HANDLING, STORAGE, AND PROTECTION OF ALUMINUM

The following precautions are recommended to protect the material against damage. Following these precautions will help ensure early acceptance of your products and workmanship.

A. HANDLE CAREFULLY.
All aluminum materials at job site must be stored in a safe place, well removed from possible damage by other trades. Cardboard wrapped or paper interleaved materials must be kept dry.

B. CHECK ARRIVING MATERIALS.
Check for quantities and keep records of where various materials are stored.

C. KEEP MATERIALS AWAY FROM WATER, MUD, AND SPRAY.
Prevent cement plaster or other materials from damaging the finish.

D. PROTECT THE MATERIALS AFTER ERECTION.
Protect erected frame with polyethylene or canvas splatter screen. Cement, plaster, terrazzo, other alkaline solutions, and acid based materials used to clean masonry are harmful to the finish. If any of these materials come in contact with the aluminum, immediately remove with water and mild soap.

IMPORTANT: READ THIS MANUAL THOROUGHLY BEFORE BEGINNING INSTALLATION.

NOTE: Any modifications, other than those specified in this document, could result in this product's failure to meet UL safety ratings and void the manufacturer's warranties.

The rapidly changing technology within the architectural aluminum products industry demands that C.R. Laurence/U.S. Aluminum reserve the right to revise, discontinue, or change any product line, specification, or electronic media without prior written notice.

NOTE: Dimensions in parentheses ( ) are millimeters unless otherwise noted.
GENERAL INSTALLATION NOTES

Recommended Guidelines For All Installations:

1. **REVIEW CONTRACT DOCUMENTS.** Check shop drawings, installation instructions, architectural drawings, and shipping lists to become thoroughly familiar with the project. The shop drawings take precedence and include specific details for the project. Note any field verified notes on the shop drawings prior to installing. The installation instructions are of a general nature and cover most conditions.

2. **INSTALLATION.** All materials are to be installed plumb, level, and true. Install operable windows preglazed only.

3. **BENCH MARKS.** All work should start from bench marks and/or column lines as established by the architectural drawings and the general contractor with guaranteed accuracy. Working from these datum points and lines determine:
   a) The plane of the wall in reference to offset lines provided on each floor.
   b) The finish floor lines in reference to bench marks on the outer building columns.
   c) Mullion spacing from both ends of masonry opening to prevent dimensional build-up of daylight opening.

4. **FIELD WELDING.** All field welding must be adequately shielded to avoid any splatter on glass or aluminum. Results will be unsightly and/or structurally unsound. Advise general contractor and other trades accordingly. All field welds of steel anchors must receive touch-up paint (zinc chromate) to avoid rust.

5. **SURROUNDING CONDITIONS.** Make certain that construction which will receive your materials is in accordance with the contract documents. If not, notify the general contractor in writing and resolve differences before proceeding with work.

6. **ISOLATION OF ALUMINUM.** Aluminum to be placed in direct contact with uncured masonry or incompatible materials should be isolated with a heavy coat of zinc chromate or bituminous paint.

7. **SEALANTS.** Sealants must be compatible with all materials with which they have contact, including other sealant surfaces. Consult with sealant manufacturer for recommendations relative to joint size, shelf life, compatibility, cleaning, priming, tooling, adhesion, etc. It is the responsibility of the Glazing Contractor to submit a statement from the sealant manufacturer indicating that glass and glazing materials have been tested for compatibility and adhesion with glazing sealants, and interpreting test results relative to material performance, including recommendations for primers and substrate preparation required to obtain adhesion. The chemical compatibility of all glazing materials and framing sealants with each other and with like materials used in glass fabrication must be established. This is required on every project.

8. **FASTENING.** Within the body of these instructions "fastening" means any method of securing one part to another or to adjacent materials. Only those fasteners used within the system are specified in these instructions. Due to the varying perimeter conditions and performance requirements, perimeter and anchor fasteners are not specified in these instructions. For perimeter and anchor fasteners refer to the shop drawings or consult the fastener supplier.

