

650 **Patio Door**

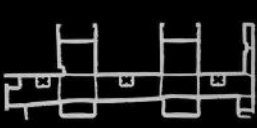
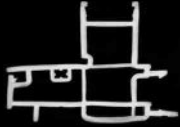



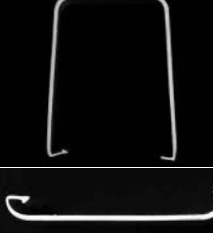


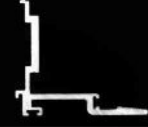

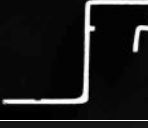

Assembly Instructions





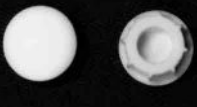






Standard/Non-Impact & Impact








IMPRESS THE WEATHER

PARTS



1.		Vinyl two-track main frame.
Frame (Head, Sill, and Jamb)		
2.		Additional vinyl tracks that can be added onto the main frame.
Adapters		
3.		Vinyl track cover. To cover installation holes.
Track Covers		
4.		Aluminum extrusions that snap into the track on the sill for panels to roll on.
Roller Tracks		
5.		Aluminum piece used at the center of bi-parting doors.
Astragal		
6.		Interior and exterior covers for the aluminum astragal.
Astragal Covers		
7.		Aluminum extrusion that snaps over the interior wall of the sill.
Sill Riser		
8.		Used for pocket door installation, interlocks panels to the wall.
Pocket Hook (P-Hook)		
9.		Aluminum extrusion attached to sash to lock panels together.
Interlock		
10.		Vinyl piece that covers aluminum interlock and hurricane clip on the side of the panel.
Interlock Cover		
11.		Installed between the side of the fixed panel and the jamb.
Fixed Panel Jamb Spacer		
12.		Attaches to all operable panels.
Element Handle		

13.		Attach to jambs, allow panels to lock to the frame.
Keeper		
14.		Vinyl snap in covers for the weep holes on the exterior of the sill.
Weep Hole Covers		
15.		Foam sticker applied to the end of head and sill to seal between jambs.
Frame Corner Gasket		
16.		Foam sticker applied to the end of head and sill ADAPTERS to seal between jambs.
Adapter Corner Gasket		
17.		Vinyl plug used to cover the roller adjustment holes after panel installation.
Roller Adjustment Covers		
18.		Weather strip pads used on the top and bottom of frame.
Weather Strip Pads Frame		
19.		Weather strip pads used on the door panel.
Weather Strip Pads Panel		
20.		Aluminum bracket attached to the top and bottom of each interlock.
Hurricane Clip		
21.		Used to engage multiple panels while only operating one panel.
Bumper		
22.		Only used for pocket door installation.
Pocket Door Stop		
23.		Standard door screen track for 2-panel doors.
Standard Door Screen Track		

