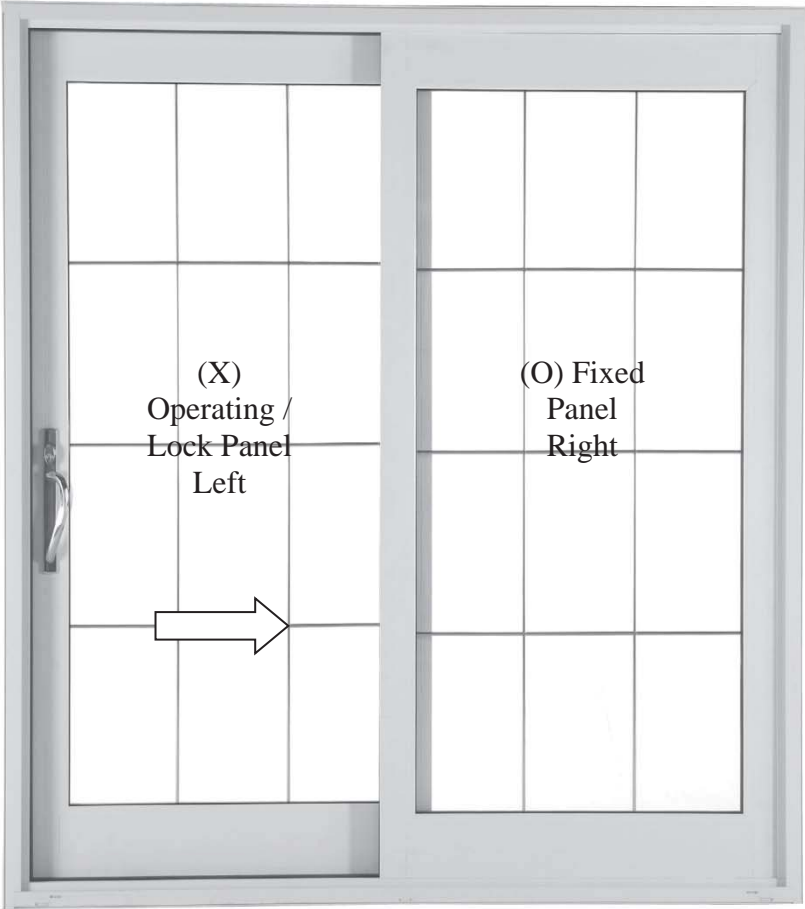


Contemporary – 3” Panel  
Classic – 5” Panel  
French Panel

# SLIDING DOOR

## ASSEMBLY AND INSTALLATION INSTRUCTIONS

6400, 8400 and 9400 Series Sliding Patio Doors



Note : **Glazing Beads For All Panel Face To The Exterior**  
2 Panel XO – Left Is Shown Above – Opposite = OX Right



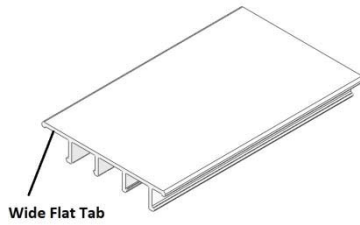
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Note: Replacement part numbers and next level kit listed. There may be extra parts included in the installation kits provide with the door, depending on the Patio Door option you received.



Sloped Sill Sash Support (491020xx) 1



4" Sash Stop (491006xx - 491025xx Kit) 2



Fixed Panel Sash Block (49100501) 2



Roller Track & Cover (491057 & 491058) 1



Fixed Panel Bracket (49110300 - 49110400 Kit) 2



#8 x 3" Pan Head Screw (49100900 – 49102700 Kit) 42



#8 x 1" Pan Head Screw (49106900– 49102700 Kit) 3



#8 x 2" Pan Head Screw (part of 49102700 Kit) 6



#8 x 5/8" Truss Head Screw (49178500 - 49110400 Kit) 4



#8 x 1 1/4" Pan Head Screw (49101000 - 49110400 Kit) 2



#6 x 1 1/2" Flat Head Screw (49061701 - 49105100 Kit) 10



#5210 – 1" x 2" High Profile Fuzz Pad (49100210 – 49102700 Kit) 2



#5310 – 1/2" x 2" High Profile Fuzz Pad (49100110 - 49102700 Kit) 4



#5410 – 1/2" x 2 Low Profile Fuzz Pad (49100310 - 49102700 Kit) 8



3/8" Hole Plug – Interlock Hole Plug (49060801 - 491025xx Kit) 3



1/2" Hole Plug – Roller Adjustment Plug (490549xx - 491025xx Kit) 2

**NOTE:**

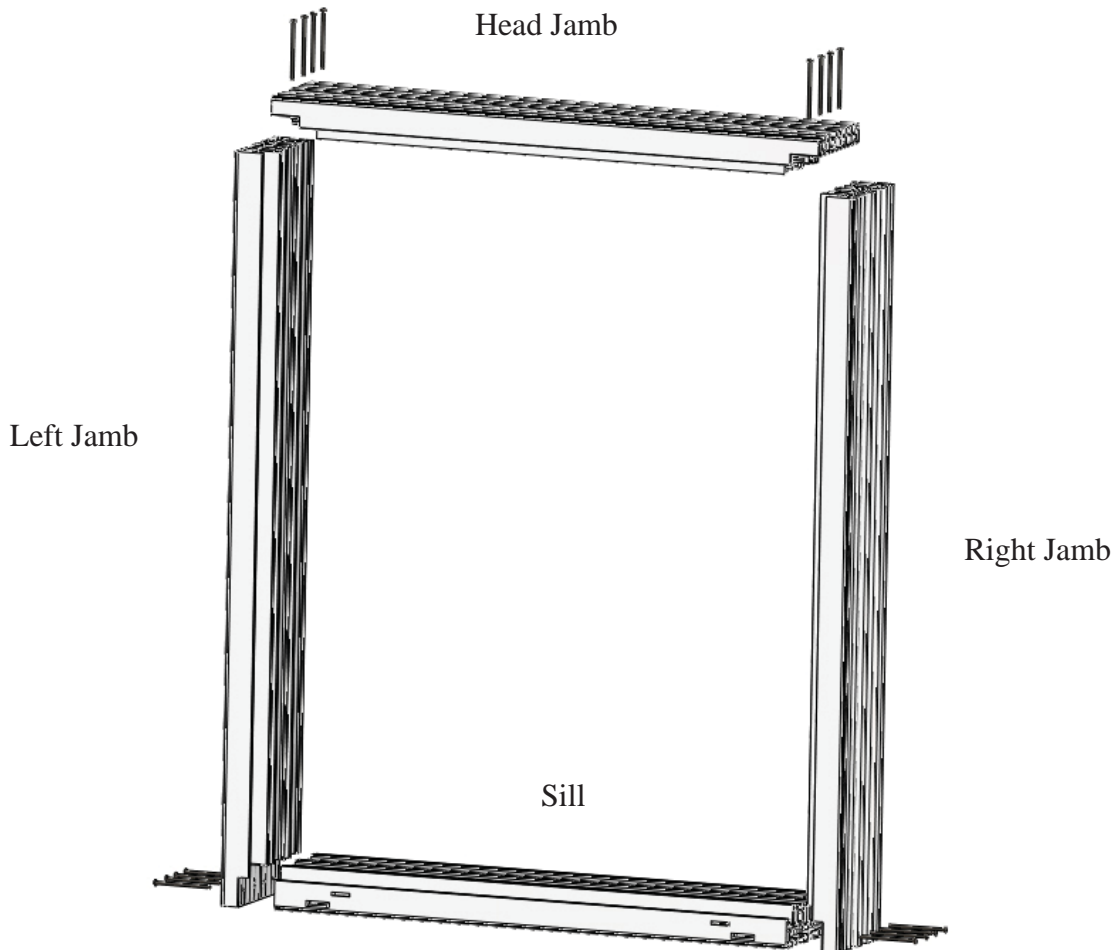
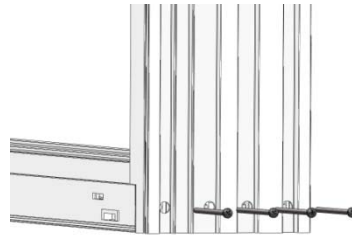
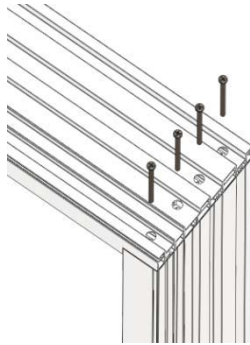
Before starting the installation of this door, please read and understand completely these instructions. Failure to follow and finish these assembly and installation instructions voids all existing and implied warranties.

