

## Glazing Instructions:

Note: These are general glazing instructions and **may not** be used for HVHZ (Impact Rated) products. See the Fleetwood website ([www.fleetwoodusa.com](http://www.fleetwoodusa.com)) for the product specific glazing instructions.

1. **Cleaning Glass** - Use alcohol to wipe at least a 2" edge distance around the entire glass perimeter. (**Note:** It is very important that the glass perimeter is clean of oils, dirt or debris to ensure proper bonding of silicone to the glass.)
2. **Select Proper Blocks** - Setting and edge blocks for each product series are as defined in the table below.

**Table 1 – Glazing Components**

Product Series	Setting Block 23217 (Rigid PVC)	Setting Block 18620 (4" x 1/4" x 1")	Setting Block 18621 (4" x 1/8" x 1")
Series 250-T	Yes (Sill)	Yes (Head & Jambs)	Yes (if needed)
Series 530-T GTF	Yes (Sill)	Yes (Head & Jambs)	Yes (if needed)
Series 3800-T	Yes (Sill)	Yes (Head & Jambs)	Yes (if needed)
Series 3400P	No	Yes (1" Glazing)	*Yes (1/4" Glazing)
Series 3200-T	Yes (B-Rail)	Yes (Top & Side Rails)	Yes (if needed)
Series 3600-T	Yes (B-Rail)	Yes (Top & Side Rails)	Yes (if needed)
Series 3900-T	Yes (B-Rail)	Yes (Top & Side Rails)	Yes (if needed)

\*18621 must be cut to 3/8" width

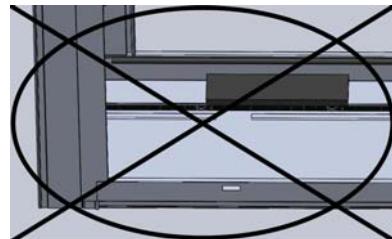
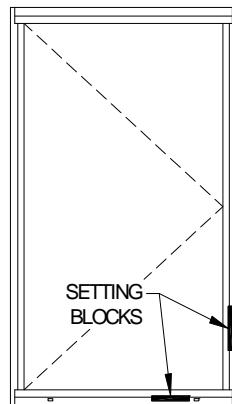
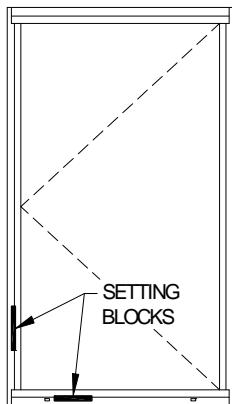
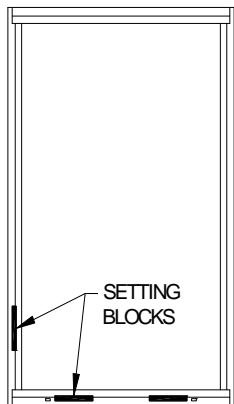
3. **Centering Glass** - Use 2 or 3 setting blocks as shown below to establish a corner to locate glass before glazing. Locate the sill setting blocks approximately 6" in from the jamb. Be careful not to block any weep holes or notching that is used to evacuate water from the frame or vent. Use silicone to hold the blocks in place if they do not have an adhesive backing.

GTF, Awning, or Hopper

Hinged Left

Hinged Right

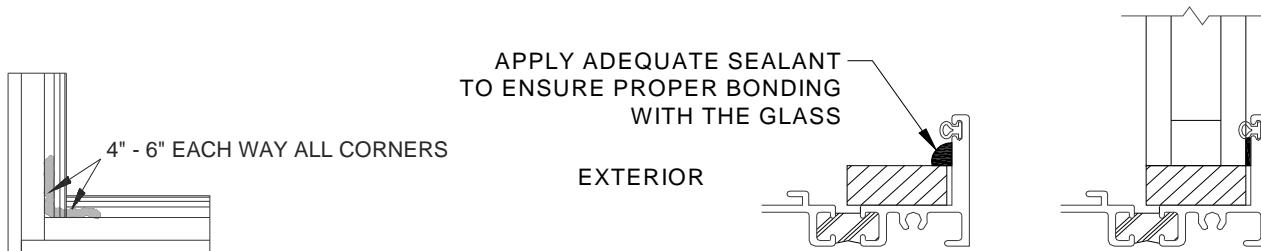
Do Not Block Weeps



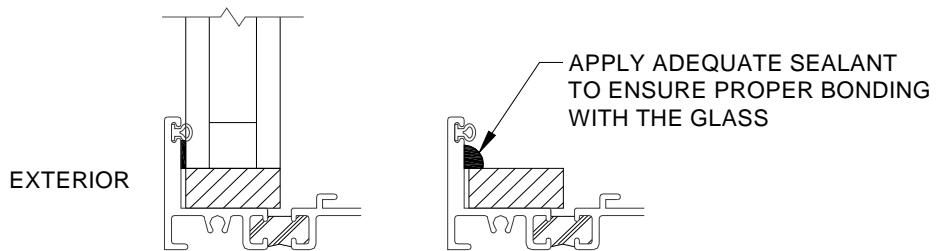
## 4. Application of Sealant:

**Note to Installer:** After applying sealant as defined below it is very important that the glass be glazed immediately. The sealant, depending on environmental conditions, forms a skin within minutes of application. Once the sealant has formed a skin the glass will not bond properly to the sealant.

