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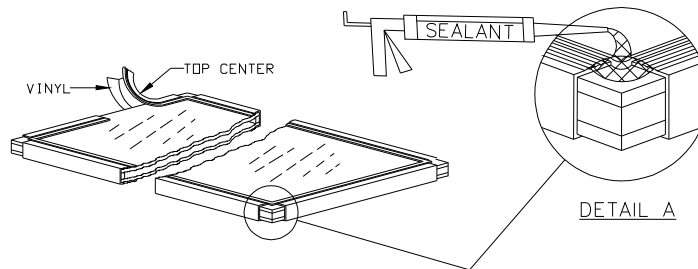
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**I. Care and Maintenance**

1. This product is factory finished. Please 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 (contact factory or print online). 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. After confirming fit, storing screens away from the construction site is recommended.**
2. [http://www.fleetwoodusa.com/menu\\_bar/Products/info\\_caremaint.php](http://www.fleetwoodusa.com/menu_bar/Products/info_caremaint.php)

## II. Glazing Assembly

2. Start attachment of glazing vinyl at top center of the glass.
3. Cut glazing vinyl at all four corners as shown in Detail "A".
4. At start/end point (seam), cut glazing vinyl 1/8" oversize to compensate for stretching. Apply sealant to top portion of this seam.
5. Apply a bead of sealant that is compatible with the insulated glass seal to all four *exterior* corners as shown in Detail "A".



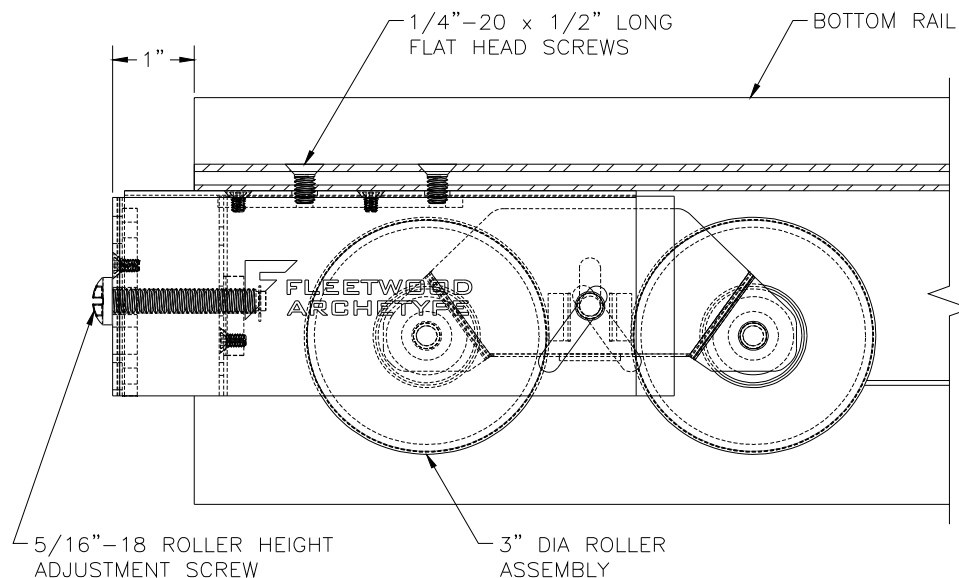
**Figure 1:**  
Glazing Vinyl

## III. Panel Assembly

**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. "X" Panel

- Confirm the roller assemblies (2 required per "X" panel) adjusts properly by turning the adjustment screw both directions using a #4 Phillips screw driver.
- Attach roller assembly to both ends of bottom rail as shown in figure 2.



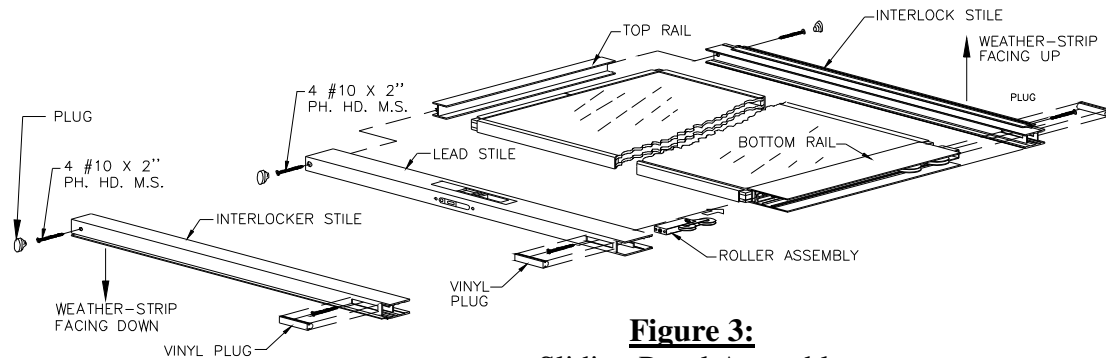
**Figure 2:**  
3" Precision Archetype Roller

- Center the top rail onto the glass. Using a rubber or dead blow mallet and a block of wood, drive the rail onto the glass until the rail seats against the vinyl lip. Repeat this procedure with the bottom rail.

