ELEPHANT
WINDOWS & DOORS

G MAX FIELD MULLING INSTALLATION GUIDE

G Max Window System · English Edition

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1 **Factory preparation / Step 01**

G Max Window Field Mulling

For side-by-side G Max windows with a factory-installed T-bar. Use with the project drawings and standard window installation instructions. Level, plumb, square, fasten and flash the first unit before joining the next unit.

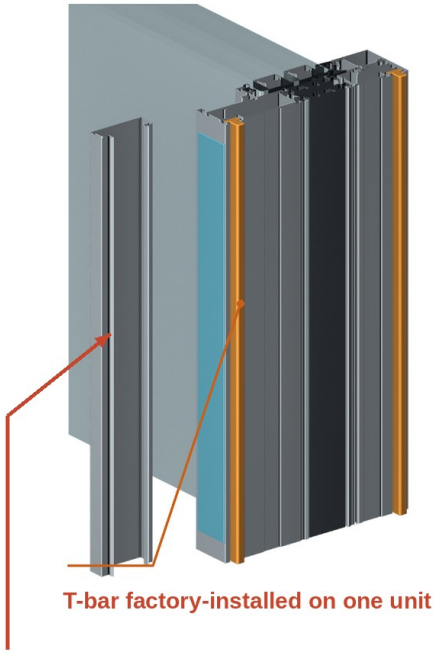
Load support: The T-bar provides alignment and assists sealing; it does not carry sash or window dead load. Support all vertical weight with load-bearing blocks and the specified installation fasteners or anchors, transferring the load to the building structure.

Factory condition: mating fins removed



Keep protective film on BOTH mating frames

Mull joint detail



Blue: protective film on both units. Orange: T-bar. The factory-removed glazing bead is shown offset for clarity.

01 Check the factory preparation

Verify unit numbers, configuration and dimensions; inspect frames, glass and parts for damage. Both mating nail fins must be factory-removed, with the T-bar preinstalled on one unit. The fixed unit's interior glazing bead at the mull has been removed to expose the predrilled holes. Check the supplied screws and covers.

Site preparation

Have tools and cleaning supplies ready. Wear eye protection and cut-resistant gloves. Use handling equipment suitable for the window weight; support the units and prevent tipping.



Caulk gun · Padded clamps · Level · Tape measure · Screwdriver · Rubber mallet · Lint-free wipes

Use only the factory-installed T-bar for field mulling. Use the supplied parts and project anchorage and support details. Tool photographs are for identification.

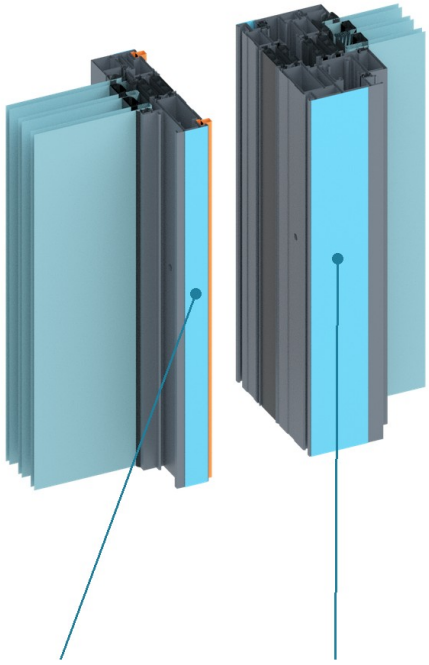
2 **Preparation / Steps 02–04**

Protect both units and set the first window

Level, plumb, square and fasten the first unit before applying mull sealant or bringing in the second unit.

Protect both units

Mating-frame detail. Glass stays in place.



Protect the finish from sealant squeeze-out.

First unit: level, plumb and fasten



Wood rough opening: support and fasten as detailed.

Keep film out of bonding channels. Wood framing is illustrative; use the framing, anchors and shims specified for the project.

