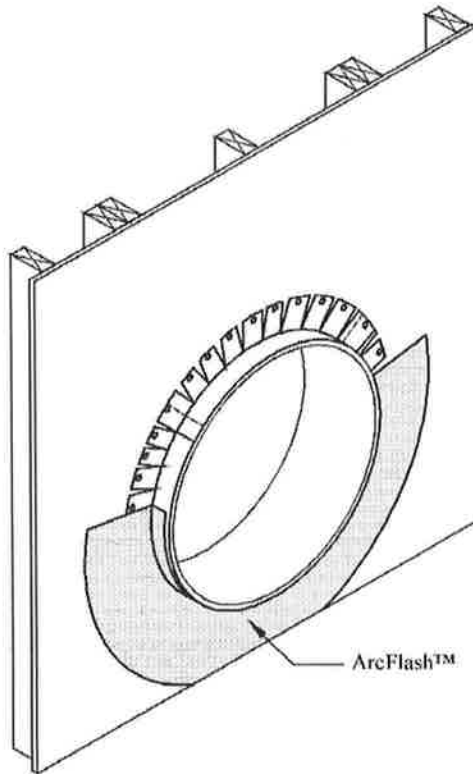
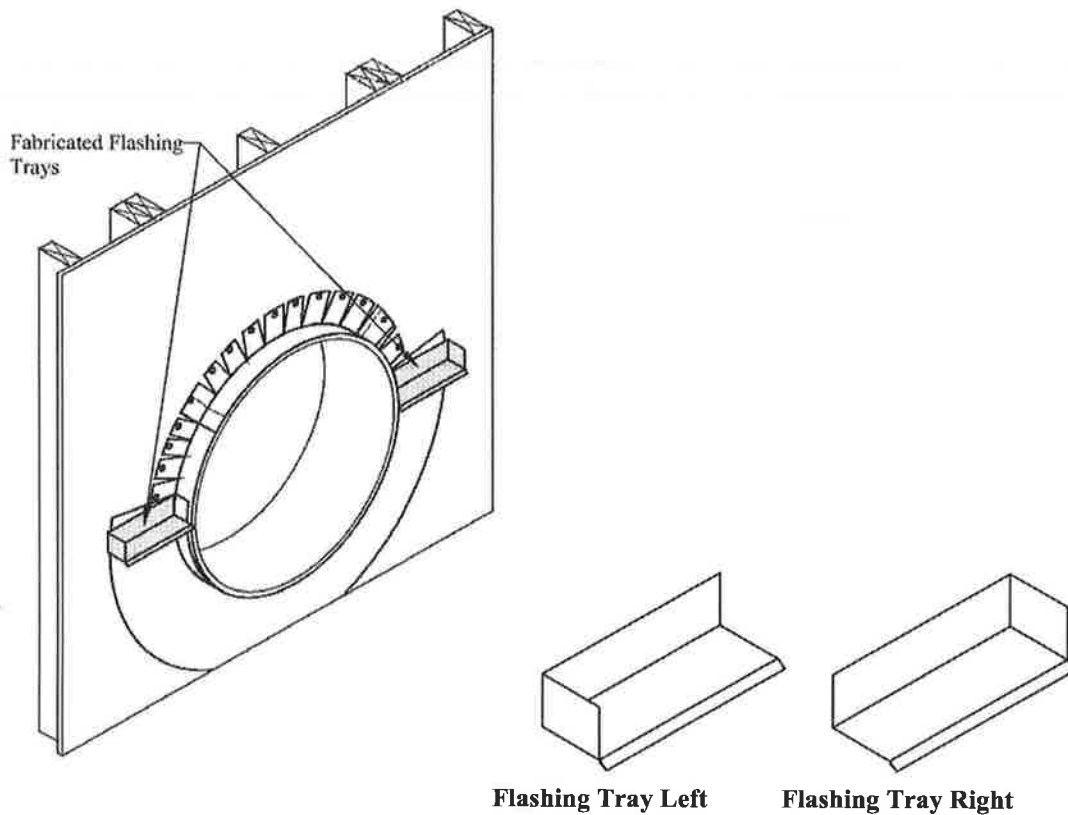


