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## I. Care and Maintenance

This product is factory finished, 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, Screws, Screw Gun, #2 Phillips Bit, T25 Torx Bit, Power Drill, Sealant, Structural Sealant, Caulk Gun, Backer Rod, Utility Knife, Rubber/Plastic Mallet, Pliers, Wax.

### Sealant Requirements

- The sealant referred to within this document for seals associated with the assembly of the product should conform to **AAMA 800**. It 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, size, and spacing for design load requirements.
- Proper material must be used between all dissimilar surfaces (i.e. block/concrete & aluminum).

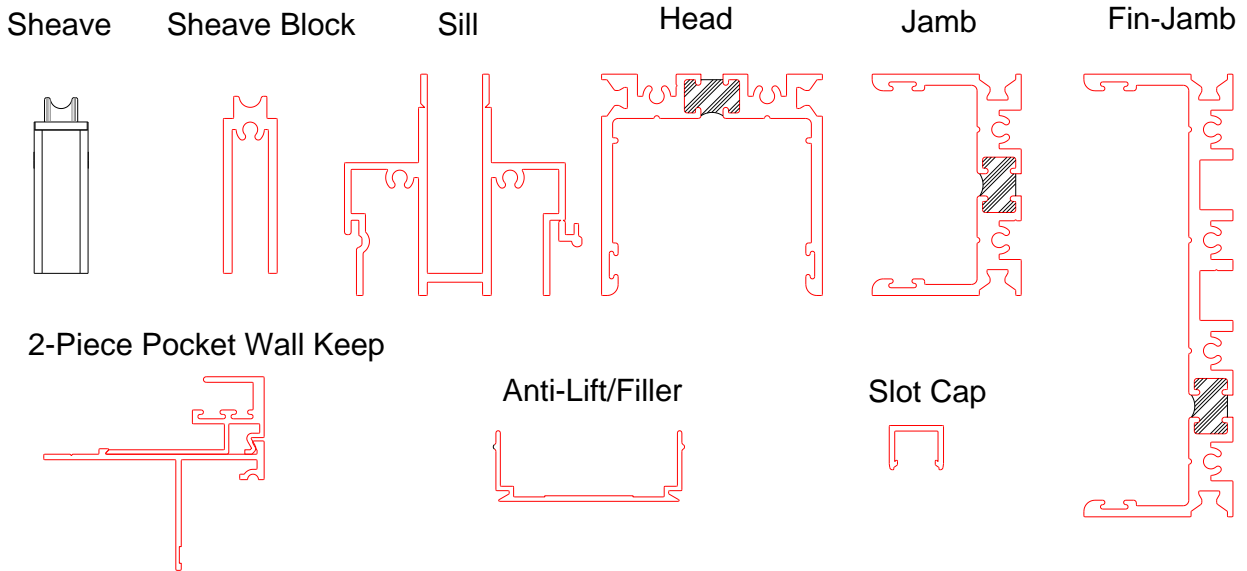
## III. Assembly and Installation

**Note:** Add tube wax lubricant to the ends of all fasteners to reduce the drive torque required for installation, apply a small amount of tube wax to the head of the fastener to assist with installation.

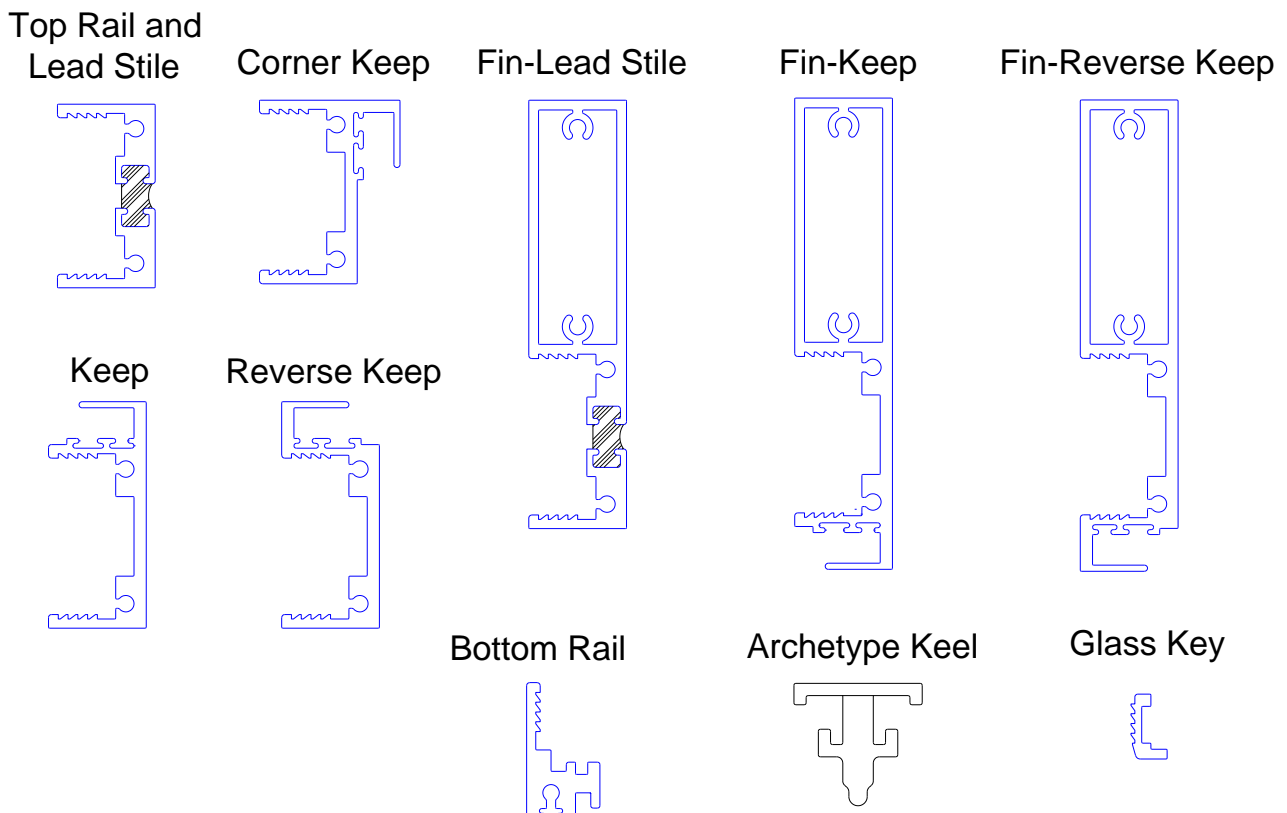
**It is essential that each Fleetwood product be assembled and glazed in accordance with AAMA standards and factory instructions.** It is the installer's responsibility to ensure that each Fleetwood product is assembled, glazed and installed and completely sealed to ensure that the product is leak-free 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.

