



4-PANEL (OXXO) KNOCK-DOWN SLIDING DOOR ASSEMBLY

TOOLS REQUIRED:

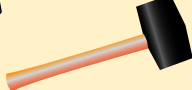
- Screw Gun with a Phillips Drive bit



- Sealant Gun



- Mallet

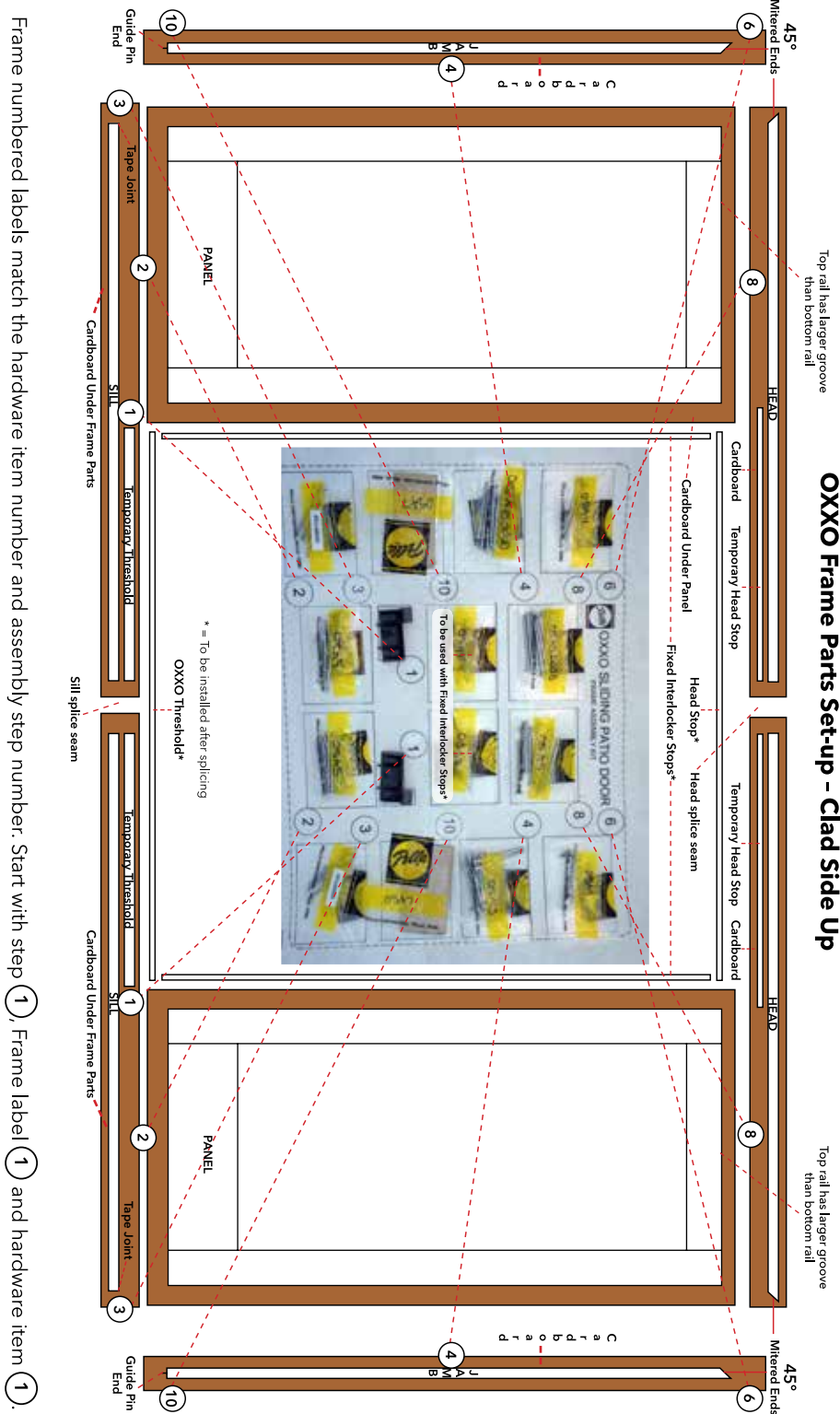


- Quick Grip Clamp



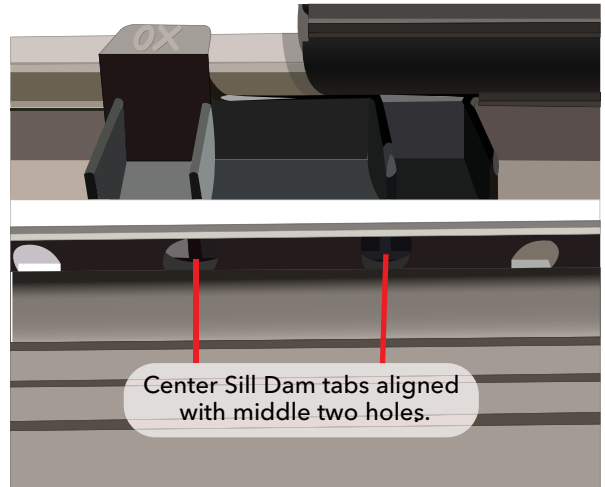
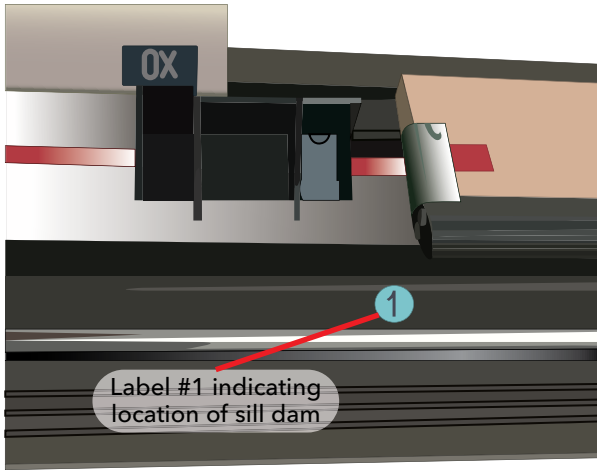
REMEMBER TO USE APPROPRIATE PERSONAL PROTECTIVE EQUIPMENT

Lay parts on a flat hard surface with exterior cladding side up. Pella recommends keeping the panel and the frame parts on the cardboard to protect the interior surface during the assembly process. Frame parts have plastic spacers installed which help in