**IMPORTANT!!!**

**Before removing the existing door, measure the new door making sure it will fit properly into the rough opening.**

**Step 1 – (Frame Assembly Instructions):**

- 1) Lay out all 4 parts of the frame profiles on the ground.
- 2) Using the #8 x 3" Phillips Pan Head screws provided, fasten the frame parts together through the head into jambs and through the jambs into the sill. See sketch below.



## **Step 2 – (Checking Frame Size & Opening):**

### **IMPORTANT!!!**

#### **Before removing the existing door !!!**

- 1) Measure the width and height of the door frame.
- 2) Measure the width and height of the opening.

#### **Make sure the door is not bigger than the opening.**

#### **If the door size and opening size are not correct **STOP!****

Depending on which is not correct, you may need to order a new door or adjust your opening.

## **Step 3 – (Removing Existing Door):**

- 1) Remove the interior trim from around the old door.
- 2) Remove the siding from around the out side the old door.
- 3) Remove the panels of the old door.
- 4) Remove the frame of the old door.

Refer to our online Tech Center at [www.associatedmaterials.net](http://www.associatedmaterials.net) for an instructional video on how to remove an old patio door.

## **Step 4 – (Prepping Door Opening):**

### **NOTE:**

The rough opening is critical to the proper installation and operation of the patio door. If the rough opening is too small or large this door will not install or operate properly. A level Sill is critical in the operation and performance of this door.

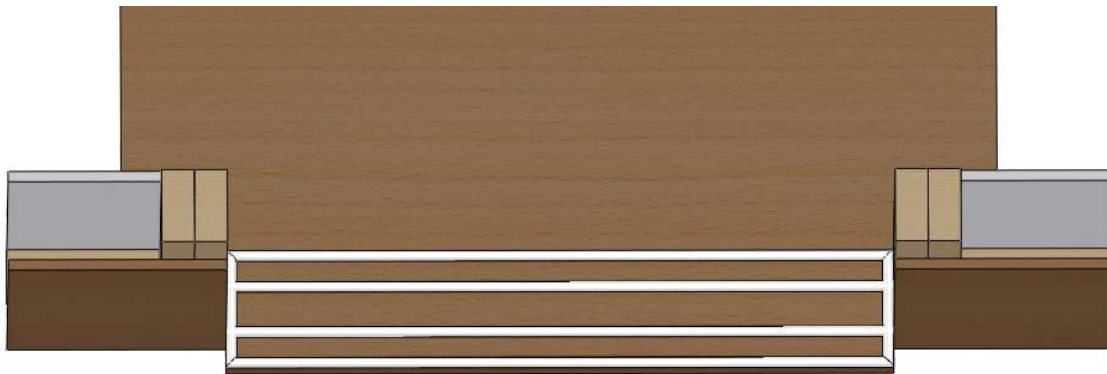
- 1) Clean debris from opening.
- 2) Check the sill for level.
- 3) Use floor leveling compound or shims to ensure a flat and level surface.

## **Step 5 – (Installing Door Frame):**

- 1) Using a chalk line, snap a line along the floor on the interior of the opening.
- 2) Place liberal bead of caulk along the floor at the jambs going from the exterior to the interior.
- 3) Place liberal bead of caulk along the chalk line and the exterior edge of the opening.
- 4) Between the lines of caulk apply 2 parallel beads of caulking.

## **Door Frame Types**

1. **3” Contemporary & 5” Classic have sloped sills**
2. **French & HP (high performance) have pocket sills**

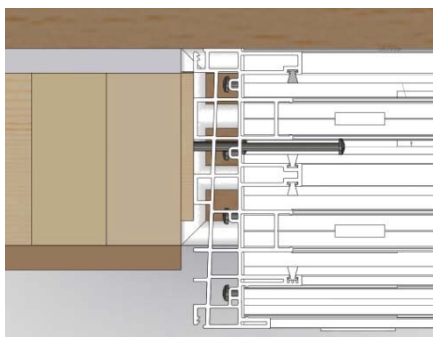


- 5) Place the door frame into the opening Sill first, continue tilting the rest of the frame into the opening.
- 6) **Level, plumb, and square** the door frame in to the opening. Shim the door frame per the drawing below. Fasten the door frame into the opening with the #8 x 3" Phillips Pan Head screws.
- 7) Fasten through the outside channel of the interior panel track of the frame members. Put screws 8" from each of the corners and then 3 more screws evenly space along each jamb. (See figure below)