**IV. Terminology for EDGE | s | parts**

**Frame Components**



**Panel Components**



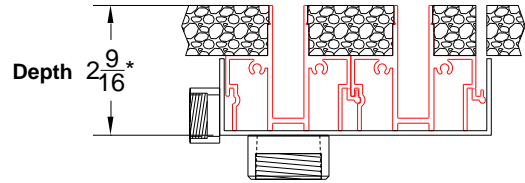
**V. Arche-Duct Block Out**

**Option #1: Close Fit block out**

- Refer to dealer drawing, add a 0.5" space around all tracks and jambs. For the depth of the block out see Figure 1.

**Option #2: Generic block out**

- A: N.F.W.+1"
- B: (# of tracks x 2.5") + 1".
- For the depth of the block out see Figure 1.

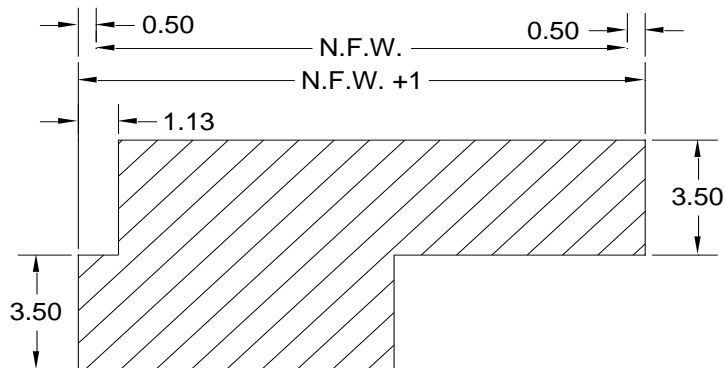


\* Minimum depth required for Arche-Duct. Additional depth may be required for drainage setup. Side drains sit 3/16" below bottom of Arche-Duct.

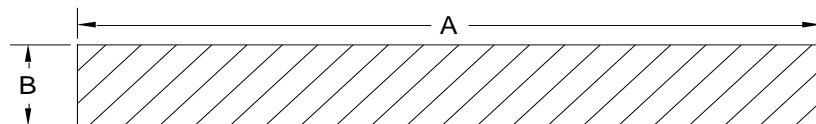
**Figure 1:**  
 Arche-Duct Depth (Side View)

**Arche-Duct Block Out**

Option #1  
 (OX Shown,  
 will vary per  
 configuration)



Option #2



**Figure 2:**  
 Arche-Duct Block Out (Top View)

**CAUTION: If combining EDGE | f | fixed system- see Appendix A**

## VI. Structure Verification & Arche-Duct Installation

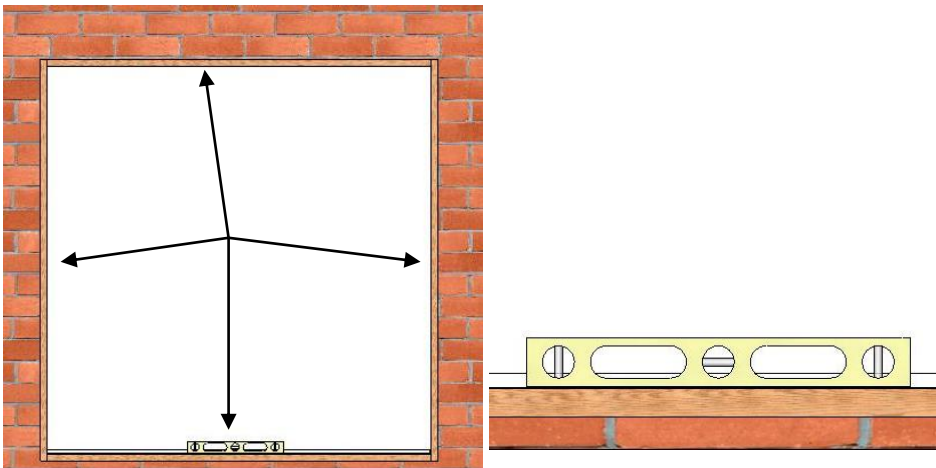
**Note:** If the factory provided Arche-Duct drain system is not desired, the product warranty will remain intact if the substitute system emulates the essential factory design.