02 Check the protective film on both units

Keep film on the exposed frame finishes beside BOTH mating edges to protect against sealant squeeze-out. Replace damaged or missing film and fit it closely to the edges. Keep bonding channels clear.

03 Check the rough opening

Verify opening dimensions, level, plumb and square. Check support and flashing substrates; the sill flashing must drain to the exterior. Remove dirt, debris and moisture from mating faces and channels.

04 Install and flash the first unit

Follow standard window installation practice and the project drawings. Prepare the opening and sill flashing. Before setting the unit, apply sealant to the back of the remaining nail fin where it contacts the opening; leave bottom drainage breaks as detailed. Set load-bearing blocks, level, plumb and square the frame, then fasten it. Integrate the fin flashing with the wall’s weather-resistive barrier. Support the second unit independently; do not hang it from the T-bar.

Wood framing and support blocks illustrate the installation sequence. Use the framing and support configuration specified for the project.

3 **Mull sealant / Step 05**

Straight beads in channels, S-pattern on aluminum

Apply sealant only when the units are ready to be joined immediately. Stay within the sealant's stated open time. Do not leave coated mating surfaces unjoined for an extended period.

Apply sealant to the frame WITHOUT the preinstalled T-bar

1 First designated channel

Continuous straight bead, full length

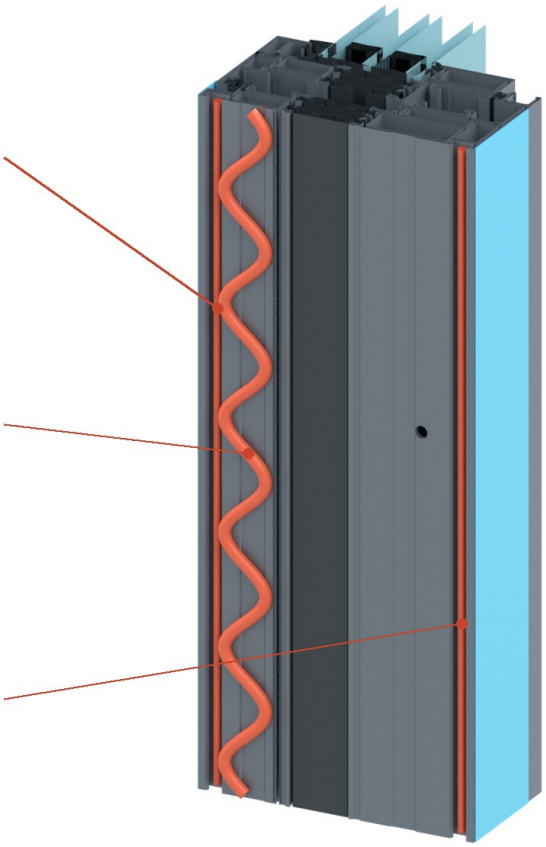
2 Exterior aluminum section

Continuous S-pattern bead centered on the mating side face

3 Other designated channel

Continuous straight bead, full length

Keep all beads continuous with no gaps or missed sections



Straight beads stay in the designated channels. Center the S-pattern on the exterior aluminum mating face. Keep drainage clear.

05 Apply sealant at the designated locations

Apply to the frame WITHOUT the preinstalled T-bar. Run continuous straight beads the full length of both designated channels. Apply a continuous S-pattern bead along the center of the exterior aluminum mating side face. Keep beads even and uninterrupted. Sealant added to the exposed face after joining cannot replace these beads.

Check before joining

Inspect the beads and both ends. Correct missed areas, contamination or sealant that has exceeded its working time according to the sealant instructions, then reapply and join.

Sealant: Neutral-cure, 100% silicone for window and door applications, meeting ASTM C920, Grade NS, Class 25 or a higher movement class. It must be compatible with finishes, gaskets and flashing materials and suitable for the joint's application and curing conditions.

4 **Joining and clamping / Steps 06–07**

Align the frames and clamp evenly

Keep glass in both units. Support the second unit independently. After bringing the units together, check level and plumb before tightening clamps.