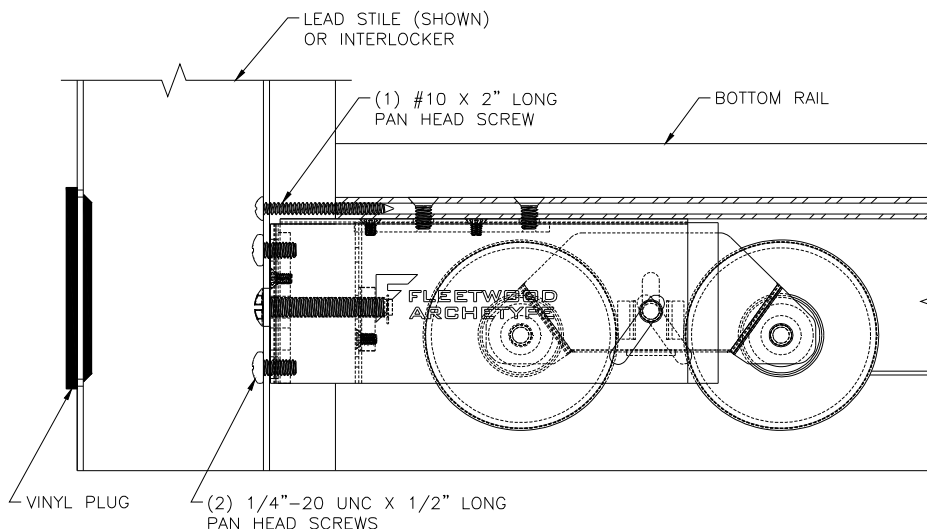
**(Note: Before installing lead and interlocker stiles to panels please check required orientation with customer order. IMPORTANT: On meeting stiles, remove any yokes before glazing as to not damage when driving the stile onto the glass.)**

General rules on panel and stile orientation:

- Operating hardware or thumb turns are always to the interior.
  - On panels with interlocker stiles at both ends, weather stripping should be oriented so that one end is facing up and the other facing down.
- Position the interlocker stile on the right side and drive it onto the glass.
  - Position the lead stile or interlocker stile on the left side and drive it onto the glass.
  - Secure the stiles to the rails with (4) #10 x 2" pan head screws (see figures 3 & 4).
  - Install (2) 1/4"-20 UNC x 1/2" long pan head screws to bottom of interlocker stile or lead stile. Screws attach vertical rails to 3" Mammoth Roller Housing (see figure 4).



**Figure 3:**  
Sliding Panel Assembly



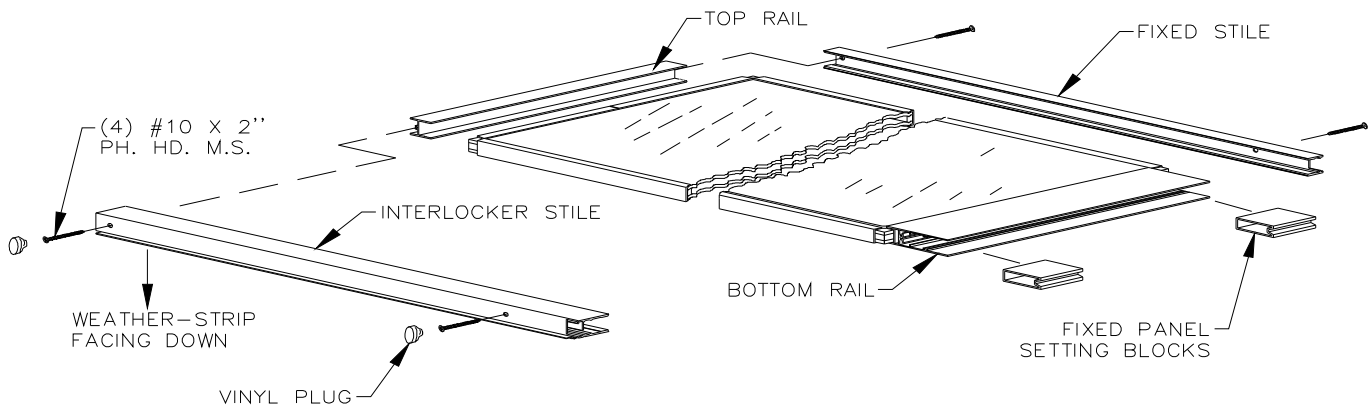
**Figure 4:**  
Sliding Bottom Rail Assembly

## 2. "O" Panel

- Center the top rail onto the glass. Using a rubber or dead blow mallet and a block of wood, drive the rail onto the glass until the rail seats against the vinyl lip. Repeat this procedure with the bottom rail.

**(Note: Before installing interlocker stile to panel please check required orientation with customer order.)**

- Position the fixed stile on the right side and drive it onto the glass.
- Position the interlocker stile on the left side and drive it onto the glass.
- Secure the stiles to the rails with (4) #10 x 2" pan head screws.
- Insert vinyl plugs at top and bottom of stiles.