### 1. Opening Verification

- Check the measurements of the opening and verify that the door will fit into the opening. Measure all four sides of the opening to make sure there is a clearance of 1/2" in width and 1/4" in height (Figure 3).
- Remove the door(s) from the packaging and lay it in front of the opening. Check width and height dimensions.
- Verify the opening is plumb and level (Figure 3).

### 2. Pre-Fit and Leveling

- Place the Arche-Duct drain system into the opening and determine any leveling that must be done prior to installation (Figure 1). Prepare relief areas for the PVC drain flange(s).
- Shim as necessary to stabilize the entire depth and length of the Arche-Duct. No unsupported width of more than 8" is allowed. Shim to be load bearing, non-porous, non-absorbent and inorganic.
- 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.

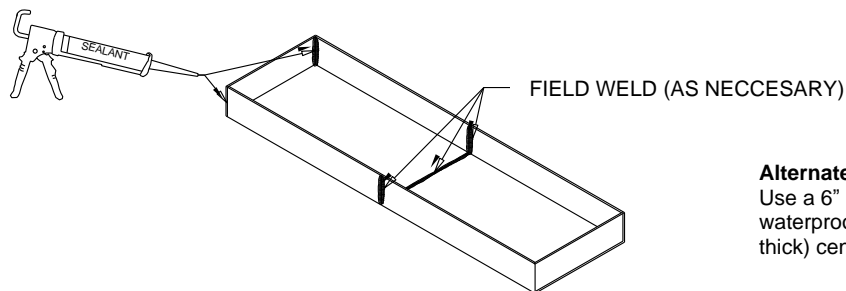


**Figure 3:**  
Use level to determine if the opening is plumb and level

### 3. Arche-Duct Installation

**Note:** Multiple piece Arche-Duct sections require field splicing.

- It is necessary to use an insulating material between the outer edge of the Arche-Duct and the rough opening. Direct contact with grout, concrete, or dissimilar metal can lead to corrosion of the Arche-Duct pan.
- Apply sealant in all corners and seams of the pan (Figure 4).



**Alternate Joining Method:**  
Use a 6" piece of adhesive waterproof material (max 1/16" thick) centered on the joint.

**Figure 4:**  
Seal corners and seams

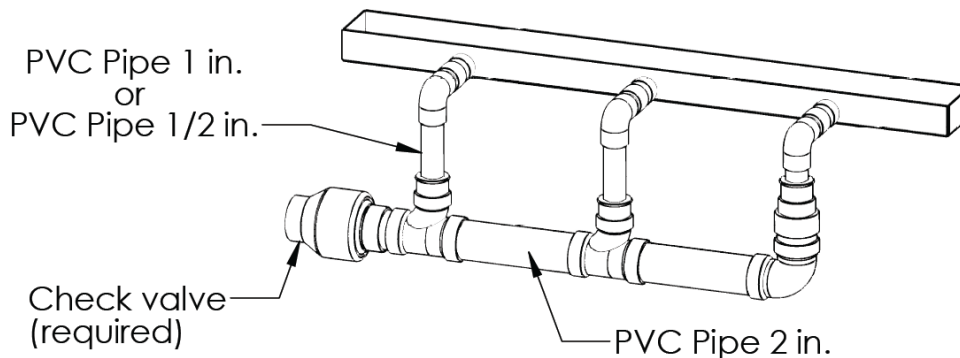
### 4. Arche-Duct Water Test

**Note:** Installer responsible for verifying the integrity of the Arche-Duct for water leakage and performance.

- Block all drain outlets and fill the Arche-Duct with water to verify the integrity of all seams and drain connections. Look for leak points, the water level of the Arche-Duct should remain constant. If the Arche-Duct passes water test, drain Arche-Duct and continue with installation of frame.

### 5. Arche-Duct Install

- Confirm proper orientation of Arche-Duct for tracks and drain location with customer order and/or dealer drawings.
- Install Arche-Duct into already leveled opening. An insulating material should be placed between the Arche-Duct and the supporting structure (concrete, steel, etc.) to prevent corrosion of the aluminum Arche-Duct.
- Connect tubing or pipe to Arche-Duct drain connections.



