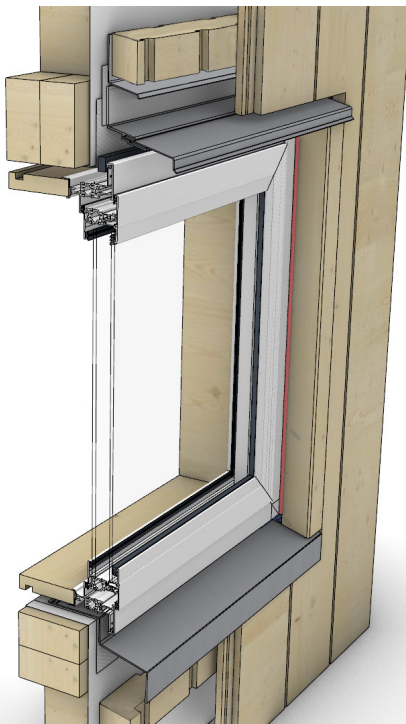


INSTALLATION GUIDE

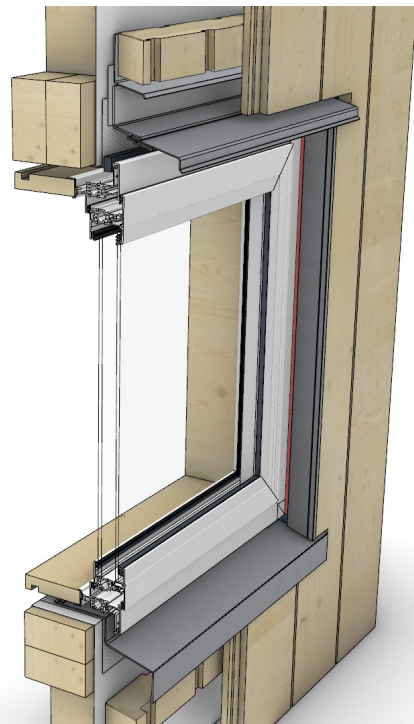
PURPOSE

This installation guide applies to the installation of Aro® Recessed Joinery Flashing System (JSC Aro® System). The system is intended for use in conjunction with JSC 18.5 mm thick Verticlad or Rusticlad weatherboards, cavity using JSC-H (45×45), JSC-V (45×45) and JSC (70×45) Structural Cavity Battens, and aluminium joinery that is to be recessed back to the framing line.

It is intended for use by licensed LBP (carpentry) or a builder who is supervised by a licensed LBP (carpentry).



Aro Flashing System with timber jamb



Aro Flashing System with aluminium jamb

IMPORTANT DOCUMENTS

In addition to this guide refer to:

- Building Consent documentation (where applicable),
- JSC Verticlad or Rusticlad Installation guides,
- Aro® System BPIR statement,
- Installation information of related building work

FOR MORE HELP

Technical assistance is available at www.jsc.co.nz

PRE-INSTALLATION

KEEP SAFE

Follow simple health and safety practices:

- Create a safe working environment - be organised and tidy.
- Follow all instructions when using tools.
- Make sure that tools are regularly serviced.
- Work in a well-ventilated area.
- Use PPE equipment (including safety from falling harnesses, safety glasses and gloves).

More information can be found at [Construction](#) | [WorkSafe](#)

HANDLING AND STORAGE

The Aro Flashing System comprises:

- JSC extruded aluminium flashings (JSC flashing)
- Thermoplastic stop ends
- Adhesives & sealant
- Mechanical fixings ASSY plus 4 A2 TH 40mm 304 stainless steel screws.

When delivered to site ensure that the JSC flashings are:

- dry
- unmarked, and
- undamaged

Unload by hand or using a hiab or crane. When using a hiab or crane the JSC flashing must be supported at two load points spaced to prevent excessive flexing. If using slings or chains, packers must be used to spread the load and protect the flashings.

When unloading confirm the defined warranted condition has been met.

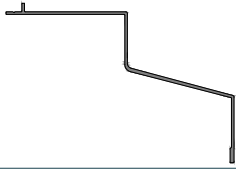
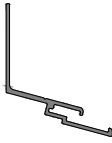
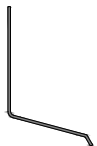
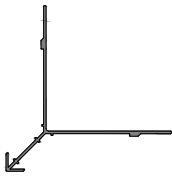
Confirm that the products delivered match items and quantities listed on the delivery docket.

JSC Flashings must be stored horizontally on fillets that are spaced to prevent excessive flexing of the flashings. Ensure that there are no sharp projections that may scratch the flashings.

It is best to store flashing in a dry, well-ventilated area.

If flashings are to be stored outside or in damp conditions the fillets should be placed on a waterproof cover. Storage is completed by covering with another waterproof cover. Ensure that the storage allows good airflow.

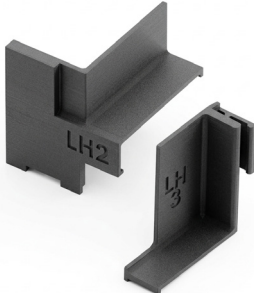
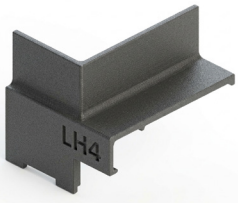
SYSTEM COMPONENTS

FLASHING CODE	PROFILE	DESCRIPTION
JSCFL-19		- Window Sill Flashing 5.85m long - Mill finish or powder coated black
JSCFL-23		- Door Sill Flashing 5.85m long - Mill finish or powder coated black
JSCFL-20		- Head Flashing - Part 1 5.85m long - Mill finish or powder coated black
JSCFL-12		- Head Flashing - Extension 5.85m long - Mill finish or powder coated black
JSCFL-21		- Inner Jamb Flashing 5.85m long - Mill finish or powder coated black
JSCFL-22		- Jamb Flashing - J42/TMT42 moulding 5.85m long - Mill finish or powder coated black
JSCFL-14		- Cavity closer - Head details 5.85m long - Mill finish or powder coated black
JSCFL-31		- Corner Flashing / Jamb Flashing 5.85m long - Mill finish or powder coated black
JSCFL-32		- Jamb Trim Flashing 5.85m long - Mill finish or powder coated black

SURFACE FINISH

Aro® Recessed Flashings are available powder coated in black or mill finished, allowing flashings to be matched to window and door joinery or other design elements. Dulux Duratec® powder coating is not suitable for use within 10 metres of the high tide mark or in strongly acidic or caustic environments (pH outside 5–9), or where flashings may be exposed to chemically treated water such as pool or spa environments.