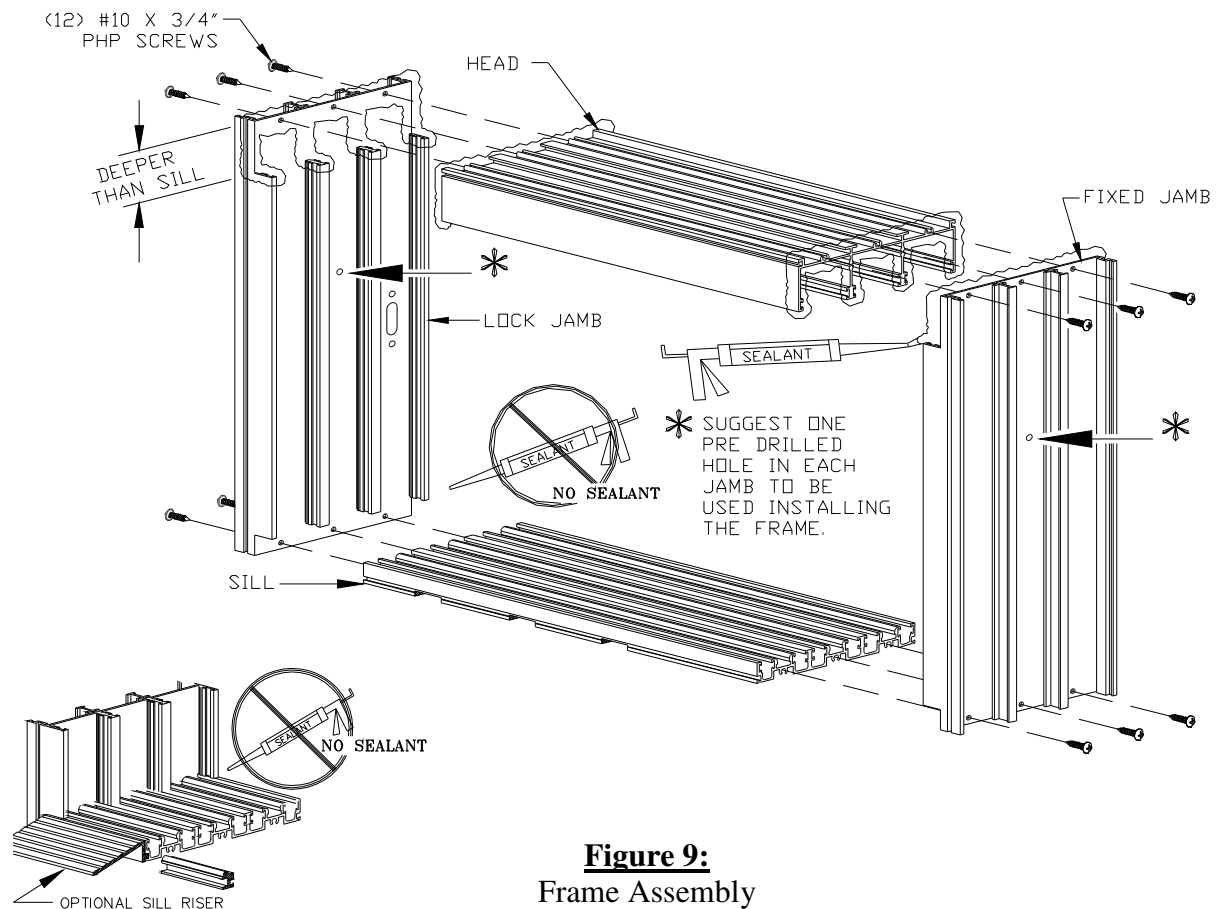


**Figure 5:**  
Fixed Panel Assembly

#### IV. Frame Assembly

1. Recommended that one pre-drilled hole be added in each jamb(s) for use during installation.
2. 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 9.
3. Attach the jamb(s) to the head using #10 x 3/4" long pan head screws (Note: please check that the screws past through jamb(s) and into the screw raceways in the head).
4. Do not add sealant to the lower corners of the jamb(s) or ends of sill track(s).
5. On pocket installations orient sill track so that no weeps holes are located in pocket.
6. Attach the jamb(s) to the sill using #10 x 3/4" long pan head screws (Note: please check that the screws past through jamb(s) and into the screw raceways in the sill).
7. If sill riser (optional) is included, insert riser tab into sill pocket and slide together.
8. After frame has been assembled make sure ample sealant is forced in and around each contour at all head joints.

**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 9:**  
Frame Assembly  
(3-Track Shown)

## V. Frame Opening Verification & Sillpan<sup>1</sup> Installation

### 1. Sillpan Substitution

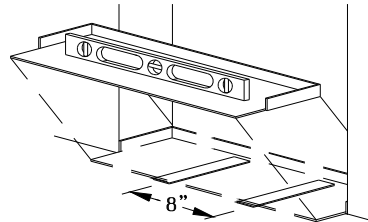
- If the factory provided sillpan is not desired, the product warranty will remain intact if the substitute panning system emulated the essential design of the factory pan. This sliding door system has passed specific air, water, energy and structural testing with the factory provided sillpan.

### 2. Frame Opening Verification

- Check the measurements of the opening and verify that the door will fit into the opening.

### 3. Pre-Fit and Leveling

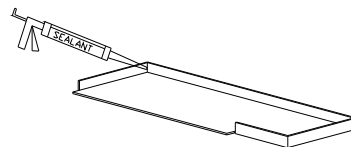
- Place sillpan into the opening and determine leveling that must be done prior to installation.
- Shim as necessary to stabilize the entire depth and length of the sillpan. No unsupported width of more than 8" is allowed.
- If more than 1/8" shim height is required, it is recommended that pouring self-leveling "Rock Hard" (or equal) to achieve level and stable surface.