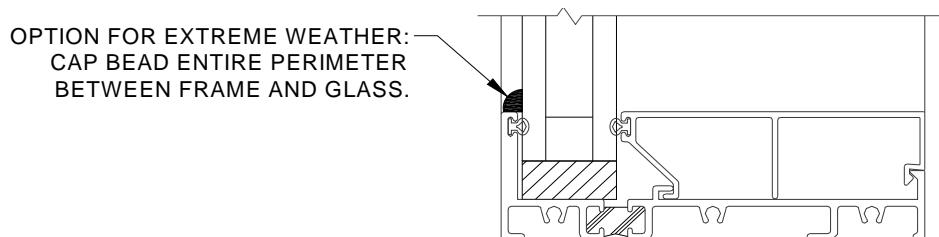
**Outside Glazed Products** – Apply 4"-6" bead of sealant at the **corners as shown** in the figure below. Be sure to apply adequate sealant to ensure proper bonding with the glass. This sealant prevents one from easily removing the glass from the outside and entering the dwelling. (Note: glass must be centered in opening)



**Inside Glazed Products** – Apply a heal bead of sealant around the **entire perimeter** of the frame as shown in the figure below. Be sure to apply adequate sealant to ensure proper bonding with the glass. This sealant is used to prevent air and water from entering the dwelling. (Note: glass must be centered in opening)

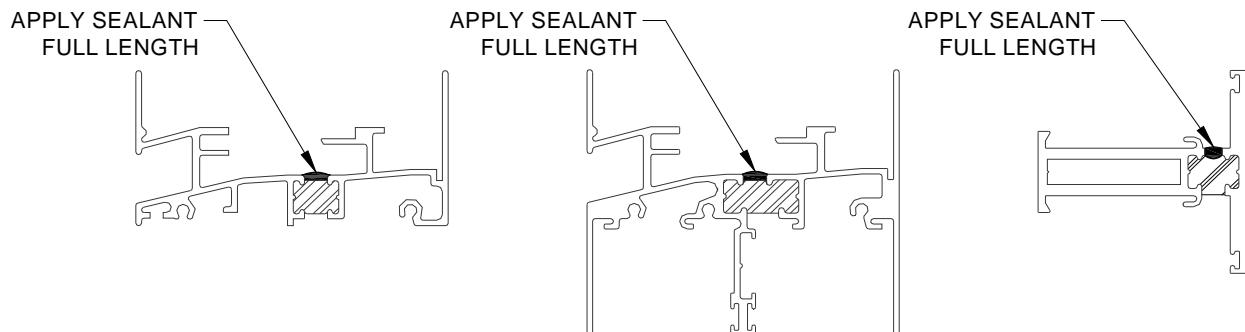


**Optional Extreme Weather Cap Bead (Applied in Field Only)** – In extreme weather conditions it is recommended the installer add a cap bead of sealant around the perimeter of the frame (either exterior or interior) as shown below.



## 5. Extreme Weather or Dry Shrinkage Conditions (Insulated Frame Products Only)

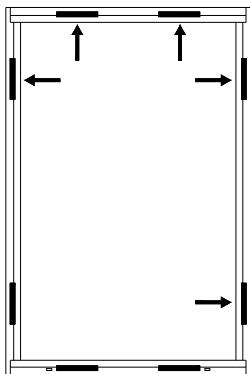
For installations that will be exposed to extreme weather, apply a compatible sealant on top of the thermal break cavity of sills, t-bars and stack bars as shown



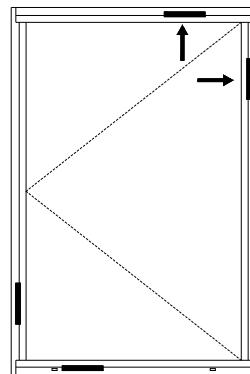
## 6. Securing Glass

Insert additional setting and edge blocks as required into jambs and the head as shown below to square the glass with the vent and prevent movement. Edge blocks may be stacked (using adhesive backing) to minimize or eliminate gap between frame and glass. Use silicone to hold the blocks in place if they do not have an adhesive backing.

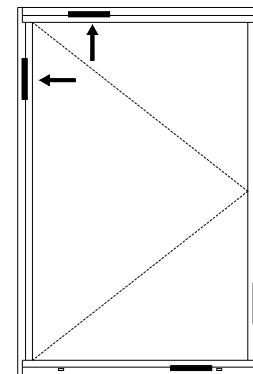
GTF or Awning



Casement Left



Casement Right



7. **Installing Glass Stops** - Finish the assembly by inserting the glass stops into the head, sill and finally the jambs. Install the stop by inserting the lead leg of the glass stop into the hook of the frame. Then push the glass stop down towards the frame to snap into place. (Note: When removing the precut glass stops from the frame or vent, note location of removal. Each glass stop is hand cut for a specific location on the frame or vent and must be returned to the same location during the glazing process.)

