

**Table of Contents**

**I. Care and Maintenance ..... 2**

**II. Glazing Assembly..... 2**

**III. Panel Assembly ..... 2**

    1. “X” Panel ..... 2

    2. “O” Panel ..... 4

    3. Add Yokes to Meeting Stiles ..... 5

**IV. Frame Assembly ..... 5**

**V. Frame Opening Verification & Sillpan Installation ..... 6**

    1. Sillpan Substitution ..... 6

    2. Frame Opening Verification ..... 6

    3. Pre-Fit and Leveling ..... 6

    4. Sealant Application ..... 6

**VI. Frame Installation ..... 7**

**VII. Sill Track Installation ..... 7**

**VIII. Sill Track Removal ..... 8**

**IX. Head Bumper Installation ..... 8**

**X. Panel Installation ..... 8**

**XI. Screen Installation ..... 10**

**XII. OXO Panel Configuration ..... 11**

## I. Care and Maintenance

This product is factory finished. Please handle with extreme care. Protect all exposed surfaces from contact with caustics, corrosives, solvents, abrasions, impacts, wet packing material etc. **FAILURE TO DO SO WILL NULLIFY THE WARRANTY.** Before **ANY CLEANING**, review the Care & Maintenance Instructions (go to [www.fleetwoodusa.com](http://www.fleetwoodusa.com) for more information).

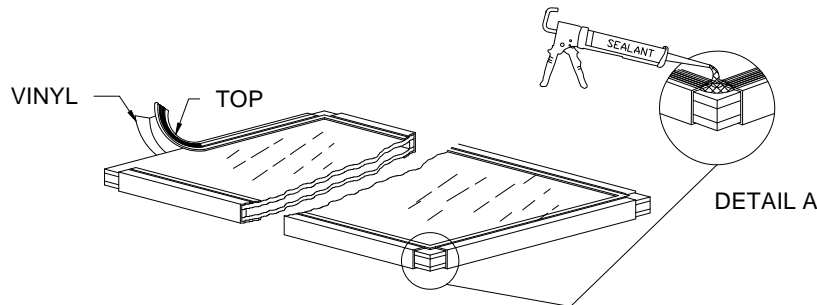
**Contact the local dealer with any questions or concerns.** Fleetwood strongly recommends that all products be cleaned after installation and totally protected from construction debris and equipment.

## II. Glazing Assembly

1. Start attachment of glazing vinyl at top corner of the glass.
2. Cut glazing vinyl at corners as shown in Figure 1, Detail "A".
3. At start/end point (seam), cut glazing vinyl 1/8" oversize to compensate for stretching.
4. Apply sealant to top portion of this seam.
5. Apply a bead of sealant that is compatible with the insulated glass seal to all four exterior corners as shown in Figure 1, Detail "A".

### Notes:

- a. The glass thickness, net width and height must be to size within  $\pm 1/32"$ .
- b. Failure to install according to these instructions nullifies all warranties related to this product.



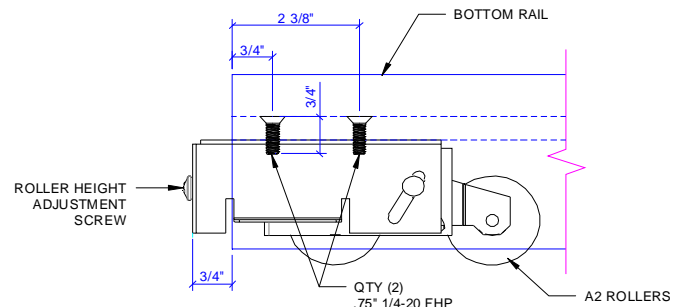
**Figure 1:**  
Glazing Vinyl Application

## III. Panel Assembly

**Note:** Match door configuration and panel orientation with customer order. Configuration and orientation of panels shown in assembly instructions is for illustration purposes only.

### 1. "X" Panel

- Adjust the roller assemblies (2 required per "X" panel) to the full up right position using the adjustment screw.
- Center the top rail onto the glass. Using a rubber mallet, drive the rail onto the glass until the rail seats against the vinyl lip. Repeat this procedure with the bottom rail.

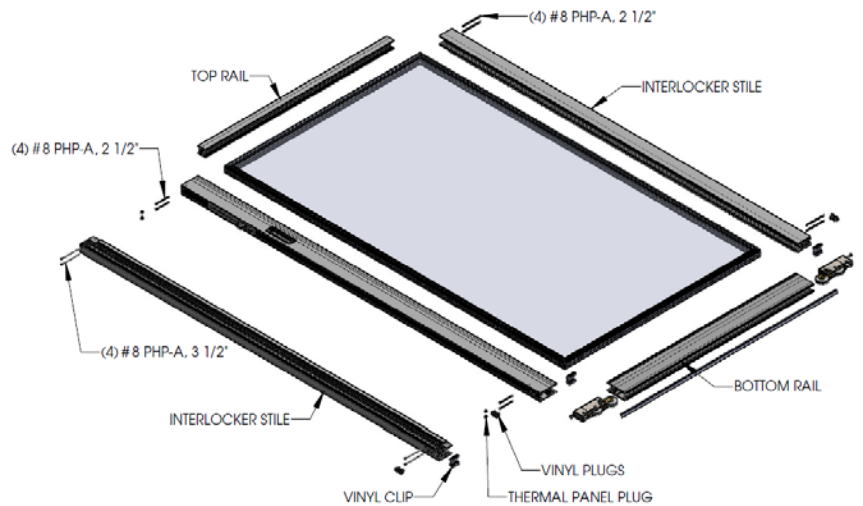


**Figure 2:**  
Roller Adjustment

**Note:** Prior to adjusting the roller on **ANY** door you **MUST** first remove the weight of the panel.

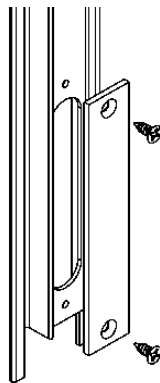
**Note:** Before installing lead and interlocker stiles to panels please check required orientation with customer order