For more information visit www.dulux.co.nz

STOP END CODE	PROFILE	DESCRIPTION
JSCHS-01		Head stop end set (2 pieces in total: 1 piece left-hand side and 1 piece right-hand side)
JSCSS-02		Window sill stop end set (4 pieces in total: 2 pieces left-hand side and 2 pieces right-hand side)
JSCDSS-04		Door sill stop end set (2 pieces in total: 1 piece left-hand side and 1 piece right-hand side)

RECESSED WINDOWS ACCESSORIES (NOT SUPPLIED BY JSC)

Wall Underlay (Flexible or Rigid)

- To comply with [E2/AS1 Table C.2.1.1](#) or
- Wall underlays covered by CodeMark or a BRANZ Appraisal used within the scope
- Installed and handled per manufacturer's specification

Flashing Tape

- To comply with [E2/AS1 Paragraph 4.2.12](#) or
- Product with a CodeMark or a BRANZ Appraisal used within the scope
- To be compatible with wall underlay

Flashing Fixings

- Materials to comply with [E2/AS1 Table C.1.1.1B](#) and [Table C.1.1.1C](#)
- Stainless steel

Other Fixings

- Any other fixing shall comply with [NZS 3604:2011](#) for timber framing

Bonding

- Stop ends are bonded to flashings using Sika Primer-3N, Sika Aktivator-205, and Sikaflex-11FC — refer to Appendix 2 for the full bonding procedure

INSTALLATION

TOOLS AND EQUIPMENT REQUIRED

Aro® Flashings are installed using general carpentry tools.

STEP A: BUILDING CONSENT AND USE

Where applicable, access and view building consent documentation.

Confirm scope of use by referring to the Aro® Flashing BPIR.

Access and view details in the building consent documentation or refer to this document.

STEP B: CHECK RELATED BUILDING WORK

PRIMARY STRUCTURE AND WALL UNDERLAY

Confirm the primary structure and wall underlay have been installed in accordance with the building consent (if applicable). Where the building work is existing, confirm that it is suitable for the installation of the Aro® Flashing System and associated joinery.

OPENING PREPARATION AND CREATION OF CAVITY

Ensure that the openings have been prepared in accordance with WANZ Guide to [Window Installation v1.7, 23/11/2022](#)

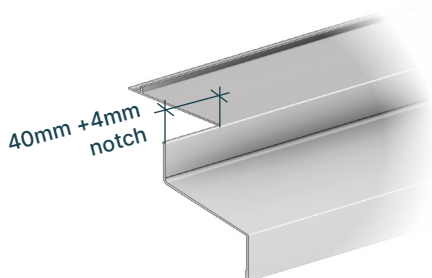
When creating cavity ensure that provision is made for cavity created from JSC 45mm cavity battens.

STEP C: PREPARE SILL AND HEAD FLASHINGS AND BOND STOP ENDS

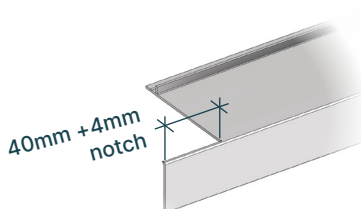
Cut the sill and head flashings and install the stopends at least 24 hours before fixing the flashings to the framing. This gives the stopend adhesive time to cure.

SILL FLASHING (JSCFL-19 / JSCFL-23)

- Cut to length: opening width + 88 mm total (40 mm each end + 4 mm notch each end).
- There are two types of sill flashings (window and door)

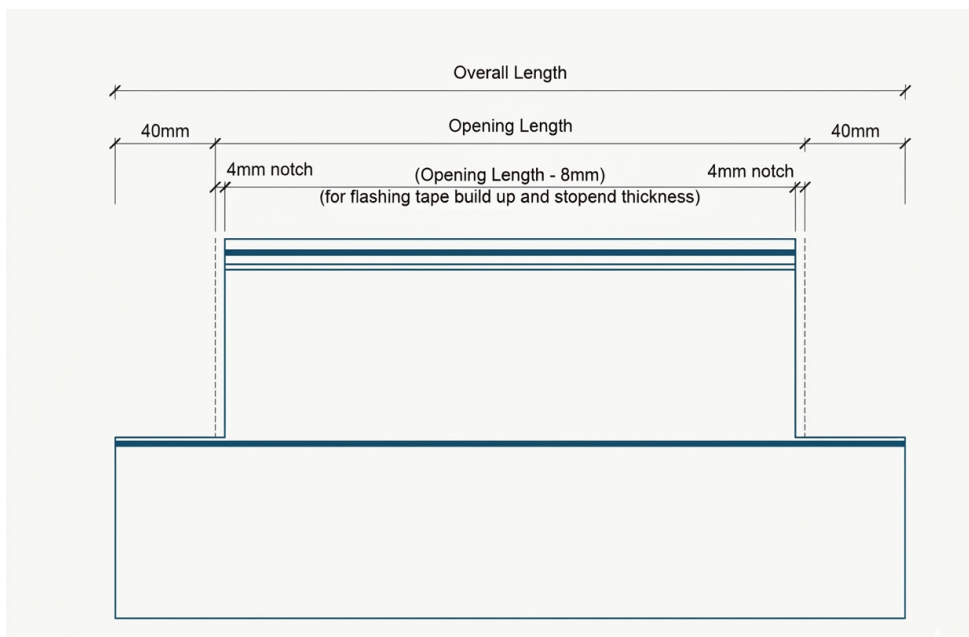


JSCFL-19 - Window sill flashing



JSCFL-23 - Door sill flashing

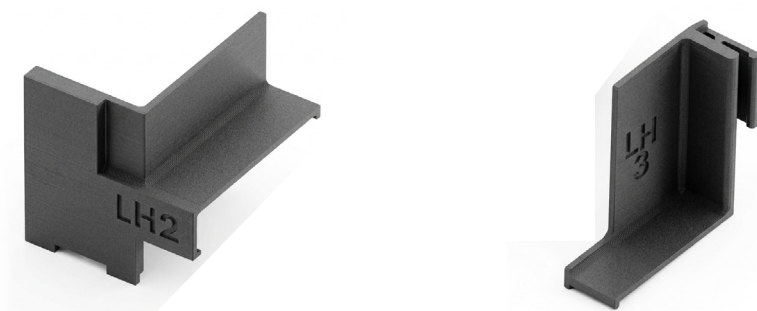
- Sill flashings to be a total of 44mm longer than the opening at each end of the flashing - 40 mm longer than the opening width an additional 4 mm notch.