**Figure 10:**  
Sillpan leveling

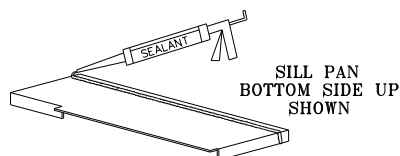
### 4. Sealant Application / Joining Sillpans

- Apply sealant in all corners and seams of the sillpan.

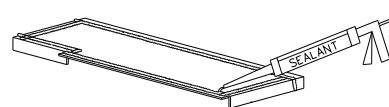


**Figure 11:**  
Seal corners and seams

- With bottom side of sillpan up, apply a 3/8" bead of compatible sealant 1/2" in from interior leg (see figure 12). Sealant bead to run across the bottom as well as up each vertical leg of the sill pan. Also apply sealant beads near the sides and across the front as shown in figure 13.



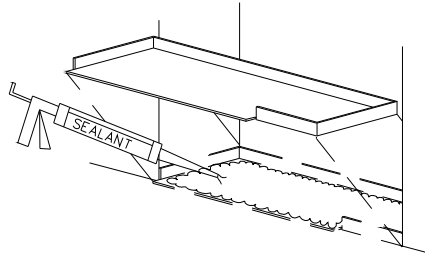
**Figure 12:**  
Bead 1/2" from interior leg



**Figure 13:**  
Bead at sides and across front

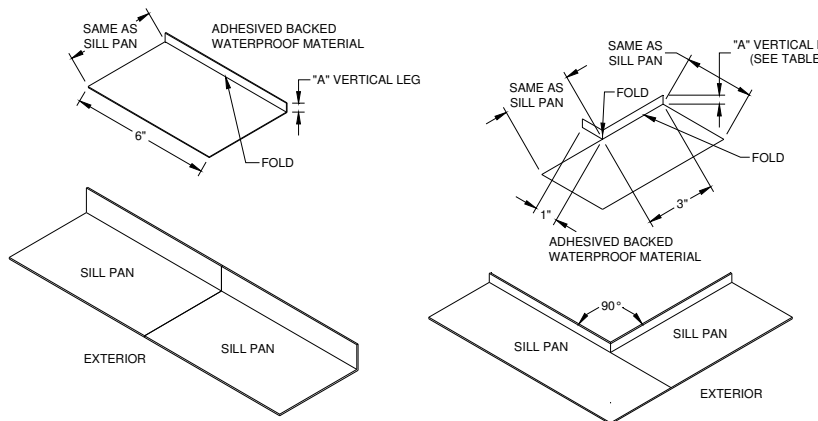
<sup>1</sup> Sillpan refers to a factory provided aluminum pan (or equivalent).

- Secure the sillpan to the floor with a compatible construction adhesive. **Caution:** For pocket doors do not forget required space for post interlocker. Sill track is located 3/8" from pocket wall on side with post interlocker. Position sillpan as necessary to allow for proper installation of frame assembly.

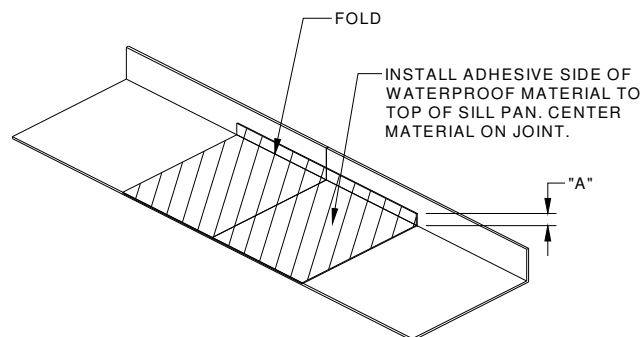


**Figure 14:**  
Seal Sillpan to floor

- If sillpan is more than one piece, butt the pieces and glue them to the floor together.
- Cut a piece of adhesive backed waterproof material to fit the joint as specified in figure 15, A= 1/4". **Caution:** Select waterproofing material that is compatible for your application. Waterproofing material must have an adhesive backing and be capable of withstanding the temperature ranges for your region
- Apply sealant to all interior and exterior seams.



**Figure 15:**  
Joining Sillpans with adhesive backed material



**Figure 16:**  
Adhesive backed material centered on seam

## VI. Frame Installation

### 1. Anchor Requirements

Frame may be either direct mounted to the opening, mounted onto a continuous wood spacer, anchored to a min. 18 ga. 33 ksi metal stud or anchored to a min. 2x4 no. 3 southern pine wood buck. When anchored to a 2x\_ buck or metal stud, no. 10 screws shall be used. When direct mounted or mounted with spacer to block/concrete, 1/4" concrete screws shall be used. See "anchor requirements table" for embed requirements. Proper material shall be used between all dissimilar materials (block/concrete & aluminum).

Frame Anchor Requirements Table			
Opening Type (Substrate)	Jamb to Opening Fastener Type	Minimum Embedment	Minimum Edge Distance
2X_ Wood Frame of Buck	No. 10 SMS Screw	1-1/4"	3/4"
Min. 18 GA. 33 KSI Metal Stud	No. 10 SMS Screw	FULL	3/8"
CMU/Concrete	<sup>(1)</sup> 1/4" Concrete Screws	1-1/4"	1-3/4"
<sup>(1)</sup> Concrete screws shall be ITW Ramset/Red Head Tapcons, ELCO Tapcons, Hilti Kwik-Con II or Powers Rawl Tapper (Hardened Steel or S.S.).			