- Place the interlock stile; weather-strip facing up on the right side for XO, and weather-strip facing up on the left side for OX.
- Position the interlocker stile on one side as described above and drive it onto the glass.
- Position the lead stile or interlocker stile on other side and drive it onto the glass.
- Slide the Vinyl sweep into the top groove of the bottom rail 13/16" on lead stile side and 2 3/4" on interlocker side.
- Secure the stiles to the rails with (4) #8 x 3 1/2" flat head screws in the top and bottom rails for the interlockers and (4) #8 x 2 1/2" pan head screws for lead stile (Figures 3 & 4). Add wax to the ends of all fasteners to reduce the drive torque required for installation.



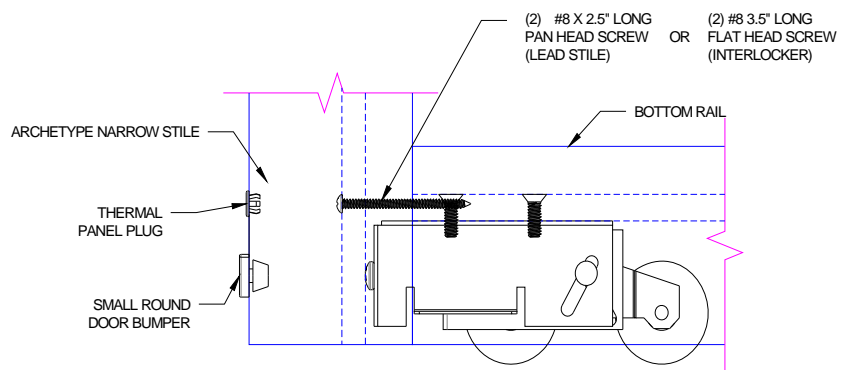
**Figure 3:**  
"X" Panel Assembly (exterior)

**General Rules:** On panel and stile orientation operating hardware or thumb turns are always to the interior. On panels with interlocker stiles at both ends, weather stripping should be oriented so that one end is facing up and the other facing down.



**On doors with meeting stiles, a stainless steel cover is provided to cover the oblong holes at the bottom of the lead stiles.**

**Figure 4a:**  
Meeting Stile Cover plate



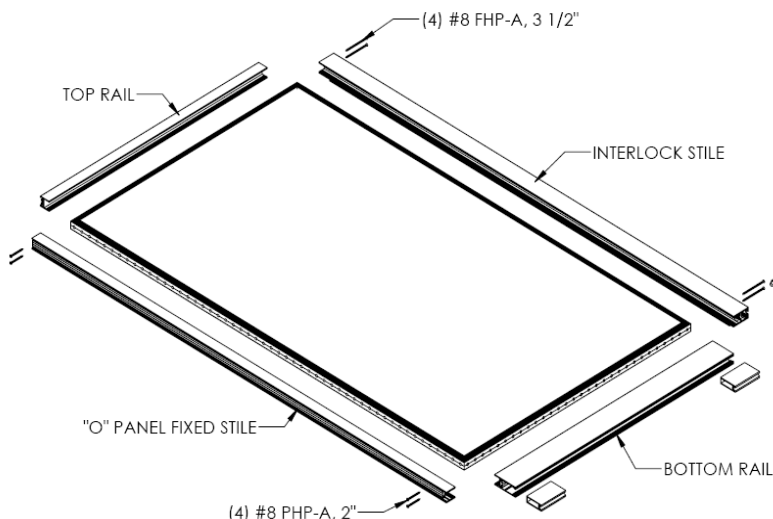
**Figure 4b:**  
Roller Fastening

## 2. "O" Panel

- Center the top rail onto the glass. Using a rubber mallet, drive the rail onto the glass until the rail seats against the vinyl lip. Repeat this procedure with the bottom rail.

**Note:** Before installing fixed and interlocker stiles to panels please check required orientation with customer order.

