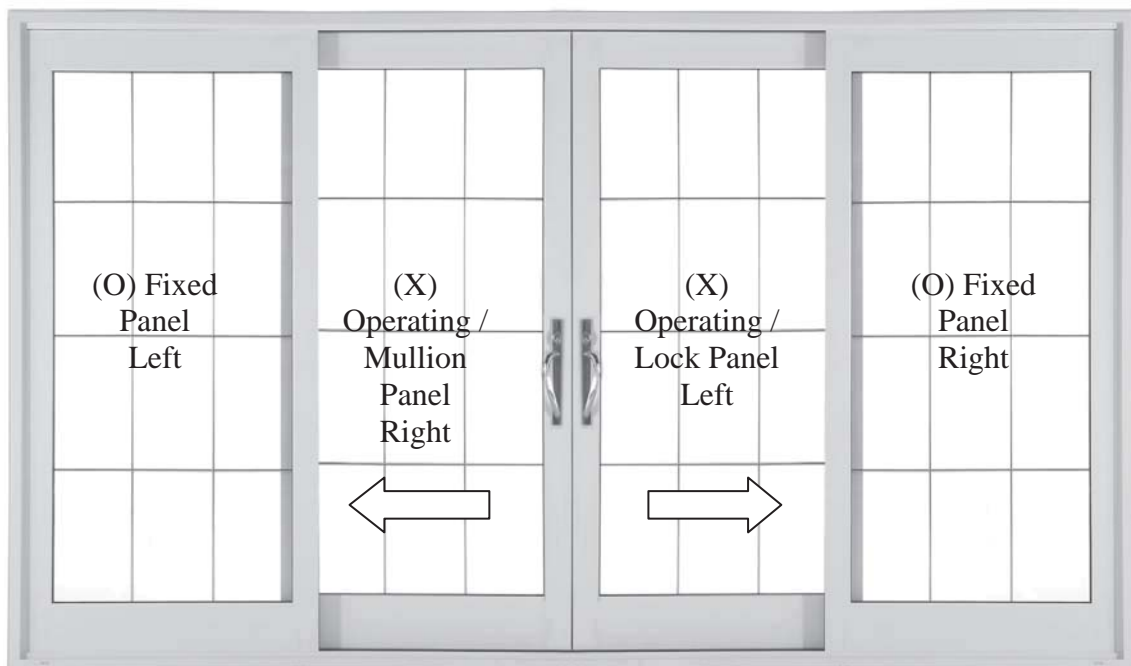


Contemporary – 3” Panel  
Classic – 5” Panel  
French Panel

# SLIDING DOOR

## ASSEMBLY AND INSTALLATION INSTRUCTIONS

3- or 4- Panel  
6500 Series Sliding Patio Door



Note : ***Glazing Beads For All Panel Face To The Exterior***  
4 Panel OXXO Door Only Have One Configuration – As Shown  
3 Panel OXO – Left (Is Standard) – Opposite = OXO Right

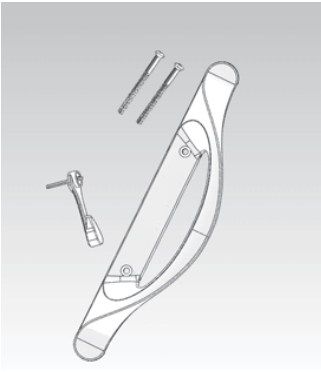


ASSOCIATED MATERIALS®  
INCORPORATED

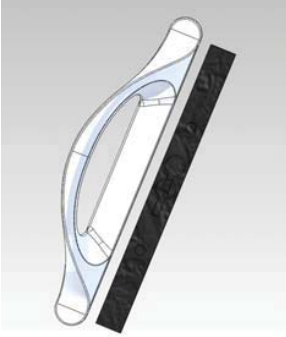
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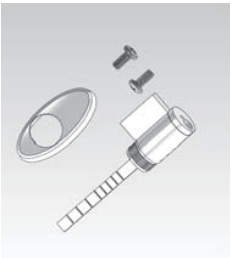
**Note:** Replacement part numbers and next level kit listed. There may be extra parts included in the installation kits provided with the door depending on the Patio Door option you received.



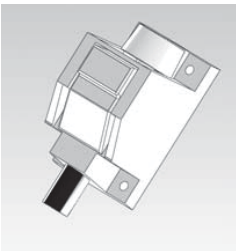
Interior Handle Kit (varies by style) 1



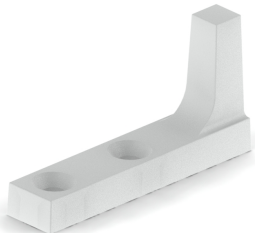
Exterior Handle Kit (varies by style) 1



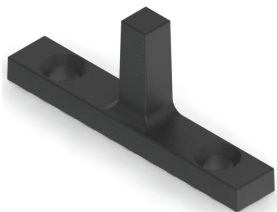
Keyed Cylinder – (keyed alike) (OPTIONAL)



Foot Lock (491019xx Kit) (OPTIONAL)



