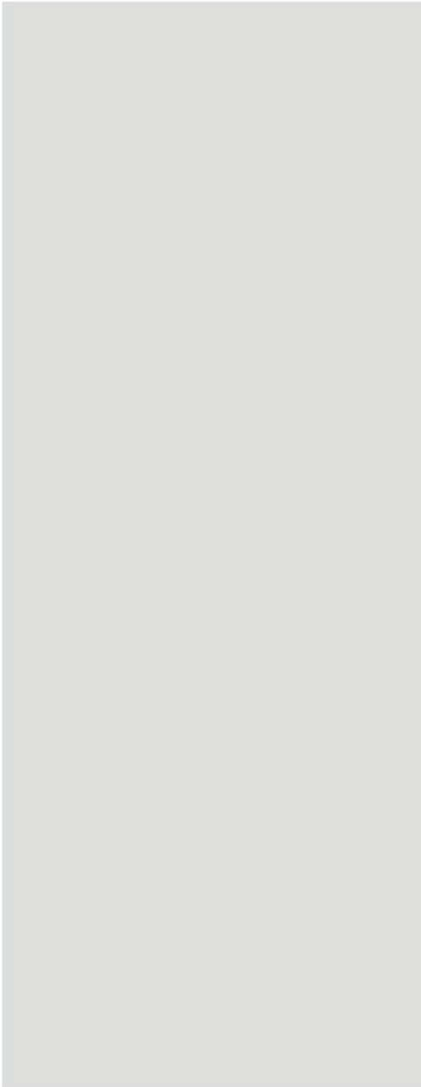
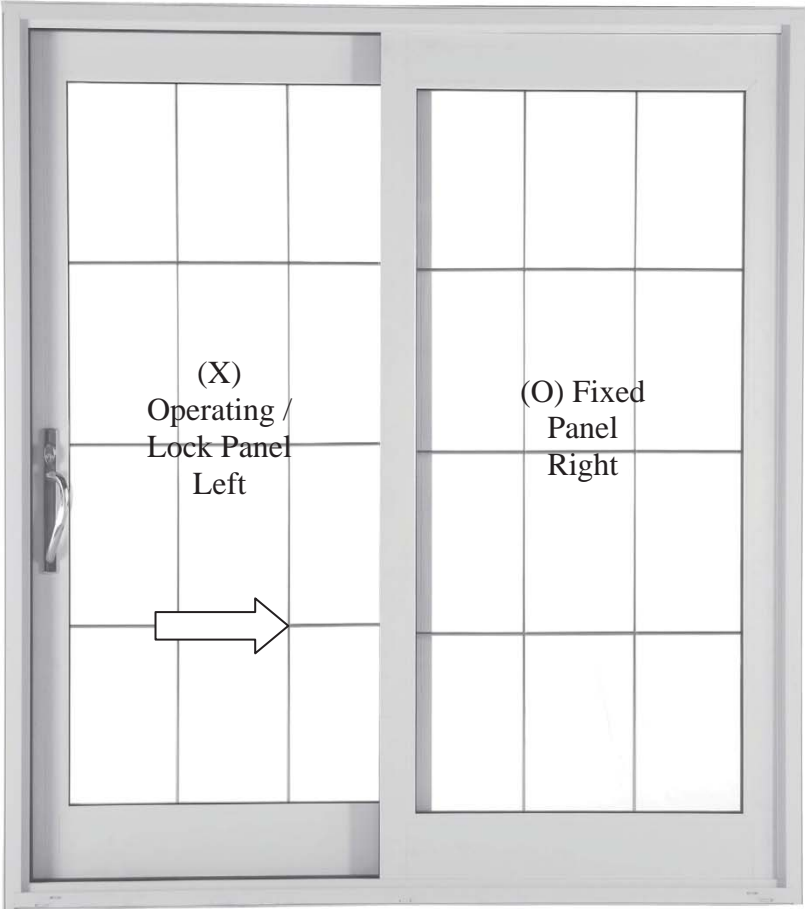


Contemporary – 3” Panel  
Classic – 5” Panel  
French Panel

# SLIDING DOOR

## ASSEMBLY AND INSTALLATION INSTRUCTIONS

6500 Series Sliding Patio Door



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 provided with the door, depending on the Patio Door option you received.



