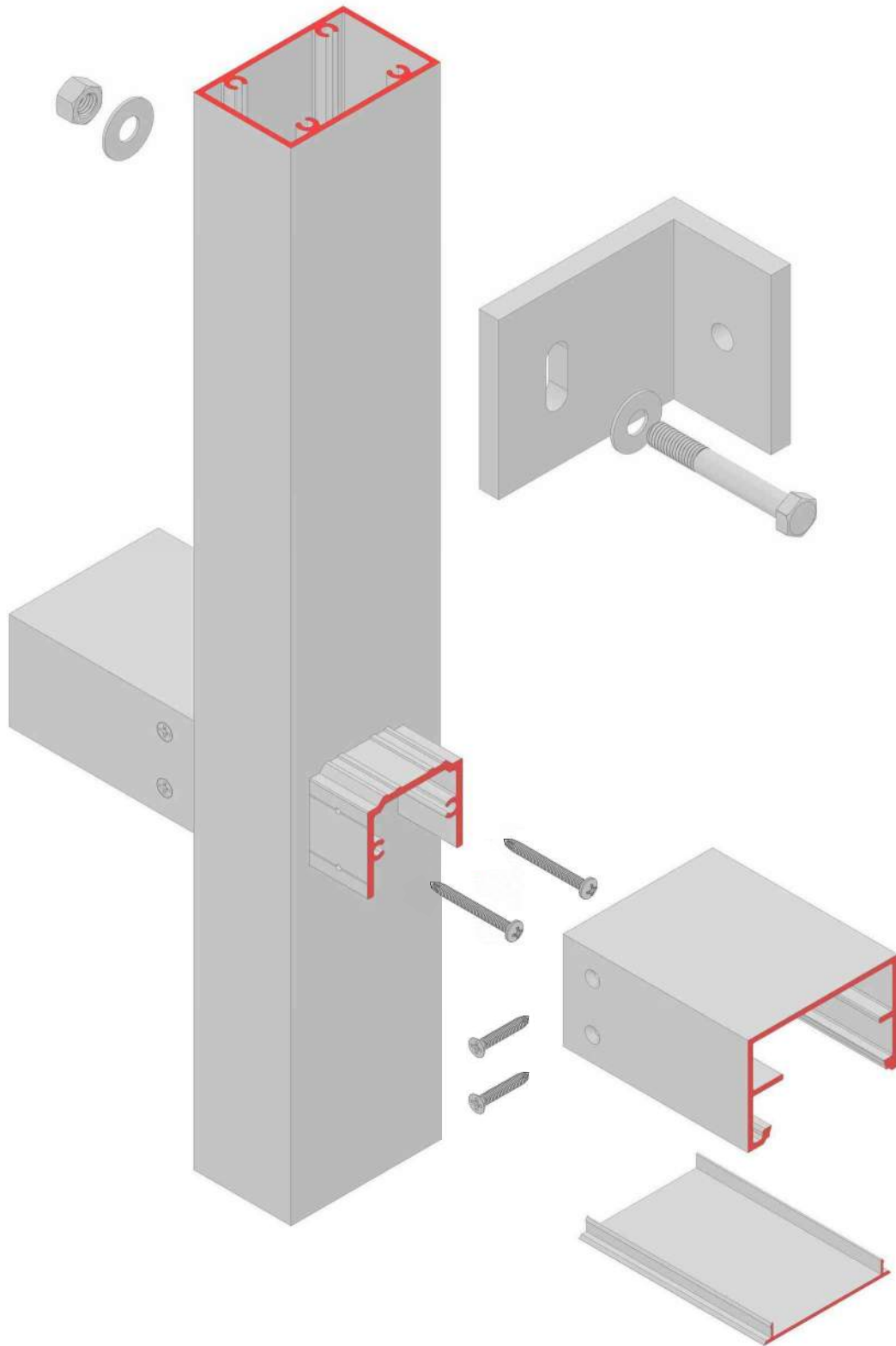


Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



Table of Contents

| | |
|---|-------|
| Cover | 1 |
| Table of Contents | 2 |
| General Notes/Handling, Storing, and Protecting Aluminum Material | 3 |
| General Rules | 4 |
| Vertical Mullion Fabrication - Wind Load Anchor Detail | 5 |
| Vertical Mullion Fabrication - Dead Load Anchor Detail | 6 |
| Vertical Mullion Fabrication - Shear Block Detail | 7 |
| Vertical Mullion Fabrication - Splice Detail | 8 |
| Shear Block Fabrication | 9 |
| Horizontal Stack Fabrication | 10 |
| End Cap Fabrication | 11 |
| Installation Steps | 12-16 |
| Fastener Details | 17 |

Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



General Notes

THESE FABRICATION AND INSTALLATION INSTRUCTIONS ARE A SUPPLEMENT TO THE APPROVED SHOP DRAWINGS. USE THIS DOCUMENT IN CONJUNCTION WITH THOSE DRAWINGS.

DESIGN PARAMETERS

1. IN ORDER TO ENSURE STRUCTURAL PERFORMANCE, NO OTHER ATTACHMENTS TO THE PANELS OR FRAMING SHOULD BE MADE BY CONTRACTORS OTHER THAN FACADES USA, WITHOUT PRIOR WRITTEN APPROVAL FROM FACADES USA.

STRUCTURE BY OTHERS

1. THE BUILDING STRUCTURE AND COMPONENTS THEREOF MUST BE CAPABLE OF SAFELY CARRYING THE LOADS IMPOSED BY THE PANEL SYSTEM, INCLUDING BUT NOT LIMITED TO DEAD LOADS OF THE PANEL SYSTEM, WIND LOADS SHOWN HEREIN ON DRAWINGS AND/OR CALCULATIONS, THERMAL LOADINGS, SEISMIC LOADINGS, SNOW LOADINGS, AND LIVE LOADINGS.

2. VERIFICATION OF SUBSTRATE:

THE MAXIMUM DEVIATION IN THE PLANE OF THE SUBSTRUCTURE MUST NOT EXCEED +/- 1/4" IN ANY 20 FOOT LENGTH HORIZONTALLY OR VERTICALLY AND CANNOT VARY MORE THAN 1/2" OVER THE ENTIRE BUILDING ELEVATION. TRANSITION AREAS SUCH AS CORNERS AND SOFFITS MUST HAVE THE SUBSTRUCTURE WITHIN +/- 1/8" OF THE THEORETICAL GIRT PLANES. SUBSTRUCTURE ALIGNMENT OUTSIDE OF THE ABOVE LIMITS MUST BE CORRECTED PRIOR TO CLADDING INSTALLATION.

INSTALLATION SHALL NOT PROCEED UNTIL THE SUBSTRUCTURE IS CORRECTED. MAXIMUM SHIM UP TO 1/4" AS REQUIRED TO BRING THE GIRT PLANE TO WITHIN +/- 1/16" OF THE THEORETICAL GIRT PLANE. SHIMMING MAY REQUIRE LONGER FASTENERS.

THE SURFACE OF THE GIRT TO WHICH PANELS ARE TO BE ATTACHED MUST BE FREE OF BOLT AND RIVET HEADS, EXCESSIVE WELDS, OR ANY OTHER OBSTRUCTIONS WHICH COULD PREVENT PROPER BEARING. ALL STRUCTURAL SUPPORTS SHALL BE IN PLACE AND ALL SAG RODS, DIAGONAL BRACING, AND CONNECTIONS SHALL BE TIGHTENED BEFORE WORK PROCEEDS. WELD ALL SLOTTED CONNECTIONS INTENDED FOR ALIGNMENT PURPOSES ONLY UPON COMPLETION OF ALIGNMENT.

IN NO CASE SHALL GIRTS BE ERECTED AND ALIGNED PRIOR TO POURING THE FLOOR AND/OR ROOF SLABS. DEAD LOAD DEFLECTIONS WILL CAUSE SEVERE GIRT ALIGNMENT PROBLEMS.

3. CONCRETE MUST BE 6000 PSI OR BETTER TO MOUNT THE PANEL SYSTEM.

EVERY EFFORT IS BEING MADE TO ELIMINATE ERRORS; HOWEVER, SINCE ERRORS CAN AND WILL HAPPEN, FACADES USA WILL NOT ASSUME RESPONSIBILITY BEYOND MANUFACTURING IN ACCORDANCE WITH APPROVED DRAWINGS OR RESPONSIBILITY FOR ERRORS RESULTING FROM THE USE OF THESE DRAWINGS BY OTHER TRADES.

Handling, Storing, and Protecting Aluminum Material

THE FOLLOWING PRECAUTIONS ARE RECOMMENDED TO ASSURE EARLY ACCEPTANCE OF YOUR PRODUCTS AND WORKMANSHIP.

A) HANDLE CAREFULLY - DO NOT DROP FROM THE TRUCK. STACK WITH ADEQUATE SEPARATION SO MATERIAL WILL NOT RUB TOGETHER. STORE OFF THE GROUND. PROTECT AGAINST ELEMENTS AND OTHER CONSTRUCTION TRADES.

B) KEEP MATERIAL AWAY FROM WATER, MUD, AND SPRAY - PREVENT CEMENT, PLASTER, AND OTHER MATERIALS FROM DAMAGING THE FINISH.

C) PROTECT THE MATERIALS AFTER ERECTION BY WRAPPING WITH KRAFT PAPER - OR BY ERECTING VISQUEEN/CANVAS SPLATTER SCREENS. CEMENT, PLASTER, TERRAZZO, AND OTHER ALKALINE MATERIALS ARE VERY HARMFUL TO THE FINISH AND SHOULD BE REMOVED WITH WATER AND MILD SOAP BEFORE SETTING OCCURS. UNDER NO CIRCUMSTANCES ALLOW THESE MATERIALS TO DRY OR PERMANENT STAINING WILL OCCUR. PRIOR TO THE SETTING OF OTHER MATERIALS REQUIRE THE CONTRACTOR TO CLOSELY SUPERVISE OTHER TRADES SO AS TO PREVENT MARRING OR DISCOLORATION FROM ANY CAUSE.

D) GENERAL CONTRACTOR SHALL TAKE NECESSARY MEASURE TO PROTECT ALUMINUM FROM WELDING OPERATIONS BY CONTRACTORS OTHER THAN FACADES USA.

Facades USA

930 Cass St, New Castle, PA 16101

412-820-2200

www.FacadesUSA.com

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Laws and building and safety codes governing the design and use of Facades USA products vary widely. Facades USA does not control the selection of product configurations, materials, or hardware and assumes no responsibility therefore.

Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



General Rules

THE FOLLOWING PRACTICES ARE RECOMMENDED FOR ALL INSTALLATIONS.

A) READ COMPLETE INSTRUCTIONS BEFORE ORDERING PANELS OR FABRICATED MATERIAL.

B) CHECK SHOP DRAWINGS TO BECOME THOROUGHLY FAMILIAR WITH THE JOB.

C) ALL MATERIALS ARE TO BE INSTALLED PLUMB, LEVEL, AND TRUE.

D) ALL WORK SHOULD START FROM ESTABLISHED BENCH MARKS AND COLUMN CENTER LINES ESTABLISHED BY THE ARCHITECTURAL DRAWINGS AND THE GENERAL CONTRACTOR.

E) THE SEQUENCE OF ERECTION SHOULD BE COORDINATED WITH THE JOB SUPERINTENDENT SO DELAYS ARE PREVENTED AND RISK OF MATERIAL DAMAGE IS MINIMIZED. IF PRESETTING OF ANCHORAGE IS REQUIRED, COORDINATE WITH GENERAL CONTRACTOR AND SUPERVISE LOCATION.

F) MAKE CERTAIN CONSTRUCTION WHICH WILL RECEIVE YOUR MATERIALS IS ACCORDING TO THE CONTRACT DOCUMENTS. IF NOT, NOTIFY THE GENERAL CONTRACTOR IN WRITING AND RESOLVE DIFFERENCES BEFORE PROCEEDING WITH YOUR WORK.

G) INSULATE ALL ALUMINUM TO BE PLACED DIRECTLY IN CONTACT WITH THE MASONRY OR INCOMPATIBLE MATERIALS WITH A HEAVY COAT OF ZINC CHROMATE OR BITUMINOUS PAINT. ALL MILL FINISHED/UNFINISHED ALUMINUM MUST HAVE A SEPERATOR (NON-METALLIC) BETWEEN DISSIMILAR METALS.

H) FOLLOW FACADES USA FABRICATION AND INSTALLATION INSTRUCTIONS.

I) CHECK ALL MATERIAL ON ARRIVAL FOR QUANTITY.

J) BE SURE TO HAVE ALL THE MATERIALS AND TOOLS NEEDED TO BEGIN THE INSTALLATION.

1. APPROVED SHOP DRAWINGS.
2. LEVEL AND PLUMB (TRANSIT).
3. FASTENERS AND REQUIRED DRILL BITS AND DRIVERS.
4. PERIMETERS AND ACCESSORIES SUCH AS ANCHORS, FASTENERS, AND END CAPS.
5. METAL PANELS FOLLOWING THE DESIGN SPECIFICATIONS.

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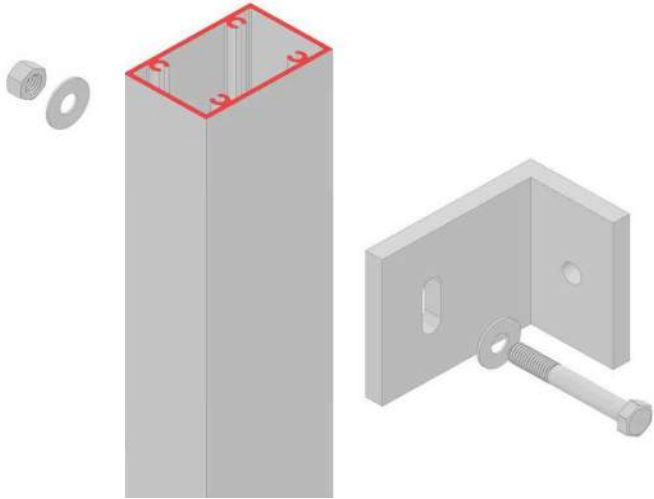
Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured

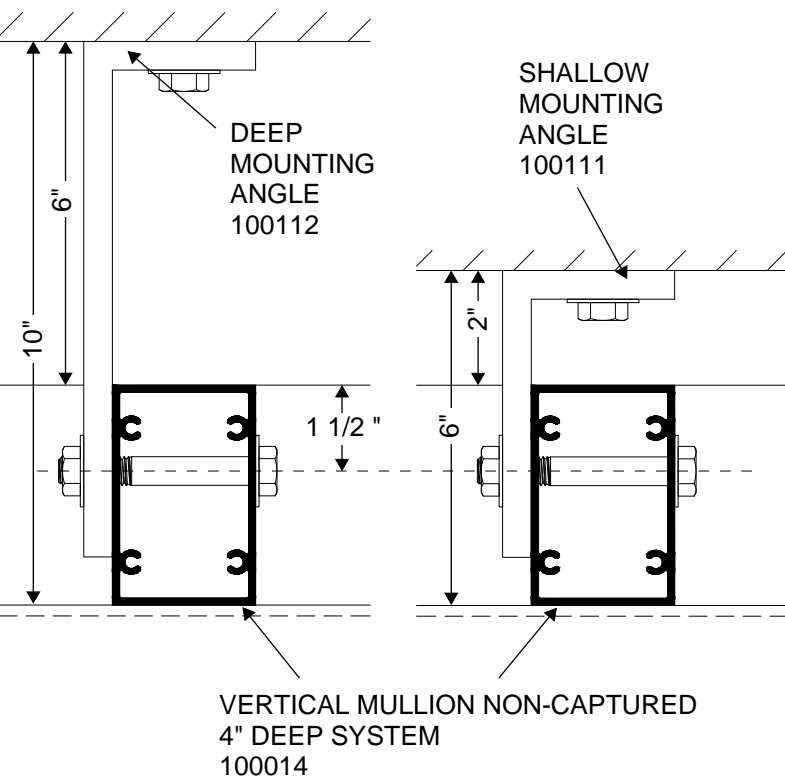


Vertical Mullion Fabrication - Wind Load Anchor Detail

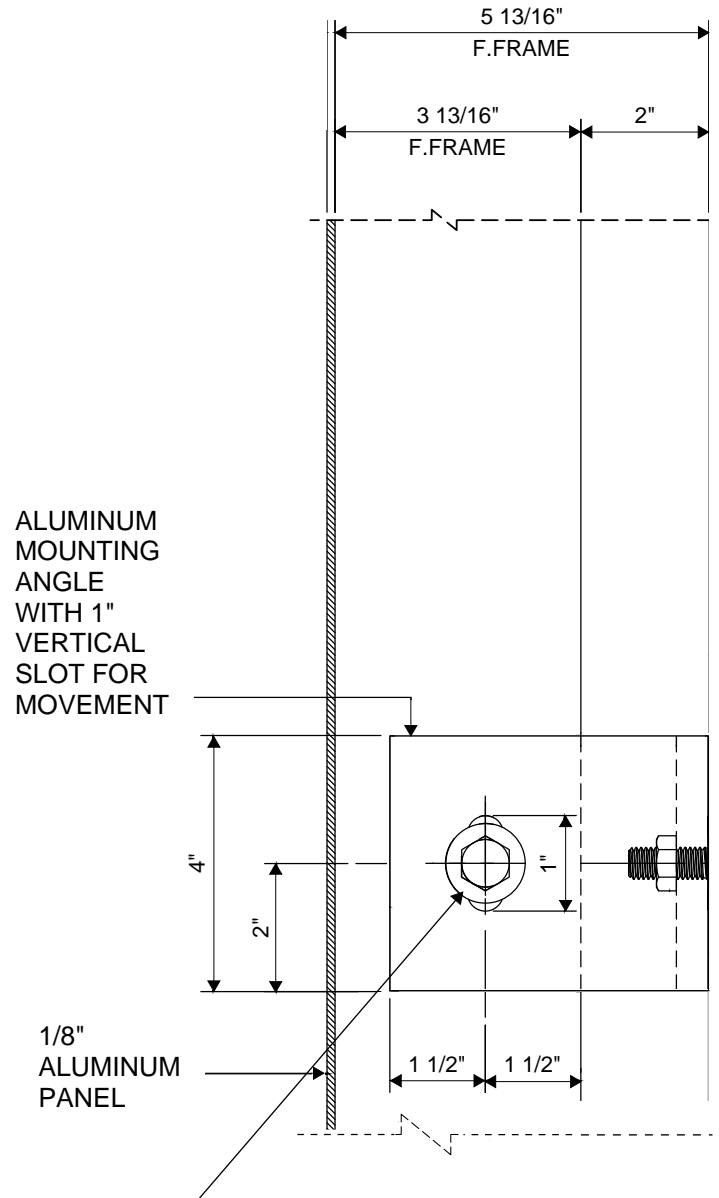
REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL LENGTHS AND HORIZONTAL LOCATIONS. ACTUAL PROJECT CONDITIONS WILL DETERMINE SPECIFIC ANCHOR DESIGN. DETAILS ON THIS PAGE ARE FOR REFERENCE ONLY.



VERTICAL MULLION HOLE IS FIELD/MATCH DRILLED WITH 9/16" DIAMETER IN THE CENTER OF THE SLOT.



SHALLOW MOUNTING ANGLE ANCHOR DETAIL



9/16" DIAMETER MATCH DRILLED HOLE IN VERTICAL MULLION

WIND LOAD ANCHORS ARE PLACED ALONG THE VERTICAL MULLION.

HOLE DIMENSIONS ARE THE SAME FOR BOTH THE SHALLOW AND DEEP MOUNTING ANGLES.

REFERENCE PAGE 17 FOR FASTENER DETAILS.

