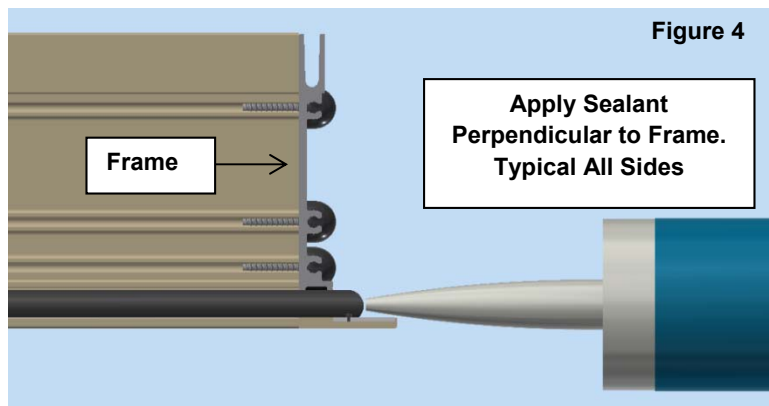
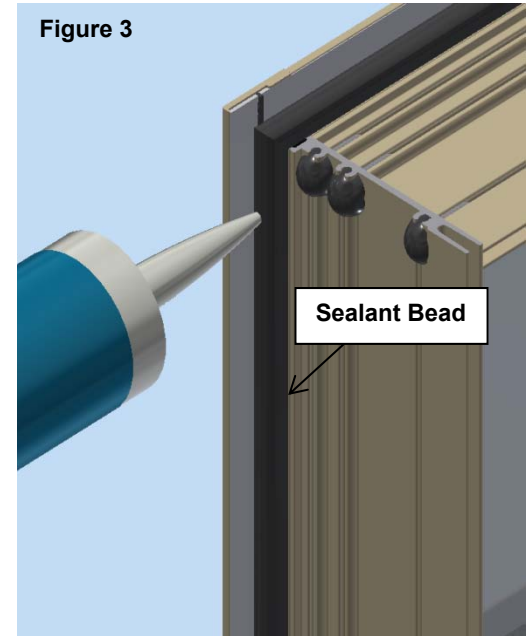
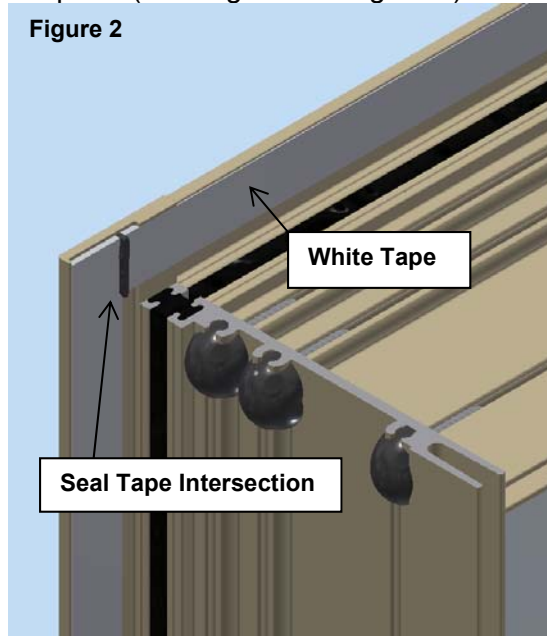
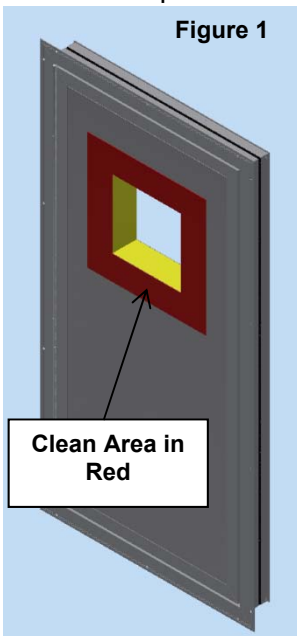


