



MB-79

INSTALLATION INSTRUCTIONS



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1. Safety & handling

Safety

- Before commencing any work, thoroughly read and comprehend all manufacturers' instructions.
- It is imperative not to work alone. Ensure that two or more individuals are present. Utilize proper lifting techniques to prevent injury.
- Use caution when handling glass. Broken or cracked glass can cause serious injury.
- Always wear appropriate protective gear such as safety glasses, gloves, and a hard hat.
- Operate hand/power tools safely, adhering strictly to the manufacturer's operating instructions. adhering strictly to the manufacturer's operating instructions.
- Exercise caution when working at elevated heights

Materials and Window Handling

- Ensure that operable windows are securely locked prior to installation.
- Adhere strictly to material manufacturers' handling and application instructions.
- Protect adhesive surfaces from dirt, moisture, direct sunlight, and folding over onto themselves.
- Handle materials in a vertical position; avoid carrying them flat or dragging them along the floor.
- Avoid placing stress on joints, corners, or frames.
- Store windows in a dry, well-ventilated area in a vertical, leaning position to facilitate air circulation. Do not stack them horizontally.
- Shield windows from direct sunlight during storage
- Install only into vertical walls and when conditions and sheathing are dry.

2. Product Arrival at site

Before delivery arrives at your project, review all existing documents from the manufacturer, namely: project drawings, installation instructions, and shipment list, etc.

Ensure the vehicle is parked taking into consideration safe access for the customer. Permission to park on drives should be obtained from the customer after introduction. The lead/foreman installer should ask to be shown around the property, drawing to the attention of the customer the removal of any furniture, fixtures or fittings that may otherwise be damaged during the installation. The lead installer should discuss and agree with the customer the installation schedule of works. The installers shall conduct themselves in a polite, courteous and professional manner at all times.

3. Offloading

Our delivery process involves live offloads, where the truck driver waits during the unloading of the container/trailer

Please be aware that most trucking companies offer only two to three hours of free offloading for your freight. If you anticipate offloading taking longer than three hours, please inform us in advance.

Note that some items can be loosely packed, especially if they are too large to fit on a pallet. Loose items will require manual offloading, which can increase the risk of damage

To expedite the ordering of any replacement items that had been damaged while shipping, please follow the following procedure:

1. Upon opening your container/trailer or receiving a crate, mark any observed damages on the driver's paperwork.
2. If possible, photograph any crate and pallet damage while they are still in the container/trailer
3. Remove the damaged items from the container and place them aside in their original packaging.
4. Once secured, photograph the damaged items within their original packaging. Do not remove the original packaging until after submitting the damaged photos to ILKORN INDUSTRIES.
5. Contact ILKORN LLC via email (shipping@ilkorn.us) within 24 hours of offloading your container and ensure to attach the photos of any damage.

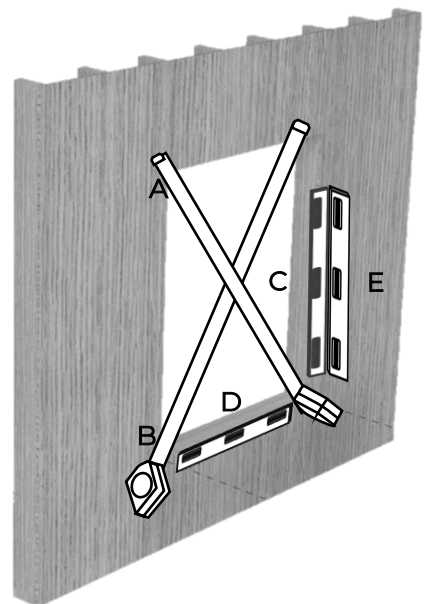


Unpacking and Inspection Guidelines

- Unpack the window carefully, removing all shipping materials such as corner covers, shipping blocks or pads.
- Do not remove any protective film on the glass until installation and construction are complete.
- Thoroughly inspect the window for any cosmetic damage, ensuring there are no splits, cracks, holes, missing sections, or other damage to the nail fin longer than 6" and/or within 1/2" of the window frame.
- Check for product squareness by measuring diagonal lengths, ensuring they do not differ by more than 1/8".
- Verify that the window is the correct product in terms of size, color, grid pattern, handing, glazing, and energy efficiency requirements.
- For side-by-side mulled units, ensure there is a drip cap that extends the length of the frame plus a 1/8" overhang on each end.
- If any of the above conditions raise concerns or if you anticipate environmental conditions that may exceed the window's performance rating, refrain from installing the window. Instead, contact your dealer or distributor for recommendations.

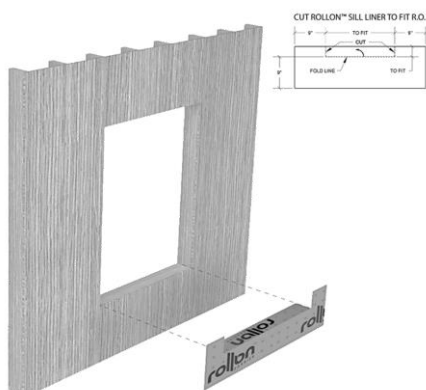
4. Inspect rough opening

- Verify that the rough opening is the correct size to assure that the window will fit in the opening. (Rough opening should be $\frac{7}{8}$ " bigger than the window's net width and height).
- Verify the rough opening is square. The (A) and (B) measurements above should be the same. maximum allowable deviation from square is $\frac{1}{8}$ " for windows 20 sq. ft. and smaller, and $\frac{1}{4}$ " for windows larger than 20 sq. ft. Verify Square, Level, & Plumb
- Verify the rough opening is level and plumb (C) and (D). The maximum allowable deviation is $\frac{1}{16}$ " for every 2' of rough opening (not to exceed $\frac{1}{8}$ ").
- Verify the rough opening is level and plumb (C) and (D). The maximum allowable deviation is $\frac{1}{16}$ " for every 2' of rough opening (not to exceed $\frac{1}{8}$ ").
- The rough opening sill must not be crowned or sagged (D).
- The exterior face of the rough opening must be in a single plane (E) with less than $\frac{1}{8}$ " twist from corner to corner.
- Verify the header is supported by trimmer studs.