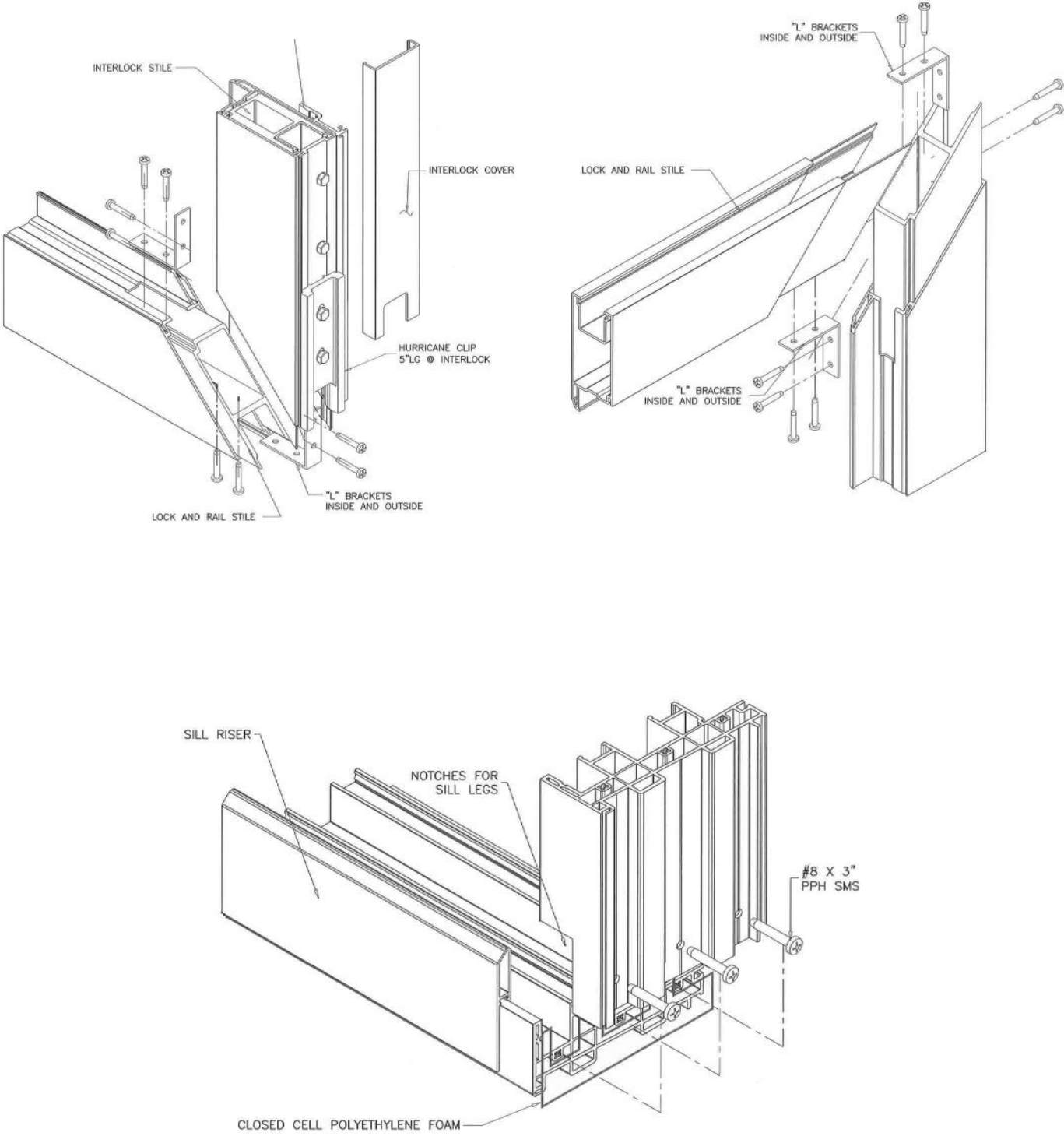
SCREWS

24.		Screws used to attach jambs to head and sill (#8 3" Truss head).
Frame Assembly Screws		
25.		Screws used to secure the adapters to the main frame, and attaching flashing flanges (#8 5/8" Pan head).
Frame Adapter Screws & Flashing Flange		
26.		Screws used to attach keeper to jambs (#8 1-1/4" Flat head), used for fixed panel, and pocket stop.
Keeper, Fixed Panel and Pocket Stop Screw		
27.		Screws used to attach the bumper (#8 1" Pan head).
Bumper Attachment Screws		
28.		Screws used to attach astragal to the side of the panel (2" Hex head).
Astragal Screws		

FLASHING FLANGE PARTS

29.		Use only the supplied silicone for installation. It is used to attach the flashing flange to the door frame. If replacement is needed, use a high quality exterior grade silicone, preferably white and compatible with vinyl. DOW is recommended, or an approved equivalent.
White Silicone Sealant		
30.		An accessory option to assist in creating a weatherproof seal between the door frame and building structure.
Flashing Flange		
Part 25 - Frame Adapter & Flashing Flange Screw. See Chart above.		

EXPLODED VIEW



PANEL INSTALLATION CHART

Full Frame Options

Key: X = Operable O = Fixed
Always begin installation with inner most panel and work towards exterior panel.