4-Lite Center Stop - White (49436401 - 49436700 Kit) 1



4-Lite Screen Stop - Black (49436570 - 49436700 Kit) 1

**Note:** There maybe 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 – 49436700 Kit) 21



#8 x 1" Pan Head Screw (49106900– 49436700 Kit) 3



#8 x 5/8" Pan Head Screw (49178500 - 49436700 Kit) 8



#8 x 1 1/4" Pan Head Screw (49101000 - 49436700 Kit) 4



#8 x 3" Phillips Flat Head Screw (49207500 - 49436700 Kit) 2



#6 x 1" Phillips Flat Head Screw (4943384C - 49436700 Kit) 2



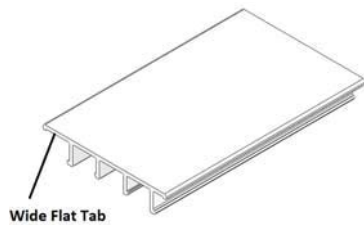
#5410 – 1/2" x 2 Low Profile Fuzz Pad (49100310 - 49436700 Kit) 8



3/8" Hole Plug – Interlock Hole Plug (490608xx - 491025xx Kit) 6



1/2" Hole Plug – Roller Adjustment Plug (490549xx - 491025xx Kit) 4



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



Fixed Panel Bracket (49110300 - 49436700 Kit) 4

## NOTE:

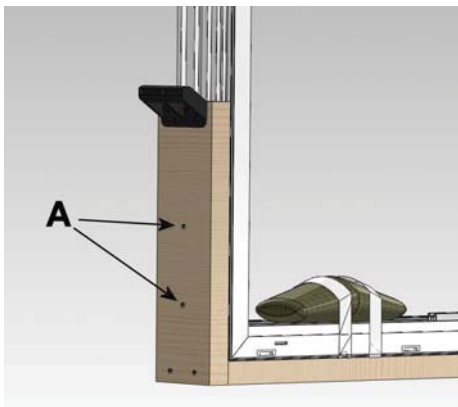
Before starting the installation of this door, please read and understand completely these instructions. Failure to follow and finish these assembly and installation instructions voids all existing and implied warranties.

## 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 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.



5) Place the door unit into the opening Sill first, making sure there is a good seal between the door sill and the floor. Continue tilting the rest of the frame into the opening

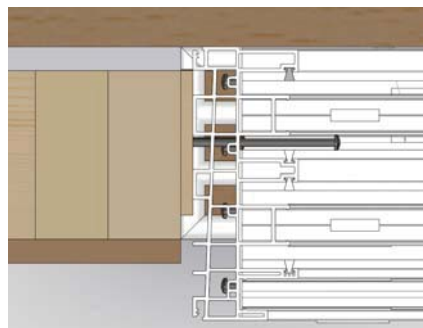
6) Level and square the door frame in to the opening.

- Shim the door frame per the drawing.

Be careful not to over shim the door, as this will cause the door to not operated properly and cause binding.

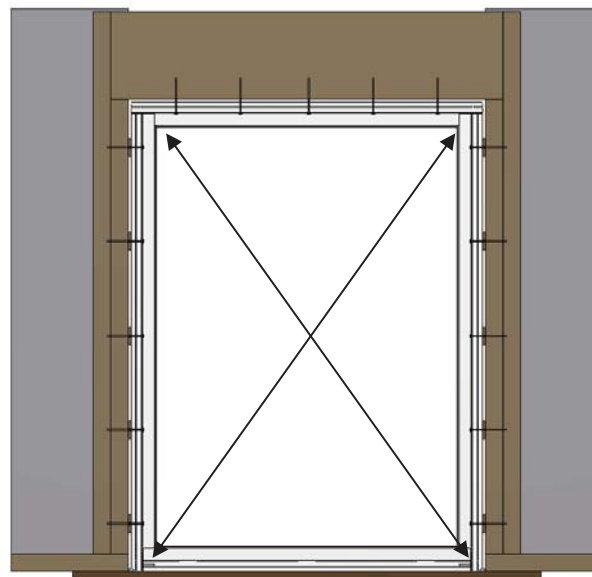
- Fasten the door frame into the opening with the #8 x 3" Phillips Pan Head screws that were provided. Fasten through the outside channel of the interior panel track of the frame members. Put screws 8" from each of the corners and then 3 more screws evenly space along each jamb.