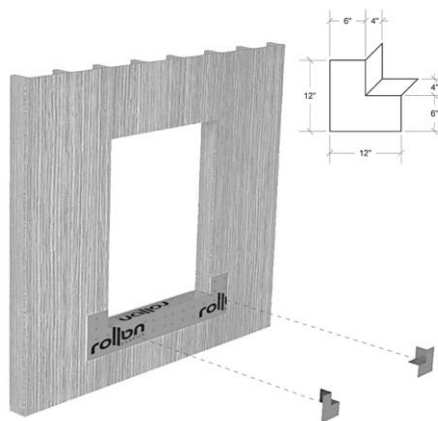
5. Pre-wrap installation

Install rollon™ sill liner to sill of R.O.
Leave bottom of liner loose to
allow primary rollon™ to be inserted
underneath.



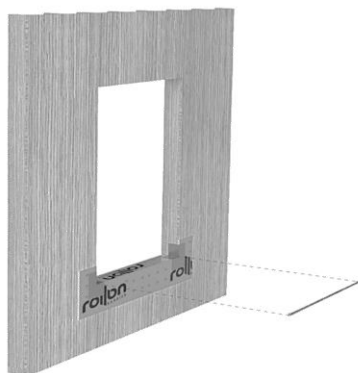
Step #1

Apply rollon™ corner to sill jamb of
R.O. over sill line.



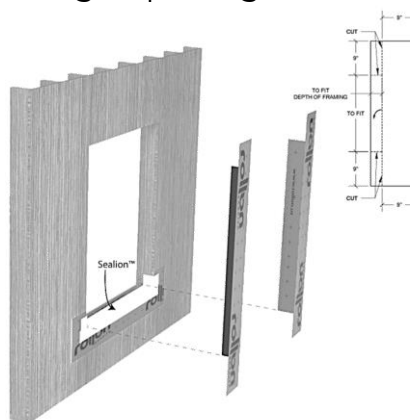
Step #2

Install L-angle in R.O.



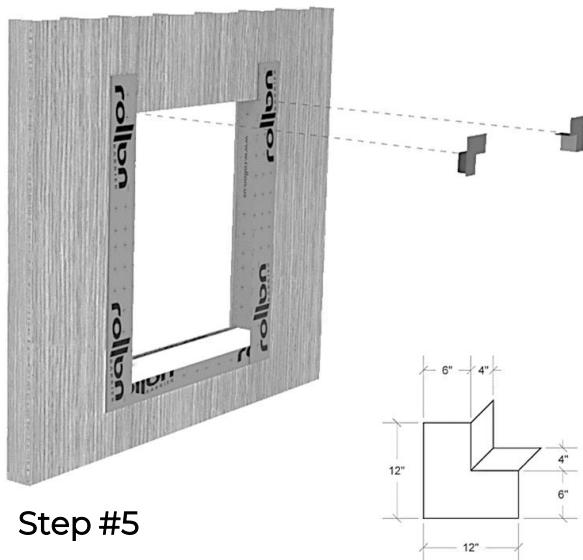
Step #3

Apply Sealion™ butyl tape flashing.
Apply rollon™ jamb liner to jamb of
rough opening..

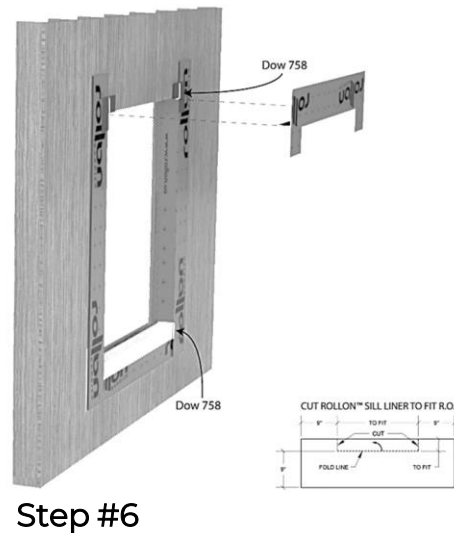


Step #4

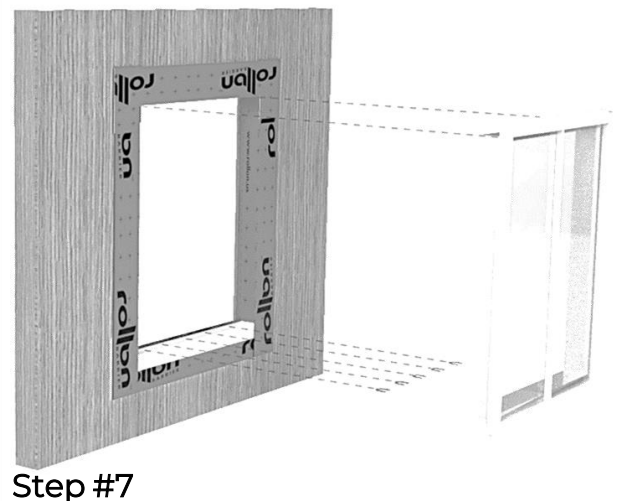
Apply rollon™ sill corner to sill jamb of R.O. over sill liner.



