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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 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, Soft mallet, Plumb bob / line, Flat head screwdriver, Laser Level or 8' level, Shims, Nails, Screws, Sealant, caulk gun, Backer Rod, Scissors or utility knife, hex keys, drill bit, drive bit and powered drill.

Sealant Requirements

- The sealant referred to within this document for seals associated with the assembly of the product should conform to **AAMA 800-16**. It is recommended that all other sealants should also conform to **AAMA 800-16** but may be a sealant recommended and approved by the sealant manufacturer that is compatible with the framing, finish and surrounding materials.
- All sealant bead sizes must conform to the sealant manufacturers' size requirements.
- The Owner / General Contractor is responsible for identifying the need for any additional sealant to be applied by others. Such sealant shall be elastomeric material, with the framing, finish and surrounding materials.

Anchor Instructions

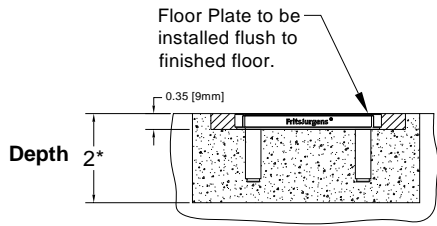
- Structural engineer to determine anchor quantity and spacing for design load requirements.
- Review panel pressure loads and lateral force with flooring manufacturers specifications.
- Proper material must be used between all dissimilar materials (i.e. block/concrete & aluminum).

III. Assembly and Installation

It is essential that each Fleetwood product be assembled and glazed in accordance with AAMA standards and factory instructions. It is the installer's responsibility to ensure that each Fleetwood product is assembled, glazed and installed and completely sealed to ensure that the product is leak-free and operates correctly. **Installation of Fleetwood products must be in accordance with the standards set forth in ASTM E 2112.** If there are any questions regarding the installation of a Fleetwood product contact the factory customer service department.

Due to inherent manufacturing tolerances Fleetwood has provided this product with recommended field glazed weather-stripping. If the provided weather-stripping does not ensure an optimum fit of glass to frame the Fleetwood Authorized Dealer should contact Customer Service for an expedited NO CHARGE shipment of replacement weather-stripping.

IV. Arche-Duct Block Out



* Minimum depth required for Arche-Duct. Additional depth may be required for drainage setup. Side drains sit 3/16" below bottom of Arche-Duct.

Figure 1:
IRC Arche-Duct Opening (Side View)

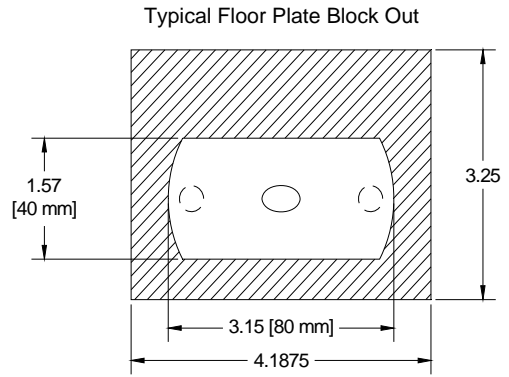
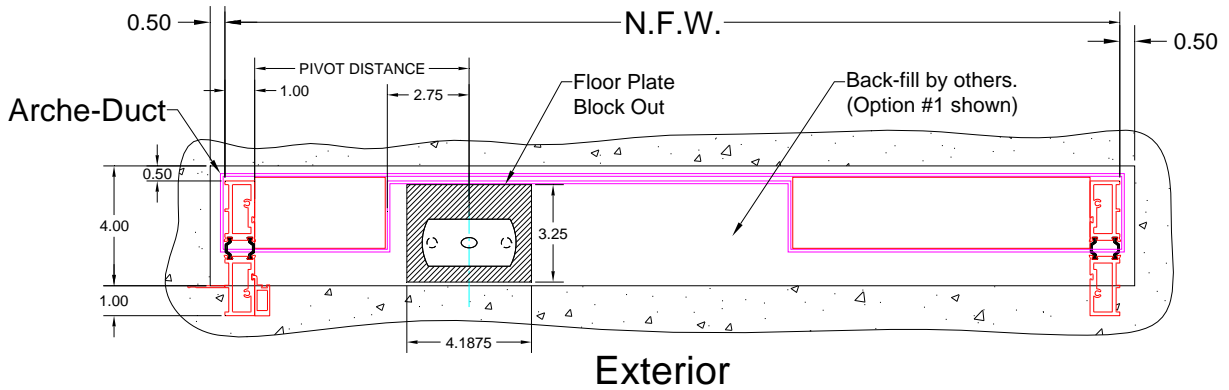
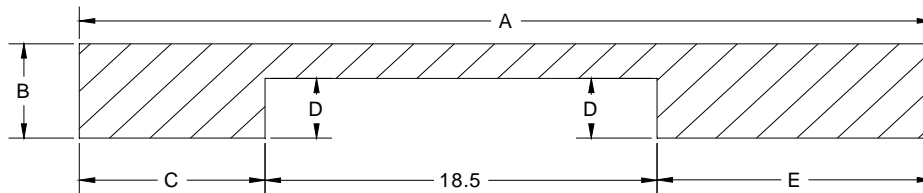