- Ensure all cut edges are clean and free from burrs. Deburring cut edges must be carried out at this point to prevent damage to the flashing tape

FIT SILL FLASHING STOP-ENDS

There are two parts to each stop-end for window sill flashings. There are left-hand and right-hand stop-ends.



2 part Window sill stopends - Left-hand side

There is one stop-end for door sill flashings. There are left-hand and right-hand stop-ends.

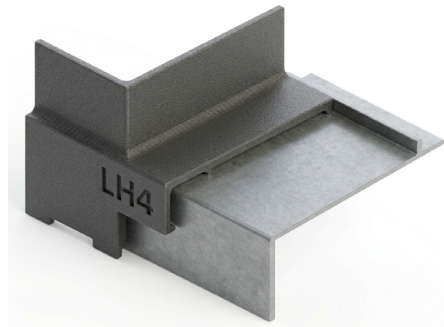


Door sill stopend - Left-hand side

Prepare and bond stop-ends to the sill flashing following the procedure in [Appendix 2 - Sika surface preparation, bonding & sealant](#)



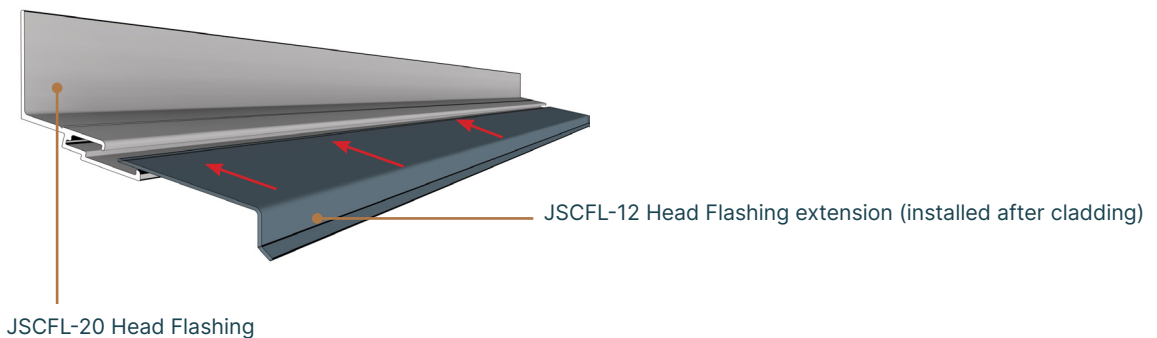
Window sill stop-ends - Left-hand side bonded to window sill flashing



Door sill stop-end - Left-hand side bonded to door sill flashing

HEAD FLASHING (JSCFL-20 / JSCFL-12)

- Cut to length
- There are two parts: the head flashing (JSCFL-20) and an extension (JSCFL-12)



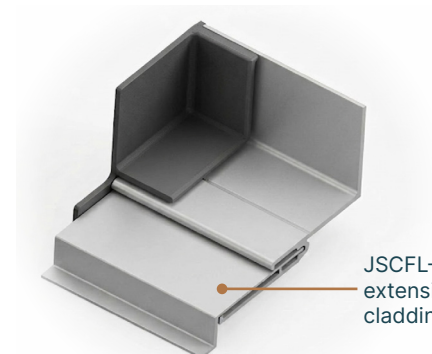
- Head flashing extension (JSCFL-12) is installed after cladding. Do not fix at this stage - see [Step L](#).
- The head flashings are used for both window and door openings.
- Head flashings are to be a total of 44 mm longer than the opening at each end of the flashing.
- Confirm head and sill cutting dimensions are the same.
- Ensure all cut edges are clean and free from burrs. Deburring cut edges must be carried out at this point to prevent damage to the flashing tape.

FIT HEAD FLASHING STOP-ENDS

There is one stop-end for head flashings. There are left-hand and right-hand stop-ends.