Installation Sequencing of the "L" Shaped Flashing

- Step 2** Fabricate an "L" shaped flashing from metal specified in the construction documents as follows:
 (The overall width of metal to form should equal the sum of 1-1/2-inches, the dimension of the wall leg, plus the distance from the face of the backing wall to where the face of the masonry veneer will be, the dimension of the "L" leg, plus 1/4-inch for the hem.)
- Cut two lengths so they will cover from the 8:00 to 10:00 position on the form (as if the circle were the face of a clock) plus 2-inches. These parts are 2 and 3.
 - Cut two lengths so they will cover from the 10:00 to 2:00 position on the form plus 2-inches. These parts are 1 and 4.
 - Fold a 1/4-inch hem along the outer edge of each piece and onto the outward side of the "L".
 - Bend each piece 90-degrees, upward from the outer edge along a line that is equal to the distance from the face of the backing wall to where the face of the exterior finish will be. Done correctly, the dimension of the remaining leg should be 1-1/2-inches.
 - Slit the wall leg so that the piece can be shaped to the curve of the circle.
- Step 3** Install the "L" shaped metal flashing in the following sequence:
- Center Part 1 at 12:00 and then shape it around the form or spacer and fasten it with flat head fasteners;
 - Center Part 2 at 9:00 and then shape and fasten it as above;
 - Center Part 3 at 3:00 and then shape and fasten it as above;
 - Center Part 4 at 6:00 and then shape and fasten it as above.



- Step 4 Adhere ArcFlash™ onto the form leg of the L shaped flashing, beginning 2-inches above the 9:00 position and in a counter clockwise direction, with the edge of the ArcFlash™ along the inward edge of the hem, to 2-inches above the 3:00 position. Tightly shape the form leg of the ArcFlash™ into the wall bend. Proceed to stretch and shape the remaining flashing onto the backing wall, working from the wall bend with progressively outward movements along the length of the flashing.

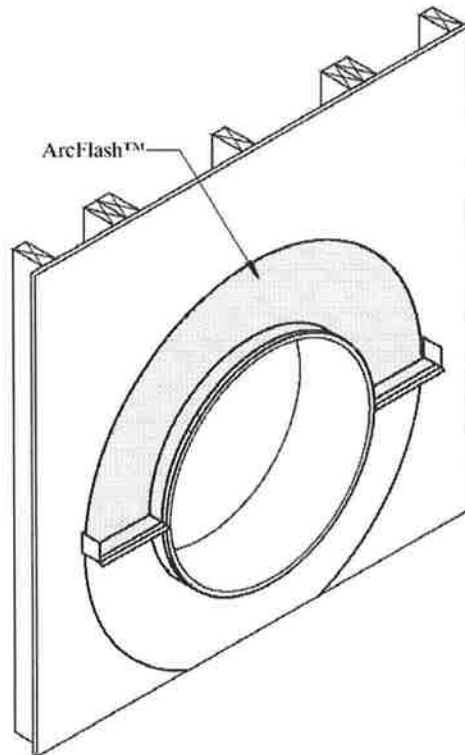


- Step 5** Fabricate two three-sided flashing trays from metal specified in the construction documents and with:
- A length of 7-3/4-inches;
 - A drip edge bent at a 15-degree minimum downward angle from flat and having a minimum 3/8-inch hemmed lip;
 - A horizontal depth from the bend in the drip equal to the calculated distance between the face of the backing wall and where the face of the exterior finish will be;
 - A backing wall leg height of 2-inches bent 90-degrees upward from flat;
 - An end dam on the outside each of tray 2-inches high and bent 90-degrees upward from flat and;
 - Soldered end dam seams.

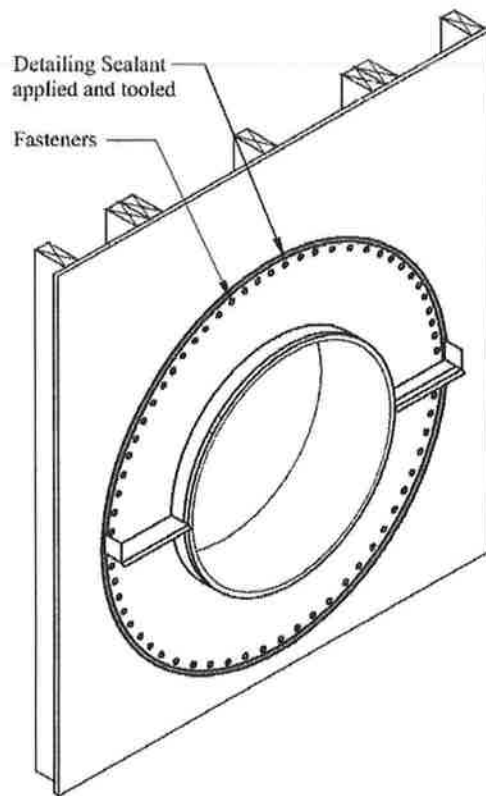
- Step 6** Install the flashing trays for applied exterior finishes with their top edge aligned along the 9:00 and 3:00 respective positions on the circle.

Install flashing trays for masonry veneer with the bottom of the tray aligned along where the top of a veneer course will be located at or below the 9:00 and 3:00 respective positions on the circle.

Fasten the wall leg of the tray to the backing wall with fasteners compatible with the tray metal.

