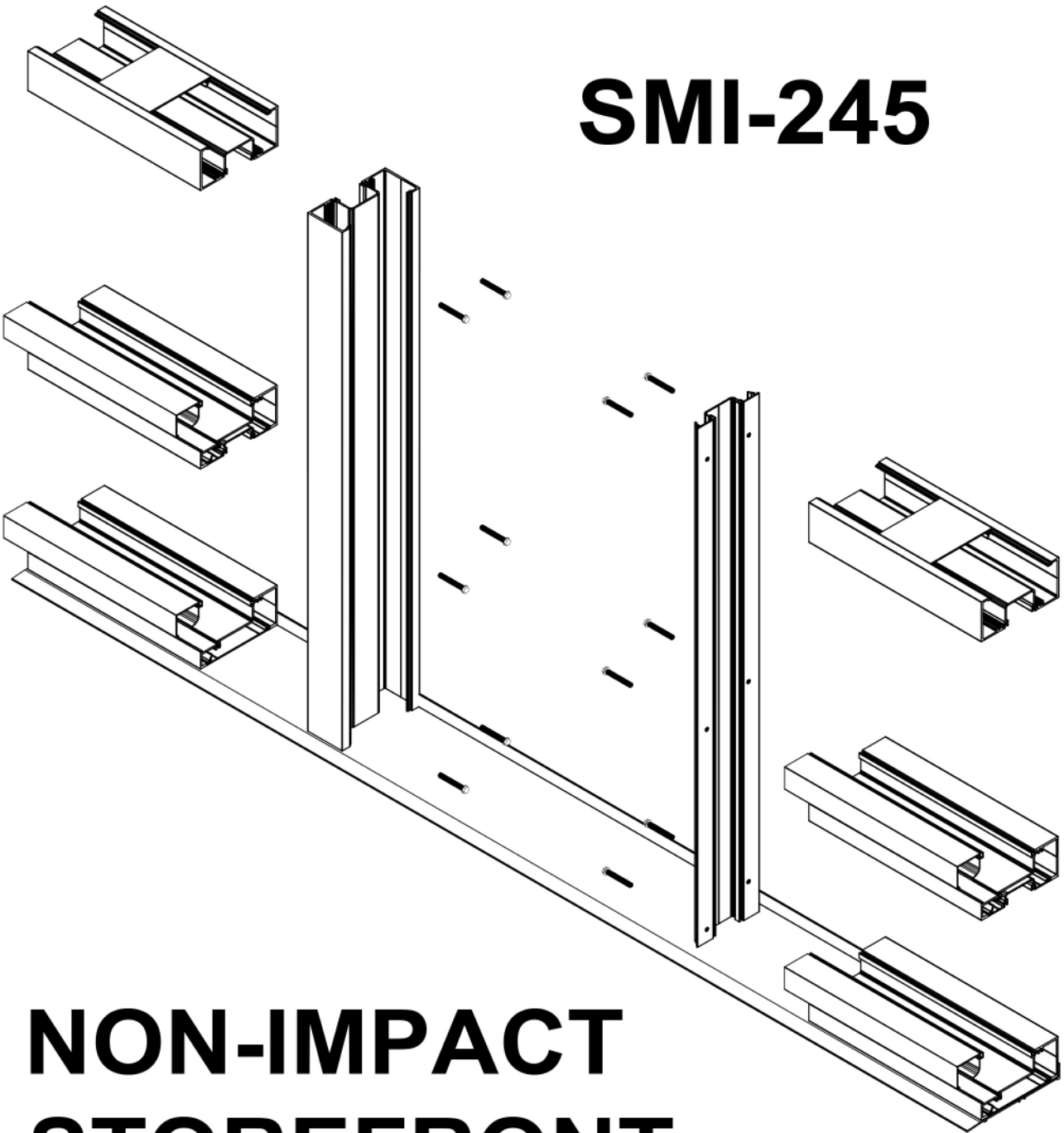


SMI-245

INSTALLATION INSTRUCTIONS

**NON-IMPACT
STOREFRONT
SYSTEM**



<u>CONTENTS</u>	<u>PAGE</u>
GENERAL INSTALLATION NOTES	3
PARTS IDENTIFICATION	4
TYPICAL WINDOW DETAILS	5 - 6
TYPICAL SIDELITE DETAILS	7
FABRICATION: ASSEMBLY SCREW	8
SYSTEM ASSEMBLY (TYPICAL)	9 - 10
INSTALLATION	11 - 15
GLAZING: 1" THK. INSULATED GLASS	16
GLAZING: 1/4" THK. TEMPERED GLASS.....	17
STEEL REINFORCEMENT	18

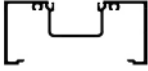
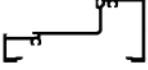




GENERAL INSTALLATION NOTES






1. **Safety-** Safety should be the primary concern throughout the installation process. Keep the installation areas clear of debris and obstructions. Lift and carry products carefully using proper lifting procedures. Always wear safety gear as determined by products and or jobsite conditions.
2. **Building Code-** The Building Code determines the requirements of products to be used on a project. Aldora manufactures products to the installer's specifications; however, Aldora does not assume any responsibility for the suitability of its products for any project. It is the responsibility of the glazier to ensure each product meets the project requirements.
3. **Openings-** Measure the openings to determine if they match the building plans. Notify the General Contractor immediately to correct any deviance.
4. **Shop drawings-** Review shop drawings to ensure all materials have been manufactured in accordance with the shop drawings.
5. **Receiving-** Inspect all products upon receipt. Do not install any damaged or deficient products. Return to Aldora immediately for correction.
6. **Protection-** Protect all materials from damage including cement, stucco, paint, mud or other abrasives or chemicals. Materials need to be protected properly before, during and after installation.
7. **Field testing-** Glaziers must fully understand all sealing procedures in advance of installation. If installed correctly and properly sealed, Aldora's products will achieve satisfactory results during field test. Aldora will not accept any responsibility for installation deficiencies.

Pre-installation

1. **Checklist-** Working from a checklist, bring all necessary documents, tools, equipment and supplies to the jobsite.
2. **Products-** Review all products versus the shop drawings to ensure everything is at the jobsite. Examine mark numbers to verify proper products per opening.
3. **Frame units-** With multiple panel openings, identify the panel with two jambs for the opening, this is typically the starting panel for the left hand side of the opening (outside looking in).
4. **Sealants-** Ensure compatibility of the sealant with all products involved.
5. **Anchors-** Verify anchors supplied match shop drawings.
6. **Opening preparation-** Clean opening of all debris and examine for level and plumb.
7. **Aluminum surfaces in contact with lime-mortar, concrete or other masonry materials, shall be protected with alkali-resistant coating.**

Note: Perimeter sealing of the product to the substrate is not covered under this document. Please refer to the product's notice of acceptance or Florida building code approval for specifics.
All perimeter caulking and waterproofing should comply with the above mentioned documents and sealant compatibility and performance should be designed for specific job conditions.
Failure to have an adequate barrier will lead to water intrusion.