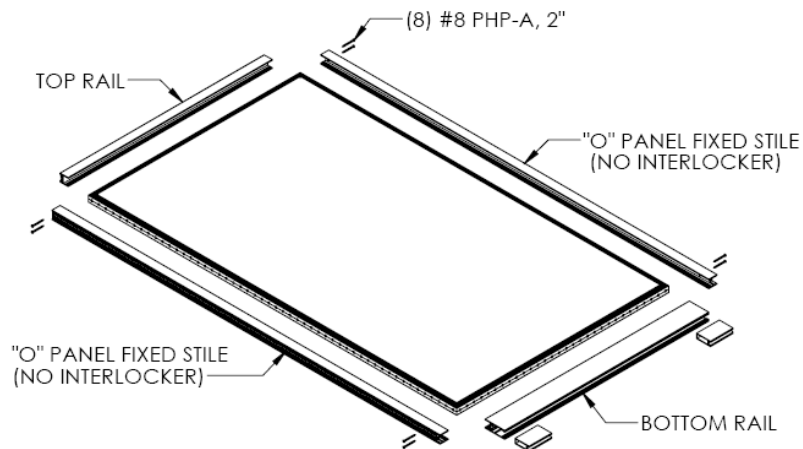
- Place the interlock stile; weather-strip facing down on the right side for OX, and weather-strip facing down on the left side for XO.
- Position the interlocker stile on one side as described above and drive it onto the glass.
- Position the fixed stile or interlocker stile on other side and drive it onto the glass.
- Finish assembly by inserting (4) #8 x 3 1/2" flat head screws into the interlocker, and (4) #8 x 2" pan head screws into the fixed stile screw grooves in the top and bottom rails (Figure 5). Add wax to the ends of all fasteners to reduce the drive torque required for installation.
- Insert vinyl plugs at top and bottom of stiles.



**Figure 5:**  
"O" Panel assembly  
(interior)

## 3. "O" Panel (non-interlocker)

- Center the top rail onto the glass. Using a rubber mallet, drive the rail onto the glass until the rail seats against the vinyl lip. Repeat this procedure with the bottom rail.
- Position the fixed stiles on sides and drive it onto the glass.
- Finish assembly by inserting (8) #8 x 2" pan head screws into the fixed stile screw grooves in the top and bottom rails (Figure 6). Add wax to the ends of all fasteners to reduce the drive torque required for installation.

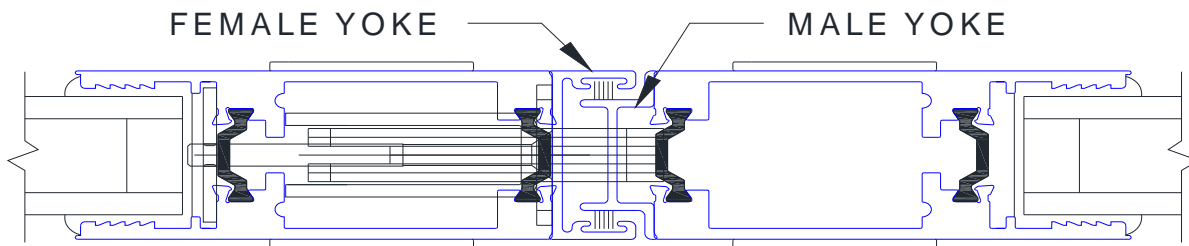


**Figure 6:**  
"O" Panel assembly non-interlocker

#### 4. Add Yokes to Meeting Stiles

**General Rules:** Latching hardware for typical installation is located in the right hand panel (facing exterior); customer has option to reverse at the time of order. Female yoke is attached to the stile containing the latch mechanism.

- Install male and female yokes with #8 x 3/4" screws, 6" from ends, maximum 18" on centers (Figure 7).

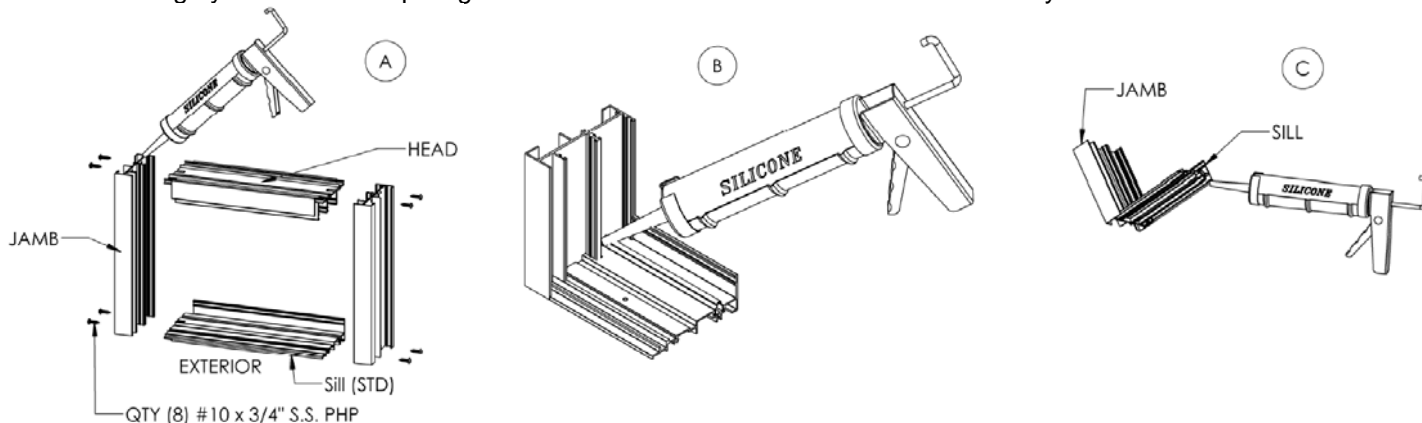


**Figure 7:**  
In-Line Meeting Stiles

#### IV. Frame Assembly

1. Add sealant to the upper corners of the jamb(s) and to the end of the head that is compatible to the entire assembly as shown in Figure 8, Detail A.
2. Attach the jamb(s) to the head using #10 x 3/4" long pan head screws (Note: please check that the screws past through jamb(s) and into the screw raceways in the head). Add wax to the ends of all fasteners to reduce the drive torque required for installation.
3. Attach the jamb(s) to the sill using #10 x 3/4" long pan head screws (Note: please check that the screws past through jamb(s) and into the screw raceways in the sill). Add wax to the ends of all fasteners to reduce the drive torque required for installation.
4. After frame has been assembled make sure ample sealant is forced in and around each contour at all four corners as shown in Figure 8, Detail B. Seal outside corners from underneath threshold as shown in Figure 8, Detail C.