#8 x 3" Pan Head Screw (49100900 – 49103300 Kit) 21



#8 x 1" Pan Head Screw (49106900– 49103300 Kit) 3



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



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



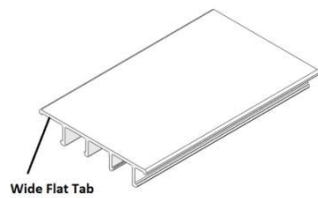
#5410 – 1/2" x 2 Low Profile Fuzz Pad (49100310 - 49103300 Kit) 4



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



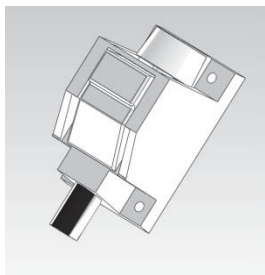
1/2" Hole Plug – Roller Adjustment Plug (490549xx - 491025xx Kit) 2



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



Fixed Panel Bracket (49110300 - 49110400 Kit) 2



Foot Lock (491019xx Kit) (OPTIONAL)

## NOTE:

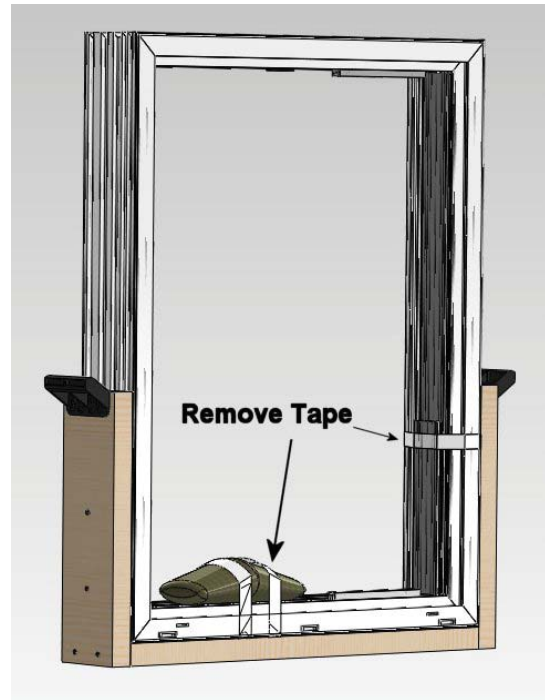
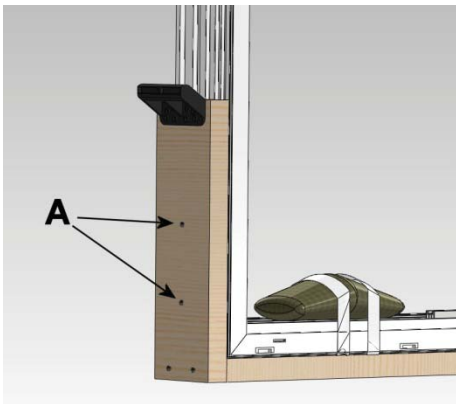
Before starting the installation of this door, please read and understand completely these instructions. Failure to follow and finish these assembly and installation instructions voids all existing and implied warranties.

## IMPORTANT!!!

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

### Step 1 – (Unpacking Frame Assembly):

- 1) Remove the #8 x 2" Pan Head screws labeled A below, 2 screws each side. Remove wood packaging material and discard.
- 2) Using a utility knife cut the tape that holds the hardware kit at the sill and frame covers at the jamb. Set aside hardware and frame covers for assembly later.