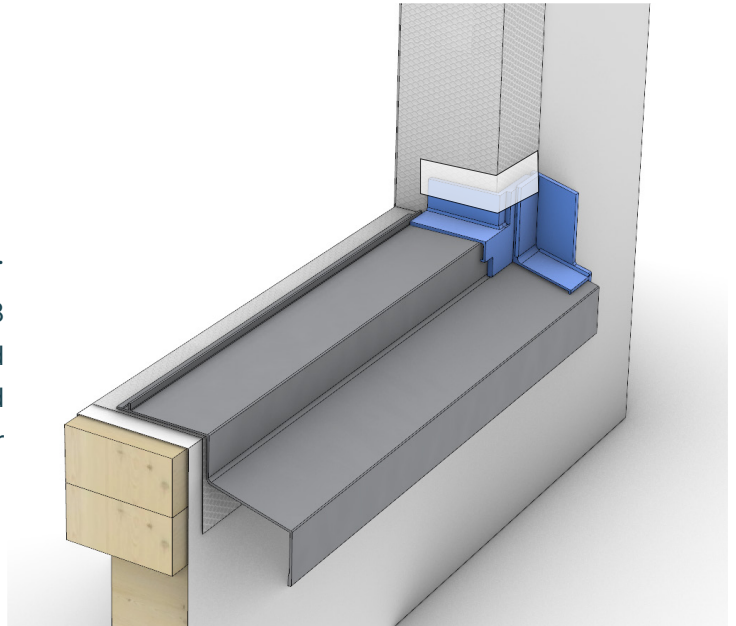
Head flashing stop-end - Left-hand side



Head flashing stop-end - Left-hand side bonded to head flashing

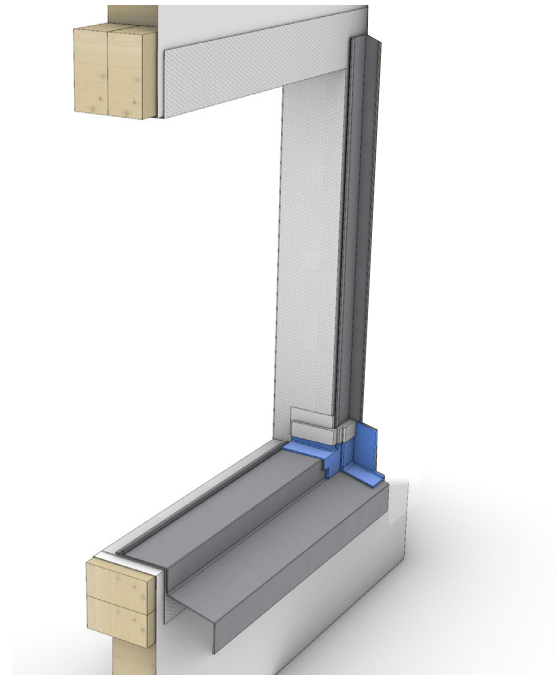
STEP D: FIX SILL FLASHING IN PLACE

- Install sill flashing to the framing with WURTH ASSY plus 4 A2 TH 40mm stainless screws partial thread top head 60° at 200mm centres.
- Tape over sill stopends with flexible flashing tape.
- Mark head flashing position on the framing: 6–8 mm above the window head flange. This mark is used to position the head flashing once joinery is installed. This allows for accurate cutting of the JSCFL-21 inner jamb flashing.
- Do not fix head flashing yet.



STEP E: CUT AND FIX INNER JAMB FLASHING

- Cut inner jamb flashing (JSCFL-21)
- Cut head at 15° to follow head flashing and sill at 90°.
- Ensure all cut edges are clean and free from burrs. Deburring cut edges must be carried out at this point to prevent damage to the flashing tape.
- Confirm there is a minimum 5mm joinery flange cover over the inner jamb flashing.
- Fix flashing to the framing with WURTH ASSY plus 4 A2 TH 40mm stainless screws partial thread top head 60° at 200mm centres.

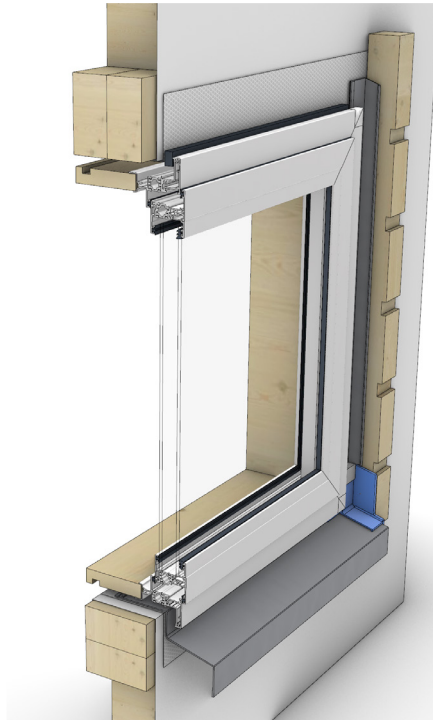


STEP F: INSTALL VERTICAL CAVITY BATTENS ON JAMBS

- Fix vertical cavity battens to both jambs.
- Batten must sit 10 mm from the inner flashing face and 40 mm from the jamb line.
- Machine cavity battens as required (5mm max.) to accommodate flashing depth.

STEP G: INSTALL WINDOW/DOOR JOINERY

- Place and fix window or door joinery in accordance with building consent or joinery supplier's instructions.
- No WANZ bar is required. The joinery is supported by the framing.
- Confirm there is a 10mm gap all around the opening.
- Install closed cell foam tape behind the top of the joinery.
- Check joinery flange fit: Flange sizes and thicknesses vary between manufacturers. Check fit on site and adjust flashing positions as needed. Critical dimensions:
 - » Joinery flange covers JSCFL-21 by minimum 5 mm
 - » Reveal depth must allow 7-8mm for flashing tape and stop-end buildup. Refer to JSC technical drawings.
 - » JSCFL-21 runs under the head flashing and above the sill flashing



STEP H: INSTALL HEAD FLASHING

- Fixing the JSCFL-20 head flashing 6 to 8mm above the window head flange.
- Fix flashing to the framing with WURTH ASSY plus 4 A2 TH 40mm stainless screws partial thread top head 60° at 200mm centres.
- Tape the head flashing in place.

STEP I: INSTALL CAVITY CLOSER

- Fix JSCFL-14 Cavity Closer above head flashing.
- Install horizontal cavity batten over Cavity Closer.
- Machine cavity battens as required (5mm max.) to accommodate flashing depth and build-up.



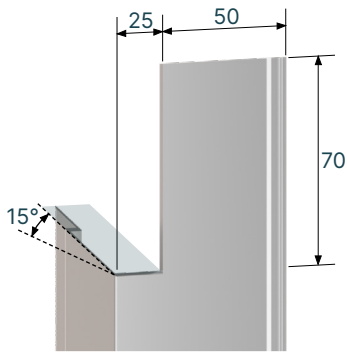
STEP J: CUTTING AND INSTALLATION OF OUTER JAMB FLASHINGS

JSC provides the option of a timber outer jamb flashing (JSCFL-22 + J42 timber moulding) and aluminium outer jamb flashing (JSCFL-31 + JSCFL-32).

TIMBER JAMB FLASHING

The aluminium flashing where a timber jamb is to be installed is JSCFL-22.

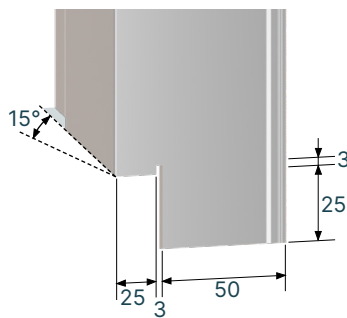
- Cut to length: bottom of head flashing to top of sill stop-end. Cut a 3×3 mm notch at the sill end.
- Refer to diagrams below for cut:



JSCFL-22 - Head cutting



JSCFL-22 - Head and sill cutting before fitting J42/TMT42



JSCFL-22 - Sill cutting



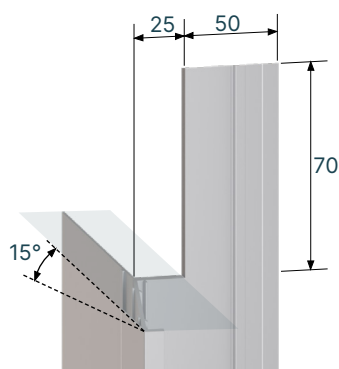
JSCFL-22 - Jamb Flashing

- Make sure at the head, the cut is at a 15° angle to create a snug fit under head flashing. A 15° angle is also required at the sill cutting to ensure a close fit over sill flashing.
- Ensure all cut edges are clean and free from burrs. Deburring cut edges must be carried out at this point to prevent damage to the flashing tape.
- Predrill and reverse-fix the J42/TMT42 moulding to the JSCFL-22 flashing. The J42/TMT42 must be both adhesive-fixed using Sikaflex - 11FC and mechanically reverse-fixed at 600mm crs.
- Fix the assembled JSCFL-22 and J42/TMT42 to vertical cavity battens using WURTH ASSY plus 4 A2 TH 40mm stainless screws partial thread top head 60° at 200mm centres.