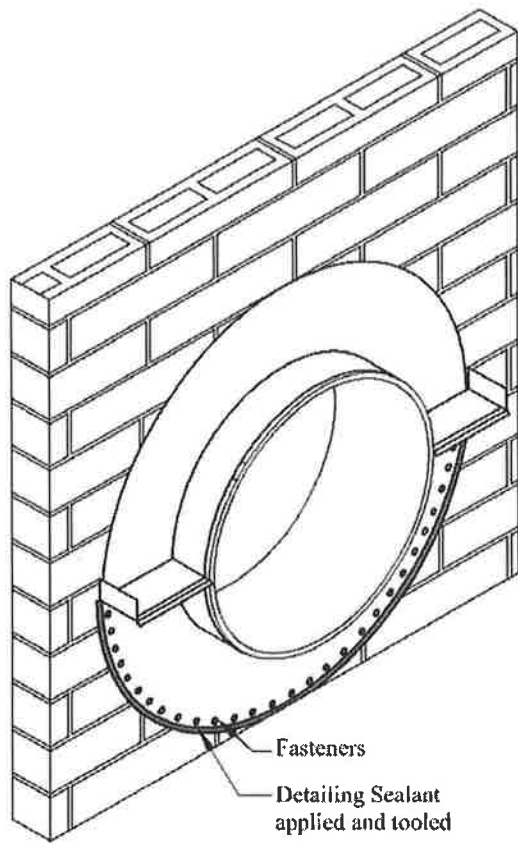


- Step 7 Adhere ArcFlash™ onto the form leg of the L shaped flashing, beginning in and along 2-inches of the bottom of one of the trays and across the top of the circle into and along 2-inches of the bottom of the other tray with the edge of the ArcFlash™ along the inward edge of the hem. Tightly shape the form leg of the ArcFlash™ into the wall bend. Proceed to stretch and shape the remaining flashing onto the backing wall, working from the wall bend with progressively outward movements along the length of the flashing.

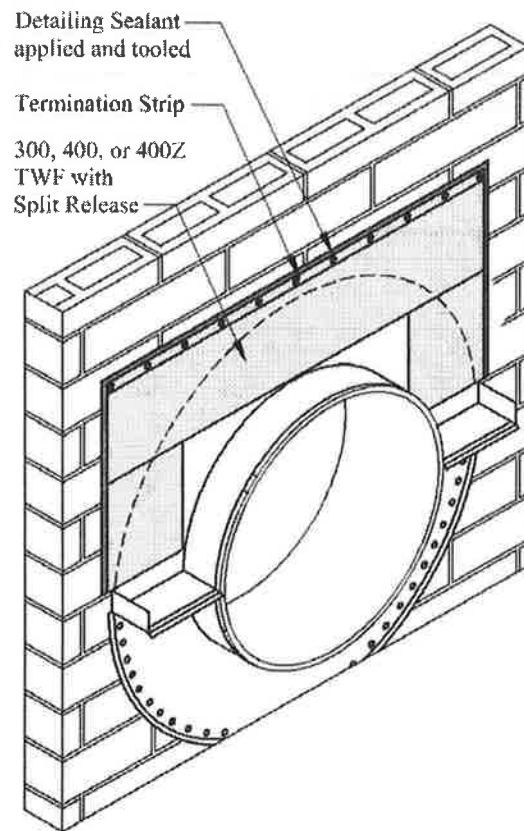


- Step 8** Fasten the outer edge of the ArcFlash™ to the backing wall with fasteners spaced at not more than 3-inches apart. If the edge will not be covered at a later time by a liquid or sheet, air or water barrier, apply a 3/8-inch bead of Detailing Sealant along the terminated edge. Tool the bead to a uniform an even coverage.

In applications with masonry back-up terminate the flashing as shown in Steps 9 and 10.



- Step 9** Fasten the outer edge of the lower half of the ArcFlash™ to the masonry with fasteners spaced at not more than 3-inches apart. If the edge will not be covered at a later time by a liquid or sheet, air or water barrier, apply a 3/8-inch bead of Detailing Sealant along the terminated edge. Tool the bead to a uniform an even coverage.