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

### **IMPORTANT!!!**

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

- 1) Measure the width and height of your new 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):**

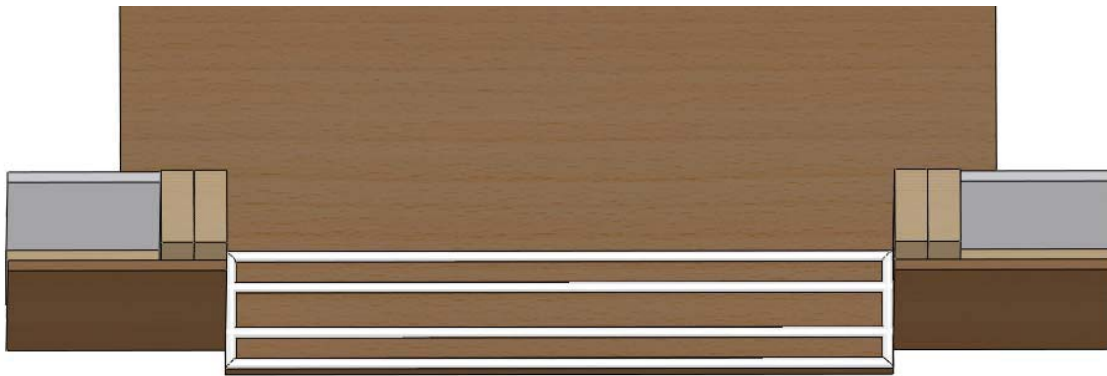
### **NOTE:**

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.

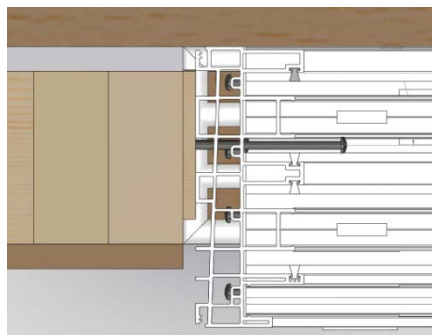


- 1) Place the door frame into the opening Sill first, continue tilting the rest of the frame into the opening.
- 2) **Level, plumb, and square** the door frame in to the opening. Shim the door frame per the drawing below. Fasten the door frame into the opening with the #8 x 3" Phillips Pan Head screws.
- 3) 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!**

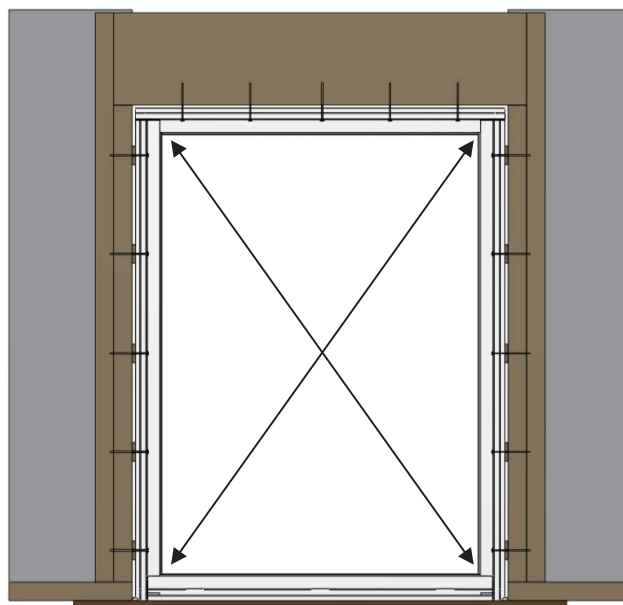
**CHECK level and plumb with a four foot level.**

**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

## Step 6 – (Installing Fixed Sash Panel)

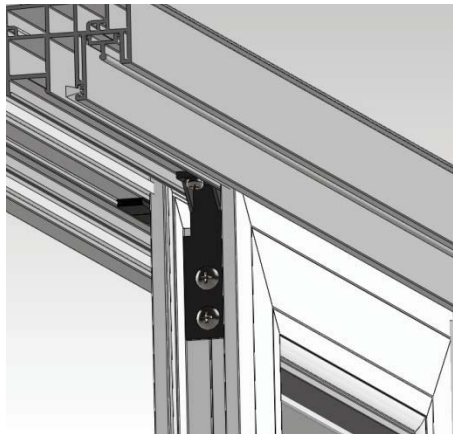
- 1) Insert the fixed sash panel from the exterior of the opening on the operator side of the door frame into the exterior sash track at the head. Missing the sash panel block.



