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## I. Care and Maintenance

This product is factory finished. Please handle with extreme care. Protect all exposed surfaces from contact with caustics, corrosives, solvents, abrasions, impacts, wet packing material etc. **FAILURE TO DO SO WILL NULLIFY THE WARRANTY.** Before **ANY CLEANING**, review the Care & Maintenance Instructions (go to [www.fleetwoodusa.com](http://www.fleetwoodusa.com) for more information).

**Contact the local dealer with any questions or concerns.** Fleetwood strongly recommends that all products be cleaned after installation and totally protected from construction debris and equipment.

## II. Tools / Materials, Sealant Requirements, & Anchor Instructions

**Tools Required:** Tape measure, Soft mallet, Level, Shims, Screws, Sealant, caulk gun, Backer Rod, Scissors or utility knife, metal cutting saw, drill bits (#25, 1/4" and anchoring), drive bit and powered drill.

### Sealant Requirements

- The sealant referred to within this document for seals associated with the assembly of the product should conform to **AAMA 800-16**. It is recommended that all other sealants should also conform to **AAMA 800-16** but may be a sealant recommended and approved by the sealant manufacturer that is compatible with the framing, finish and surrounding materials.
- Structural sealant DOW 795 required for butt glazed joints.
- All sealant applications must conform to the sealant manufacturers' requirements.
- The Owner / General Contractor is responsible for identifying the need for any additional sealant to be applied by others. Such sealant shall be elastomeric material, with the framing, finish and surrounding materials.

### Anchor Instructions

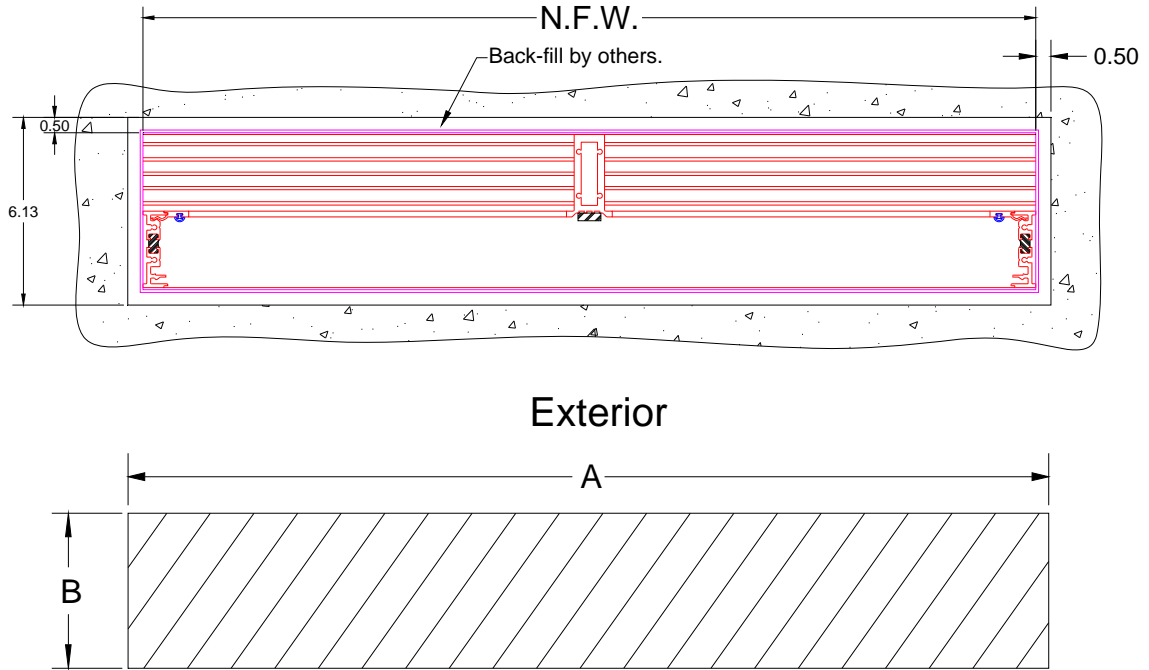
- Structural engineer to determine anchor quantity and spacing for design load requirements.
- Proper material must be used between all dissimilar materials (i.e. block/concrete & aluminum).