9. **BUILDING CODES.** Due to the diversity in state/provincial local, and federal laws and codes that govern the design and application of architectural products, it is the responsibility of the individual architect, owner, and installer to assure that products selected for use on projects comply with all the applicable building codes and laws. U.S. Aluminum exercises no control over the use or application of its products, glazing materials, and operating hardware and assumes no responsibility thereof.

10. **EXPANSION JOINTS.** Expansion joints and perimeter seals shown in these instructions and in the shop drawings are shown at normal size. Actual dimensions may vary due to perimeter conditions and/or difference in metal temperature between the time of fabrication and the time of installation. Gaps between expansion members should be based on temperature at time of installation.

11. **COORDINATION WITH OTHER TRADES.** Coordinate with the general contractor any sequence with other trades which offset curtain wall installation (i.e. fire proofing, back-up walls, partitions, ceilings, mechanical ducts, converters, etc.)

12. **CARE AND MAINTENANCE.** Final cleaning of exposed aluminum surfaces should be done in accordance with AAMA 609.1 for anodized aluminum and 610.1 for painted aluminum.
# ORDER OF ASSEMBLY AND INSTALLATION

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## FABRICATION CALCULATIONS

### FABRICATION DEDUCTIONS:

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<td>Doorway Jamb</td>
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<td>Sub Sill</td>
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<td>Top Anchor Track and Sidelite Rail (Wall to Doorway)</td>
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### DOOR SIZE:

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<td>Door Width</td>
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**NOTE:**
- R.O. = Rough Opening
- D.L.O. = Daylight Opening
## PARTS IDENTIFICATION

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<td><img src="image23.png" alt="Image" /></td>
<td>4’ Square Sidelite Rail Housing</td>
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<td><img src="image24.png" alt="Image" /></td>
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For replacement parts, please contact Technical Sales at (800) 582-7501.
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**PARTS IDENTIFICATION (CONTINUED)**

- Neoprene Edge Block: 1” x 4” x 1/8” (25.4 mm x 101.6 mm x 3.2 mm) 65 ± 5 Durometer
- Setting Block
- 10-16 X 5/8” Hex Washer Head Self Drilling Screw
- 10 X 1-1/2” Hex Washer Head Self Drilling Screw
SITE PREPARATION

1. Review and measure the opening.

2. Verify rough window opening size 1/2” (12.7) clearance in both width and height to the window. Verify framing is plumb, straight, and true around window opening. Measure opening at each end and at center vertically and horizontally. Make corrections to openings as required. Measure opening diagonally to check squareness. Chip concrete high points to flush and rounded corners to square.
DOOR WITH SIDELITE INSTALLATION

Door with Sidelite Installation Order

1. Threshold | Page 10
2. Sub Sill | Page 11
3. Top Track and Header | Page 12
4. Wall Jamb | Page 13
5. Top and Bottom Rail | Page 14
6. Sidelite Glass | Page 15
7. Doorway Jamb at Sidelite | Page 16
8. Doorway Jamb at Wall | Page 18
9. Cladding | Page 19
10. Door | Page 31
11. Finishing and Sealing | Page 32
THRESHOLD INSTALLATION

1. Determine the perimeter centerline of the opening and location of the bottom door spindle from the shop drawings.
2. Install the cement box and closer if applicable.
3. Apply a continuous bead of **Cat. No. 33S** Sealant to the floor substrate around the perimeter line below the threshold. Leave two weep gaps for water drainage and set threshold while sealant is wet.
4. Fasten the threshold to the floor with the appropriate fasteners as specified in the engineering requirements. Cover fastener heads with **Cat. No. 33S** Sealant.

**NOTE:** For installations with doors, the threshold must be installed first to determine the location of the other components.

Threshold is notched on each end for Doorway Jambs that run through.