Apply rollon™ head liner to head or R.O. wrap into R.O. Apply sealant at all seams.



Install minimum 1/8" shims. If sill is not level use high compression strength plastic shims across the entire sill to prevent sagging and insert the window into the opening. Use shims as necessary to adjust the window so that it is plumb, level, and square in the opening. A shim should be placed 6" from each jamb to support the window. Shims should be no more than 6" apart in order to fully support window



6. Windows/doors installation

WARNING! To avoid injury, use at least two people to install. Adequately support the window until completely fastened

1. If windows are block frame windows, snap in installation clips into the jamb of the frame and secure with 1" #10 self-drilling screw (galvanized or stainless steel).

Clip spacing:

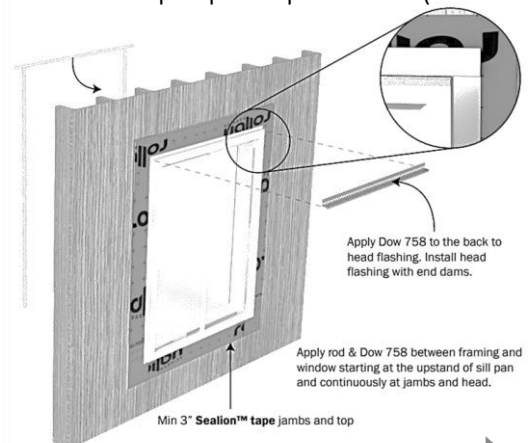
6" from each corner + 16" on center (aluminum);

6" from each corner + 12" on center (PVC);

For aluminum doors, needed additional fixation of the frame with metal anchors ($\frac{3}{8}$ " for concrete)/screws (#10 for wood) max 4" from the hinges. All fixing elements must be galvanized or stainless steel.

The bottom side of the window must be fixed to L-angle using #10 $\frac{3}{4}$ " self-drilled screws (galvanized or stainless steel).

2. Run a continuous $\frac{3}{8}$ " bead of sealant around the interior side of the nail fin where it will contact the rough opening
3. Place the window sill onto the shims on the sill and tilt it into the rough opening. The window sill must rest on and be fully supported by the rough opening (for the door shims fillment - 50%, for windows - 6" from the corner, 12" on center).
4. Fasten the window with a galvanized or stainless steel screw through the nail fin/clips 6" from one lower corner.
5. Inspect the window for square, level, and plumb. Test for proper operation (remove and reinstall if necessary).
6. Install Sealion tape jambs and top
7. Create a continuous air seal on the interior by integrating the rough opening and the window frame with low expansion polyurethane foam or backer rod and sealant.
8. Ensure weep holes/channels are clear of debris for proper water drainage. do not seal weep holes/channels.



7. Adjusting

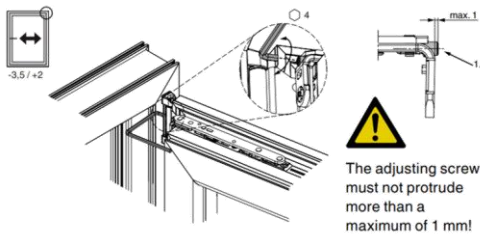
Adjust window for best operation.

Adjustment values are always specified in regards to the hinge-side air gap and/or the bottom horizontal air gap.

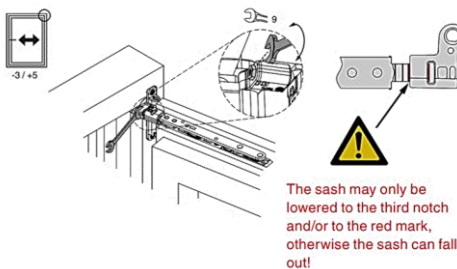
Setting scissor stay or turn-only hinge

1. Lift/lower

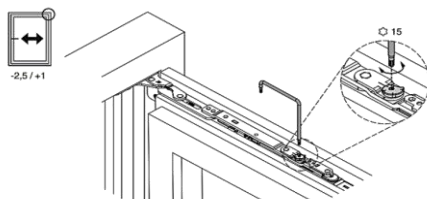
- MULTI-MATIC / MULTI-TREND corner hinge version



