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## 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. Tools / Materials, Sealant Requirements, & Anchor Instructions

**Tools Required:** Tape measure, level, shims, nails, rubber mallet, putty knife, screws, sealant, caulk gun, backer rod, 6mm hex wrench, scissors or utility knife, drill bit, drive bit and powered drill.

### Sealant Requirements

1. The sealant referred to within this document for seals associated with the assembly of the product should conform to **AAMA 800-92**. It is recommended that all other sealants should also conform to **AAMA 802-92** but may be a sealant recommended and approved by the sealant manufacturer that is compatible with the door framing, finish and surrounding materials.
2. The size of all sealant beads must meet or exceed the sealant manufacturers' minimum size requirements.
3. Some exterior wall finishes require additional sealing between the perimeter of the door frame and adjacent finish wall material. The Owner / General Contractor is responsible for identifying the need for any additional sealant which will be applied by others. Such sealant shall be elastomeric material, and compatible with the door framing, finish and surrounding materials.

### Anchor Instructions

Frame may be either direct mounted to the opening, mounted onto a continuous wood spacer, anchored to a min. 18 ga. 33 ksi metal stud or anchored to a min. 2x4 no. 3 southern pine wood buck. When anchored to a 2x\_ buck or metal stud, no. 12 screws shall be used. When direct mounted or mounted with spacer to block/concrete, 1/4" concrete screws shall be used. Proper material shall be used between all dissimilar materials (block/concrete & aluminum).

### III. Frame Opening Verification & Sillpan Installation

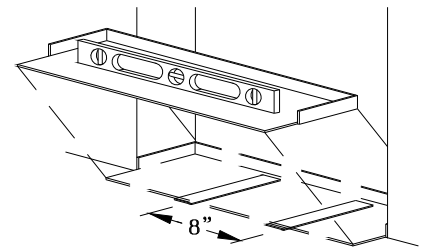
**Note:** Factory provided sillpans are not available on bent doors. It is the installer's responsibility for materials and weatherproofing of sill on all bent doors. If the factory provided sillpan is not desired, the product warranty will remain intact if the substitute panning system emulates the essential design of the factory pan. This sliding door system has passed specific air, water, energy and structural testing with the factory provided sillpan.

#### 1. Frame Opening Verification

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

#### 2. Pre-Fit and Leveling

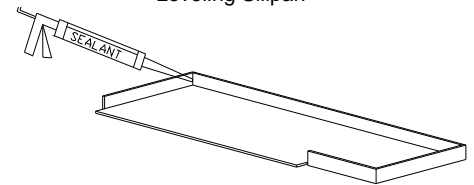
- Place sillpan into the opening and determine leveling that must be done prior to installation.
- Shim as necessary to stabilize the entire depth and length of the sillpan. No unsupported width of more than 8" is allowed (Figure 1).
- If more than 1/8" shim height is required, it is recommended that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



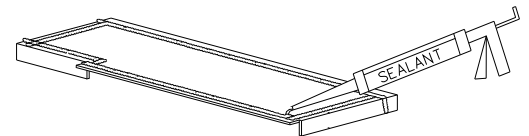
**Figure 1:**  
Leveling Sillpan

#### 3. Sealant Application

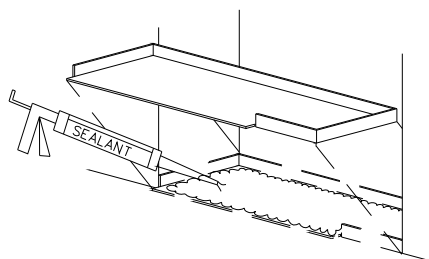
- Apply sealant in all corners and seams of the sillpan (Figure 2).
- With bottom side of sillpan up, apply a 3/8" bead of compatible sealant 1/2" in from interior leg. Also apply sealant beads near the sides and across the front (Figure 3).
- Secure the sillpan to the floor with glue. Position sill pan as necessary to allow for proper installation of frame assembly. **Caution:** For pocket doors do not forget required space for post interlocker. Sill track is located 3/8" from pocket wall on side with post interlocker (Figure 4).
- If sillpan is more than one piece, butt the pieces and glue them to the floor together (Figure 5).
- Apply sealant to all interior and exterior seams.



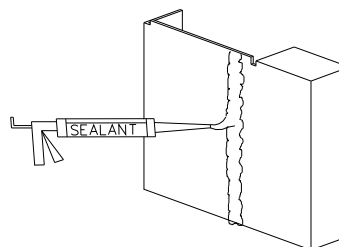
**Figure 2:**  
Seal Corners and Seams



**Figure 3:**  
Seal Underside of Sillpan



**Figure 4:**  
Set Pan in Sealant



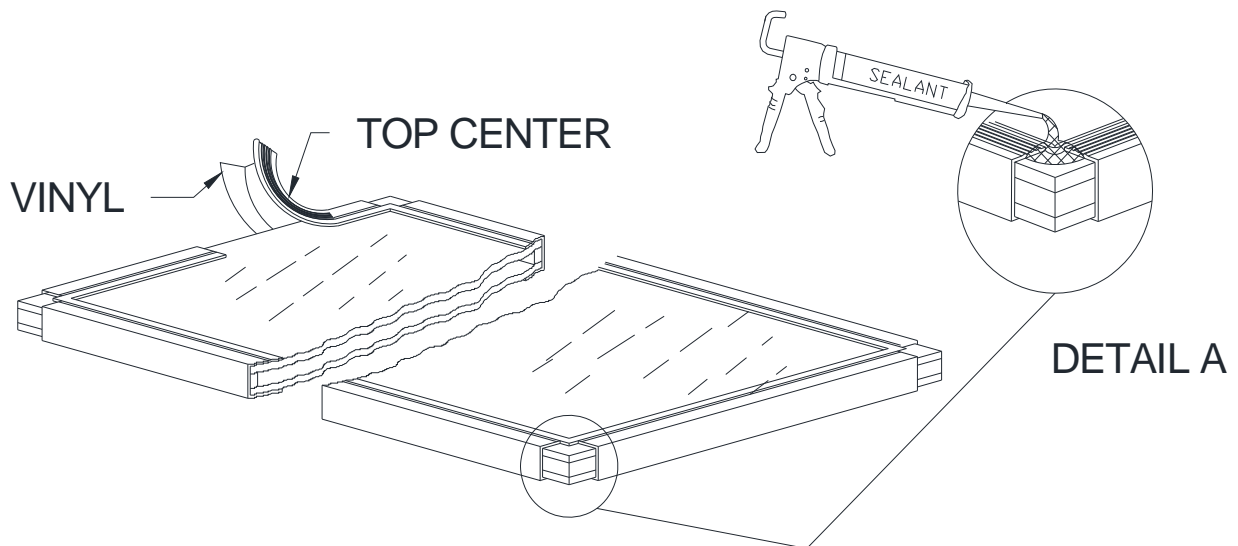
**Figure 5:**  
Joined Sillpans

#### IV. Glazing Assembly

1. Start attachment of glazing vinyl at top center of the glass.
2. Cut glazing vinyl at all four corners as shown in Figure 6, 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 6, 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 6:**  
Glazing Vinyl Application

