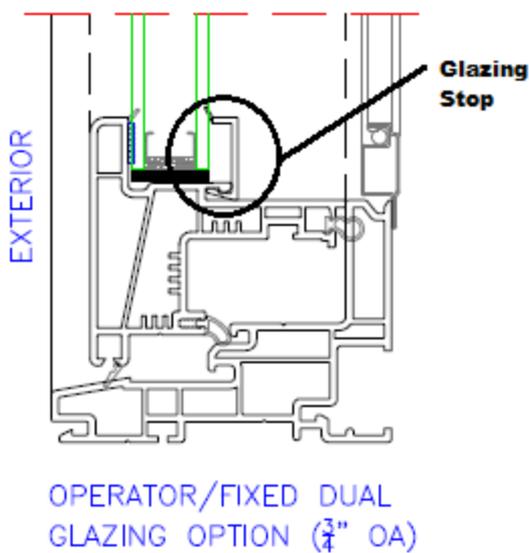


Figure 13: Dual Glazed Select Casement

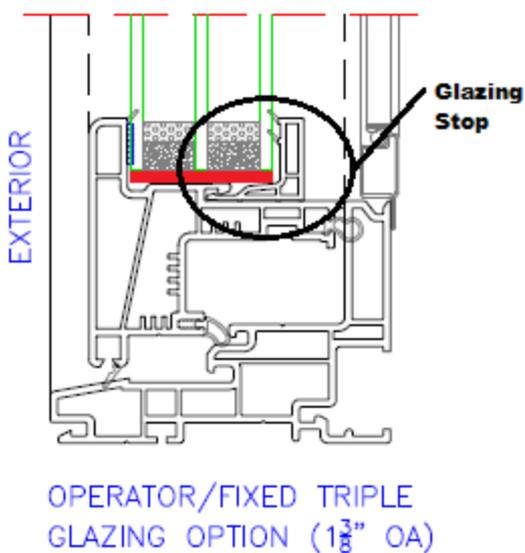
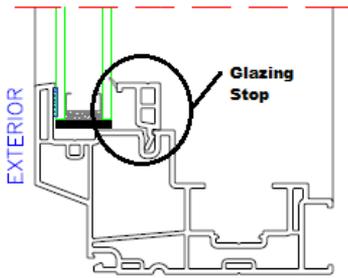
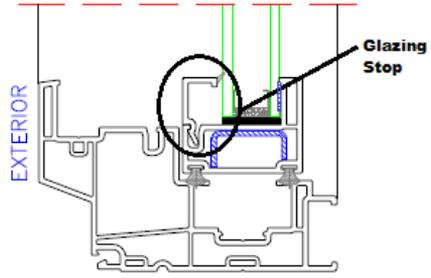


Figure 14: Triple Glazed Select Casement

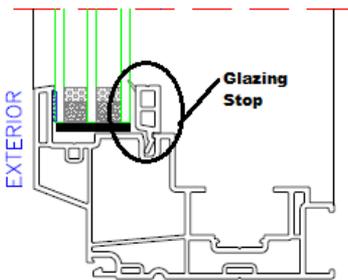


FIXED DUAL GLAZING
OPTION ($\frac{3}{4}$ " OA)

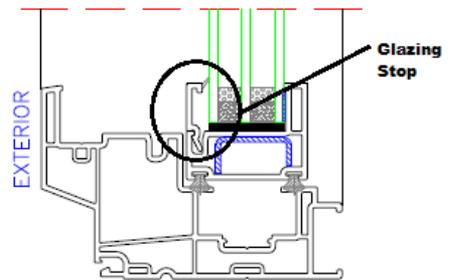


OPERATING SASH
DUAL GLAZING OPTION ($\frac{3}{4}$ " OA)

Figure 15: Dual Glazed Supreme Single Hung/Single Glider



FIXED TRIPLE GLAZING
OPTION (1" OA)



OPERATING SASH
TRIPLE GLAZING OPTION (1" OA)

Figure 16: Triple Glazed Supreme Single Hung/Single Glider

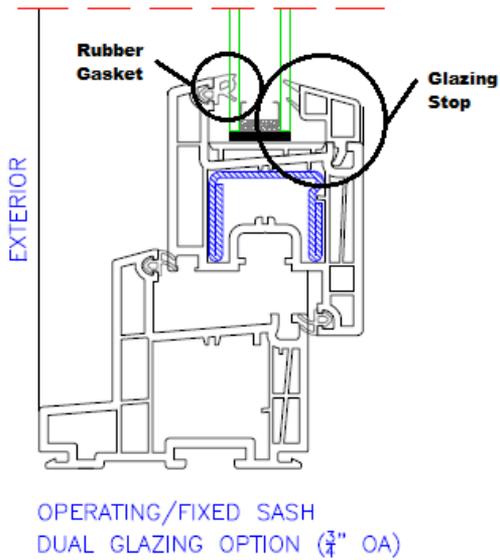


Figure 17: Dual Glazed Tilt & Turn

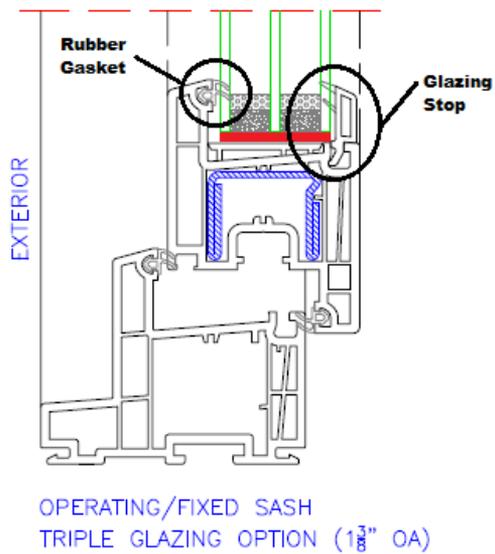


Figure 18: Triple Glazed Tilt & Turn

Deglazing

Materials Required

- Utility knife
- Putty knife
- Chisel
- Gloves
- Wrist guards

Notes

- This is a two person job. A helper is needed to help hold and remove the glass unit.
- A How-To video for deglazing can be found at www.Kohltech.com/resources

Instructions

1. First remove the glazing stops, starting with the heights and then the widths.
2. Cut through the heal bead. The heal bead will be 6" down each side and across the bottom on the interior of the unit. This step will be skipped if your unit was Compression Glazed.
3. Cut through the caulking at the setting block locations.
4. Have your helper on the interior of the unit hold the glass in place.
5. From the exterior of the window slide the utility knife between the vinyl and glass unit. At least 1" of blade will need to be showing to completely break the seal.
6. Cut all along the perimeter of the unit.
7. Slowly apply pressure to the top of the unit to remove it from the frame. Ensure your helper is there to stop the glass unit from falling out of the frame.
8. Have your helper grab the glass unit and completely remove it.
9. Remove the left over caulking or glazing tape using a utility knife, putty knife, or chisel.
10. Remove all setting blocks.
11. Ensure there is no debris in the glazing tower.
12. Go to Page 1 for further Glazing Instructions.