



**WINDSOR**  
WINDOWS & DOORS  
A WOODGRAIN MILLWORK COMPANY

## **PINNACLE / LEGEND ZERO MULL ASSEMBLY SPECIFICATIONS**

**Excellent Choice**

### **Purpose:**

The purpose of this document is to describe the method in which to assemble and seal mulled Pinnacle Clad units. The document is used by Production Operators to perform the job tasks and to train Operators on the proper procedures. Adherence to this procedure provides a quality product to our customers.

### **Equipment:**

1. Silicone Gun
2. Screw Gun
3. Hammer
4. Wood/UHMW Block
5. Corrugator Staple Gun
6. Jamb Extension Staple Gun
7. Interior Mull Cover Staple Gun
8. Gusset Plate Staple Gun
9. Bar Clamp

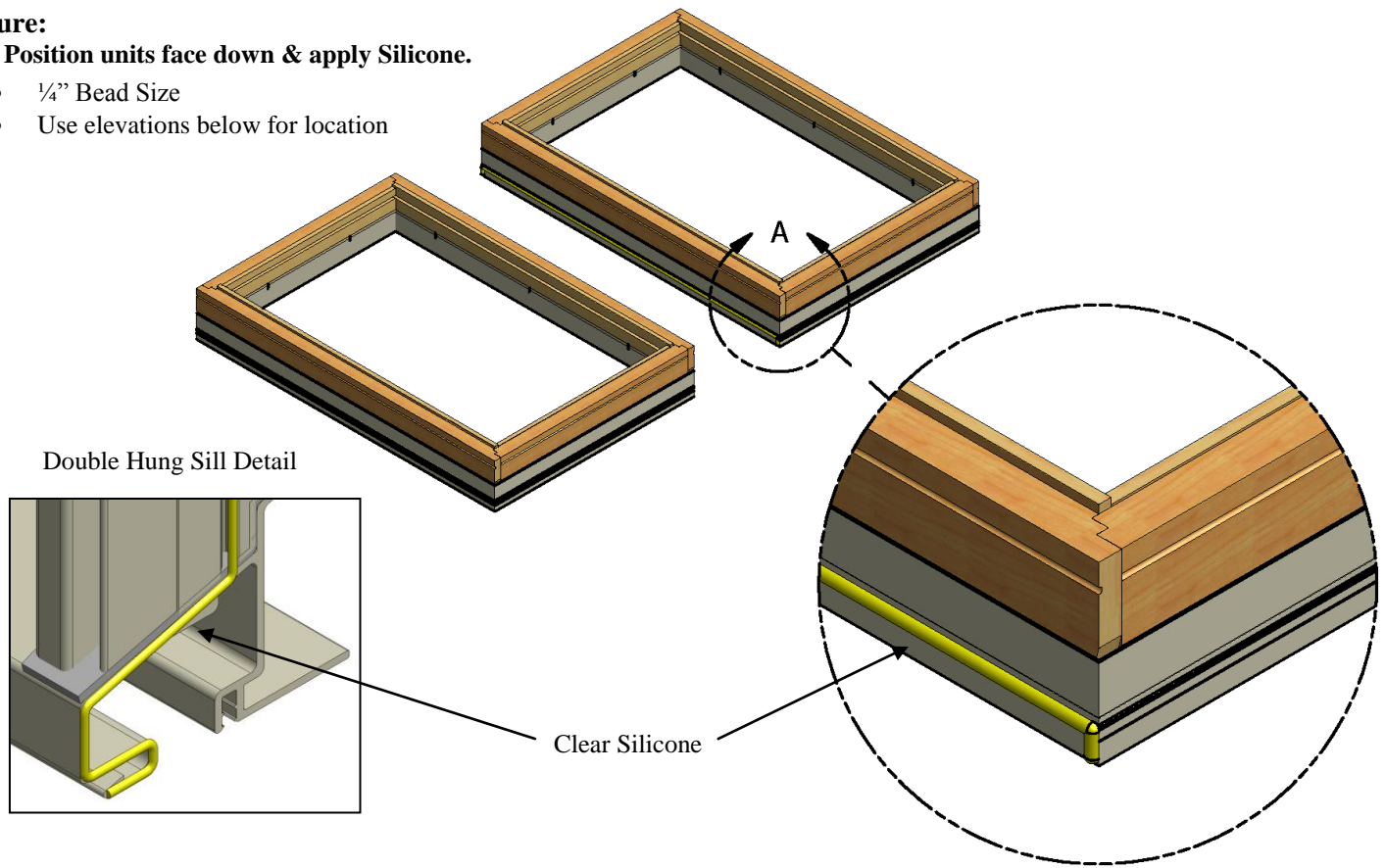
### **Materials:**

1. Units to be mulled
2. Exterior Mull Cover
3. Interior Mull Cover
4. Jamb Extension (If Applicable)
5. ½" Corrugator Staple
6. ¾" or 1" 18 Ga. Brad Nail
7. ¼" x 1 ¼" Crown Staple
8. Clear Non-Beaded Silicone (PN: 798018)
9. 2 x 10 Gusset Plate (PN: 510065)
10. Gusset Plate Staple (PN: 518013)
11. Packaging (See Packaging SOP)

**Procedure:**

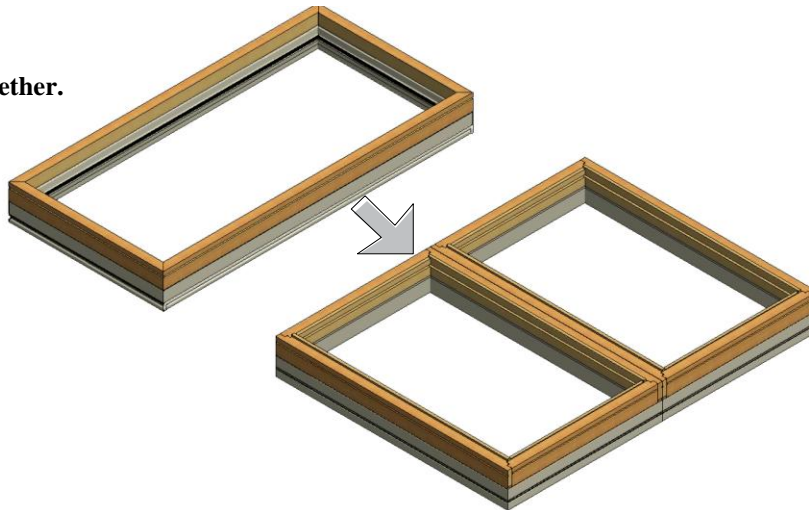
**1. Position units face down & apply Silicone.**