- MULTI-MATIC / MULTI-TREND stay and hinge

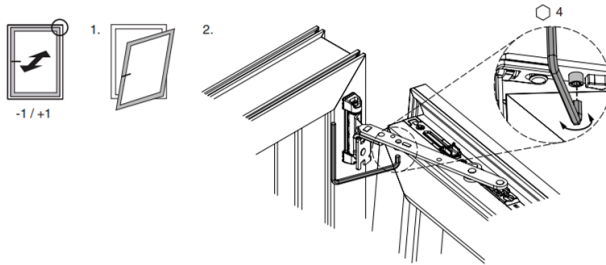


- MULTI POWER

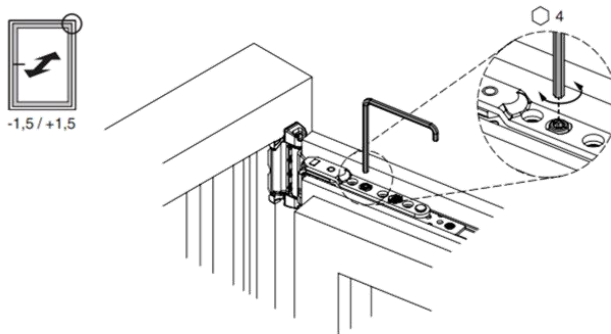


2. Gasket compression

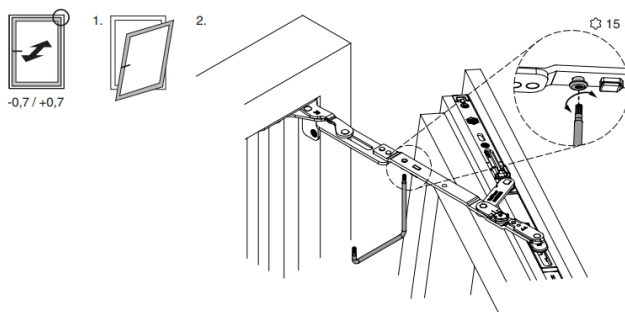
- MULTI-MATIC scissor stay



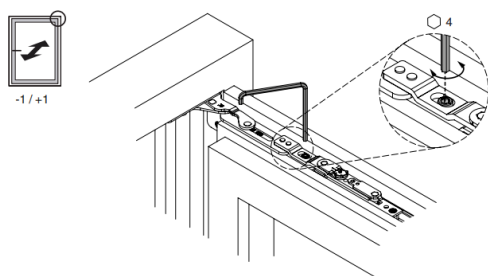
- MULTI-MATIC turn-only hinge - sash part



- MULTI POWER scissor stay

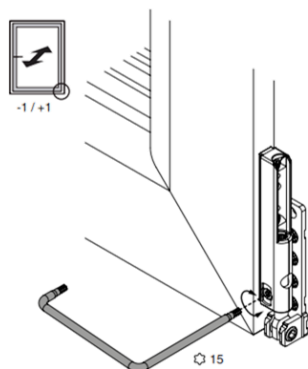
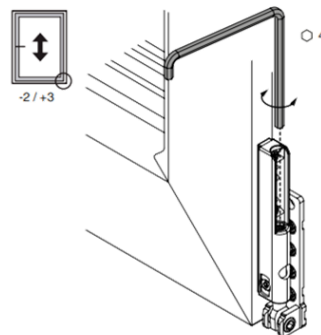
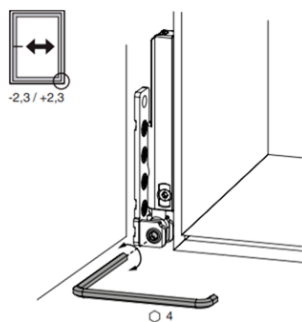


- MULTI POWER turn-only hinge - sash part

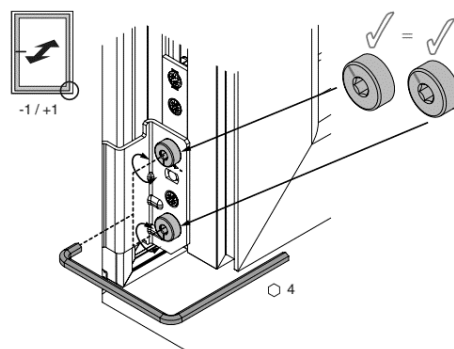
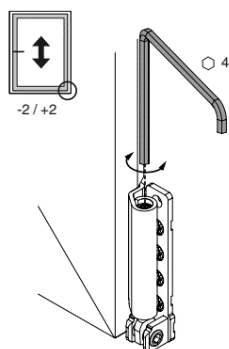


Pivot post setting

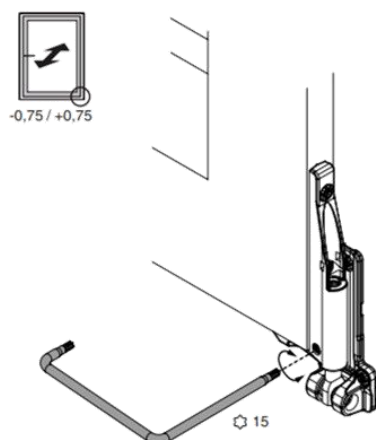
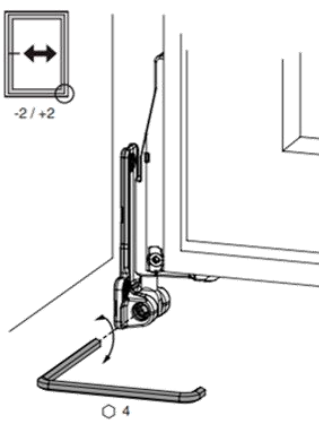
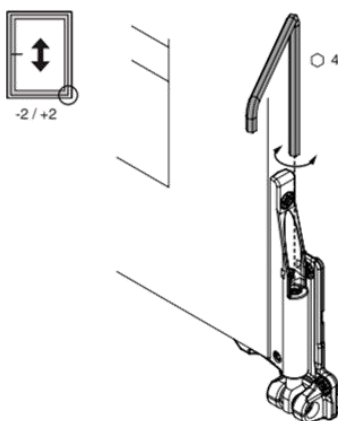
- PVC / DT / TO / AS pivot post



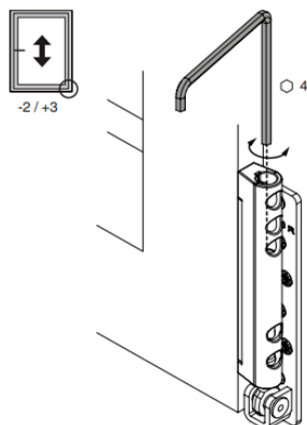
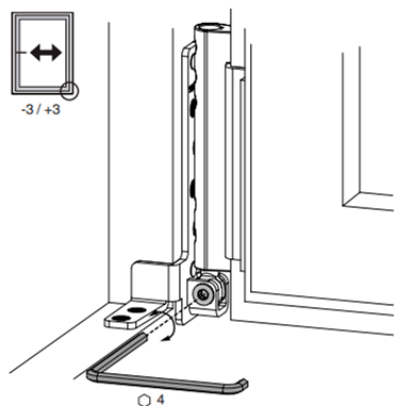
- PVC / AS rebated corner support