06 Bring together slowly



Before clamping

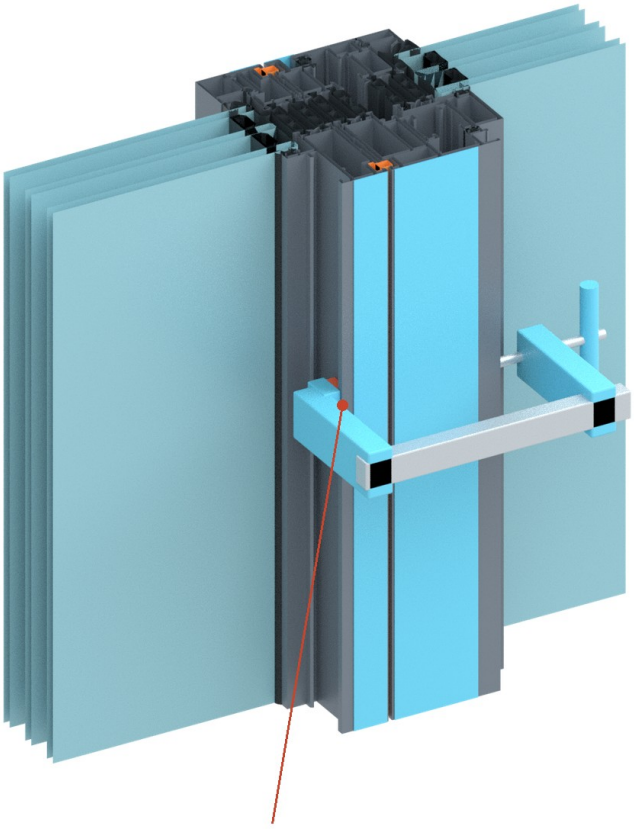
Level and plumb the second unit



07 Clamp evenly



Clamp detail: glass stays in place



Padded jaws bear on designated frame sections

Align before clamping. Keep jaws off glass, glazing beads, operable sash and thermal breaks. Clamp locations shown are illustrative.

06 Bring the units together slowly

Before setting the second unit, apply sealant to the back of its remaining nail fin. Align elevations and frame planes, then slowly bring the units together in parallel so the T-bar enters the mating channel. If it binds, back off and inspect; do not hammer or force it. Recheck the second unit for level, plumb and alignment before clamping.

07 Clamp progressively and evenly

Use padded clamps along the mull and tighten evenly in stages. Bear only on the designated load-bearing frame sections. Keep glass in place. Do not clamp glass, glazing beads, operable sash or thermal breaks.

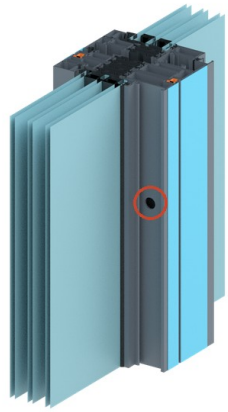
Some squeeze-out may occur, but it does not prove that the concealed seal is complete. If alignment shifts, loosen the clamps and correct it.

5 **Alignment and fastening / Steps 08–09**

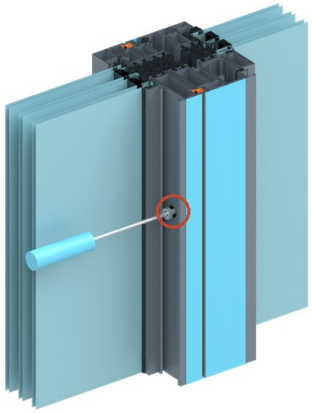
Drive screws through the glazing-bead recess

The fixed unit's glazing bead is factory-removed. Insert the driver through the exposed access hole to connect the inner frame walls. Keep glass in place.