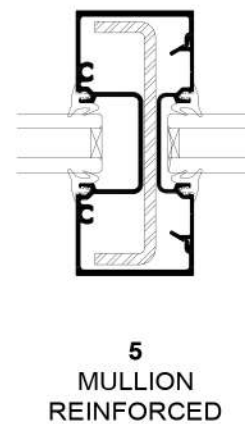
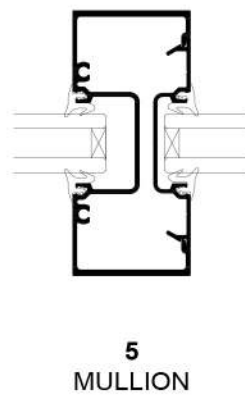
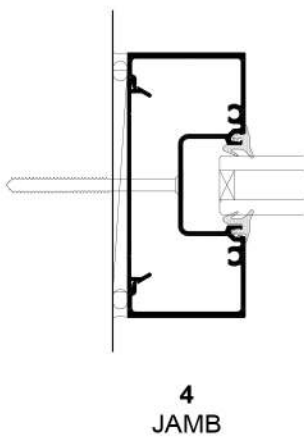
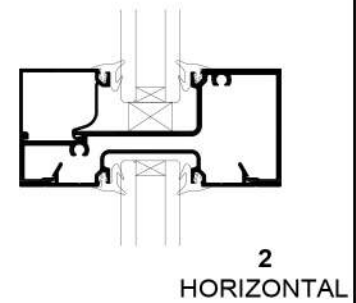
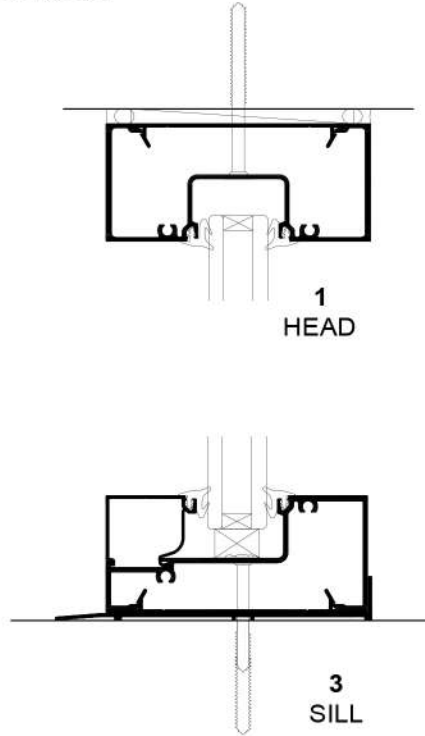
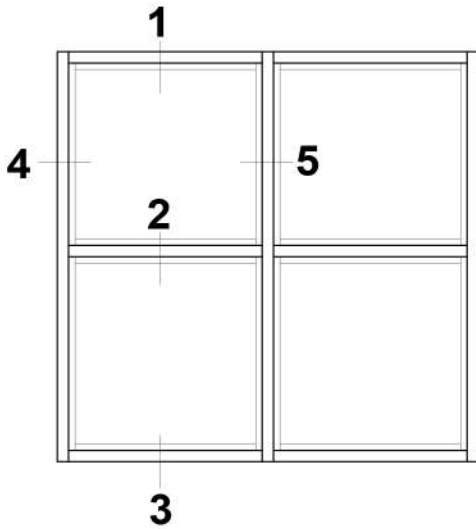
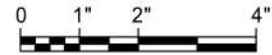
PROFILE	PART #	DESCRIPTION
	SMI-213	HEAD/JAMB & MULLION
	SMI-214	SILL, INTERM. HORIZONTAL
	SMI-216	GLASS STOP
	SMI-217	POCKET FILLER
	SMI-118	PLAIN SNAP
	SMI-122	SUB-SILL

PROFILE	PART #	DESCRIPTION
	SMI-G04	INTERIOR & EXTERIOR GLAZING GASKET
	SMI-G08	INTERIOR & EXTERIOR GLAZING GASKET
	SMI-SB10	SETTING BLOCK 1/2" X 3/4" X 2" LG.
		ASSEMBLY SCREW #12 X 1 1/2" LG. HX. WASHER SMS. ST/ST
	NI-1	VERTICAL STEEL REINFORCEMENT

INSTALLATION INSTRUCTIONS

Aldora's SMI-245 Fixed Non-Impact System is assembled as a screw spline system. The screw spline assembly can be pre-fabricated for multi-unit panels using the jamb/mullion member and the pocket filler.

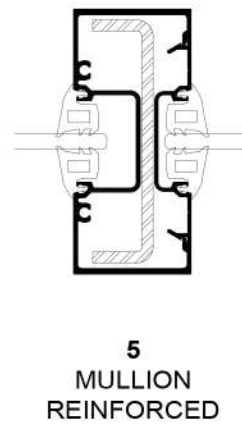
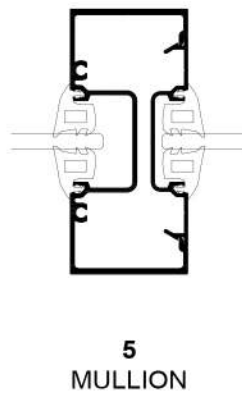
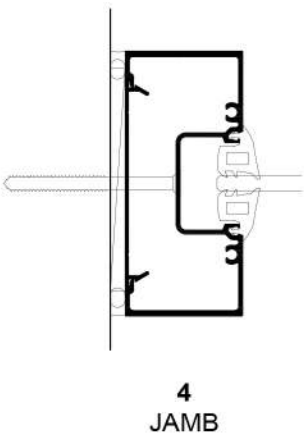
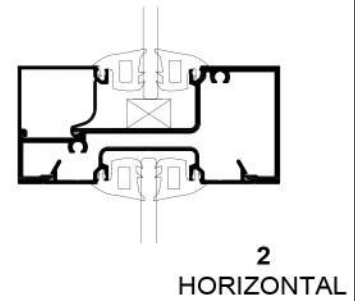
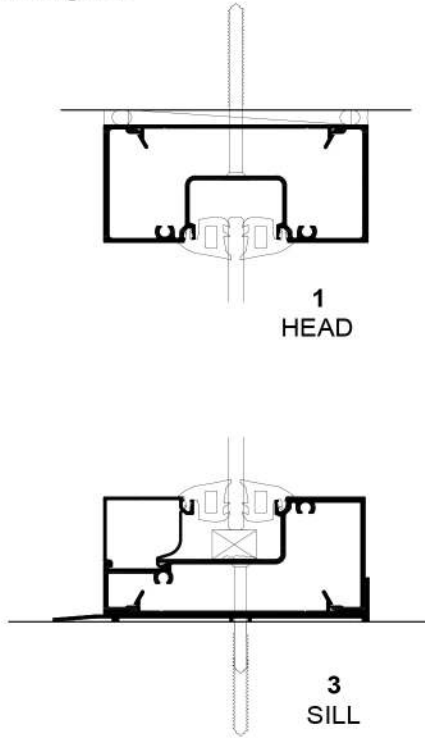
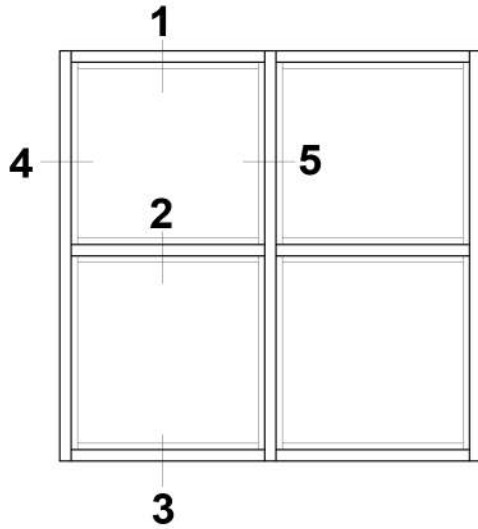
Glazing represented below is 1" thk. insulated glass.



INSTALLATION INSTRUCTIONS

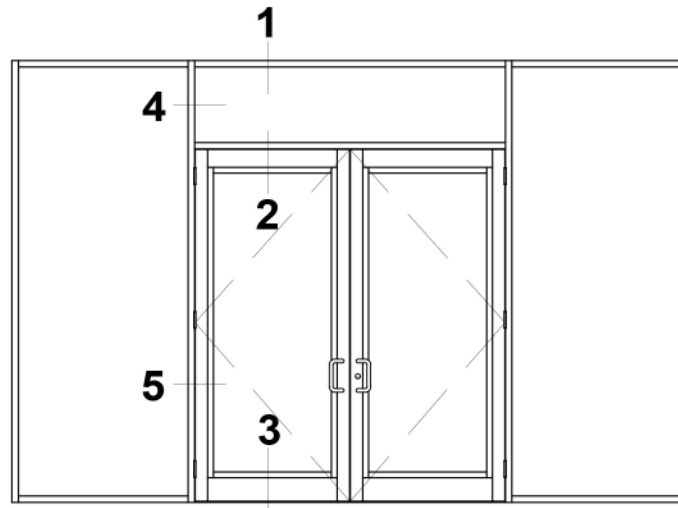
Aldora's SMI-245 Fixed Non-Impact System is assembled as a screw spline system. The screw spline assembly can be pre-fabricated for multi-unit panels using the jamb/mullion member and the pocket filler.