- ¼" Bead Size
- Use elevations below for location

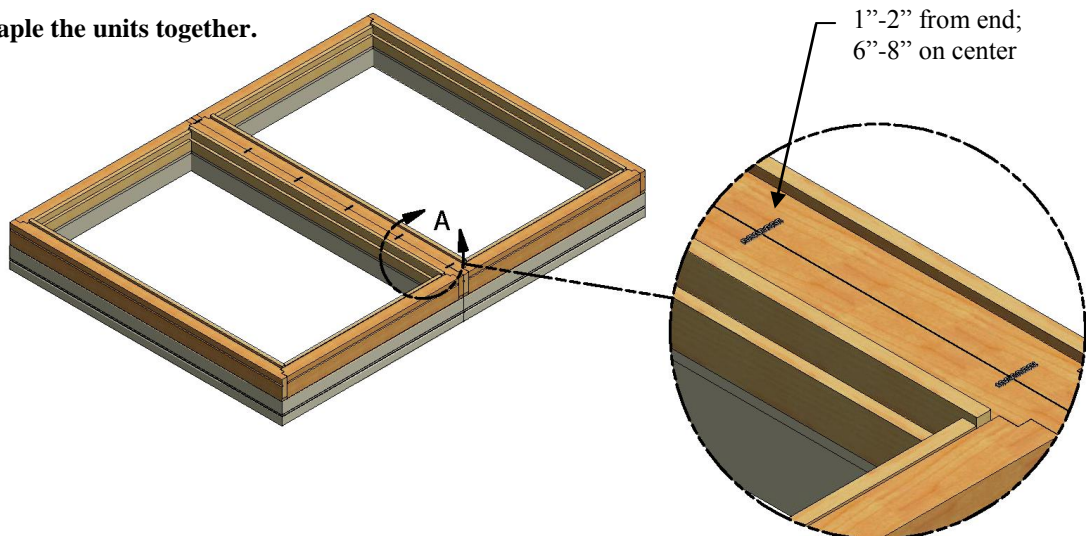


**2. Position the units together.**

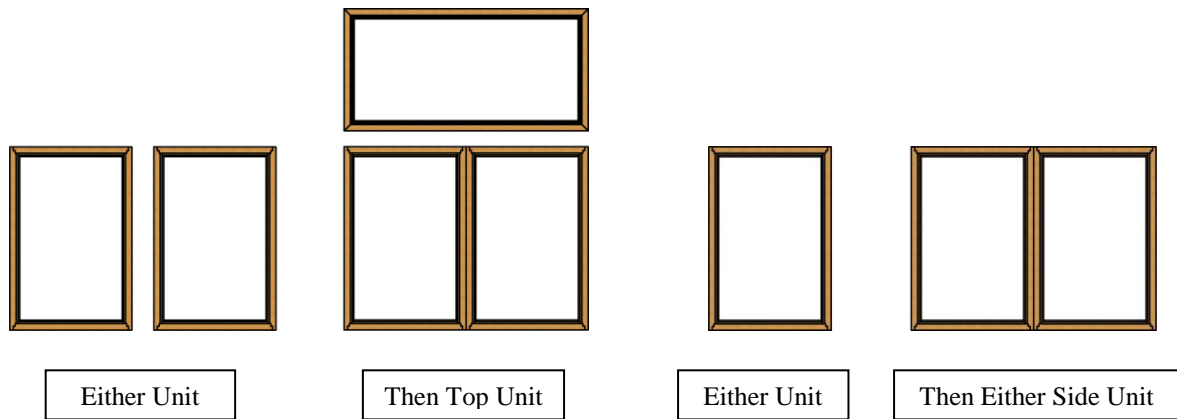
- Each side is flush
- No gaps at mull



