ASSEMBLY PROCEDURE:

1. Locate ship loose hardware required for louver multi-section assembly.
2. Position the louver sections faced down on a level, non-abrasive surface in the configuration they will be assembled in. Reference the tag numbers on each section to ensure the sections are in correct order.
3. Refer to appropriate exploded details, parts list table for splice hardware identification & location. Now fasten the sections together at frames, support splices. Supports are pre-drilled at plant for ease of installation.
4. Installer must remove factory installed screen frame screws prior to installation of splice members.
5. On architectural style units, check blade alignment at the vertical joints. Loosen section connecting hardware & adjust the position of the sections as required to achieve good blade-to-blade alignment. When alignment is complete, tighten all section connecting hardware.

FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS

ITEM # | DESCRIPTION | QTY. | PART # | MATERIAL
--- | --- | --- | --- | ---
** PARTS LIST TABLE - TYPE I (Ship loose)**
1 | SPLICE PLATE 1 1/4 X 12 X 1/8 | 1 | 900430975 | A36 STEEL ZINC PLATED
2 | BLT 1/4-20 X .75 HHD | 4 | 38004800 | ZC
3 | NUT NYLOCK 1/4-20 | 4 | 38009500 | ZC
4 | WSH FLAT 1/4 USS | 4 | 38026300 | ZC

** PARTS LIST TABLE - TYPE II (Ship loose)**
1 | SPL PLT LVR 2 X 18 X 3/8 | 2 | 900431409 | A36 STEEL ZINC PLATED
2 | BLT 3/8-16 X 1.50 HHD | 12 | 38006800 | ZC
3 | NUT NYLOCK 3/8-16 | 12 | 380430951 | ZC
4 | WSH FLAT 3/8 USS | 12 | 38026500 | ZC

** Square balloons denotes ship loose parts
**FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS**

**HVBS SUPPORT SPLICE INSTALLATION (EXPLODED DETAIL)**

**ITEM #** | **DESCRIPTION** | **QTY.** | **PART #** | **MATERIAL**
--- | --- | --- | --- | ---
1 | SPL PLT HDG 5 X 18 X 1/4 | 1 | 360500786 | HOT DIPPED GALVANIZED
2 | BLT 3/8-16 X 1.00 HHD | 12 | 38008700 | ZC
3 | NUT NYLOCK 3/8-16 | 12 | 380430951 | ZC
4 | WSH FLAT 3/8 USS | 12 | 38026500 | ZC

**PARTS LIST TABLE (Ship loose)**

**FACTORY DRILLED (SHIP LOOSE)**

**FACTORY INSTALLED**

**SHIP LOOSE**

(12 QTY REQ'D)

**Square balloons denotes ship loose parts**
**MULTI-SECTION INSTALLATION ASSEMBLY PROCEDURE:**

1. Locate ship loose hardware required for louver multi-section assembly.
2. Position the louver sections faced down on a level, non-abrasive surface in the configuration they will be assembled in. Reference the tag numbers on each section to ensure the sections are in correct order.
3. Refer to appropriate exploded details, parts list table for splice hardware identification & location. Now fasten the sections together at frames, support splices. Supports are pre-drilled at plant for ease of installation.
4. Installer must remove factory installed screen frame screws prior to installation of splice members

**FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS**

```
ITEM #      DESCRIPTION                        QTY. PART #    MATERIAL

PARTS LIST TABLE (TYPE I) (Ship loose)
1 2" H.V.B.S SINGLE FLANGE, 18.000" LG      2  36493600  6063-T6 EXTRUDED ALUM.
2 BOLT 1/4-20 X 1.00 HHD                   4  38007500  ZC
3 NUT NYLOCK 1/4-20                        4  38009500  ZC
4 WSH FLAT 1/4-20 USS                      4  38026300  ZC
5 SCR 10 X 1.5 HWH TEK                     12 380430830 410/ZC

PARTS LIST TABLE (TYPE II) (Ship loose)
1 FRM SPLICE EX LVR VIS MUL (18.000" LG.)  2  360437301 6063-T6 EXTRUDED ALUM.
2 BOLT 1/4-20 X 1.00 HHD                   4  38007500  ZC
3 NUT NYLOCK 1/4-20                        4  38009500  ZC
4 WSH FLAT 1/4-20 USS                      4  38026300  ZC
5 SCR 10 X 1.5 HWH TEK                     12 380430830 410/ZC

** Square balloons denotes ship loose parts
LIST OF MODELS AFFECTED (FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS)

<table>
<thead>
<tr>
<th>MODELS AFFECTED (TYPE I)</th>
<th>MODELS AFFECTED (TYPE II)</th>
</tr>
</thead>
<tbody>
<tr>
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<td>ELF15J</td>
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<td>ELF211</td>
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<td>ELF211D</td>
<td>ELF211D</td>
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FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS (WELDED CONSTRUCTION ONLY)

ITEM # | DESCRIPTION | QTY. | PART # | MATERIAL |
<table>
<thead>
<tr>
<th></th>
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<tbody>
<tr>
<td>1</td>
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<td>HOT DIPPED GALVANIZED</td>
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<td>3</td>
<td>NUT NYLOCK 3/8-16</td>
<td>12</td>
<td>380430951</td>
<td>ZC</td>
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<td>4</td>
<td>WSH FLAT 3/8 USS</td>
<td>12</td>
<td>38026500</td>
<td>ZC</td>
</tr>
</tbody>
</table>

** Square balloons denotes ship loose parts
FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS (MECHANICALLY FASTENED CONSTRUCTION ONLY)

**MULLION SUPPORT SPLICE INSTALLATION (VISIBLE MULLION STYLE)**
(Shown as Rear Isometric View)

**SUPPORTS (PRE PUNCHED)**
FACTORY INSTALLED

**FACTORY DRILLED**
(SHIP LOOSE)

**ITEM #** | **DESCRIPTION** | **QTY.** | **PART #** | **MATERIAL**
---|---|---|---|---
1 | SPL PLT HDG 5 X 18 X 1/4 | 1 | 360500786 | HOT DIPPED GALVANIZED
2 | 3/8-16 X 1.50 HHD | 12 | 38006800 | ZC
3 | NUT NYLOCK 3/8-16 | 12 | 380430951 | ZC
4 | WSH FLAT 3/8 USS | 12 | 38026500 | ZC

**PARTS LIST TABLE (Ship loose)**

**Square balloons denotes ship loose parts**
### Item # Description | QTY. | Part # | Material
--- | --- | --- | ---
1 | BLT 1/4-20 X 1.00 HHD | VARIES | 38007500 | ZC
2 | NUT NYLOCK 1/4-20 | VARIES | 38009500 | ZC
3 | WSH FLAT 1/4 USS | VARIES | 38026300 | ZC

**Square balloons denotes ship loose parts**
**FOR MULTI-SECTION WIDE & SINGLE-SECTION TALL LOUVER ARRANGEMENTS (WELDED CONSTRUCTION ONLY)**

MULLION SUPPORT INSTALLATION (ARCHITECTURAL STYLE)
(SHOWN AS REAR ISOMETRIC VIEW)

MULLION SUPPORT INSTALLATION (ARCHITECTURAL STYLE)
(SHOWN AS REAR ISOMETRIC VIEW)

<table>
<thead>
<tr>
<th>ITEM #</th>
<th>DESCRIPTION</th>
<th>QTY.</th>
<th>PART #</th>
<th>MATERIAL</th>
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<tr>
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<td>BLT 1/4-20 X 1.00 HHD</td>
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<td>NUT NYLOCK 1/4-20</td>
<td>VARIES</td>
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<td>3</td>
<td>WSH FLAT 1/4 USS</td>
<td>VARIES</td>
<td>38026300</td>
<td>ZC</td>
</tr>
</tbody>
</table>

** Square balloons denotes ship loose parts
### FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS (WELDED CONSTRUCTION ONLY)

**MULLION SUPPORT SPLICE INSTALLATION (ARCHITECTURAL STYLE)**
(Shown as rear isometric view)