## III. Assembly and Installation

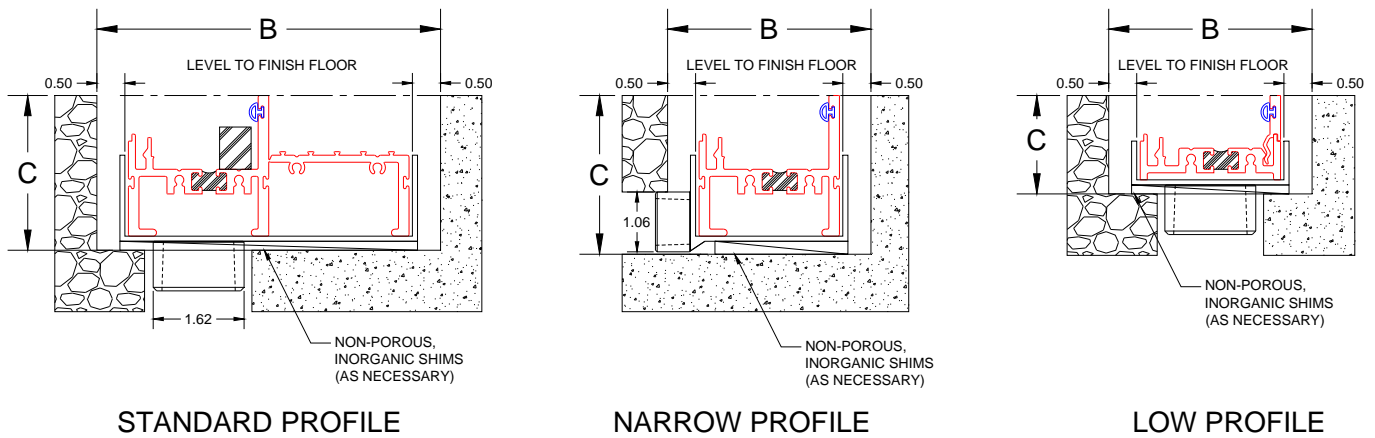
**It is essential that each Fleetwood product be assembled and glazed in accordance with AAMA standards and factory instructions.** It is the installer's responsibility to ensure that each Fleetwood product is assembled, glazed and installed, and completely sealed to ensure that the product is leak-free and operates correctly. **Installation of Fleetwood products must be in accordance with the standards set forth in ASTM E 2112.** If there are any questions regarding the installation of a Fleetwood product contact the factory customer service department.

Due to inherent manufacturing tolerances Fleetwood has provided this product with recommended field glazed weather-stripping. If the provided weather-stripping does not ensure an optimum fit of glass to frame, the Fleetwood Authorized Dealer should contact Customer Service for an expedited **NO CHARGE** shipment of replacement weather-stripping.

**IV. Arche-Duct Block Out**



**Figure 1:**  
Arche-Duct Block Out (Top View)



**Figure 2:**  
Arche-Duct Block Out (Side View)

Table 1: Arche-Duct Block Out Dimensions

PROFILE	DIMENSION		
	A	B	C
STANDARD	N.F.W. + 1.00"	6.13"	*2.75"
NARROW		3.63"	*2.75"
LOW			1.75"

\*= add 3/16" depth for side drain option.