Glazing represented below is 1/4" thk. tempered glass.

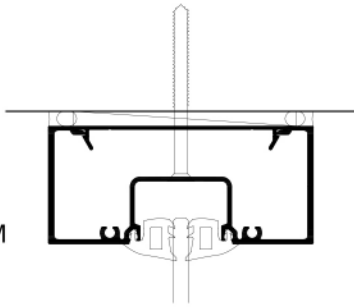


INSTALLATION INSTRUCTIONS

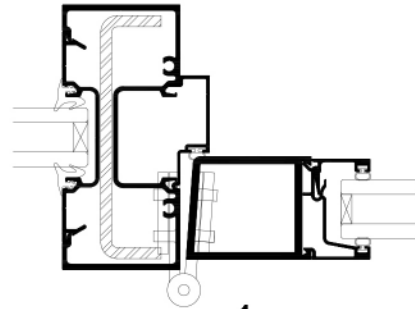
The open back jamb of Aldora's McKinley narrow & medium stile doors series accepts the pocket filler of the SMI-245. Transom assembly for the 245 System is shown below with 1" glazing and 1/4" glazing.



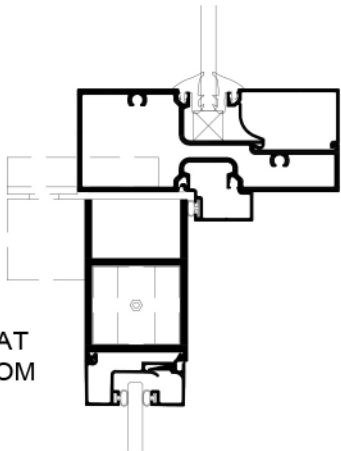
1
HEAD AT
TRANSOM



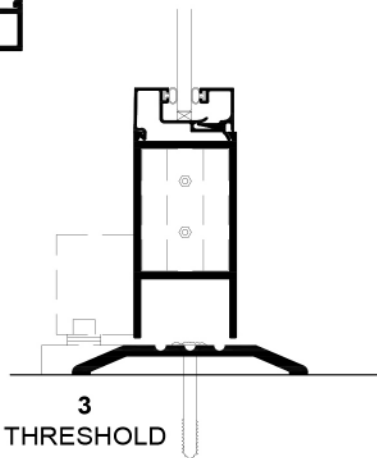
4
SIDE LITE AT
DOOR MULLION



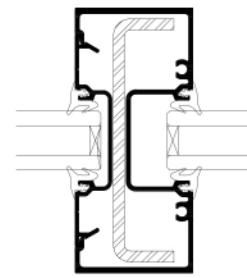
2
DOOR AT
TRANSOM



3
THRESHOLD



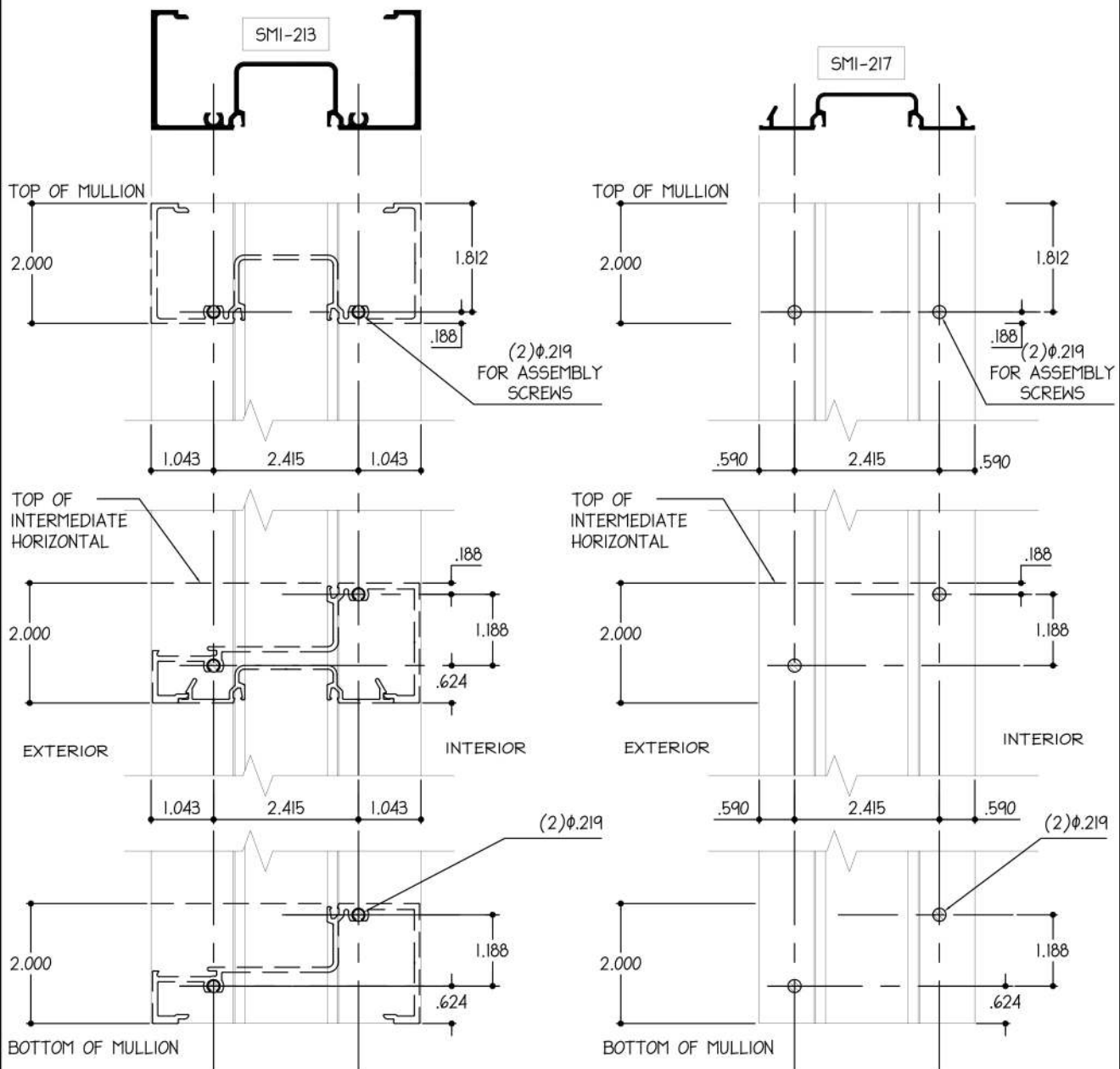
5
SIDE LITE AT
TRANSOM



INSTALLATION INSTRUCTIONS

Determine opening dimensions by measuring width and height and reduce each by 1/4" on all sizes. This allows for shim spacing and perimeter sealant. If the opening is not square, use the smallest dimension for each measurement before deducting for shim space.