**3. Corrugate staple the units together.**



4. Follow the elevation guideline below.



5. Apply jamb extension.

- Run the sill/head JE through
- Flush to outside edge (except std. casement)

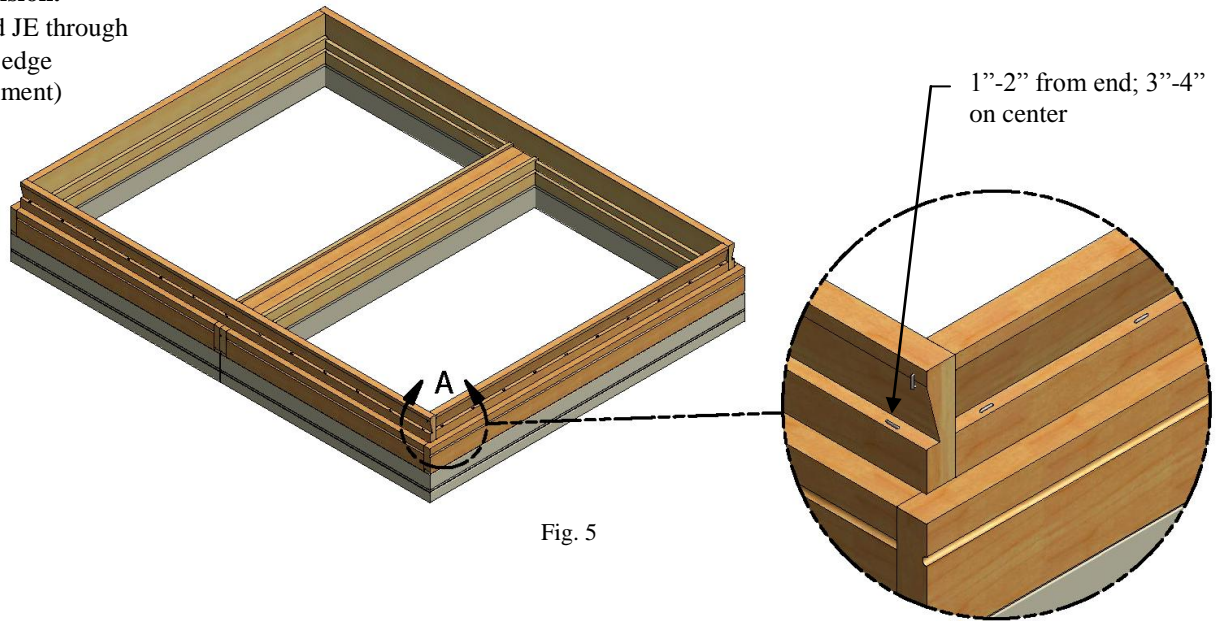
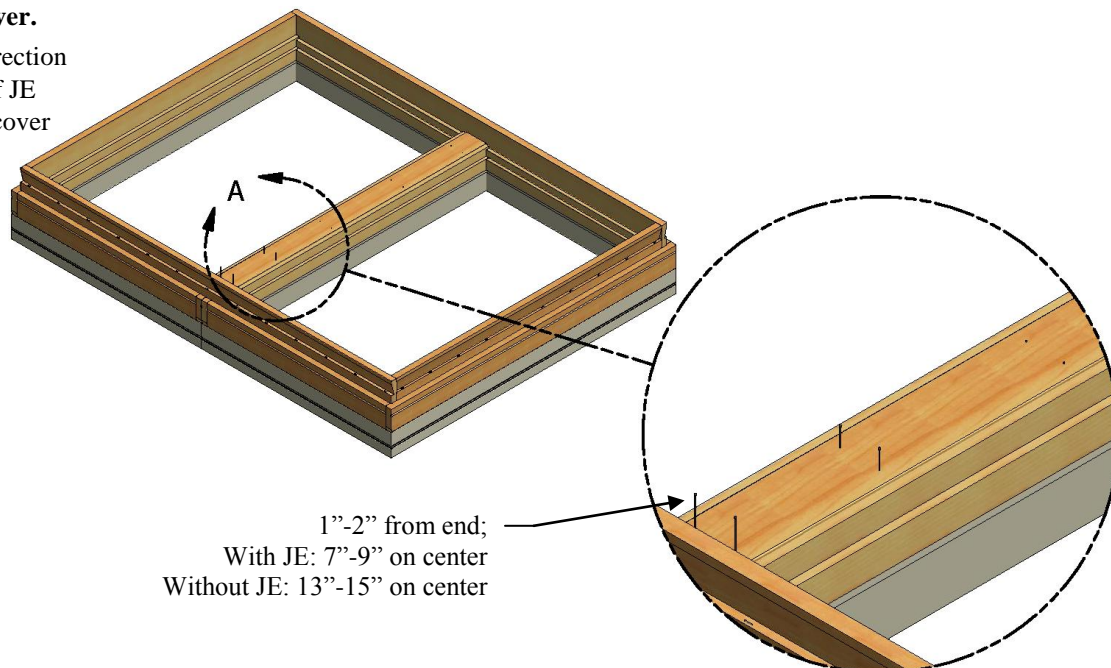