panel alignment. The step numbers of the following instruction correspond to the screw package numbers on the skin card and the number labels on the frame parts. Screw packs may include extra screws.

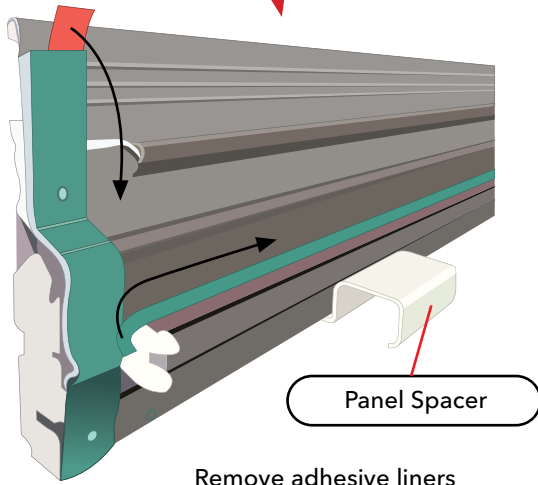
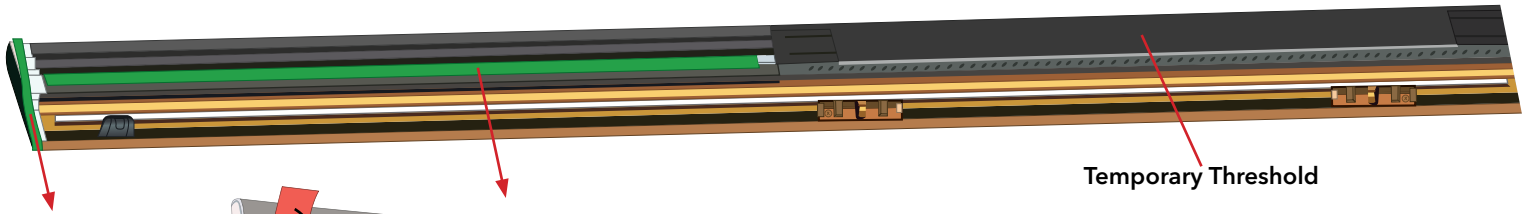


1

SILL ATTACHMENT: Sill dam – align the two tabs of hardware item ① with the two middle holes in the sill extrusion at label ① location. Rotate the sill dam down and snap onto the sill. The sill dam must be installed before the sill is attached to the bottom of the panel because the sill dam is held in place by the bottom edge of the panel cladding.