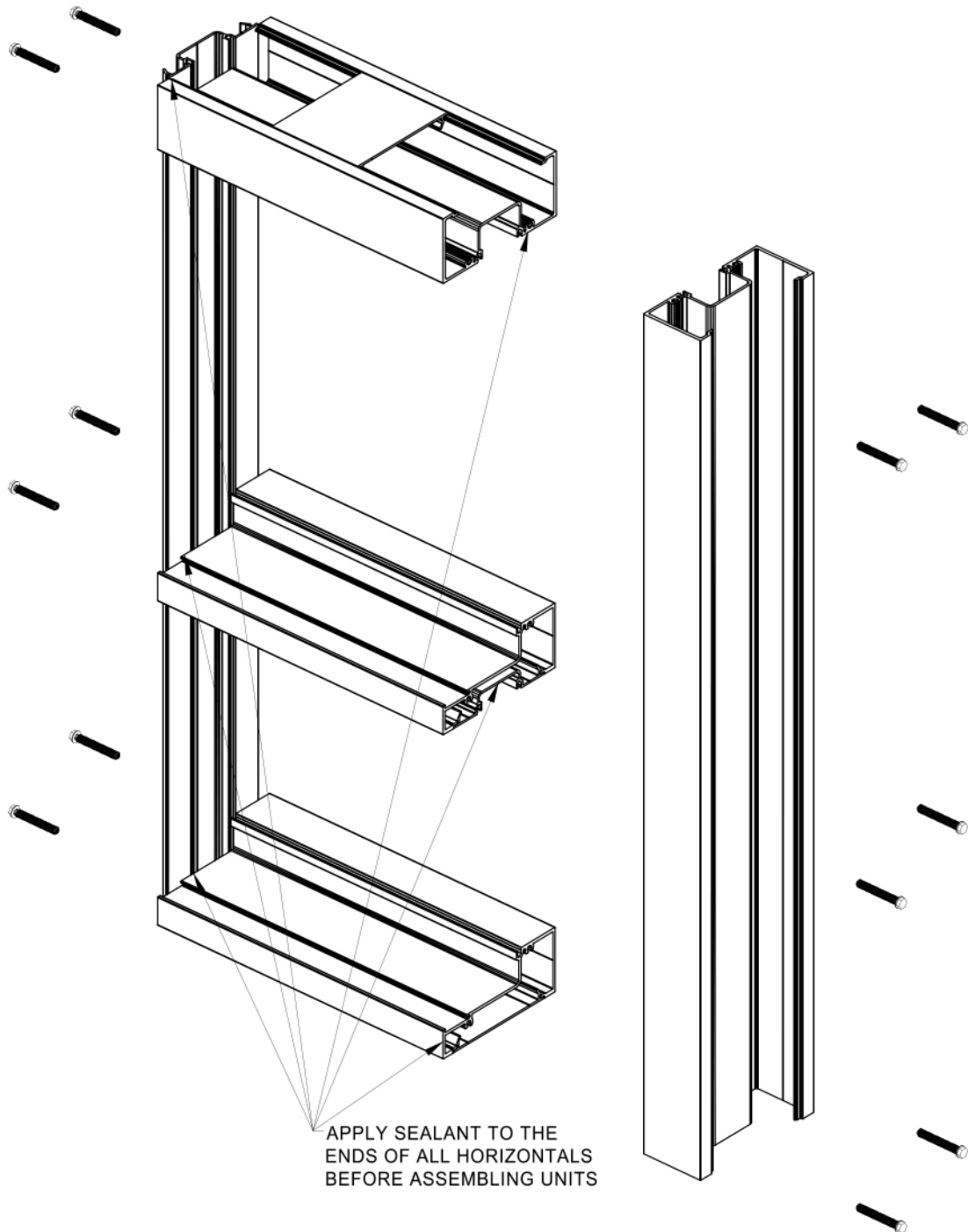
Vertical members are cut at the frame height dimension. Horizontal members are cut to fit within vertical members. Assembly holes are drilled in the verticals framing member wherever horizontals are adjoined.



Assembly Instructions

Apply sealant to the ends of the horizontal framing members prior to fastening to the vertical jambs or mullions. This will provide the joint seal necessary to prevent water penetration.

Affix the horizontal members to the vertical framing member by screwing four (2) # 12 X 1 ½" S.S. hex head screws into each joint location as shown below.

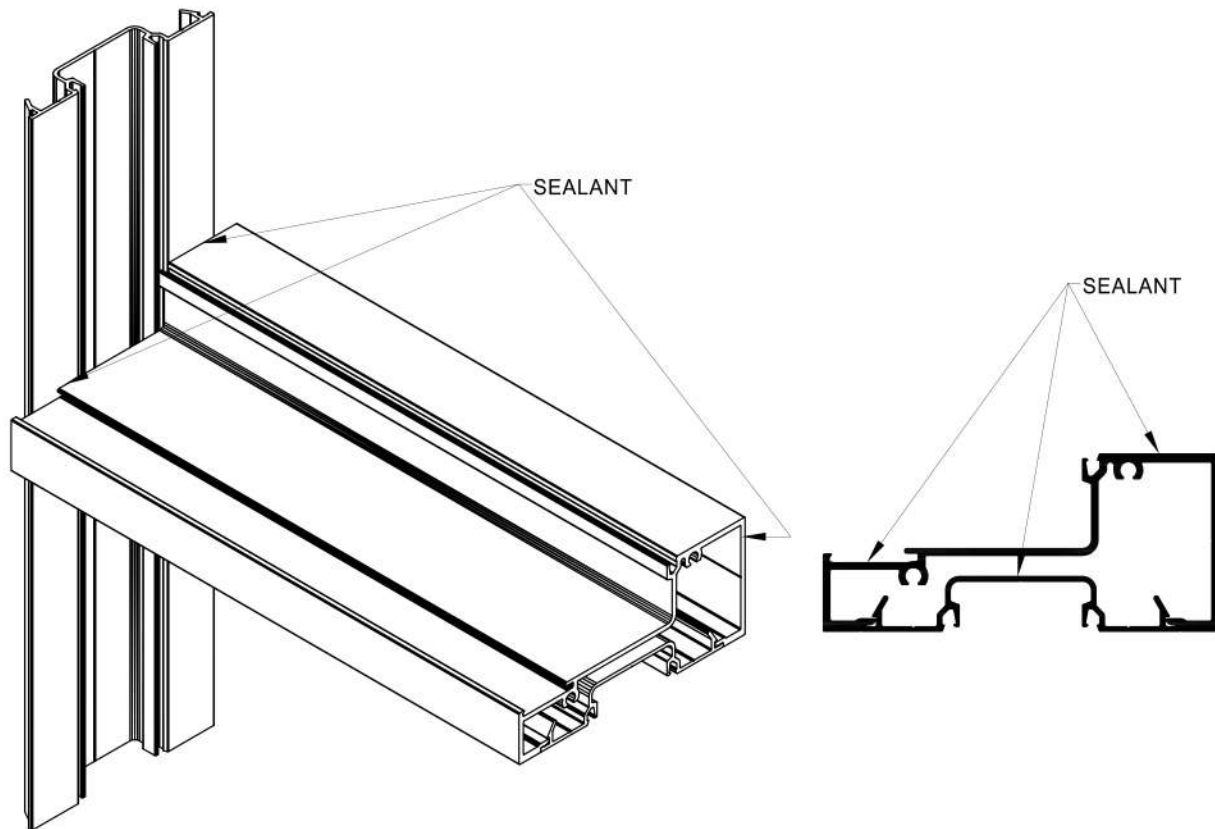
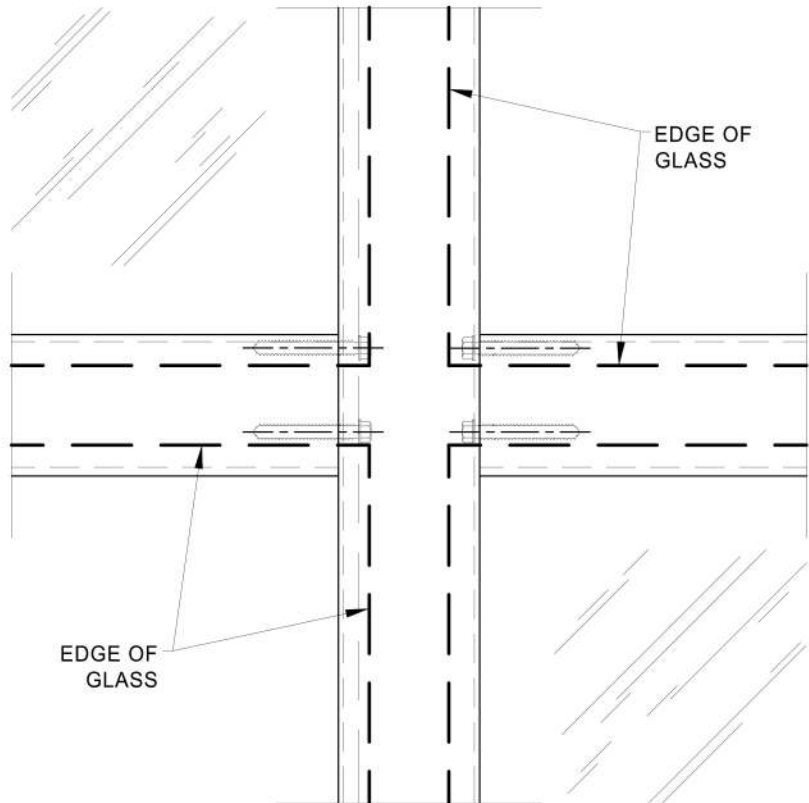


INSTALLATION INSTRUCTIONS

INSTALLATION INSTRUCTIONS

Assembly

When assembling the horizontal framing member to the vertical, apply recommended sealant to the front surface and the edge of the horizontal extrusion. Extend the sealant around the ends of all horizontal members to ensure a uniform seal between the two framing members.