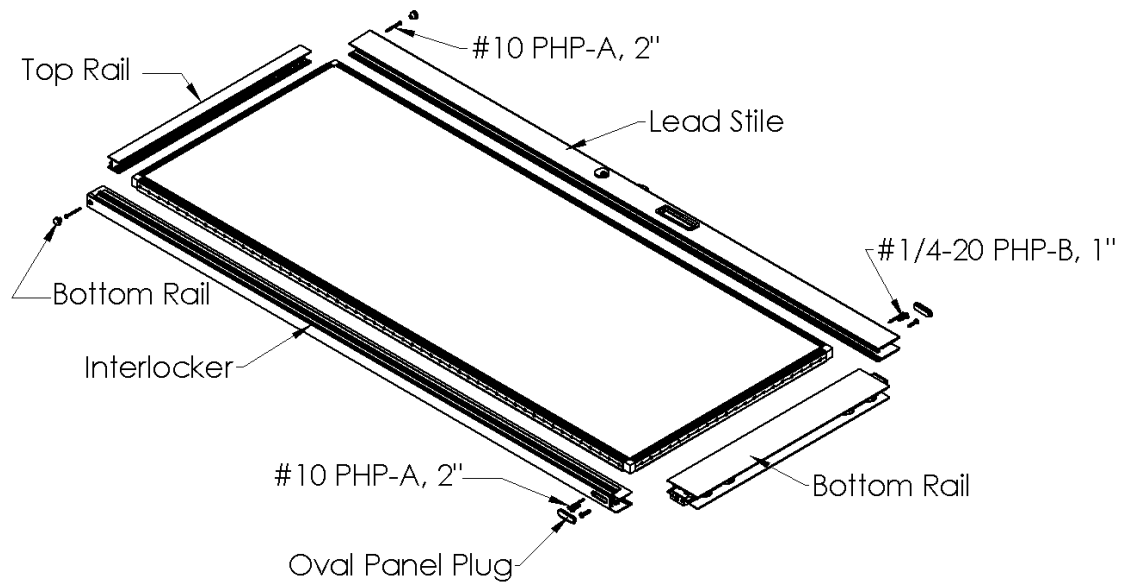
#### V. Panel Assembly (If panels were ordered glazed, skip to section IV)

**Note:** Match door configuration and panel orientation with customer order. Configuration and orientation of panels shown in assembly instructions is for illustration purposes only. Operating hardware or thumb turns are always to the interior.

##### 1. "X" Panel

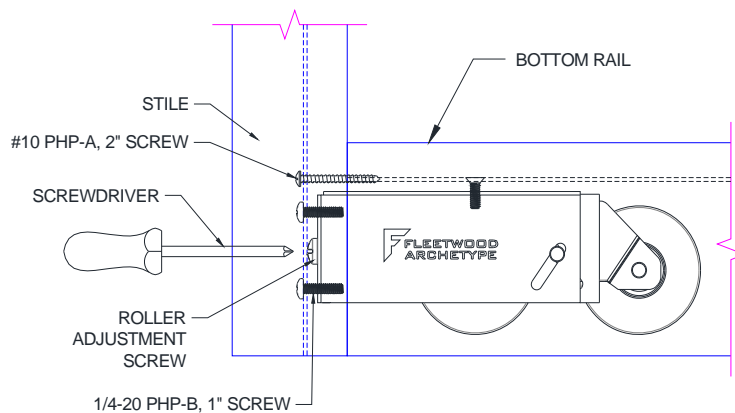
- Center the top rail onto the glass. Using a rubber mallet, drive the rail onto the glass until the rail seats against the vinyl lip. Repeat this procedure with the bottom rail.
- Position the interlocker stile, weather-strip facing up (on the right for OX, left for XO) and drive it onto the glass.
- Position the lead stile or interlocker stile on the left side and drive it onto the glass.

- Secure the stiles to the rails with (4) #10 x 2" pan head screws (Figure 7). Add wax to the ends of all fasteners to reduce the drive torque required for installation.
- Install (2) 1/4-20 UNC x 1" long pan head screws to bottom of interlocker stile or lead stile. Screws attached vertical rails to Roller Housing (Figure 8).
- Adjust the roller assemblies (2 required per "X" panel) to the full up right position using the adjustment screw (Figure 8).
- On doors with meeting stiles, a stainless steel cover is provided to cover the oblong holes at the bottom of the male meeting stile (Figure 9).