**DO NOT screw through the Sill. This will void warranty!**

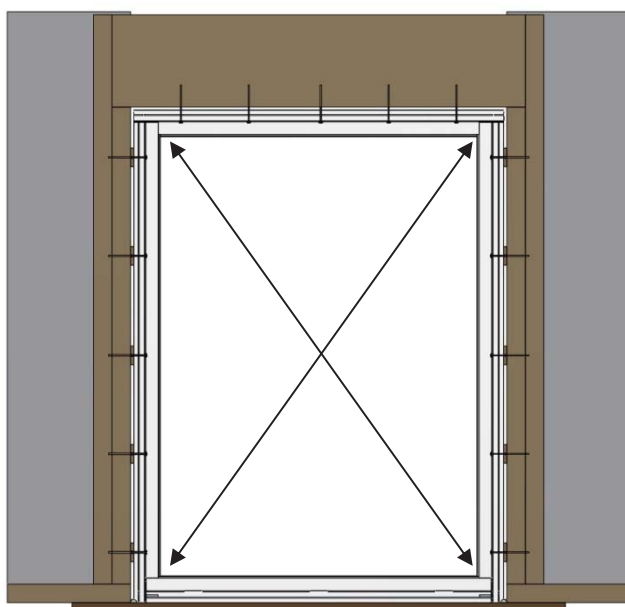
**CHECK level and plumb with a four foot level.**

**CHECK square with corner to corner measurements, both must match within 1/8".**



Interior

Exterior



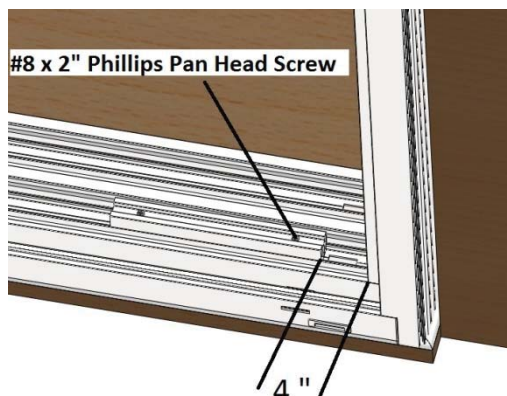
Shim as shown and check for level, plumb, and square

**Note: If you have a French sash or HP option patio door please follow Step 6a.**  
**If you have a 3" or 5" sash option patio door please follow Step 6b.**

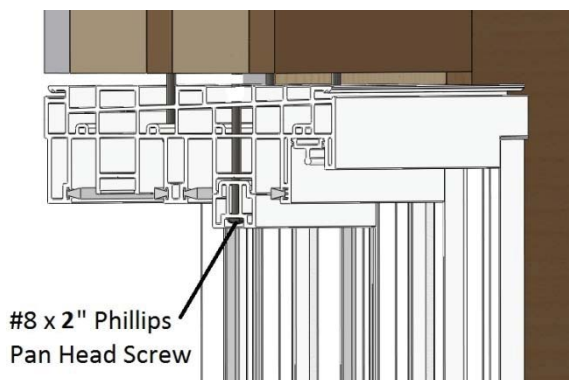
**Step 6a – (Installing Sash Panel Blocks):**



- 1) On the fixed side of the door frame, install the sash panel block in to the sill using the #8 x 2" Phillips pan head screws provided. Fasten the panel block 4" from the corner. DO NOT block the weep!!! See Figure Below:

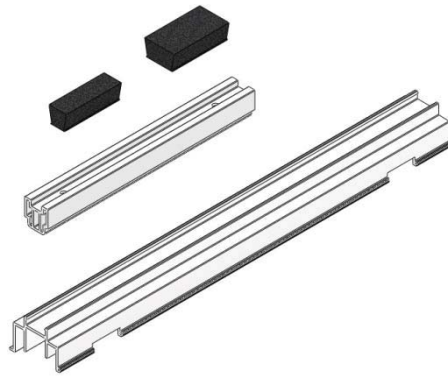


- 2) In the head of the frame install the sash panel block using the #8 x 2" Phillips pan head screws provided at the same 4" spacing as the sill.

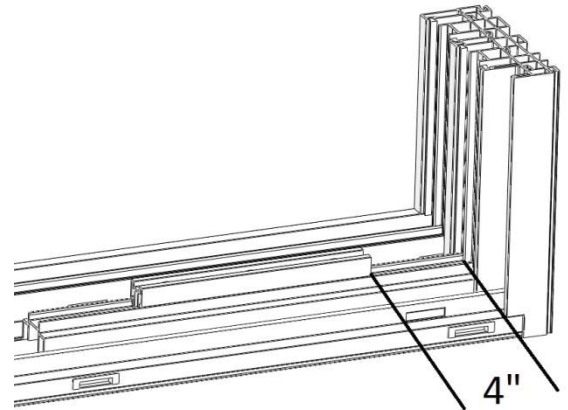
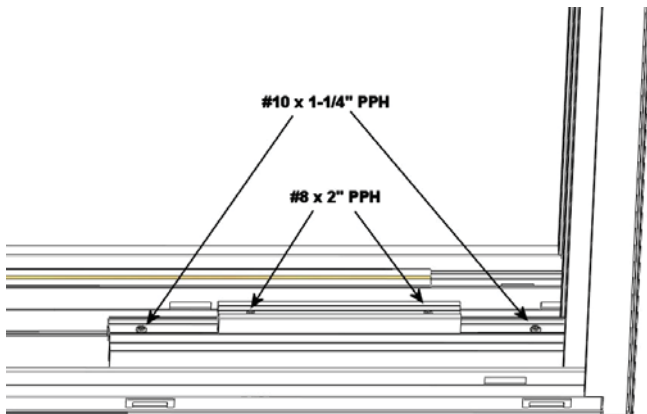




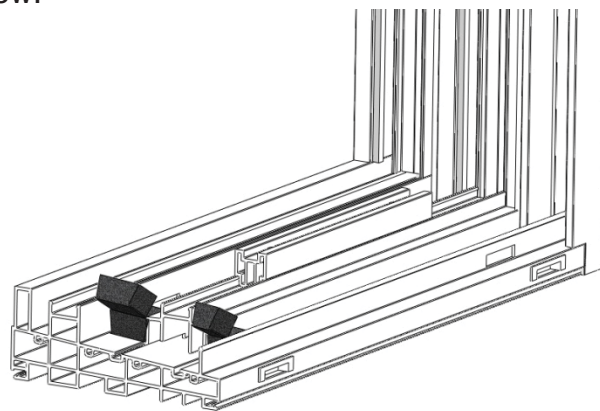
## Step 6b – (Installing Exterior Sash Support, Sash Panel Blocks & Fuzz Pads):