(See figure below) – **DO NOT screw through the Sill. This will void warranty!**



Interior

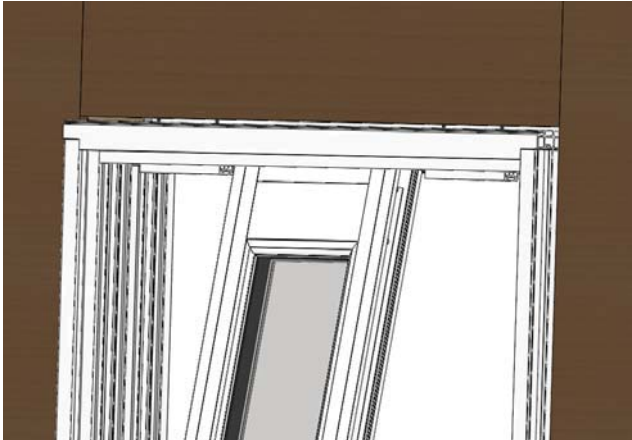
Exterior



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

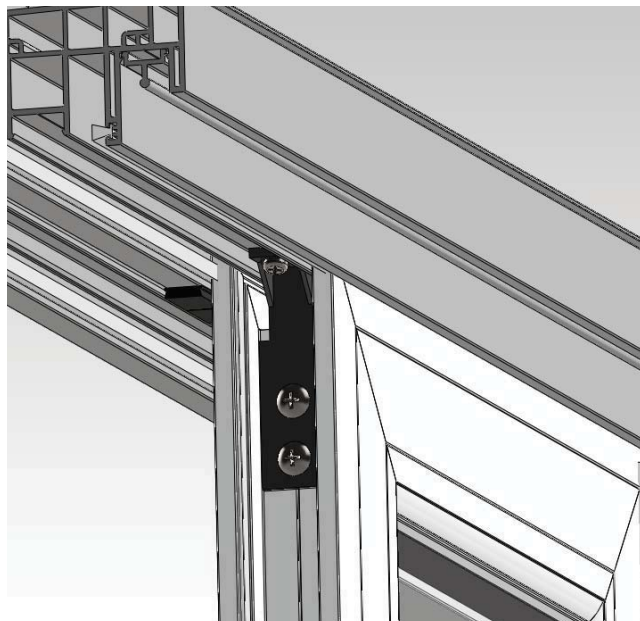
## Step 6 – (Inserting Fixed Sash Panels):

- 1) Insert the fixed sash panels from the exterior of the opening in the center of the door frame into the exterior sash track at the head. Missing the sash panel blocks.
- 2) Swing the bottom of the sash panel over the sill.
- 3) Slide the fixed panels over the sash panel block and fully engaged into the side jamb.



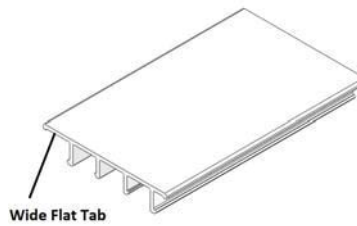
## Step 7 – (Fastening the Fixed Sash Panels):

- 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.

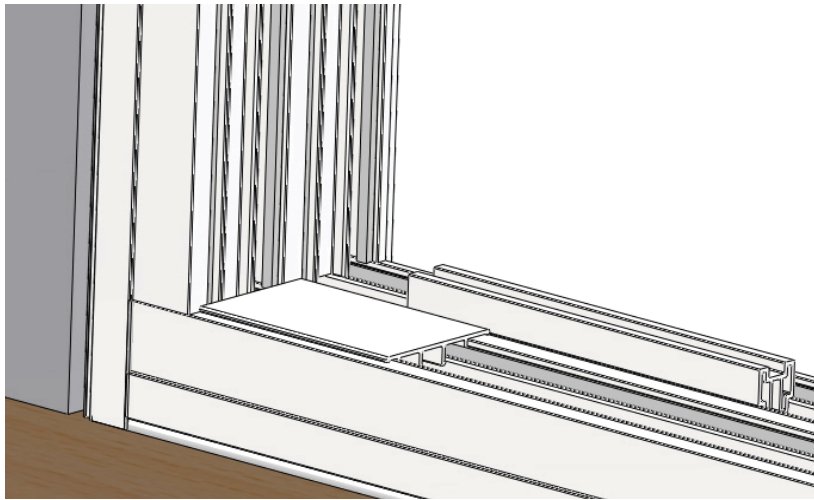




## Step 8 – (Installing 4” Sash Stops – Sill Only):

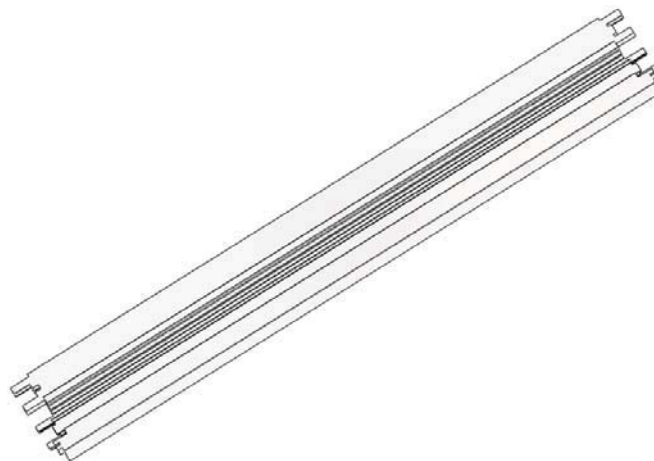


- 1) Insert the supplied 4” sash stops with the wide flat tab toward the fixed panel into the interior sash panel frame track in Sill at the corners of the jamb and sill on the fixed panel sides of the frame as shown. You may need to tap into place with a rubber mallet