Figure 2:
IRC Floor Plate Block Out (Top View)



Arche-Duct Block Out

Option #1
(Additional blocking for Floor Plate may be required)



OR

Option #2

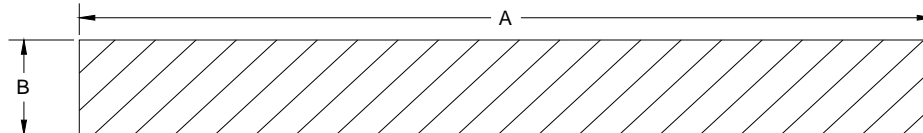


Figure 3:
Arche-Duct Block Out (Top View)

Table 1: Arche-Duct Block Out Dimensions

A	B*	C	D*	E
N.F.W. + 1.00"	4"	Pivot Distance - 0.75"	3"	A - (C+18.5")

* = Add 1.5" to exterior and interior spacing for tab option.

V. Opening, Frame and Panel Verification

1. Check the measurement of the rough opening and verify that the door frame and Arche-Duct will fit into the opening. Measure all four sides of the opening to make sure it is 1/2" larger than the doors in width and 1/4" in height.
2. Verify the opening is plumb and level (Figure 4).
3. Verify location / dimension Arche-Duct opening (see Figure 3 & Table I).
4. Remove the frame(s) from the packaging and lay it in front of the opening. Check door net frame width / height dimensions and verify pivot distance (per order).

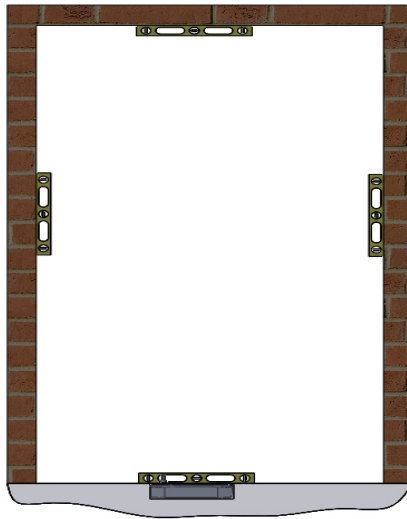


Figure 4:
Level Locations

VI. Frame Assembly

Note: Failure to assemble the frame according to the installation instructions, nullifies warranties related to this product.

- Apply a compatible sealant to the corners of the frame. Assemble the frame with screws provided (Figure 5).

