Flangeless Installation Instructions
(Full-Frame and Insert Installations)

- **Product Series** - 100 Series
- **Product Type** - All Windows

Read these instructions before starting procedure. For additional information visit www.andersenwindows.com. For questions call 1-888-888-7020.
Para obtener una versión en español de esta guía, visite el sitio www.andersenwindows.com

Parts Included:

- Window (single-hung shown in guide)
- Exterior Sill Extender Trim (optional)
- Head Expander (optional)
- Screw Pack(s)
- Installation Clip Pack(s)

- For Full-Frame Window Installation, go to page 8.
- For Insert Window (Interior Installation), go to page 19.
- For Insert Window (Exterior Installation), go to page 33.
Andersen Installation Sealant may be used at the sill as a structural attachment alternative to installation clips in flat sill insert applications. No sealant substitutions may be made. See interior and exterior insert instructions for details. Failure to use Andersen Installation Sealant may result in product or property damage.

Tools and Supplies Needed:

- Safety Glasses
- Protective Gloves
- Tape Measure
- Drill / Driver
- Utility Knife
- Putty Knife
- Level
- Caulking Gun
- Combination Square
- Rubber Mallet
- Wood Block
- J-roller
- Reciprocating Saw
- Foam Backer Rod
- Shims (waterproof)
- Non-Abrasive Cleaner
- Cleaning Cloth
- Fasteners
- Sealant
- Andersen Installation Sealant (Flat sill structural attachment alternative)
- Level
- Caulking Gun
- Combination Square
- Rubber Mallet
- Wood Block
- J-roller
- Reciprocating Saw
- Foam Backer Rod
- Shims (waterproof)
- Non-Abrasive Cleaner
- Cleaning Cloth
- Fasteners
- Sealant
- Andersen Installation Sealant (Flat sill structural attachment alternative)

NOTICE
Andersen Installation Sealant may be used at the sill as a structural attachment alternative to installation clips in flat sill insert applications. No sealant substitutions may be made. See interior and exterior insert instructions for details. Failure to use Andersen Installation Sealant may result in product or property damage.

IMPORTANT
Flat sill structural attachment alternative requires Andersen Installation Sealant. Pre-order adequate amount of sealant prior to installation.

- Units in joined combinations must be individually supported to the rough opening.
- Do Not remove band or packing clips from windows until instructed.
- Anchoring screws must attach to framing members.
- Depending on unit size, windows may or may not come with installation clips applied.

Window Identification:

- Single-Hung
- Arch Single-Hung
- Casement
- Awning
- Gliding
- Fixed
- Combinations
### FASTENER CHART

#### INSTALLATION CLIP ANCHORING REQUIREMENTS (select one)

<table>
<thead>
<tr>
<th>Fastener</th>
<th>Substrate</th>
<th>Minimum Head</th>
<th>Minimum Shank</th>
<th>Minimum Embedment to Structural Framing</th>
<th>Steel Type/Coating</th>
<th>Spacing</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wood Screw</td>
<td>Wood</td>
<td>5/16&quot;</td>
<td>#8</td>
<td>1-1/2&quot;</td>
<td>Galvanized, Zinc Chromate, *Stainless Steel, *Ceramic Coated</td>
<td>2 per Clip</td>
</tr>
<tr>
<td>Wood Screw</td>
<td>Wood</td>
<td>5/16&quot;</td>
<td>#12</td>
<td>1-1/2&quot;</td>
<td></td>
<td>1 per Clip</td>
</tr>
<tr>
<td>Self-Tapping</td>
<td>Metal</td>
<td>5/16&quot;</td>
<td>#8</td>
<td>3 Full Threads</td>
<td></td>
<td>2 per Clip</td>
</tr>
<tr>
<td>Metal Screw</td>
<td>Masonry</td>
<td>5/16&quot;</td>
<td>3/16&quot;</td>
<td>1-1/4&quot;</td>
<td>n/a</td>
<td>1 per Clip</td>
</tr>
</tbody>
</table>

#### INSTALLATION THROUGH THE JAMB ANCHORING REQUIREMENTS (select one)

<table>
<thead>
<tr>
<th>Fastener</th>
<th>Substrate</th>
<th>Minimum Head</th>
<th>Minimum Shank</th>
<th>Minimum Embedment to Structural Framing</th>
<th>Steel Type/Coating</th>
<th>Spacing</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wood Screw</td>
<td>Wood</td>
<td>5/16&quot;</td>
<td>#8</td>
<td>1-1/2&quot;</td>
<td>Galvanized, Zinc Chromate, *Stainless Steel, *Ceramic Coated</td>
<td>Every Hole</td>
</tr>
<tr>
<td>Self-Tapping</td>
<td>Metal</td>
<td>5/16&quot;</td>
<td>#8</td>
<td>3 Full Threads</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Metal Screw</td>
<td>Masonry</td>
<td>5/16&quot;</td>
<td>3/16&quot;</td>
<td>1-1/4&quot;</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