**Note:** Due to the potential disruption during handling and installation, the installer is responsible for the integrity of all areas requiring sealant whether or not these frames were factory assembled.



**Figure 8:**  
Frame Joint Sealing

## V. Frame Opening Verification & Sillpan Installation

### 1. Sillpan Substitution

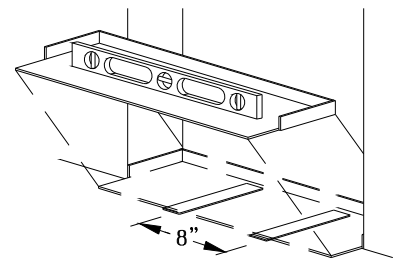
- If the factory provided sillpan is not desired, the product warranty will remain intact if the substitute panning system emulates the essential design of the factory pan. This sliding door has passed specific air, water, energy and structural testing with the factory provided sillpan.

### 2. Frame Opening Verification

- Check the measurements of the opening and verify that the door will fit into the opening.

### 3. Pre-Fit and Leveling

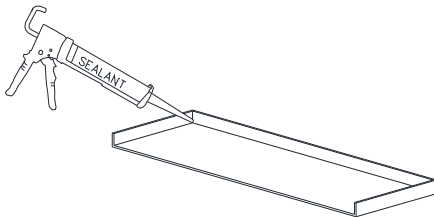
- Place sillpan into the opening and determine leveling that must be done prior to installation.
- Shim as necessary to stabilize the entire depth and length of the sillpan. No unsupported width of more than 8" is allowed.
- If more than 1/8" shim height is required, pouring self-leveling "Rock Hard" (or equal) to achieve a level and stable surface is recommended.



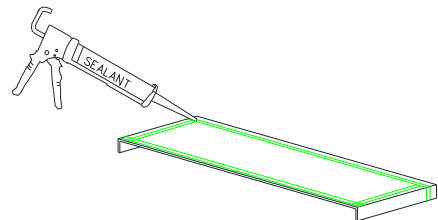
**Figure 9:**  
Leveling Sillpan

### 4. Sealant Application

- Apply sealant in all corners and seams of the sillpan (Figure 10).
- With bottom side of sillpan up, apply a 3/8" bead of compatible sealant 1/2" in from interior leg. Sealant bead to run across the bottom as well as up each vertical leg of the sillpan. Also apply sealant beads near the sides and across the front (Figure 11).

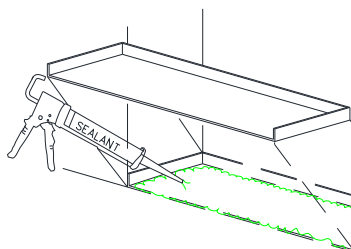


**Figure 10:**  
Seal corners and seams

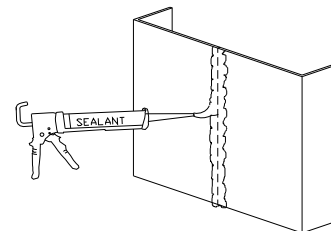


**Figure 11:**  
Seal underside of Sillpan

- Secure the sillpan to the floor with sealant (Figure 12). Position sillpan as necessary to allow for proper installation of frame assembly.
- If sillpan is more than one piece, butt the pieces and glue them to the floor together (Figure 13).
- Apply sealant to all interior and exterior seams.



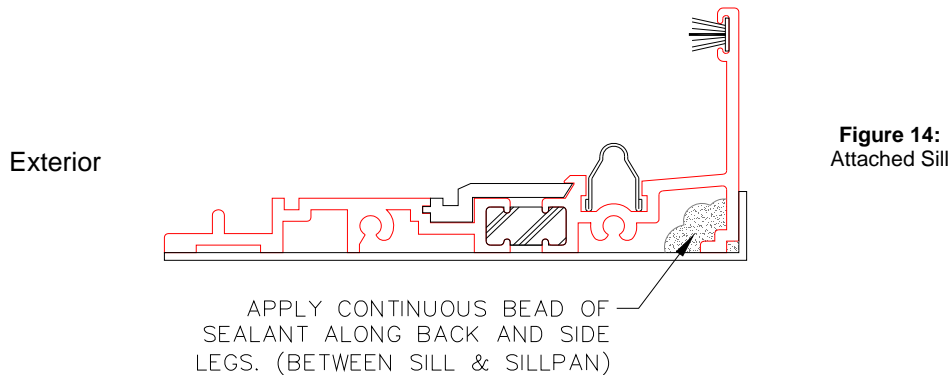
**Figure 12:**  
Set Pan in full bed  
of sealant



**Figure 13:**  
Glued Sillpans

## VI. Frame Installation

- Attach sill to the sillpan with a compatible sealant as shown below.



- Attach frame to structure as shown below (Figures 15 & 16).