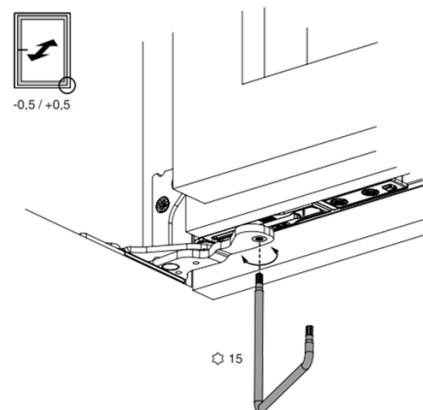
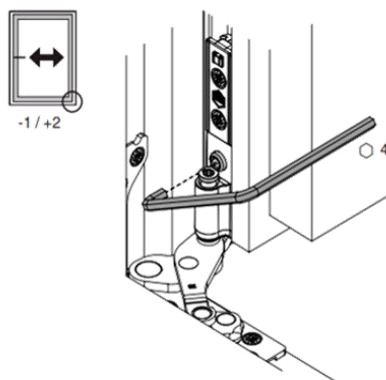
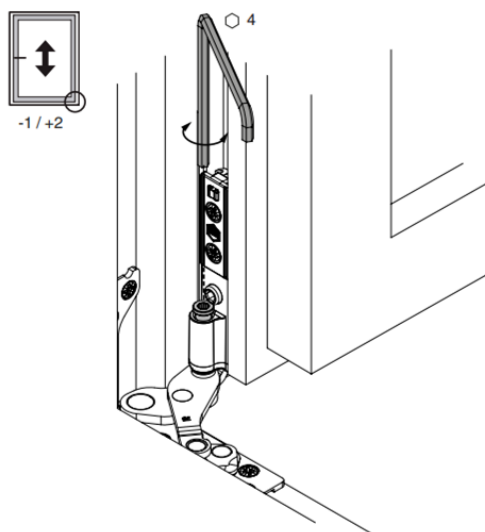
- Drill-in pivot post