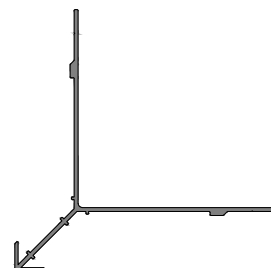
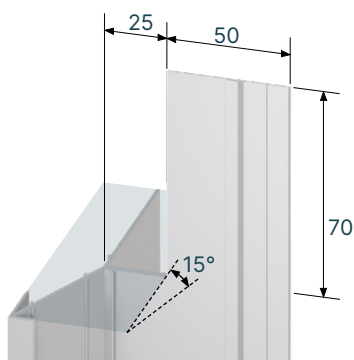
ALUMINIUM JAMB FLASHING

The aluminium flashing where an aluminium jamb is to be installed is JSCFL-31.

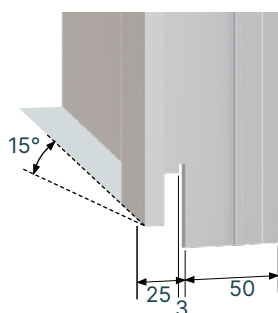
- Cut to length.
- Refer to diagrams below for cut:



JSCFL-31 - Head cutting



JSCFL-31 - Jamb Flashing



JSCFL-31 - Sill cutting



- Make sure at the head, the cut is at a 15° angle to create a snug fit under head flashing. A 15° angle is also required at the sill cutting to ensure a close fit over sill flashing .
- Ensure a 3×3 mm notch at each piece. This ensures the flashing fits neatly around the stop ends and provides a precise trim.
- Refer to the diagrams for the cutting dimensions and notch placement. Use these diagrams to verify your measurements before trimming.
- To help with the cut of JSCFL-31, we have developed top and bottom cut templates. Place the appropriate template to the JSCFL-31 flashing, trace the outline with a pencil and cut.



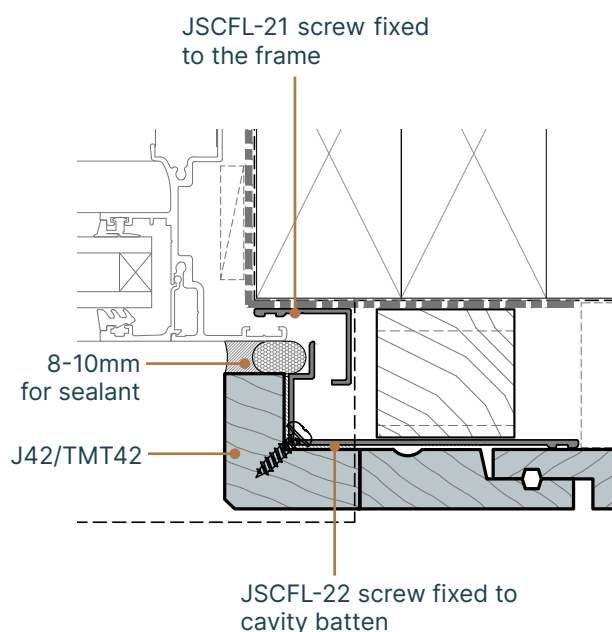
Template to cut bottom right of JSCFL-31 flashing



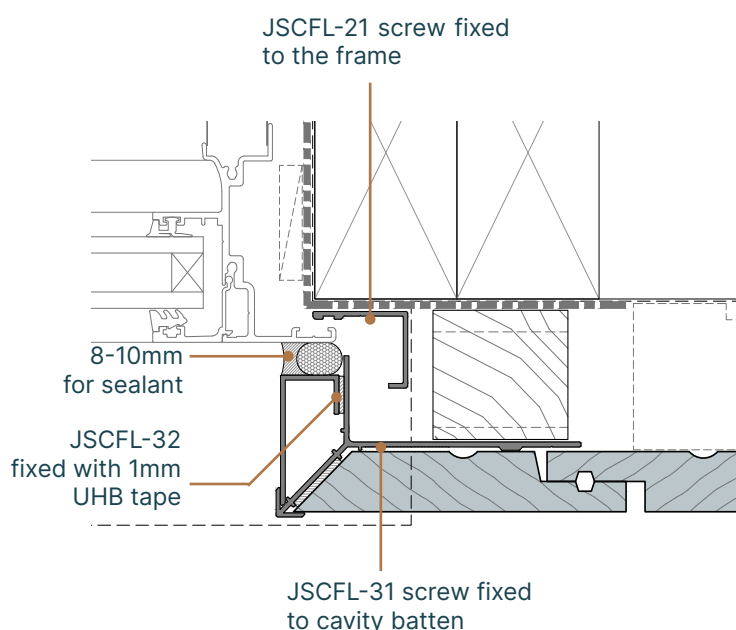
Template to cut top right of JSCFL-31 flashing

- Ensure all cut edges are clean and free from burrs. Deburring cut edges must be carried out at this point to prevent damage to the flashing tape.
- Fix the flashing to vertical cavity battens using WURTH ASSY plus 4 A2 TH 40mm stainless screws partial thread top head 60° at 200mm centres.