- 2) Swing the bottom of the sash panel over the sill.

## Step 7 – (Fastening the Fixed Panel):

- 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.

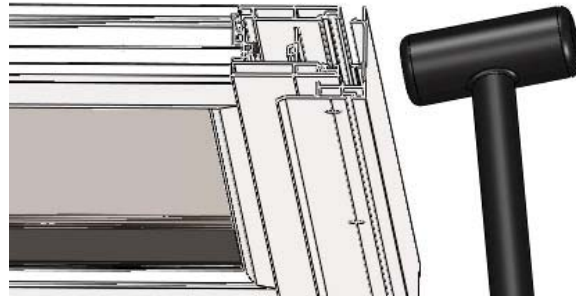


## Step 8 – (Installing Fuzz Pads):



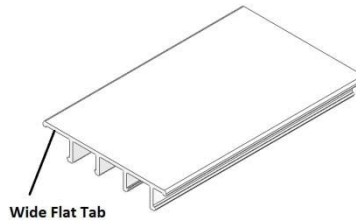
- 1) Along the head and sill (head only for sloped sill) on the Center Sash Panel Divider place the low profile fuzz pad (5410) 1/4 “ past the fixed sash panel. Put another low profile fuzz pad against the first low profile fuzz pad.

## Step 9 – (Attaching Fixed Panel Interlocks):

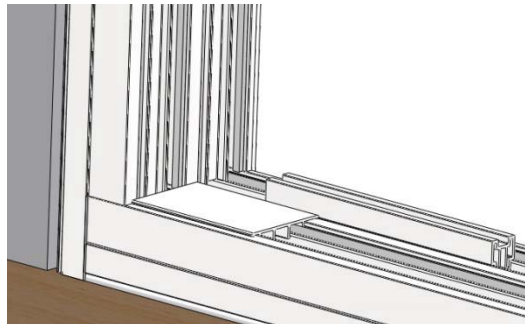


- 1) Using a rubber mallet, tap the snap on interlock with the installation holes in it to the fixed panel exposed vertical rail.
- 2) Fasten the snap on interlock to the sash panel with the #8 X 1" Phillips pan head screws provided through the installation holes in the interlock
- 3) Apply the 3/8"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

## Step 10 – (Installing 4" Sash Stop – Sill Only):

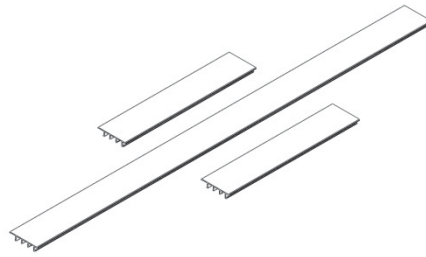


- 1) Insert the supplied 4" sash stop with the wide flat tab toward the fixed panel into the interior sash panel frame track in Sill at the corner on the fixed panel side of the frame as shown. You may need to tap into place with a rubber mallet

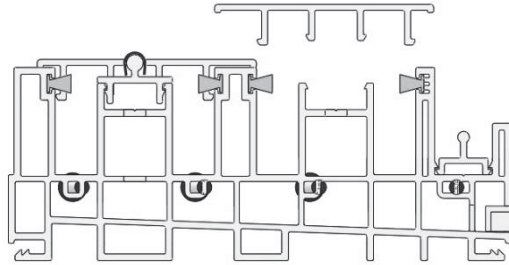




## Step 11 – (Installing Threshold & Exterior Head & Jamb Covers):

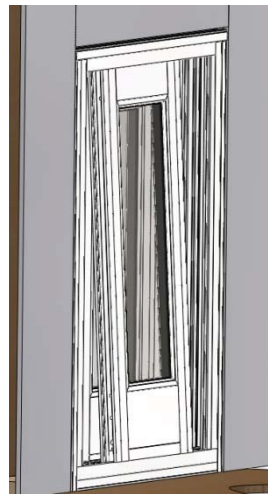
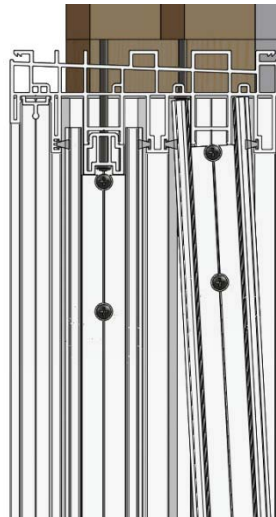


- 1) Place the threshold with the wide flat tab toward the active sash panel into the exterior sash panel frame track on the sill. If necessary use rubber mallet to tap securely into place.