#### INSTALLATION GUSSET PLATE ANCHORING REQUIREMENTS (select one)

<table>
<thead>
<tr>
<th>Fastener</th>
<th>Substrate</th>
<th>Minimum Head</th>
<th>Minimum Shank</th>
<th>Minimum Embedment to Structural Framing</th>
<th>Steel Type/Coating</th>
<th>Spacing</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wood Screw</td>
<td>Wood</td>
<td>5/16&quot;</td>
<td>#10</td>
<td>1-1/2&quot;</td>
<td>Galvanized, Zinc Chromate, *Stainless Steel, *Ceramic Coated</td>
<td>Every Hole</td>
</tr>
<tr>
<td>Self-Tapping</td>
<td>Metal</td>
<td>5/16&quot;</td>
<td>#10</td>
<td>3 Full Threads</td>
<td></td>
<td>Every Hole</td>
</tr>
<tr>
<td>Metal Screw</td>
<td>Masonry</td>
<td>5/16&quot;</td>
<td>3/16&quot;</td>
<td>1-1/4&quot;</td>
<td></td>
<td>Every Hole (except where minimum spacing cannot be met)</td>
</tr>
</tbody>
</table>

Use the correct fastener driver based on the selected fastener's head type.
Size pilot and clearance holes based on the selected fastener's shank diameter as needed.
* Use 300 series stainless steel or ceramic coated fasteners when fastening to treated lumber.
** Follow fastener manufacturer's anchoring recommendations (i.e. spacing, edge distance, hole depth, etc.)
Important Safety and Product Information
for Andersen® Windows and Doors

This is the Safety Alert Symbol used to alert you to potential injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

Signal Word and Consequence

<table>
<thead>
<tr>
<th>COULD Result in:</th>
<th>WARNING</th>
<th>CAUTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Result in:</td>
<td>Major Injury/Death</td>
<td>Minor Injury</td>
</tr>
<tr>
<td>NOTICE Result in:</td>
<td>Product or Property Damage</td>
<td></td>
</tr>
<tr>
<td>IMPORTANT Result in:</td>
<td>Procedure and Product Information</td>
<td></td>
</tr>
</tbody>
</table>

Read this Important Safety and Product Information completely before starting.

Safety and Product Information Index
- Tools
- Handling
- Installation
- Sealing
- Fastening
- Finishing
- Glass
- Protective Film
- Cleaning
- Use/Operation
- Joining
- Product Information

- Leave this installation instruction with the home/building owner
- For additional support or help please go to: help.andersenwindows.com
- To configure installation instructions go to: andersenwindows.com/installation

Tools

- Follow manufacturers’ instructions for hand and power tools. Always wear safety glasses. Failure to do so could result in injury, product or property damage.

Handling

- Windows and doors can be heavy. Use safe lifting techniques and a reasonable number of people with enough strength to lift, carry, and install window and door products. Heavier windows and doors will require mechanical assistance. Failure to do so could result in injury, product or property damage.

- DO NOT lift or carry window or door by the exterior trim or extension jambs. Doing so could result in injury, product or property damage.

- Windows, doors, and installation components can have sharp edges. Wear protective equipment when handling. Failure to do so could result in injury.

Installation

- Use caution when working at elevated heights and around window and door openings. Follow the manufacturers’ instructions for ladders and scaffolding. Failure to do so could result in injury or death.

- Support window or door in opening at all times until fully fastened. Failure to do so could result in window or door falling out causing injury, property or product damage.

- Windows and doors have small parts (e.g. hole plugs, operator spline caps, fasteners, etc.). Small parts if swallowed could pose a choking hazard to young children. Dispose of unused, loose, or easily removed small parts. Failure to do so could result in injury.

Thank you for choosing Andersen.

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Notice

Installation (Continued)

• Andersen head flashing and installation flanges DO NOT take the place of window and door flashing tape or liquid flashing. Window or door must be properly flashed and sealed with a material compatible sealant for protection against water and air infiltration. Failure to do so could result in product or property damage.

• DO NOT set window or door directly on installation flange. Doing so could affect product performance, and could result in product or property damage.

• DO NOT set window directly on sill plate. Elevate window with shims under the side jambs. Failure to do so could affect operation and product performance, and could result in product damage.

• Window or door must be properly shimmed. Failure to do so could affect operation and product performance, and could result in product damage.

• A continuous full perimeter interior seal between window or door frame and opening is required. Failure to do so will affect product performance, and could result in product or property damage.

• Protect window and door sills during installation and throughout construction. Failure to do so could result in product damage.

• DO NOT remove window or door packaging material until instructed to do so. Doing so could result in product damage.

Sealing

• Follow instructions of foam, sealant, and flashing manufacturers regarding safety, material application, compatibility, and periodic maintenance for continued weather resistance of their products. Failure to do so could result in injury, product or property damage.