### 2. Anchor Locations

- Frame installation anchors furnished by installer, not by Fleetwood. Stainless steel screws are recommended.
- **Head & Sill** – Frame anchors spaced 5" from ends and then evenly on 16" (max.) centers. One frame anchor required per track per location. Example: 3-Track system requires 3 anchors per location at both the head and sill (see figure 17).
- **Jambs** – Frame anchors spaced 4" from ends and then evenly on 12-1/2" (max.) centers. Two frame anchors are required per location for both 2 and 3 track jambs. When additional jamb tracks are used a minimum of one row of anchors is required for each track.
- **Meeting Stiles** – When meeting stiles are used in a 2-track system an additional set of anchors is required at the meeting point of the stile ends in both the head and sill.
- **90 Degree Corners** – Frame anchors spaced 5" from ends and then evenly on 16" (max.) centers. One frame anchor required per track per location. Example: 3-Track system requires 3 anchors per location at both the head and sill. Anchors at miter corner connection of frame shall not be more than 5" from exterior corner.

### 3. Sealing Sill Anchors

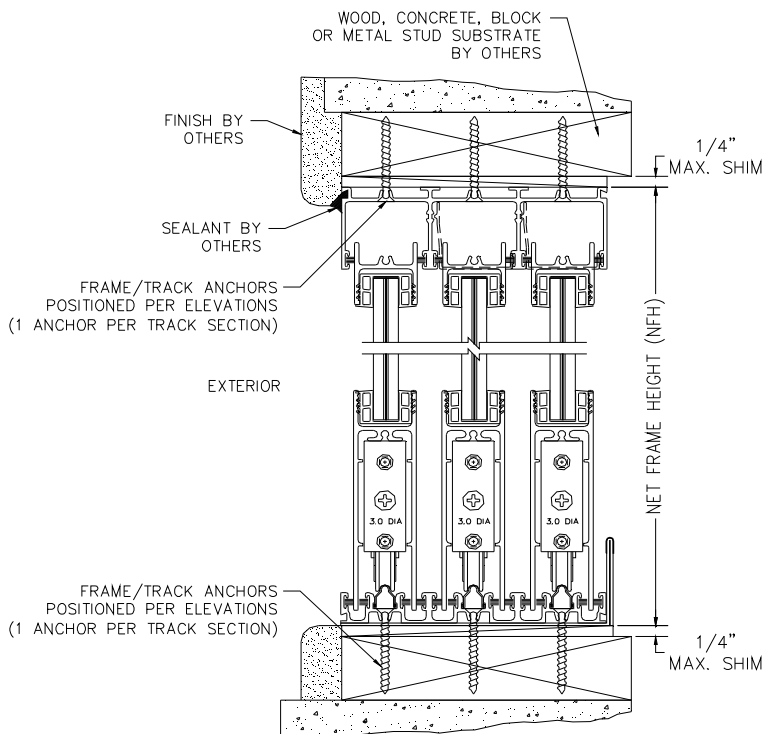
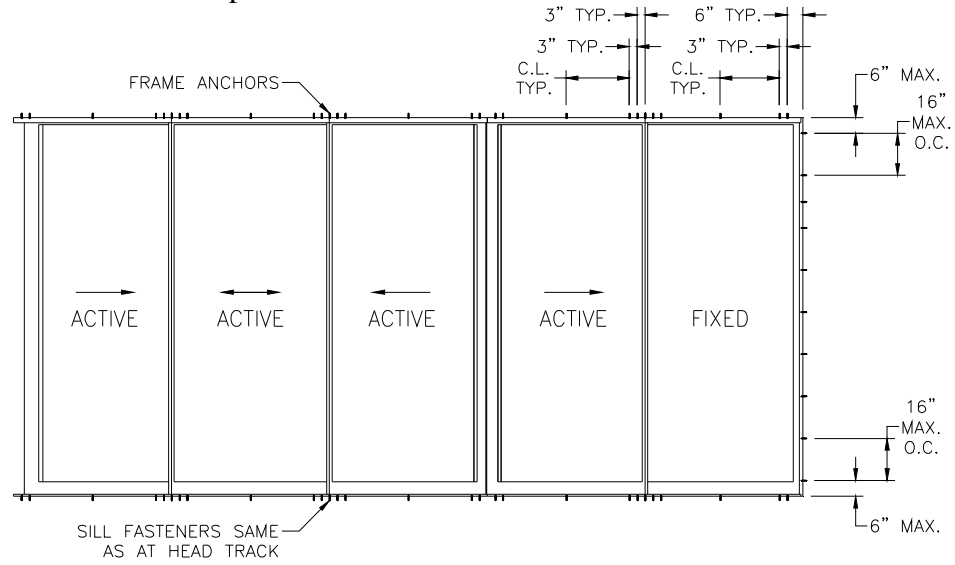
- When using 1/4" concrete screws, remove dust from around drilled hole after drilling.
- Before installing sill anchors, apply a compatible sealant into the drilled hole, filling the pocket area between the sill track and sill pan.
- After installing the anchor, apply sealant over the anchor screw head (see figure 18).