---

**Threshold Options**

- Half Saddle Threshold Offset Pivot
- Saddle Threshold Offset Pivot
- Saddle Threshold Center Pivot
- Half Saddle Threshold Center Pivot

**NOTE:** Saddle Threshold Offset Pivot shown in illustrations.
SUB SILL TRACK INSTALLATION

NOTE: Sub Sills are delivered with Fastening Clips installed in the track and End Dams sealed at each end.

1. Shim at each screw with Cat. No. PHS4 Horseshoe Shims turned parallel to Sub Sill. Position screws in center of slotted hole to allow for expansion.

2. Seal over screw heads with Cat. No. 33S Sealant.

NOTE: DO NOT block weep holes in Sub Sill.
Fastening Clips must be installed before Sidelite Rails. Use holes in Sidelite Rails as a guide for placement. Maximum distance between clips = 9” (229 mm)

1. Level and mount Header directly above Threshold.
2. Slide Fastening Clips into each top track. Mount track directly above Sub Sill. Secure with screws centered in slots.

Position screws in center of slotted holes. Turn PHS4 Shims parallel.  

Header is notched for Doorway Jamb.

# 10 Fastener appropriate for substrate
WALL JAMBS INSTALLATION

1. Fit the Wall Jamb Main Body on the Sub Sill with the cladded side facing the exterior. Push it tight against the End Dam and wall. 
2. Shim and fasten to the wall. 

NOTE: Cladded side faces exterior.

Position screws in center of slotted holes. 

Turn PHS4 Shims parallel. 

Wall Jamb sits on Sub Sill tight against End Dam.
TOP AND BOTTOM RAIL INSTALLATION

1. Position Top and Bottom Rails with Shear Clips next to Doorway Jamb.
2. Position Fastening Clips to line up with holes in Top and Bottom Rails. Secure with **10X112HHDTEK** self drilling screws.

NOTE: Do not block the drain slots placed between the mounting holes.

NOTE: The Shear Clips also act as spacers for the cladding. These clips are used only where the Rail butts against a Doorway Jamb.
SIDELITE GLASS INSTALLATION

1. Trim edges of the glass at face and sides with a sharp utility knife to remove any excess Silicone Sealant.

2. Place Setting Blocks at quarter points in Bottom Rail and Edge Blocks at quarter points inside Wall Jamb pocket.

3. Lift and set glass into pocket. Position glass so one end is outside opening 1/2" (12.7 mm).
DOORWAY JAMB AT SIDELITE INSTALLATION

1. With Slotted Holes next to Top Rail, fit Doorway Jamb onto glass and lightly tap into place.

2. Secure Jamb to Top and Bottom Rail Shear Clips with Cap Screws.

3. Ensure glass is fully inserted into both Jambs.

4. Fit Removable Stop to Wall Jamb Main Body and secure with screws at all predrilled hole locations.

NOTE: Spray glass edge with Cat. No. 1973 to prevent Doorway Jamb Gaskets from binding.
DOORWAY JAMB AT SIDELITE INSTALLATION (CONTINUED)

5. Hand tighten Set Screws in Doorway Jamb to center glass in Sidelite Rails. Torque 1/8 turn past tight to secure.

6. Roll **NP238** Gaskets into both sides of Top and Bottom Rails using a CRL Vinyl Roller.
**DOORWAY JAMB AT WALL INSTALLATION**

1. Mount Jamb Anchor to wall.

   - Turn **PHS4** Shims parallel.
   - Position screws in center of slotted holes. Secure Jamb Anchor to wall.

2. Place Doorway Jamb and secure using the Set Screws on each side.

   - Slide Doorway Jamb against Jamb Anchor.
   - Hand tighten Set Screws in Doorway Jamb evenly. Torque 1/8 turn past tight.

---

# 10 Fastener appropriate for substrate

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**ENTICE SERIES ENTRANCE SYSTEMS INTERIOR GLAZE**

**ALUMINUM**
CLADDING INSTALLATION

Remove liner from VHB Tape and apply Cladding. Roll On Pressure = 15 Pounds Per Linear Inch.