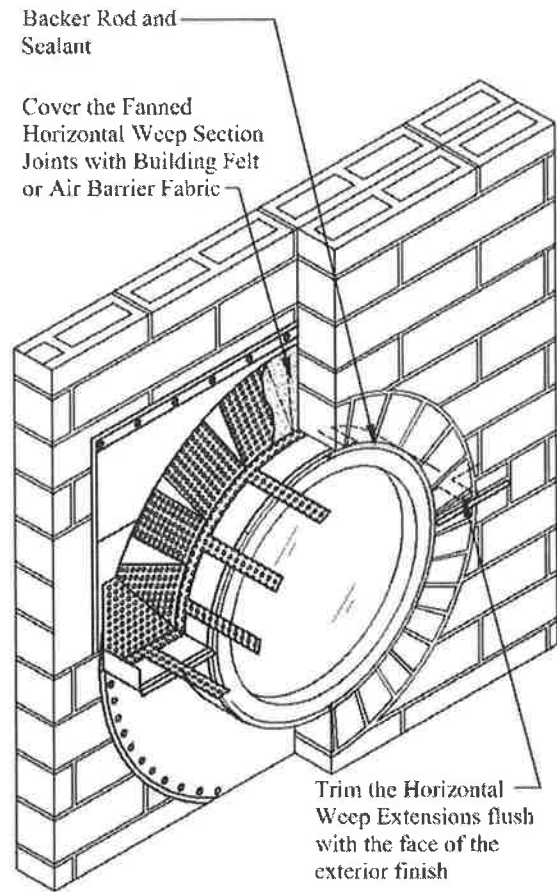
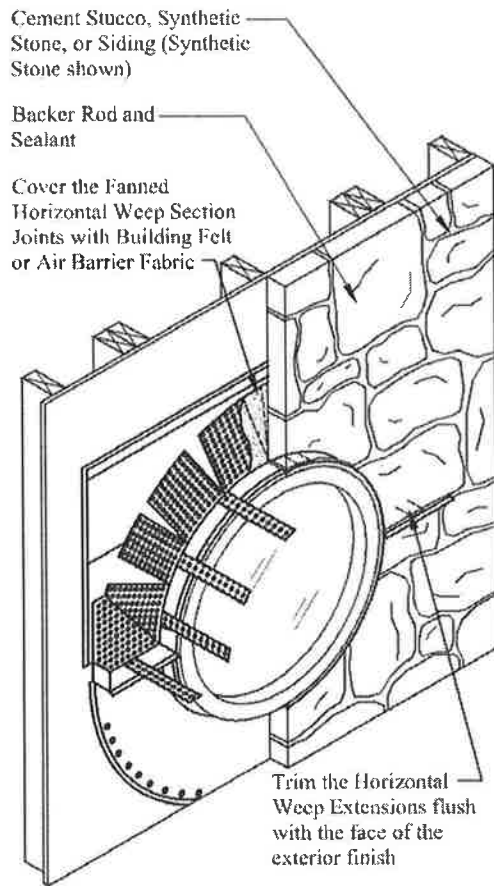


- Step 10 Install a covering flashing, for the top half of the ArcFlash™, with 300, 400, or 400Z TWF with Split Release, so that it can be terminated horizontally.

If the coverage will be with one large piece of flashing, cover the area from the outer sides of the flashing trays to the top of the ArcFlash™.

If the coverage will be constructed with segments of flashing, begin in the flashing trays and move to the top of the arch maintaining a common outer edge that is aligned with the outer edge of the respective tray. Overlap the ArcFlash™ top edge a minimum of 2-inches with each segment.

Fasten a Termination Strip along the top edge of the covering flashing. If the edge will not be covered at a later time by a liquid or sheet, air or water barrier, apply a 3/8-inch bead of Detailing Sealant along the terminated edge. Tool the bead to a uniform an even coverage.



Step 11 Install Horizontal Weeps across the top half of the ArcFlash™ as follows:

Place a weep in each flashing tray. If cutting and repositioning a weep is necessary, cut a weep extension flush with the lower body edge. Nest the separated weep into cups along the lower body and in the desired location.

In cavity wall applications, shape and crease the lower body of sections of the Horizontal Weep so that the forward edge of the lower body will be positioned along where the plane of the back of the exterior finish or masonry veneer will be. Make relief cuts in the body of the Horizontal Weep to allow the piece to be shaped across the arch. Adhere the piece across the arch.

In non-cavity wall applications, cut the Horizontal Weep into sections, with a weep extension centered in each section. Bend the weep extension to lay flat on the arch. Adhere the sections to the wall with the weep extension flat against the arch.

Cover the fanned Horizontal Weep section joints with building felt or air barrier fabric.

In Hard Siding applications substitute Polyguards' Low Flow pliable drainage mat for the Horizontal Weep. Shape it across the face of the flashing and tack it in place. Install the bottom edge of the siding with a 1/8-inch separation from the arch.

Step 12 Install the exterior finish.

Step 13 Trim the Horizontal Weep extensions flush with the face of the exterior finish, or masonry joint after the joint is tooled.

- Step 14 Remove the form from the opening and install the non-flanged window, or remove the form /spacer from the flanged window.
- Step 15 Install a backer rod and sealant between the exterior side of the window and underside of the L shaped flashing and between the interior side of the rough opening and frame of non-flanged windows.