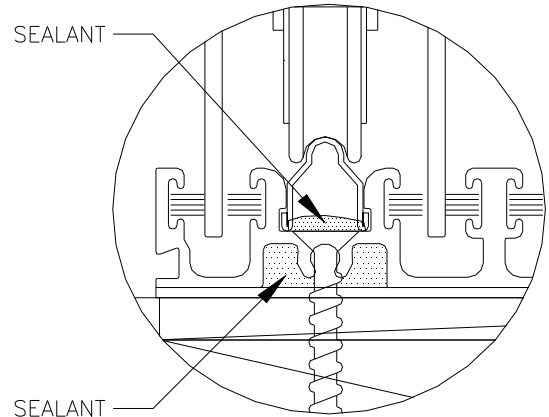
**4. Shims**

- If shim space between substrate and door frame member exceeds 1/4", a continuous wood member, with depth equal to or greater than the frame depth must be placed between the frame and substrate and the frame anchors must run through the spacer into the substrate with the specified embedment.

**Figure 16:**  
Anchor Spacing



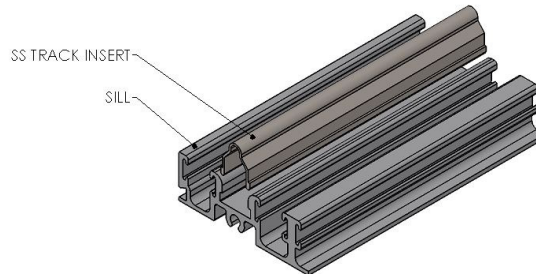
**Figure 17:**  
Fastener locations, Head and Sill



**Figure 18:**  
Sealant at sill Anchors

### 5. Sill Track Installation

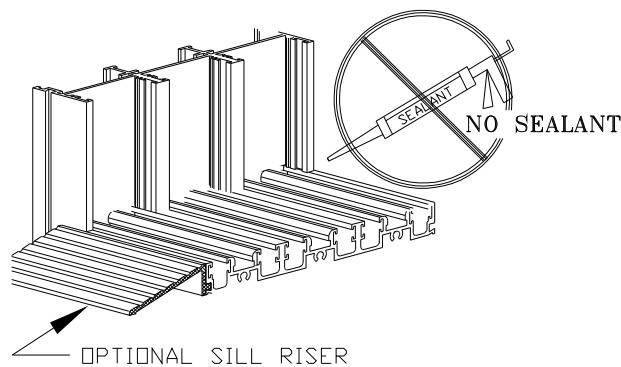
Snap stainless steel tracks into all sill tracks. Note: Be careful not to bend or deform the track before or during installation. Damage to the track before or during installation will affect performance of the rollers.



**Figure 19:**  
Stainless Steel track insert

### 6. Optional Sill Riser

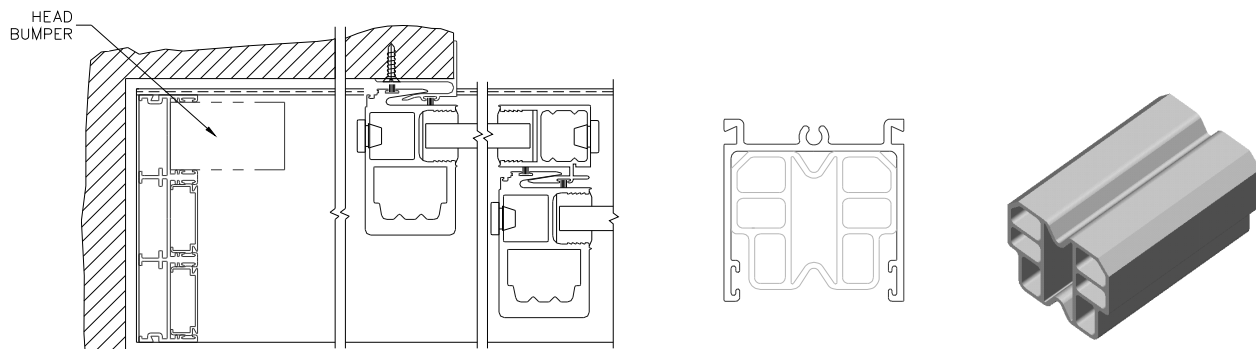
Do not close off ends of sill riser unless weeps in the face have been provided. No weeps provided on Pemko sill riser. Do not apply sealant under or around sill riser.



**Figure 20:**  
Optional Sill Riser

### 7. Head Bumper Installation

Install black rubber bumper in the frame head as shown below. Only one bumper is usually required in the head of the pocket-interlocking panel on pocket doors, and in the head of the sliding panel that is next to the fixed panel, on non-pocketed doors.

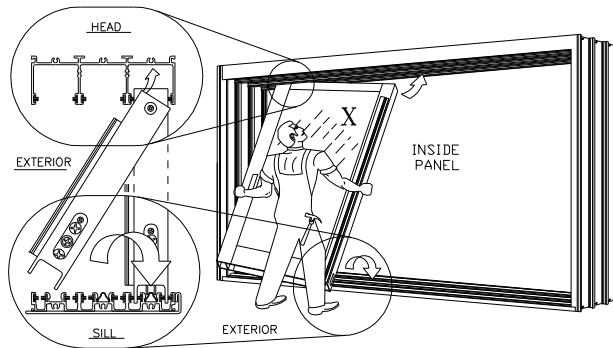


**Figure 21:**  
Head Bumper location-(L-type post interlocker shown)

## VII. Panel Installation Non-Pocketed Doors (OX, OXX, etc.)

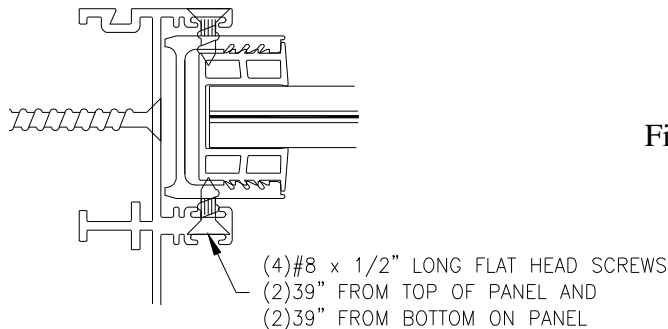
**Note: Check customer order for proper panel configuration and orientation.**