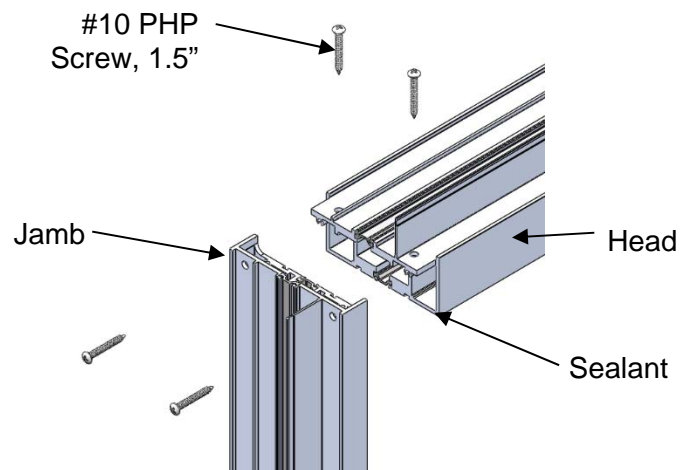


Figure 5:
Frame Assembly

VII. Nail-fin Frame Installation

Note: Fleetwood recommends the use of a laser level or 8' level for frame installations. Cross-measure within $\pm 1/32"$ for interior and exterior.

1. Seal frame and vent joints completely with compatible sealant.
2. Insert the frame into the Arche-Duct. Cross-measure and adjust to achieve a plumb square and level condition. Shim where needed. Seal all fastener heads with compatible sealant.
3. Secure Top pivot to header with #10 screw min. 4" long (not by Fleetwood). See Figure 6 for illustration.
4. Floor Plate Installation see Section IX.

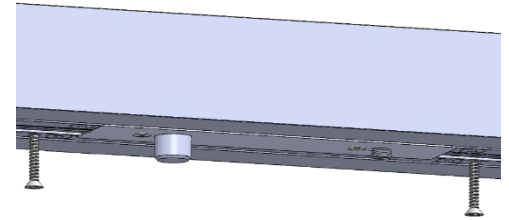


Figure 6:
Securing Top Pivot
(Block Frame Shown)

