

## WINDOWS

**Purpose**

This document outlines the replacement procedure for the splice plate on Hehr windows.

**Resources Required**

- Hook tool
- Putty knife for scraping caulk
- Clamp
- Rivets
- Rivet tool
- Cordless or electric drill or screw gun
- 1/8" drill bit
- #8 - 1/2" screws
- Exterior grade waterproof caulk
- Caulk gun

**Safety****CAUTION**

Moving parts can cut, pinch, or crush. Keep clear and use caution.

**Procedure**

1. From the inside of the window, locate the area of the fractured splice.
2. Using a hook tool, pull the vinyl cover strip down approximately 10" (Fig. 1).
3. Open the window and expose the fractured splice joint.

Fig. 1

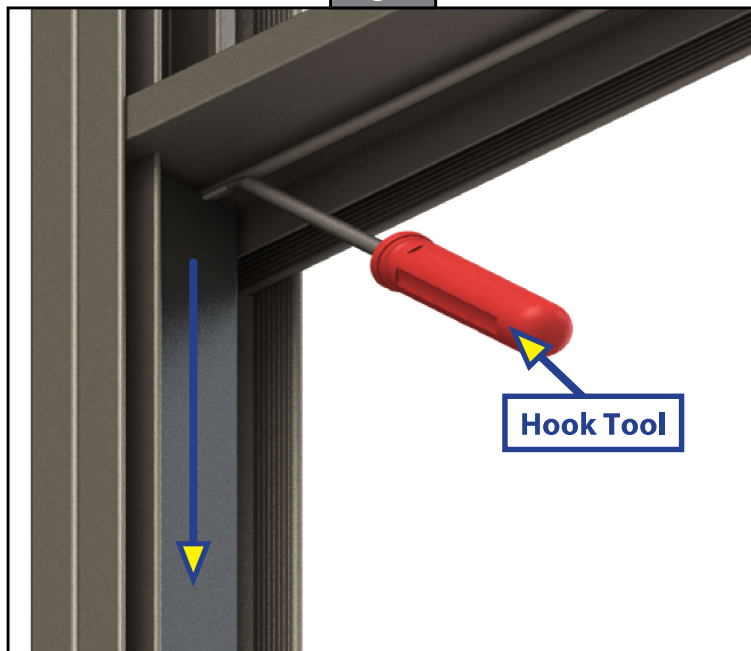
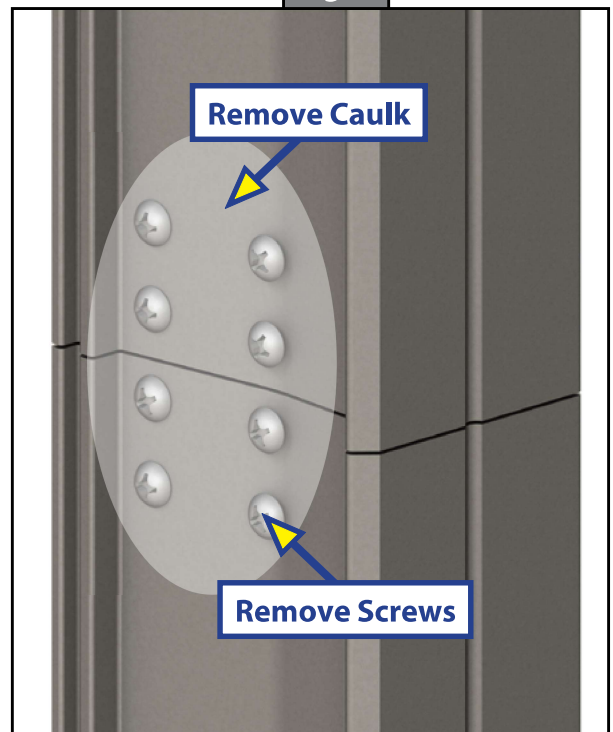