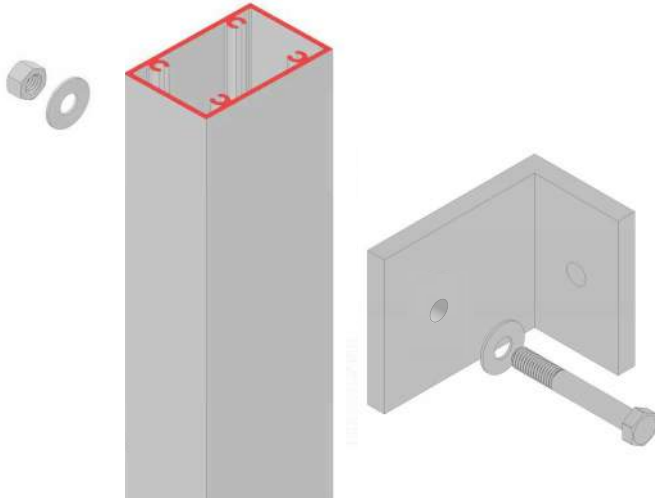
Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



Vertical Mullion Fabrication - Dead Load Anchor Detail

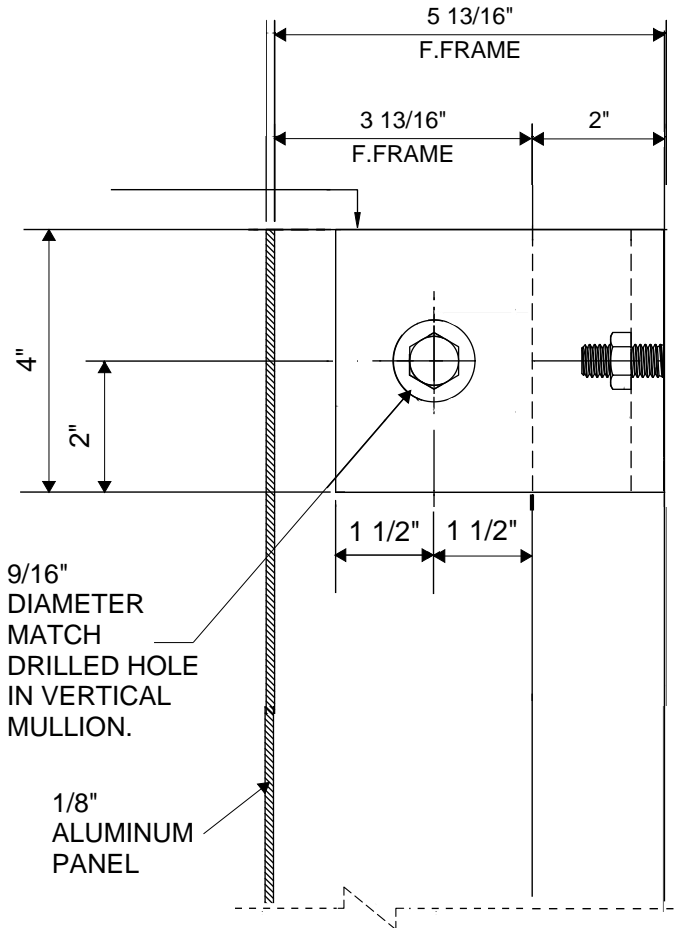
REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL LENGTHS AND HORIZONTAL LOCATIONS. ACTUAL PROJECT CONDITIONS WILL DETERMINE SPECIFIC ANCHOR DESIGN. DETAILS ON THIS PAGE ARE FOR REFERENCE ONLY.



VERTICAL MULLION HOLE IS FIELD/MATCH DRILLED WITH 9/16" DIAMETER.

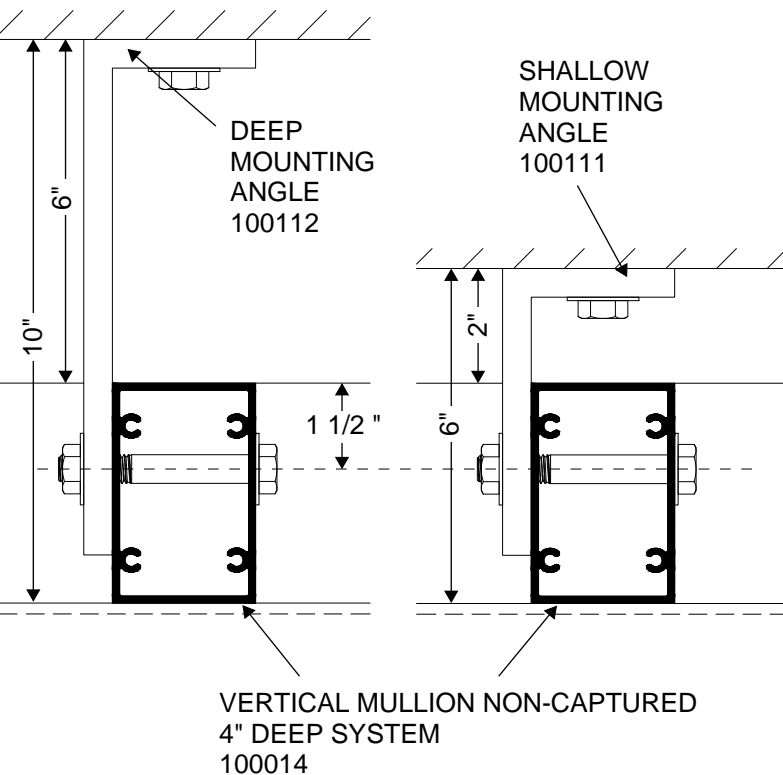
SHALLOW MOUNTING ANGLE ANCHOR DETAIL

HOLE DIMENSIONS ARE THE SAME FOR BOTH THE SHALLOW AND DEEP MOUNTING ANGLES.



DEAD LOAD ANCHOR IS PLACED AT THE TOP OF THE VERTICAL MULLION AS A STANDARD.

REFERENCE PAGE 17 FOR FASTENER DETAILS.



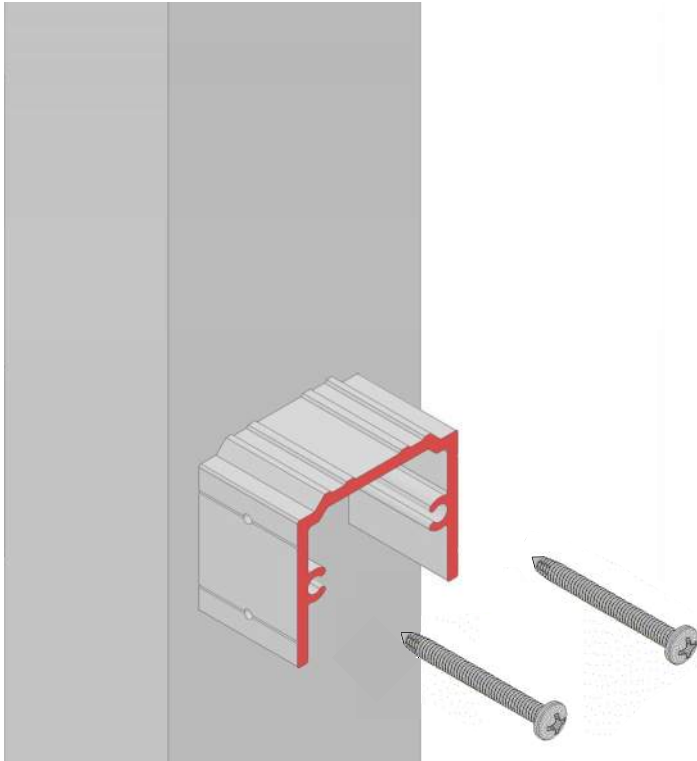
Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



Vertical Mullion Fabrication - Shear Block Detail

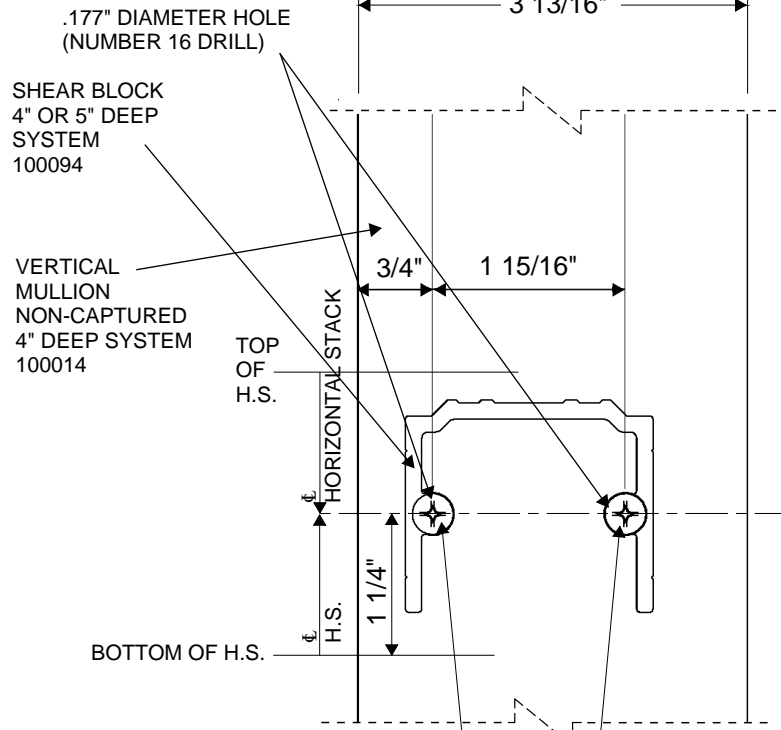
REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL LENGTHS AND HORIZONTAL LOCATIONS.



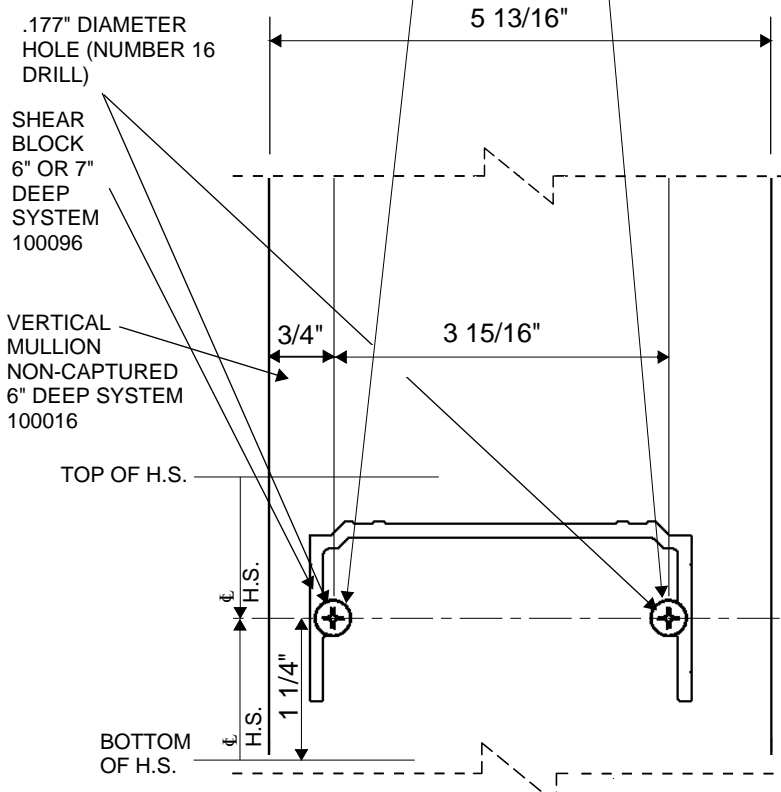
DRILL TWO HOLES FOR EACH SHEAR BLOCK ON BOTH SIDES OF VERTICAL MULLION WITH EXCEPTION TO THE END MULLIONS. REFERENCE APPROVED SHOP DRAWINGS FOR NUMBER OF SHEAR BLOCKS (ONE ON EACH END OF EACH HORIZONTAL STACK).