Installation Instructions

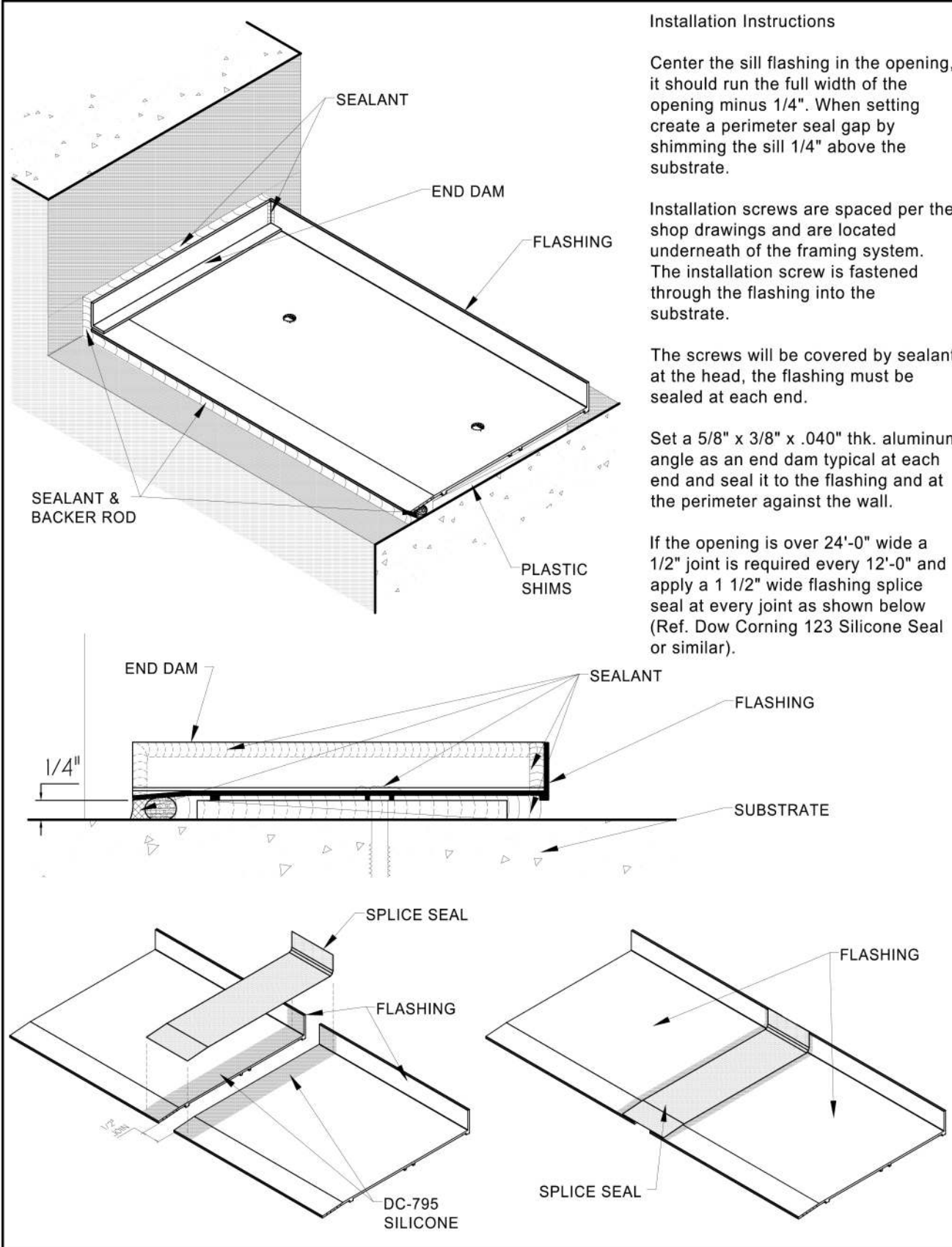
Center the sill flashing in the opening, it should run the full width of the opening minus 1/4". When setting create a perimeter seal gap by shimming the sill 1/4" above the substrate.

Installation screws are spaced per the shop drawings and are located underneath of the framing system. The installation screw is fastened through the flashing into the substrate.

The screws will be covered by sealant at the head, the flashing must be sealed at each end.

Set a 5/8" x 3/8" x .040" thk. aluminum angle as an end dam typical at each end and seal it to the flashing and at the perimeter against the wall.

If the opening is over 24'-0" wide a 1/2" joint is required every 12'-0" and apply a 1 1/2" wide flashing splice seal at every joint as shown below (Ref. Dow Corning 123 Silicone Seal or similar).



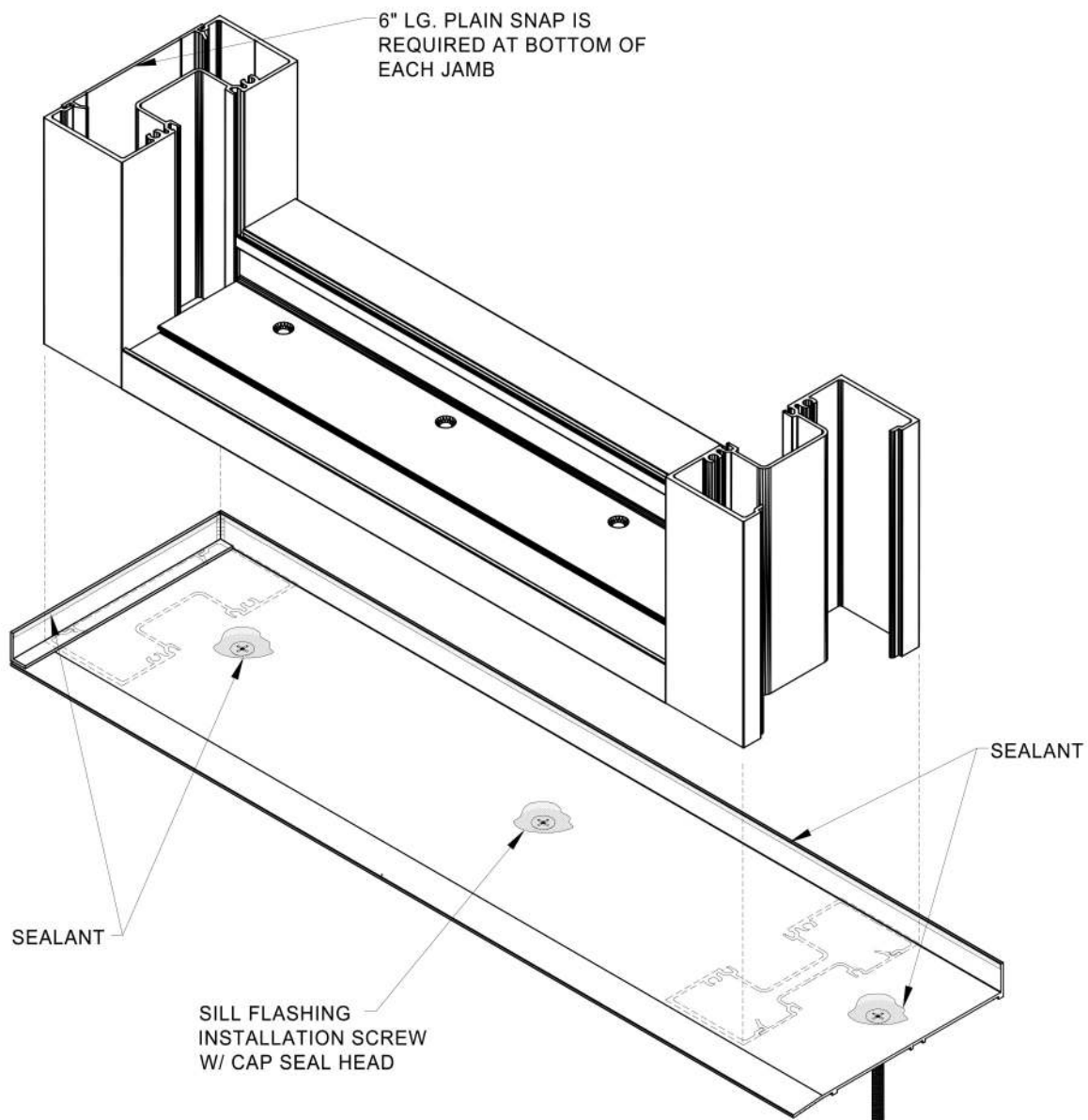
Installation Instructions (continued)

Start the installation of the assembled frames on one side of the opening aligned with the sill flashing. It is required to add 6" lg. plain snap at bottom of each jamb to seal between jamb and sill flashing end dam.