Fig. 2

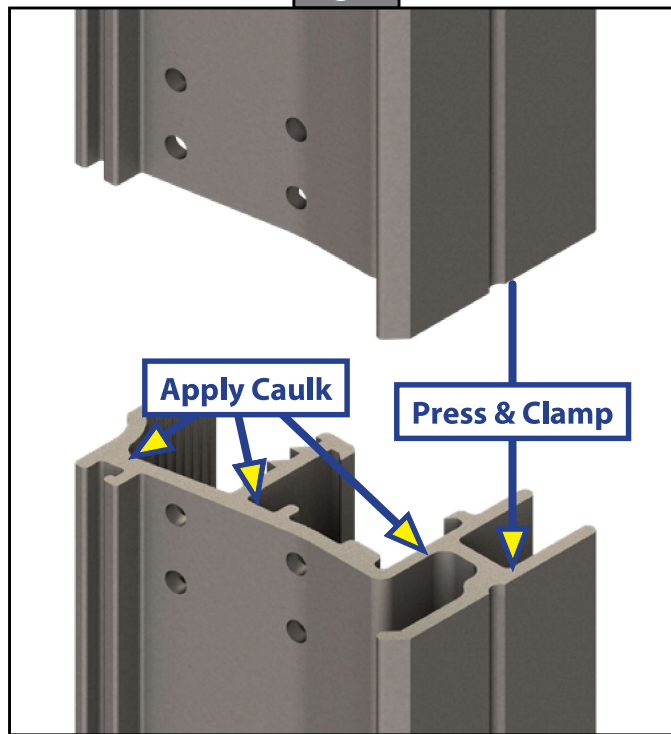


**NOTE:** The window may need to be pried slightly to open due to the fractured splice.

4. Remove any caulking from the separated joint and around the screws (Fig. 2).
5. Remove the screws.

## WINDOWS

Fig. 3



6. Apply caulk on the mating ends of the joint's interior (Fig. 3)
7. Press each half of the frame together and hold with a clamp.
8. Add the stiffener plate and rivet it to the frame using four rivets on the left side of the plate only (Figs. 4 and 5).

