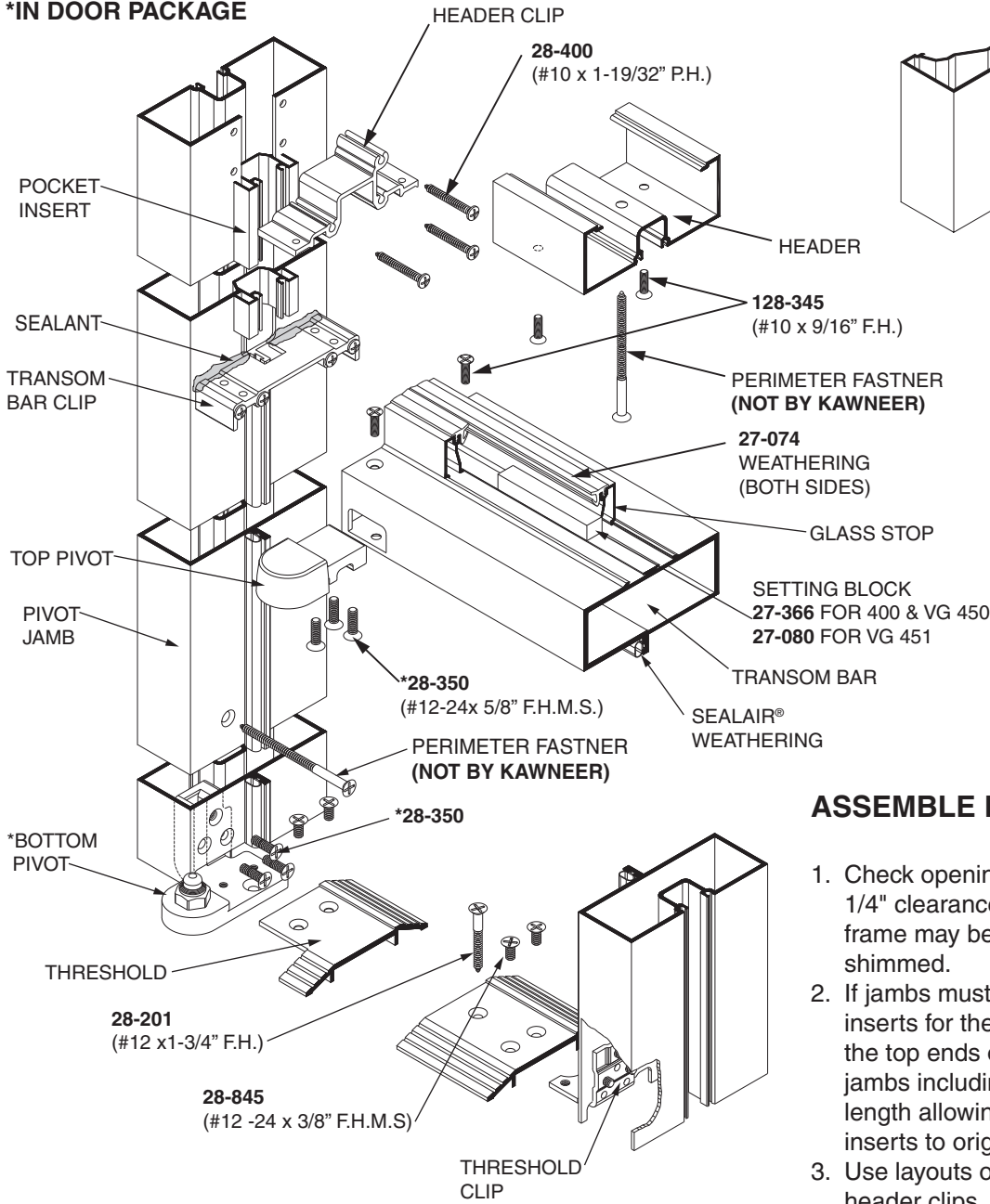


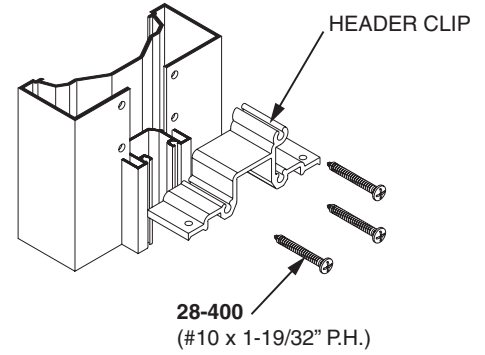
**TRIFAB® VG 450 SHOWN  
(400 & 451 SIMILAR)**