1. Sequence of panel installation is from interior to exterior.
2. Insert panel (panel located on the track closest to the interior) into the upper head channel. Push up and swing the bottom inward until panel is vertical, then lower panel down onto the track.



**Figure 22:**  
Panel Installation

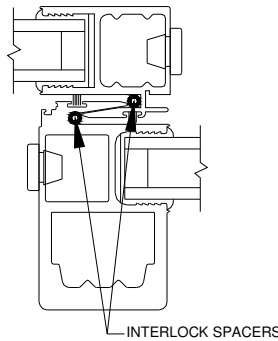
- **“X” Panel** - Do not attempt to slide the panel unless the rollers have been adjusted. Adjust the rollers as needed to make the panel plum and level. The top of the bottom rail should be 3-5/8” above the sill for the standard bottom rail (rail height 4-1/32”) and 4-3/4” for mammoth bottom rail (rail height 5-5/32”) for the best weather seal. If the panel contains a lock stile, verify that the latch height is correct for proper operation with the frame. Insert vinyl plugs into the holes at top and bottom of the panel.
- **“O” Panel** - Lift and move the panel into the fixed jamb as far as possible. Verify that the weather stripping in the frame head is located so that it contacts the width of the “O” panel. Add (4) #8 x 1/2” long flat head screws to all fixed panels as shown below in figure 22. Screws shall be countersunk and located 39” from top and bottom.



**Figure 23:**  
Fixed Panel anchoring

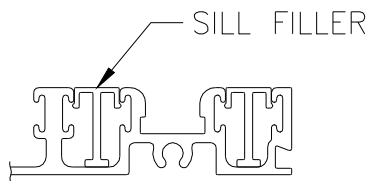
3. Repeat step 2 until all panels have been installed. . (Note: panels must overlap during installation to allow proper engagement of interlockers.)

- Verify that all panels with interlocker hooks engage properly. If lead stile panel is not engaging properly with the jamb or meeting stiles, remove interlock spacers as necessary.



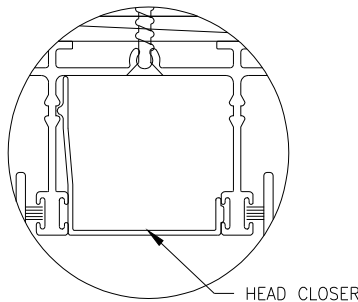
**Figure 24:**  
Interlock spacers

- Install sill fillers into sill tracks except where it will interfere with the sliding panels. (See figure 25).



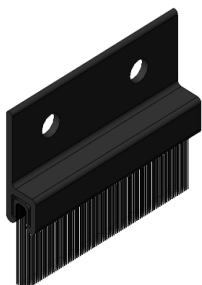
**Figure 25:**  
Sill Fillers

- Install head closer(s) into the head except where the closer interferes with sliding panel(s). (See figure 26)



**Figure 26:**  
Head Closers

- After all panels have been adjusted plum and level and panels close and lock, open panels and install air barriers. Air barriers are attached to the bottom (see figure 27) and top (see figure 28) of all sliding interlockers and secured with (2) #6 x 3/8" long, Tek screw



**Figure 27:**  
Bottom Air Barrier

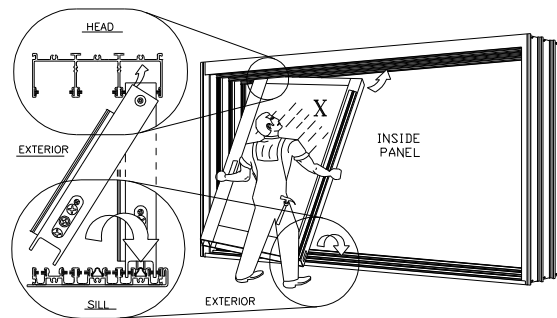


**Figure 28:**  
Top Air Barrier

### VIII. Panel Installation Pocketed Doors (PX, PXX, etc.)

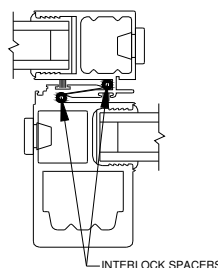
- Note:**
- a) Check customer order for proper panel configuration and orientation.
  - b) Pocket walls: Installer to flash inside pocket walls to adequately protect from moisture.
  - c) Installation of panels should be completed before construction of pocket is complete.

1. Sequence of panel installation is from interior to exterior.
2. Insert panel (panel located on the track closest to the interior) into the upper head channel. Push up and swing the bottom inward until panel is vertical, then lower panel down onto the track. (Note: On PX or XP configurations, if the pocket construction has been completed, it may be necessary to remove the lead stile from the panel before installation into the frame can be accomplished.)