- **Supports (Pre punched)**
  - Factory Installed
- **Factory Drilled**
  - (Ship loose)

**Item #** | **Description** | **QTY.** | **Part #** | **Material**
--- | --- | --- | --- | ---
1 | SPL PLT HDG 5 X 18 X 1/4 | 1 | 360500786 | HOT DIPPED GALVANIZED
2 | 3/8-16 X 1.75 HHD | 12 | 38226500 | ZC
3 | NUT NYLOCK 3/8-16 | 12 | 380430951 | ZC
4 | WSH FLAT 3/8 USS | 12 | 38026500 | ZC

**Square balloons denotes ship loose parts**
### Parts List Table (Type I) (Ship loose)

<table>
<thead>
<tr>
<th>Item #</th>
<th>Description</th>
<th>Qty</th>
<th>Part #</th>
<th>Material</th>
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<tr>
<td>1</td>
<td>SPLICE PLATE 1/4 X 12 X 1/8</td>
<td>1</td>
<td>900430975</td>
<td>A36 Steel Zinc Plated</td>
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<tr>
<td>2</td>
<td>BLT 1/4-20 X 1.50 HHD</td>
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<td>38008500</td>
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<td>NUT NYLOCK 1/4-20</td>
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<td>ZC</td>
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<td>4</td>
<td>WSH FLAT 1/4 USS</td>
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### Parts List Table (Type II) (Ship loose)

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<tr>
<th>Item #</th>
<th>Description</th>
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<th>Part #</th>
<th>Material</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>SPL PLT LVR 2 X 18 X 3/8</td>
<td>2</td>
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<td>A36 Steel Zinc Plated</td>
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<tr>
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<td>NUT NYLOCK 3/8-16</td>
<td>12</td>
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</tr>
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<td>4</td>
<td>WSH FLAT 3/8 USS</td>
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</tbody>
</table>

** Square balloons denotes ship loose parts
FOR MULTI-SECTION WIDE & SINGLE-SECTION TALL LOUVER ARRANGEMENTS (MECHANICALLY FASTENED CONSTRUCTION ONLY)

MULLION SUPPORT INSTALLATION (ARCHITECTURAL STYLE) (SHOWN AS REAR ISOMETRIC VIEW)

MULLION SUPPORT INSTALLATION (ARCHITECTURAL STYLE) (SHOWN AS REAR ISOMETRIC VIEW)

ITEM # | DESCRIPTION | QTY. | PART # | MATERIAL
--- | --- | --- | --- | ---
1 | BLT 1/4-20 X 1.00 HHD | VARIES | 38007500 | ZC
2 | NUT NYLOCK 1/4-20 | VARIES | 38009500 | ZC
3 | WSH FLAT 1/4 USS | VARIES | 38026300 | ZC

** Square balloons denotes ship loose parts
### Parts List Table (Ship loose)

<table>
<thead>
<tr>
<th>ITEM #</th>
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</thead>
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<td>Varies</td>
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<td>ZC</td>
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<td>3</td>
<td>WSH FLAT 1/4 USS</td>
<td>Varies</td>
<td>38026300</td>
<td>ZC</td>
</tr>
</tbody>
</table>

** Square balloons denotes ship loose parts.
FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS (MECHANICALLY FASTENED CONSTRUCTION ONLY)

MULLION SUPPORT SPLICE INSTALLATION (ARCHITECTURAL STYLE)
TYPE - I
(SHOWN AS REAR ISOMETRIC VIEW)

MULLION SUPPORT SPLICE INSTALLATION (ARCHITECTURAL STYLE)
TYPE - II
(SHOWN AS REAR ISOMETRIC VIEW)

<table>
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** Square balloons denotes ship loose parts
MULLION SUPPORT SPLICE INSTALLATION (ARCHITECTURAL STYLE)
(SHOWN AS REAR ISOMETRIC VIEW)

FACTORY DRILLED
(SHIP LOOSE)

(12 QTY REQ’D)
(SHIP LOOSE)

SUPPORTS (PRE PUNCHED)
FACTORY INSTALLED

REFER SHEET 9 FOR MULLION SUPPORT ATTACHMENT INFO.

PARTS LIST TABLE (Ship loose)

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FOR MULTI-SECTION WIDE & MULTI-SECTION TALL LOUVER ARRANGEMENTS (MECHANICALLY FASTENED CONSTRUCTION ONLY)