## V. Structure Verification

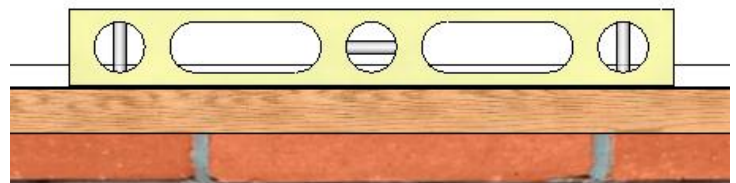
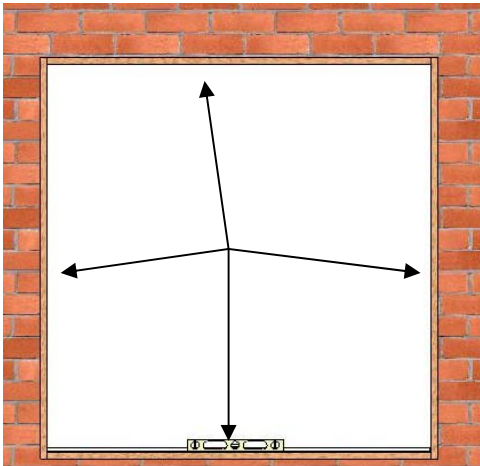
**Note:** If the factory provided Arche-Duct drain system is not desired, the product warranty will remain intact if the substitute panning system emulates the factory design.

### 1. Opening Verification

- Check the measurements of the opening and verify that the product will fit into the opening. Measure all four sides of the opening to make sure it is 1/2" larger than the product in width and 1/2" in height.
- Verify the opening is plumb and level.
- Remove the product from the packaging and lay it in front of the opening. Check width and height dimensions.

### 2. Pre-Fit and Leveling

- Place Arche-Duct into the opening and determine any leveling that must be done prior to installation (Figure 2).
- Shim as necessary to stabilize the entire depth and length of the Arche-Duct. No unsupported width of more than 8" is allowed. Shim(s) should be load bearing, non-porous, non-absorbent, and inorganic.
- If more than 1/8" shim height is required, it is recommended to use a self-leveling product like "Rock Hard" (or equal) to achieve a level and stable surface.

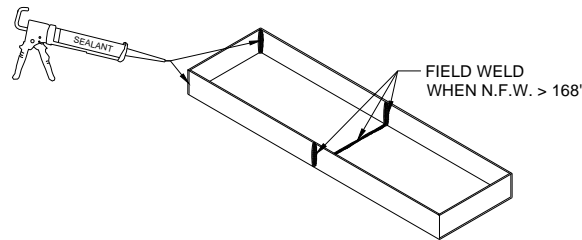


**Figure 2:**  
Use level to determine if the opening is plumb and level

### 3. Arche-Duct Installation

**Note:** Multiple piece Arche-Ducts are required on products with net frame widths greater than 14 feet (168 inches) and corner units. It is required to weld when there are multiple pieces of Arche-Ducts.

- It is necessary to use an insulating material between the outer edge of the Arche-Duct and the rough opening. Direct contact with grout, concrete, or dissimilar metal can lead to corrosion of the Arche-Duct pan.
- Apply sealant in all corners and seams of the pan (Figure 3).



**Figure 3:**  
Seal corners and seams

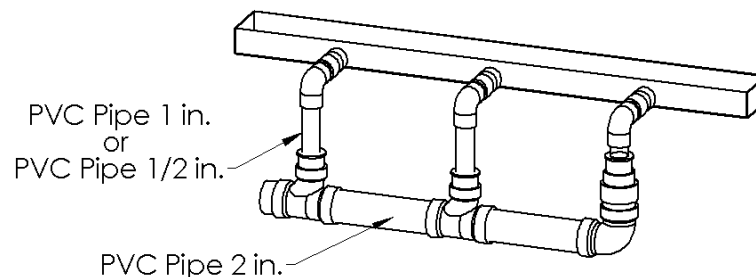
### 4. Arche-Duct Water Test

**Note:** Installer responsible for verifying the integrity of the Arche-Duct for water leakage and performance.

- Block all drain outlets and fill the Arche-Duct with water to verify the integrity of all seams and drain connections. Look for leak points, the water level of the Arche-Duct should remain constant. If Arche-Duct passes water test, drain Arche-Duct and continue with installation of frame.

### 5. Arche-Duct Install

- Confirm proper orientation of Arche-Duct for tracks and drain location with customer order and/or dealer drawings.
- Install Arche-Duct into already leveled opening. An insulating material should be placed between the Arche-Duct and the supporting structure (concrete, steel, etc.) to prevent corrosion of the aluminum Arche-Duct.
- Connect tubing or pipe to Arche-Duct drain connections (Figure 4).