2P2T

INTERIOR

EXTERIOR

2P2T-XX

INTERIOR

EXTERIOR

2P2T-XXR

INTERIOR

EXTERIOR

2P2T-OX

INTERIOR

EXTERIOR

2P2T-XOR

3P2T

INTERIOR

EXTERIOR

3P2T-OXOL

INTERIOR

EXTERIOR

3P2T-OXOR

3P3T

INTERIOR

EXTERIOR

3P3T-XXX

INTERIOR

EXTERIOR

3P3T-XXXR

INTERIOR

EXTERIOR

3P3T-XXO

INTERIOR

EXTERIOR

3P3T-OXXR

4P2T

INTERIOR

EXTERIOR

4P2T-XX-XX

INTERIOR

EXTERIOR

4P2T-OX-OX

4P4T

INTERIOR

EXTERIOR

4P4T-XXXX

INTERIOR

EXTERIOR

4P4T-XXXXR

INTERIOR

EXTERIOR

4P4T-XXXO

INTERIOR

EXTERIOR

4P4T-OXXXXR

Pocket Options

2P2T

INTERIOR

EXTERIOR

2P2T-PXX

INTERIOR

EXTERIOR

2P2T-XXPR

3P3T

INTERIOR

EXTERIOR

3P3T-PXXX

INTERIOR

EXTERIOR

3P3T-XXXPR

4P2T

INTERIOR

EXTERIOR

4P2T-PXX-XXP

4P4T

INTERIOR

EXTERIOR

4P4T-PXXXX

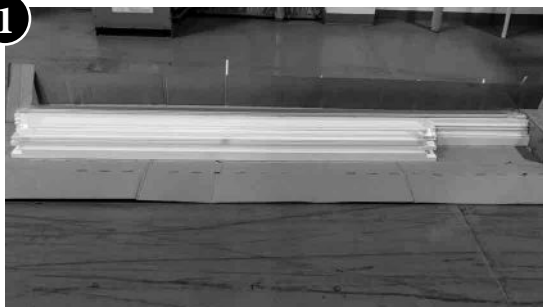
INTERIOR

EXTERIOR

4P4T-XXXXPR

SECTION 1: FRAME ASSEMBLY

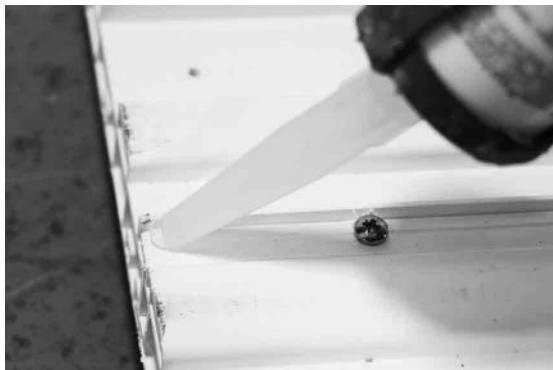
1



Locate all frame parts
(Part 1, Head/sill/jambs).

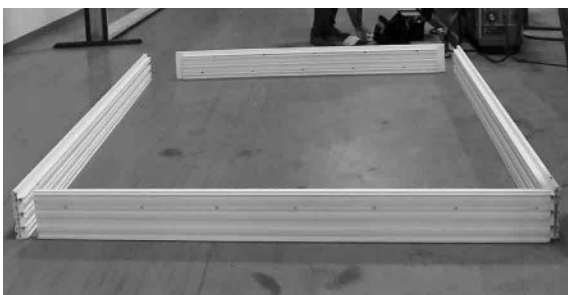
IMPORTANT: If the door is more than two tracks, locate the frame adapters (Part 2) first and correctly match them to the corresponding frame parts.

Three or More Tracks



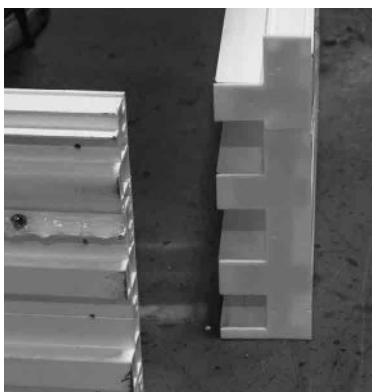
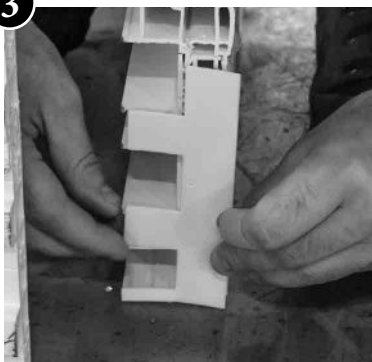
D. Apply a bead of sealant over the top of screw heads at adapter joints around the frame.

2



Set the frame (Part 1) on a leveled surface with the exterior facing up and line up all four corners.

3



Apply foam gaskets (Part 15) to the ends of the **HEAD** and **SILL**, and track **ADAPTERS** (Part 16) if needed.

