

**23.3.2 Mullion - transom construction as a unitized construction (system with inlet transom)****23.3.2.1 Mullion profiles**

We recommend carrying out the following work cycles on the mullion profiles in the workshop:

- inserting and fixing the connecting pieces,
- water-tight glueing of the drainage profiles, drainage plates
- inserting the transom housing gaskets
- inserting the plastic spacing profiles
- inserting the internal gaskets according to selection and
- fixing the plastic shaped pieces for the transom supplementary profiles.

**23.3.2.2 Transom profiles**

- inserting the internal gaskets according to selection

**23.3.2.3 Pre-assembling the individual segments**

- inserting and screwing down the transom profiles
- bond the sealing elements with the mullion and transom metre length material as well as
- screwing down the transom supplementary profiles.

**23.3.2.4 Pressure plate profiles**

- inserting the rubber clip piece separately into the pressure plate profiles

**23.3.2.5 Cover profiles**

- fitting the expansion joint plates using glue

**23.3.3 Mullion - transom construction as a unitized construction with split mullions (system with deepened transom)****23.3.3.1 Mullion profiles**

We recommend carrying out the following work cycles on the mullion profiles in the workshop:

- inserting and fixing the connecting pieces,
- water-tight glueing the drainage profiles, drainage plates
- inserting the transom housing gaskets
- inserting the plastic spacing profiles
- inserting the internal gaskets according to selection and
- fixing the t-brackets.

**23.3.3.2 Transom profiles**

- inserting the internal gaskets according to selection and
- inserting the plastic spacing profiles

**23.3.3.3 Pre-assembling the individual segments**

- align the mullion and transom on the work surface,
- brace the mullion and transom with the connecting rod as well as
- bond the transom housing gaskets with the metre-length mullion material.

**23.3.3.4 Pressure plate profiles**

- inserting the rubber clip piece separately into the pressure plate profiles

**23.3.3.5 Cover profiles**

- fitting the expansion joint plates using glue.

**23.3.4 Mullion - transom construction with t-bracket with spring pin (system with deepened transom)****23.3.4.1 Mullion profiles**

We recommend carrying out the following work cycles on the mullion profiles in the workshop:

- inserting and fixing the connecting pieces,
- water-tight glueing of the drainage profiles, drainage plates
- inserting the transom housing gaskets
- inserting the plastic spacing profiles
- inserting the internal gaskets according to selection and
- drilling the fixing hole for the t-bracket spring pin.

**23.3.4.2 Transom profiles**

- inserting the internal gaskets according to selection,
- inserting the t-bracket with spring pin as well as
- inserting the plastic spacing profiles.

**23.3.4.3 Pressure plate profiles**

- inserting the rubber clip piece separately into the pressure plate profiles

**23.3.4.4 Cover profiles**

- fitting the expansion joint plates using glue.

## 23.4 Assembly at the load-bearing basic mullion - transom construction

For reasons of thermally caused deflection (bi-metal effect) and technical installation we recommend that the mullions are only fitted in storey-high lengths. In doing so, every mullion must be fixed in such a way that consideration is given to ceiling deflection and thermally caused expansion.

### 23.4.1 Assembling mullions in case of mullion - transom design

Apply three-dimensional alignment to the basic construction for the lower mullion connection and secure.