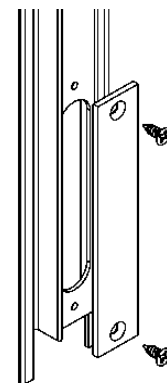


**Figure 7:**  
X Panel Assembly

**Note:** Before adjusting rollers, lift panels to relieve weight.



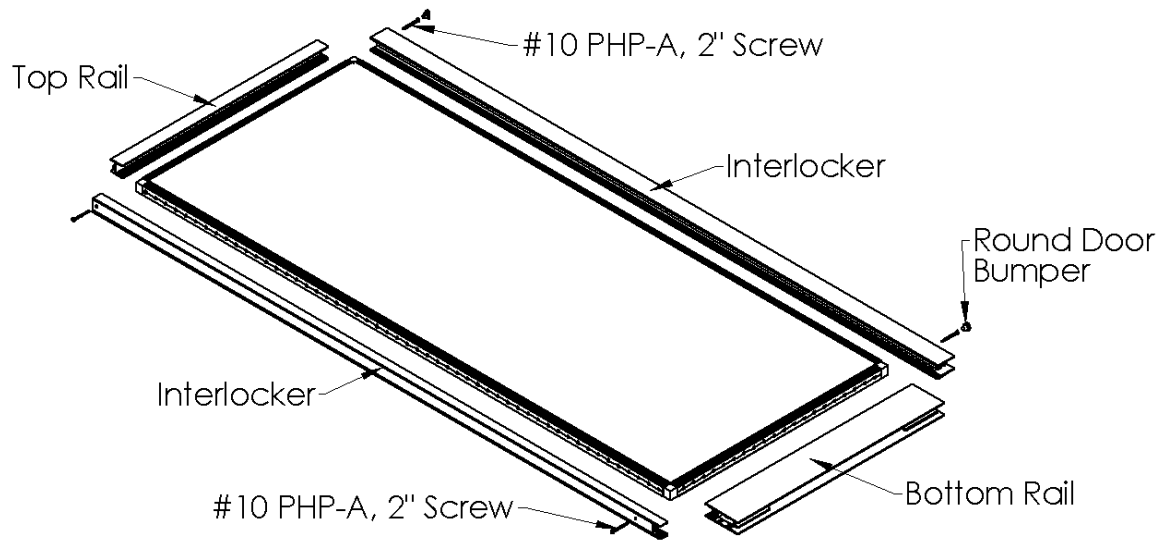
**Figure 8:**  
Roller Adjustment



**Figure 9:**  
Stainless Steel Cover

## 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.
- Position the fixed stile on the right side and drive it onto the glass.
- Position the interlocker stile on the left side and drive it onto the glass.
- Secure the stiles to the rails with (4) #10 x 2" pan head screws. 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 10).

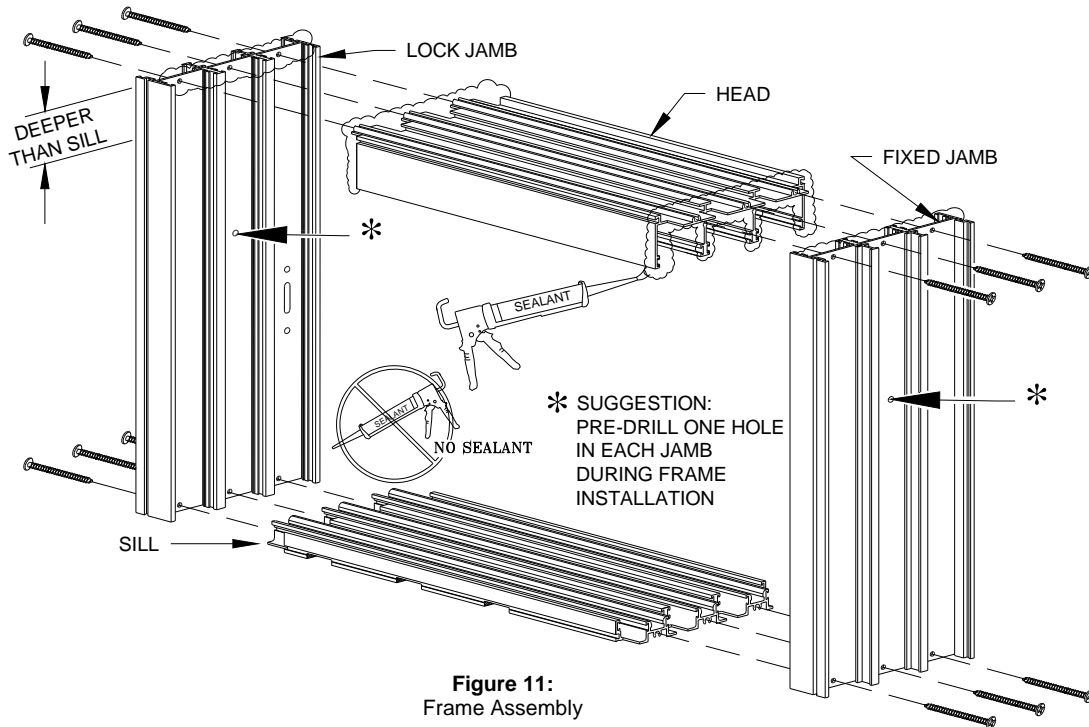


**Figure 10:**  
O Panel Assembly

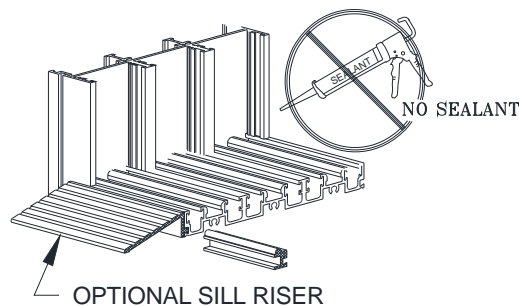
## VI. Frame Assembly

**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.

1. Remove Jamb Fillers from jambs, these will be installed after frame installation.
2. Add sealant to the upper corners of the jamb(s) and to the end of the head that is compatible to the entire assembly (Figure 11).
3. Attach the jamb(s) to the head using #10 x 3/4" long pan head screws, 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.
4. Do not add sealant to the lower corners of the jamb(s) or ends of sill track(s).
5. On pocket installations orient sill track so that no weeps holes are located in pocket.
6. Attach the jamb(s) to the sill using #10 x 3/4" long pan head.
7. If sill riser (optional) is included, insert riser tab into sill pocket and slide together (Figure 12).
8. After frame has been assembled make sure ample sealant is forced in and around each contour at all head joints.