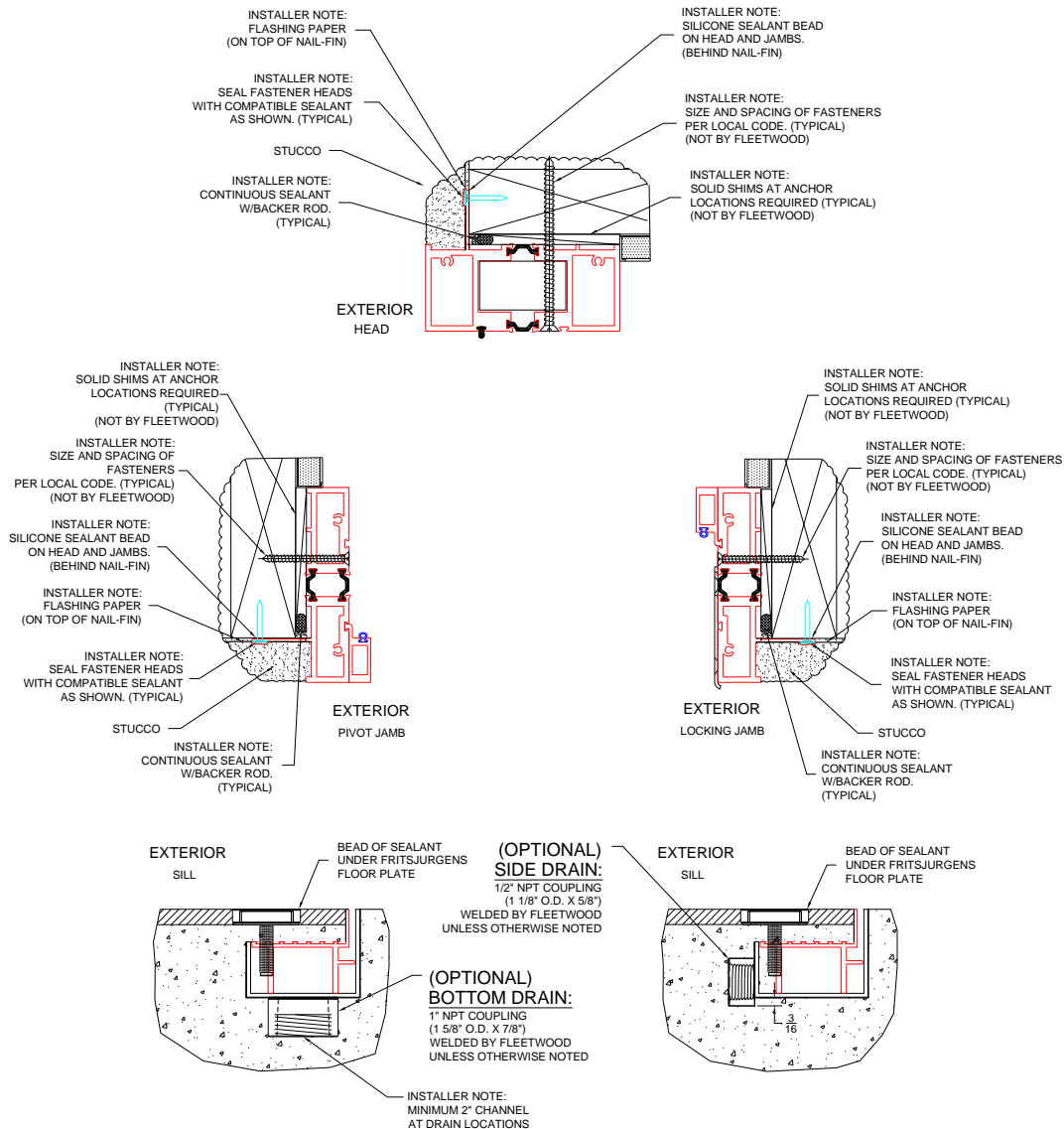


Figure 7:
IRC Nail-fin frame installation

IX. Floor Plate Installation

CAUTION: Review flooring structural specifications prior to installation. When drilling into a wood substrate use a 19/64" drill bit, others use a 5/16" drill bit.

1. Use a plumb line to center the floor plate location with the top pivot pin (Figure 10).

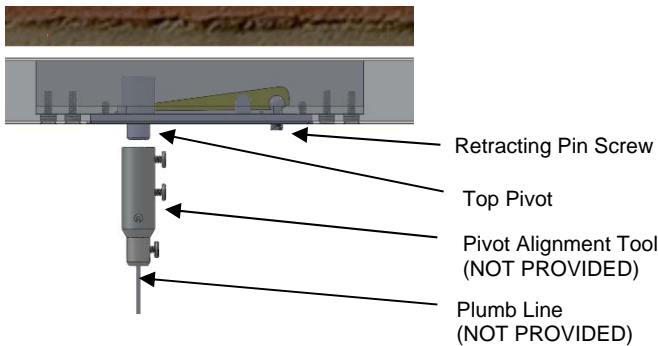
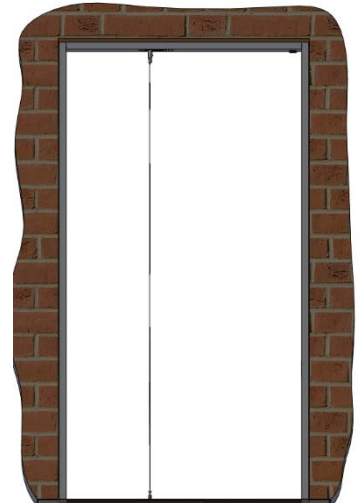


Figure 10:
In-line Verification



2. IRC floor plate (red bag attached to frame) to be mounted flush to finished floor, backfill after installation (Figure 2).
3. The center of the floor plate is to be set back 2-1/16" from the interior face of the jamb and level (Figure 11).
4. Use a plumb line and the provided template to center the floor plate with the top pivot. Mark the hole locations of the floor plate with a pencil (Figure 12).
5. Remove template and drill 1.25" deep (see caution note for drill bit size). Clean away the excess debris.
6. Each door is provided with one tube of sealant (red bag attached to frame) and has a 6-month shelf life. DO NOT OPEN until ready for floorplate installation. Apply the sealant into the holes drilled and the bottom of the floor plate (Figure 13).
7. Using a soft mallet, secure the floor plate into the drill holes (Figure 13). Allow 24 hours to cure.
8. To fine tune the radial position of the floor plate see Figure 14.
9. Note: Backfill Floor Plate after panel and glazing installation / adjustments are performed.