A bead of silicone is to be applied prior to installing each frame, at the back fin of the sill flashing and at interior top part of the end dam, the installation of the frame will be tight against these two surfaces.

Check to make sure the frame is level and plumb, use standard horseshoe shims as needed at the jambs and head to create a gap necessary for the perimeter sealant to be applied. Shims are inserted around the installation screws between the plain snap and the substrate.

Apply silicone into the sill installation holes and at the installation screws threads before fastening them at the sill through the sill flashing.

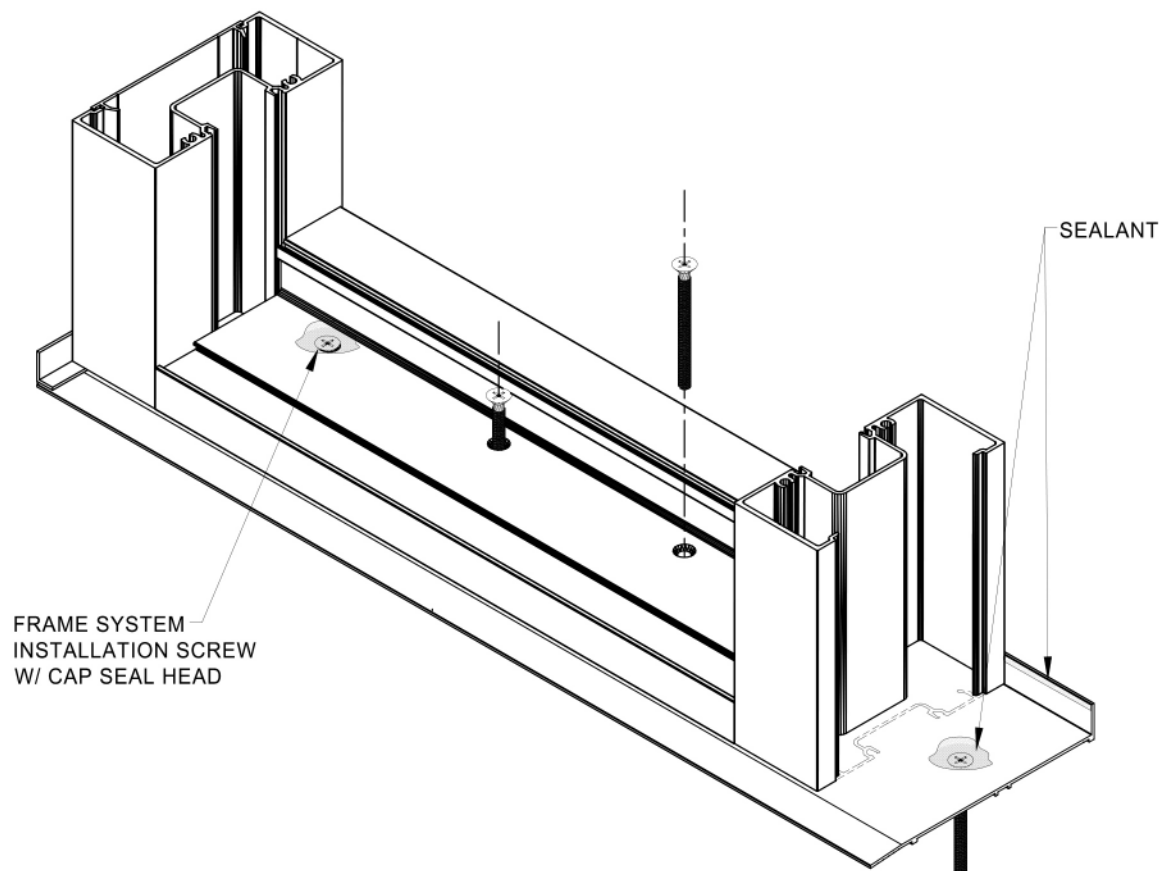


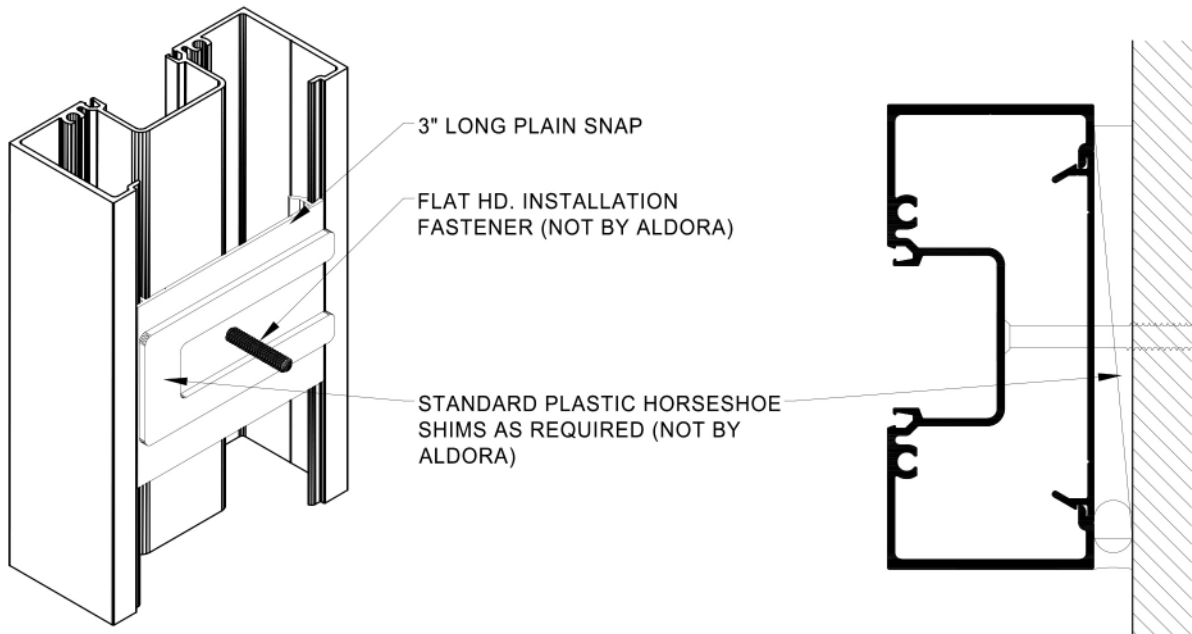
Installation Instructions (continued)

Transfer the installation holes to the sill flashing and seal. Install the frame with the flat head screws specified, sealing screw head with a cap seal.

Prior to installing the following frames, run a 6" bead of sealant at the bottom of each vertical mullion snap.

DO NOT SEAL THE EXTERIOR PORTION BETWEEN THE SILL FLASHING AND THE SILL FRAME TO ALLOW FOR DRAINAGE.

