

I. Installation

Note: Do not leave the Arche-Duct system exposed for more than 3 months. Prolonged exposure will damage the powder coated finish.

Consider Maintenance and Cleaning of entire drainage system. A drain cleanout should be considered and is recommended on all Arche-Duct installations. In the event that dirt, leaves or other debris blocks any of the drainage outlets a cleanout would allow removal of the blockage.

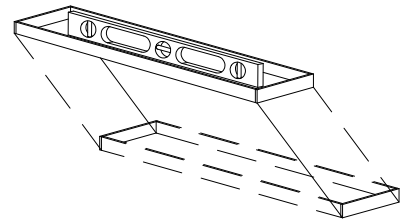
On pocket doors, the relationship between the pocket interlocker (attached to the wall) and sliding panel interlocker must be maintained. The sill of the door frame should be 3/8" from the interior wall of the pocket where a 2-piece or an "L-Type" pocket interlocker is used and 5/16" where a "J-Post" interlocker is used in order to get proper engagement of the interlockers. Please consider this relationship when determining the size of the trench for the Arche-Duct.

1. Opening Verification

- Check the measurement of the opening and verify that the Arche-Duct will fit into the opening.
- Recommended 1/2" clearance around full perimeter of Arche-Duct (back-fill by others).

2. Pre-Fit and Leveling

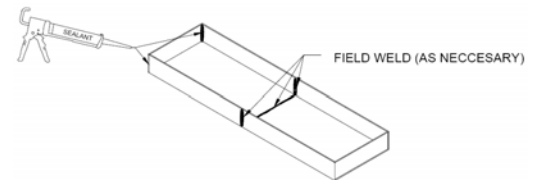
- Place the Arche-Duct into the opening and determine what leveling must be done prior to installation. Prepare relief areas for the PVC drain flange(s).
- Full length support of the Arche-Duct is required to prevent the weight of the sliding door panels from bowing the track and Arche-Duct.
- If more than an 1/8" shim height is required, it is recommended to pour a self-leveling
- "Rock Hard" (or equivalent) to achieve a level and stable surface.



3. Sealant Application

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

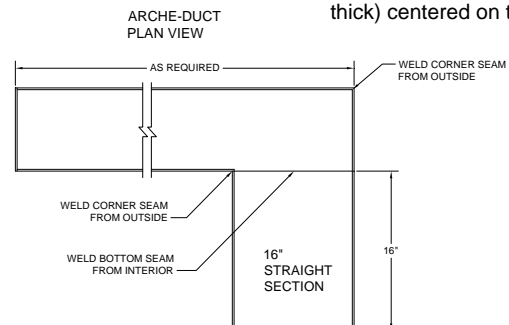
- It is necessary to use an insulating material between the outer edge of the Arche-Duct and the rough opening. Direct contact with grout, concrete, or dissimilar metal can lead to corrosion of the Arche-Duct pan.
- Apply sealant in all corners and seams of the pan.



4. Corner Arche-Duct

- Seams at corners are welded from the exterior and are full length to create a watertight seal. The Arche-Duct will contain a 16" long straight section (see below) that will be welded at the corner to obtain the desired angle. Corner brace included.

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



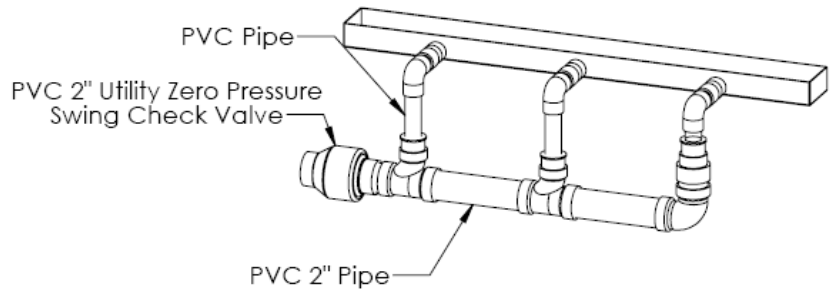
5. Water Test

- 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 Arche-Duct passes water test, drain Arche-Duct and continue with installation of frame.

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

6. Drain Connection

- Confirm proper orientation of Arche-Duct for tracks and drain location.
- Install Arche-Duct into already leveled opening.
- Connect tubing or pipe to Arche-Duct drain connections.
- Connect other end of the tubing or pipe to a PVC 2" Utility Zero Pressure Swing Check Valve.