• Clean and prepare surfaces receiving sealant following sealant manufacturer's instructions. Failure to do so could result in water infiltration causing product or property damage.

Finishing

• DO NOT stain or paint weatherstrip, vinyl, glass, or hardware. Doing so could result in product damage.

• Read and follow finish manufacturer's instructions and safety information. Failure to do so could result in product damage.

• DO NOT over load brush with stain or paint when finishing. Doing so could allow finish to wick between glass stop or grille, and glass.

Fastening

• Metal fasteners and components could corrode when exposed to preservative-treated or fire-retardant treated lumber. Use approved fasteners and components to fasten window or door. Failure to do so could cause a failure resulting in injury, product or property damage.

• Fastener must attach to a structural framing member with a 1-1/2" minimum fastener embedment. Failure to do so could result in injury, product or property damage.

• DO NOT remove screws that attach installation clips or gusset plates to window or door frames. Doing so could result in injury, product or property damage.

Notice

WARNING

• Use masonry screws when fastening directly into masonry or through a buck into masonry. Failure to do so could affect product performance, and could result in product or property damage.

• DO NOT over drive screws or nails. Doing so could result in product damage.

• Fasteners must be attached to a structural framing member. Failure to do so will reduce the structural performance to less than published values and could affect product performance, and could result in product or property damage.

Notice

CAUTION

• Follow instructions of foam, sealant, and flashing manufacturers regarding safety, material application, compatibility, and periodic maintenance for continued weather resistance of their products. Failure to do so could result in injury, product or property damage.
**NOTICE**
- Finish unassembled unfinished gliding patio doors and MultiGlide™ patio doors prior to installation. Some surfaces are not accessible after installation. For all other products not mentioned above, finish all wood surfaces immediately after installation. Unfinished wood will deteriorate, discolor, and could bow or split. Some surfaces are hidden from view.

**Glass**

**WARNING**
- Unless specifically ordered, Andersen windows are not equipped with safety glass, and if broken, could fragment causing injury. Many laws and building codes require safety glass in locations adjacent to or near doors. Andersen windows are available with safety glass that could reduce the likelihood of injury when broken. Information on safety glass is available from your local Andersen dealer.

- Tempered or laminated safety glass is not standard for windows and must be special ordered. Check local building codes for required locations. Failure to do so could result in injury, product or property damage.

**NOTICE**
- DO NOT apply any type of film to insulating glass. Doing so could cause thermal stress conditions and result in glass damage. Shading devices (e.g. insulated coverings, shutters, etc.) could also cause thermal stress and condensation causing deterioration of windows or doors.

- DO NOT use sealants on exterior or interior glass surface.

**Protective Film**

**WARNING**
- DO NOT place suction grips over film seam. Suction grips will not hold if placed over film seam to lift or move window or door. Window or door will fall and could result in injury, product or property damage.

- DO NOT remove protective film near flammable materials. Static charge created when removing film can ignite flammable materials or cause a shock. Doing so could result in injury, product or property damage. See warning label on glass.

- Dispose of protective film immediately after removing. Failure to do so could pose a suffocation hazard to children.

**NOTICE**
- DO NOT remove protective film until after construction is completed. Doing so could allow glass to be damaged.

**Cleaning**

**NOTICE**
- Acid solutions used for cleaning masonry or concrete will damage all components of window or doors. Protect window or door and follow cleaning product manufacturer's instructions. If acid contacts window or door, wash all surfaces immediately with clean water.

- DO NOT use or apply solvents, abrasives, harsh chemicals or cleaners to window or door components. Doing so will result in product damage. For a list of recommended cleaners go to: andersenwindows.com

- DO NOT use metal razor blades to clean glass surface. Glass damage could result.
Use/Operation

**WARNING**

- **DO NOT** stand in front of or near windows or doors during a storm. Doing so could result in injury. Accessories such as grilles, art glass, and insect screens could dislodge and become airborne if window or door is impacted by wind-borne debris from severe storms or hurricane strength winds. In the event of a storm, remove all accessories from windows or doors and move to a safe location.

- **DO NOT** install air conditioner in window. Doing so could result in injury, product or property damage.

- Wind load brackets must be flipped out when not tilting or cleaning. If wind load brackets are not flipped out, window could blow in resulting in potential injury and/or product damage.

**CAUTION**

- **DO NOT** attach objects or accessories to window or door except Andersen® products specifically designed for the window or door. Doing so could result in injury, product or property damage.

Product and General Information

**IMPORTANT**

- Buildings constructed prior to 1978 could contain lead paint which could be disturbed during window or door replacement. For more information on proper management of lead paint, go to: [www.epa.gov/lead](http://www.epa.gov/lead)

- Instructions may not be right for all installations due to building design, construction materials, or methods used and/or building or site conditions. Consult a contractor or architect for recommendations.