NOTE: Apply Cladding to Header before hanging doors.
1. Follow instructions on Page 8 for Site Preparation, Page 10 for Threshold Installation, and Page 12 for Top Track Installation.
TRANSOM DOORWAY JAMB INSTALLATION

1. Install Doorway Jambs with notched ends at top, facing the door opening. See Pages 16-18 for mounting options.

TRANSOM VERTICAL JAMB INSTALLATION

TRANSOM TOP RAIL INSTALLATION

1. Position Fastening Clips above holes in Top Rail and secure.

TRANSOM HEADER INSTALLATION

1. Attach Left and Right Support Fin Bottom Fittings to each end of Transom Header Main Body. 
   NOTE: Header ends are notched to accept Support Fins. Support Fins are installed on interior.

2. Match holes on Doorway Jambs with holes of Support Fin Fitting and secure with screws.
TRANSOM GLASS INSTALLATION

1. Trim edges of the glass at face and sides with a sharp utility knife to remove any excess Silicone Sealant.

2. Place Setting Blocks 4" from each end of Transom Header and Edge Blocks at quarter points inside Transom Jamb Vertical pocket.

3. Lift and set glass into pocket. Center.

4. Roll NP238 Gaskets into both sides of Top Rail using a CRL Vinyl Roller.

5. Install Removable Stop for Header and then install Removable Stops for Transom Verticals. Secure with screws at all predrilled hole locations.

6. View from Interior
**SUPPORT FIN INSTALLATION**

NOTE: Go to Page 19 to install Cladding before proceeding with the Support Fin installation.

3. Install Nylon Grommets in top holes and slide glass into Mounting Bracket.
4. Secure.
5. Secure.
6. Remove paper from Double Stick Tape and apply Fitting Covers.

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1. Follow instructions on Page 8 for Site Preparation and Pages 11-12 to install Sub Sill and center Top Track above it. (Top Track is cut 1/2" (12.7 mm) short.)

2. Follow instructions on Page 13 to install Wall Jambs.
FIXED LITE TOP AND BOTTOM RAIL INSTALLATION

1. Attach Vertical Shear Clips at Intermediate Mullion position on Top and Bottom Rails.

2. Position Fastening Clips above holes in Top and Bottom Rails and secure.

Do not block Drain Slots.
FIXED LITE GLASS INSTALLATION

1. Trim edges of the glass at face and sides with a sharp utility knife to remove any excess Silicone Sealant.

2. Place Setting Blocks at quarter points in each section of Bottom Rail and two Edge Blocks inside each Wall Jamb Vertical pocket.

3. Lift and set each glass panel into pocket and center.

4. Place Removable Stop on Wall Jamb Main Body and secure with screws at all predrilled hole locations.
INTERMEDIATE VERTICAL MULLION INSTALLATION

1. Fit Vertical Mullion Main Body between Vertical Mullion Shear Clips.

2. Fit Removable Stop and secure with screws at all predrilled hole locations.

3. Roll **NP238** Gaskets into both sides of Top and Bottom Rails using a CRL Vinyl Roller.
DOUBLE DOOR WITH FRAME INSTALLATION

Double Door with Frame Installation Order

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Doorway Jamb at Wall

Doorway Jamb at Wall

Door
OPTIONAL CORNER INSTALLATION

1. Install Mitered Sub Sill and Top Track above.
2. Install Corner Main Body and Wall or Doorway Jambs on either side of it.

3. Install Top and Bottom Sidelite Rails with Corner Shear Clips next to Corner Main Body.

4. Prepare and install glass panels. Fit Removable Stops and secure with screws at all predrilled hole locations.
DOOR INSTALLATION

The doors for the Entice System are shipped fully assembled. Because of the weight of both the aluminum and the glass, it is advisable that two individuals are involved in moving and installing this door.
NOTE: Installation varies with hardware selection. Consult Installation Instructions in hardware packages.