**Note:** Size and location of fasteners to be per local code. Blocking, stainless steel screws (recommended), and wall finish not furnished by Fleetwood. Frame installation anchors furnished by installer.

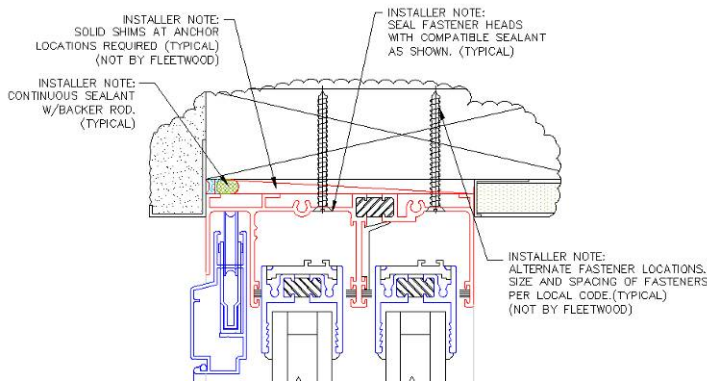


Figure 15:  
Door Head

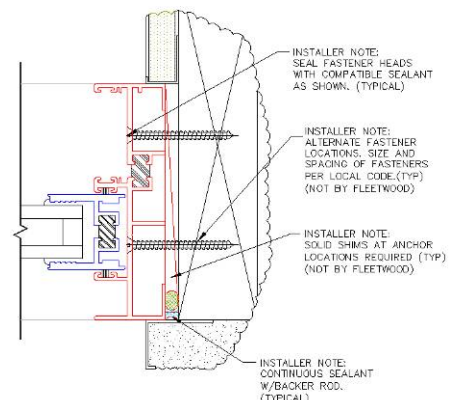


Figure 16:  
Door Jamb

## VII. Sill Track Installation

1. Using a pair of pliers, slightly squeeze one end of the track to create a tapered edge.
2. Push tapered edge of track into the sill.
3. Using a rubber mallet, tap the track into the sill.

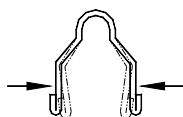


Figure 17:  
Squeeze track

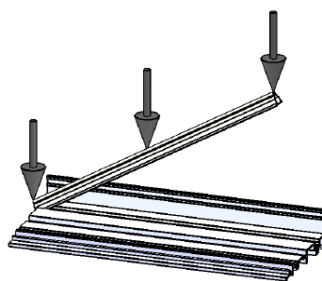


Figure 18:  
Sill Track Installation

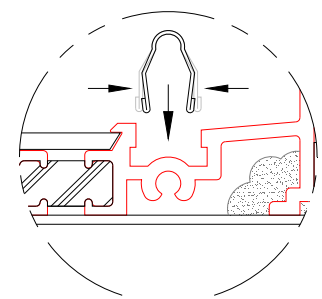
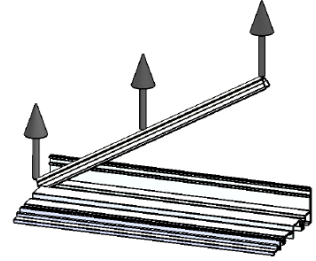


Figure 19:  
Track (Typical)

### VIII. Sill Track Removal

1. Using a pair of pliers, slightly squeeze the track together at one end and pull up.
2. Using a screwdriver, slowly pry the track out of the sill. Although you can re-insert the track, we recommend replacing with a new track for optimal performance of the door.

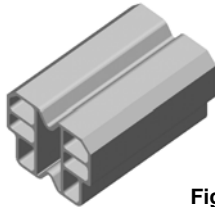


**Figure 20:**  
Sill Track Removal

### IX. Head Bumper Installation

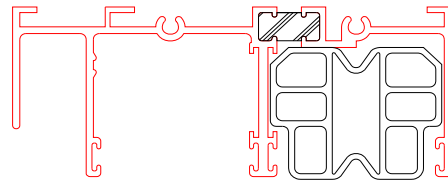
**Note:** A head bumper is required in the head of the “X” panel track.

- Install head bumpers into head as shown.



**Figure 21:**  
Head Bumper

Exterior



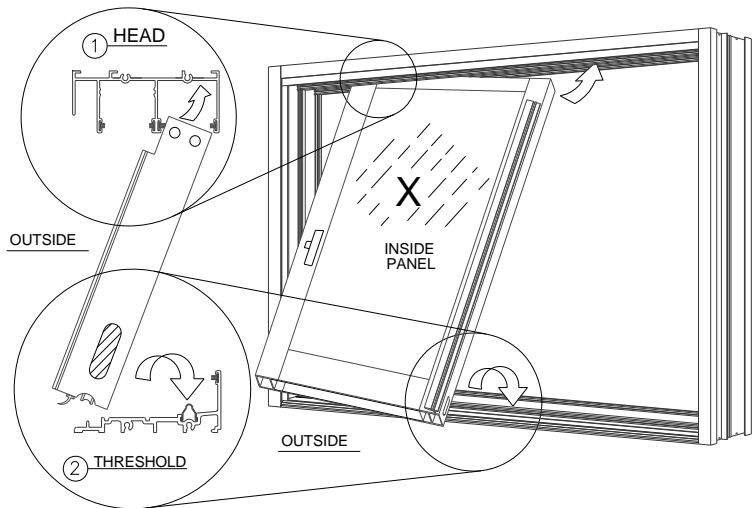
**Figure 22:**  
Head Bumper Installation

### X. Panel Installation

**Note:** Check customer order for proper panel configuration and orientation.

#### “X” Panel

1. Sequence of panel installation is from interior to exterior.
2. Insert panel (panel located on the track closest to the interior) into the upper head channel. Push up and swing the bottom inward until panel is vertical, then lower panel down onto the track (Figure 23).