TIMBER JAMB (J42/TMT42)



ALUMINIUM JAMB (JSCFL-32)



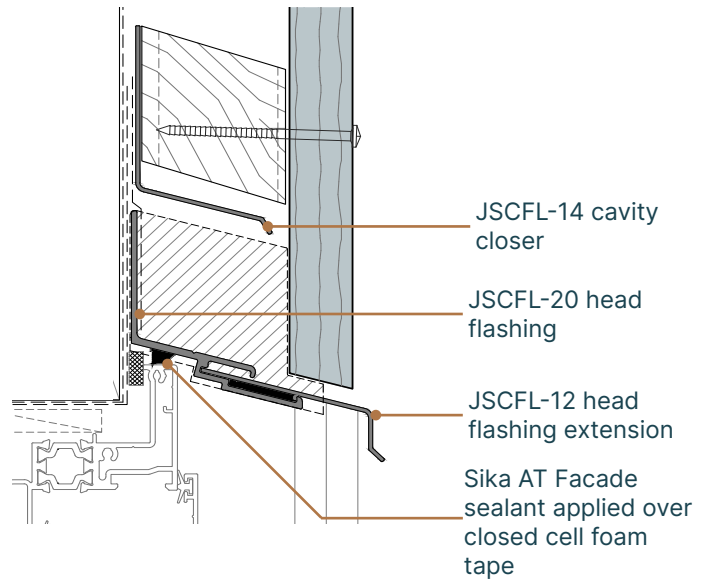
NOTE: Joinery units may vary. You may need to trim the J42/TMT42 or JSCFL-32 profiles to achieve the required 8-10 mm sealant gap.

STEP K: INSTALL CLADDING

- Plan board layout before installing cladding:
 - VertiClad: work out the layout so a full board lands on the starting jamb.
 - RustiClad: work out the layout so a full board lands at the head flashing line.
- Install JSC VertiClad or RustiClad weatherboards per installation instructions.
- VertiClad: mechanically fix the first board at the jamb. Pre-drill the weatherboard and pre-drill the flashing (JSCFL-22 or JSCFL-31).
- RustiClad: do not penetrate the jamb flashing (JSCFL-22 or JSCFL-31). Every board would otherwise require a penetration, resulting in too many penetrations along the flashing. Instead, install a second vertical cavity batten to fix the boards to. Refer to details RC12-RW, RC13-RW, RC14-RW and RC15-RW.

HEAD DETAIL

- Install head flashing extension (JSCFL-12) with a continuous bead of Sikaflex-11 FC.
- Apply Sika AT Facade over the closed cell foam tape on the head flashing detail.



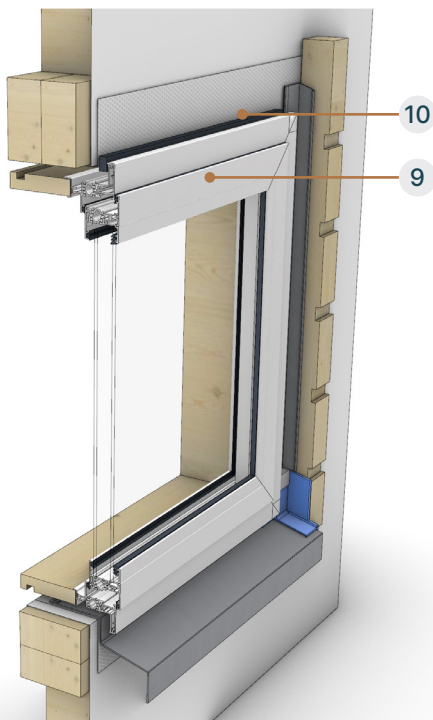
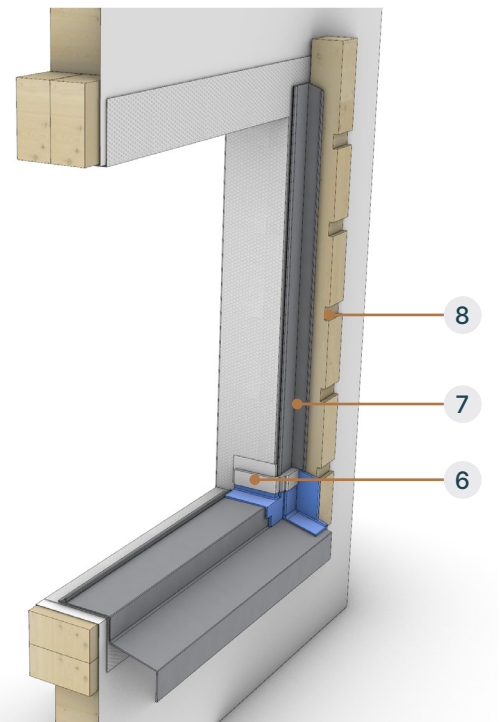
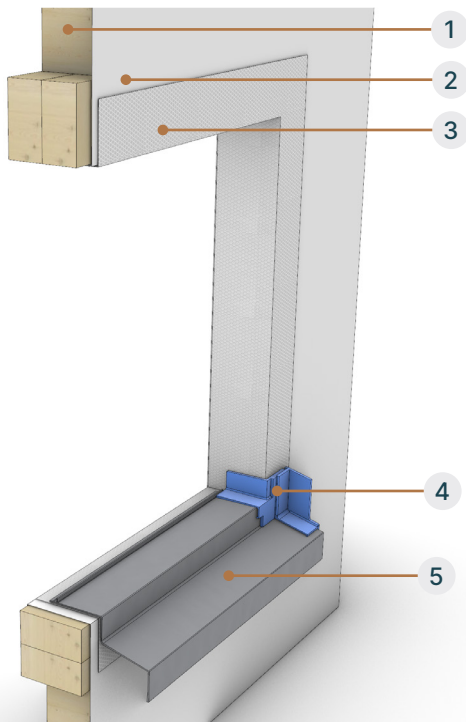
Window/Door head detail

JAMB DETAIL

- If using the aluminium jamb finish, cut JSCFL-32 to measure and fix it with UHB 1mm tape.
- Apply Sika AT Facade over PEF rods at jambs.
- Refer to [page 12](#) for jamb section details.

Before applying the sealant, clean the surfaces with Sika Aktivator-205. Once dried, apply Sika Primer - 3N to the flashings.