Access behind the glazing bead



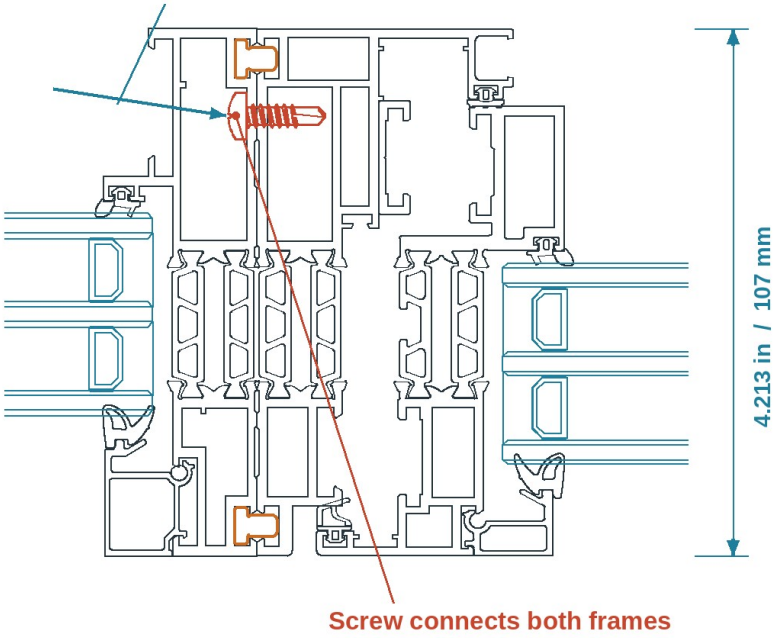
Factory-removed bead exposes access hole

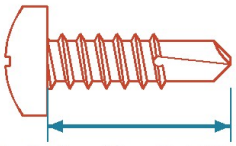


Drive the supplied screw through the recess

Mull cross-section

Interior at top. Fixed unit left; casement right.





Mull screw detail

Nominal diameter: #10 (approx. 4.8 mm)

Use factory-supplied screws and holes

Under-head length: 5/8 in (approx. 16 mm)

Use factory-supplied screws and predrilled holes. See the screw specification below.

08 Recheck alignment

Check both units for level, plumb, square and matching elevations. Corresponding interior and exterior edges must be flush, with a uniform joint and no frame twist.

09 Install the mull screws

Maintain support and clamping. Drive the supplied screws through the factory-predrilled holes in the recess normally covered by the glazing bead. Tighten in stages from the middle of the mull toward the top and bottom; recheck alignment. Do not use screws to pull misaligned frames together or overtighten.

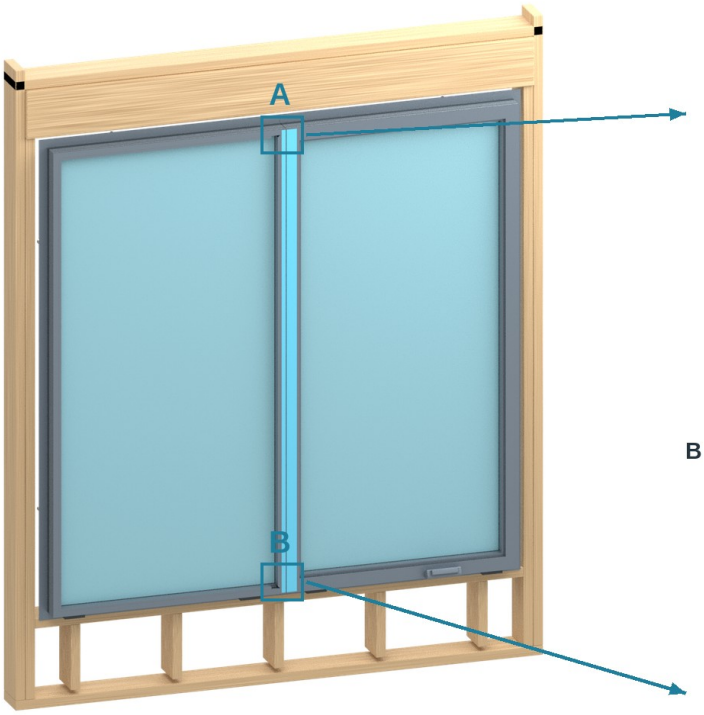
Mull screw: #10-16 × 5/8 in stainless steel Phillips pan-head self-drilling screw (approx. 4.8 × 16 mm). Use supplied screws and predrilled holes; do not enlarge holes. Building anchors are specified separately in the installation drawings.