4



Securely attach the **HEAD** and **SILL** to the **JAMBS** using the screws provided (Part 24) through the pilot holes. Make sure that the track on jambs lines up with head/sill for smooth operations.

IMPORTANT: DO NOT over tighten screws.

SECTION 1: FRAME ASSEMBLY

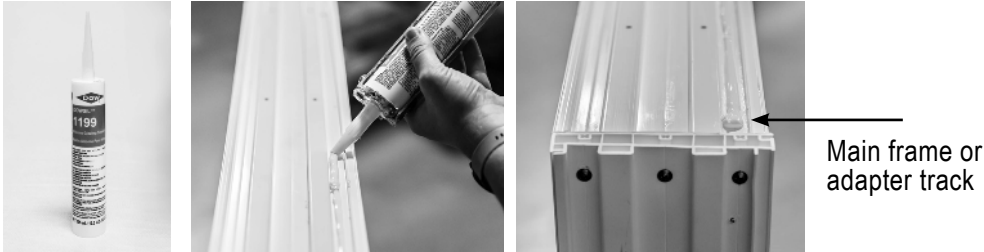
Installing Flashing Flange

If using a Flashing Flange, attach the flanges after completing Frame Assembly steps 1–4 but before installing the unit.

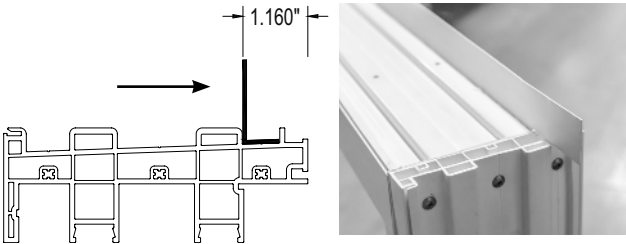
- 1 Install Head Flange first, Jamb Flanges second



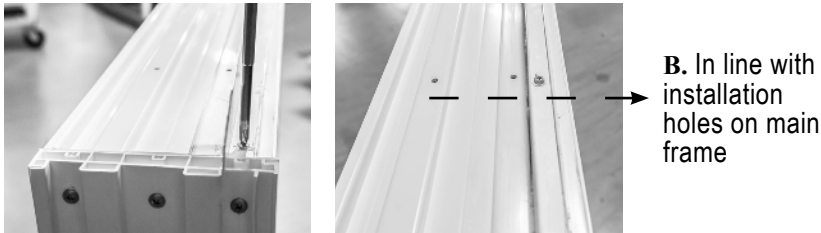
- 2 Apply 1/4" bead of white silicone (supplied) in Flange track of Main Frame or Adapter Track



- 3 Place Flange in track (orientation is optional, but manufacturer suggestion is as shown)



- 4 Affix Flange with #8 - 5/8" Phillips Head screws provided (part 25) at the following positions



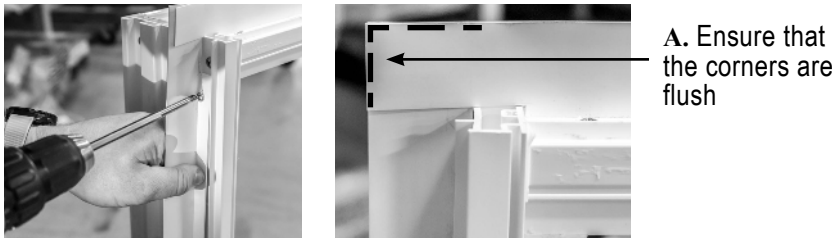
A. 2" from each corner

- 5 Dry fit the Jamb Flange into the track to ensure proper fit

IMPORTANT: For proper water diversion, Head Flange must overlap in front of the Jamb Flange

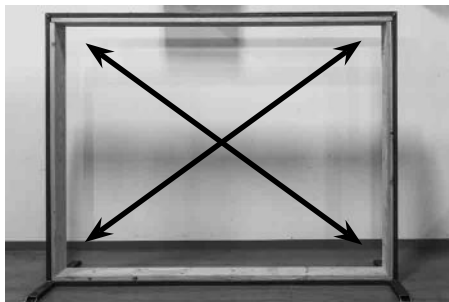
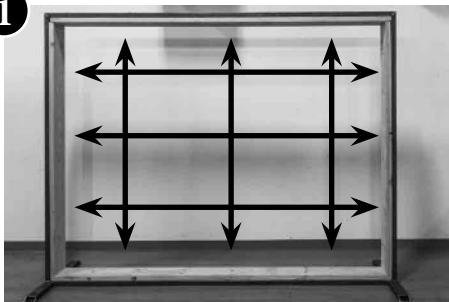