**ASSEMBLY AND INSTALLATION**

**\*IN DOOR PACKAGE**



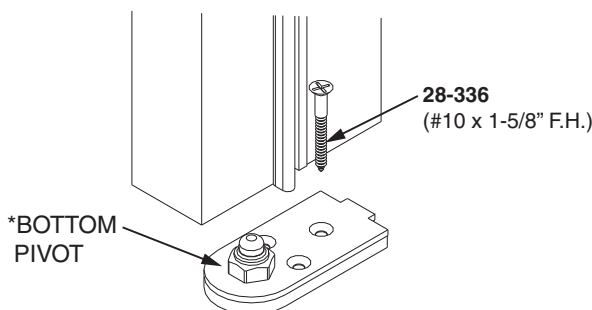
**OPEN BACK  
HEADER  
ATTACHMENT**



**ASSEMBLE FRAME AS SHOWN**

1. Check opening, allowing approximately 1/4" clearance at sides and top so that frame may be plumbed, squared and shimmed.
2. If jambs must be shortened, move pocket inserts for the transom area flush with the top ends of each vertical jamb. Cut the jambs including inserts to the desire length allowing the 1/4" clearance. Re-set inserts to original position.
3. Use layouts on page 4 to locate holes for header clips. Drill holes and attach clips to vertical jambs. Position header on clips and secure in place. (Note: Header clip is non-handed and is reversed from side to side).
4. Apply sealant to the exposed bearing surfaces of the factory-applied transom bar clips and secure the transom bar.
5. On units with header, apply sealant to end of header and secure.
6. On units with threshold, attach bottom pivot(s) to jamb(s), threshold to the pivot(s) and/or clip.
7. Attach top pivot to transom bar/header.

**VESTIBULE FRAME  
(NO THRESHOLD- 11/16" CLEARANCE)**



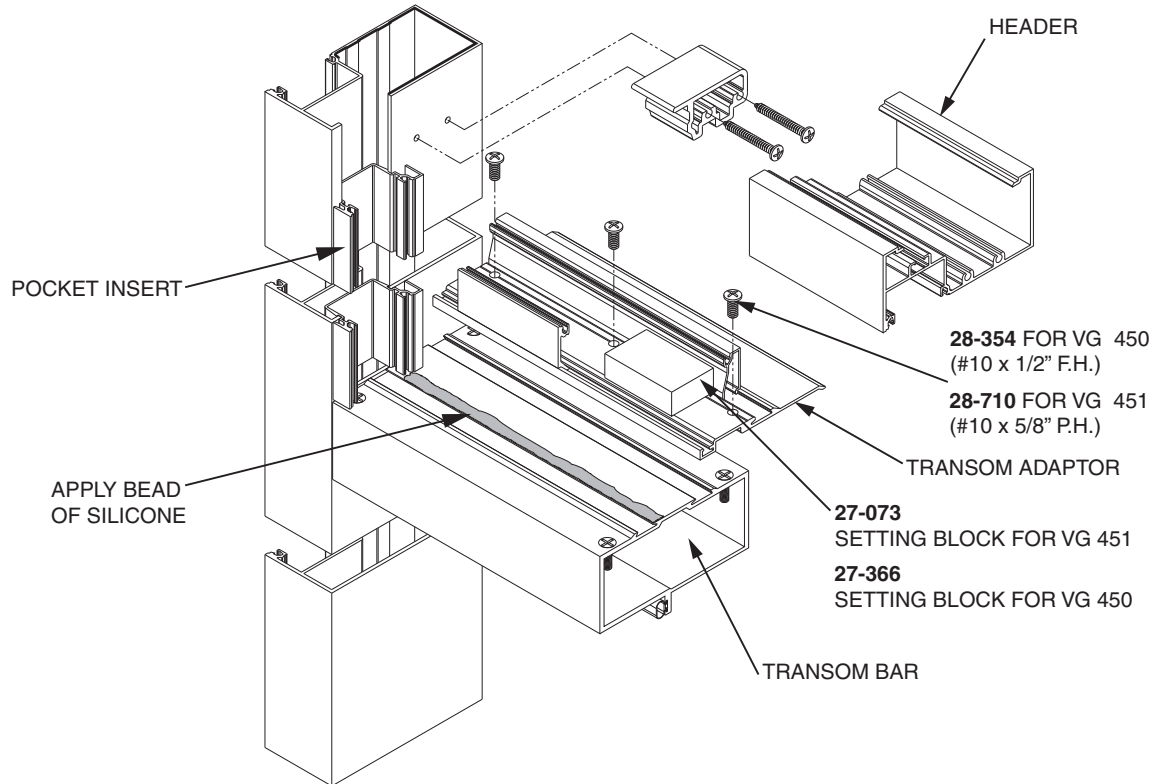
Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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**ASSEMBLY OF TRIFAB® VG 450 AND VG 451 FRONT AND BACK TRANSOM ADAPTER**