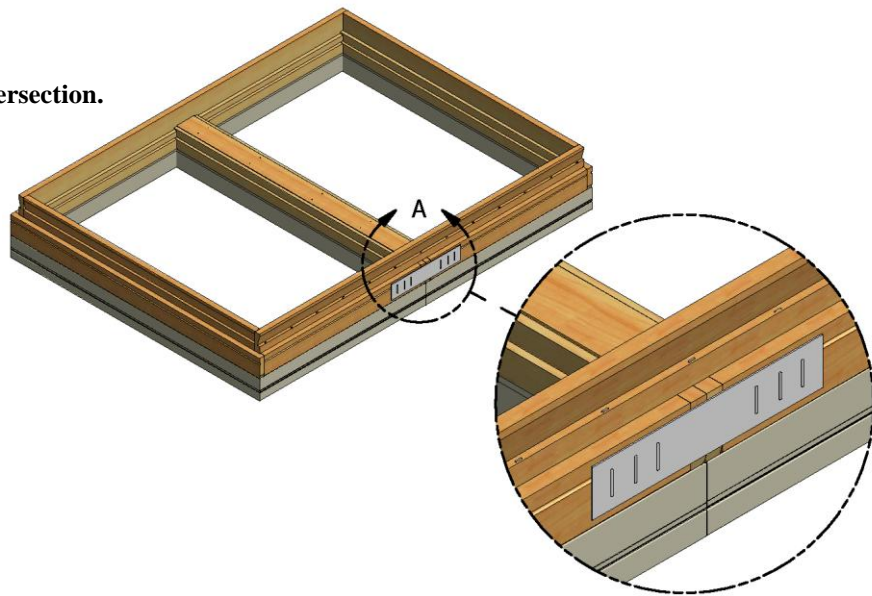
Fig. 5

6. Apply the interior mull cover.

- Continuous in Vertical Direction
- Terminate at inside face of JE
- No Jamb extension: mull cover equals mull length