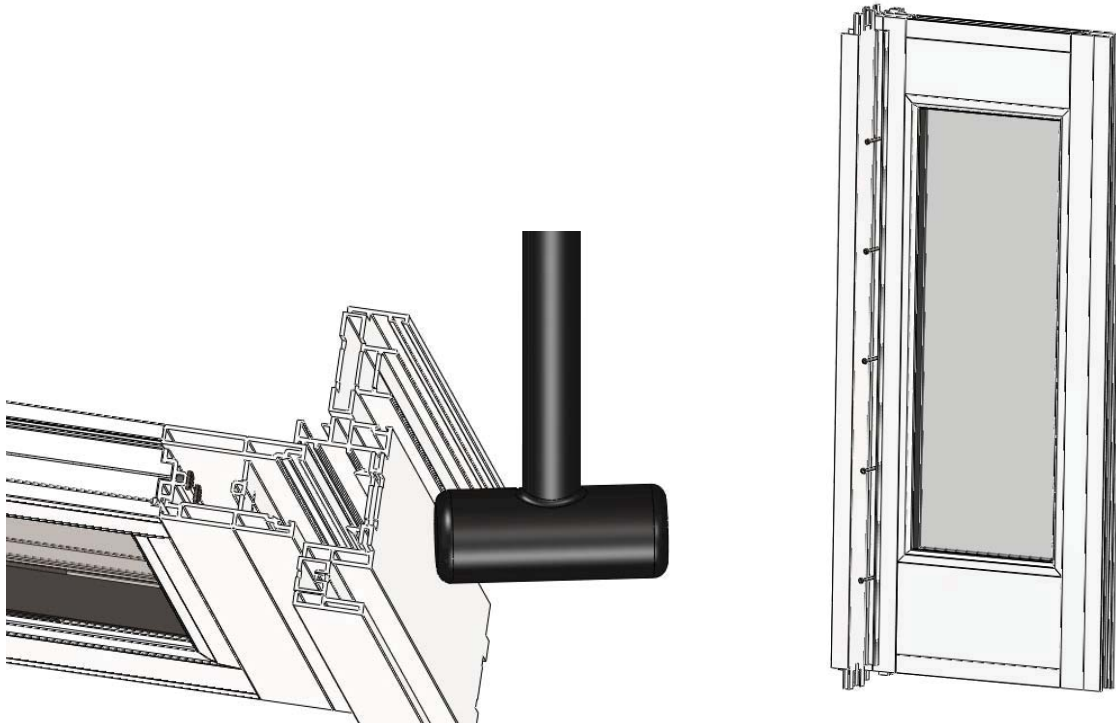


**Note: If you have a 3 panel patio door please go to Step 9.**  
**If you have a 4 panel patio door please go to Step 10**

## Step 9 – (Installing 3 Panel Mullion):



- 1) Remove the weather stripping from the fixed panel on the left from the outside looking in.
- 2) Attach the 3 Panel Mullion to the end of the fixed sash panel to the left.
- 3) Fasten the 3 panel mullion through the screw channel on the interior of the mullion. Place the 5 - #8 x 1/4" Phillips Pan Head screws equally spaced the length of the mullion.



**Step 10 – (Attaching The Fuzz Pads):**

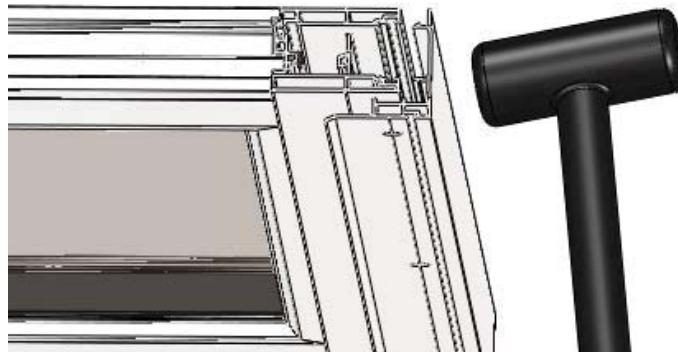
**(On a 3 Panel Door Only Install Next To Left Fixed Panel)**

**(On a 4 Panel Door Install Next To Both Fixed Panel)**



- 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.

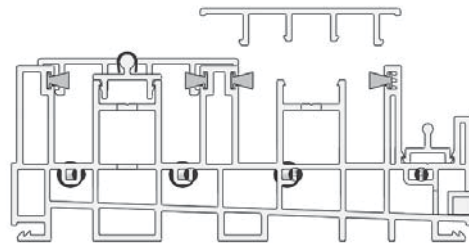
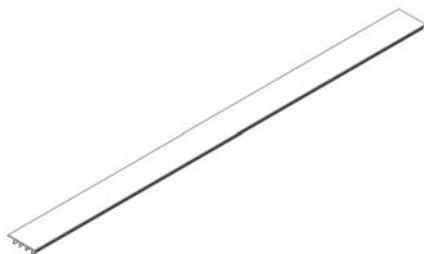
**Step 11 – (Attaching Fixed Panel Interlocks):**  
(On a 3 Panel Door Only Install 1 Interlock)



- 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 12 – (Installing Threshold & Exterior Head Cover):**

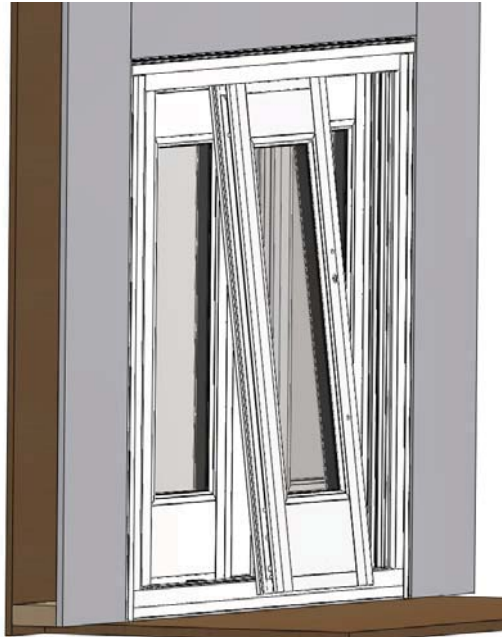
**Note:** If you have a 3" or 5" sash option patio door only install Exterior Head Cover.



- 1) Place the threshold between the 2 fixed sash panels 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.

### Step 13 – (Active Sash Panel or Panels):

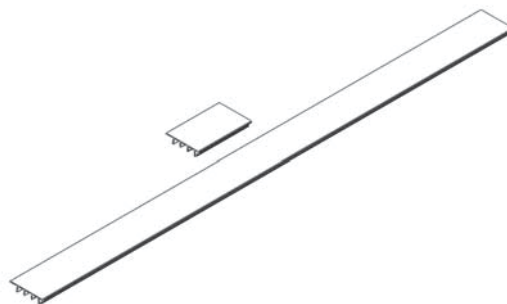
- 1) Insert the active sash panel from the interior of the opening at the center of the door frame into the interior sash track at the head.