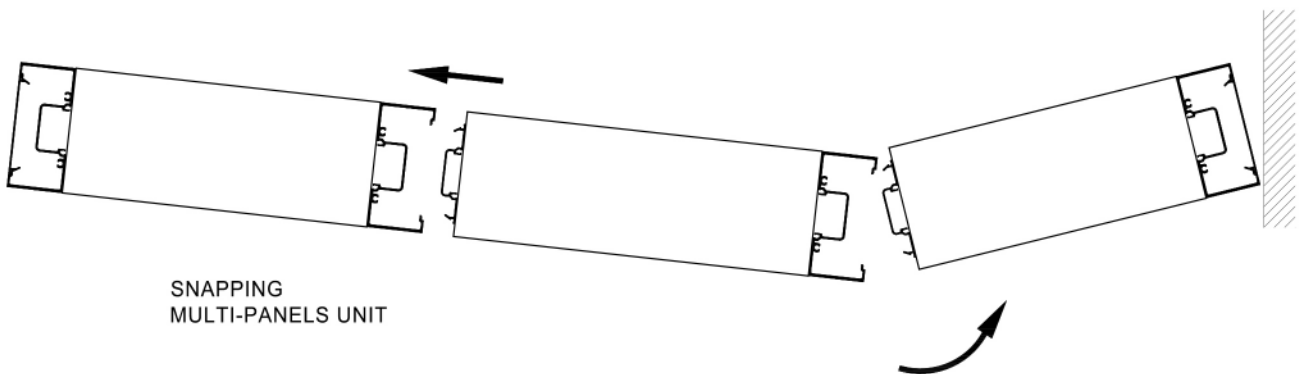
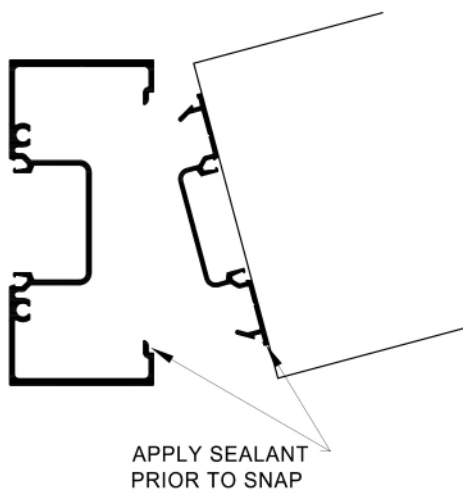




Installation Instructions (continued)

Use standard horseshoe shims to create the perimeter gap necessary for perimeter sealant to be applied. Shims are inserted around the installation screws between the plain snap and the substrate.

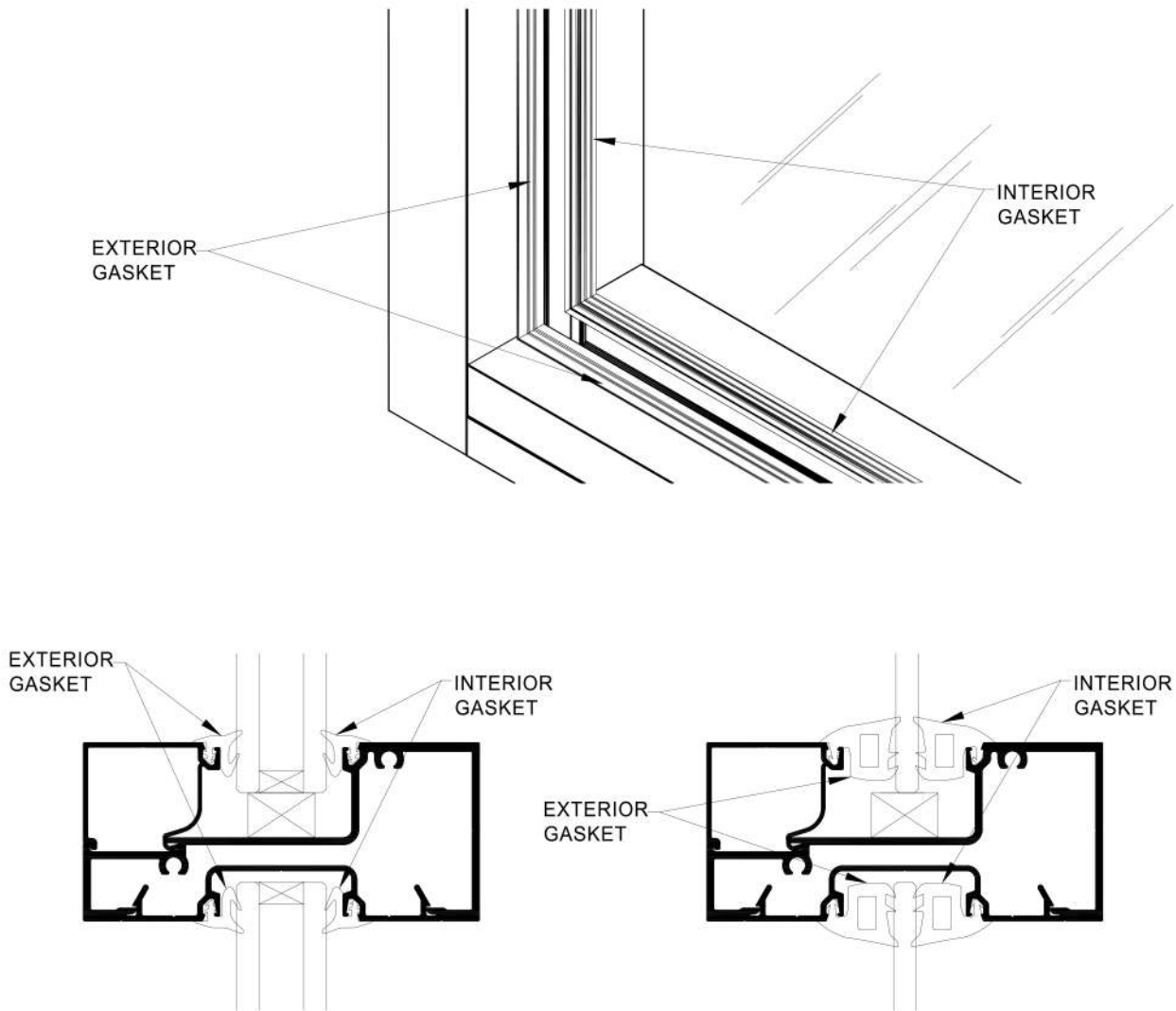
When installing multi-panel units, set the first panel (the panel with jambs on both verticals), then snap in the adjacent unit. Prior to snapping, run a 6" lg. sealant bead along the joints created at fin of both panels. Once snapped, fasten with installation screws at head and sill and repeat the process with each remaining panel until the opening is complete.



Installation Instructions (continued)

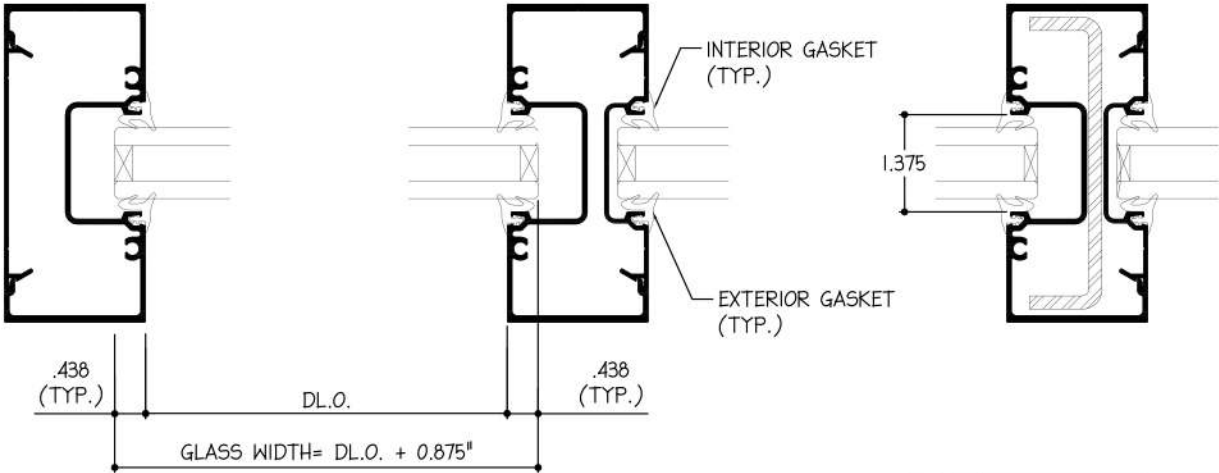
The SMI-245 System can be glazed with two (2) different glass types; non-impact 1/4" tempered and non-impact 1" IG. Depending upon the glass type (1/4" or 1"), the system gasket used will change.