- Installation flanges may need to be removed for some installations. (e.g. masonry, replacement), or where exterior finish is already applied (e.g. siding, brick veneer, stucco).

- Installation flange on the window or door alone will not properly flash and seal the window or door.

- **DO NOT** remove band, plastic ties, or packing clips from window or door until instructed.

- **DO NOT** remove performance (NFRC) label until after final inspection. Doing so could delay final inspection and sign-off by the code official.

- Check with your local building code official to identify and confirm compliance with local building code requirements.

- Contact local authorities or waste management company for proper recycling and disposal instructions for removed window or door.

- For cleaning instructions for window and door components go to: andersenwindows.com

- During construction protect products from construction debris, harsh chemical such as brick wash, roof runoff, and cement/masonry which can cause damage to window and door products.

- Protective film is not present on all windows or doors. Protective Film is not a substitute for masking.

- Remove protective film within six (6) months of installation and when temperature is above 32° F.

- Remove protective film by peeling from seam or corner. Use a plastic scraper to start if needed.

- Extension jambs can be factory applied on some windows or field applied prior to installation. **DO NOT** apply extension jambs prior to window or door installation that will be fastened with installation clips. Doing so could prevent access to installation clips for fastening.

- For extension jamb application refer to instructions included with part(s) or go to: andersenwindows.com

- Use painters masking tape for protecting products during construction. Avoid using duct or packaging tapes.
Full-Frame Window Installation

1

Remove existing window. Preserve existing water management system, if present. Clean entire opening of debris and old sealant. Repair surfaces that will be sealed or that the new window will be anchored to.

2

Check opening size. Allow for flashing thickness, and/or installation clips or joining fasteners.

3

Check that the opening is plumb, level, and square.

4

Dry fit window.
5

Apply sealant at sill, as shown. Quickly go to next step.

6

Apply rigid sill cap (full width) to sill, extending over exterior cladding. Tack in place.

7

If present, score existing drip cap and remove as shown. Dispose of properly.
Apply flashing at the bottom of the opening as shown. Smooth using a Jroller.

Apply flashing around entire opening using firm pressure. Smooth using a Jroller.

Apply flashing bridging gap between siding, sheathing, and flashing, full perimeter. Smooth out sealant using a putty knife.
Remove insect screen (if present).
Remove head expander (if present).

### IMPORTANT

- Head expander should only be used when there is a gap between the head of the unit and the exterior head stop after shimming at the sill.
- If head expander is needed, read and follow the supplemental instructions included with the head expander.
- If head expander is not needed, proceed to the next step.

When dry fitting window, if a visual gap exists between exterior stop and the top of the window, the head expander can be used. The head expander cannot be used if the gap between the head and the opening is greater than 3/4".
**Full-Frame Window Installation (continued)**

### 11 Specialty Windows Only

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>SIDE LENGTH</th>
<th>PG40 SPACING</th>
<th>PG50 SPACING</th>
</tr>
</thead>
<tbody>
<tr>
<td>Isosceles Triangle</td>
<td>0 - 23-1/2&quot;</td>
<td>4-1/2&quot; - 9&quot; from each corner.</td>
<td>4-1/2&quot; - 9&quot; from each corner.</td>
</tr>
<tr>
<td>Right Triangle</td>
<td>&gt; 23-1/2&quot;</td>
<td>4-1/2&quot; - 9&quot; from each corner.</td>
<td>4-1/2&quot; - 9&quot; from each corner.</td>
</tr>
<tr>
<td>Peak Pentagon</td>
<td></td>
<td>Max on center spacing of 24&quot;</td>
<td>Max on center spacing of 20&quot;</td>
</tr>
<tr>
<td>Octagon</td>
<td>Unit width &lt; 47-1/2&quot;</td>
<td>one centered screw in every-other jamb</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Unit width &gt; 47-1/2&quot;</td>
<td>one centered screw per jamb</td>
<td></td>
</tr>
<tr>
<td>Arch</td>
<td>0 - 23-1/2&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Unequal Leg Arch</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Half Circle</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Quarter Circle</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Springline</td>
<td>&gt; 23-1/2&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Circle</td>
<td></td>
<td>Max on center spacing of 20&quot;</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>4 fasteners, evenly spaced around the frame</td>
<td></td>
</tr>
</tbody>
</table>

Predrill installation clearance holes along scribe line for fastening to opening.

Predrill installation clearance holes through the frame along the scribe line (if needed) with a 7/32” drill bit as shown. Use the table above to determine the fastener quantity and spacing for each side of the unit. See fastener chart for approved fasteners.

### 12 Installation Clips at Sill (if provided)

Apply installation clips (if provided) following instructions provided with clips.

### 13

Verify that the frame is clean, dry, and free of debris. If not, clean the frame using soap and water or non-abrasive solvent free cleaner. Rinse and dry the frame thoroughly after cleaning.
Prepare shims to allow for a 3/8" space for interior sealing as shown.