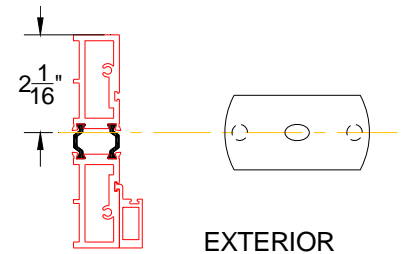


Figure 11:
Floor Plate Positioning

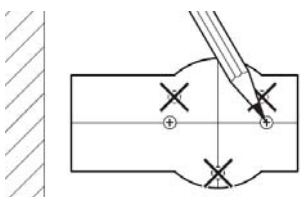


Figure 12:
Floor Plate Positioning Template

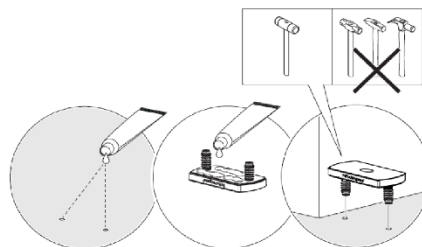


Figure 13:
Securing the Floor Plate

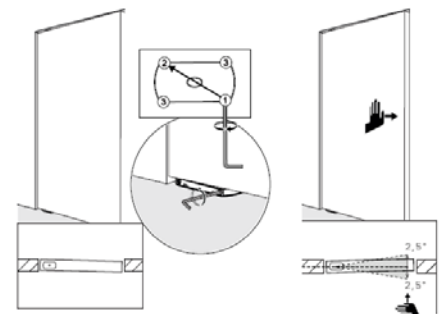


Figure 14:
Radial Adjustment

X. Panel Installation

- **Panel Squaring** (troubleshooting tip) see Appendix A.
- **Handle Pull Installation** see Appendix B.
- **Closing Speed Adjustment** see Appendix C.

1. Retract top pivot pin by turning retracting pin screw counter clockwise (Figure 15).
2. Confirm the sweep adjustment pin (located on the side of the panel) is fully closed by turning the pin clockwise.
3. Ensure the closer is orientated correctly for installation with the Floor Plate, arrow should point to the closing side of the door (Figure 16). If needed, remove floor closer from bottom rail and use floor plate (installed or with leverage) to orientate correctly.

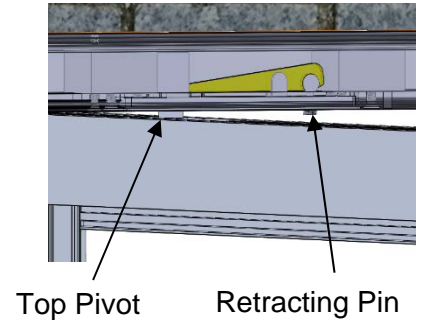
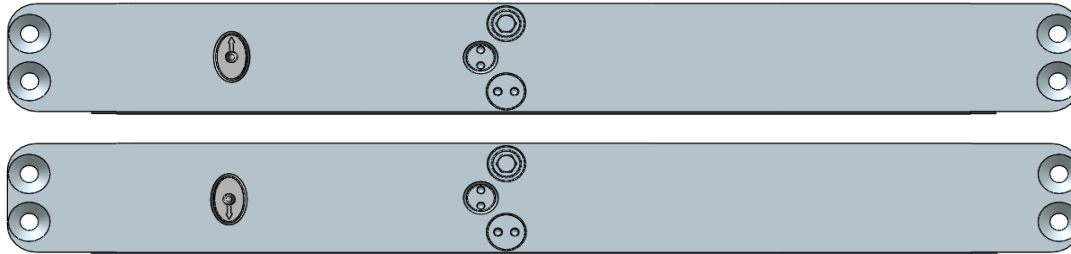


Figure 15:
Top Pivot Locking



CORRECT
Pivot Right Outswing
Pivot Left Inswing

CORRECT
Pivot Right Inswing
Pivot Left Outswing

Figure 16:
Closer Orientation (Bottom View Shown)

4. Place the panel perpendicular to the frame and lift into the opening.
5. Align panel closer with Floor Plate and lower.
6. Align the two portions of the top pivot and turn the retracting pin screw clockwise (Figure 15).