Fig. 4

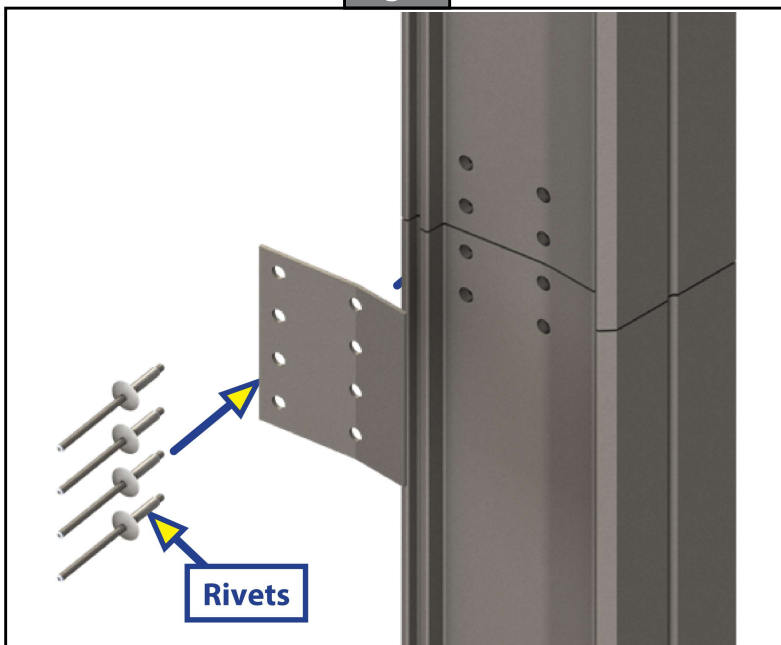


Fig. 5



## WINDOWS

Fig. 6

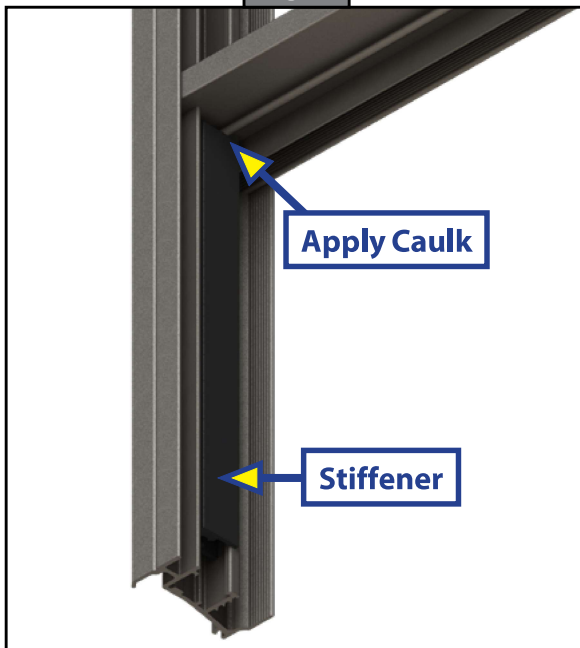
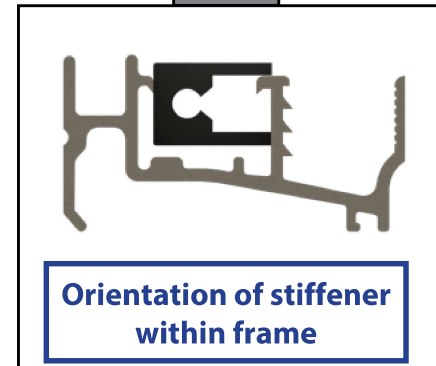


Fig. 7



9. On the inside of the window, insert the 6" stiffener where the cover strip was pulled back (Fig. 6). This can be done by rotating the stiffener into the slot of the frame (Fig. 7).
10. Seal the area between the top of the stiffener and the bottom of the mullion (Fig. 6).
11. Clamp the stiffener in place.

Fig. 8

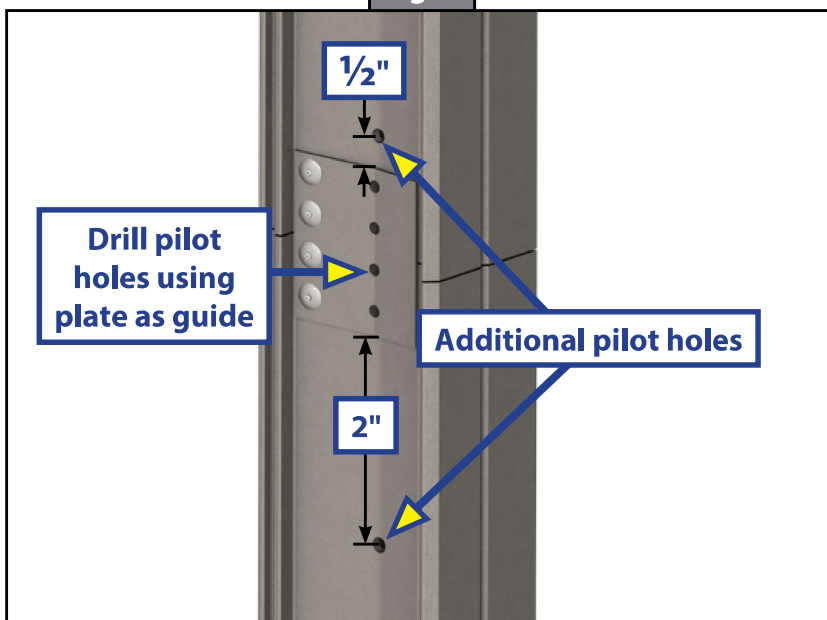
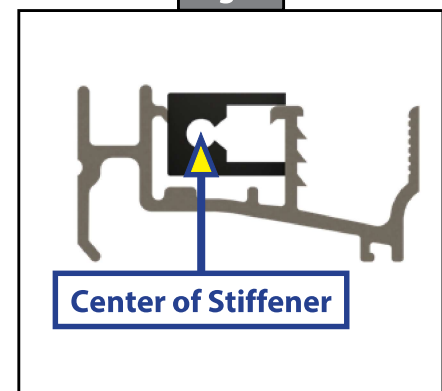


Fig. 9



12. Move to the outside of the window and drill four 1/8" pilot holes into the stiffener using the four holes in the stiffener plate as a guide (Fig. 8).
13. Drill one extra hole 1/2" above the stiffener bracket, and one hole 2" below (Fig. 8).

**NOTE:** Do not drill all the way through the stiffener. Drill only to the center hole of the stiffener (Fig. 9).

## WINDOWS

14. Install six #8-1/2" screws into the pre-drilled holes on the right side of the stiffener plate, and in both holes above and below the stiffener plate (Fig. 10).

Fig. 10