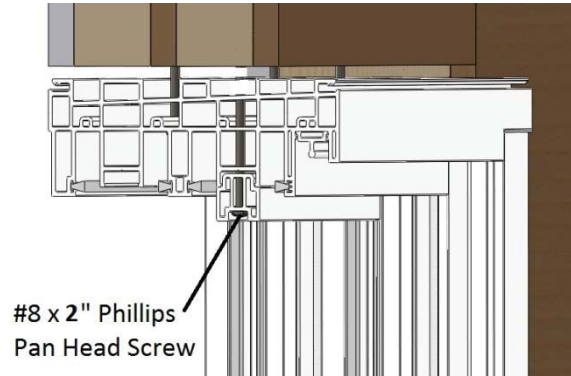
- 1) Slide the exterior sash support that is preinstalled in the sill against the fixed panel jamb. Using the #10 x 1 ¼" Phillips pan head screw, fasten the exterior sash support to the sill. Place your fasteners approximately 1" from each end of the exterior sash support.
- 2) Place the sash panel block on the exterior sash support 4" from the jamb. Using the #8 x 2" Phillips pan head screws provided, fasten the panel block See Figure Below:



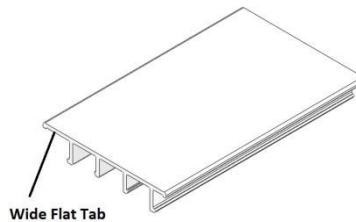
- 3) 1/8" past the end of the exterior sash support place the wide high profile fuzz pad (5210) in the gap between interior sash support and the exterior sash support. Take the second wide high profile fuzz pad and put it against the first one. As shown in figure below.
- 4) In the gap between the exterior sash support and the screen track place the narrow high profile fuzz pad (5310). Take the second narrow high profile fuzz pad and put it against the first one. As shown in figure below.



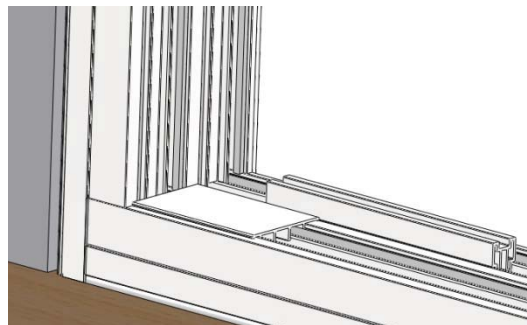
- 5) In the head of the frame install the sash panel block using the #8 x 3" Phillips pan head screws provided at the same 4" spacing as the sill.



**Step 7 – (Installing 4" Sash Stop – French & HP Sill Only):**



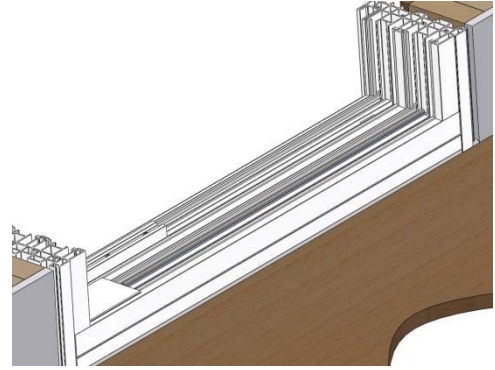
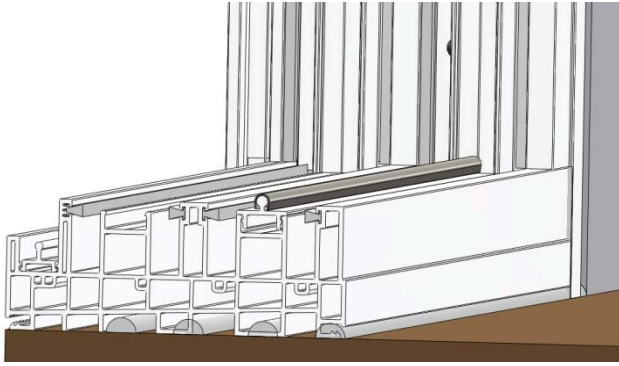
- 1) Insert the supplied 4" sash stop with the wide flat tab toward the fixed panel into the interior sash panel frame track in Sill at the corner on the fixed panel side of the frame as shown. You may need to tap into place with a rubber mallet



**Step 8 – (Installing Roller Track):**

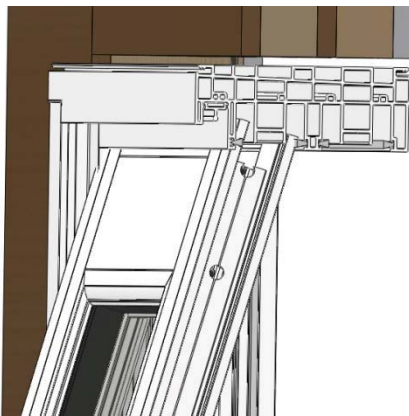


- 1) Insert the roller track and stainless steel track cover into the interior frame track, from jamb to jamb as shown. One end will touch the 4" Sash Stop for the French and HP door options.



## Step 9 – (Inserting Fixed Sash Panel)

- 1) Insert the fixed sash panel from the exterior of the opening on the operator side of the door frame into the exterior sash track at the head. Missing the sash panel block.

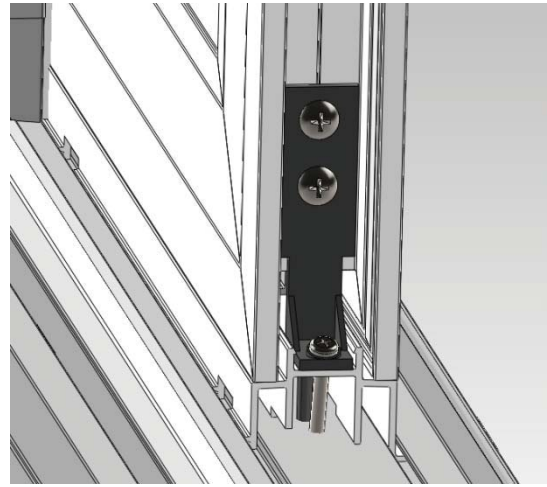
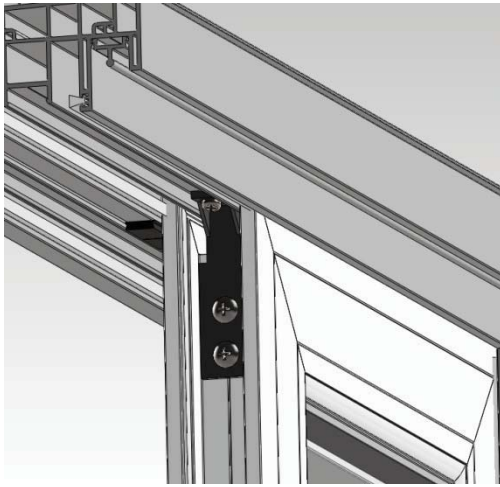