- MULTI MAMMUT pivot post

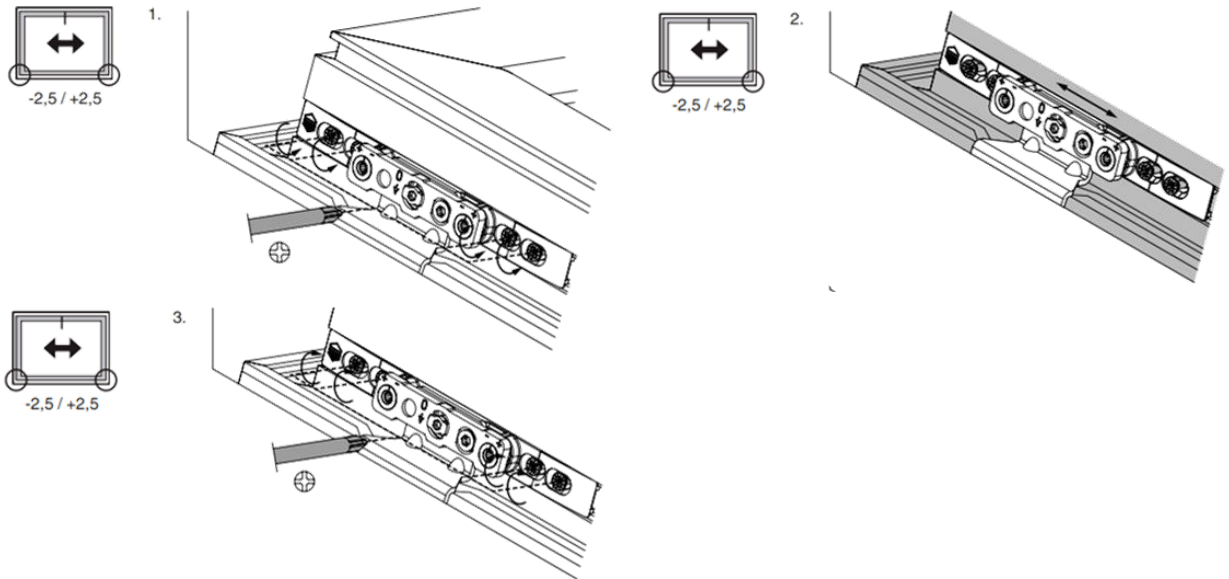


- MULTI POWER pivot post

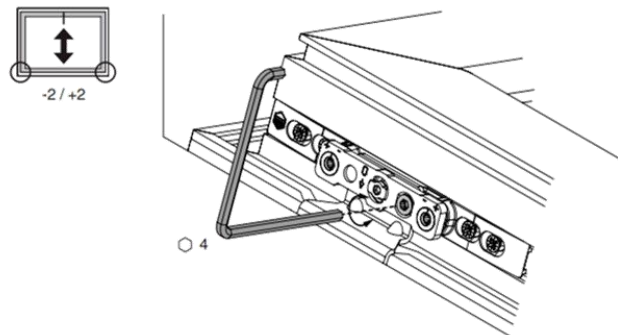


Tilt-only sash setting

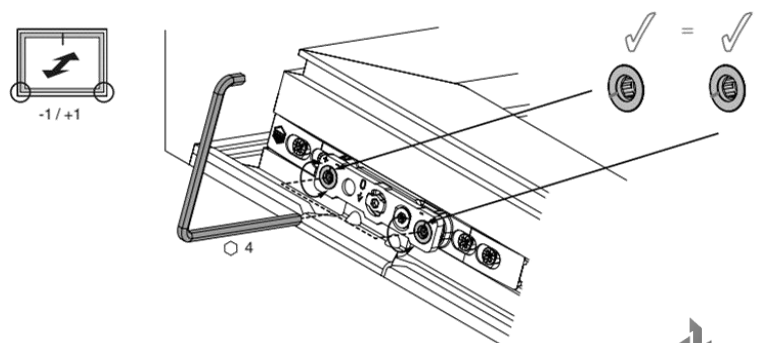
- Side adjustment



- Lift/lower

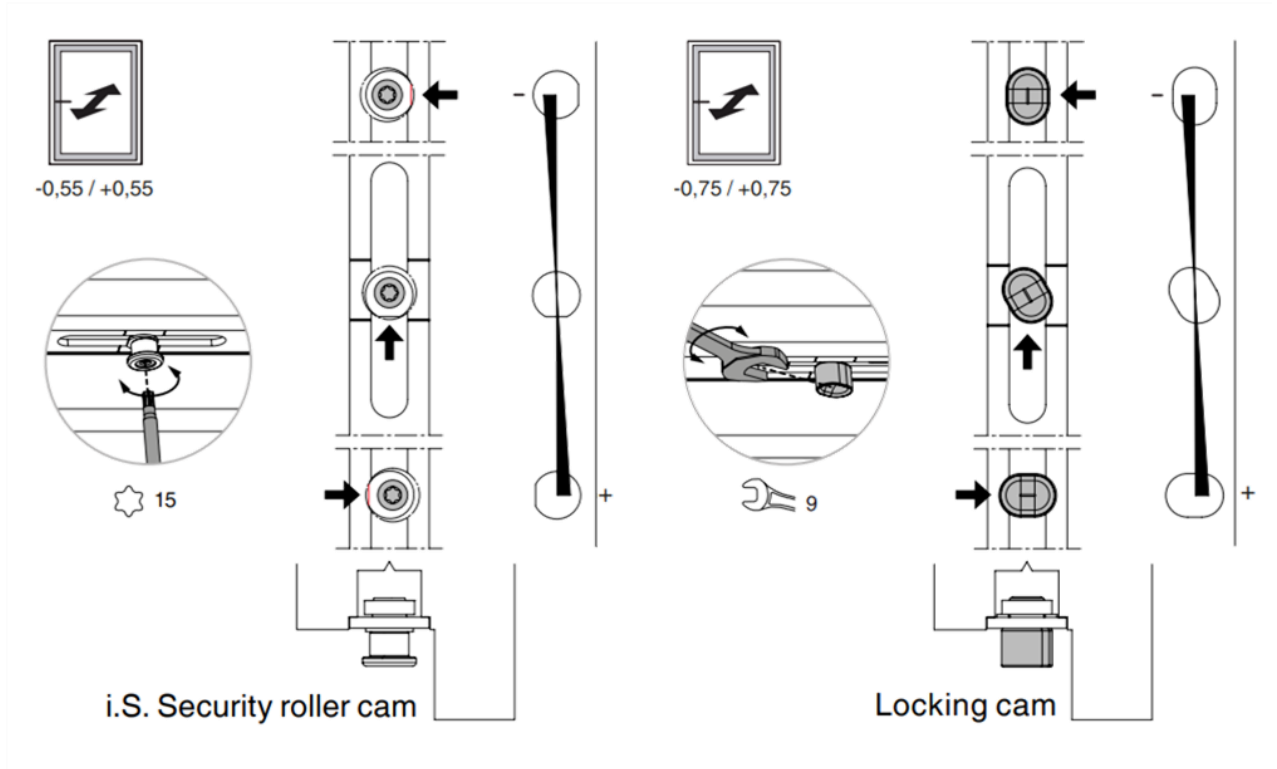


- Gasket compression

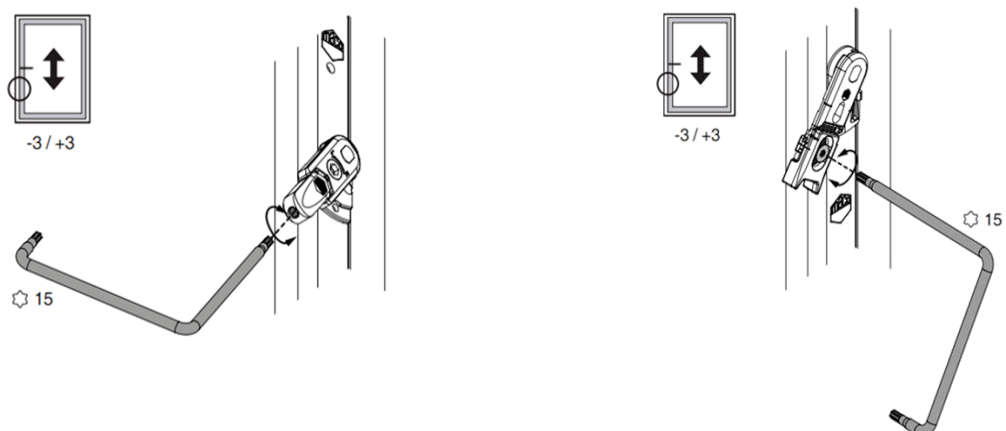


Setting the closing element, the bullet catch and the sash lifter

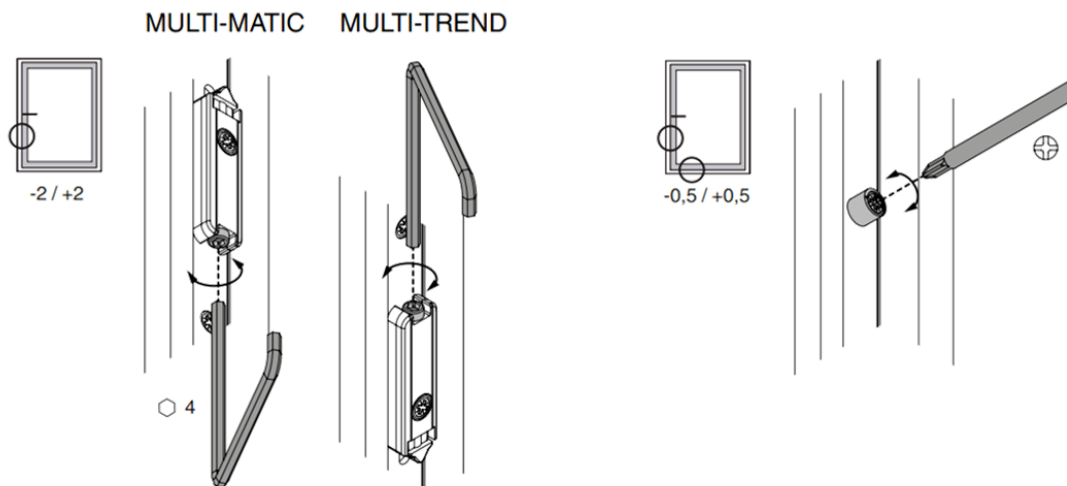
- Setting the gasket compression on the cam



- Setting the sash lifter

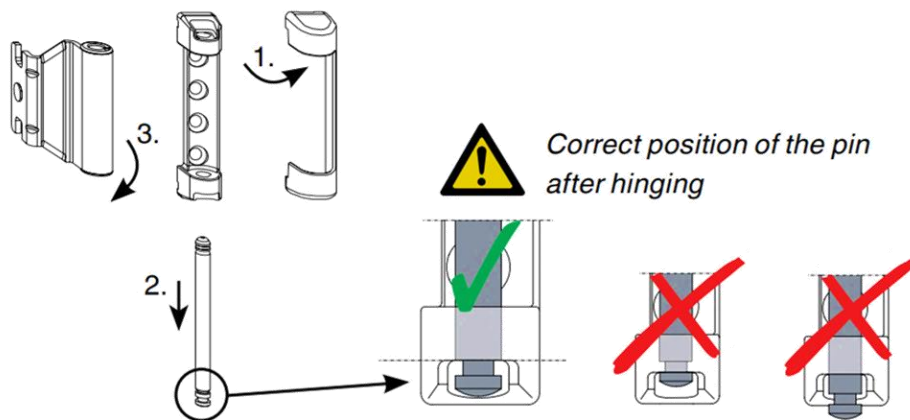


- Setting the door catch and/or the bullet catch roll