**Figure 4:**  
Drain Pipes Connected (side drains shown)

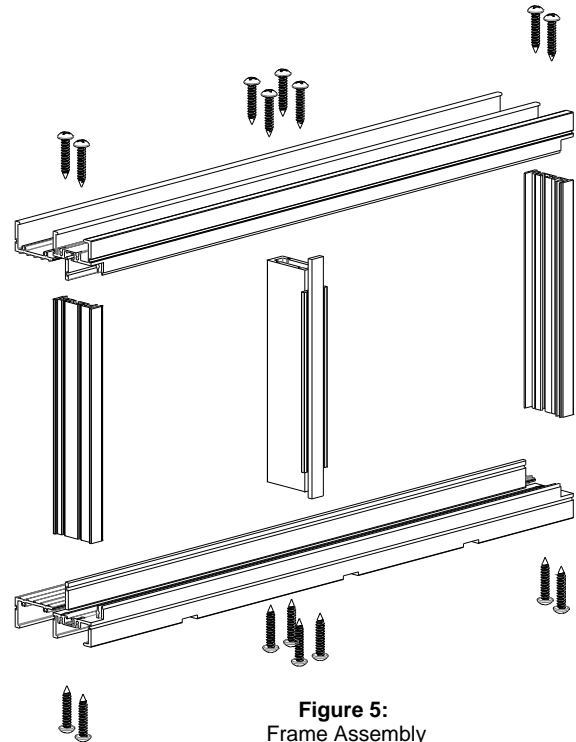
## VI. Frame Assembly

**Important Note:** Glass Wedges must be field cut to size after the frame is assembled. Failure to assemble the frame according to the installation instructions, nullifies warranties related to this product.

1. Apply a compatible sealant to the corners of the frame. Assemble the frame with screws provided (Figure 5).
2. Install Head and Sill to jambs using #10 X 1" PHP (provided)