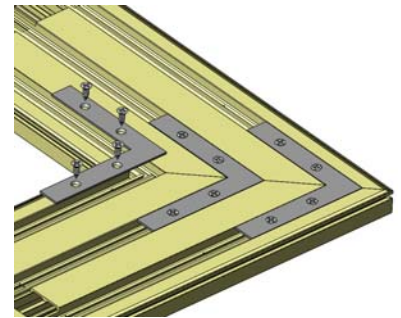
**Figure 11:**  
Frame Assembly



**Figure 12:**  
Optional Sill Riser

**VII. Sill Assembly for 90° Corner Doors**

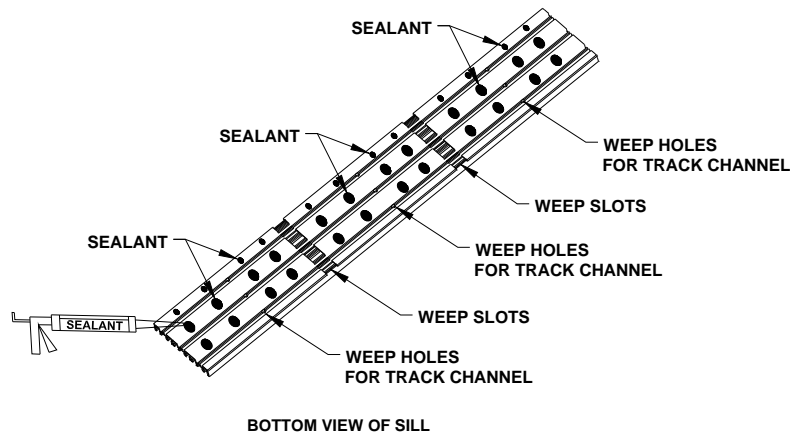
1. Remove the “L-Shaped” braces and Screw #8 FHP - A - UC, 1/2", SS, Clear from the frame pack. There should be (4) screws per brace (Figure 13).
2. Orient the sill with the bottom side up and install the “L-Shaped braces as shown in the figure below. Make sure to protect the top side of the sill with cardboard or other materials to prevent damage to the finish while installing braces. Keep corner tight while installing braces to prevent a gap at the mitered corner.



**Figure 13:**  
90° Corner Braces

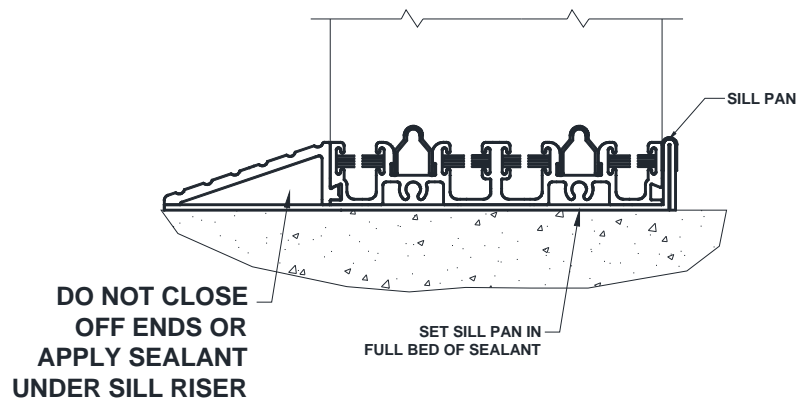
**VIII. Frame Installation**

1. Attach sill to the sillpan with a compatible sealant (Figure 14). Do not place sealant in or next to weep slots or weep holes cut or drilled in bottom of sill (Figure 15). Sealant that blocks weep slots will prevent sill from weeping.