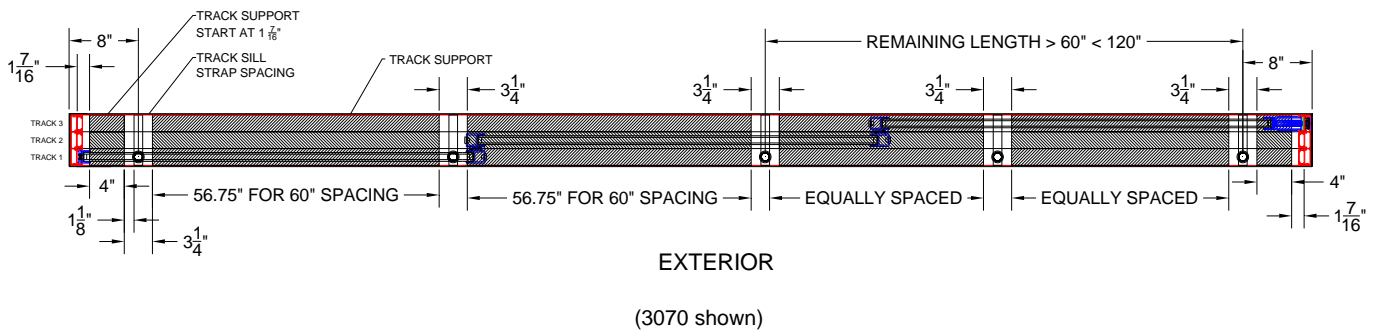


II. Frame Track – Inspection and Preparation

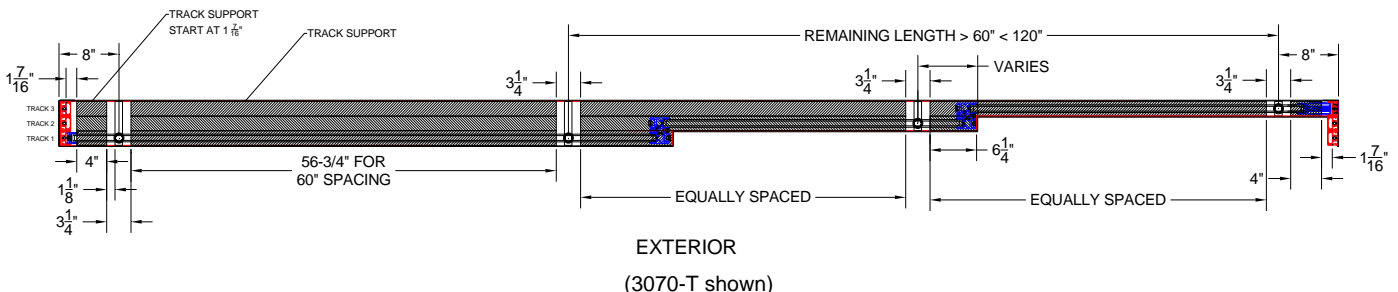
1. Track Support Locations

- Arche-Duct splicing will occur on doors with large net frame widths.
- Straight sill tracks are provided with the track supports already attached.

a) Non-staggered Arche-Duct top view shown below.

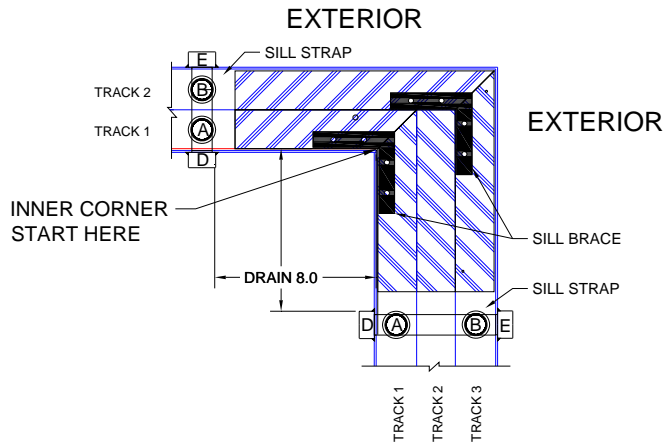


b) Staggered Arche-Duct top view shown below.



2. Corner door sill

- Sufficient support of both legs of the Sill is recommended when securing corner blocks and sill braces.
- Install sill brace, with four (4) No. 6x1/2" FHP, TEK screw per mitered track.
- Use caution when handling Sill and Arche-Duct to prevent twisting or breakage during installation.



3. Back Fill

- Do not back-fill until door operation has been fully tested, including locking into jamb(s) and locking into pocket interlocker (when applicable).
- Verify you have access to drainage connections and clean out as necessary.