- 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.

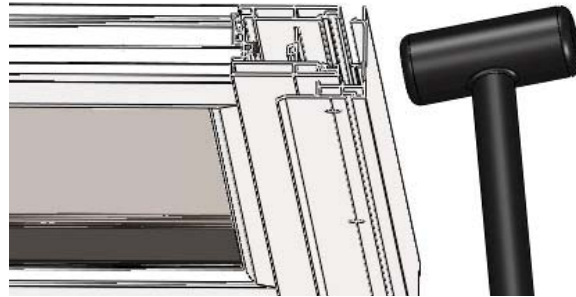
## Step 12 – (Active Sash Panel)



- 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..

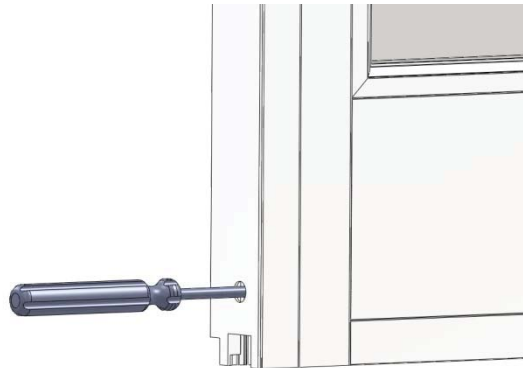
### Step 13 – (Attaching Active Panel Interlock):

- 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.



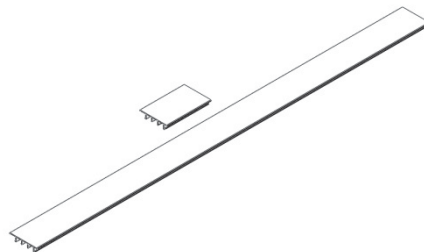
### Step 14 – (Roller Adjustment):

- 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 15 – (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.



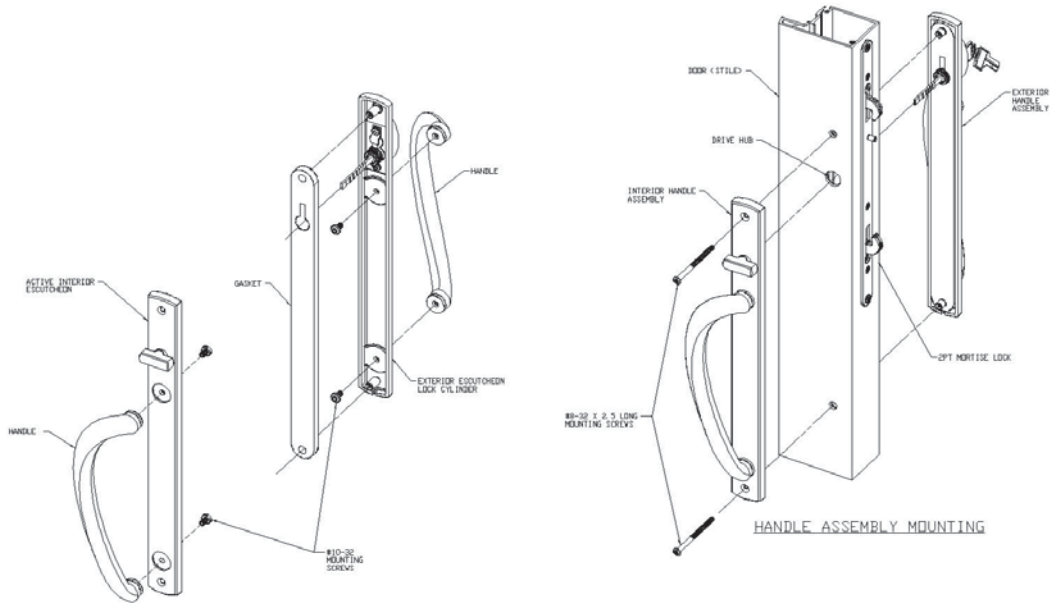
## Step 16 – (Handle Installation):