**Figure 29:**  
Panel Installation

3. Do not attempt to slide the panel unless the rollers have been adjusted. Adjust the rollers as needed to make the panel plum and level. The top of the bottom rail should be 3-5/8" above the sill for the standard bottom rail (rail height 4-1/32") and 4-3/4" for mammoth bottom rail (rail height 5-5/32") for the best weather seal. If the panel contains a lock stile, verify that the latch height is correct for proper operation with the frame. Insert vinyl plugs into the holes at top and bottom of the panel.
4. For doors with an exterior pocket interlocker, move panel into the closed position; otherwise move panel into the wall pocket.
5. Repeat steps 2-4 until all panels have been installed. (Note: panels must overlap during installation to allow proper engagement of interlockers.)
6. Verify that all panels with interlocker hooks engage properly. If lead stile panel is not engaging properly with the jamb or meeting stiles, remove interlock spacers as necessary. (see figure 30)

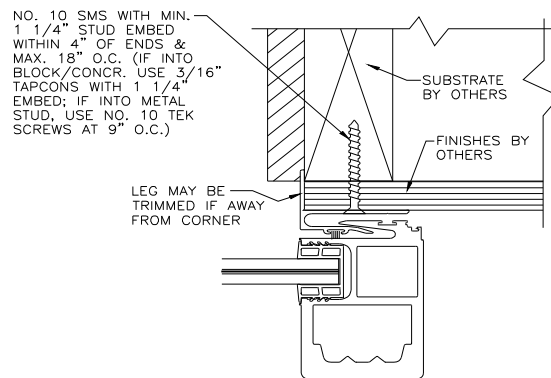


**Figure 30:**  
Interlock Spacers

7. To install pocket interlocker slide all panel(s) into the wall pocket. Pocket interlocker is furnished net frame height and must be field cut. Attached pocket interlocker with anchors as specified in table below. Drill and countersink as required.

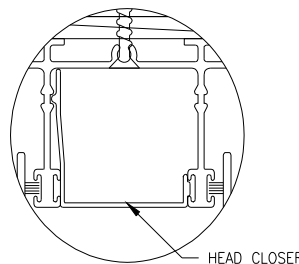
Pocket Interlocker Anchor Requirements Table			
Substrate Type	Jamb to Opening Fastener Type	Minimum Embedment	Locations
2X_ Wood Frame of Buck	No. 8 Flat Head Screw	1-1/4"	4" From Ends & 12" O.C.
Min. 18 GA. 33 KSI Metal Stud	No. 10 Flat Head Tek Screw	FULL	4" From Ends & 9" O.C.
CMU/Concrete	<sup>(1)</sup> 3/16" Flat Head Concrete Screws	1-1/4"	4" From Ends & 18" O.C.

<sup>(1)</sup> Concrete screws shall be ITW Ramset/Red Head Tapcons, ELCO Tapcons, Hilti Kwik-Con II or Powers Rawl Tapper (Hardened Steel or S.S.).



**Figure 31**  
Post Interlocker Anchor Spacing  
(L-Type shown)

8. Install head closer(s) into the head except where the closer interferes with sliding panel(s).



**Figure 32**  
Head Closer location

9. After all panels have been adjusted plum and level and panels close and lock, open panels and install air barriers. Air barriers are attached to the bottom (figure 33), and top (figure 34) of all sliding interlockers and secured with (2) #6 x 3/8" long, Tek screws.



**Figure 33**  
Bottom Air Barrier

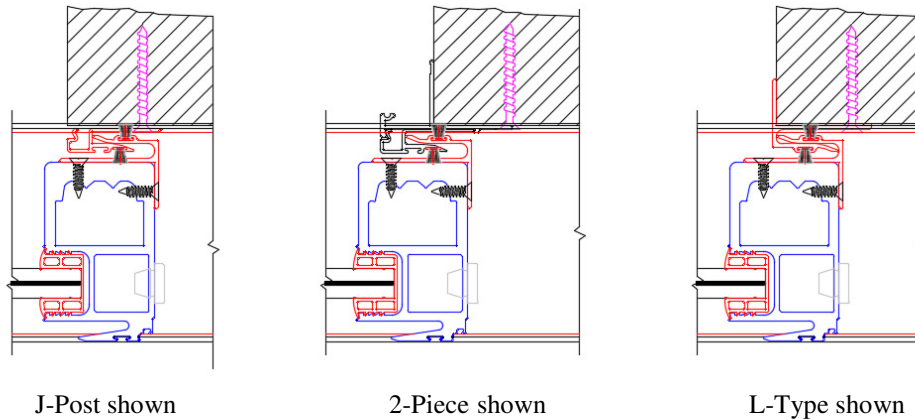


**Figure 34**  
Top Air Barrier

### IX. HP Interlocker at Pocket

**Note:** This option allows HP stiles to pocket flush to your finished wall in the open position.

10. Panels are installed in the same manner as describe in section VII, page 15.
11. The Pocket panel (panel that interlocks to the post interlocker) will install into the 2nd track from the exterior on doors with an exterior post interlocker. The outermost track is a false track with sill fillers and head closers filling the entire length. On doors with an interior post interlocker the panel will install into the 2nd track from the interior. (refer to the customer order for configuration)
12. Once the panel is installed and adjusted, install the air barriers at the top and bottom of the interlocker at the pocket.



**Figure 36:** HP Interlocker at Pocket.