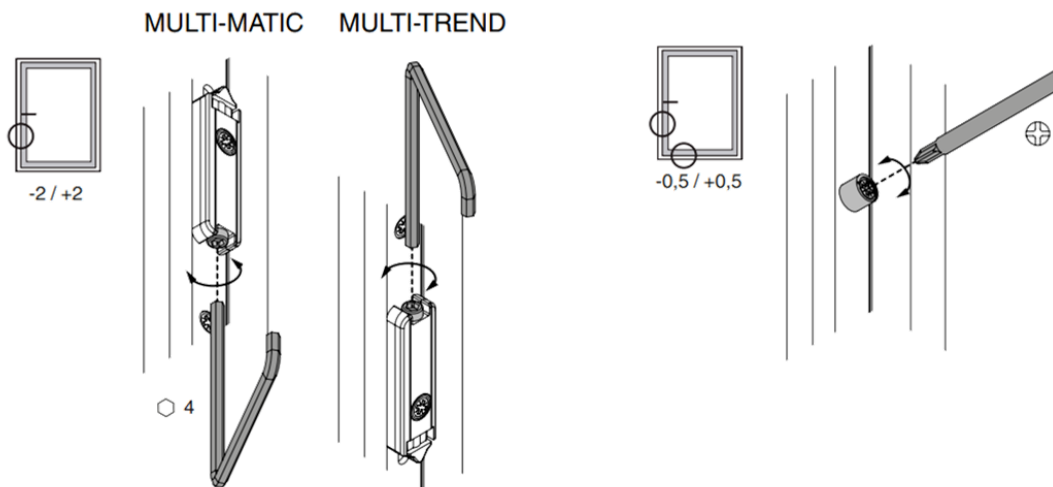
Hinging and unhinging the sash

- MULTI-MATIC / MULTI-TREND scissor stay hinge – PVC / DT / AS



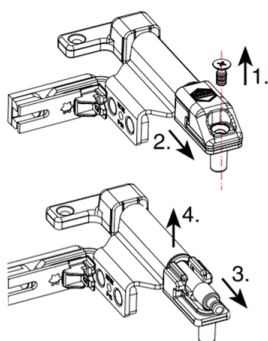
1. Remove the cover, if there is one.
2. Pull the scissor stay-hinge pin downwards with a suitable tool. The scissor stay hinge pin can only be withdrawn when the window is closed.
3. Open the sash 90° (secure against tilting on the espagnolette side), move the rebated scissor stay support arm out of the scissor stay hinge and lift the sash out of the pivot post. For hinging, carry out the above steps in reverse order.