BOTTOM VIEW OF SILL

**Figure 14:**  
Sill Sealant Locations

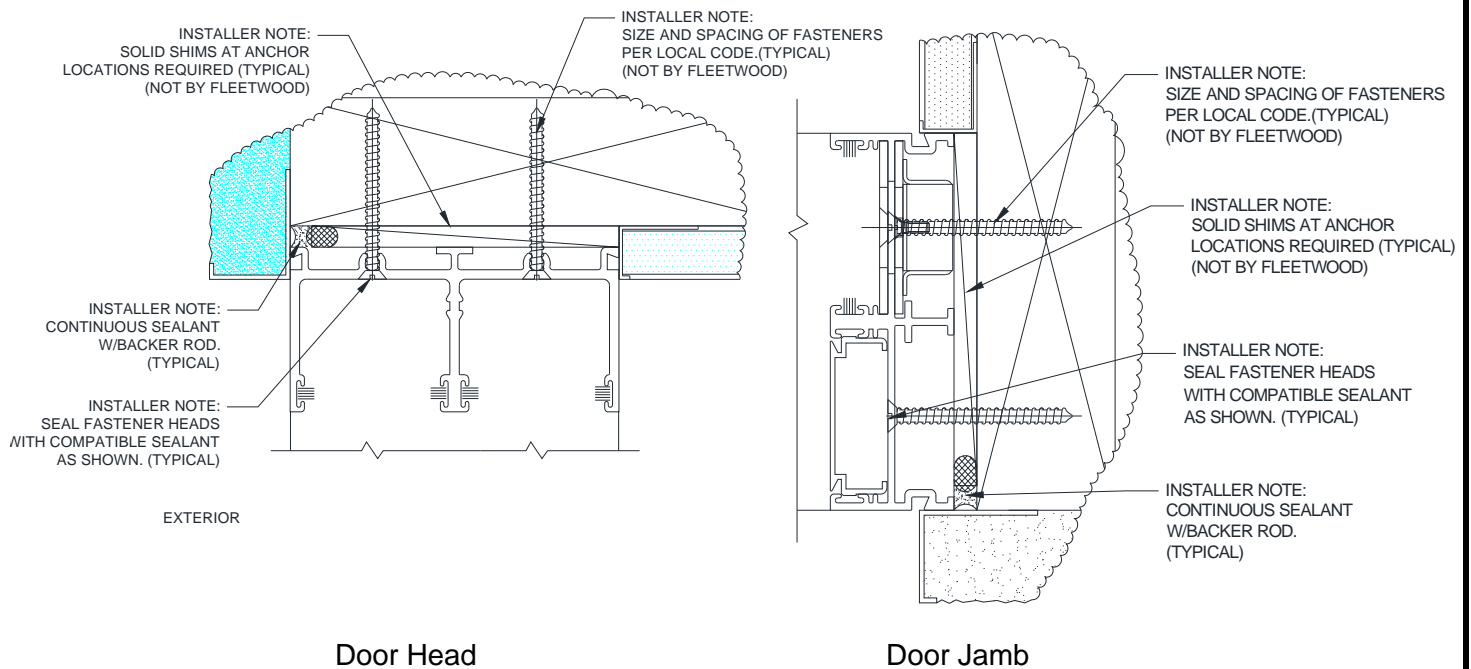


**Figure 15:**  
Sill Sealant Locations

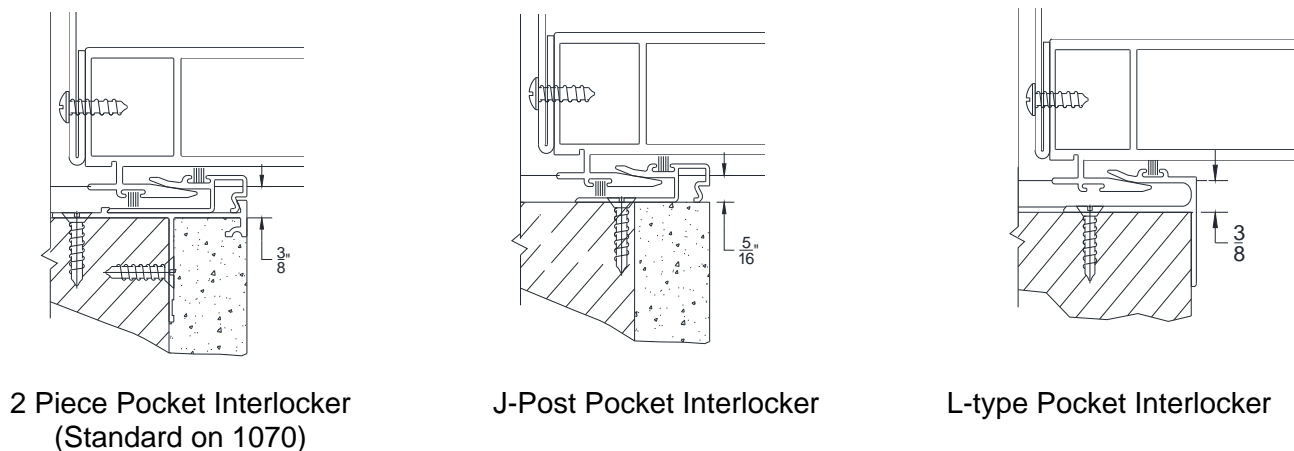


- Attach frame to structure as shown below (Figure 16). On pocket doors it is important to locate the frame 3/8" from the inside pocket wall where a 2-piece and L-type Pocket Interlocker is used to allow for proper interlocking of panel with post interlocker. On installations where the J-Post Pocket interlocker clip is only used, a 5/16" distance is required. Figure 17 illustrates the different Pocket interlocker options.
- Once the frame has been secured to the structure insert the jamb fillers. Using a rubber mallet start at the bottom and gently hammer in place. If the configuration has a fixed panel secure that to the frame first

**Note:** Size and location of fasteners to be per local code. Frame installation anchors furnished by installer, not by Fleetwood. Stainless steel screws are recommended.



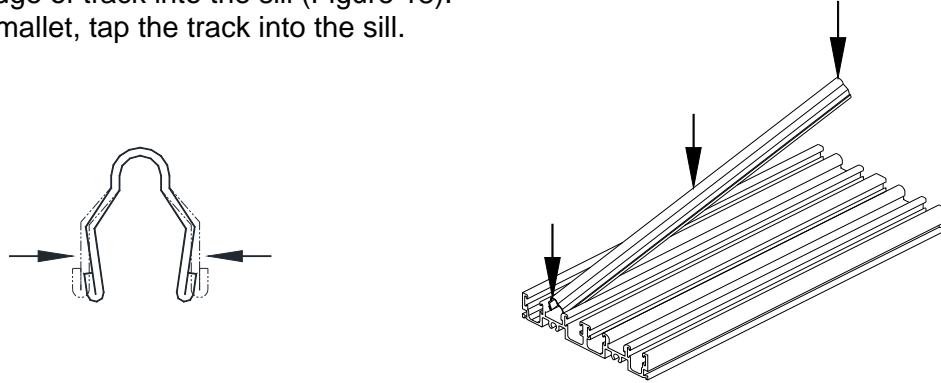
**Figure 16:**  
Door Head and Jamb Anchor Locations



**Figure 17:**  
Pocket Interlocker Options

### IX. Sill Track Installation

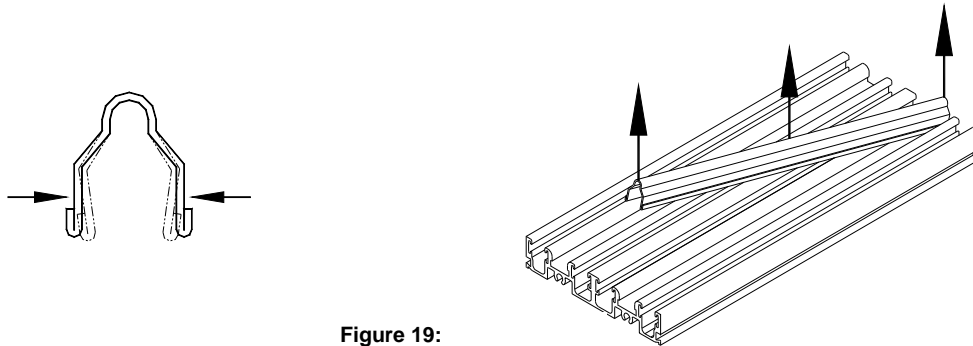
1. Using a pair of pliers, slightly squeeze one end of the track to create a tapered edge.
2. Push tapered edge of track into the sill (Figure 18).
3. Using a rubber mallet, tap the track into the sill.



**Figure 18:**  
Sill Track Installation

### X. Sill Track Removal

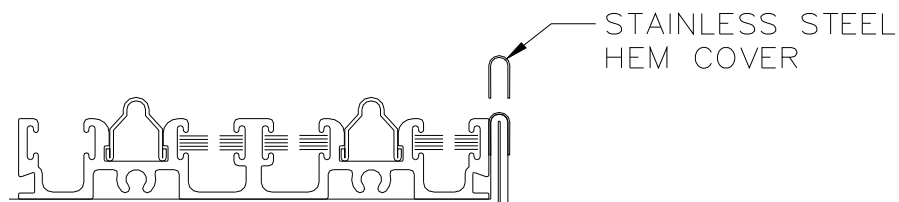
1. Using a pair of pliers, slightly squeeze the track together at one end and pull up (Figure 19).
2. Using a screwdriver, slowly pry the track out of the sill. Although you can reinsert the track, we recommend a new track be installed for optimal performance of sliding door.



**Figure 19:**  
Sill Track Removal

### XI. Aluminum Sill Pan Hem Cover Installation

1. Push the stainless steel hem cover over the inside water leg of the aluminum sillpan (Figure 20). The hem cover is used to improve the esthetics of the aluminum sillpan.