**Figure 5:**  
Drain Pipes Connected (side drains shown)

## 6. Confirm Weeping Slots

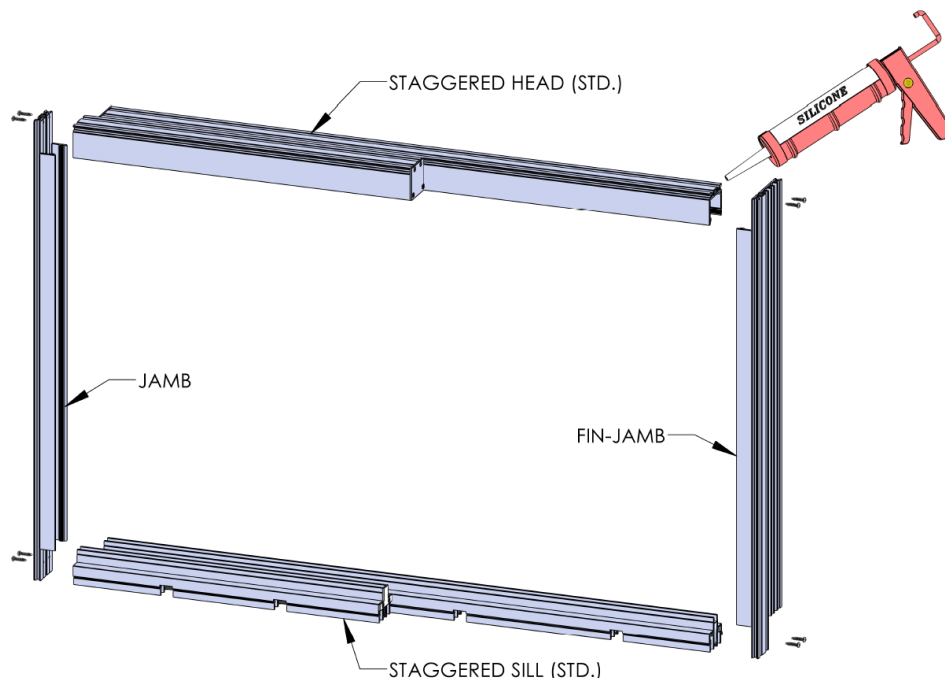
- Weep slot locations should be 8" from the ends and less than 60" (equally spaced) for proper drainage.

## 7. Backfill

- Do not back-fill until door operation is fully tested, including locking into jamb(s) and locking into pocket keep (when applicable).
- Verify that there is access to drainage connections and clean out as necessary.

## VII. 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.



**Figure 6:**  
Frame Joint Sealing (2 tracks shown w/ Fin-jamb Option Chosen)

1. Check with customer order and/or dealer drawings to ensure left and right jamb orientation. Note that the sill slot drain is to the interior (Figure 7).
2. Remove all pre-installed screws from head and sill.
3. 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 6.
4. Attach the jamb(s) to the head using #10 x 1.5" long pan head screws. Check that the screws pass through jamb(s) and into the screw raceways in the head. It is recommended to add wax to the threads of all fasteners to reduce the drive torque.
5. Attach the jamb(s) to the sill using #10 x 1.5" long pan head screws. Check that the screws pass through jamb(s) and into the screw raceways in the sill. It is recommended to add wax to the threads of all fasteners to reduce the drive torque.

**VIII. Frame Installation**

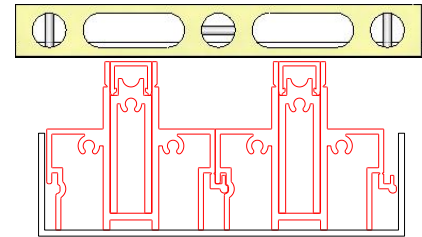
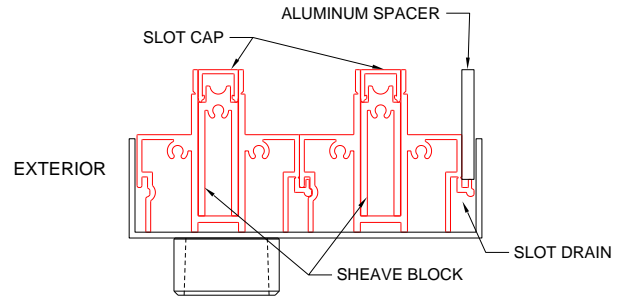
The drainage duct must be flushed prior to installation to remove any blockages that may have occurred during the construction process.

1. Pre-fit the frame into the opening (*ensuring orientation is correct*), start by placing the sill into the Arche-Duct as shown in Figure 7.
2. Cut to length (as necessary) and insert aluminum spacer into slot drain along the full width of the slot and along the edges of a staggered system. This will help protect from debris buildup that may occur during the construction phase.

