

New Morning Windows has been in business for more than a quarter century; one of the first companies to focus on the custom architectural window market. We have worked in a research and development or contract supply capacity with many of the major United States wood window and door manufacturers, assisting them in starting or developing their own custom round-top window programs.

The following information is provided to assist you in making purchasing decisions regarding our products. This data is accurate as of January 1, 2002. Due to ongoing product changes, this data may change over time.

### WOOD FRAMES / SASH

We use kiln-dried, clear northern pine for all of our finished window surfaces (other wood types may also be specified). Compatible wood or lesser grades may be used for curved or straight jamb (sub-surface) laminates. Our curved jambs use a type II water-resistant glue between the laminates, and wood frame parts are dip treated to meet WDMA standards and guidelines. Window frame joints are butted together and secured with galvanized screws. Sash joints are mortised and also secured with galvanized screws. The thickness of our window frames range from  $1\frac{3}{16}$ " to  $1\frac{1}{8}$ " depending on which exterior frame cladding is ordered. Sash thickness ranges from  $1\frac{3}{8}$ " to  $1\frac{3}{4}$ ", depending on the size and type of unit ordered. Custom sash depths and widths are available.

### EXTERIOR FRAME / SASH CLADDING

Our (white) vinyl extruded cladding material is colored during the extruding process. Our aluminum-extruded claddings are painted to AAMA 2603 or AAMA 2605 standards. Exterior vinyl joints are heat welded creating a solid corner or straight joint. Exterior aluminum joints are cut to the specified angle, back filled with silicone caulk and secured to the frame (in the corners) using metal corner locks or screw channels. Both the vinyl and aluminum extrusions are secured to the frame using  $\frac{1}{4}$ " x  $\frac{5}{8}$ " metal staples. Aluminum sash cladding joints are mitered and secured to the wood sash material with the same size metal staples. Clad framed units incorporate a continuous, factory applied vinyl nail flange inserted into a kerf, then stapled to the jamb (approximately 4" on center) with  $\frac{1}{2}$ " x  $\frac{3}{8}$ " staples. The perimeter nail flange/frame joint is caulked with silicone and overlapped in the corners to help prevent moisture from reaching the sheathing.

### GLAZING

All clad exterior and painted wood sash units are wet glazed. Unfinished or primed wood units are also wet glazed.

**Wet Glazing** Glass is positioned on a continuous  $\frac{3}{8}$ " bead of clear beaded silicone that has been applied to the glazing flange of the window or sash cladding. Wood glazing stops are nailed into the frame or sash to secure the glass.

### STRUCTURAL AUTHENTIC DIVIDED-LITE

Our clad or all-wood units can be constructed with clad or wood exterior mullions. Since many of the windows we build are oversized or unusual custom windows, we manufacture a more substantial clad or wood mullion to give better performance. Narrow clad or wood mullions can often exhibit severe flexing under wind load. Our design allows for the construction of single frame, multiple-lite units that, in turn, make installation more convenient. See the test data on our Authentic divided-lite unit.

**Note** Not every available configuration or size of a particular window is tested. New Mornings Windows, Inc. makes no representations or claims of compliance with WDMA, AAMA, and NFRC standards for other window designs.

We are confident that you will find us a capable, experienced custom window supplier, with a consistent record and solid reputation for manufacturing a quality, industry-leading product. Please contact us if you require further details or specific technical data. We look forward to working with you. Thank you for your continued interest in our products.

*Technical*