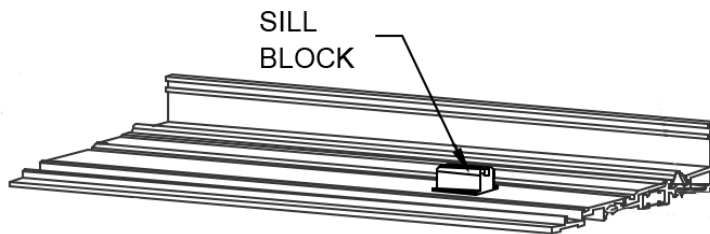
**Figure 23:**  
“X” Panel Installation

**Note:** “X” Panel - Do not attempt to slide the panel unless the rollers have been adjusted. Adjust the rollers as needed to make the panel plum and level. If the panel contains a lock stile, verify that the latch height is correct for proper operation with the frame. Insert vinyl plugs into the holes at top and bottom of the panel.



**“O” Panel Installation**

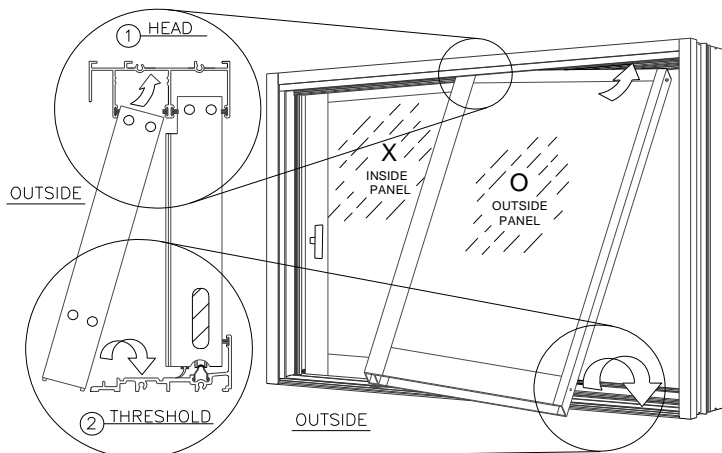
1. Add 2” long sill block and secure with #8 x 3/4” long pan head self tapping screw to the bottom of sill as shown in Figure 24.
2. Insert panel into the upper head channel. Push up and swing the bottom inward until panel is vertical, then lower panel down onto the track.



EXTERIOR

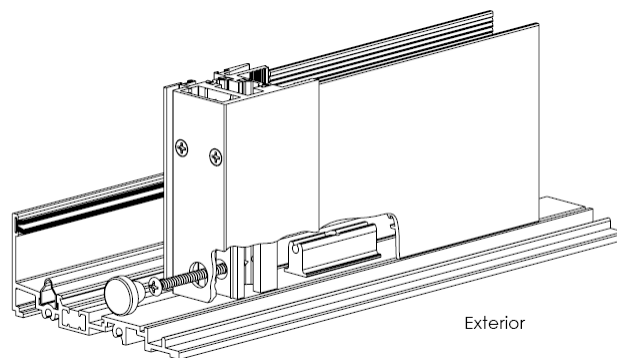
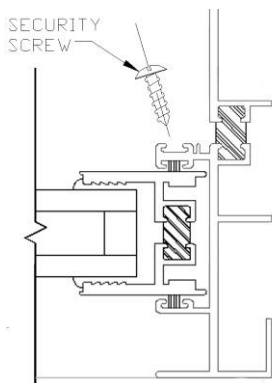
**Figure 24:**  
Attached Sill Block

**Note:** “O” Panel - Lift and move the panel into the fixed jamb as far as possible. Verify that the weather stripping in the frame head is located so that it contacts the width of the “O” panel.



**Figure 25:**  
“O” Panel Installation

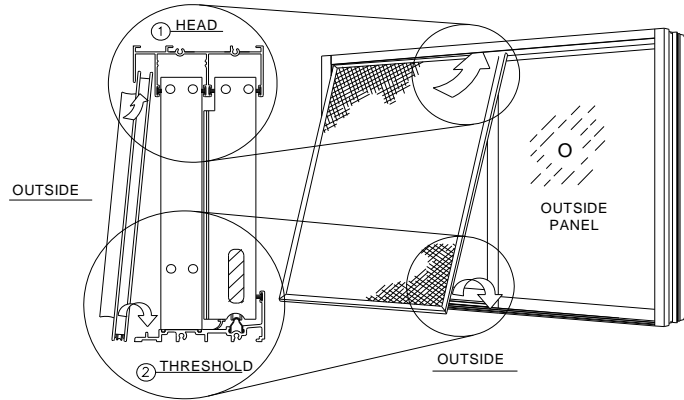
3. **Installing the fixed panel security screw:** Using a 1/16” diameter bit, drill a hole into the fixed stile through the hole showed in Figure 26. Then insert a black #8 x 3/4” PHP TEK security screw. Add #10 OH - A, 2.5, Zinc, Gold screw to sill plate (Figure 26).