1. With the frame assembled, place the transom adapter on top of the transom bar. Align adapter with the front or back edge of the transom bar as required. Using the holes provided in the adapter as a template, match drill the transom bar with a #26 (.147" dia.) drill.
2. Prior to attaching the adapter, apply a bead of silicone to the transom bar as shown.
3. Secure the adapter in place with #28-710 (#10 x 5/8") or 28-354 (#10x1/2") fasteners.

**INSTALLATION OF ASSEMBLED FRAME**

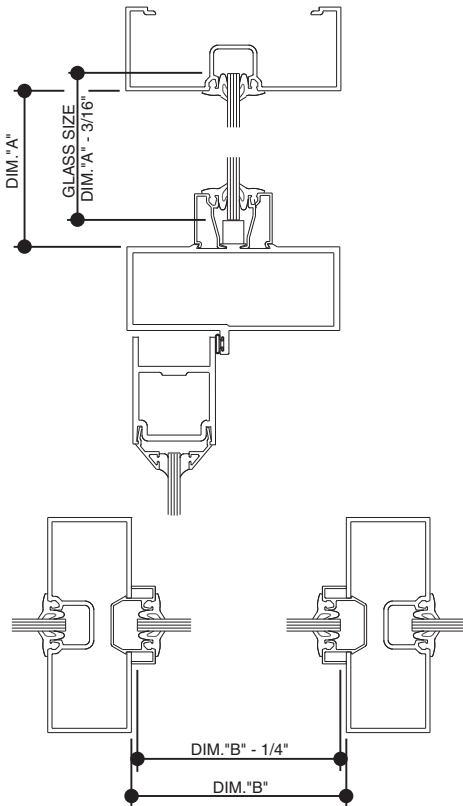
1. Position assembled frame plumb and square in opening. Drill and countersink anchor holes for #12 F.H. screws. Holes should be started 6" from the bottom of each jamb, and not more than 36" on center. Drill 1/2" clearance hole in pocket insert of jamb so head of screw sets on jamb, not the insert. Drill 3 holes evenly spaced through the glazing pocket of header.
2. Set threshold in bed of sealant or mastic.
3. Shim and secure jambs and header in opening.
4. If pivot is not supported by the finished floor, grout or block under it as required. If door will be hung and operated prior to threshold or finished floor installation. Block under pivot and anchor to floor with #12 FHMS.
5. Secure the threshold (if supplied) to the floor.
6. Glaze the transom:
  - A. Snap interior glass stop on to transom bar. Apply bead of sealant to base of front leg of the glass stop where it meets the top of the transom bar, or transom bar adaptor .
  - B. Pre-cut horizontal and vertical Push-On gasket allowing approximately 1/4" per foot extra.
  - C. Insert interior Push-On gasket into glass stop and remaining 3 glazing pockets (vertical transom jambs and header).
  - D. Position glass into transom area and place setting blocks on the transom bar at 1/4 points.
  - E. Install remaining glass stop in the transom bar. Install exterior Push-On gaskets into glazing pockets.