### EDGE |f| Fin Installation

1. Install each full length Fin, using #10 X 1" PHP Screw into pre-drilled holes at the head and sill (Figure 5).



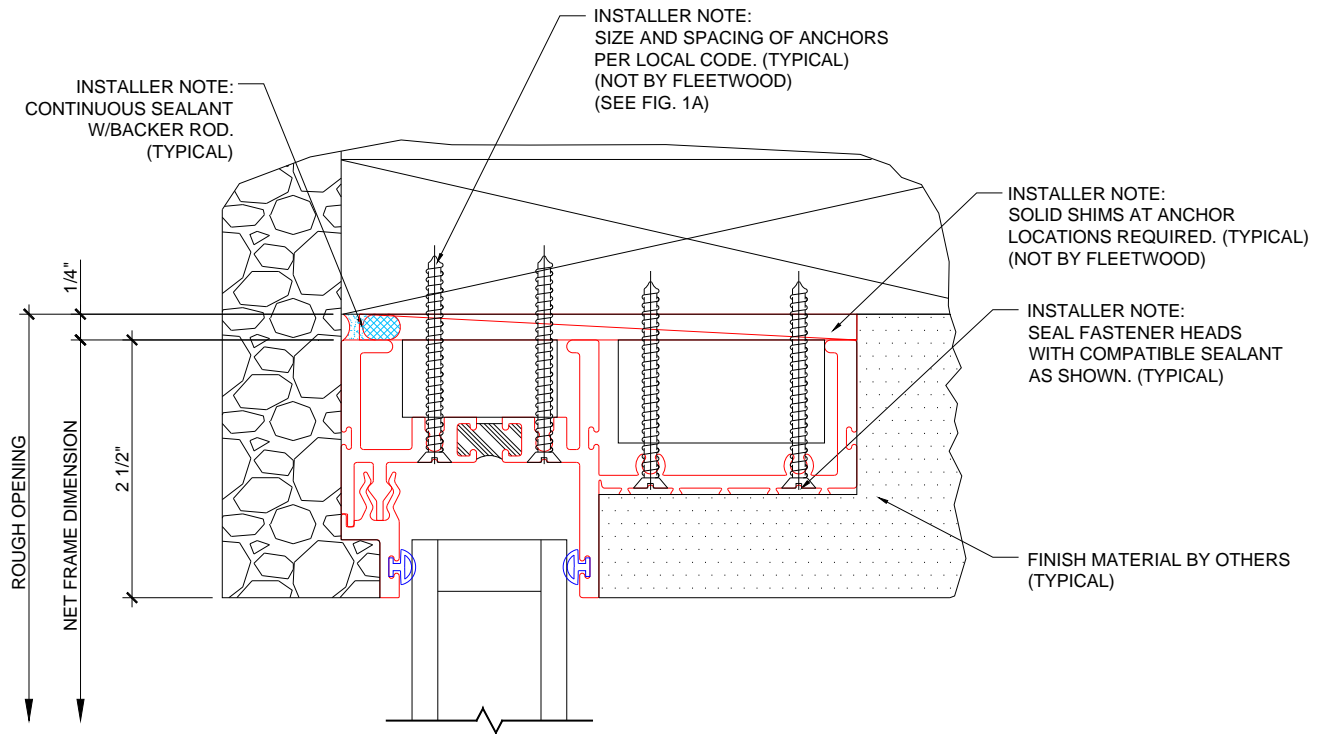
**Figure 5:**  
Frame Assembly

## VII. Frame Installation

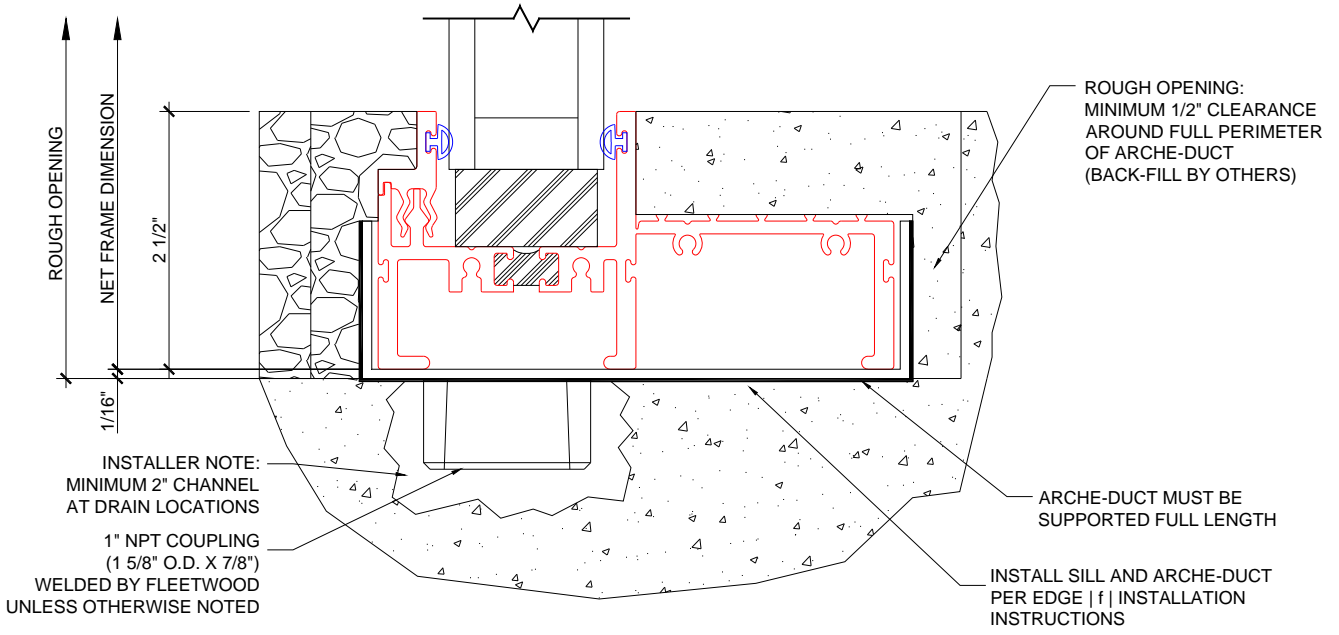
1. Prepare the opening to accept the frame ensuring that the weep-screed or diado flashing at the sill is adjusted to maintain a weatherboard style flashing.
2. Insert the frame into the Arche-Duct. Cross-measure and adjust as necessary to achieve a plumb square and level condition, as well as an even reveal around the framed opening. Shim with non-porous, non-absorbent, inorganic shims where needed. Seal all fastener heads with compatible sealant. Only drill holes through Sill as required for design load.
3. Anchor Location and Sealant