- 2) Swing the bottom of the sash panel over the sill.
- 3) Slide the fixed panel over the sash panel block and fully engaged into the side jamb

**Note: If you have a HP option patio door please follow Step 10a & 10b.**  
**If you DO NOT have a HP option patio door please follow Step 10a ONLY.**

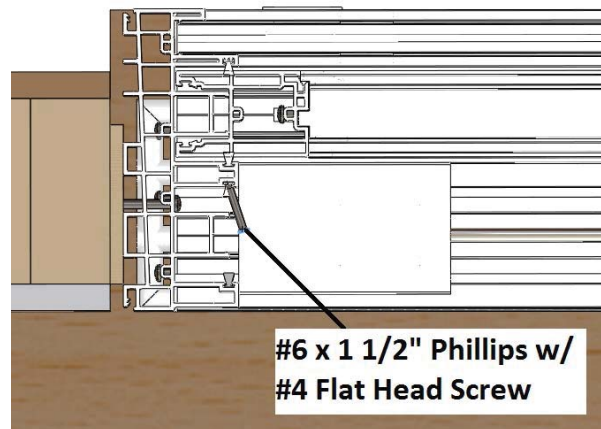
## Step 10a – (Fastening the Fixed Panel – Standard & HP versions):

- 1) Slide the fixed sash panel so it is completely engaged in the frame.
- 2) Insert the Fixed Panel Bracket as show below. Using the #8x1 ¼" Phillips Pan head screws, fasten the base of the bracket to the head and Sill.
- 3) Measure the opening at the jamb and center of the door make sure they are the same and then fasten the Fixed Panel Brackets to the door panel with the #8 x 5/8" Phillips Pan head screws.

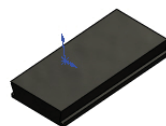


### Step 10b – (Fastening the Fixed Panel – HP version only):

- 1) With a 3/32 drill bit drill a pilot hole for the #6 x 1 1/2 " screw with the #4 Phillips flat head as shown in the figure below. Drill 5 pilot holes through the jamb evenly spaced. Drill 5 pilot holes through the head evenly spaced. Drill all holes through the weatherstrip channel of the interior frame track and into the fixed sash panel. This pilot hole will help prevent stripping the head of the screw.
- 2) Using the #6 x 1 1/2 "screws fasten the fixed sash panel to the frame using the pre-drilled pilot holes.

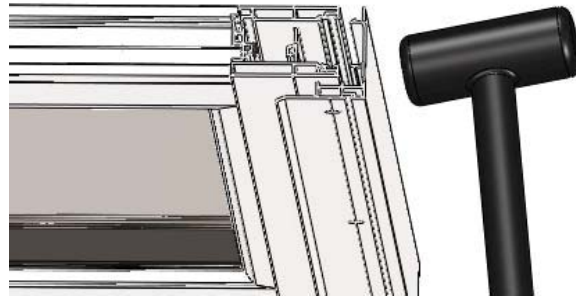


### Step 11 – (Attaching The Fuzz Pads):



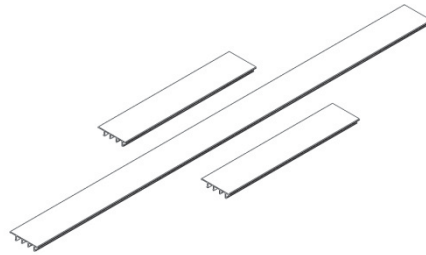
- 1) Along the head and sill (head only for sloped sill) on the Center Sash Panel Divider place the low profile fuzz pad (5410) 1/4 " past the fixed sash panel. Put another low profile fuzz pad against the first low profile fuzz pad.

## Step 12 – (Attaching Fixed Panel Interlocks):

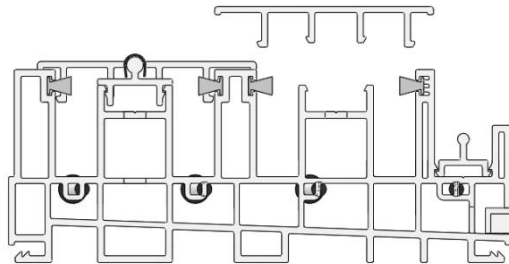


- 1) Using a rubber mallet, tap the snap on interlock with the installation holes in it to the fixed panel exposed vertical rail.
- 2) Fasten the snap on interlock to the sash panel with the #8 X 1" Phillips pan head screws provided through the installation holes in the interlock
- 3) Apply the 3/8" hole plug covers to hide the screw holes and screws.

## Step 13 – (Installing Threshold & Exterior Head & Jamb Covers):

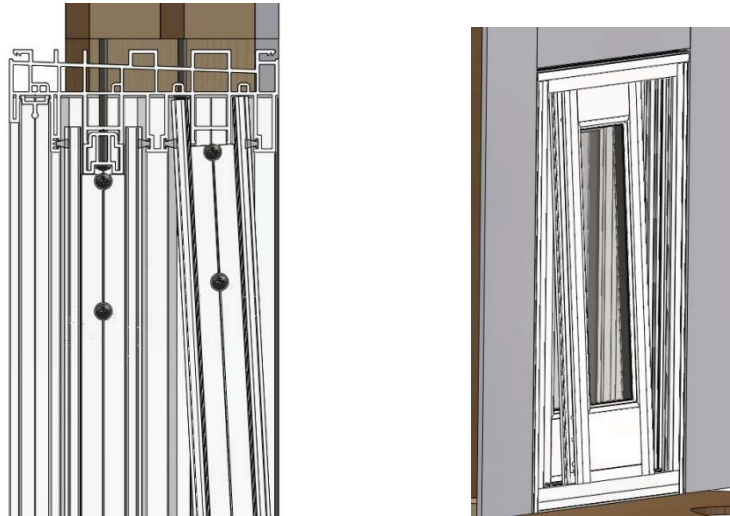


- 1) Place the threshold with the wide flat tab toward the active sash panel into the exterior sash panel frame track on the sill. If necessary use rubber mallet to tap securely into place.



- 2) Place the small head cover with the wide flat tab toward the active sash panel into the exterior sash panel frame track in the head. If necessary use rubber mallet to tap securely into place.
- 3) Place the jamb cover with the wide flat tab toward the active sash panel into the exterior sash panel frame track into the jamb. If necessary use rubber mallet to tap securely into place.