INSTALLATION SEQUENCE

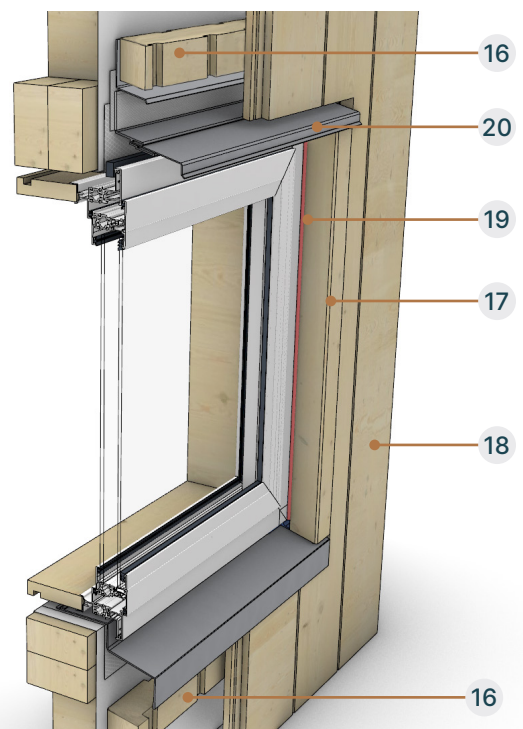
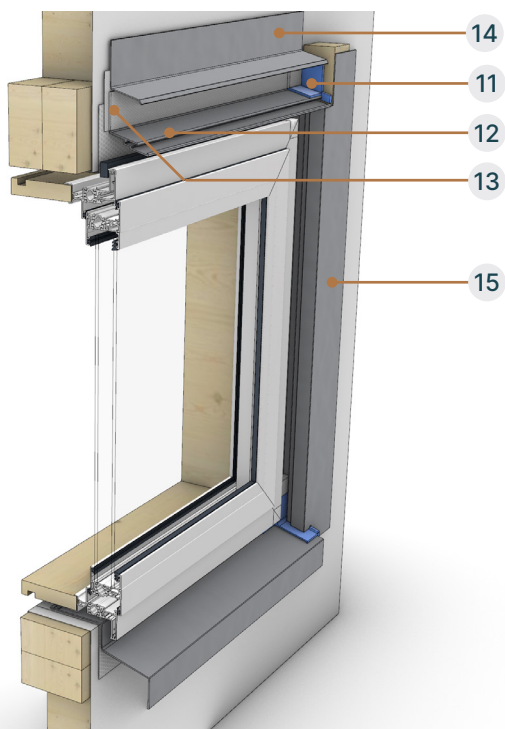


SEQUENCE

- 1 Framing
- 2 Wall underlay
- 3 Flexible Flashing tape
- 4 2-part ASA plastic stopends, sealed to sill flashing (refer to bonding instructions)
- 5 JSCFL-19 Sill Flashing
- 6 Flexible Flashing tape
- 7 JSCFL-21 Inner Jamb Flashing
- 8 Install Vertical Cavity Batten on opening jambs
- 9 Install window joinery per manufacturer's instructions
- 10 Install closed cell compressible foam tape at the back of the joinery on head detail

Steps 1–10 are common to both timber and aluminium jamb installations.
Continue with items 11–20 for the relevant detail below.

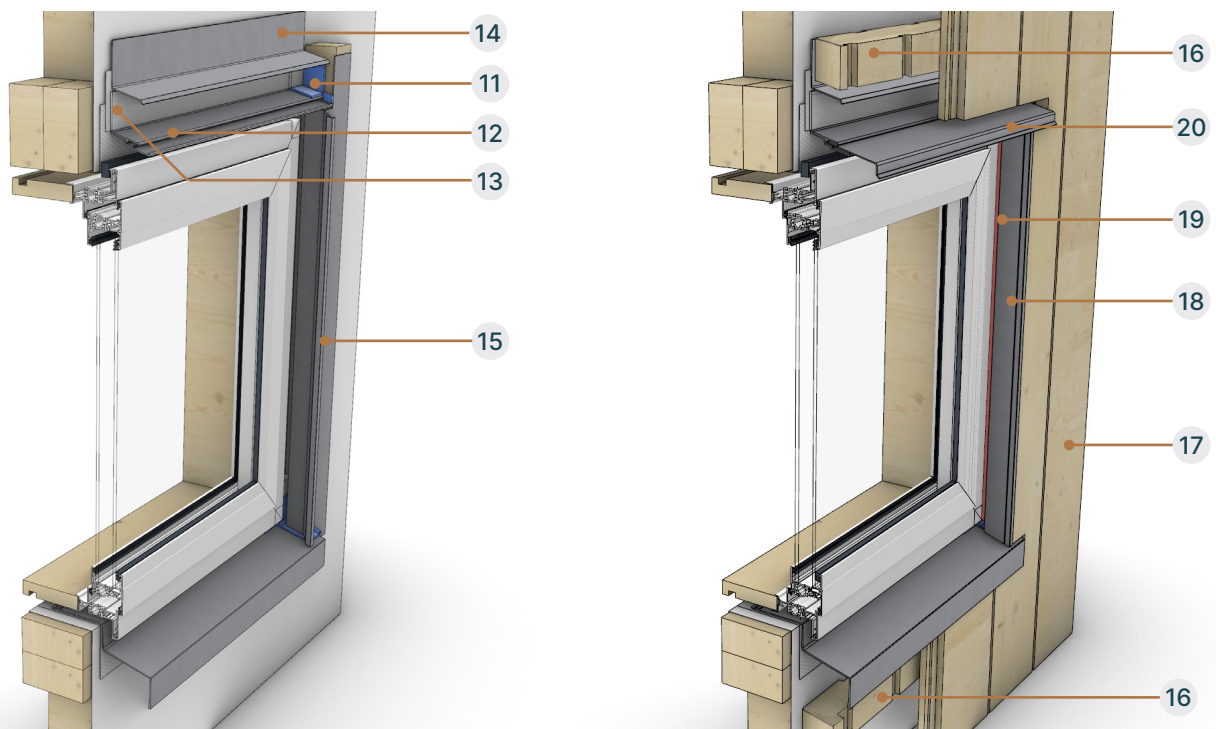
TIMBER JAMB DETAIL



SEQUENCE

- 11 Proprietary ASA Plastic stopend, sealed to head flashing
- 12 JSCFL-20 Head Flashing
- 13 Flexible Flashing tape
- 14 JSCFL-14 Cavity Closer
- 15 Cut and dry fit JSCFL-22 Jamb Flashing – do not fix in place yet
- 16 Horizontal Cavity Battens
- 17 Cut and reverse fix J42 Corner Timber Trim to JSCFL-22 Jamb Flashing. Fix Flashing in place
- 18 Install Cladding
- 19 Sikaflex AT Facade over PEF Rod
- 20 JSCFL-12 Head Flashing extension fixed with continuous bead of adhesive Sikaflex 11FC

ALUMINIUM JAMB DETAIL



SEQUENCE

- | | |
|---|--|
| <ul style="list-style-type: none"> 11 Proprietary ASA Plastic stopend, sealed to head flashing 12 JSCFL-20 Head Flashing 13 Flexible Flashing tape 14 JSCFL-14 Cavity Closer 15 JSCFL-31 Arrow Mitre Corner Flashing | <ul style="list-style-type: none"> 16 Horizontal Cavity Battens 17 Install Cladding 18 JSCFL-32 Jamb Flashing fixed with 1mm UHB tape 19 Sikaflex AT Facade over PEF Rod 20 JSCFL-12 Head Flashing extension fixed with continuous bead of adhesive Sikaflex 11FC |
|---|--|

FOR TECHNICAL DRAWINGS & OTHER CLADDING RELATED DOCUMENTS

See our full set of detailed information.