**Figure 26:**  
Security Screw Installation

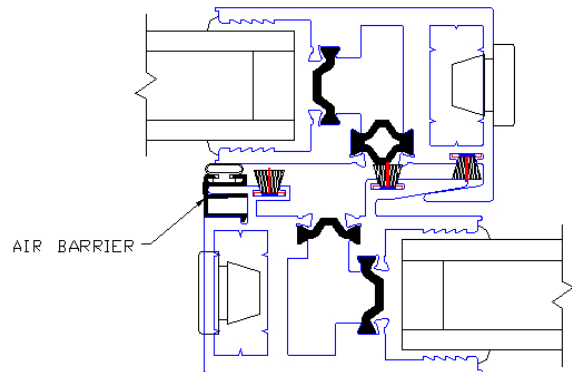
**XI. Screen Installation**

- Insert screen into the upper head channel. Push up and swing the bottom inward until screen is vertical, then lower screen down onto the track.



**Figure 27:**  
 Screen Installation

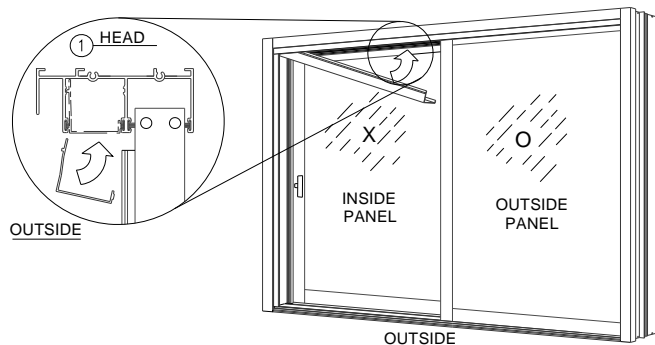
- Verify that all panels with interlocker hooks engage properly. If lead stile panel is not engaging properly with the jamb or meeting stiles (Figure 28).
- Repeat previous step until all panels have been installed properly.
- Two 6" plastic air barriers (per interlocker set) are provided in the screw pack. Snap these in the back of all exterior interlockers at the top and bottom (Figure 28).



**Figure 28:**  
 Interlockers with Air Barrier

**Note:** panels must overlap during installation to allow proper engagement of interlockers.

- Install head closer(s) into the head except where the closer interferes with sliding panel(s) (Figure 29).



**Figure 29:**  
 Head Closer Installation

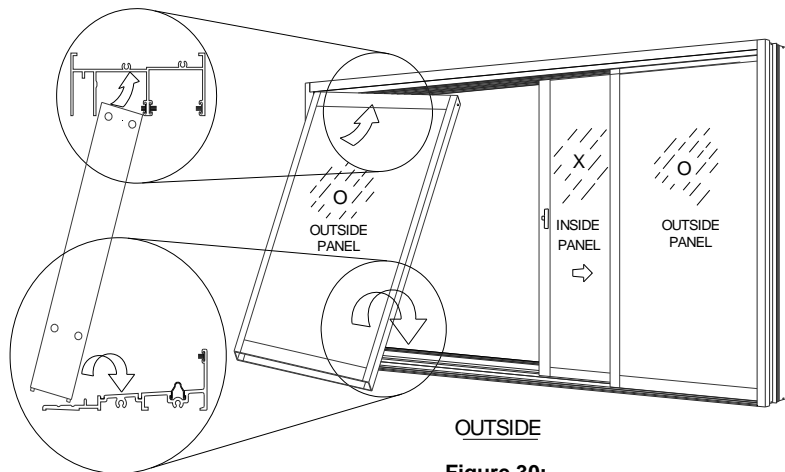
## XII. OXO Panel Configuration

**Note:** Check customer order for proper panel configuration and orientation. Assemble and install the frame as indicated on previous sections III – VIII of this manual. Insert the sliding panels as indicated on previous section “XO” Panel Configuration, once completed then continue with following instructions for OXO panel installation completion.

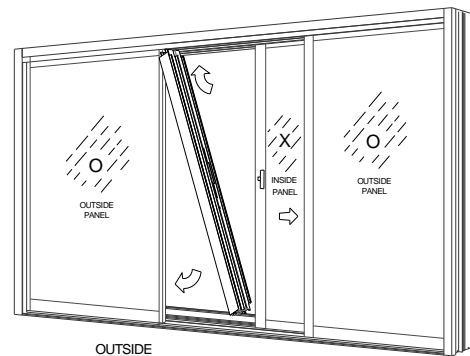
1. Slide the “X” Panel to the right side fixed jamb.
2. Insert the left side fixed panel (without interlocker) into the upper head channel. Push up and swing the bottom inward until panel is vertical, then lower panel down onto the track.