**Figure 20:**  
Sill Pan Hem Cover

## XII. Pocket Closer and Head Bumper Installation

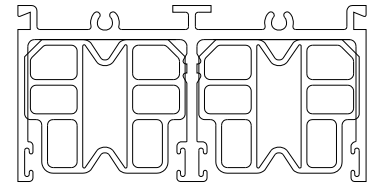
1. A head bumper (Figure 21) is required in the head of each sliding panel track unless the panels contain door collectors, wind load adapters or high performance extrusions. See the Multislide drawing provided at the time of the order for exact length and number of door bumpers required.
2. If no drawing is available, use a 2-5/8" long head bumper for PX and XP configurations. For configurations with two or more glass panels (PXX, PXXX, etc.) use a 2" head bumper in the track of the longest panel. To determine the length of the head bumpers for the remaining tracks measure the width of each panel. Subtract the measured panel width from the longest panel width plus the head bumper length for that panel (either 2" or 2-5/8").



**Figure 21:**  
Head Bumper

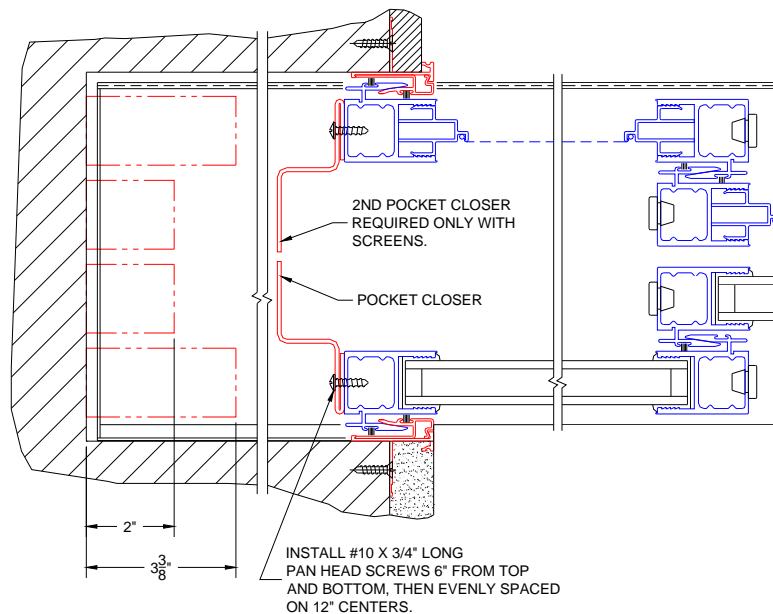
Example:

- Longest panel width is 47.00 plus the head bumper for that panel is 2.00, total equals 49.00.
- Subtract the measured panel width of other panels from the 49.00. (49.00 – 45.62 = 3.38)
- The 3.38 dimension is the required bumper length for that panel.



**Figure 22:**  
Head Bumper Installation

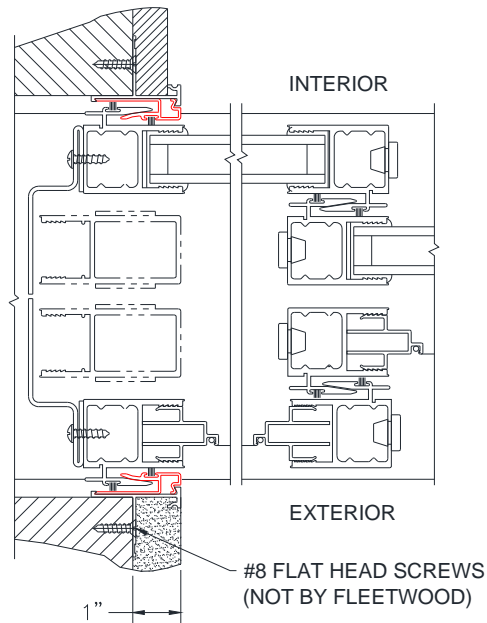
3. Install head bumpers into head (Figure 22).
4. Drill .136 diameter holes (#29 drill) thru pocket closer and one wall of interlocker. Holes to be located 6" from top and bottom of pocket closer, then evenly spaced on 12" centers. Assemble pocket closer to back side of interlocker with #10 x 3/4" long pan head screws (Figure 23).



**Figure 23:**  
Pocket Closer

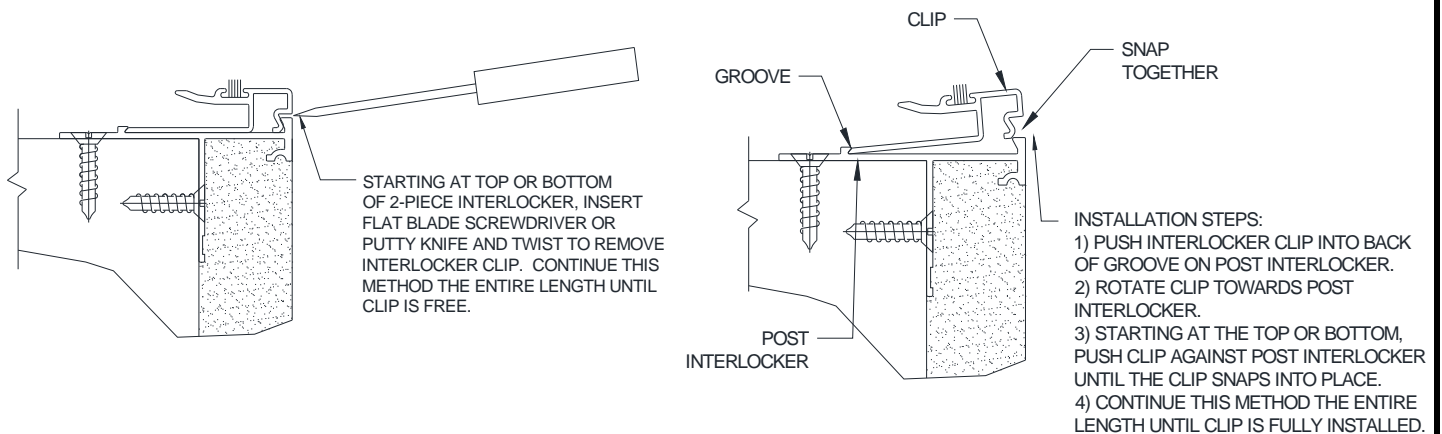
### XIII. Pocket Interlocker Installation

1. Assuming that all door and screen panels will be installed from the exterior, the interior pocket interlocker is installed before any screen or door panels.
2. Pocket interlockers are furnished net frame height and must be field cut.
3. Attach pocket interlocker(s) with #8 flat head screws, not by Fleetwood. Install screws 6" from top and bottom with additional screws on 18" centers (Figure 24).