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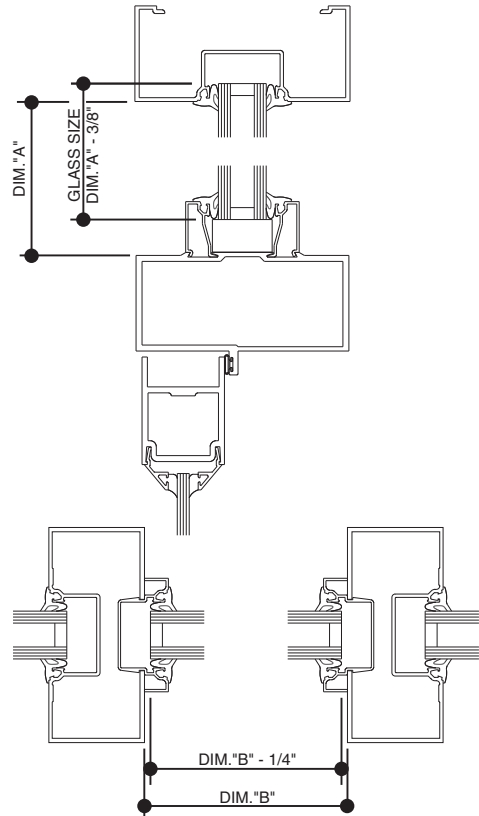
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## TRANSOM AREA GLASS SIZE

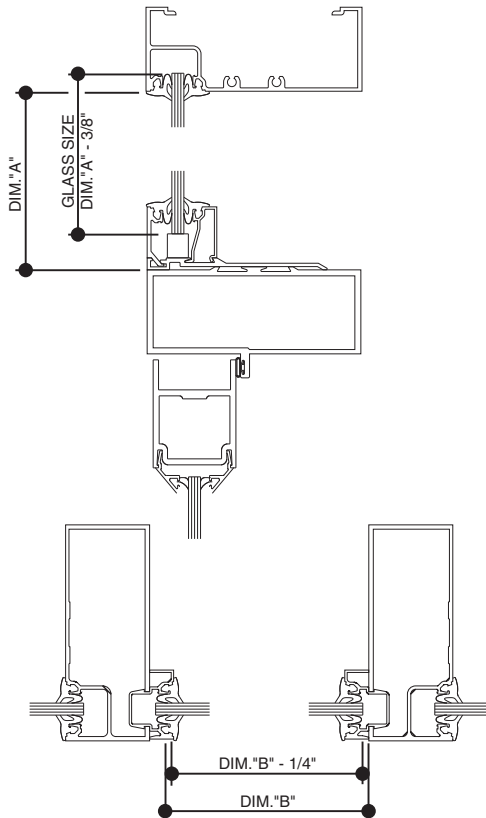
### 400 & VG 450 CENTER (SINGLE GLAZING)



