
SYSTEM 2200

TECHNICAL INFORMATION
GLAZING INSTRUCTIONS

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1. General Information

The quality of a completed window unit depends on the correct installation of the glass in the sash / frame. Therefore, glazing recommendations from the glass suppliers, weight limitations for the sash with reinforcements and specific hardware restrictions must be observed. Please check with the respective suppliers.

NOTE: If site glazing is performed, the window manufacturer needs to provide proper information regarding placement of shims to meet the static requirement for proper long-term performance of the window unit.

System 2200 is a dry glazed system utilizing co-extruded splines on the exterior as well as glazing stops with co-extruded flexible seals on the interior.

Before Glazing

- Check the glass unit for damage, specifically at the edges.
- **NOTICE:** Avoid glazing below 41°F (5°C) as the PVC is more brittle at lower temperatures.
- Remove the weld sprue from the internal side of the glazing upstand to avoid any pressure points on the glass edges.

During Glazing

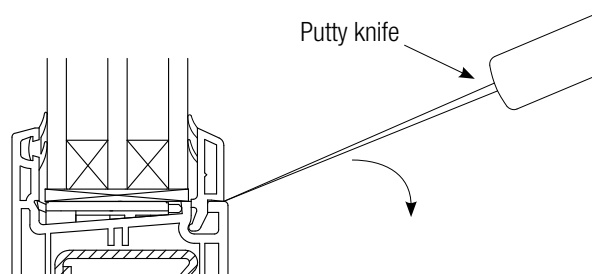
- For proper ventilation of the glazing rebate, the distance between the glass and the rebate should be at least 2 in (5 mm).

Installation of Glazing Stops

- Stops should be mitered if at all possible.
- 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 2-in (5 mm) wide, sharpened putty knife, between frame (or sash) and glazing stop, then pry stop from frame (or sash). See detail.



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2. Overview of Glazing Stops

Glazing Stop	Article Number	Miter Angle
6.5 mm	560580	25
14.5 mm	560600	19
14.5 mm contoured	561620	n/a

3. Glazing Table

Glass Thickness in (mm)	Glazing Stop (mm)
1 3/8 (35)	6.5
1 (26)	14.5

Note: Glass thickness dimensions in this table are nominal dimensions with tight tolerances for production. If glazing problems occur, as in glazing being too tight or too loose, please refer to and review section 2.

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4. Shimming Guidelines

Shimming

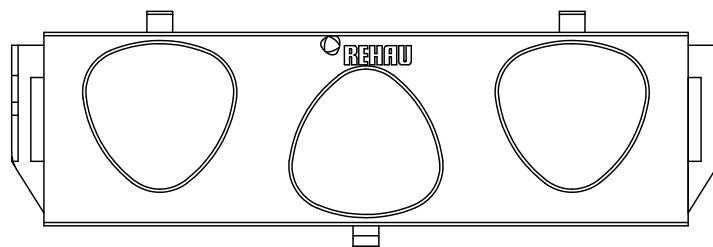
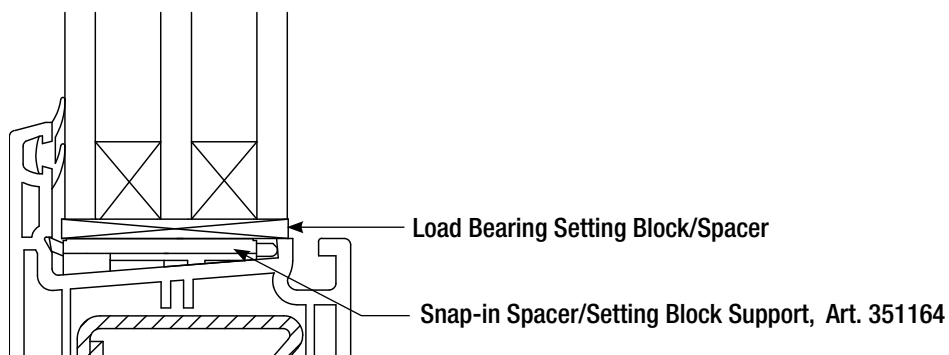
- Shimming assures the correct distribution of glass weight to the frame / sash. It also supports ease of operation for operable units.
- All spacers and load bearing setting blocks must be supported by the snap-in shim support, art. 351164. This injection molded part essentially provides a flat surface for the spacers and load bearing setting blocks, and is required at all ten locations on the 2200 sash.
- 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 are normally used for shimming because they are compatible with the surrounding materials.

Sizes

- The shims should be 1/8 in (2 mm) wider than the overall glass thickness to fully support the edges of each glass pane.
- A length of 3 to 4 in (80 to 100 mm) is recommended.
- The positioning of the shims is determined by the opening style of the window. See illustration on page 6.