**Figure 24:**  
Pocket Interlocker Installation

### XIV. Pocket Interlocker Clip Installation and Removal



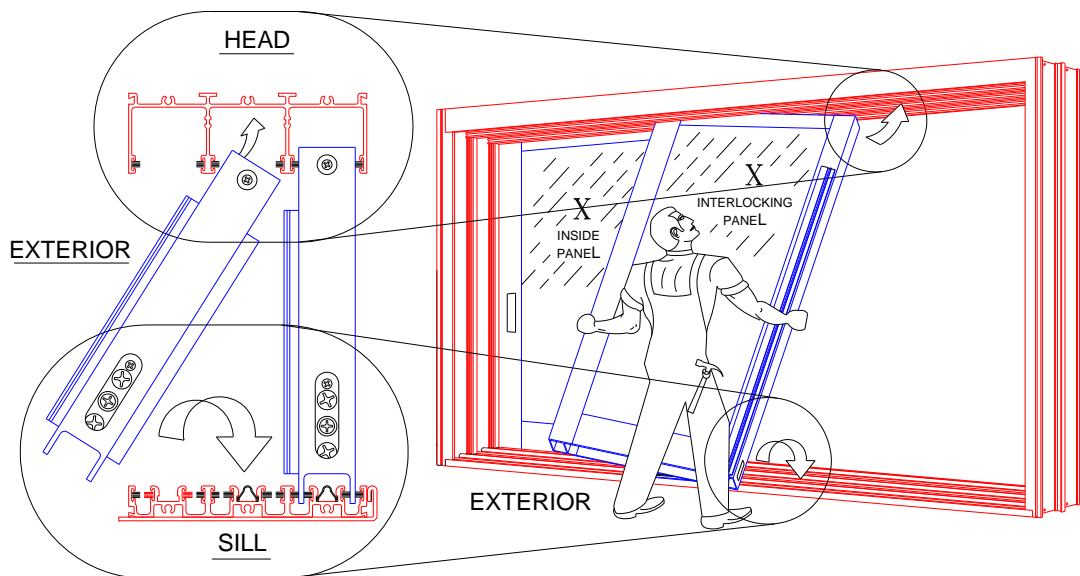
**Figure 25:**  
Pocket Interlocker Clip Removal

**Figure 26:**  
Pocket Interlocker Clip Installation

## XV. Panel Installation

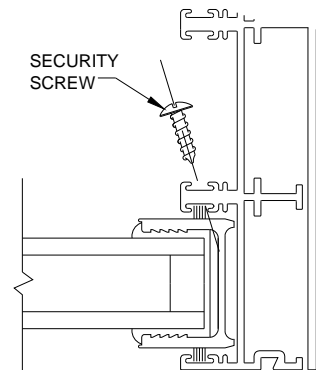
- Note:** a) Check customer order for proper panel configuration and orientation.  
b) Pocket walls: Installer to flash inside pocket walls to adequately protect from moisture.  
c) On pocket doors, installation of panels should be completed before construction of pocket is complete.

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 (Figure 27). Push up and swing the bottom inward until panel is vertical, then lower panel down onto the track. On PX or XP configurations, if the pocket construction has been completed, it may be necessary to remove the lead stile from the panel before installation into the frame can be accomplished.



**Figure 27:**  
Panel Installation

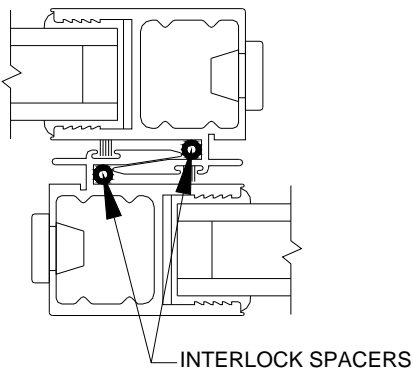
- **“X” Panel-** Do not attempt to slide the panel unless the rollers have been adjusted. Adjust the rollers as needed to make the panel plumb and level. Before adjusting rollers, lift panels to relieve weight. If the panel contains a lock stile, verify that the latch height is correct for proper operation with the frame. Insert vinyl plugs into the holes at top and bottom of the panel.
- **“O” Panel-** 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. Installing the fixed panel security screw: Using a 1/16” diameter bit, drill a hole into the fixed stile through the hole shown in Figure 28. Then insert a black #8 x 3/4” self threading screw.



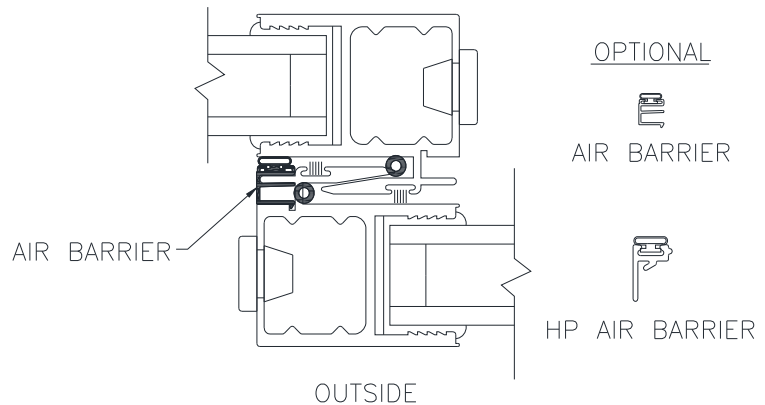
**Figure 28:**  
“O” Panel security screw

**Note:** Installer to notch jamb filler to avoid damage that may occur from security screw

3. On pocket doors with an exterior pocket interlocker, move panel into the closed position; otherwise move panel into the wall pocket.
4. Repeat steps 2-3 until all panels have been installed. Panels must overlap during installation to allow proper engagement of interlockers (Figure 29).
5. Verify that all panels with interlocker hooks engage properly. If lead stile panel is not engaging properly with the jamb or meeting stiles, remove interlock spacers as necessary (Figure 29).