Set the interior gasket on the internal perimeter groove of the framing, place the setting blocks at the bottom of the glass, 2 per lites at 1/4 points and set the glass in the pocket, position the glass bite to be even all around then work the exterior gasket at the external groove.



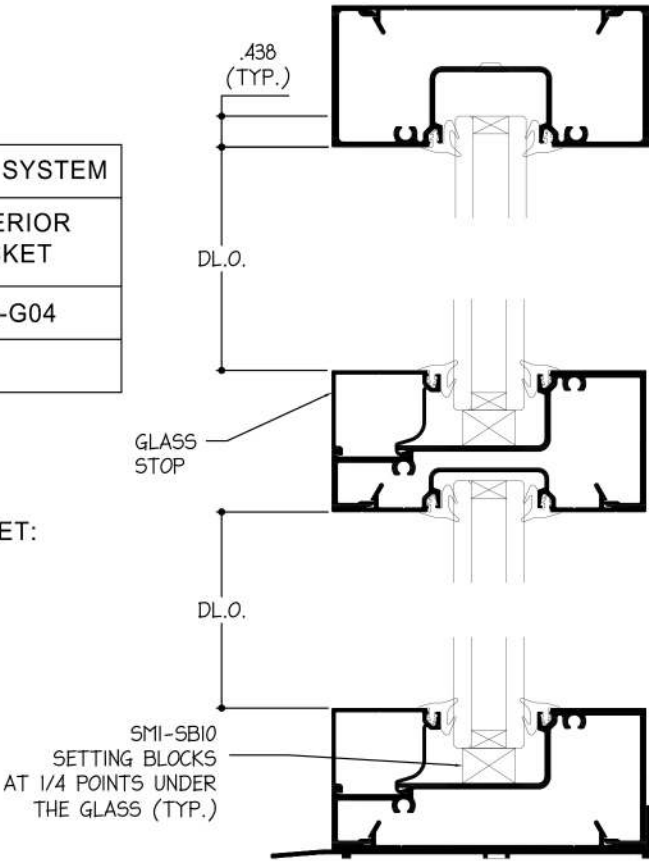
The SMI-245 allow two glass thickness. When glazing with 1" thk. insulated glass, use the gasket SMI-G04 at exterior and interior. The glazing pocket measures approximately 1 3/8" in width.

TYPICAL GLASS SIZE IS DAYLITE OPENING (D.L.O.) + 0.875"



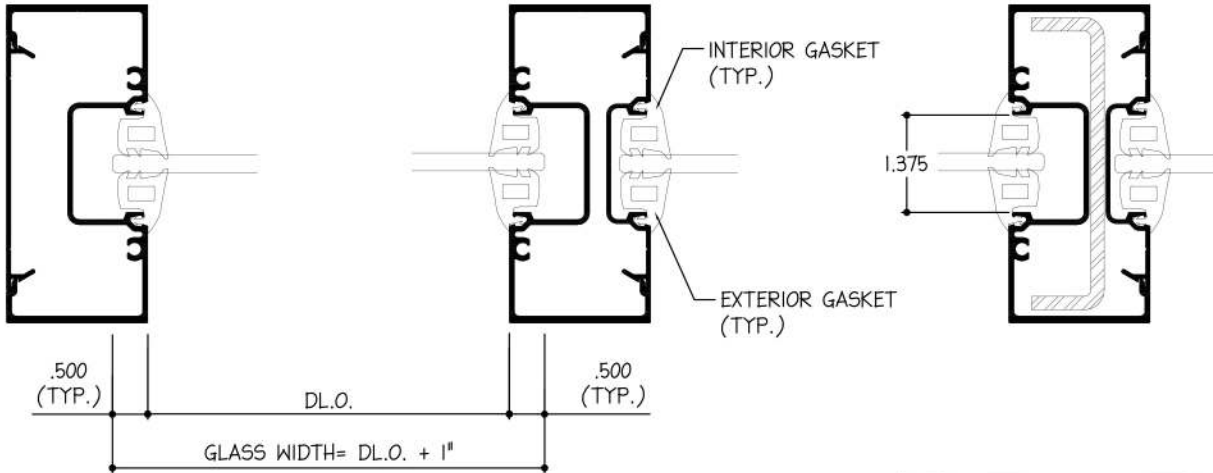
GLAZING CHART FOR SMI-245 STOREFRONT SYSTEM		
NOMINAL INFILL THICKNESS	EXTERIOR GASKET	INTERIOR GASKET
1"	SMI-G04	SMI-G04

EXTERIOR & INTERIOR GLAZING GASKET:



The SMI-245 allow two glass thickness. When glazing with 1/4" thk. tempered glass, use the gasket SMI-G08 at exterior and interior. The glazing pocket measures approximately 1 3/8" in width.

TYPICAL GLASS SIZE IS DAYLITE OPENING (DL.O.) + 1.00"

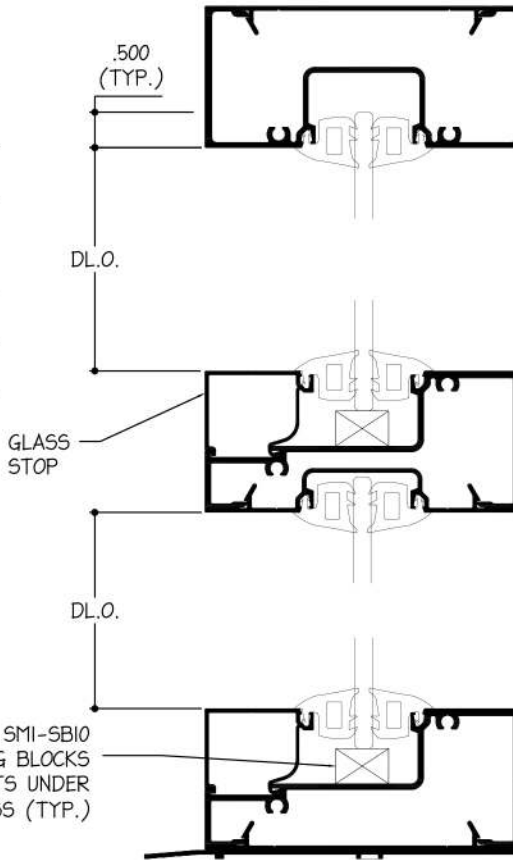


GLAZING CHART FOR SMI-245 STOREFRONT SYSTEM		
NOMINAL INFILL THICKNESS	EXTERIOR GASKET	INTERIOR GASKET
1/4"	SMI-G08	SMI-G08

EXTERIOR & INTERIOR GLAZING GASKET:



SMI-G08

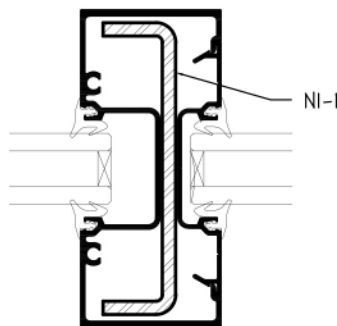


The 245 System has a reinforcement option and is required depending on the size of the units and the design pressures. The reinforcements must run the entire length of the vertical member. Please consult with your Aldora representative to ensure when use the proper reinforcement.

All steel must be coated with a corrosion-inhibitor including any cut ends.

STEEL REINFORCEMENT CHART FOR 245 SYSTEM		
PART #	SPECS	MULLION PART #
NI-1	1" X 4 1/8" X 1" 3/16" THK. FORMED STL. CHANNEL	SMI-213/217

STEEL REINFORCEMENT AT THE STANDARD MULLION
(WHEN REQUIRED, REFER TO NOA'S CHARTS)



SMI-213 / SMI-217