Use included T-Handle Key to turn the adjustment screws on the top and bottom of the hinge side of the door.
With the door open, turn clockwise to adjust the Door Rail away from the jamb and counter-clockwise to adjust the Door Rail towards the jamb. Make sure the gaps are parallel and the correct size.

NOTE: A slight clicking noise may be heard. This sound is caused by our friction retention mechanism that will help prevent the screw from loosening out of alignment.

CENTER PIVOT DOORS:
To center the door, loosen the two Pan Head Phillips Screws holding the arm to the block, then adjust the two hex bolts at the end of each arm to slightly change the angle of the arm as it mounts in the Door Rail. Make sure that both hex bolts are tightened against the inside face of the Door Rail, and the two Pan Head Phillips Screws are tightened to the block when adjustment is complete to secure the adjustments into place.
PERIMETER SEALING

1. Seal around Doorway Jamb at Threshold.
   Seal around Doorway Jamb at notched Threshold with **Cat. No. 33S Clear Silicone**.

2. Seal joints between Bottom Rail and Sub Sill inside and outside.

3. Install Backer Rod and seal perimeter with **Cat. No. 95C Silicone Sealant** at all shimmed areas inside and outside.

4. Seal interior perimeter at all verticals 2” (203 mm) up from ground where they meet Bottom Rails.

5. Seal outside bottom corners where all verticals meet Bottom Rails.
GLASS REPLACEMENT FOR DOORS
REMOVE DAMAGED GLASS

Support door on sturdy sawhorses.

Remove door handles and panic or exit devices and store in a safe place.

Loosen Set Screws on both sides of Vertical Stiles.

Remove Socket Head Cap Screws from each corner.

Remove Vertical Stiles and Top and Bottom Rails. If Gaskets are not in good condition, remove them. If replacing Top and Bottom Rail Cladding, do so now.

Remove Cladding from both sides of Vertical Stiles.

Back out Clamping Screws on Top and Bottom Rails.

NOTE: Handle Cladding with care so as to not bend or scratch it.

NOTE: Handle Cladding with care so as to not bend or scratch it.
INSTALL REPLACEMENT GLASS

Verify replacement glass size and mounting hole placement for handles.

Place Top and Bottom Rails and tighten Clamping Screws.

NOTE: Ensure Rails are properly supported until secured to Vertical Stiles.

Spray glass edges with **Cat. No. 1973** to prevent Gaskets from binding and install Vertical Stiles.

Replace Gaskets in Vertical Stiles if needed.

NOTE: The Vertical Stiles may be installed as three separate pieces. First apply the Clamping Strip to the glass, then fit the Gasket Housing over it and finally slide the Vertical Stile over it. This works well with oversized glass thickness.

Apply Blue Loctite to Socket Head Cap Screws and fasten Vertical Stiles to Top and Bottom Rails.

Ensure Stiles are Straight

Ensuring Bottom Rail is tight against glass

Push frame at bottom to ensure Setting Block is in contact with glass. Ensure Bottom Rail is tight against glass and Vertical Stiles are straight.

Tighten Set Screws evenly on Hinge Side of the Vertical Stiles. Torque 1/8 turn past tight.
Tighten Set Screws evenly on Handle Side of the Vertical Stiles. Torque 1/8 turn past tight.

Measure between Vertical Stiles near Bottom Rail and again at middle to ensure Stiles are straight.

Turn Adjuster in Top Rail on Handle Side clockwise until it contacts glass. Measure diagonally to corners. If needed, turn Adjuster again to raise corner a maximum of 1/8” (3.2 mm) until door is square.

Apply Blue Loctite on all attachment fasteners and install door handles.

Follow instructions on Page 30 to install and adjust door.

NOTE: If Handle Side sags, loosen Set Screws and turn Adjuster to raise. Then tighten Set Screws.

Remove liner from VHS Tape and apply Cladding to Vertical Stiles.

Roll On Pressure = 15 Pounds Per Linear Inch