CAUTION: The drop sweep is designed to form a seal with the door in a closed position when pressure is put on the activation pin. **Over adjustment will prevent the door from closing, damaging the sweep and voiding warranty.**

7. Once satisfied the panel is square and aligned with the frame properly, adjust the bottom sweep pin by turning the screw a 1/2 turn counter clockwise then opening and closing the door ensuring a seal is formed between the finished floor and panel (when the panel is in the closed position). Repeat as necessary.
8. The installer is responsible for the integrity of all framing joints after installation and must therefore water test all joints to guarantee a completely sealed product. Apply joint sealer and/or sealant necessary to ensure watertight joints. Retest as necessary.
9. To complete the installation, apply backer rod and a complete bed of sealant to the entire exterior and interior joint between the frame and the building structure. Tool the sealant to eliminate bubbles, voids and / or breaks and ensure a completely watertight seal (Figure 7,9).
10. Note: Backfill Floor Plate after panel and glazing installation / adjustments are performed.

XI. Glazing Instructions per Glass (Skip if panel is factory glazed).

1. Remove the precut glass stops from the frame, making sure to note the location from which each has been removed. Each stop is cut for a specific location and must be returned to the same location after the glazing process.
2. Before glazing, apply a 1/4"x1/4"x6" bead of compatible sealant from each corner on inner flange of panel (Figure 16).

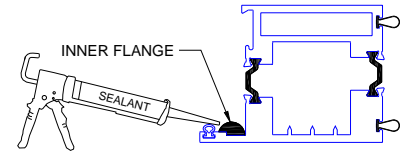


Figure 16:
Sealant Location (Top Rail Shown)

Note: For panel heights over 8 feet tall Fleetwood recommends an additional 24" of compatible sealant be applied halfway up on the vertical

3. Insert the setting blocks (red bag) according to the image that more closely resembles the product (Figure 17 or 18).
4. Stagger setting blocks accordingly to support glass lites at the bottom pivot location.
5. Insert glass into panel.
6. Cross-measure to ensure the panel is square. See Appendix A for troubleshooting tip on how to square the panel.
7. Finish assembly by inserting the two horizontal glass stops then install the two vertical glass stops.
8. Note: Backfill Floor Plate after panel and glazing installation / adjustments are performed.

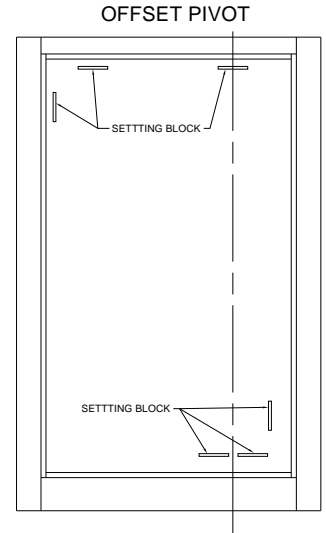


Figure 17:
Offset Pivot Location Setting Blocks

Alternate Glazing Procedure

Note: Applies to outside glazed where additional water sealant is required.

1. Apply a continuous 1/4"x1/4" bead of sealant before glazing. (Figure 16).
2. Insert the setting blocks (red bag) according to the image that more closely resembles the product (Figure 17 or 18).
3. Stagger setting blocks accordingly to support glass lites at the bottom pivot location.
4. Insert glass into panel.
5. Cross-measure to ensure the panel is square. See Appendix A for troubleshooting tip on how to square the panel.
6. Insert the two horizontal glass stops then install the two vertical glass stops.
7. Apply a bead of compatible sealant along the glass and glass stop edge.
8. Note: Backfill Floor Plate after panel and glazing installation / adjustments are performed.