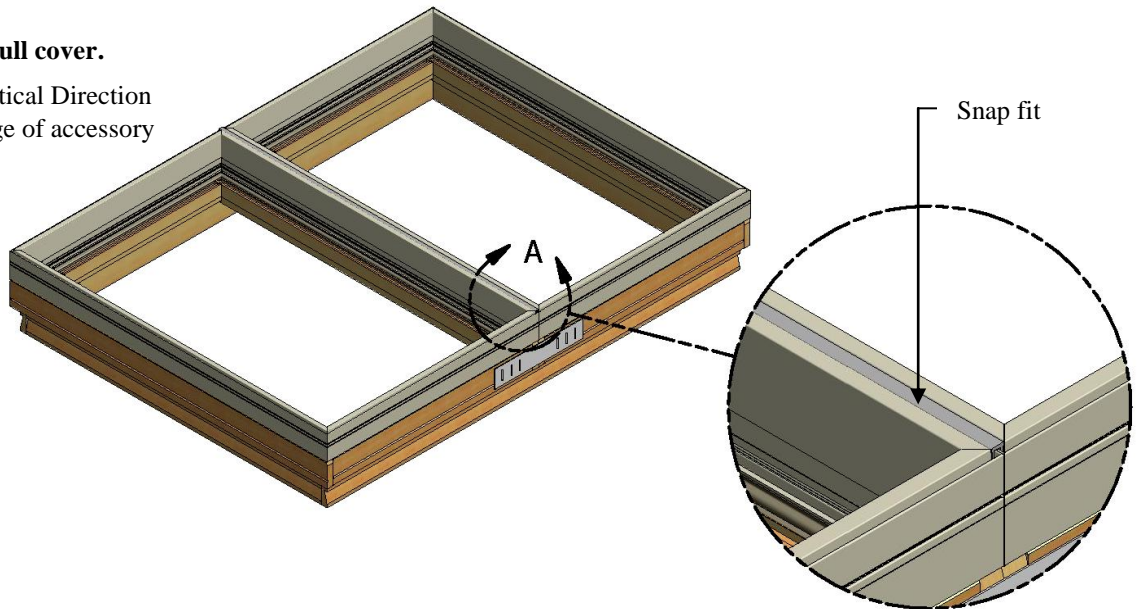
7. Apply gusset plate at mull intersection.



**Clad Procedure:**

8. Cut and apply the mull cover.

- Continuous in Vertical Direction
- Flush to inside edge of accessory groove

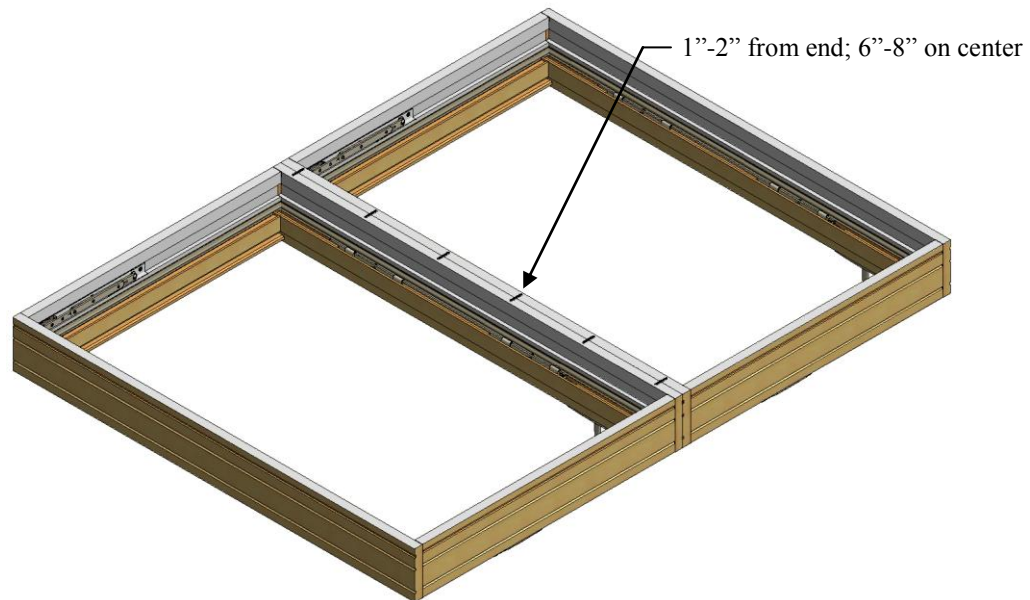


**Primed/Legend Procedure:**

9. Corrugate the exterior mull.

- Apply 1/4" bead of silicone along joint after corrugated – Tool in.

10. Apply brickmould.



11. Apply exterior mull cover.

- 2" 16 ga. nails side-by-side