- Setting the door catch and/or the bullet catch roll



Hinging and unhinging the sash

- MULTI MAMMUT scissor stay hinge



Remove the locking screw.

2. Remove the scissor stay hinge pin.

3. Pull the scissor stay hinge pin downwards and open the sash 90°.

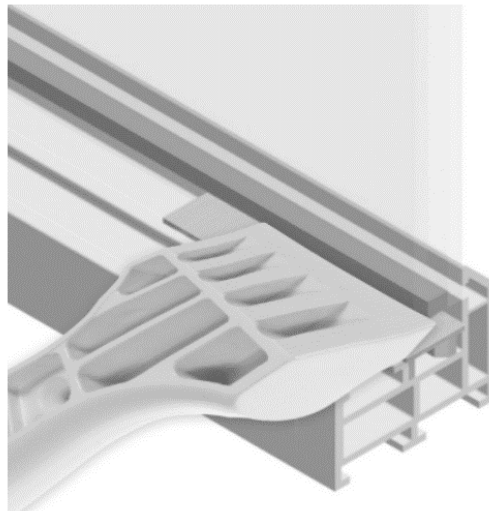
4. Move the rebated scissor stay support arm out of the scissor stay hinge and lift the sash out of the pivot post. For hinging, carry out the above steps in reverse order.



It is essential that the scissor stay hinge pin is installed.

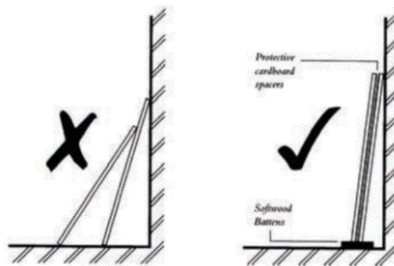
8. SITE DE-GLAZING

Beads are removed by simple insertion of a putty knife and whilst pushing the bead towards the glass, lightly twist knife to force the bead out to its retaining channel



Hinging and unhinging the sash

When glass units are temporary taken out of the frame or are supplied separately and subsequently stored in site conditions, it is advisable to store them upright on softwood battens with cardboard spacers between the units to avoid any damage. When handling larger glass units, the use of suction pads is recommended. Special attention must be given when glazing on site in colder climatic conditions due to the inherent brittleness of the glass units and the increased stiffness of the rubber glazing seals

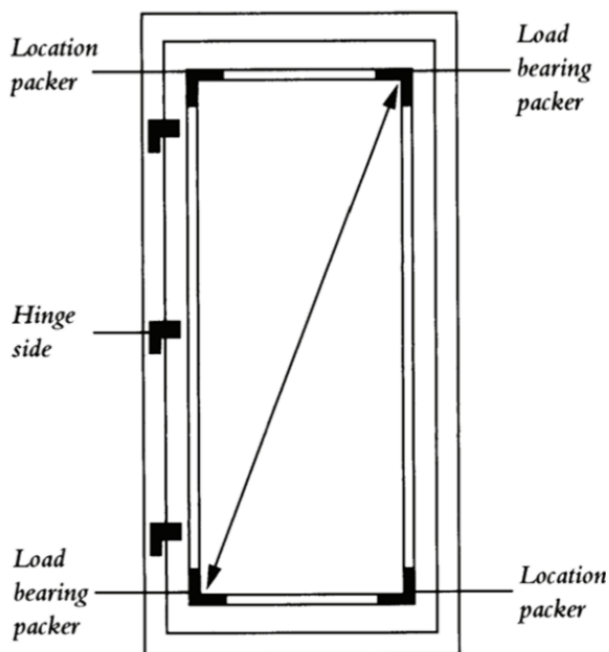


Recommended site storage of glass units

Glazing packers

The use of glazing packers is essential to allow the windows or door-sets to function properly. The recommendations for packer locations must be followed. It is of particular importance for glazing units that will be 'Toe and Heeled'

- This procedure ensures that the weight of the glazed unit is correctly supported and does not distort the frame, nor result in the opening light dropping. This affects all side hinged leaves, such as side hung windows, tilt & turn windows and hinged doors, packers should be inserted opposite locking points to aid security
- The interlocking packers **MUST** be adjusted until the frame diagonals are equal. It is recommended that the load bearing packers and location packers are secured in the 'final' position with silicone to prevent them working loose during operation. Care must be taken not to block drainage routes



Toe and Heel principle

9. INSTALLATION COMPLETION

Finishing off and making good

All protective films placed on the profiles during extrusion should be removed as soon as the installation is finished and prior to sealing the perimeter joints.

Final check and customer product awareness

After installation, a final inspection should be carried out to ensure that the installation is of the highest standard. It is good practice to ensure that the customer is familiar with the method of operation of the installed windows and door sets operating features such as opening, key locks, shoot bolts and latches should be demonstrated so that the customer knows how to use them. This is especially important in the case that may be used in fires. Such training is best supplemented with written operating and maintenance instructions.

Cleaning and maintenance

The pristine appearance of PVC-U windows and door-sets is maintained by occasional cleaning. The frequency of this cleaning will depend on the local conditions. For instance, products installed in an industrially polluted or coastal area are likely to need cleaning more frequently. Particular care should be taken to ensure that nothing, which may cause a rust stain, comes into contact with PVC-U as rust stains are not removable. The cleaning of both gaskets and profile sections should be carried out periodically to maintain the appearance. Failure to do this will not affect the performance of the products, but will spoil their appearance. Stains that are not removable with soapy water may be removable using a domestic non-abrasive cream cleaner. However these should not be used to excess as they may affect the gloss finish. On no account should any solvent based cleaners be used without prior approval from the supplier, as some of these may seriously affect the profiles