REFERENCE PAGE 17 FOR FASTENER DETAILS.

4" DEEP SYSTEM:



6" DEEP SYSTEM:



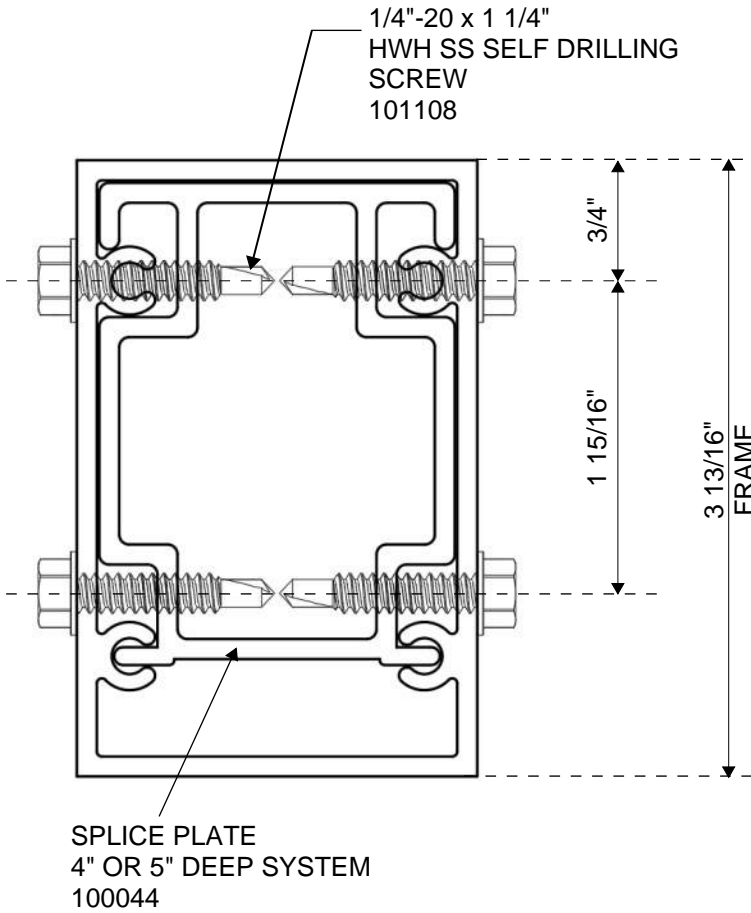
Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured

Vertical Mullion Fabrication - Splice Detail

REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL LENGTHS AND HORIZONTAL LOCATIONS.

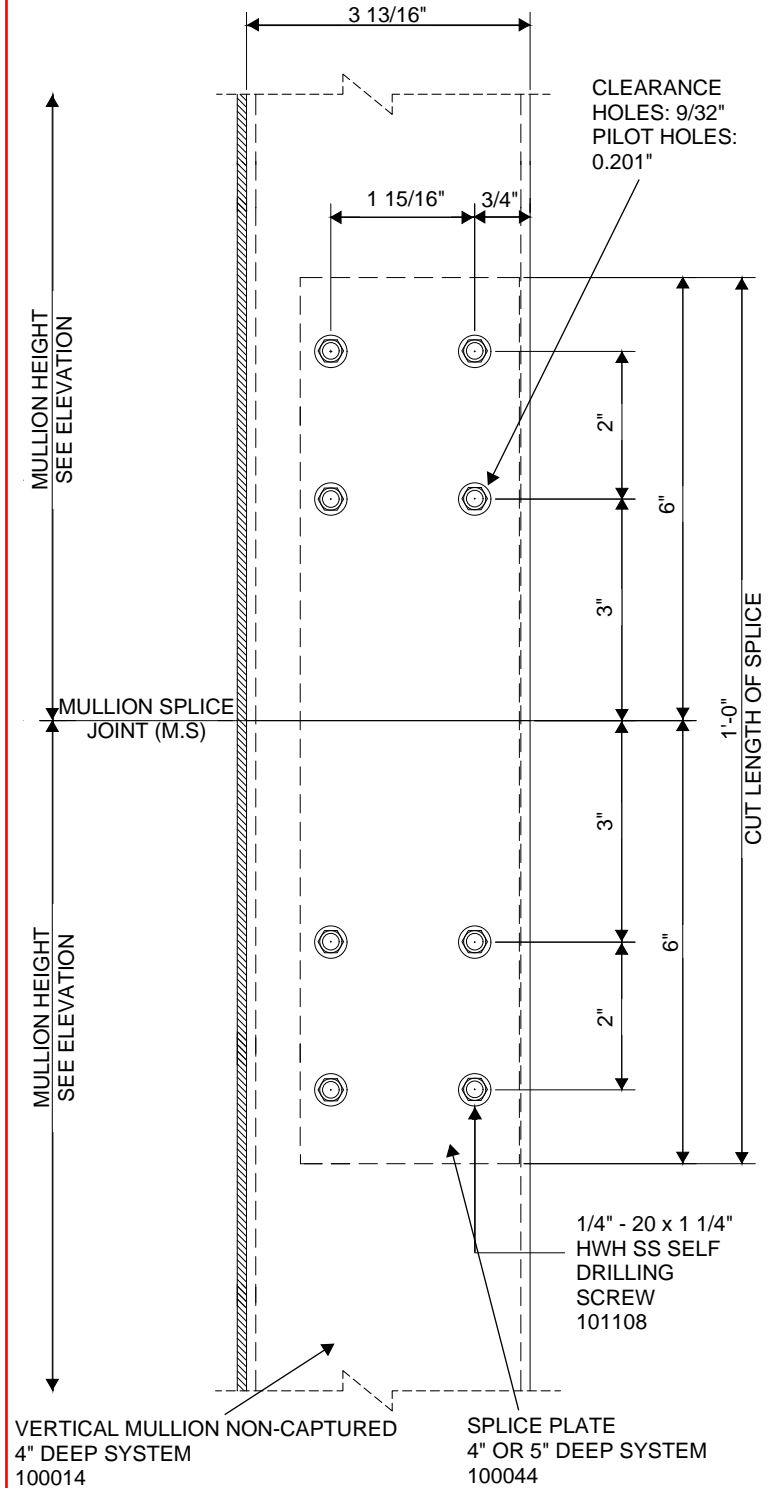
SECTION VIEW



SPLICE PLATE
4" OR 5" DEEP SYSTEM
100044

REFERENCE PAGE 17 FOR FASTENER DETAILS.

VERTICAL MULLION SPLICE JOINT DETAIL



VERTICAL MULLION NON-CAPTURED
4" DEEP SYSTEM
100014

SPLICE PLATE
4" OR 5" DEEP SYSTEM
100044

MULLION SPLICE CAN BE MOVED TO NOT INTERFERE WITH SHEAR BLOCKS IF REQUIRED.

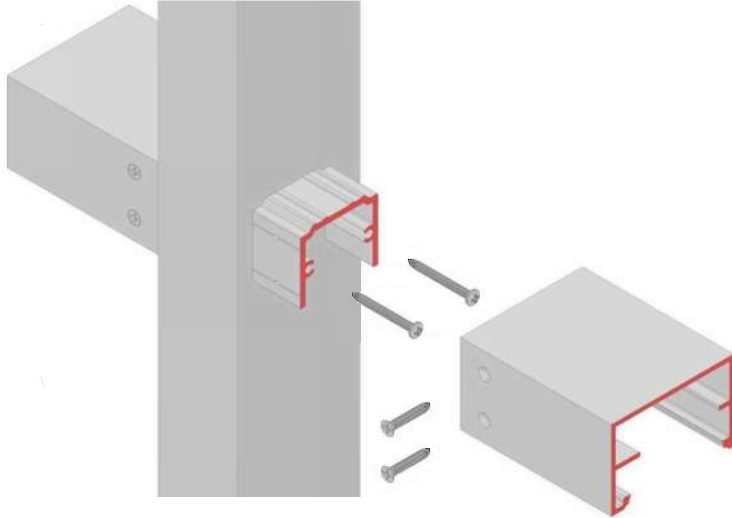
Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



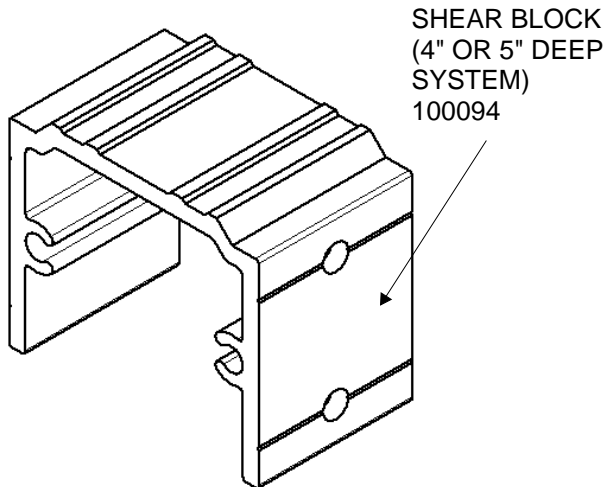
Shear Block Fabrication

REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL LENGTHS AND HORIZONTAL LOCATIONS.