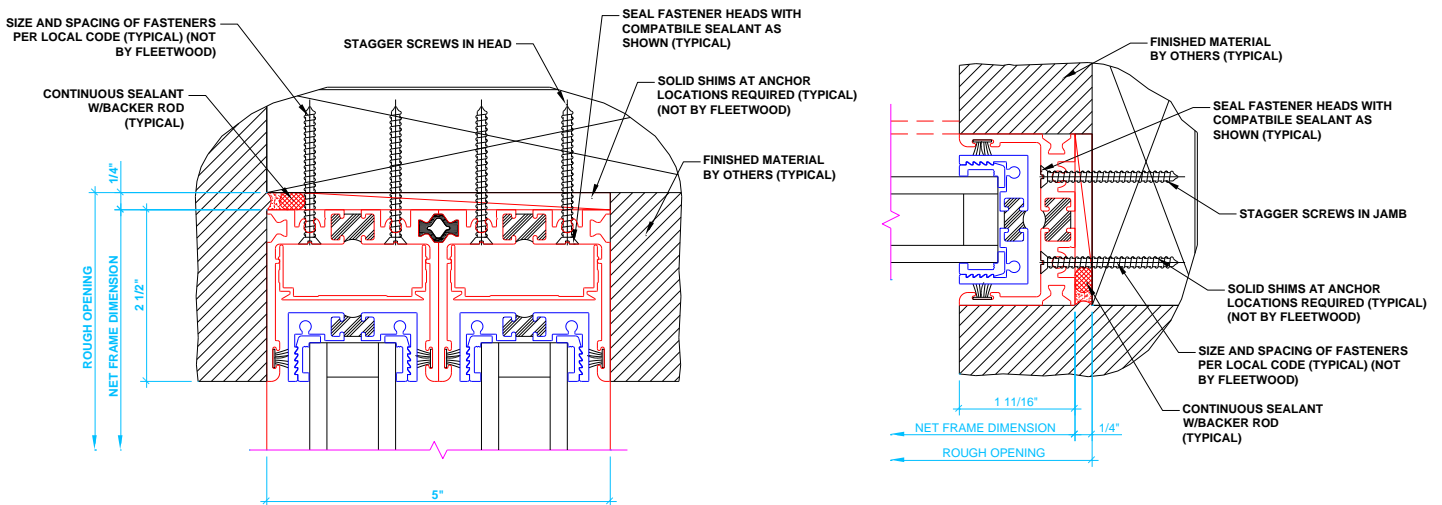
**Note:** The aluminum spacer is to be removed after the flooring is finished to ensure proper drain spacing is preserved.

3. Confirm that the frame is centered and square, sill is level (left, right, exterior and interior, Figure 7) and jambs are plumb, all adjustments must be made at this stage as there is no leveling capabilities of the panels. Once the fit has been confirmed, attach frame to structure as shown below (Figures 8).

**Note:** Blocking, stainless steel screws (recommended), and wall finish not furnished by Fleetwood. Frame installation anchors furnished by installer. Fleetwood recommends countersink of all anchor screws.



**Figure 7:**  
Sill Placement (2 tracks shown)



**Figure 8:**  
Typical Frame Installation  
(Head shown on the left, Jamb shown on the right)



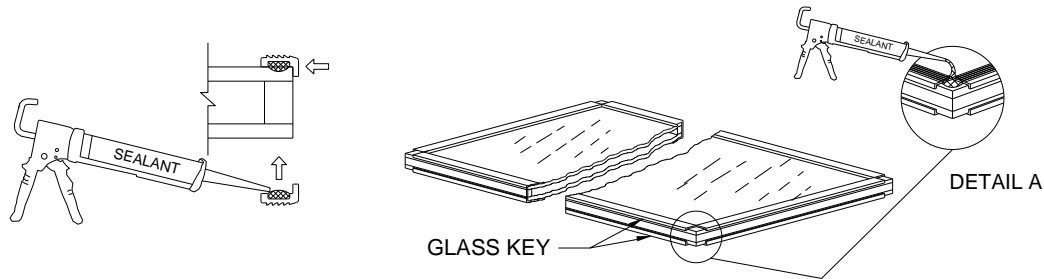
### IX. Glass Key Assembly (If Not Factory Glazed)

**Note:** If shipped loose, installer to size and cut.

1. Place 0.25" x 0.25" bead of structural sealant along middle of glass keys.
2. Press the glass key to the face of the glass. The key needs to be placed firmly against the edge of the glass (Figure 9). This is most easily achieved by pressing at a 45° angle onto the glass. Leave a 9/16" gap from the perpendicular sides of the panel to allow for extrusions to be removed / installed easily.
3. Repeat the procedure for all sides top and bottom of the glass.
4. Apply a bead of sealant that is compatible with the insulated glass seal to all four **exterior** corners as shown in Detail "A".

**Notes:**

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

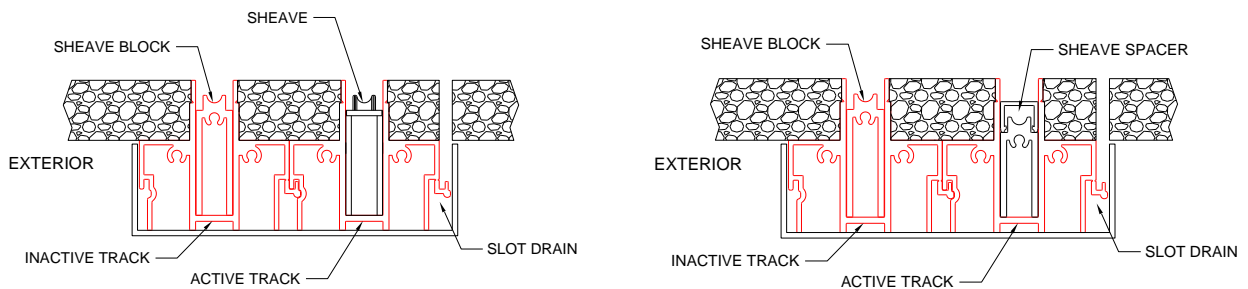


**Figure 9:**  
Glass Key Application

### X. Sheave Installation

Prior to the panel installation, the sheave blocks/slot caps in all active panel locations must be removed and replaced with sheaves. If the panels are not to be installed after sheave installation it is recommended that the slot caps be reinserted to preserve the functionality of the sheaves.