6 **Anchoring and sealing / Steps 10–11**

Anchor each window and seal both mull ends

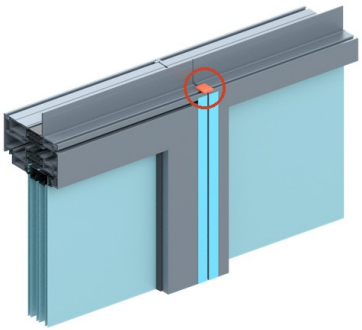
Mull screws connect the windows to each other. Each unit still requires its specified anchorage to the building.

10 Anchor each unit to the structure

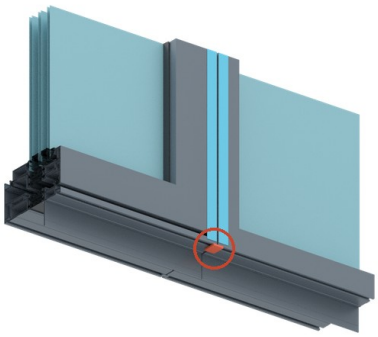


11 Seal the top and bottom mull ends

A Top: seal the mull end only



B Bottom: seal the end; keep drainage clear



Use the remaining perimeter fins or specified anchors

Mull screws do not replace structural anchors

Orange-red shows end seals only. Do not add sealant along the exposed vertical face. Flash the opening and maintain drainage.

10 Complete structural anchorage

Fasten the second unit to the building through the remaining nail fin or specified anchors, and recheck the first unit. After anchoring, recheck joint dimensions and frame position. Remove clamps only after confirming secure fastening and no movement. Avoid impacts that could shift the frames.

11 Complete the weather seals and flashing

Seal the top mull end in detail A and the bottom mull end in detail B. Do not add a bead along the exposed vertical face. Complete fin transitions, head flashing or the drip-cap detail, and perimeter flashing with weather-shedding laps into the wall's weather-resistive barrier. Preserve bottom drainage paths.

Orange-red in this figure indicates mull end seals only. Keep weep holes and drainage paths open.

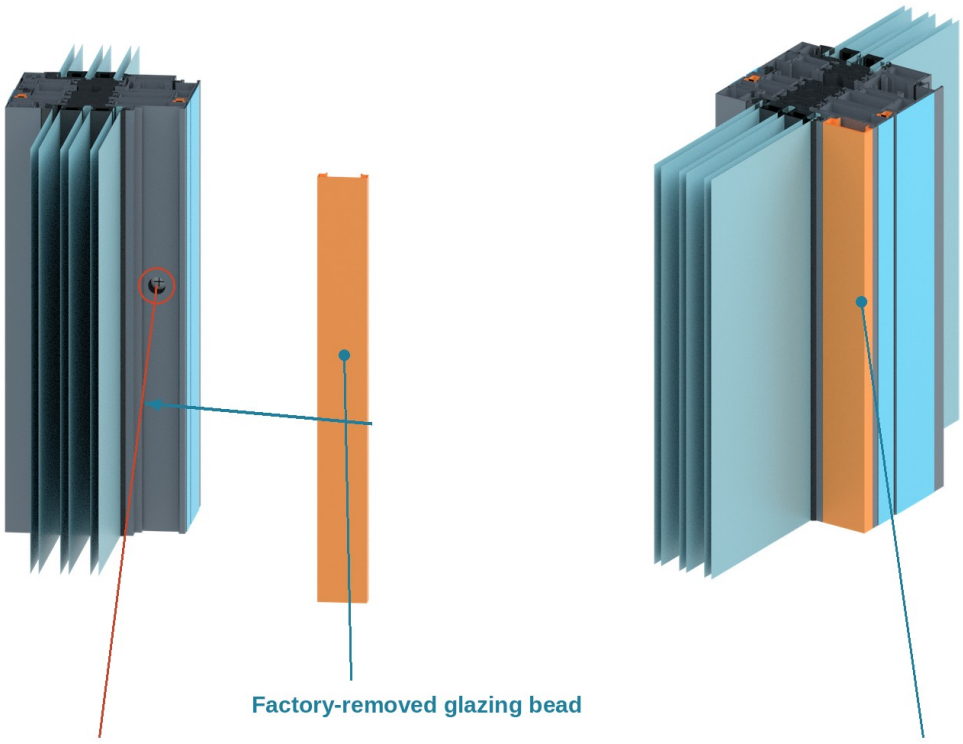
7 **Refitting and cleanup / Steps 12–13**