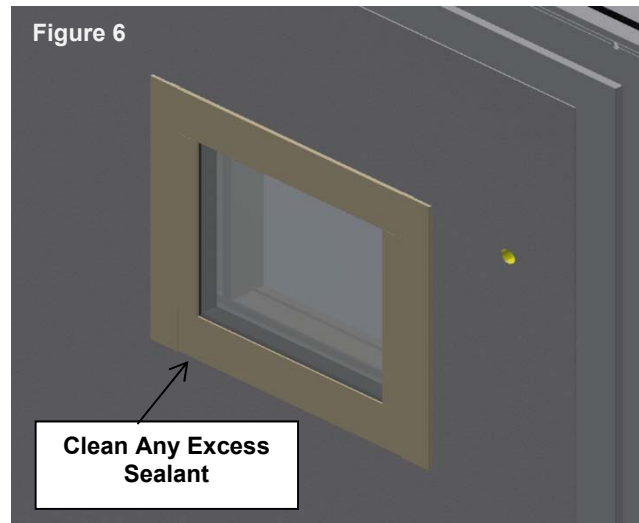
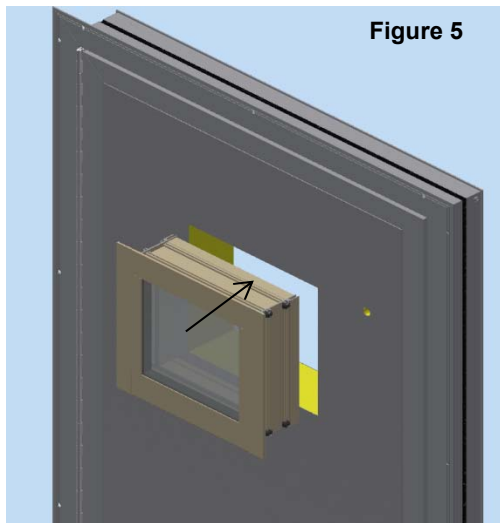
Completely read the General Installation Instructions and all other sections that pertain to your project before beginning work. These recommendations are for general installation procedures only. Actual job conditions may vary, see project specific documents and/or details on the shop drawings.

General Installation Instructions for Viewport

1. Determine exterior side of door.
2. Clean exterior face of opening at viewport cutout from edge of cutout to 3" away from cutout. (See Figure 1)
3. Locate exterior viewport assembly, this assembly contains the glass.
4. Dry fit exterior viewport assembly into door cut out. Viewport should be centered in the opening, level, and square.
5. If exterior viewport assembly fits square and level, proceed to step #6. *If viewport assembly does not fit square or level, check the cutout to ensure it is square and level with the door. If cutout is out of square or not level, contact Wintech.*
6. Peel away backer on white PSA tape.
7. Seal all four tape intersections using a compatible urethane sealant. (See Figure 2)
8. Place a large bead of compatible urethane sealant around all four sides of the viewport. Bead should be placed against the thermal pour pocket of the viewport frame and directly on the white PSA tape. It is critical sealant is applied perpendicular to the thermal pour pocket of the viewport. (See Figure 3 & Figure 4)



9. Insert exterior viewport assembly into cut out in door. Viewport should be inserted from the exterior side of the door. The viewport should be centered in the opening and level just as in step #4. Clean any excess sealant squish out between the viewport and exterior door skin. (See Figure 5 & Figure 6)
 - a. Viewports with insulated glass should be installed to the breather tube is at the top of the exterior viewport assembly. Failure to install the viewport with the breather tube at the top of the viewport will result in possible condensation being cycled into the inside of the insulated glass unit.



10. Locate interior viewport closure assembly.
11. Insert interior closure assembly into interior of door cut out.
12. Attach interior closure assembly to the exterior viewport assembly using Wintech supplied SO19 fasteners. The holes in the interior closure assembly are to match up with the fastener cavity of the exterior viewport assembly. *Do not insert fasteners into any other location other than exterior viewport fastener cavity.* (See Figure 7)
13. Make necessary adjustments to viewport one last time to ensure both the exterior and interior assemblies are installed square and level.
14. Cross tighten all interior closure assembly fasteners. (See Figure 8)
15. After SD Viewports are fully installed clean viewport frame and door on both the exterior and interior sides with denatured alcohol or window cleaner.