1. Remove the Sheave Block and Slot Cap from all active panel sill locations.
2. Using a rubber mallet lightly tap the A4-E sheaves into the sill. Start at the jamb working towards the middle (Figure 10).
3. If the larger sheave does not fit, use the A1-E sheave(s). For spaces that are too small to fit a sheave, use the factory provided sheave spacer (cut to size).



**Figure 10:**  
Sheave installation and End of Track Filler

## XI. Sheave Removal

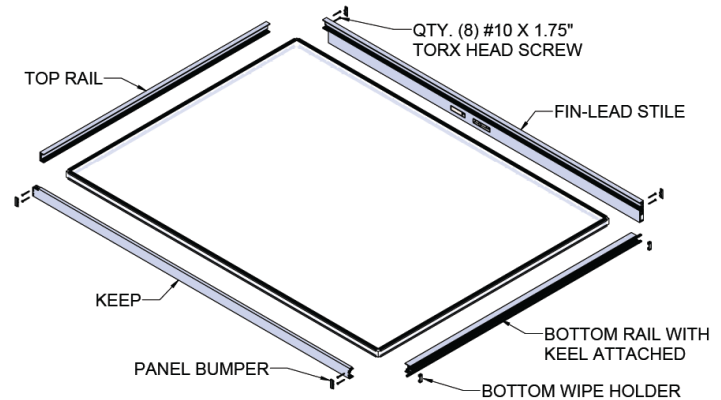
1. Remove the sheave spacer insert from the sill, relieving pressure on the sheaves.
2. To avoid damaging the top plate of the sheave, lift the sheave up evenly on both sides of the sheave to remove.

## XII. Panel Assembly (If Not Factory Assembled)

**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. Starting from the edge of the glass, slide the top rail over the glass keys into the center position.
2. Repeat this procedure with the bottom rail (Figure 11).

**Note:** Before installing Lead Stiles and Keeps, check required orientation with customer order.



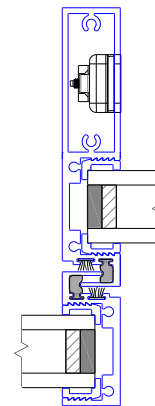
3. Position the Keep on the correct side of the glass and slide the stile over the glass keys into position.
4. Repeat this procedure with the opposite side.
5. Place the bottom wipe holder between the bottom rail and stiles.
6. Secure the Stiles to the rails with (8) #10 x 1.75" Torx Head Screw (Figure 11) using a T25 bit. Add wax to the ends of all fasteners to reduce the drive torque required for installation.
7. Cover all fastener heads with the provided panel bumpers.

### Reverse Keeps

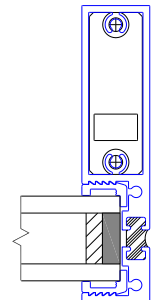
Locking hardware for typical installation is located on the interior panel, customer has the option to choose which stile will have the locking hardware at the time of order (Figure 12).

### Locking Hardware

Prior to installation of the panels, verify the locking hardware is at the correct height (from the locked position) and is installed correctly. The bottom guide of the locking hardware should be offset towards the glass (Figure 13). If not, uninstall the guide and adjust the blade hardware.



**Figure 12:**  
Reverse Keeps  
(Fin-Reverse Keep / Reverse Keep Shown)

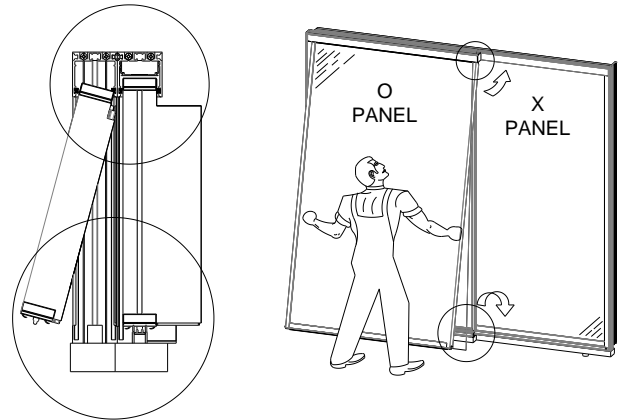


**Figure 13:**  
Blade Guide Position

### XIII. Panel Installation

**Note:**

- a. Check customer order for proper panel configuration and orientation.
- b. Pocket walls: Installer to flash pocket walls to adequately protect from moisture.
- c. On pocket doors, installation of panels should be completed before construction of pocket is complete.
- d. Sequence of panel installation is from interior to exterior.
- e. After all panels have been inserted; trim the weather stripping at the head and sill so that an air barrier is formed at the head and finished flooring.



**Figure 14:**  
Panel installation

1. 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 (Figure 14).