- 6 Follow steps 2-5 for each Jamb Flange, being sure to match the orientation of the Head Flange

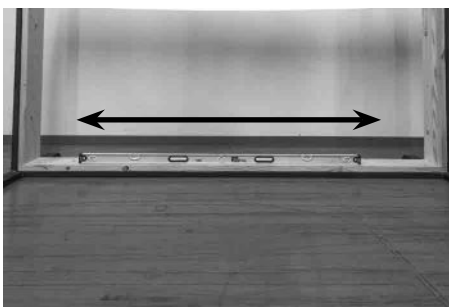


SECTION 2: FRAME INSTALLATION

1



VERY IMPORTANT:
Check the height and width
in three locations each way
to be sure the measurement
is correct.



VERY IMPORTANT: Prepare the rough opening for the frame, measure to ensure the opening is the proper size, and the sill is level. Measure the assembled frame to make sure that the size is accurate.

*****INSTALLING A SILL PAN IS REQUIRED.**

2



**VERY IMPORTANT: INSTALLATION OF THE FRAME MUST
BE IN COMPLIANCE WITH LOCAL BUILDING CODES.**

Carefully move the frame into the rough opening, the frame should fit freely.

IMPORTANT: DO NOT force the frame into the opening. If the frame is tight, be sure to clear any debris from the opening and make sure that the frame is the correct size before continuing.

3

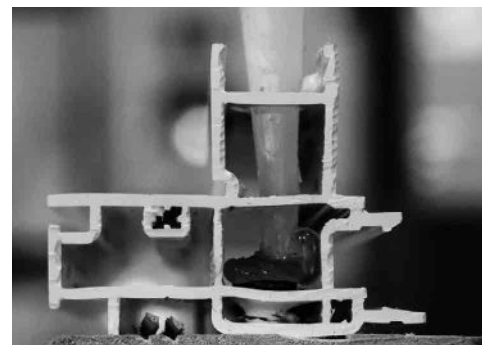


Once frame is in place, shim around it to make it plumb, level, and square. Check to make sure sill is level across tracks interior to exterior, and measure the height and width at three locations to ensure the opening is square. Attach the frame to the rough opening using the installation screws in all installation holes.

4



Apply sealant over the head of each installation screw in the sill to ensure water cannot penetrate through the frame.



SECTION 3: PANEL INSTALLATION

Operable Panels



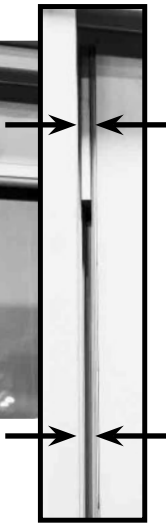
Install the roller tracks (Part 4) into the frame using a rubber mallet and a flat head screwdriver. Ensure the roller track snaps in and is installed correctly into the frame where panels will be operable.



Adjust the rollers to the lowest position (rotating counterclockwise) to make it easier for installation.



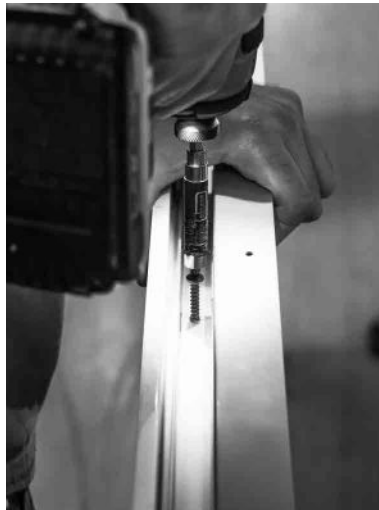
Lift the top of the panel into the head of the frame so the top of the panel engages the top track. Lift up and swing the bottom of the panel onto the correct track so the rollers are engaged with the track.



Adjust the rollers **UP** to a raised position (rotating clockwise) so the top of the panel is engaged with the head of the frame and the panel is level with even reveal along the jambs.

Fixed Panels

1



Attach the fixed panel spacer using screws provided (Part 26) starting 6" from either end, then center, then center again (5 screws total).

Pre-drilling the panel is recommended.