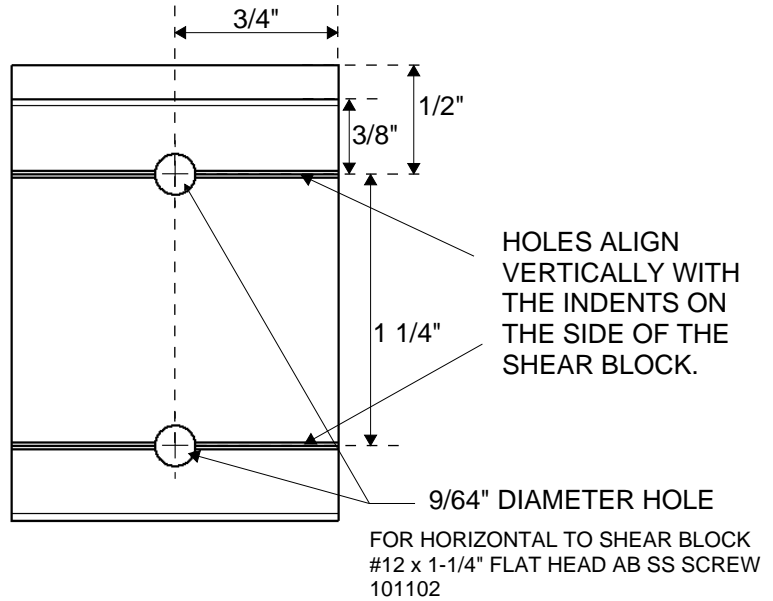
HOLE DIMENSIONS ARE THE SAME FOR BOTH THE 5" AND 7" SYSTEMS. THE 5" SYSTEM SHEAR BLOCK IS SHOWN.

AXONOMETRIC VIEW



TWO HOLES ARE TO BE DRILLED ON ONLY ONE SIDE OF THE SHEAR BLOCK FOR THE HORIZONTAL STACK CONNECTION.

SIDE VIEW



REFERENCE PAGE 17 FOR FASTENER DETAILS.

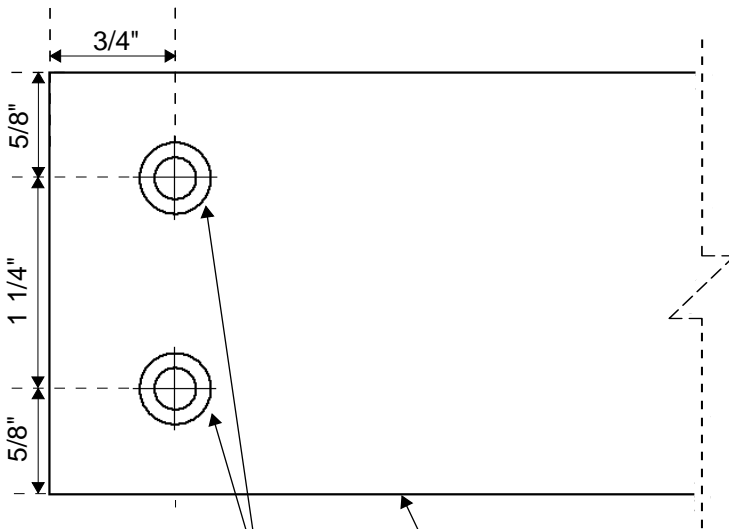
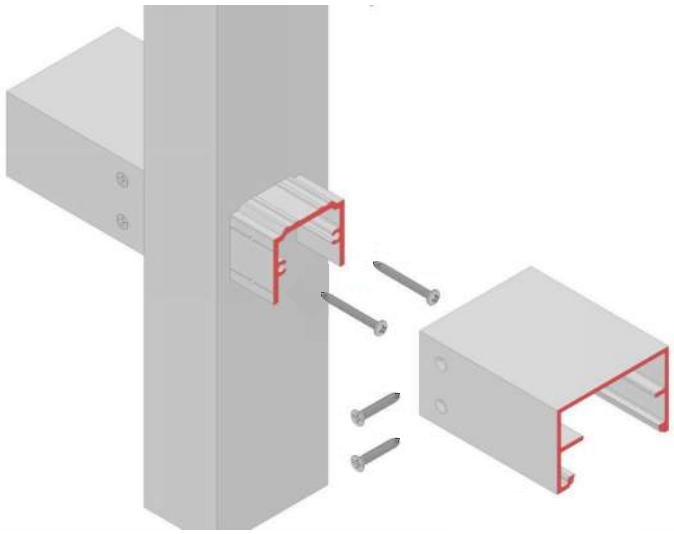
Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



Horizontal Stack Fabrication

REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL LENGTHS AND HORIZONTAL LOCATIONS.

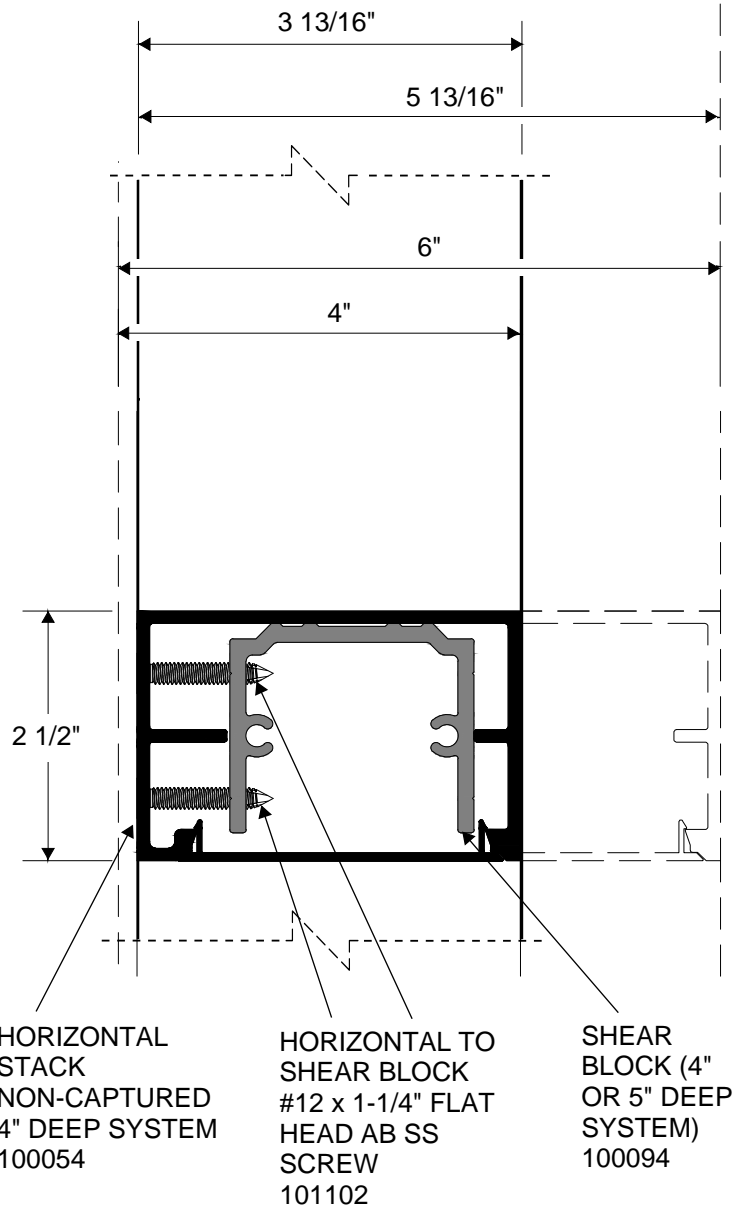


.438 O.D. x 82° HOLE
DRILL AND
COUNTERSINK FOR #12
PFH SCREW

HORIZONTAL STACK
NON-CAPTURED
4" DEEP SYSTEM
100054

COUNTERSINK TWO HOLES FOR EACH SHEAR BLOCK ON EACH END OF THE HORIZONTAL STACK (FOUR HOLES PER HORIZONTAL STACK).

TYP. HORIZONTAL DETAIL AT PANEL JOINT



REFERENCE PAGE 17 FOR FASTENER DETAILS.

Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



End Cap Fabrication

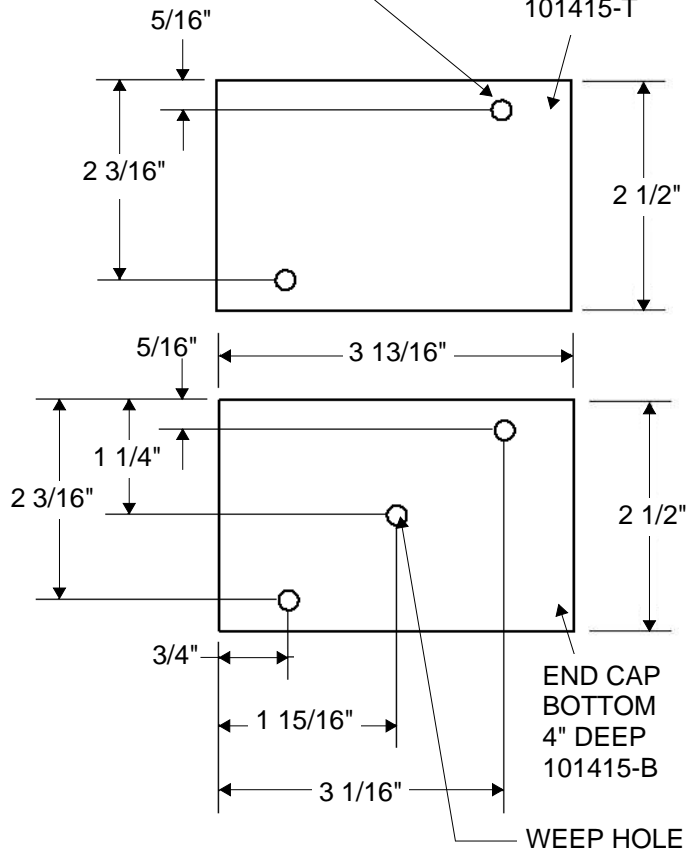
REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL MULLION DIMENSIONS.