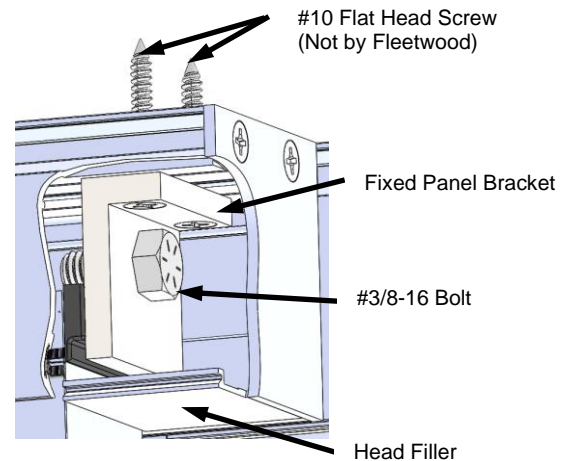
**Note:** On PX or XP configurations, if the pocket construction has been completed, demolition may be necessary to insert or remove the panel(s).

#### “O” Panel

Lift and move the panel into the fixed jamb until the glass reveal is even to the jamb. Verify that the weather stripping in the frame head is located so that it contacts the width of the “O” panel.

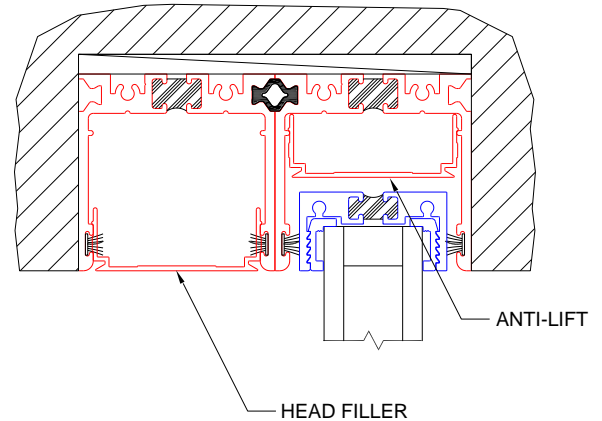
#### “O” Panel Securing

Once the fixed panel is in position, take the fixed panel bracket and butt it up against the head and fixed panel. Mark the hole locations of the bracket in the head and drill out using 1/4” drill bit. Fasten the bracket through the head to the frame using two #10 screws (not provided by Fleetwood). Screw the #3/8-16 bolt into the bracket to prevent the fixed panel from being lifted up. Cover the exposed bracket with the 1.5” section of head filler (Figure 15).



**Figure 15:**  
Fixed Panel Fastening

2. Repeat step 1 until all panels have been installed. Panels must overlap during installation to allow proper engagement of keeps after installation (except for Reverse Keeps).
3. Verify that all panels with hooks engage properly (See figure 12). If lead stile panel is not engaging properly with the jamb or Reverse Keeps reveal is not even check to ensure frame components are square and level.
5. When applicable, use a soft mallet to install Head Fillers into all tracks where they do not interfere with the operation of the system.

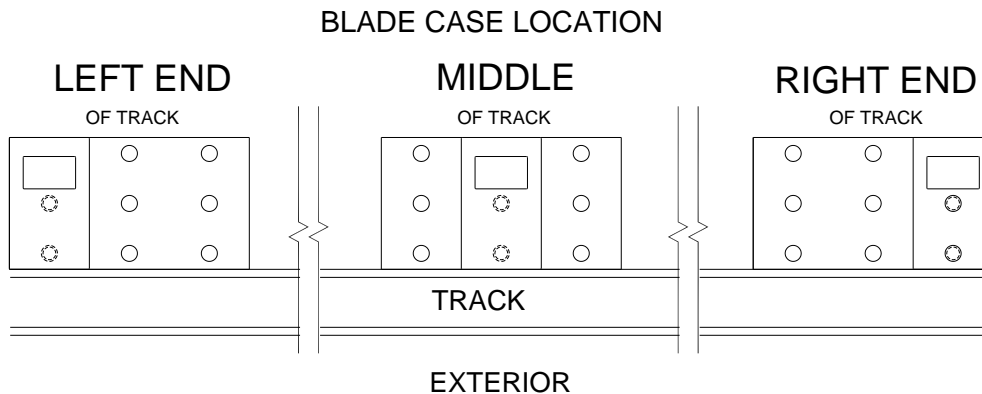


**Figure 16:**  
Head Filler and Anti-Lift Installed

#### XIV. Blade Case Installation

**Note:** Any gaps between blade case and finished flooring/jamb must be sealed to prevent water infiltration.

1. Determine the location setting for the blade case (Figure 17). Remove screws (from the underside) and reassemble as necessary.
2. Mark the blade case locations.
  - Method 1:**  
If the panels are un-installed the case locations can be determined from dealer drawings.
  - Method 2:**  
If the panels are installed the blade can be activated and the location marked.
3. Predrill holes for a #10 screw using a #25 drill bit. Fasten blade case with #10 X 1" PHP Screw.



**Figure 17:**  
Blade Case Location Options

#### XV. Anti-Lift(s)

At the top of all active panel vertical stiles, insert into the head an Anti-Lift block (4" head filler, cut to size).

**XVI. Finished Flooring Installation**

**Flooring Material:** The sill for this product was designed to incorporate the finished flooring as a key component to the bottom rail sealing and the linear slot drain. The material chosen to surround the extruded sill should be such that water will not damage it.