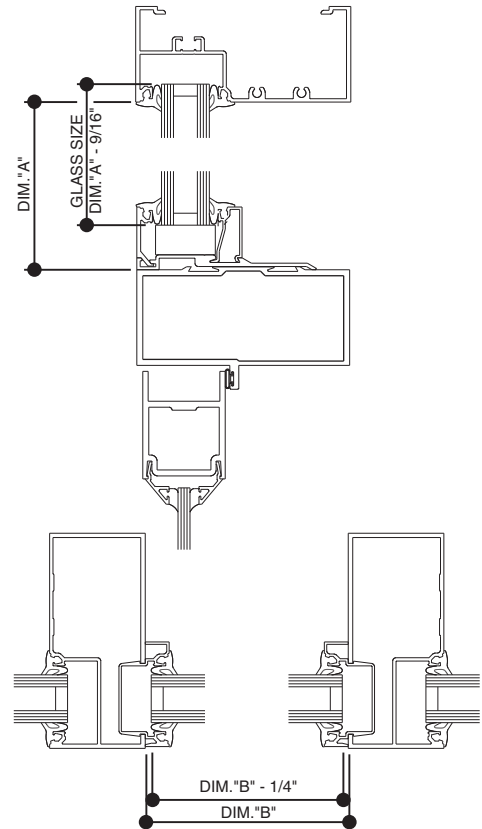
### VG 451 CENTER (DOUBLE GLAZING)



### VG 450 FRONT/BACK (SINGLE GLAZING)



### VG 451 FRONT/BACK (DOUBLE GLAZING)

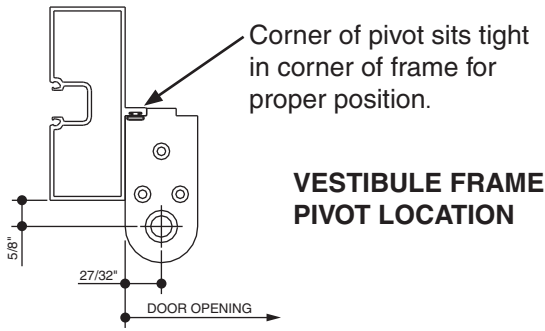


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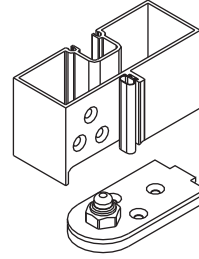
**NOTE:** FRAME TO BE SECURED IN POSITION BY EITHER SIDELITE BASE OR ADJOINING WALL.



**VESTIBULE FRAME PIVOT LOCATION**

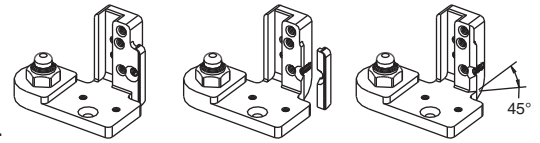
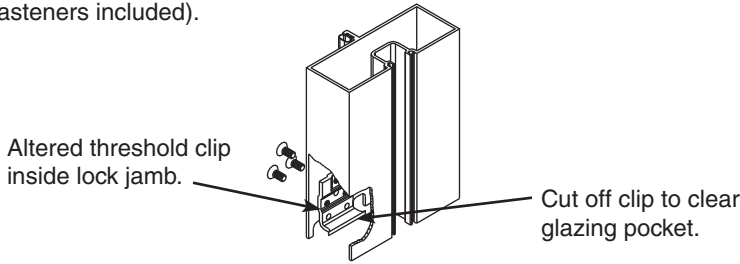
Use **35-506** bottom offset pivot frame portion when threshold is not used (fasteners included).

**NOTE:** Pivot must be ordered separately if unit was supplied with threshold.



**FIELD MODIFICATION STANDARD FRAME WHEN THRESHOLD IS NOT REQUIRED**

1. Remove the threshold clip.
2. Cut the threshold clip to clear the glazing pocket, tap all untapped holes for #12-24 screws and reverse the clip inside the lock jamb to act as the nut plate.
3. Drill and tap flat stock for #12-24 screws to act as the nut plate inside the pivot jamb. Screws serve only to plug existing holes in jamb.
4. Use **35-506** bottom offset pivot frame portion when threshold is not used (fasteners included).



**POCKETED FRAME BOTTOM PIVOT MODIFICATION**

1. On Trifab® 400 frames use hammer to break off lug as shown to fit between pocket & face of jamb. **(Not required on Trifab VG 450)**
2. On Trifab® VG 451 break off lug and file jagged edge at approximately 45° to clear the pocket.