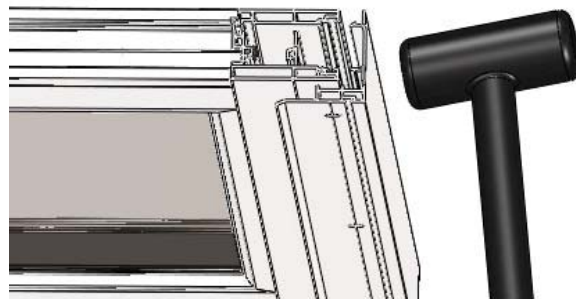
## Step 14 – (Active Sash Panel)



- 1) Insert the active sash panel from the interior of the opening at the center of the door frame into the interior sash track at the head.
- 2) Swing the bottom of the sash panel over the sill.

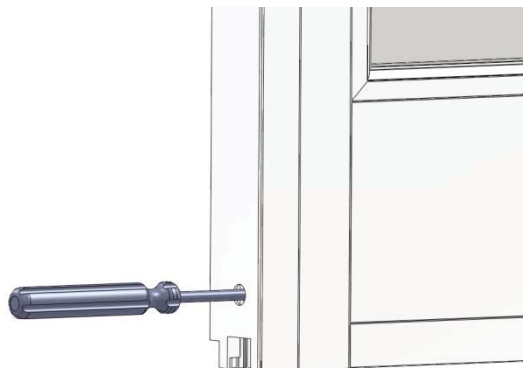
## Step 15 – (Attaching Active Panel Interlock):

- 1) Prior to installing the Active Panel Interlock, completely close the Active Panel.
- 2) Position the bottom of the interlock just on top of the low profile Fuzz Pad (5410).
- 3) Using a rubber mallet, tap the remaining snap on interlocks to the active panel vertical rail.



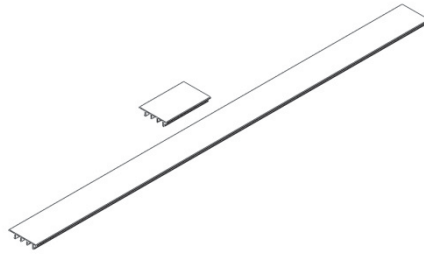
## Step 16 – (Roller Adjustment):

- 1) Relieve pressure off the rollers by using a pry bar. Insert a large Phillips head screw driver into the large roller adjustment hole on the bottom sides of the sash panel.



- 2) Adjust roller height as needed (cw – raise panel up , ccw – lower panel down)
- 3) Once adjusted place large hole plugs into adjustment holes on Active Panel.

### Step 17 – (Installing Interior Jamb Cover & 4” Sash Stop - Head):



- 1) Insert the supplied 4” sash stop with the wide flat tab toward the fixed sash panel into the interior sash panel frame track in head at the corner on the fixed panel side of the frame. If necessary use rubber mallet to tap securely into place.
- 2) Place the inter jamb cover with the wide flat tab toward the fixed sash panel into the jamb. If necessary use rubber mallet to tap securely into place.



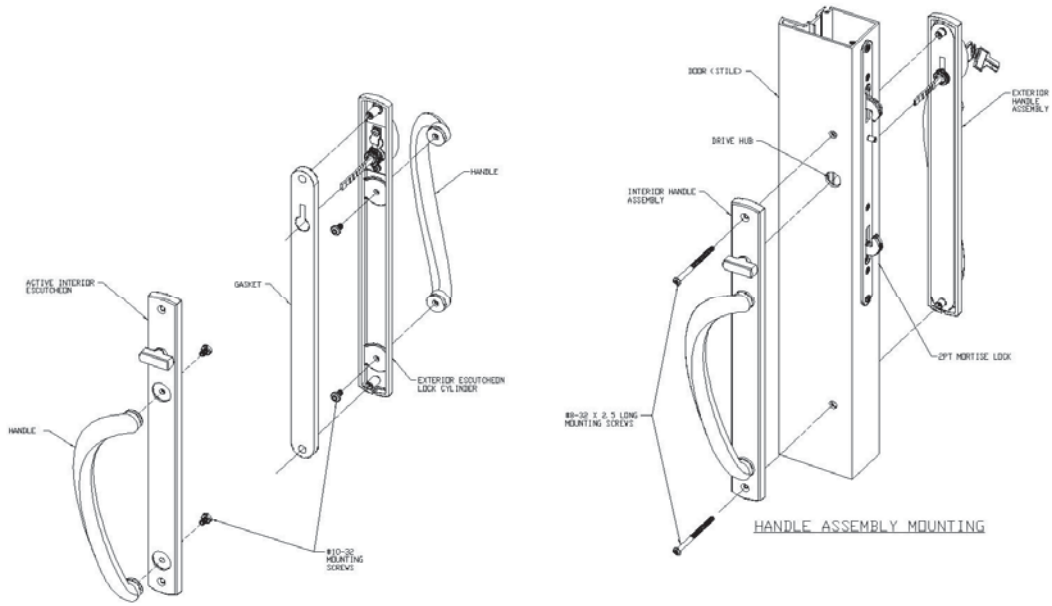
### Step 18 – (Handle Installation):

#### (Warning : Be careful not to over tighten handle!)

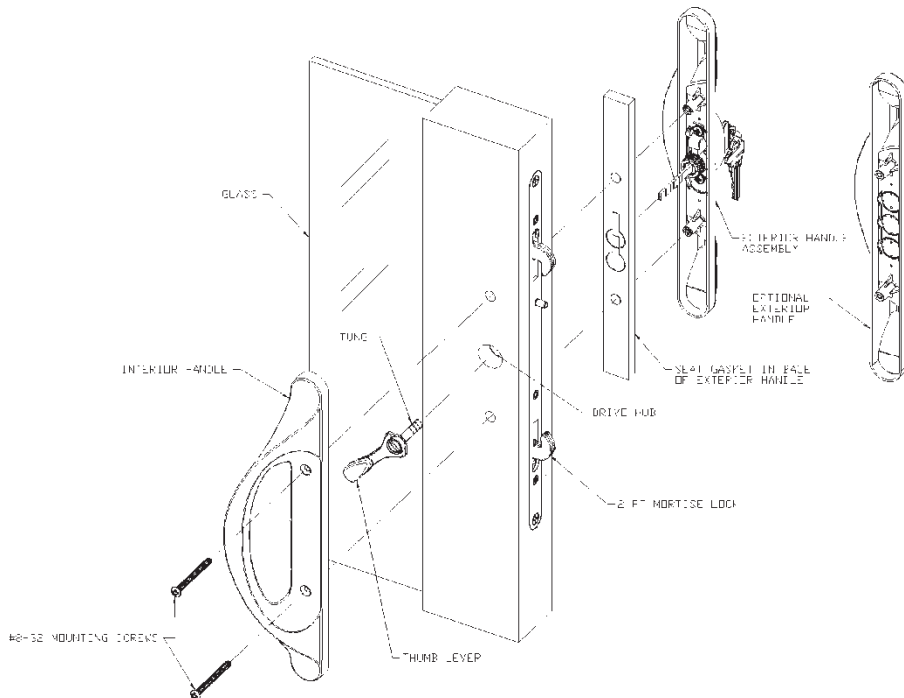
- 1) On the interior of the operating sash panel, insert thumb lever on the into the 2pt. mortise lock.
- 2) Place exterior handle with the screw hubs into the mounting holes on the exterior of the operating sash panel.
- 3) Place interior handle over thumb lever the with screw hubs into the mounting holes in the interior of the operating sash panel.
- 4) Fasten interior and exterior handles with the (2) - #8 x 32 mounting screws provided in the handle kit. **(BE CAREFUL NOT TO OVER TIGHTEN SCREWS this will cause handle set to bind and not work properly.)**