Refit the glazing bead after checking the screws

The bead will conceal the screws and holes. Inspect the connection and any required hole seals before refitting it.

Check screws before refitting the bead

Refitted bead conceals screws and holes



Check screws and required hole seals

Keep glass in place. Refit the original bead.

Align with the original groove and snap in

Tap the bead lightly with a rubber mallet if needed. Never strike glass.

Orange identifies the glazing bead. Refit after checking the connection; the bead must sit flush and secure. Keep film on both units.

12 Snap the glazing bead back into place

After checking screws and required hole seals, align the factory-removed bead with its original groove and snap it in. If needed, tap the bead lightly with a rubber mallet while protecting the finish. Never strike or press against glass. Check for loose or raised sections, then refit the supplied gaskets and hole covers.

13 Clean sealant squeeze-out

Remove excess sealant promptly as instructed by its manufacturer. Keep protective film on both units. Do not scratch the finish, pull sealant out of the joint or push residue into drainage paths.

Do not wait for excess sealant to harden and then scrape it off forcefully. Use cleaning materials compatible with the finish.

8 **Final inspection / Steps 14–15**

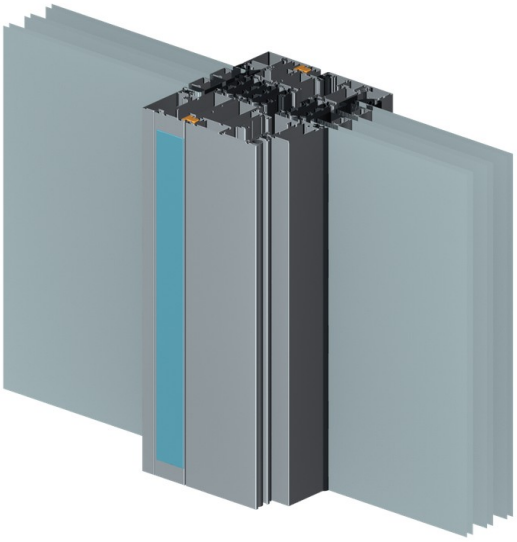
Inspect the assembly and remove film as directed

Before handover, check connections, seals, finishes and window operation.

Final inspection



Recheck and remove film



Check finishes and seals

Remove residue and dust

Recheck at about 24 hours. Follow sealant and film instructions for removal; 24 hours does not mean full cure.

14 Perform the final inspection

Check that joints are tight, all screws are installed and seals are continuous. Frames must be level, plumb and free of distortion. Confirm clear drainage and correctly seated beads and covers. Check sash opening, closing and locking.

15 Recheck and remove the protective film

Recheck at about 24 hours. Follow the sealant and film manufacturers' instructions to determine film-removal timing for both units; 24 hours does not mean full cure. Peel carefully without pulling the joint seal, then remove residue and dust.