NOTICE
Place shims directly under side jambs. At gusset plate locations, place shims to not interfere with gusset plate screws. Failure to do so could result in product damage and could result in poor operation.

Place shims on the bottom of the opening under the side jamb locations inset 1/4" from each side.
Full-Frame Window Installation (continued)

**16**

**WARNING**
Support window in opening at all times until secured. Failure to do so may result in window falling out causing injury, property, and/or product damage.

Center the window in the opening, setting the window on the shims.

**17**

Position window at desired depth and fasten upper corner to hold in place while shimming. Do not fully tighten.

**18**

Do not shim at head.

Shim Sides

Shim Middle

(interior view)

Place shims at sides next to/straddling predrilled holes in window, as shown. Do not shim at head. Check plumb, level, and square. Adjust shims as needed until diagonal measurements are within 1/8".

Side Shim Locations

- Single
- Joined Combination (Stack)
- Joined Combination (Ribbon)
- Integral Combination (Stack)
- Integral Combination (Ribbon)
- Gilding Window

(exterior views)
Fasten through all predrilled holes using installation screws supplied.

**NOTICE**

- Installation screws, clips and/or gusset plates must be securely attached to the opening. Failure to do so will reduce the structural performance to less than published values resulting in product/property damage.
- Check if frame is bowed. Correct any frame bow during installation. Failure to do so could result in product/property damage.
**Units with Sill Installation Clips Only**

1. Apply sealant under installation clip, between clip and opening.

2. Straighten installation clips into position against opening and fasten as shown.

3. Modify installation clip if necessary.

**IMPORTANT**

Straighten or bend installation clips into position as appropriate for anchoring window to framing.

**NOTICE**

- Installation screws, clips and/or gusset plates must be securely attached to the opening. Failure to do so will reduce the structural performance to less than published values resulting in product/property damage.

- If fastening through sill pan, seal at fastener location following sill pan manufacturer’s recommendation. Failure to do so could result in product/property damage.

**Joined Combinations Only**

- **Non-Reinforced Join**
  - Fasten through gusset plates

- **Reinforced Join**
  - (Reinforced joins are not available for flangeless windows with an exterior accessory kerf)

Fasten through installation clip(s) and gusset plate(s) if present.
21

**NOTICE**

Do not overpack with backer rod to avoid bowed jambs.

Insert backer rod at sides, top, and bottom.

22

Apply sealant to sides, top, and bottom. Smooth out sealant with a putty knife, if required.
23

**NOTICE**

Do not overfill with low expanding foam or overpack with backer rod to avoid bowed jambs.

Apply sealant continuously to full perimeter of opening, filling interior 1/3 of cavity as shown using low expanding foam or backer rod and sealant.

24

**NOTICE**

Do not cover weep holes. Doing so could result in product or property damage.

Remove tape from weep holes (if present) after the exterior trimming/finishing is complete.

► Full-Frame Window Installation is complete.
IMPORTANT

- Units that require installation clips or joined combinations with gusset plates must be fastened to the original rough opening and cannot be fastened solely to the existing window frame.

- Sill stool or extension jamb removal and modification (notching) may be required to allow room for installation clips or gusset plates. Mark locations prior to removal for unit position reference.

- Installation clip length may need to be modified so it does not extend past the interior edge of the stool or extension jamb.

1. Check measurements before starting to confirm correct unit size.

2. Break varnish/paint seal along interior stops. Do not damage stops. Stops may be reused.

3. Remove interior stops. Save for reuse if desired.

5. Remove parting stops and dispose of properly.

6. Lower top sash to sill. Cut top sash balancer cords, if present. Remove top sash and dispose of properly.

7. Remove pulleys, if present, and dispose of properly.

8. Remove weight pocket covers, if present, and save for reuse.

9. Remove weights, if present, and dispose of properly.

10. Insulate weight pocket and reapply covers. Fill pulley voids with wood for installation screw anchoring area.
Remove insect screen (if present).
Remove head expander (if present).

**IMPORTANT**

- Head expander should only be used when there is a gap between the head of the unit and the exterior head stop after shimming at the sill.
- If head expander is needed, read and follow the supplemental instructions included with the head expander.
- If head expander is not needed, proceed to the next step.

When dry fitting window, if a visual gap exists between exterior stop and the top of the window, the head expander can be used. The head expander cannot be used if the space between the opening and top of window is greater than 3/4".
Clean the opening of debris and dry fit window.

- For openings 48" in width and narrower with a sloped sill, level the unit with angled support blocks. Remove window and angled support blocks.

- For sills wider than 48", level sill with full width angled support to convert to a flat sill.
13 For opening with a sloped sill, apply optional exterior sill extender trim to unit as shown.

**IMPORTANT**
Exterior sill extender trim can also be cut to fit between the exterior stops and applied after unit is installed. Refer back to this page if applying the exterior sill extender trim after unit installation.