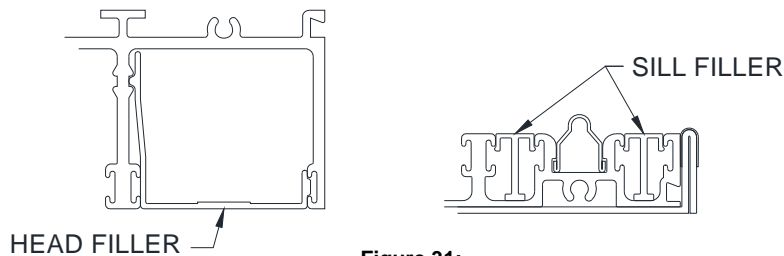


**Figure 29:**  
Proper Engagement of Interlockers



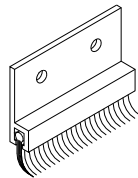
**Figure 30:**  
Optional Air Barriers

6. Optional: 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 30).
7. Head Fillers and Sill Fillers:
  - a. Series 3070: Install Head Fillers into the head tracks and Sill Fillers into the sill tracks except where the Fillers interfere with the sliding panels (Figures 31).
  - b. Series 1070: Install Head Fillers into the "O" panel head tracks and Sill Fillers into the "O" panel sill tracks (Figures 31).



**Figure 31:**  
Head Filler and Sill Filler

8. Optional: After all panels have been adjusted plumb and level and panels close and lock, open panels and install brush air barriers. Brush air barriers (Figure 32) are attached to the bottom of all sliding interlockers and secured with (2) #6 x 3/8" long, TEK screws.



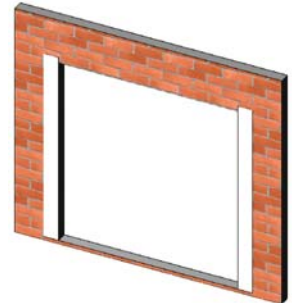
**Figure 32:**  
Head Filler and Sill Filler

## XVI. Flashing After Installation

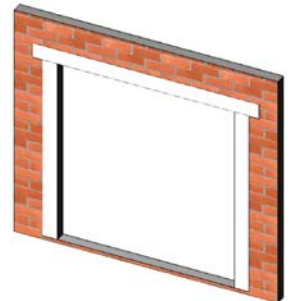
The flashing paper referred to in this document is Moistop or other code compliant flashing material that conforms to **Federal Specification UU-B-790a, Type 1, Grade A, Style 4**. The strips of flashing paper are to be no less than 9 inches wide (or wider as required by local codes). Flashing paper must be applied with galvanized nails or corrosion resistant staples. Flashing paper shall be applied in a weatherboard fashion around the full perimeter of the framed opening.

1. Once satisfied that the frame is water tight, and immediately prior to application of the flashing paper at the head and jambs, apply a continuous bead of sealant to the exposed mounting flange (nail-fin) at the top (head) and sides (jambs) of the installed frame. Also, apply sealant at corners of the frame, the full length of the seams where the nail fin flashing is mounted.
2. At each jamb, embed the flashing paper into the sealant onto mounting flange and fasten into place. The flashing paper should be cut sufficiently long enough to extend at least 3 in. past the weep-screed or diado flashing and at least 6 inches above the head of the window (Figure 33).
3. Finally, at the head, embed the flashing into the sealant on the mounting flange and fasten into place. The flashing paper should be cut sufficiently long enough to extend past the flashing paper at each jamb by at least 3 in (Figure 34).
4. Weather resistant building paper should be applied in a weatherboard fashion to complete the installation (Figure 35).

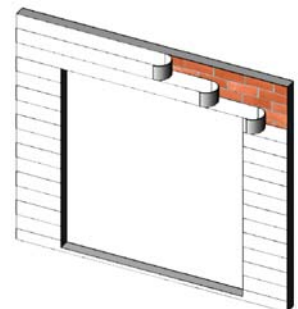
**Note:** Where weather resistant building paper, insulating board, or other materials by other trades may constitute the primary weather barrier behind the exterior wall finish (i.e. stucco, masonry, siding, etc.), the owner / General Contractor are responsible to ensure that the weather barrier is continuous by effectively sealing the material to the window frame.



**Figure 33:**  
Jamb flashing



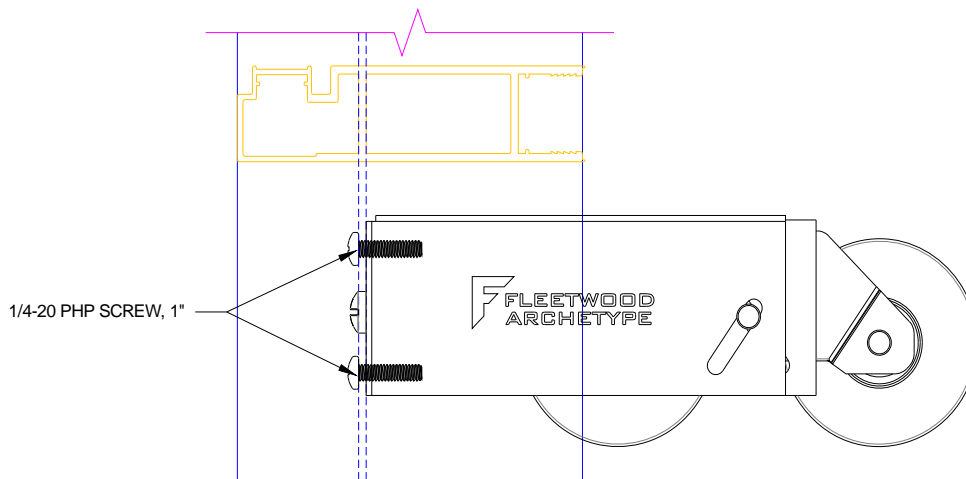
**Figure 34:**  
Head Flashing



**Figure 35:**  
Building Flashing

**Appendix A: 90° Lead Stile Roller Attachment (When panels are KD)**

1. Remove the roller closest to the 90° lead stile from the bottom rail. Discard the attached screws.
2. Attach the roller to the 90° lead stile using 1/4-20 PHP Screws, 1" long located in the red bag (Figure A1).
3. Guide the roller into the bottom rail and secure using a #10 FHP screw, 5" long located in the red bag.



**Figure A1:**  
90° Roller Attachment