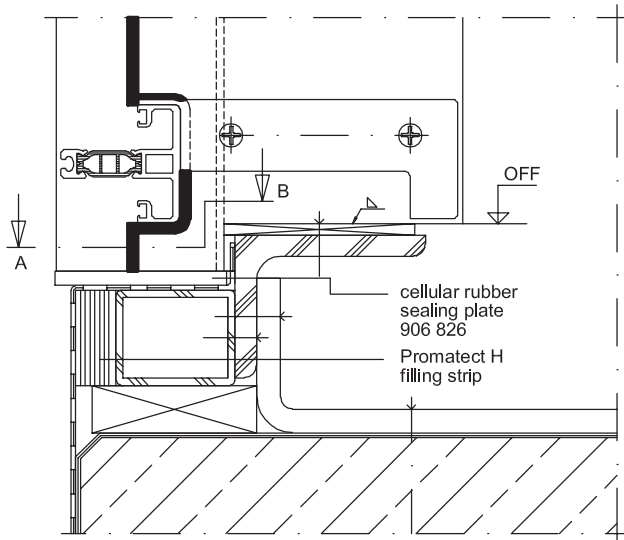


fig. 23.1

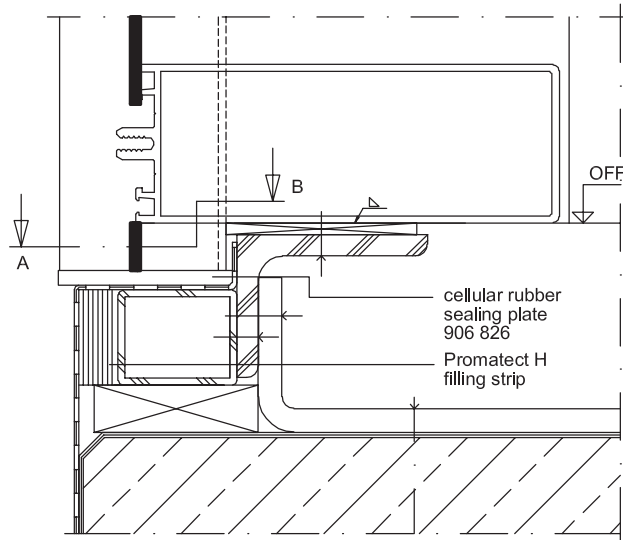


fig. 23.2

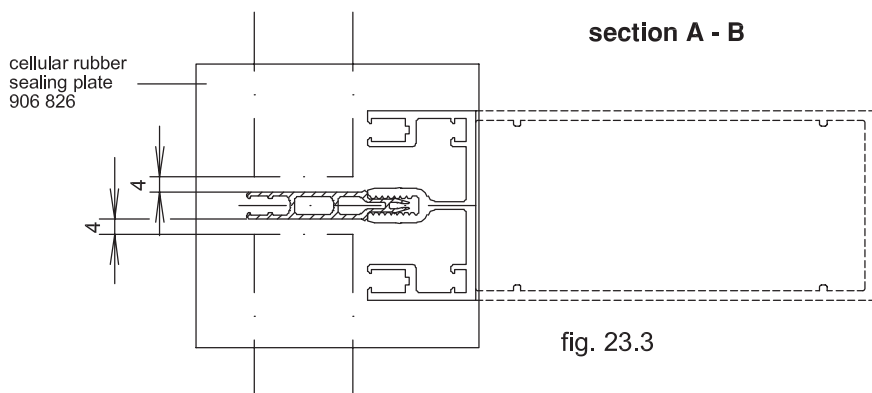


fig. 23.3

## 23.4.2 Mullion - transom assembly

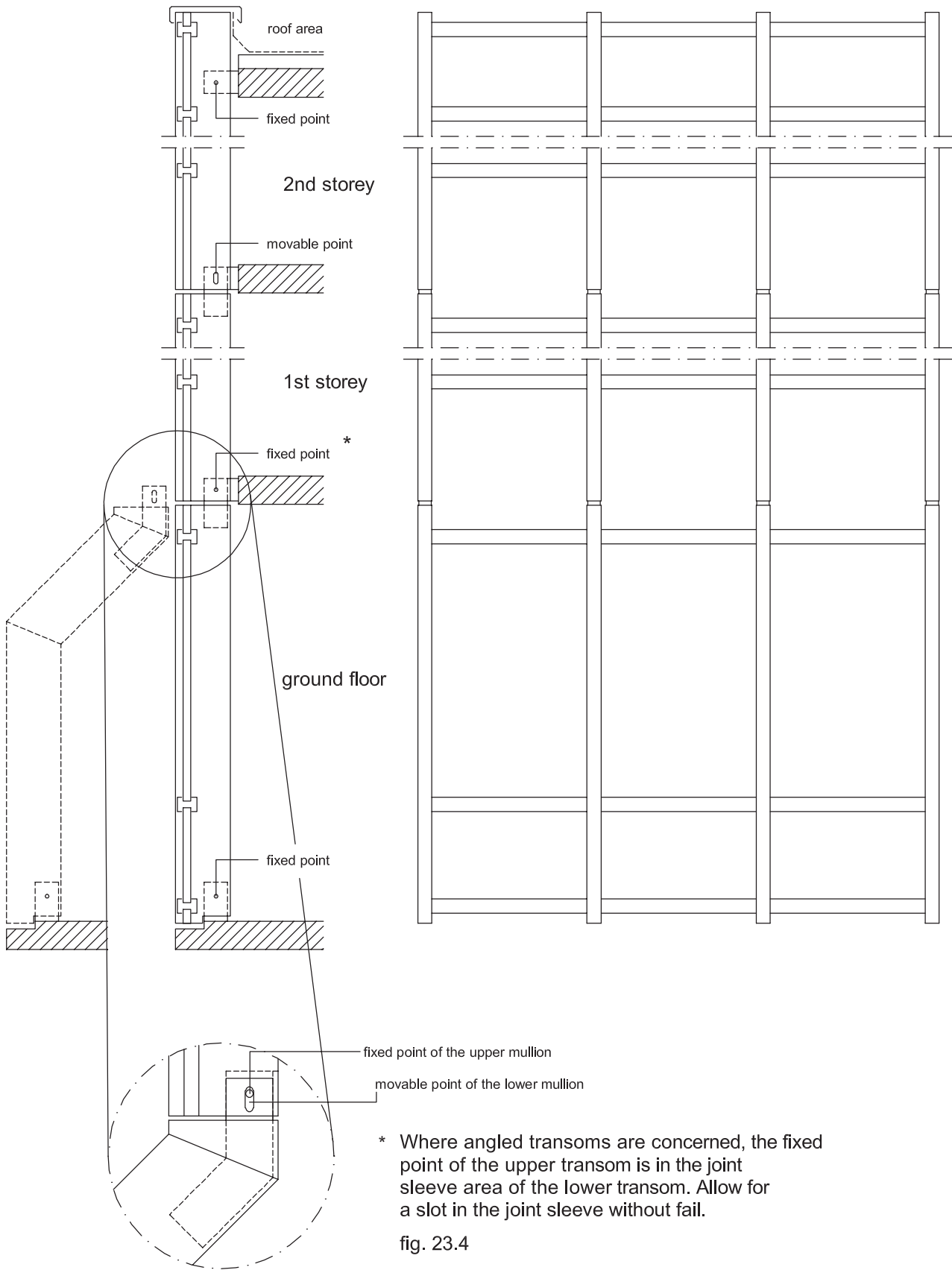


fig. 23.4