2



Install the panel into the correct track with the fixed panel installation leg to the interior of the door (not with O-XO). Slide the panel all the way to the jamb it will be fixed to.

3



Adjust the rollers to make sure the panel is level and has an even reveal from top to bottom of the jamb.

4



Attach the fixed panel spacer using screws provided (Part 26) starting 6" from either end, then center, then center again (5 screws total).

Fixed panel spacers can be painted to match door color on exposed surfaces. Be sure to pre-drill holes in the spacer prior to painting.

SECTION 4: ADDITIONAL OPTIONS

Installing Pocket Hook

- 1 If pocket application is being used, a Pocket Hook or P-Hook (Part 8) will be supplied.
- 2 Prior to installation of P-Hook, close all the panels and set the lock and keeper.
- 3 With the lock/keeper engaged, push all of the panels to the closed/interlocked positions and insert the P-Hook between the exterior of the rough opening and the interlock on the last panel.
IMPORTANT: Be sure that the interlock on the last panel is engaged with the P-Hook.
- 4 While pushing the P-Hook (Part 8) into the interlock (Part 9), mark the gap between the wall and the P-Hook at top and bottom.
- 5 Unlock the door and push completely open past the P-Hook
(Make sure not to open too far to disengage panel from the frame).
- 6 Install the P-Hook into the rough opening using the #12 - 1-1/2" screws provided (Part 26) through the pre-drilled holes (6" from top and bottom, then center, and middle of center, 5 screws total).
- 7 Ensure the last panel engages with the P-Hook. At this point adjust (as necessary) the rollers for each panel to ensure proper fit. Starting from the P-Hook working towards the locking panel. Re-adjust the lock and keeper if necessary.

SECTION 4: ADDITIONAL OPTIONS

Installing Astragal

IMPORTANT: Be sure all height adjustments have been made to the panel prior to installation of an astragal.

- 1** If an astragal (Part 5) is supplied it will be attached to the non-locking operable panel
Viewed from the exterior: astragal will attach to left panel.

- 2** The astragal should be oriented with the thick tube to the exterior and flat side to interior.

- 3** **IMPORTANT:** If the door is a **BI-PARTING POCKET DOOR** the astragal should be flipped, with the thicker tube on the interior.



Slide or snap on the vinyl covers (Part 6) for the astragal before attaching to the panel.

***NOTE:** Add caulk or other type of adhesive to vinyl covers, this will help the covers adhere to the astragal.



Place the bottom of the astragal down over top of the track that the panel is engaged on. Swing the top of the astragal under the head and line up the astragal along the side of the panel.



Lay a 3/16" drill bit under the astragal at the groove that straddles the sill tower. This will keep the astragal above the frame while you are drilling it to the panel and will make sure the aluminum doesn't damage the vinyl while operating.



Using screws provided (Part 28), attach the astragal to the side of the panel using the pre-drilled holes.



Attach the keeper (Part 13) to the tower using screws provide (Part 26).



Use vinyl track covers (Part 3) to cover up the astragal track tower and screw holes.

Add handle on astragal panel first. The handle installed on the astragal panel should follow the fixed (inactive) panel instructions.

SECTION 5: HARDWARE

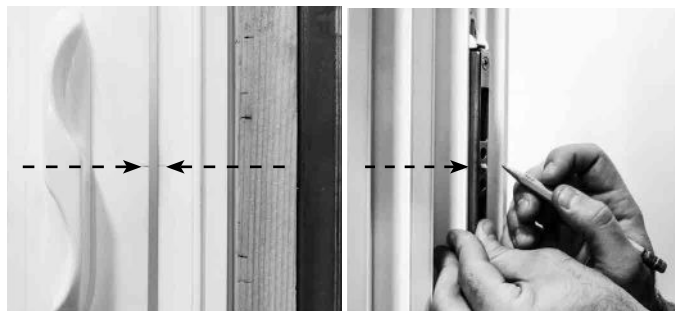
Handles

- 1 See detailed handle instructions included box (Part 12).
IMPORTANT: Operable handle should follow active panel instructions.
Astragal panel should follow the fixed (inactive) panel instructions.