- 2) Swing the bottom of the sash panel over the sill
- 3) Slide the active sash panel until it comes in within 4" of the 4" sash stop at the sill.

**NOTE:** If you have a 4 Panel Door insert the next operating sash panel following the steps listed above.

### Step 14 – (Installing Interior Jamb Covers & 4" Sash Stops - Head):

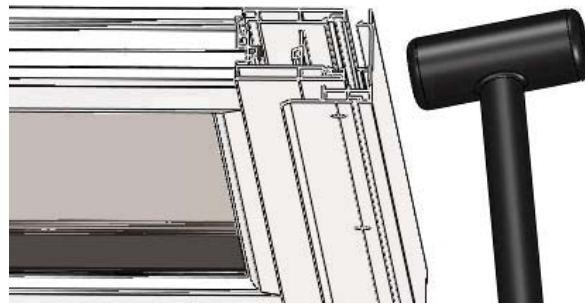


- 1) Insert the supplied 4" sash stops with the wide flat tab toward the fixed sash panel into the interior sash panel frame track in head at the corners on each of the fixed panel sides of the frame. If necessary use rubber mallet to tap securely into place.
- 2) Place the inter jamb covers with the wide flat tab toward the fixed sash panels into the jambs. If necessary use rubber mallet to tap securely into place.



**Step 15 – (Attaching Operating Sash Panel Interlocks):**  
**(On a 3 Panel Door Only Install 1 Interlock)**

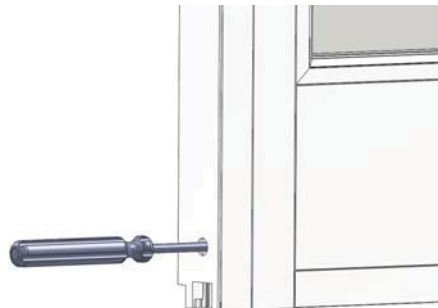
- 1) Prior to installing the Active Panel Interlock, completely close the Active Panel.
- 2) Position the bottom of the interlock just on top of the low profile Fuzz Pad (5410).
- 3) Using a rubber mallet, tap the remaining snap on interlocks to the active panel vertical rail.



**Note: If you have a 3 panel patio door Skip Step 15 and proceed to Step 20.**

**Step 16 – (Roller Adjustment):**

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

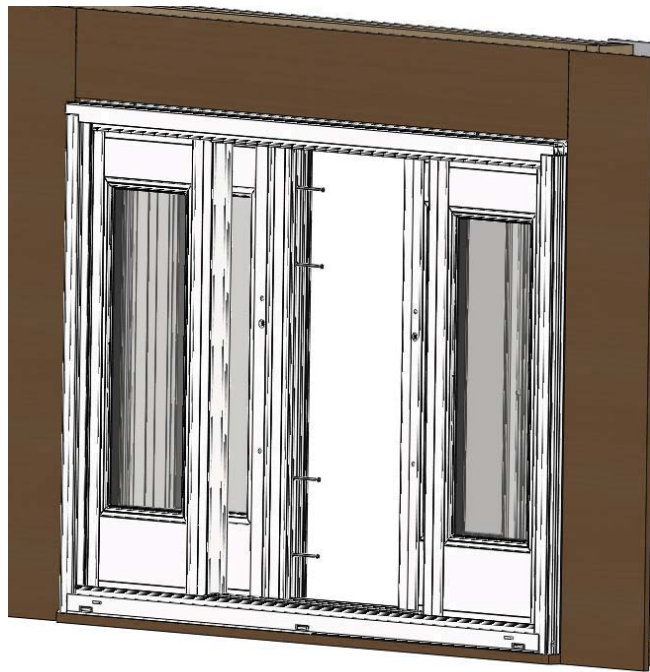


- 3) Adjust roller height as needed (cw – raise panel up , ccw – lower panel down)
- 4) Once adjusted place large hole plugs into adjustment holes on Active Panel.

## Step 17 – (Installing 4 Panel Mullion):



- 1) Open both active panels and insert the 4 panel mullion into the interior sash panel track.
- 2) Attach the 4 panel mullion to sash with out the mortis lock in it. Fasten the mullion to the sash panel using the #8 x 3" Phillips pan head screws provided.