1. Measure sill angle height, as shown, and add 1/4".

   Sill angle height: ______ + 1/4" = ______

2. Cut exterior sill extender trim to height using determined measurements:

   Sill angle height + 1/4"
   (measurement above)

   + Sill shim height
   (determined from dry-fit step)

   Exterior sill extender trim height

3. Make weep holes by cutting 3/16" x 3/16" notches in bottom trim piece, 3" from each end.

4. Insert exterior sill extender trim into the sill kerf of window by aligning one end with the edge of the unit. Seat along entire width with a wood block and rubber mallet.
Predrill installation clearance holes through the frame along the scribe line (if needed) with a 7/32" drill bit as shown. Use the table above to determine the fastener quantity and spacing for each side of the unit. See fastener chart for approved fasteners.
Prepare shims to allow for a 3/8" space from the interior face of the unit to the front of the shim to allow for a continuous interior sealant bead as shown.

**Installation Clips at Sill or Alternative Andersen Installation Sealant at Sill**

**Installation Clips at Sill (if provided)**  
*(Preferred)*

- Apply installation clips following instructions provided with clips.

**Andersen Installation Sealant**  
*(Alternative)*

- IMPORTANT
  - Clean, dry wood
  - Well adhered paint
  - Liquid flashing applied at the sill
  - Rigid vinyl structurally fastened to the opening

No sealant substitutions may be made.

**WARNING**

Failure to properly prepare the opening and use adequate Andersen Installation Sealant may result in product or property damage.

*Andersen Installation Sealant may be used at the sill as a structural attachment alternative to installation clips in flat sill insert applications. Locate and apply sealant at the sill as shown in the sealant application steps below.*

Apply installation clips (if provided) following instructions provided with clips or prepare sill for Andersen Installation Sealant.
17
Verify that the frame is clean, dry, and free of debris. If not, clean the frame using soap and water or non-abrasive solvent free cleaner. Rinse and dry the frame thoroughly after cleaning.

18
Clean opening. Apply 3/8" continuous bead of sealant around inside edge of exterior stops at top and sides.

19
**Flat Sill**

**IMPORTANT: Andersen Installation Sealant must be used for alternative structural attachment at the sill.**

Apply additional sealant to sill 2" from stool across entire width and liberally in both corners.

Connect the sealant beads at both ends.

**Sloped Sill**

Apply 3/8" continuous bead of sealant to sill across entire width as shown. Make sure the sealant at the sill connects to the sealant previously applied to the exterior stops.

Andersen Installation Sealant must be used for alternative structural attachment at the sill.
20

**Flat Sill**

- Sealant Bead (sealant bead height MUST be greater than shim height.)

**Sloped Sill**

- Angled Blocking or Full Width Angled Support (by others)

For openings 48" in width and narrower, use angled blocking at the sill. Sill shim locations shown below.

If opening is wider than 48", and full width angled support was applied at the dry fit step, proceed to next step.

Apply additional sealant over the shim(s) at all the locations where the shim interrupts the sill sealant bead. Align the additional sealant with the sill sealant bead below the shim.

**Sill Shim Locations**

- Single
- Joined Combination (Stack)
- Joined Combination (Ribbon)
- Integral Combination (Stack)
- Integral Combination (Ribbon)
- Gliding Window
- Under Integral Combination Posts
- Under Joined Combination Unit Corners
- Under Gliding Window Meeting Stiles

Place sill shims in the locations as shown, prior to placing the unit into the opening. Sealant bead height must exceed shim height by a minimum of 1/8". Apply additional sealant as needed and over the shim at any locations where the shim interrupts the sill sealant.
21

**WARNING**
Support window in opening at all times until secured. Failure to do so may result in window falling out causing injury, property, and/or product damage.

Lift window into center of opening. Tip top of window against exterior stops. Support window until fastened.

---

22

Pull sill tight to stool.

---

23

Fasten corners of unit through the predrilled holes using supplied installation screws. Do not fully tighten.

---

24

Shim directly behind corner screw locations. Adjust shims to center the window and to straighten jambs if necessary. Make sure sash are closed and locked. When diagonal measurements are within 1/8", tighten screws. **DO NOT** shim at head.
**Units with Sill Installation Clips Only**

1. Apply sealant under installation clip, between clip and opening.

2. Straighten installation clips into position against opening and fasten as shown.

3. Modify installation clip if necessary.

**IMPORTANT**
Straighten or bend installation clips into position as appropriate for anchoring window to framing.

**NOTICE**
- Installation screws, clips and/or gusset plates must be securely attached to the opening. Failure to do so will reduce the structural performance to less than published values resulting in product/property damage.
- If fastening through sill pan, seal at fastener location following sill pan manufacturer’s recommendation. Failure to do so could result in product/property damage.