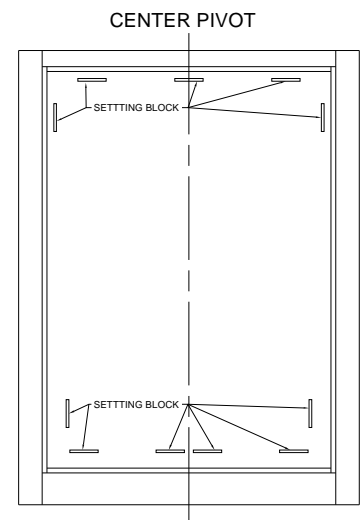


Figure 18:
Center Pivot Location Setting Blocks

XII. 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 19).
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 20).
4. Weather resistant building paper should be applied in a weatherboard fashion to complete the installation (Figure 21).

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.

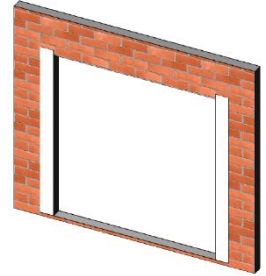


Figure 19:
Jamb flashing

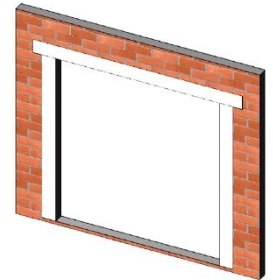


Figure 20:
Head Flashing

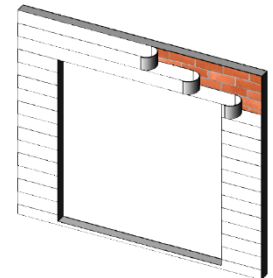


Figure 21:
Building Flashing

Appendix A: Panel Squaring

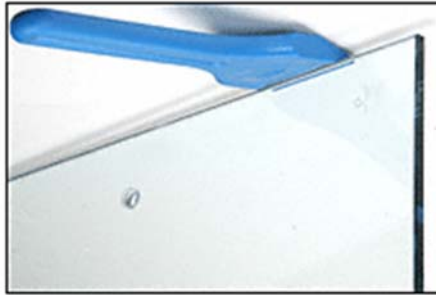


Figure A1:
Glass Lifting Tool

Required Tools: 9/16" wrench, pliers, tape measure, shim, plate glass lifting tool.

1. If panel hits the sill due to the weight of glass/panel.
 - a. Make sure the frame is squared before any adjustment to panel.
 - b. If the problem is solved, stop here.
 - c. Lay panel on table and check distance of both diagonals. If they are not the same, the panel is not square.
 - d. Loosen nuts at 4 corners (2 turns), use plate glass lifting tool and add additional shim(s) to the top of the panel opposite of the pivot, between the glass and vent top rail.
 - e. Check diagonal distances, gap of panel to frame.
 - f. Tighten corner key nuts.
2. If panel hits the head.
 - a. Make sure the frame is squared before any adjustment to panel.
 - b. If the problem is solved, stop here.
 - c. Lay panel on table and check distance of both diagonals. If they are not the same, the panel is not square.
 - d. Loosen nuts at 2 top corners (2 turns), use plate glass lifting tool and remove/replace with thinner shims to the top of the panel opposite of the pivot, between the glass and vent top rail.
 - e. Check diagonal distances, gap of panel to frame.
 - f. Tighten corner key nuts, insert thermal barrier back.

Appendix B: Hardware Locations

The following are latching hardware locations to avoid when installing **surface mount handle pulls**.