#### Adjusting Lock Fingers:

- 1) Open door panel and engage lock.
- 2) Place a flat headed screw driver in the slotted screw just above the top locking finger. Turn CW to extend the locking finger or CCW to retract the locking finger.
- 3) Place a flat headed screw driver in the slotted screw just below the bottom locking finger. Turn CW to extend the locking finger or CCW to retract the locking finger.



**French Handle Set**



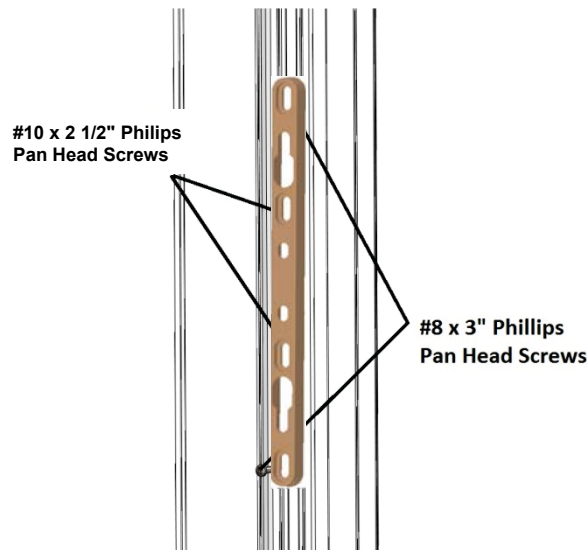
**Standard Handle Set**



## Step 19 – (Keeper Installation):



- 1) Place the keeper into the interior sash panel frame track on the jamb.
- 2) Align 2 center slots of keeper with the dimple marks in the jamb.
- 3) Fasten the Keeper through the center slot with the (2) #10 X 2 1/2" Phillips pan head screws.
- 4) Screw through the outer slots of the keeper with the (2) #8 x 3" Phillips pan head screws.



### Keeper Adjustment:

*Open door panel and turn the lock to engage the locking mechanism. Slide the door panel toward the jamb and check the alignment of the lock and keeper. If they are not aligned loosen the keeper screws and adjust the keeper up or down to give proper alignment.*

## Step 20 – (Screen Installation):

- 1) Remove the screen from its packaging.
- 2) Insert the top of the screen into the screen track in the head of the frame..
- 3) Swing the bottom of the screen over the sill and into the screen track.
- 4) Align the screen rollers with the screen track in the sill for smooth operation
- 5) Install the screen keeper into the screen channel in the jamb by aligning the slots in the keeper with the dimples and fastening with screws provided with the screw.

## Step 21 – (Insulating Around Door):

- 1) Using pipe wrap fiberglass insulation or approved low expanding window and door foam, fill the gap around the door jambs and head.

## ***Trouble Shooting Guide***

### **Unable to insert Active Panel**

Check vertical opening at the jambs and compare them to the vertical opening at the center. They should be the same, if not readjust the frame and shim as needed.

### **Door panel will not move easily.**

Check to see if rollers are centered over the roller track. If not, lift sash panel and move in or out to get the roller over the roller track.

Clean and lubricate roller track.

Remove active sash panel and check to see if rollers are rolling. If not, free rollers with silicone lubricant and reinsert the active panel.

Loosen roller mounting screws by ½ turn to allow rollers to self align on roller track.

Adjust roller height. See page 14 – Step 16 – (Adjusting Rollers)

### **Screen does not move easily.**

Check to see if rollers are centered over the roller track. If not, lift screen and move in or out to get the roller over the roller track.

Remove screen panel and check to see if rollers are rolling. If not, free rollers with silicone lubricant and reinsert the screen.

Clean and lubricate screen roller track.

Adjust screen roller height. See instructions supplied with screen.

### **Door will not lock.**

Check to see if door is installed plumb, level and square in the opening. If not, readjust the frame shims.

Check the Roller Adjustment - Is the Active Panel parallel to Jamb?

See page 14 – Step 16 – (Adjusting Rollers)

Check the throw on the lock fingers

– See page 15 - Step 18 (Handle Installation)

Check the Keeper vertical alignment to the Lock

– See Page 17 – Step 19 (Keeper Installation)

### **Air leakage between door panels**

Check to see if the operating panel is adjusted too high and doesn't contact the fuzzy pad on the sill. If so, adjust rollers down until the interlock contacts the fuzzy pad. Fuzzy pads must contact the bottom and top of the interlocks for the full width of the interlock.

Adjust rollers to get both panels parallel at the interlocks and consistent bulb contact top to bottom.

Make sure there are no obstructions keeping the fixed panel from being fully seated into the jamb. No installation screws are allowed in the exterior fixed panel track of the frame. The fixed panel not being fully seated in the jamb will cause poor bulb seal contact at the center of the door panel.

Make sure side jambs are not bowed inward. This will cause poor bulb contact at the interlocks.

# Care & Maintenance

## Cleaning:

**Glass** – The glass in your new patio door can be cleaned with the following:

Warm Soapy Water

Regular Glass Cleaners

Ammonia Base Glass Cleaners – Except Sun Clean Glass Options

**Vinyl** – The best way to clean the vinyl frame and sash of your new door is with warm soapy water. For tough dirt use any commercially available non abrasive cleaners. **DO NOT** use solvents, paint removers, or sharp objects to clean our new door. Use of these will **VOID** your warranty and damage your door.

Clear the Screen Track and Active Sash Panel Track of debris. Clean these tracks with warm soapy water.

**DO NOT** use abrasive cleaners on your door. These cleaners will cause the surface of the vinyl to become dull and yellow.