## Step 18 – (Keeper Installation):

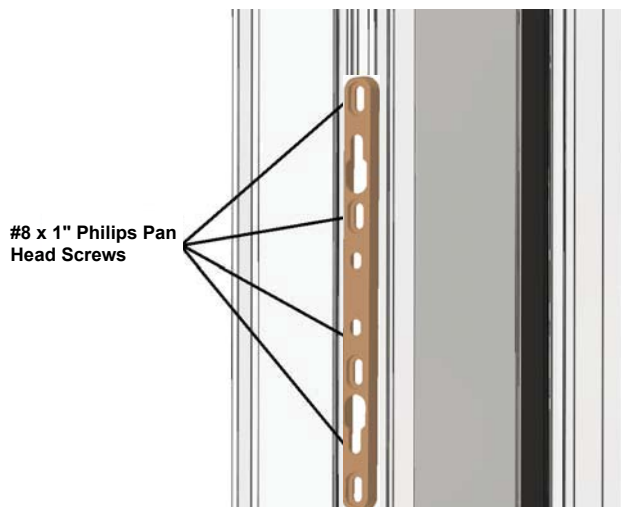


### Step 18a – (3 Panel Door)

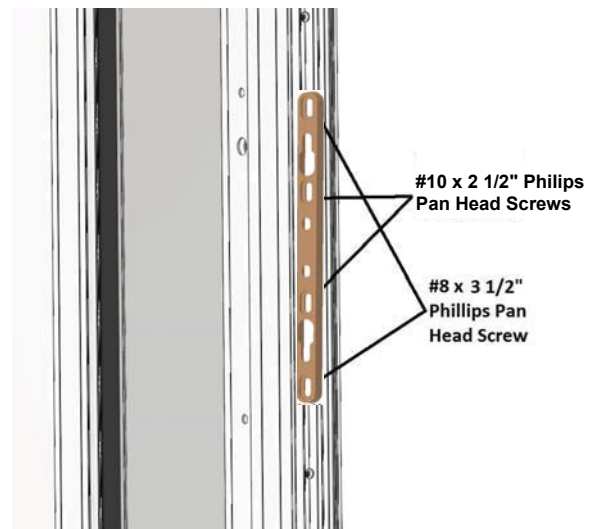
- 1) Place the keeper into the 3 panel mullion.
- 2) Align 2 center slots of keeper with the dimple marks in the mullion.
- 3) Fasten the keeper to the mullion with the (4) #8 X 1" Phillips pan head TEK screws.
- 4) **DO NOT USE THE #10 x 2 1/2" SCREWS BAGGED WITH THE KEEPER. THEY ARE TOO LONG AND WILL PROTRUDE THROUGH THE MULLION!!!**

### Step 18b – (4 Panel Door)

- 1) Place the keeper into the 4 panel mullion.
- 2) Align 2 center slots of keeper with the dimple marks in the mullion.
- 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 1/2" Phillips pan head screws.



3 Panel Installation



4 Panel Installation

### 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.*

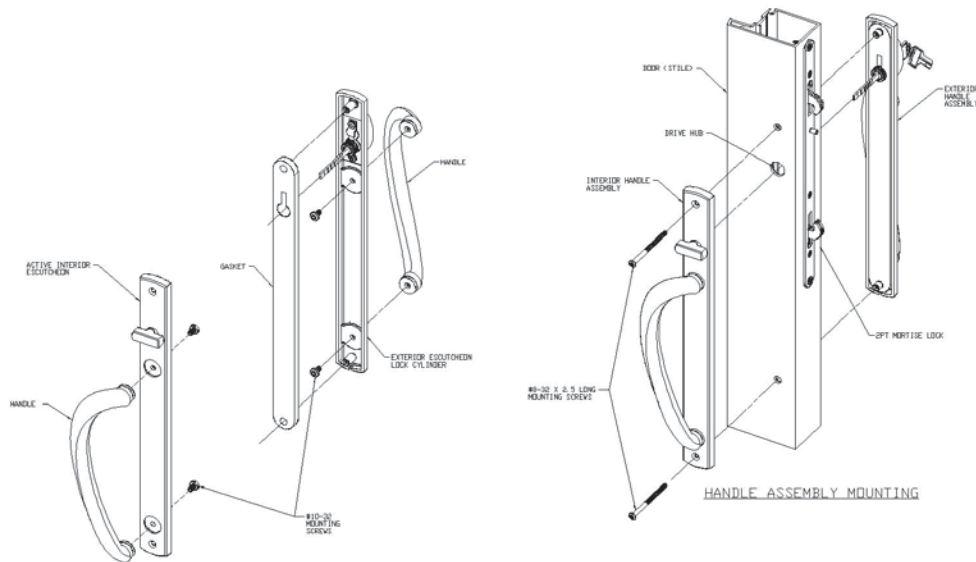
## Step 19 – (Handle Installation):

### (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.)**

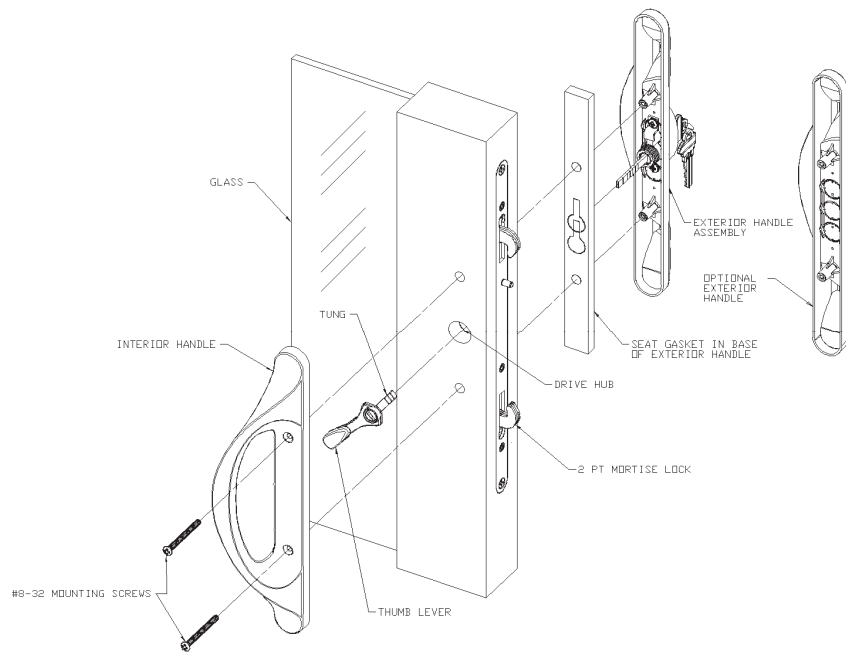
### Adjusting Lock Fingers:

- 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





## 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.

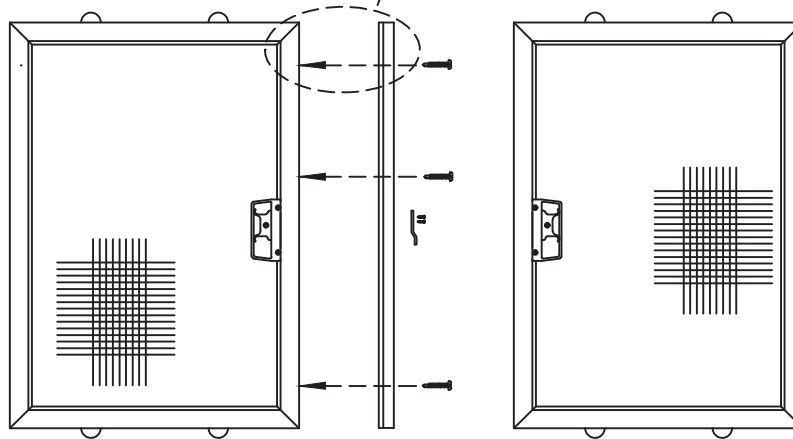
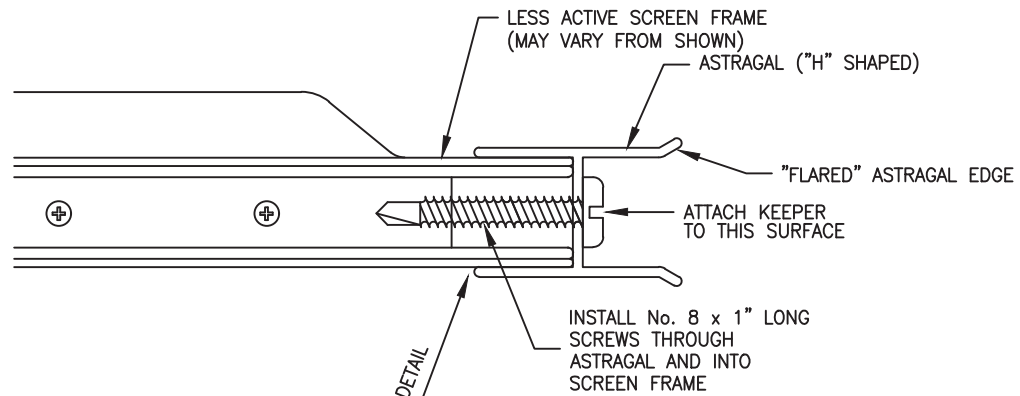
## Step 21 – (Insulating Around Door):

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

## Step 22 – (4-Panel Screen Astragal) :

### PATIO SCREEN ASTRAGAL INSTALLATION

TOP VIEW OF SCREEN FRAME AND ASTRAGAL



ELEVATION VIEW

IMPORTANT: ADJUST ROLLERS OF EACH SCREEN FOR PROPER FIT/OPERATION BEFORE ATTACHING ASTRAGAL, AS ROLLER ADJUSTMENT SCREW ACCESS MAY NOT ALWAYS BE POSSIBLE AFTER ASTRAGAL IS INSTALLED.

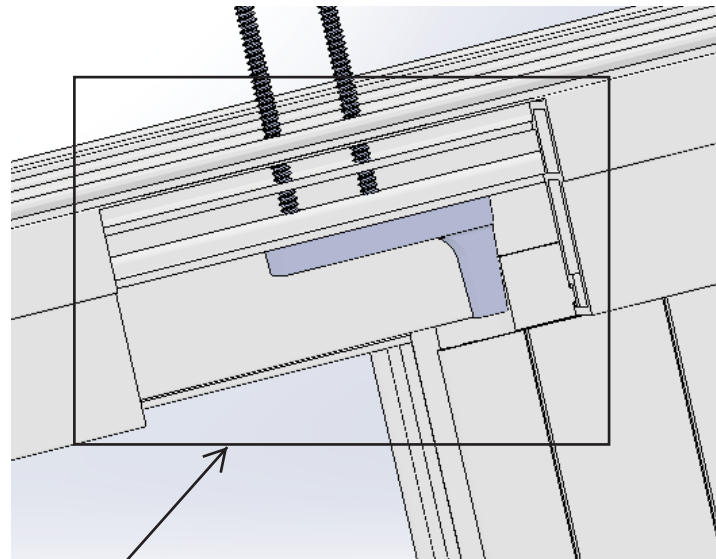
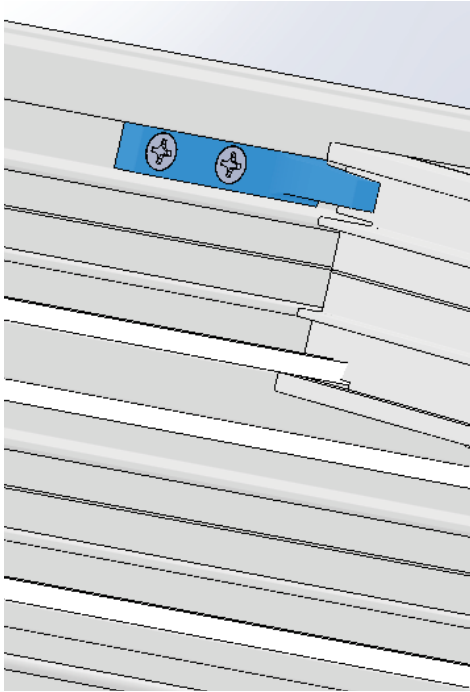
IMPORTANT: WEAR SAFETY GOGGLES