**Joined Combinations Only**

- **Non-Reinforced Join**
  - Fasten through gusset plates

- **Reinforced Join**
  - Reinforced joins are not available for flangeless windows with an exterior accessory kerf
  - Fasten through installation clip(s) and gusset plate(s) if present.
26

Fasten through all remaining predrilled holes using supplied installation screws. **Do not** fully tighten screws.

27

Shim directly behind center screws as shown. Adjust shims to straighten jambs if necessary. Tighten screws when jambs are straight. **DO NOT** shim at head.

**NOTICE**
Check if frame is bowed. Correct any frame bow during installation. Failure to do so could result in product/property damage.
**NOTICE**

Do not overfill with low expanding foam or overpack with backer rod. Doing so could result in bowed jambs.

---

Apply sealant at top and sides, filling interior 1/3 of cavity as shown using low expanding foam. *or* Insert backer rod and apply sealant at top and sides.

---

For sloped sills, apply low expanding foam or sealant to fill void at both ends.
Apply sealant at head and side jambs.

Notice:
Do not cover weep holes. Doing so could result in product damage.

Apply fillet bead of sealant between the trim pieces and opening as shown. Do not cover weep holes at sill.

Remove tape from weep hole (if present.)

Insert window Interior Installation is complete.
Insert Window - EXTERIOR Installation

IMPORTANT

► Units that require installation clips or joined combinations with gusset plates must be fastened to the original rough opening and can not be fastened solely to the existing window frame.

► Sill stool or extension jamb removal and modification (notching) may be required to allow room for installation clips or gusset plates. Mark locations prior to removal for unit position reference.

► Installation clip length may need to be modified so it does not extend past the interior edge of the stool or extension jamb.

1

Check measurements before starting to confirm correct unit size.

2

Remove exterior stops and dispose of properly.

3

Balancer Cord

Lower top sash to sill. Cut top sash balancer cords, if present.
Remove top sash and dispose of properly.

4

Parting Stop

Remove parting stops and dispose of properly.
Cut bottom sash balancer cords, if present. Remove bottom sash and dispose of properly. Balancer systems may vary.

Remove pulleys, if present, and dispose of properly.

Remove weight pocket covers, if present, and save for reuse.

Remove weights, if present, and dispose of properly.

Insulate weight pocket and reapply covers. Fill pulley voids with wood for installation screw anchoring.
Remove insect screen (if present).
Remove head expander (if present).

**IMPORTANT**

- Head expander should only be used when there is a gap between the head of the unit and the interior head stop after shimming at the sill.
- If head expander is needed, read and follow the supplemental instructions included with the head expander.
- If head expander is not needed, proceed to the next step.

When dry fitting window, if a visual gap exists between interior stop and the top of the window, the head expander can be used. The head expander cannot be used if the space between the opening and top of window is greater than 3/4".
Clean the opening of debris and dry fit window.

- For openings less than 48" in width with a sloped sill, level the unit with angled support blocks. Remove window and angled support blocks.

- For sills wider than 48", level sill with full width angled support to convert to a flat sill.
Predrill installation clearance holes through the frame along scribe line for fastening to opening.

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>SIDE LENGTH</th>
<th>PG40 SPACING</th>
<th>PG50 SPACING</th>
</tr>
</thead>
<tbody>
<tr>
<td>Isosceles Triangle</td>
<td>0 - 23-1/2&quot;</td>
<td>Centered</td>
<td></td>
</tr>
<tr>
<td>Right Triangle</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Peak Pentagon</td>
<td>&gt; 23-1/2&quot;</td>
<td>4-1/2&quot; - 9&quot; from each corner.</td>
<td>4-1/2&quot; - 9&quot; from each corner.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Max on center spacing of 24&quot;</td>
<td>Max on center spacing of 20&quot;</td>
</tr>
<tr>
<td>Octagon</td>
<td>Unit width &lt; 47-1/2&quot;</td>
<td>one centered screw in every-other jamb</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Unit width &gt; 47-1/2&quot;</td>
<td>one centered screw per jamb</td>
<td></td>
</tr>
<tr>
<td>Arch</td>
<td>0 - 23-1/2&quot;</td>
<td>Centered</td>
<td></td>
</tr>
<tr>
<td>Unequal Leg Arch</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Half Circle</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Quarter Circle</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Springline</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>&gt; 23-1/2&quot;</td>
<td>4-1/2&quot; - 9&quot; from each corner.</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>Max on center spacing of 20&quot;</td>
<td></td>
</tr>
<tr>
<td>Circle</td>
<td></td>
<td>4 fasteners, evenly spaced around the frame</td>
<td></td>
</tr>
</tbody>
</table>

Predrill installation clearance holes through the frame along the scribe line (if needed) with a 7/32" drill bit as shown. Use the table above to determine the fastener quantity and spacing for each side of the unit. See fastener chart for approved fasteners.
Prepare shims to allow for a 3/8" space from the exterior face of the unit to the front of the shim to allow space for sealant as shown.