4" DEEP SYSTEM:

5/16" DIAMETER HOLE

FOR END CAP TO VERTICAL
1/4"-14 x 1/2" PAN HEAD AB SS SCREW
101107

END CAP TOP
4" DEEP
101415-T



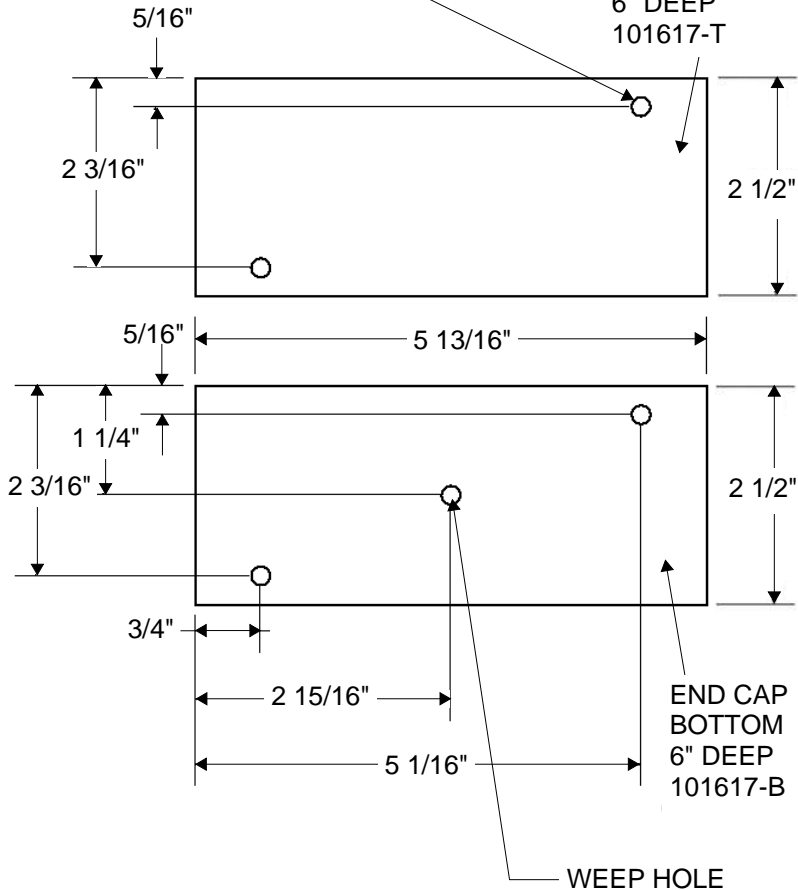
END CAPS ARE 1/16" THICK.

6" DEEP SYSTEM:

5/16" DIAMETER HOLE

FOR END CAP TO VERTICAL
1/4"-14 x 1/2" PAN HEAD AB SS SCREW
101107

END CAP
TOP
6" DEEP
101617-T



FABRICATE ONE TOP AND ONE BOTTOM END CAP FOR EACH VERTICAL MULLION UNLESS CONDITIONS SPECIFY OTHERWISE.

REFERENCE PAGE 17 FOR FASTENER DETAILS.

Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



Installation

STEP 1 - CHECK OPENINGS

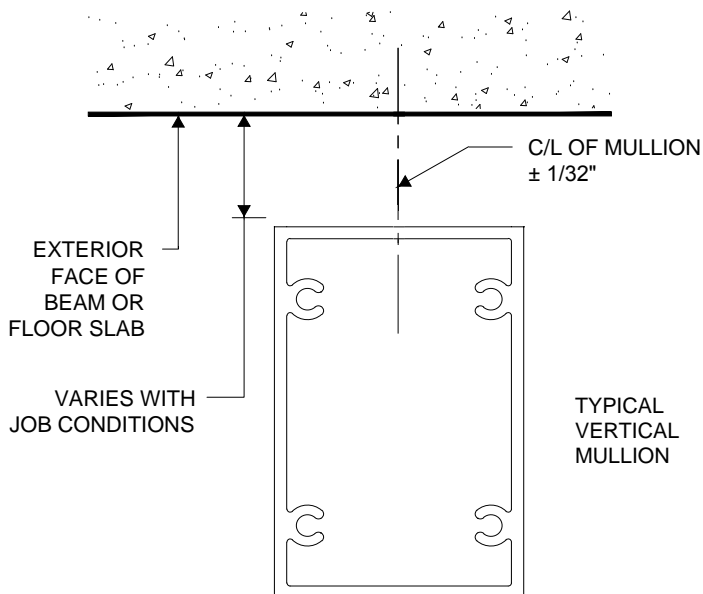
ELEVATIONS AND SLABS MUST BE WITHIN ADJUSTMENT OF ANCHORING SYSTEM. SEE APPROVED SHOP DRAWINGS FOR ALLOWABLE ADJUSTMENT.

ANCHORING SURFACES OF PERIMETER CONSTRUCTION MUST BE LEVEL AND PLUMB WITHIN THE ADJUSTMENT LIMITS OF THE MULLIONS. SEE APPROVED SHOP DRAWINGS FOR ALLOWABLE ADJUSTMENT.

STEP 2 - LAY OUT ANCHOR AND MULLION CENTERLINES

USE WALL LINES ESTABLISHED BY THE GENERAL CONTRACTOR. ON EACH FLOOR LAY OUT A REFERENCE LINE TO ESTABLISH IN AND OUT WALL LOCATIONS.

USE COLUMN CENTER LINES ESTABLISHED BY THE GENERAL CONTRACTOR. ON EACH FLOOR LAY OUT MULLION CENTER LINES AND ANCHOR CENTER LINES.



SEE APPROVED SHOP DRAWINGS FOR ANCHOR LAYOUTS

STEP 3 - INSTALL PRESET ANCHORS IF APPLICABLE

USING LOCATION LINES PREVIOUSLY ESTABLISHED INSTALL PRESET ANCHORS IN PLACE PER APPROVED SHOP DRAWINGS.

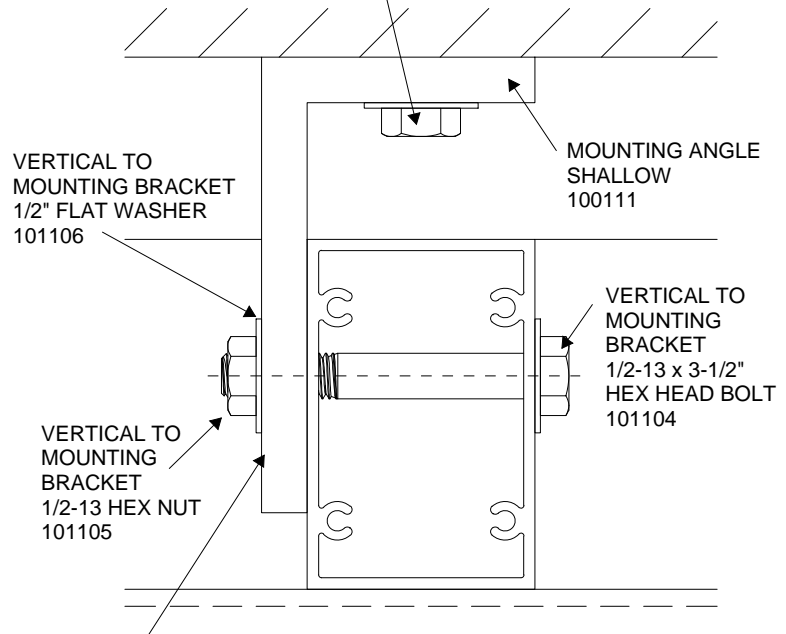
STEP 4 - FRAME ASSEMBLY: ANCHOR

ATTACH ANCHORS TO MULLIONS WHERE APPLICABLE.

ANCHOR PREP MAY BE FABRICATED IN THE FIELD OR FACTORY. CONSULT APPROVED SHOP DRAWINGS FOR CORRECT METHOD.

STANDARD ANCHOR PREP IS THRU BOLTED AT VERTICALS. REFER TO APPROVED SHOP DRAWINGS FOR CORRECT METHOD.

ANCHOR IS TO BE TORQUED TO RECOMMENDED MANUFACTURER SETTINGS.



SET ANCHOR CONNECTION TO A TORQUE OF 30 FEET PER POUND.

ACTUAL PROJECT CONDITIONS WILL DETERMINE SPECIFIC ANCHOR DESIGN. REFERENCE APPROVED SHOP DRAWINGS FOR MOUNTING ANGLE AND VERTICAL DIMENSIONS.

REFERENCE PAGE 17 FOR FASTENER DETAILS.

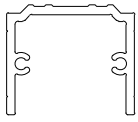
Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured

Installation

STEP 4 - FRAME ASSEMBLY: SHEAR BLOCKS

ATTACH SHEAR BLOCKS.

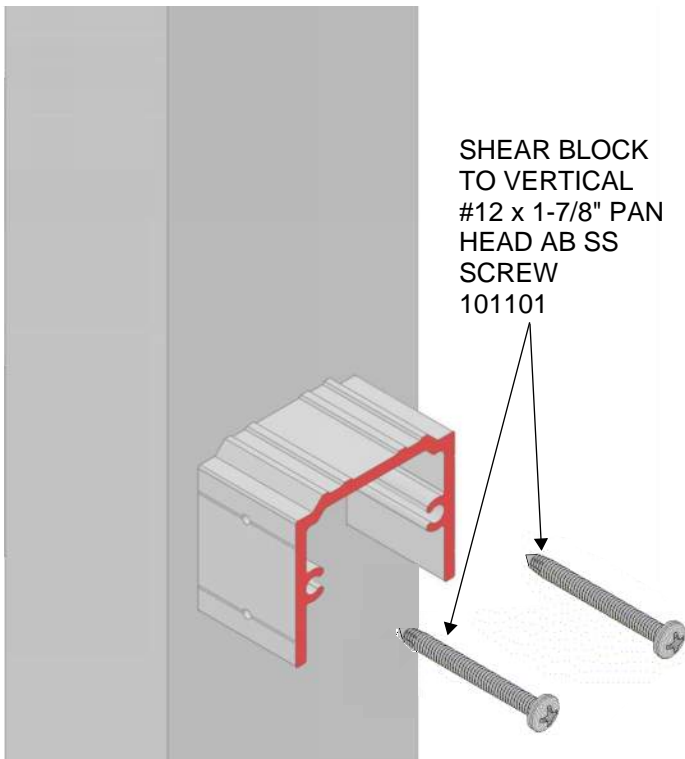


SHEAR BLOCK (4" OR 5"
DEEP SYSTEM)
100094



SHEAR BLOCK (6" OR 7"
DEEP SYSTEM)
100096

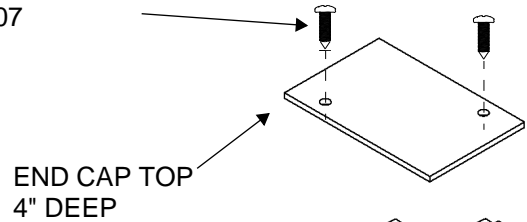
REFERENCE FABRICATION INSTRUCTIONS FOR EXTERIOR FRAME PERIMETERS.



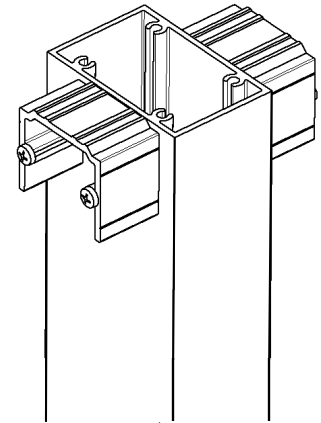
REFERENCE PAGE 17 FOR FASTENER DETAILS.