**DO NOT** use abrasive cleaners on the glass of your door. These cleaners may remove glass coatings and scratch the glass.

## Lubrication:

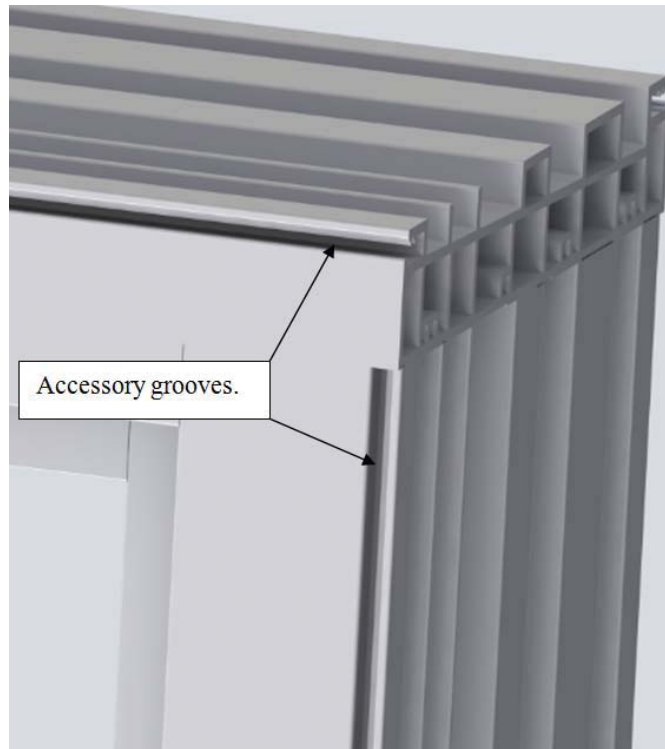
- Spray silicone lubricant to the locking assembly on the end of the sash panel.
- Apply a graphite lubricant in the keyway of the exterior key lock assembly.
- Remove sash panel and spray silicone lubricant at the shaft of the roller wheels.
- Lightly spray Screen Track with silicone lubricant.
- Lightly spray Roller Track with silicone lubricant

**DO NOT** use oil based spray lubricants such as WD40. They attract dirt. This dirt will bind the Mechanical functions of the rollers and locks and cause your door not to operate properly.

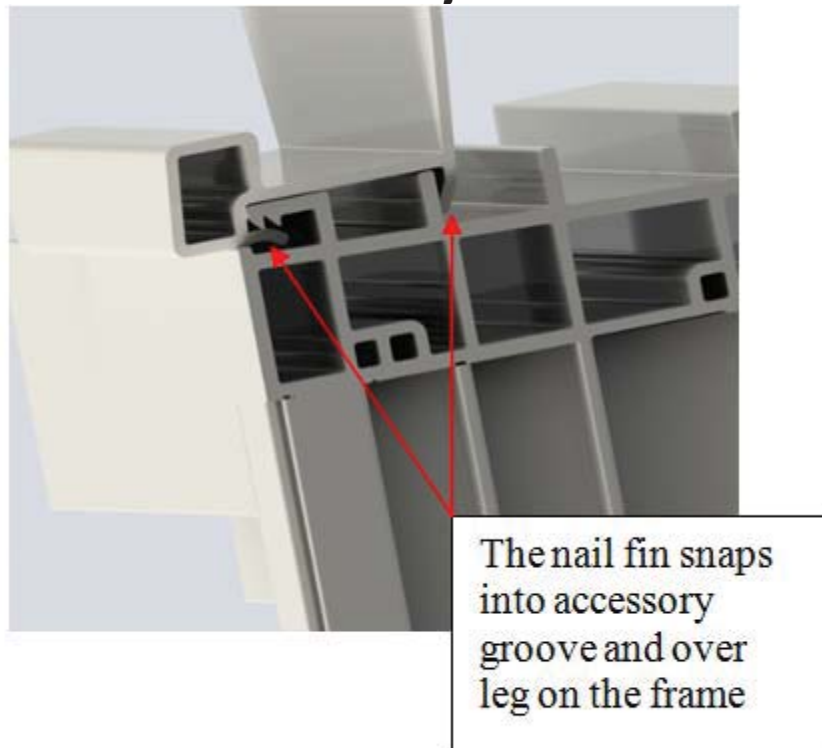
## ***Brick mould and Casing Option***

**Step 1: Apply Nail fin to the finished frame assembly.**

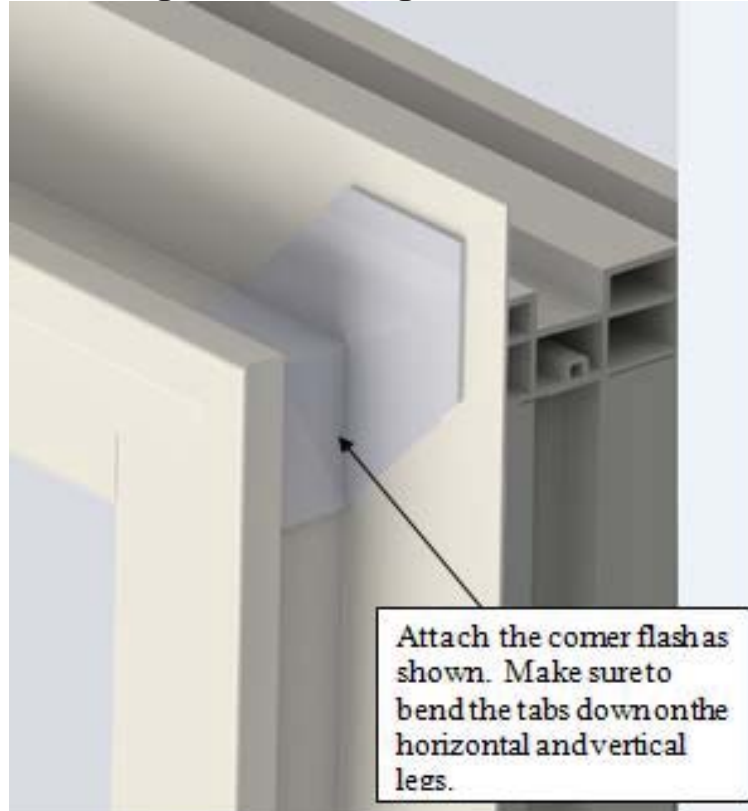
**a. Caulk the accessory groove with a thin bead of caulking.**



**b. Apply the nail fin to the head and jambs**



**c. Apply corner flashing to the 45 degree miters.**



**d. Back caulk nail fin and flash over the fin per AAMA specifications.**

**e. Install Frame and apply the Brick mould or Casing to the nail fin.**





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