Scan the QR code to access the related website page.

[Recessed Windows webpage](#)



This information is to be read in conjunction with the Recessed Window Technical Details and the Rusticlad and Verticlad System Installation Guidelines.

Disclaimer: JSC provides this installation guide to assist builders in installing the Aro® Recessed Flashing System correctly. It is the installer's responsibility to ensure that any third-party accessories or components not supplied by JSC are suitable for the intended application. Where uncertainty exists, contact JSC technical support at TechHelp@jsc.co.nz.

APPENDIX 1

DRAWINGS LIST

The following details are available on the JSC website:

DETAIL NUMBER	DETAIL TITLE
VS10-RW	VertiClad Recessed Window Head Detail
VS11-RW	VertiClad Recessed Window Sill Detail
VS12-RW	VertiClad Recessed Door Sill Detail
VS13-RW	VertiClad Recessed Window Jamb Right Hand Detail - Aluminium
VS14-RW	VertiClad Recessed Window Jamb Left Hand Detail - Aluminium
VS15-RW	VertiClad Recessed Window Jamb Right Hand Detail - Timber J42/TMT42
VS16-RW	VertiClad Recessed Window Jamb Left Hand Detail - Timber J42/TMT42
RC10-RW	RustiClad Recessed Window Head Detail
RC11-RW	RustiClad Recessed Window Sill Detail
RC12-RW	RustiClad Recessed Window Right Hand Jamb Detail - Aluminium
RC13-RW	RustiClad Recessed Window Left Hand Jamb Detail - Aluminium
RC14-RW	RustiClad Recessed Window Right Hand Jamb Detail - Timber J42/TMT42
RC15-RW	RustiClad Recessed Window Left Hand Jamb Detail - Timber J42/TMT42

APPENDIX 2

SIKA SURFACE PREPARATION, BONDING & SEALANT

This section must be read in conjunction with the relevant Sika product data sheets and Sika Method Statement. Where product data sheets conflict with this guide, the Sika documentation takes precedence.

PRODUCT	ROLE IN THE SYSTEM
Sika Aktivator-205	Cleans and activates powder-coated aluminium flashings before bonding or sealing
Sika Primer-3 N	Primes ASA plastic stop ends before adhesive bonding
Sikaflex-11 FC	Structural adhesive — bonds stop ends to aluminium sill and head flashings
Sikaflex AT Facade	Weather sealant — joinery flange joints at jambs and head, applied over backer
Sika Remover-208	Removal of uncured adhesive and sealant traces only

SURFACE PREPARATION

SURFACE 1: ASA STOPENDS (SIKA PRIMER-3 N)

- Surfaces must be clean, dry, free from contaminants. Lightly abrade bonding face with polyester scouring pad; remove all dust.
- Apply Sika Primer-3 N to bond line with a clean brush. Dry: min 30 min, max 8 hr.

SURFACE 2: POWDER COATED ALUMINIUM FLASHINGS (SIKA AKTIVATOR-205)

- Wipe bond area with Sika Aktivator-205 on a clean lint-free rag; wipe off immediately with a separate rag. Change rags frequently.
- Dry: min 10 min, max 2 hr.
- Apply low-tack masking tape around the bond area to protect the powder-coat finish.

BONDING STOPENDS TO FLASHINGS (SIKAFLEX-11 FC)

- **MARK & MASK:** Trace stop end outline on flashing. Apply low-tack masking tape around perimeter.
- **APPLY ADHESIVE:** Apply triangular bead of Sikaflex-11 FC to flashing bond line (8mm wide × 10mm high).
- **ASSEMBLE:** Position stop end within 10 minutes. Press firmly and clamp.
- **CLAMP & CURE:** Maintain clamping pressure until cured.
- **FIX & CLEAN:** Once cured, fix flashing to framing. Remove uncured adhesive with Sika Remover-208 only.

NOTES:

- Assemble within 10 minutes of applying Sikaflex-11 FC. Refer to product data sheet for cure schedule.
- Stop-end bonding must be fully cured before flashings are fixed to framing. Prepare and bond stop-ends in advance.

SEALANT APPLICATION (SIKAFLEX AT FACADE)

- **PREPARE SURFACES:**
 - » Clean with Sika Aktivator-205 (min 10 min dry).
 - » Prime joinery flanges.
 - » Mask both sides.
- **INSTALL BACKER:**
 - » Head: closed-cell foam tape behind head flange.
 - » Jambs: PEF rod 8–10mm.
 - » Joint width 8–10mm; sealant depth 6–8mm.
- **APPLY & TOOL:**
 - » Apply continuous bead of AT Facade over backer.
 - » Tool immediately to smooth concave profile.
- **FINISH:**
 - » Remove masking tape before sealant skins. Inspect for continuity (no gaps, voids, or bridging).

DESCRIPTION	CRITICAL DIMENSIONS
Joinery flange cover over JSCFL-21 inner jamb flashing	5mm min.
Stop-end setback from joinery opening	25mm min. - 40mm
AT Facade sealant joint width at jambs	8mm min. – 10mm
AT Facade sealant depth (controlled by backer)	6mm min. – 8mm
Sika Primer-3 N drying time	30 min. min.
Sika Aktivator-205 drying time	10 min. min.
Sikaflex-11 FC: assemble after application	Within 10 min.
Clamp removal after Sikaflex-11 FC bonding	~24 hr

This guide provides installation guidance for the Aro® Recessed Flashing System. All Sika product application procedures, surface preparation requirements, drying times, and application parameters must be read in conjunction with the current Sika product data sheets and Sika Method Statement for this system. Where any conflict exists between this guide and Sika's technical literature, Sika's documentation takes precedence. Current Sika NZ product data sheets are available at nzl.sika.com.



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