STEP 5 - INSTALL VERTICAL MULLION END CAPS

FASTENERS:
END CAP TO VERTICAL
1/4"-14 x 1/2" PAN HEAD AB SS SCREW
101107



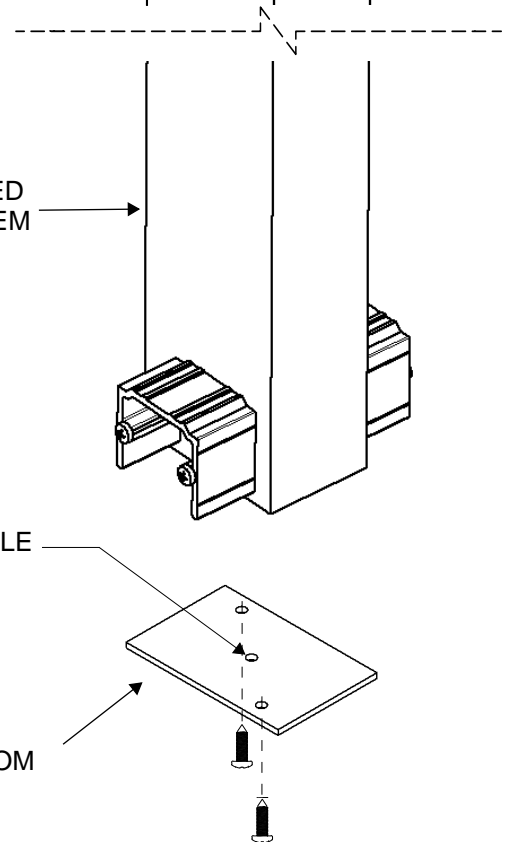
THE 5" SYSTEM IS SHOWN. REFERENCE APPROVED SHOP DRAWINGS FOR MULLION DIMENSIONS.



VERTICAL MULLION NON-CAPTURED 4" DEEP SYSTEM 100014

WEEP HOLE

END CAP BOTTOM 4" DEEP



REFERENCE PAGE 17 FOR FASTENER DETAILS.

Fabrication and Installation Instructions

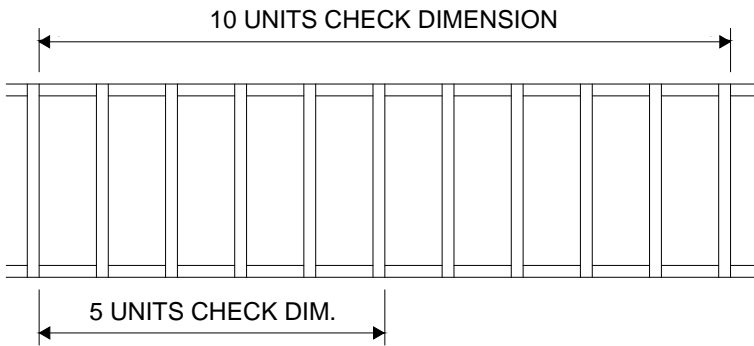
Buccan Framing System 1000: Non-Captured

Installation

STEP 6 - INSTALL VERTICAL MULLIONS

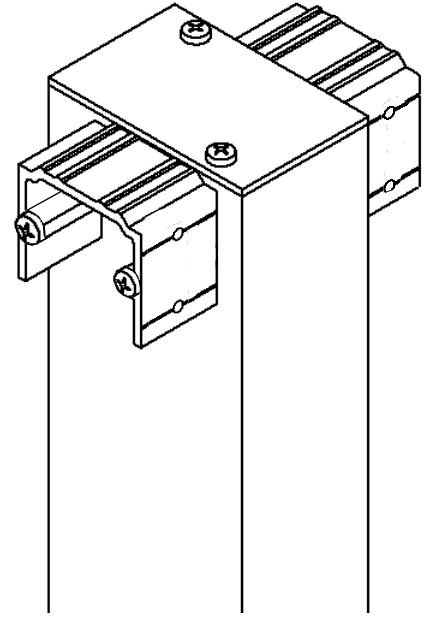
DIMENSION BUILD-UP CHECK.

OVERALL FRAME DIMENSIONS ABOUT EVERY FIVE MULLIONS ON LONG RUNS. THIS IS TO AVOID DIMENSION BUILD-UP.

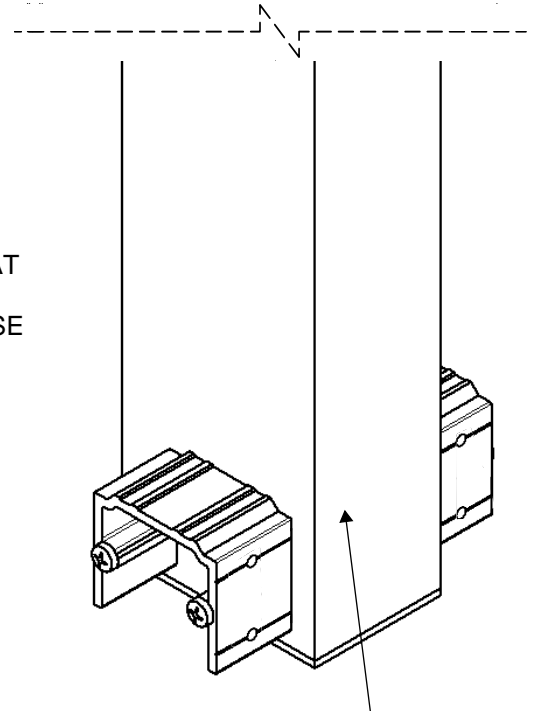


REFERENCE FABRICATION INSTRUCTIONS FOR EXTERIOR FRAME PERIMETERS.

ANCHOR FASTENER LOCATIONS PER APPROVED SHOP DRAWINGS.



THESE SHEAR BLOCKS MAY NEED TO BE REMOVED TO INSTALL AN ANCHOR FASTENER THAT MIGHT BE LOCATED CLOSE TO THE STACK.



VERTICAL MULLION
NON-CAPTURED
4" DEEP SYSTEM
100014

Fabrication and Installation Instructions

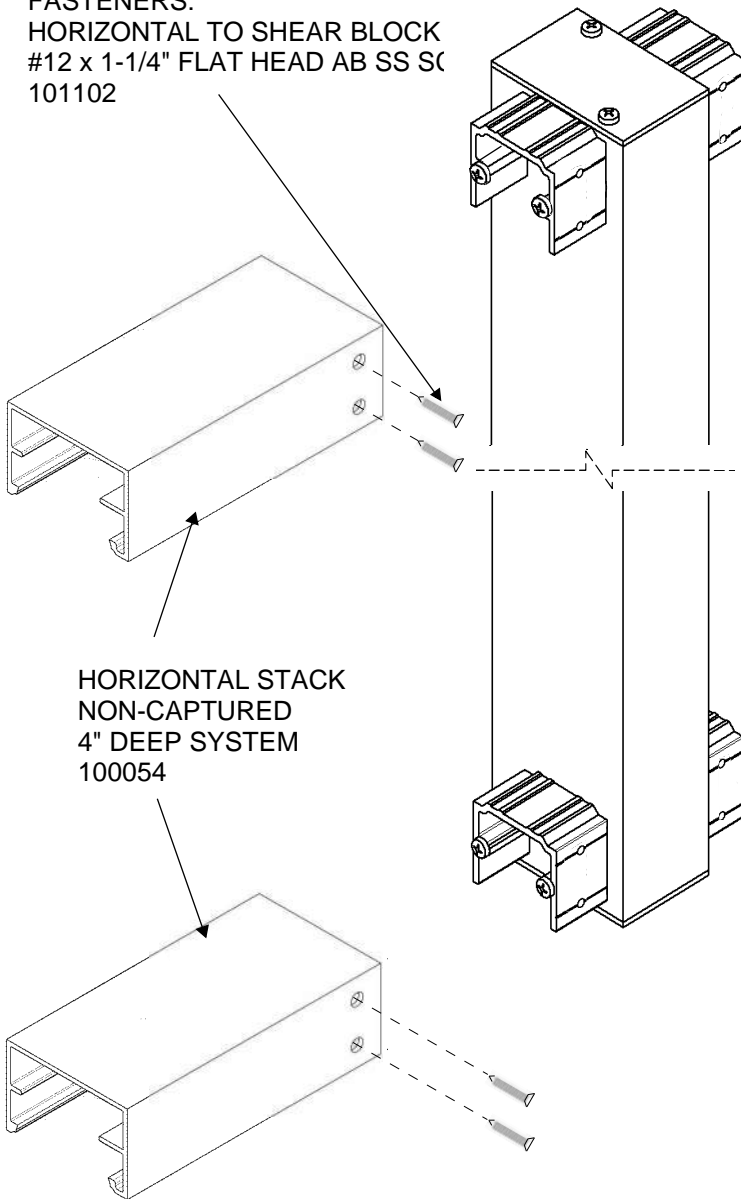
Buccan Framing System 1000: Non-Captured

Installation

STEP 7 - INSTALL HORIZONTAL STACKS

REFERENCE FABRICATION INSTRUCTIONS FOR EXTERIOR FRAME PERIMETERS.

FASTENERS:
HORIZONTAL TO SHEAR BLOCK
#12 x 1-1/4" FLAT HEAD AB SS SC
101102

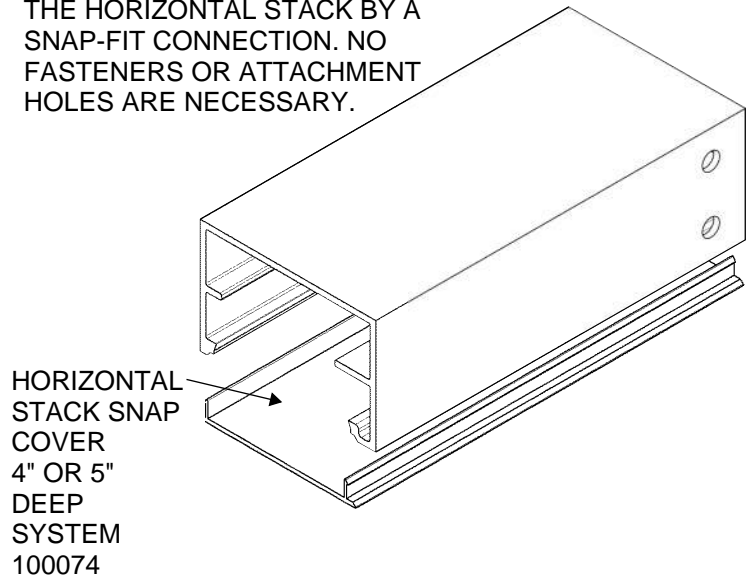


ACTUAL PROJECT CONDITIONS WILL DETERMINE SPECIFIC STACK DESIGN. REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL DIMENSIONS AND HORIZONTAL LENGTH.