**Note:** Frame installation anchors furnished by installer, not by Fleetwood. Stainless steel screws are recommended. Fleetwood recommend countersink for all frame anchors.

4. The installer is responsible for the integrity of all framing joints after installation and must therefore **water** test all joints to guarantee a completely sealed product. Apply joint sealer and/or sealant necessary to ensure watertight joints. Retest as necessary.
5. To complete the installation, apply backer rod and a complete bead of sealant to the entire exterior and interior joint between the frame and the building structure. Tool the sealant to eliminate bubbles, voids and / or breaks and ensure a completely watertight seal. See Anchor Location Drawing, Figure 6.



EXTERIOR

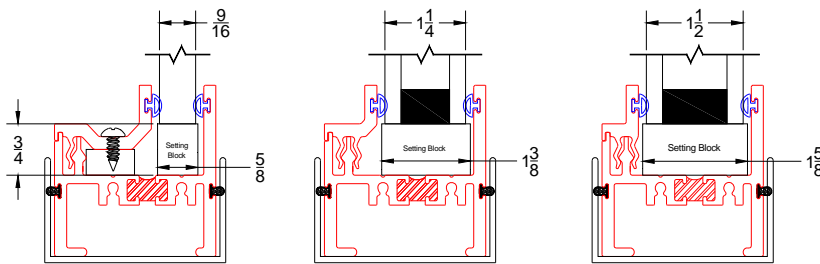


**Figure 6:**  
 Standard Sill with Sealant Shown (Exterior Glazed)

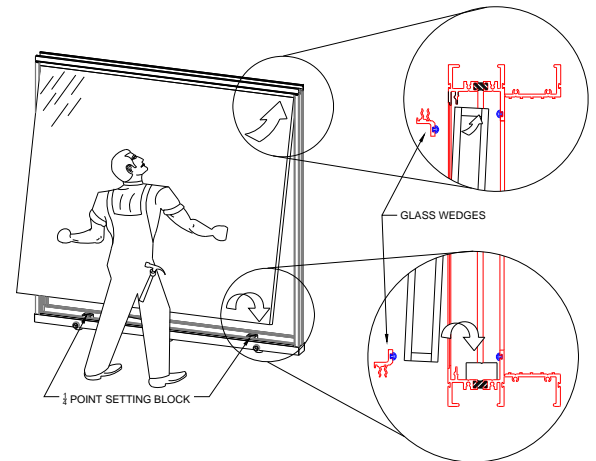
### VIII. Glazing Instructions (without Fin)

**Note:** For Low Profile Sill option leave exterior Glass Wedges installed while glazing.

1. Place setting blocks (Figure 7) at  $\frac{1}{4}$  points along the sill or as needed (Figure 8).
2. Cut each glass wedge to size and test fit. Remove prior to glass installation. When using  $\frac{9}{16}$ " glass, pre-drill holes through the glass wedge and frame using a #25 drill bit, use a  $\frac{1}{4}$ " drill bit to open the hole in wedge / spacer to prevent breakage.
3. Insert glass into the head channel. Push up and swing the bottom inward until vertical, then lower down into the sill (Figure 8). Center the glass horizontally into the daylight opening (Figure 8).
4. Finish assembly by inserting the two horizontal glass Wedges, two exterior vertical glass Wedges and two interior glass Wedges. Once all four Wedges are installed on one side move to the opposite side and install the last two vertical Wedges. For  $\frac{9}{16}$ " glass, pre-drill and fasten the glass Wedge into the frame with the screws provided (red bag).
5. Once satisfied with glass installation backfill around the Arche-Duct. Verify you have access to drainage connections and clean out as necessary.