**Note:** Leave the head unanchored until the false jamb has been installed and set into position.

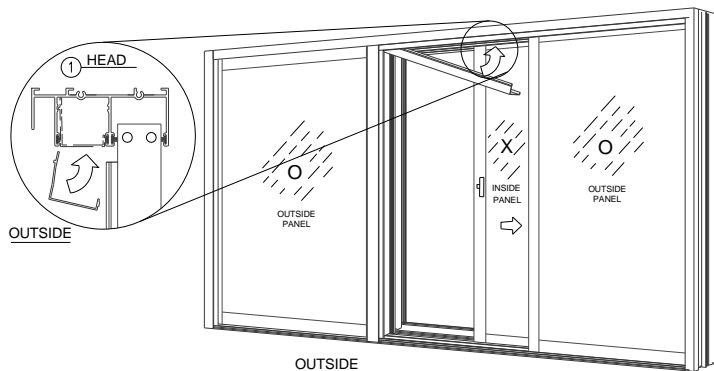
3. Slide the left side fixed panel into the left side fixed jamb as far as possible.
4. Install the false jamb at an angle until it rests against the left side fixed panel (Figure 31).
5. Using a wood block and hammer, set the false jamb firmly into its place against the fixed panel.
6. Install the head closer between the false jamb and the right side fixed panel (Figure 32).



**Figure 30:**  
OXO Panel Installation



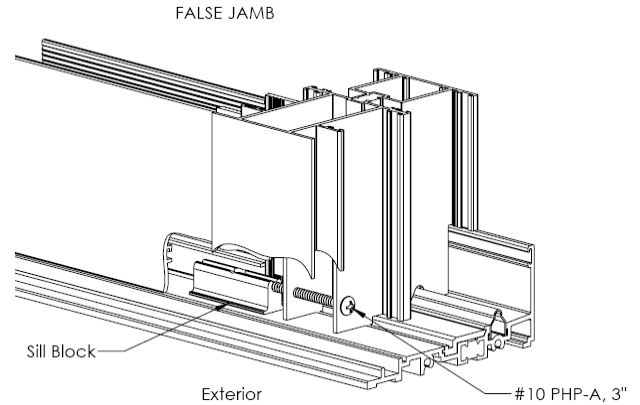
**Figure 31:**  
False Jamb Installation



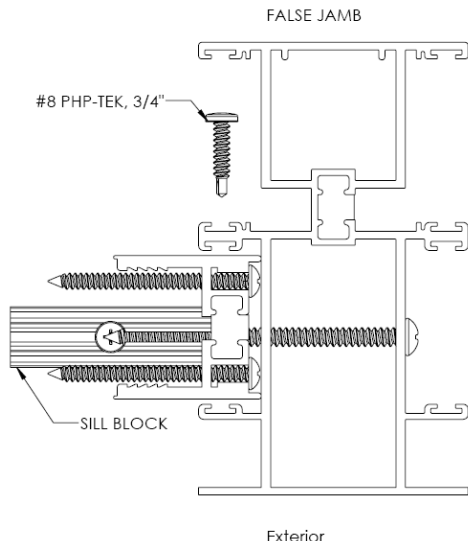
**Figure 32:**  
Head Closer Installation

7. Anchor False Jamb to the Frame and Structure

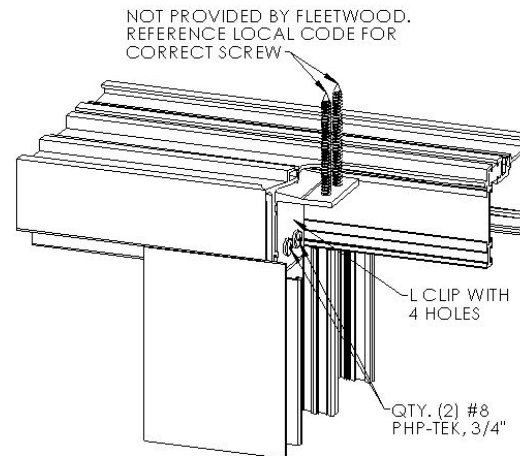
- Add the Sill Block using (1) #8 PHP-TEK, 3/4" screw (Figure 33).
- Attach the false jamb to the sill block using a (1) #10 PHP-A, 3" screw.
- Add (4) #8 PHP-TEK, 3/4" screw along the false jamb interior of fixed panel (Figure 34).
- Using (4) #8 x 3/4" long pan head self tapping screws (Figure 34).
- Seal all the holes.



**Figure 33:**  
Sill Block at False Jamb

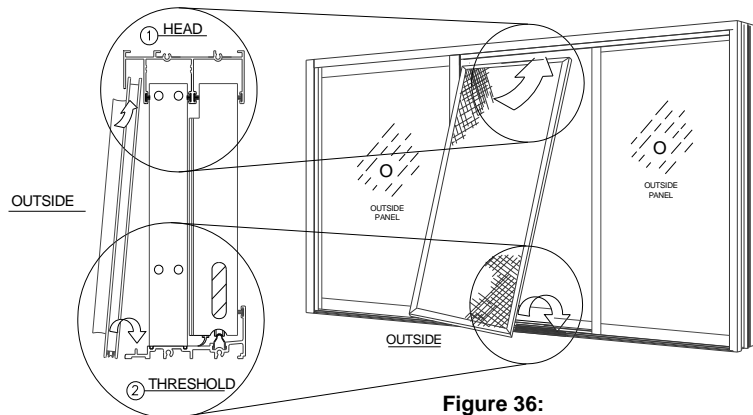


**Figure 34:**  
Security screw at fixed panel and False



**Figure 35:**  
"L" Bracket at False Jamb / Frame Head

8. Insert screen into the upper head channel. Push up and swing the bottom inward until screen is vertical, then lower screen down onto the track (Figure 36).



**Figure 36:**  
OXO Screen Installation