- 1) PLACE "NON-FLARED" EDGE OF ASTRAGAL OVER HANDLE SIDE EDGE OF LESS ACTIVE SCREEN FRAME AS SHOWN. (NOTE: SHOWN ABOVE AS "HANDLE FACING HANDLE" SCREEN APPLICATION. ASTRAGAL CAN ALSO BE APPLIED TO NON-HANDLE SIDE OF LESS ACTIVE SCREEN IF DESIRED).
- 2) WITH ASTRAGAL IN PLACE, IF NOT ALREADY DONE, PRE-DRILL (3) 3/32" DIA. HOLES THROUGH ASTRAGAL AND INTO EDGE OF SCREEN. LOCATE TOP AND BOTTOM HOLES ROUGHLY 6" FROM ENDS OF SCREEN. MAKE SURE TO LOCATE CENTER SCREW HOLE SEVERAL INCHES ABOVE SCREEN HANDLE. INSTALL (3) No. 8 x 1" LONG SCREWS (MAY HAVE BEEN PROVIDED) THROUGH ASTRAGAL AND INTO SCREEN FRAME.
- 3) INSTALL KEEPER/STRIKE OF SCREEN WHICH WILL SLIDE INTO ASTRAGAL TO THE ASTRAGAL AT THE PROPER HEIGHT TO ENGAGE THE HANDLE LATCH.
- 4) SCREENS CAN THEN BE OPERATED TOGETHER (LATCHED) OR INDIVIDUALLY (UNLATCHED).

NOTE: IN SOME CASES, ASTRAGAL LENGTH SUPPLIED MAY HAVE TO BE SHORTENED SLIGHTLY SO THAT ASTRAGAL DOESN'T INTERFERE WITH TOP OR BOTTOM SCREEN TRACKS. USE HACKSAW TO CUT ASTRAGAL WHEN NECESSARY.

### Step 23 – (4-Lite Center Stop Screw Replacement) 4-Panel Door Only :

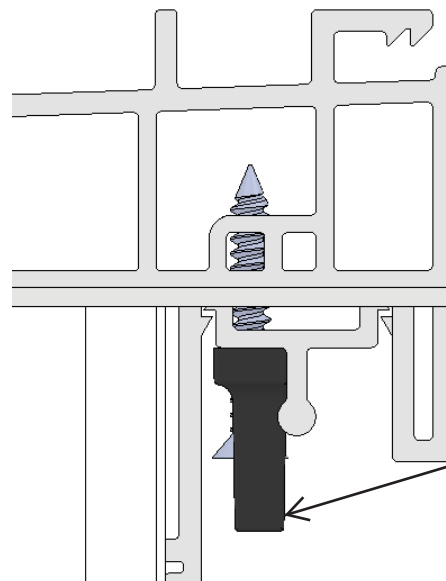
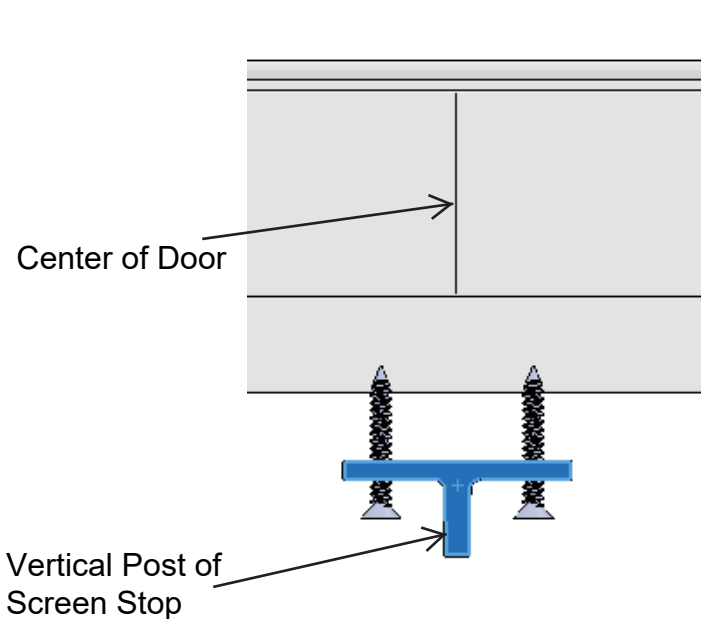
After the Door is installed locate the 4-Lite Center Stop in the Interior sash track in the Head. Remove one short screw at a time and replace with a #8 X 3" Phillips Flat Head Screw provided in the poly bag.



Cut Section View shown for orientation of Center Stop

### Step 24 – (4-Lite Screen Stop Installation) 4-Panel Door Only :

Locate the Vertical post of Screen Stop on center of door, orientate screen stop as shown below in 2nd image and drive screw #6 X 1" Phillips Flat Head Screw.



Flat Surface side of Screen Stop  
(This has to be flat against interior side of Screen track post)

Cross Sectional View shown for orientation of Screen Stop

# ***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 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.

**Notes**

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