**Figure 7:**  
Setting Block Dimensions  
(Narrow Option Shown, same for all sills)

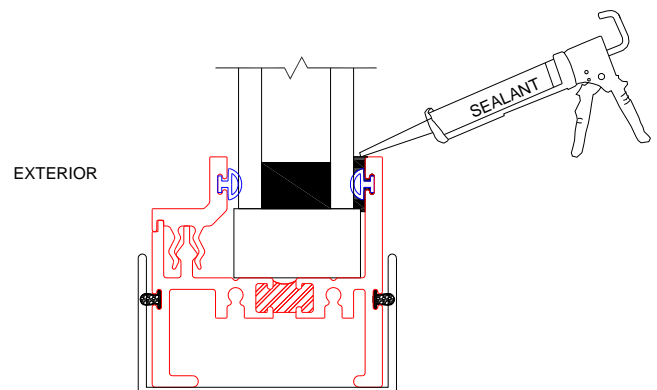


**Figure 8:**  
Glazing Directions

#### Alternate Glazing Procedure

**Note:** Applies to inside glazed or outside glazed products where additional water sealant is required.

- Apply a continuous  $\frac{1}{4}$ "x $\frac{1}{4}$ " bead of sealant before and/or after glazing (Figure 9).



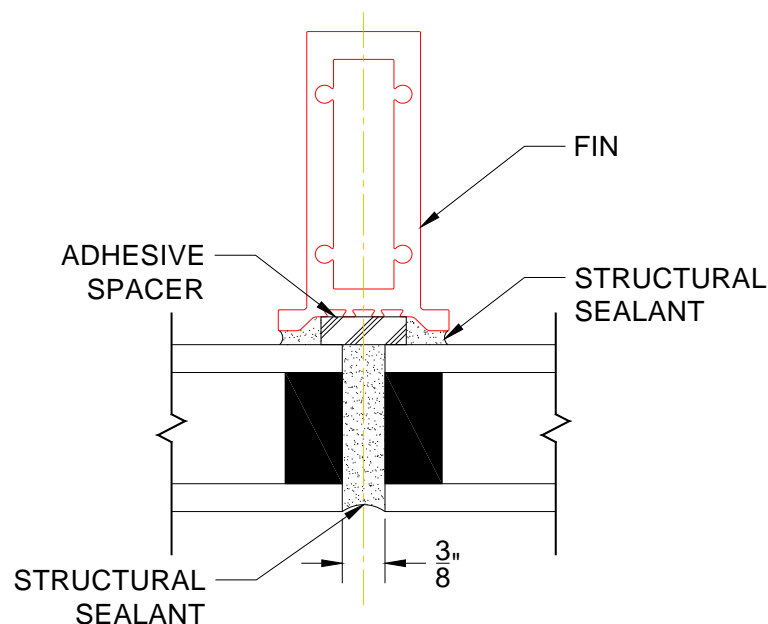
**Figure 9:**  
Inside Glazing Sealant Locations