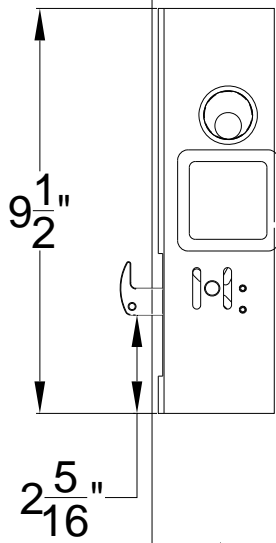
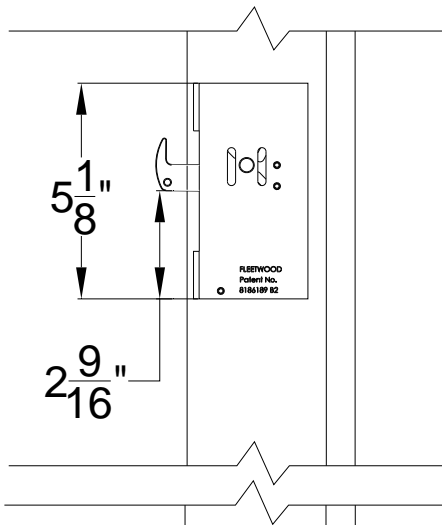


Figure B1:
 Archetype Latch and Secondary Latch

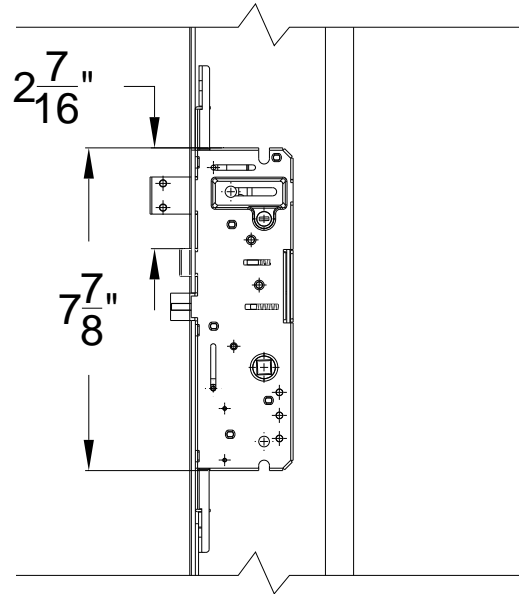


Figure B2:
 5 Point Latch

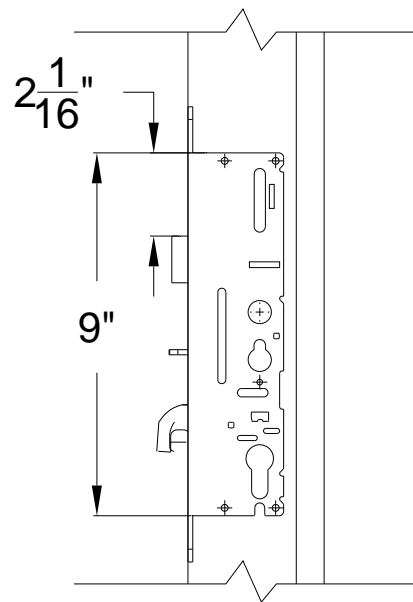


Figure B3:
 1 Point Latch

Appendix C: Adjusting Closer Speed

To adjust the closer speed remove the panel and turn the closer adjustment pin with a flat head screwdriver. See images below for more details.

Clockwise will reduce the closing speed.



Counter-Clockwise will increase the closing speed.

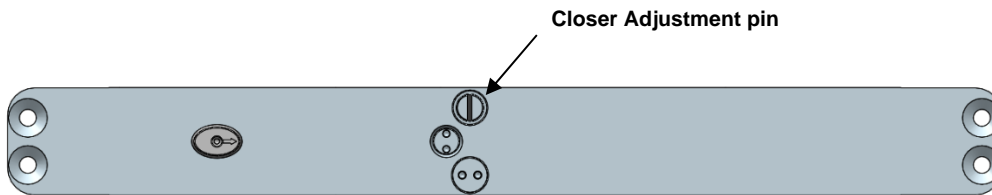


Figure C1:
Closer Adjustment Pin