### Installation Clips at Sill or Alternative Andersen Installation Sealant at Sill

**Installation Clips at Sill (if provided)** *(Preferred)*

- Apply installation clips following instructions provided with clips.

**Andersen Installation Sealant** *(Alternative)*

- **IMPORTANT**
  - For proper structural adhesion, the opening must be a flat sill with one of the following conditions:
    - Clean, dry wood
    - Well adhered paint
    - Liquid flashing applied at the sill
    - Rigid vinyl structurally fastened to the opening
  - No sealant substitutions may be made.

- **WARNING**
  - Failure to properly prepare the opening and use adequate Andersen Installation Sealant may result in product or property damage.

*Andersen Installation Sealant may be used at the sill as a structural attachment alternative to installation clips in flat sill insert applications. Locate and apply sealant at the sill as shown in the sealant application steps below.*

Apply installation clips (if provided) following instructions provided with clips or prepare sill for Andersen Installation Sealant.
Verify that the frame is clean, dry, and free of debris. If not, clean the frame using soap and water or non-abrasive solvent free cleaner. Rinse and dry the frame thoroughly after cleaning.

Clean opening. Apply 3/8" continuous bead of sealant around outside edge of interior stops at top and sides.

Flat Sill

3/8" Sealant Beads

**IMPORTANT:** Andersen Installation Sealant must be used for alternative structural attachment at the sill.

Apply additional sealant to sill 2" from stool across entire width and liberally in both corners.

Connect the sealant beads at both ends.

Sloped Sill

3/8" Sealant Beads

Connect the sealant beads at both ends.

Apply 3/8" continuous bead of sealant to sill across entire width. Make sure the sealant at the sill connects to the sealant previously applied to the interior stops.

**Andersen Installation Sealant must be used for alternative structural attachment at the sill.**
Place sill shims in the locations as shown, prior to placing the unit into the opening. Sealant bead height must exceed shim height by a minimum of 1/8". Apply additional sealant as needed and over the shim at any locations where the shim interrupts the sill sealant.
Lift window into center of opening and press against stool and interior stops. Support window until fastened.

**WARNING**

Support window in opening at all times until secured. Failure to do so may result in window falling out causing injury, property, and/or product damage.

Fasten corners of unit through the predrilled holes using supplied installation screws. Do not fully tighten.

Shim directly behind corner screw locations. Adjust shims to center the window and to straighten jambs if necessary. Make sure sash are closed and locked. When diagonal measurements are within 1/8", tighten screws. **DO NOT** shim at head.
Units with Sill Installation Clips Only

1. Apply sealant under installation clip, between clip and opening.

2. Straighten installation clips into position against opening and fasten as shown.

3. Modify installation clip if necessary.

NOTICE
- Installation screws, clips and/or gusset plates must be securely attached to the opening. Failure to do so will reduce the structural performance to less than published values resulting in product/property damage.
- If fastening through sill pan, seal at fastener location following sill pan manufacturer’s recommendation. Failure to do so could result in product/property damage.

IMPORTANT
Straighten or bend installation clips into position as appropriate for anchoring window to framing.

Joined Combinations Only

Fasten through installation clip(s) and gusset plate(s) if present.

Non-Reinforced Join

Fastener (see fastener chart)

Gusset Plate

Fasten through gusset plates

Reinforced Join

(Reinforced joins are not available for flangeless windows with an exterior accessory kerf)

Fastener (see fastener chart)

Gusset Plate
Fasten through all remaining predrilled holes using supplied installation screws. *Do not* fully tighten screws.

Shim directly behind center screws as shown. Adjust shims to straighten jambs if necessary. Tighten screws when jambs are straight. **DO NOT** shim at head.
25. **NOTICE**
Do not overfill with low expanding foam or overpack with backer rod to avoid bowed jambs.

Apply sealant at top and sides, filling interior 1/3 of cavity as shown using low expanding foam.

26. **For Sloped Sill Only.**

For sloped sill, apply additional low expanding foam or sealant to bottom corners on both ends.

27. **NOTICE**
Do not overfill with low expanding foam or overpack with backer rod to avoid bowed jambs.

Insert backer rod and apply sealant at top and sides.
For opening with a sloped sill, apply optional exterior sill extender trim to unit as shown.

1. Measure sill angle height, as shown.

2. Add 1/4" to measurement from previous step. Cut trim piece to proper dimension.

3. Make weep holes by cutting 3/16" x 3/16" notches in bottom trim piece, 3" from each end.

4. Apply color matched sealant to bottom accessory kerf.

5. Insert sill trim piece into accessory kerf and seat by tapping with a wood block and rubber mallet. Clean sealant squeeze out as needed.

6. Apply fillet bead of sealant between the trim pieces and opening as shown. Do not cover weep holes at sill.
Insert Window Exterior Installation is complete.

- Remove tape from weep holes (if present) after the exterior trimming/finishing is complete.

**NOTICE**
Do not cover weep holes. Doing so could result in product damage.