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

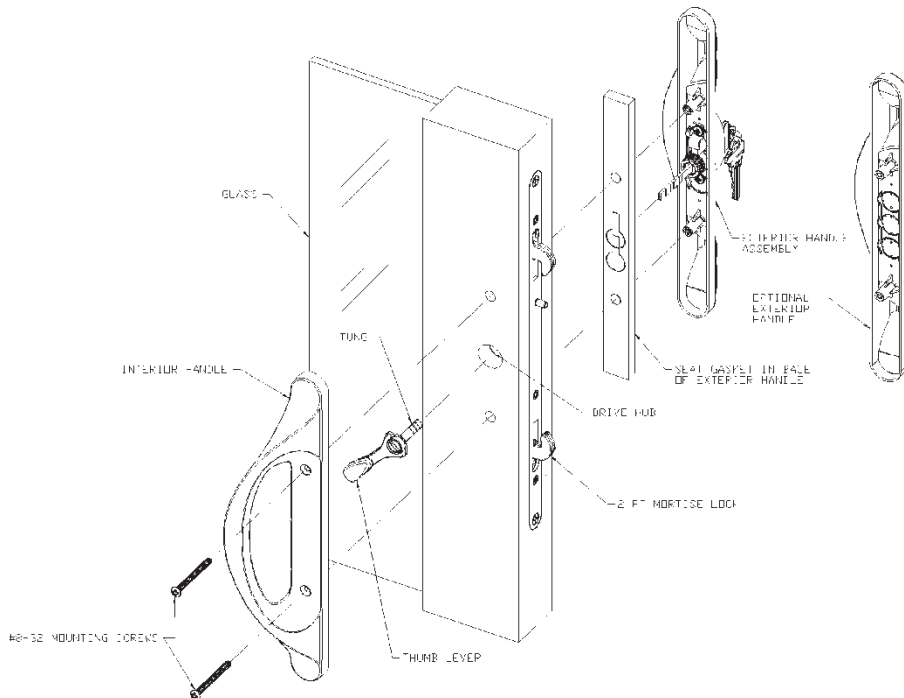
- 1) On the interior of the operating sash panel, insert thumb lever on the into the 2pt. mortise lock.
- 2) Place exterior handle with the screw hubs into the mounting holes on the exterior of the operating sash panel.
- 3) Place interior handle over thumb lever the with screw hubs into the mounting 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**

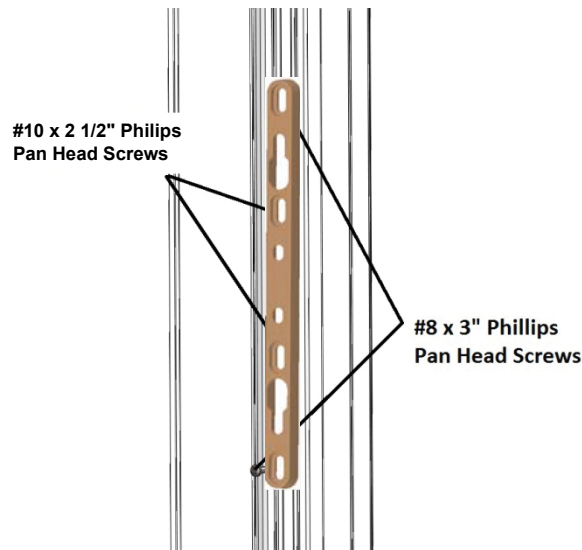


**Standard Handle Set**

## Step 17 – (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 18 – (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 19 – (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 10 – Step 14 – (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 10 – Step 14 – (Adjusting Rollers)

Check the throw on the lock fingers

– See page 11 - Step 16 (Handle Installation)

Check the Keeper vertical alignment to the Lock

– See page 13 – Step 17 (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.



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