2 Keepers (Part 13)



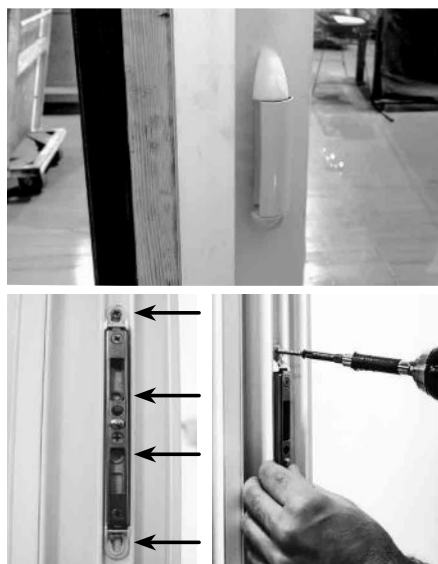
A. Line up operable panel next to the locking jamb making sure to align the keeper with the lock on the panel.



B. Mark the location on the jamb and install the strike to the door jamb.



C. First, attach two adjustable screws check alignment of the lock to the keeper and make any height adjustments that are needed.



D. After making sure the panel locks properly you can secure the keeper with all 4 screws provided (Part 26).

NEW Element Handle

We have redesigned the patio door handle, and will no longer be using the handle pictured above.

The new patio door handle contains a proprietary locking system and has a modern look. It also uses the same punch settings and can easily replace old handles on existing doors.

There will be additional instructions included in the handle door kit (Part 12).



NEW Interior and exterior door handle views.

3 Hurricane clips (Part 20) - Interlock Cover (Part 10)

Hurricane clips will come installed on panels, they will need to be adjusted for final assembly.



A. Loosen the screws holding the clip on to the panel, slide clips up so they extend no more than .1875"-.25" beyond the end of the interlock/panel.



B. Retighten screws with the clip in its final place.

IMPORTANT: DO NOT allow the clips to dig into the head or Sill. If the clip is touching any part of the frame it should be brought in closer to end of panel.



C. For easy installation of the interlock cover (Part 10) start by hooking the cover over the interlock on the edge, closer to the panel the interlock will engage with. Snap the cover on so it is attached for a few inches 6"-12". Slide the cover to the top of the panel over the hurricane clip. Using the rubber mallet, tap the edge of the interlock cover, so it snaps into place.

Note: Make sure the cover stays engaged on both sides after the cover is aligned with the top of the panel you can use a mallet to tap the outside edge to complete the installation.

Repeat this for each interlock.



D. Make sure the top of the interlock cover lines up with top of the interlock/panel. The hurricane clip should stick out no more than 1/4" on top or bottom when panels are installed.

SECTION 6: FINISHING

1 Weather Strip Pads (Part 18)

Install the adhesive weather strip pads on the head and sill where the interlock of the panel will rest.



A. Top/Bottom - Close and lock door. Take a pencil and mark the ends of the panels on both, the interior and exterior of the door, head and sill between the tracks. (The line only needs to be half-way across.)

B. Slide panels open to reveal the area between the lines.

C. Remove backing and place at the edge of pencil lines against the tracks. The end of the pads will be between the lines.

When door is closed, pads should be hidden behind the panels/interlock.



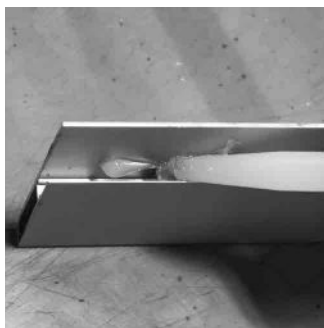
D Add weather strip pads to all corners where operable panels meet the jamb. Attach the pad to the sill where the panel meets the jamb and another on the jamb attached to it.



2 Sill Riser (Part 7)



A. Before installing the sill riser, make sure it is the correct length to cover the interior wall of the sill frame, line up the sill riser with the frame.



B. Once the sill riser is lined up put a bead of sealant along the interior wall of the sill riser.



C. Install the sill riser over the interior wall of the sill frame, using a rubber mallet to be sure not to dent the sill riser. Tap the sill riser down so it snaps into place.



D. Once installed put a small bead of sealant vertically between the sill riser and the jamb (or between the sill riser and P-Hook if applicable).