## IX. Glazing Instructions (with Fin)

**Note:** Glass Wedges must be removed before continuing.

1. Attached to the Fin is a double-sided adhesive spacer, prior to glass installation partially peel back the protective film.
2. Place setting blocks (Figure 7) at ¼ points along the sill or as needed (Figure 8).
3. Cut each glass wedge to size and test fit. Remove prior to glass installation. When using 9/16" glass, pre-drill holes through the glass wedge and frame using a #25 drill bit, use a 1/4" drill bit to open the hole in wedge / spacer to prevent breakage.
4. Insert glass into the head channel. Push up and swing the bottom inward until vertical, then lower down into the sill (Figure 8).
5. Align the glass with the edges of the fin(s) ensuring a 3/8" gap between glass for sealant (Figure 10).
6. Finish assembly by inserting the two horizontal glass Wedges, two exterior vertical glass Wedges and two interior glass Wedges. Once all four Wedges are installed on one side move to the opposite side and install the last two vertical Wedges. For 9/16" glass, fasten the glass Wedge into the frame with the screws provided (red bag).
7. Fully remove the protective film on the double-sided adhesive spacer.
8. Apply structural sealant between the glass and fin (Figure 10).
9. Once satisfied with glass installation backfill around the Arche-Duct. Verify you have access to drainage connections and clean out as necessary.



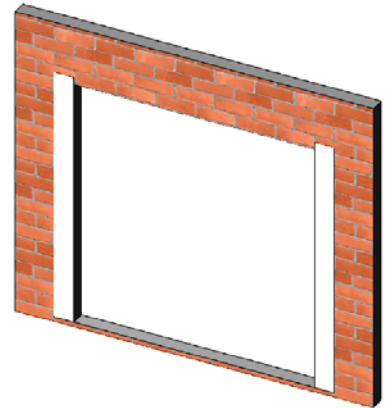
**Figure 10:**  
Fin Glazing Directions

## X. Flashing after Installation

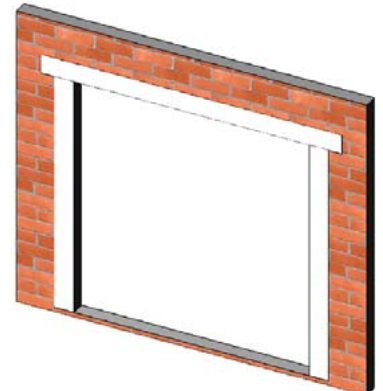
The flashing paper referred to in this document is Moistop or other code compliant flashing material that conforms to **Federal Specification UU-B-790a, Type 1, Grade A, Style 4**. The strips of flashing paper are to be no less than 9 inches wide (or wider as required by local codes). Flashing paper must be applied with galvanized nails or corrosion resistant staples. Flashing paper shall be applied in a weatherboard fashion around the full perimeter of the framed opening.

1. Once satisfied that the frame is water tight, and immediately prior to application of the flashing paper at the head and jambs, apply a continuous bead of sealant to the exposed mounting flange (nail-fin) at the top (head) and sides (jambs) of the installed frame. Also, apply sealant at corners of the frame, the full length of the seams where the nail fin flashing is mounted.
2. At each jamb, embed the flashing paper into the sealant onto mounting flange and fasten into place. The flashing paper should be cut sufficiently long enough to extend at least 3 inches past the weep-screed or diado flashing and at least 6 inches above the head of the window (Figure 11).
3. Finally, at the head, embed the flashing into the sealant on the mounting flange and fasten into place. The flashing paper should be cut sufficiently long enough to extend past the flashing paper at each jamb by at least 3 inches (Figure 12).
4. Weather resistant building paper should be applied in a weatherboard fashion to complete the installation (Figure 13).

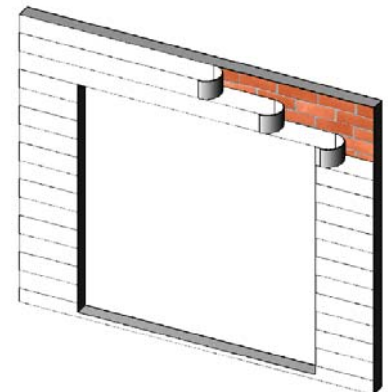
**Note:** Where weather resistant building paper, insulating board, or other materials by other trades may constitute the primary weather barrier behind the exterior wall finish (i.e., stucco, masonry, siding, etc.), the owner / General Contractor are responsible to ensure that the weather barrier is continuous by effectively sealing the material to the window.



**Figure 11:**  
Jamb flashing



**Figure 12:**  
Head Flashing



**Figure 13:**  
Building Flashing