After Shimming

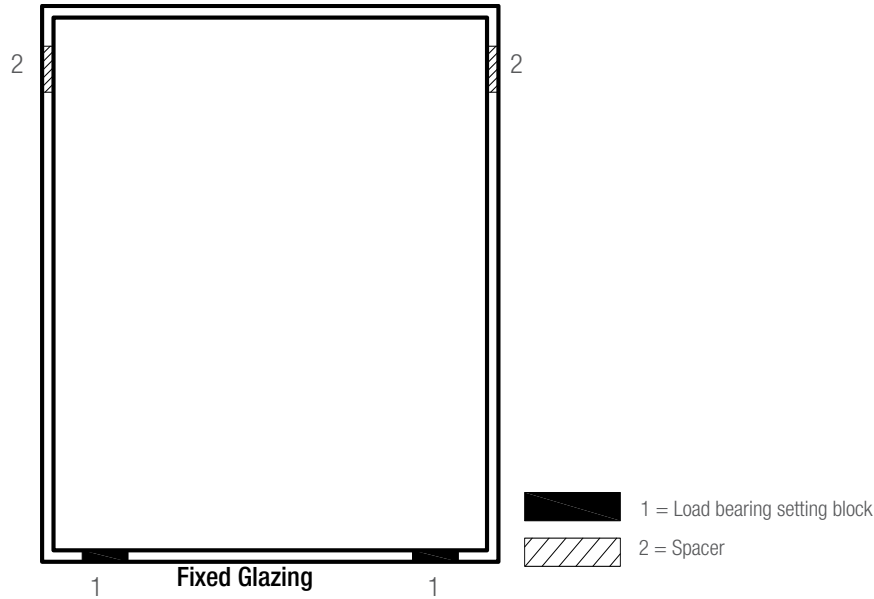
- After shimming, the proper operation of the window has to be confirmed or the shimming has to be re-done.
- For operating sashes, the distance of the shims from the internal corner of the unit is the length of the shim.
- For fixed glazed units, the distance from the unit corners can be between 6 in (150 mm) and the quarter points of the glass width.



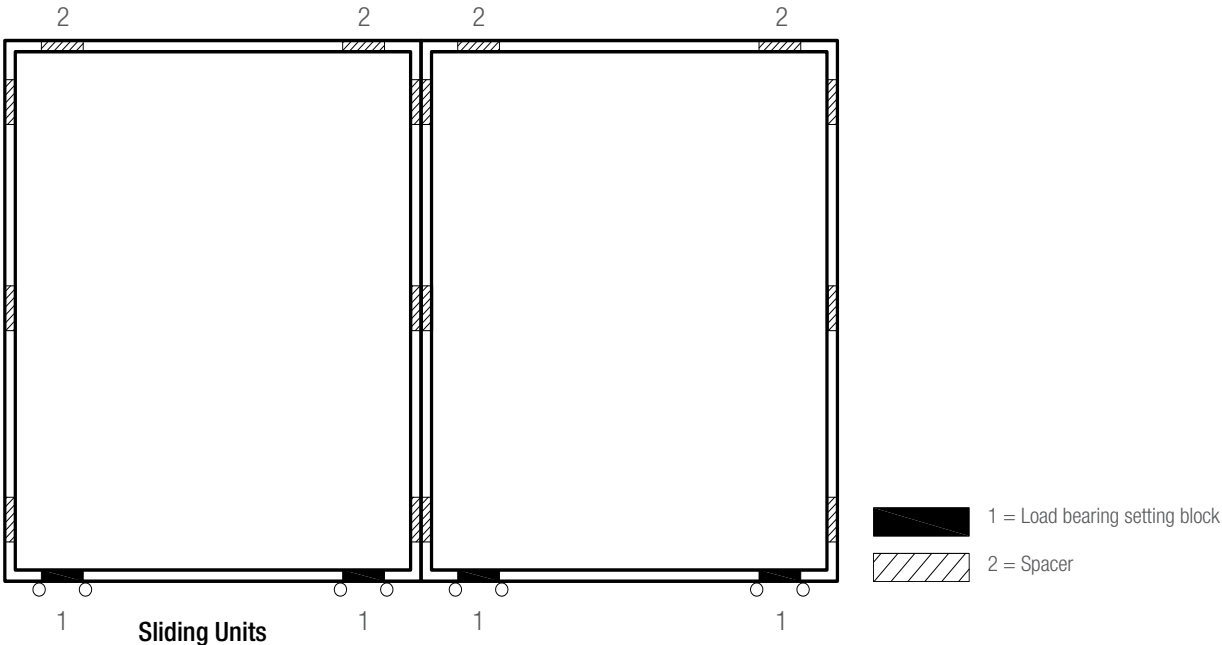
Plan view of Art. 351164 for reference

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



The load bearing setting blocks should be positioned right above the rollers which are positioned at the appropriate distance from the corners. Spacer blocks made of shock-absorbing material Shore 60 to 80 are recommended.

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