3 Track Covers (Part 3)

A. Measure and cut vinyl track covers to length for all exposed tracks in both head and jambs.



B. Install track covers in header first making sure to cover the full length of the track.



C. Repeat with all remaining tracks in jambs making sure to keep edges straight at corners.

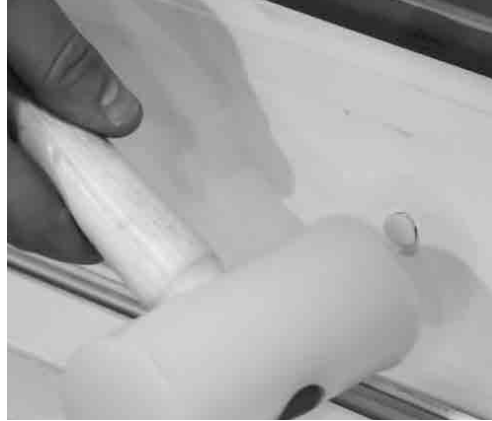


IMPORTANT: Measure around hardware such as keepers and trim covers to line up with the edge of the keepers.

4 Roller Adjustment Covers (Part 17)



A. Before installing the roller adjustment covers be sure that keepers have been installed at appropriate heights, and all other height adjustments have been made to the panels.



B. Push the covers into the roller adjustment hole on the exterior of the panel, use a rubber mallet to gently tap the cover into place if needed.

5 Weep Hole Covers (Part 14)



A. Install the three weep hole covers provided in the exterior face of the sill.



B. Push one side of the cover into the weep hole and gently tap the other end with a rubber mallet to snap the cover into place.

IMPORTANT: Be sure to install with the flap facing downwards.

6 Bumpers (Part 21)

***Bumpers are used to engage multiple panels when operating, as well as to not interfere with the handles.**

Bumpers can be installed on the interior or exterior of the door. It is recommended to keep all bumpers on the same side of the door for an easier and more precise installation, but you can choose any orientation you prefer.

1. Separate the black rubber and the white cover from the metal plate.
2. Attach the metal plate to the door panel using the screws provided. Example shown in **Picture A**.
3. Install the white cover over the metal plate.
4. Insert the black rubber part into the white cover.



Recommended 5" space between the panel with a handle.

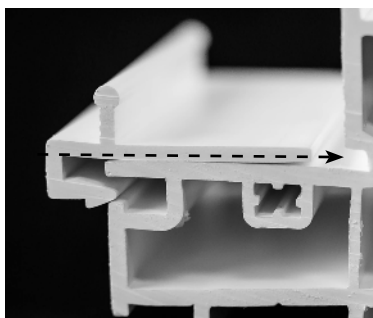
Pocket Door Bumper Configuration (POCKET DOORS MUST FOLLOW)

1. All panels with a handle should have a bumper (Part 21) attached to it to offset 5 inches from the edge of the next panel (to keep the handle clear off the next panel).
2. All panels that do not have a handle should have bumper (Part 21) attached to it for an offset of 3 inches to the edge of the next panel.
3. Pocket door stops (Part 22) are to be attached to the Head and Sill flush with the end of the interior track.

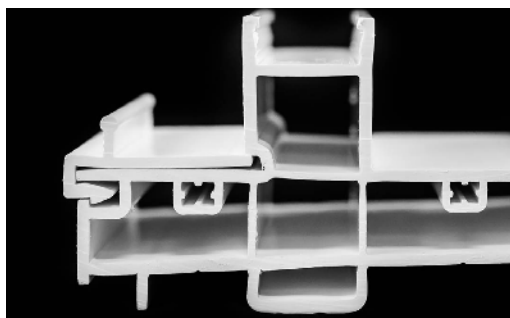
7 Standard Door Screen Track for 2-Panel Doors (Part 23)

If a standard 650 screen track is ordered, there will be 2 pieces of screen track material (Part #23) shipped with the door.

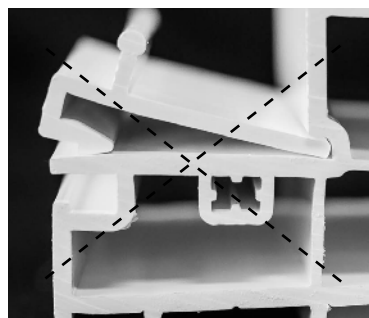
The screen tracks are to be installed on both the head and sill of the door.



A. To install the screen track, place the flat side of the track down on the outermost part of the door.



B. Using a rubber mallet to not damage the part, hit the front of the screen track to snap it into place. Be sure that the track is seated in the head/sill properly. Continue to snap in the part along the full opening of the door.



C. Incorrect placement.

[illegible]



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