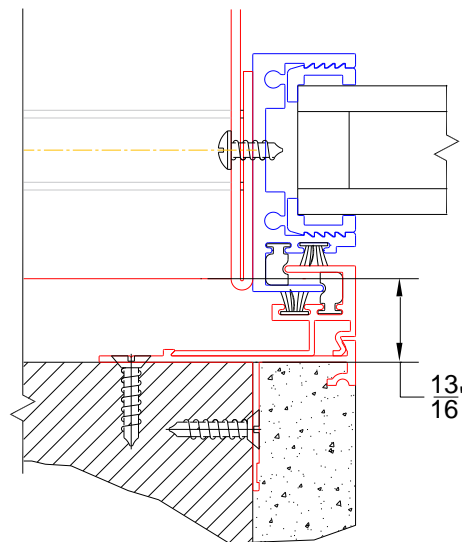
**Linear Slot drain:** The sill comes with an aluminum spacer to ensure the linear slot drain spacing is correct (Figure 7). This spacer is to be removed after the finished flooring is installed.

**XVII. Pocket Keep and Pocket Closer Installation**

**Note:** Installation of Pocket Keep and Pocket Closer should be done prior to wall completion. Pocket keeps are furnished net frame height and must be field cut.

1. Assuming that all door and screen panels will be installed from the exterior, the interior pocket keep is installed before any screen or door panels.
2. Attach pocket keep(s) with #8 flat head screws, not by Fleetwood. Install screws 6" from top and bottom with additional screws 18" on center.
3. Drill .136 diameter holes (#29 drill bit) thru pocket closer and one wall of keep. Holes to be located 6" from top and bottom of pocket closer, then evenly spaced on 18" centers. Assemble pocket closer to back side of keep with #10 x 1/2" long pan head screws (Figure 33).

**Note:** On PX or XP configurations, if the pocket construction has been completed, demolition may be necessary to insert or remove the panel(s).



**Figure 33:**  
 2-piece Pocket Interlocker

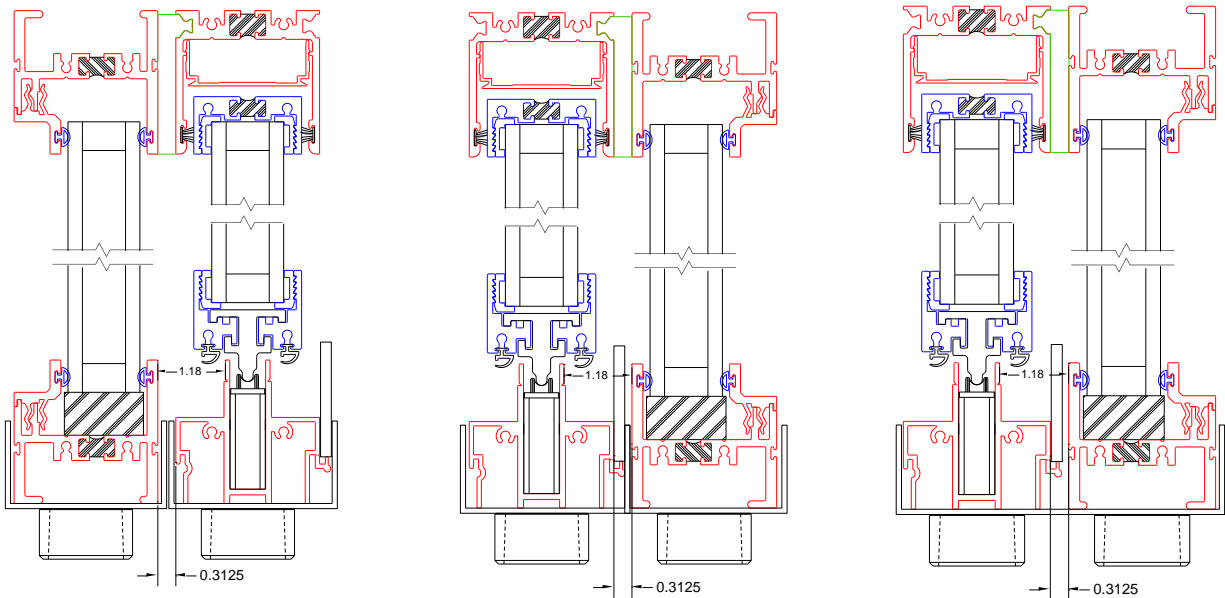
**Appendix A: O Panel Type EDGE | f |**

**Note:** Drainage between multiple systems must be reviewed, and may vary depending on configuration. EDGE | f | frame installation must be installed with the glazing wedges facing away from EDGE | s | track(s).

The O panel type EDGE | f | when paired with an EDGE | s | will have a minimum of 1 side with the glass keys and keep already attached.

Follow the EDGE | f | and EDGE | s | product Installation Instructions for how to properly install and assembly the frames of the two series. Proper block out spacing at the combined products to be a minimum of 6-5/16" to allow for proper backfill.

At the location where the heads of the two series meet there is a factory extruded shim that will help maintain proper spacing between the two products. At the sill, the distance between products should be 5/16", Figure A1 shows an alternate measuring location. The distance between products is crucial, any misalignment may prevent hooks from properly engaging.



**Figure A1:**  
O Panel Type EDGE | f | Spacing