REFERENCE PAGE 17 FOR FASTENER DETAILS.

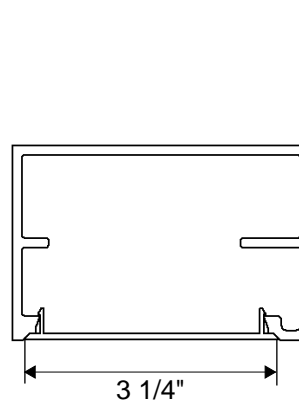
STEP 8 - INSTALL HORIZONTAL SNAP COVERS

SNAP COVER IS ATTACHED TO THE HORIZONTAL STACK BY A SNAP-FIT CONNECTION. NO FASTENERS OR ATTACHMENT HOLES ARE NECESSARY.

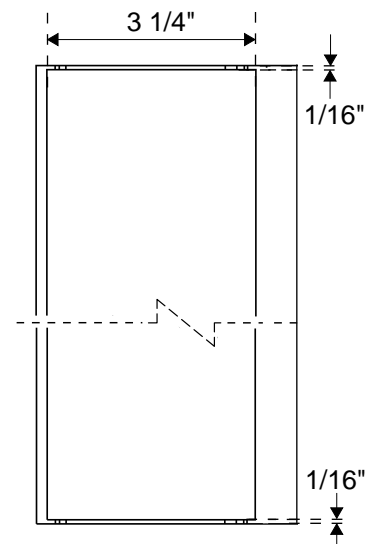


HORIZONTAL SNAP COVERS ARE 1/16" SHORTER THAN THE STACK ON BOTH ENDS. (1/8" SHORTER OVERALL.)

FRONT FACE VIEW



BOTTOM FACE VIEW



DIMENSIONS SHOWN ARE FOR THE 4" OR 5" PART. REFERENCE APPROVED SHOP DRAWINGS FOR WIDTH AND HORIZONTAL DIMENSIONS.

Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured

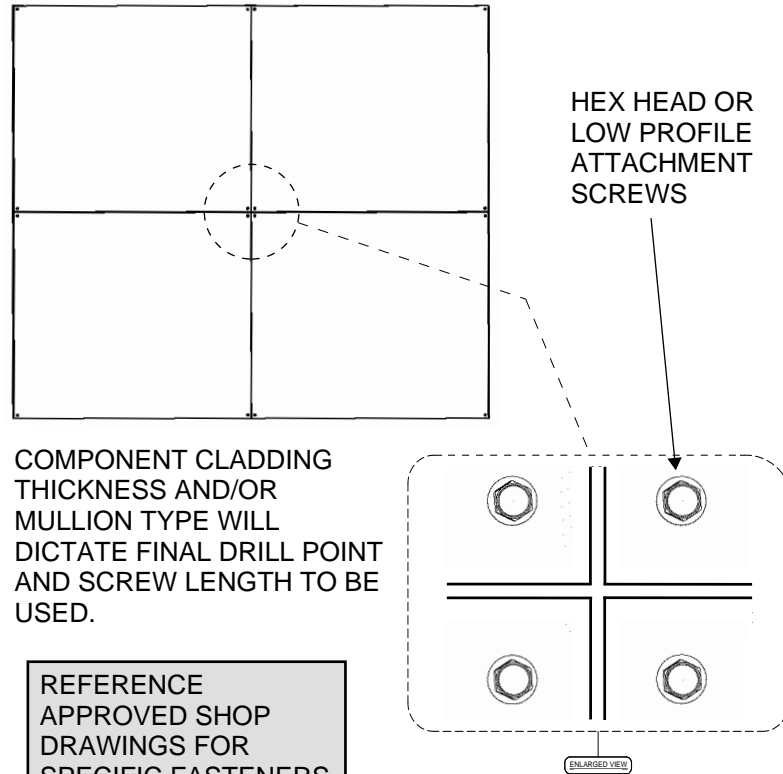
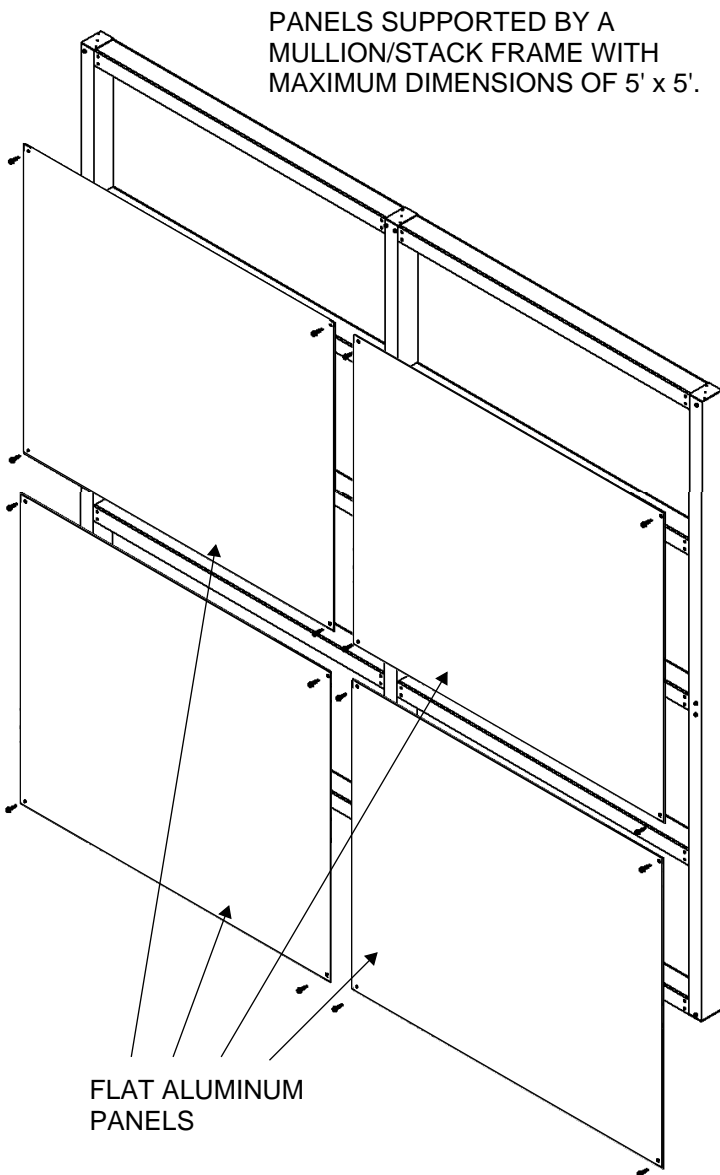
Installation

STEP 9 - INSTALL COMPONENT CLADDING

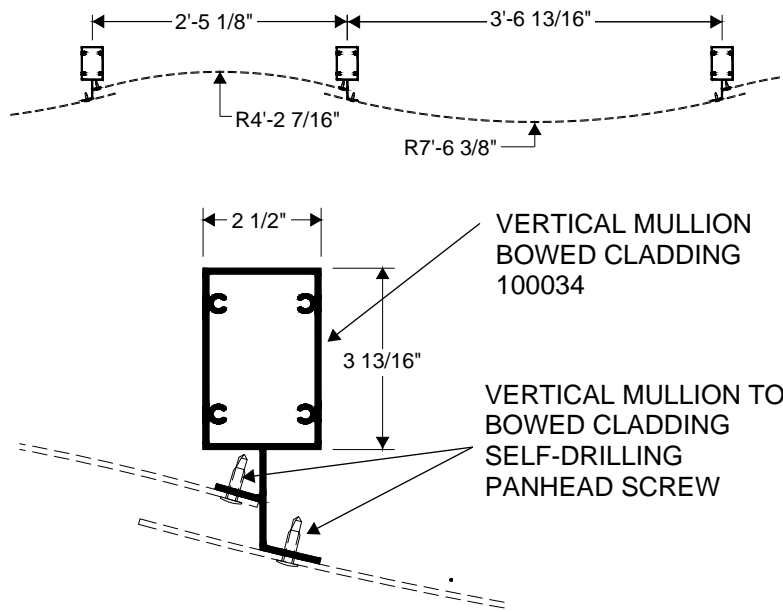
ACTUAL PROJECT CONDITIONS WILL DETERMINE SPECIFIC PANEL DESIGN. REFERENCE APPROVED SHOP DRAWINGS FOR VERTICAL AND HORIZONTAL DIMENSIONS AND DESIGN SPECIFICATIONS.

FLAT ALUMINUM PANEL OPTION

FOR 1/8" THICK INFILL PANELS:



BOWED ALUMINUM PANEL OPTION



REFERENCE APPROVED SHOP DRAWINGS FOR CLADDING DIMENSIONS AND CURVATURE.

Fabrication and Installation Instructions

Buccan Framing System 1000: Non-Captured



Fastener Details

| FASTENER | PART NUMBER | COUNT | CONNECTION | PAGE(S) |
|--|----------------------------|--|--|-----------|
| 1/2-13 x 3-1/2" HEX HEAD SS BOLT 1/2-13 HEX SS NUT 1/2" FLAT SS WASHER | 101104 101105 101106 | ONE BOLT, ONE NUT, AND TWO WASHERS PER MOUNTING BRACKET | MOUNTING BRACKET TO VERTICAL MULLION | 5, 6, 12 |
| #12 x 1-7/8" PAN HEAD AB SS SCREW | 101101 | TWO PER SHEAR BLOCK | SHEAR BLOCK TO VERTICAL MULLION | 7, 13 |
| 1/4"-20 x 1 1/4" HWH SS SELF DRILLING SCREW | 101108 | SIXTEEN PER SPLICE PLATE | SPLICE PLATE TO VERTICAL MULLION | 8 |
| #12 x 1-1/4" FLAT HEAD AB SS SCREW | 101102 | TWO PER SHEAR BLOCK | HORIZONTAL STACK TO SHEAR BLOCK | 9, 10, 15 |
| 1/4"-14 x 1/2" PAN HEAD AB SS SCREW | 101107 | TWO PER END CAP | END CAP TO VERTICAL MULLION | 11, 13 |