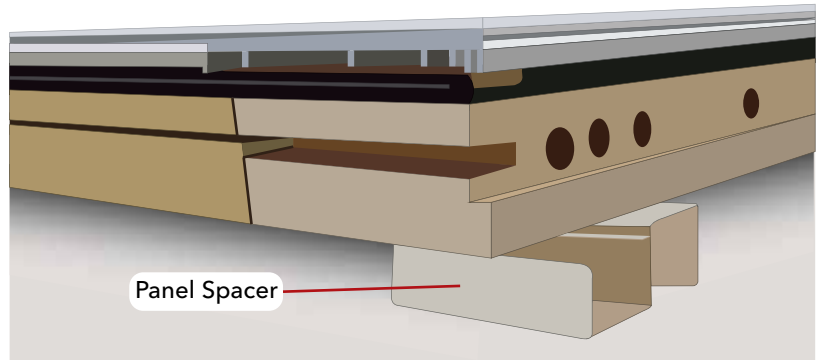


Remove the two adhesive liners from the sill. (1 from the end of the sill and 1 from across the sill.)

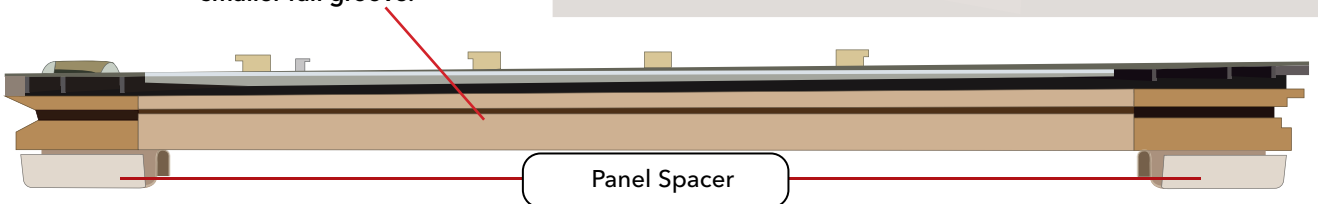


Remove adhesive liners

Use two of the loose panel spacers found in the Head & Sill Package to place under the bottom end of the panel.



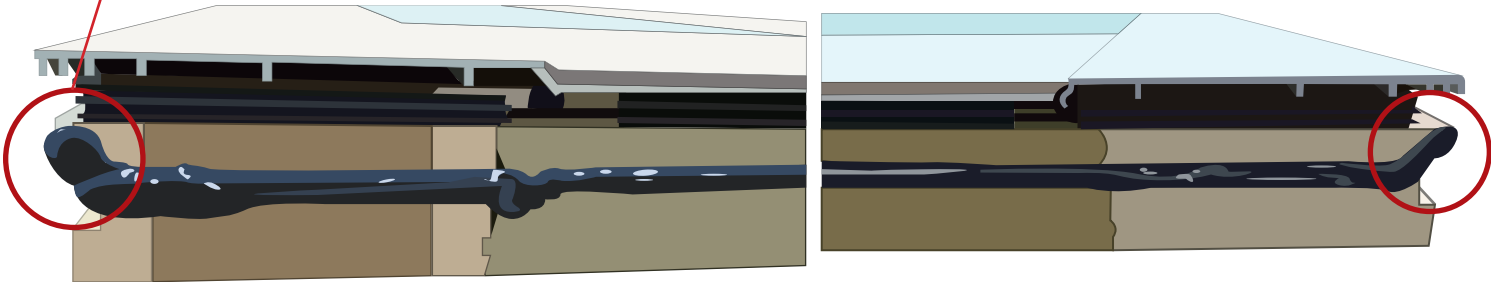
Bottom of panel at sill end has smaller rail groove.



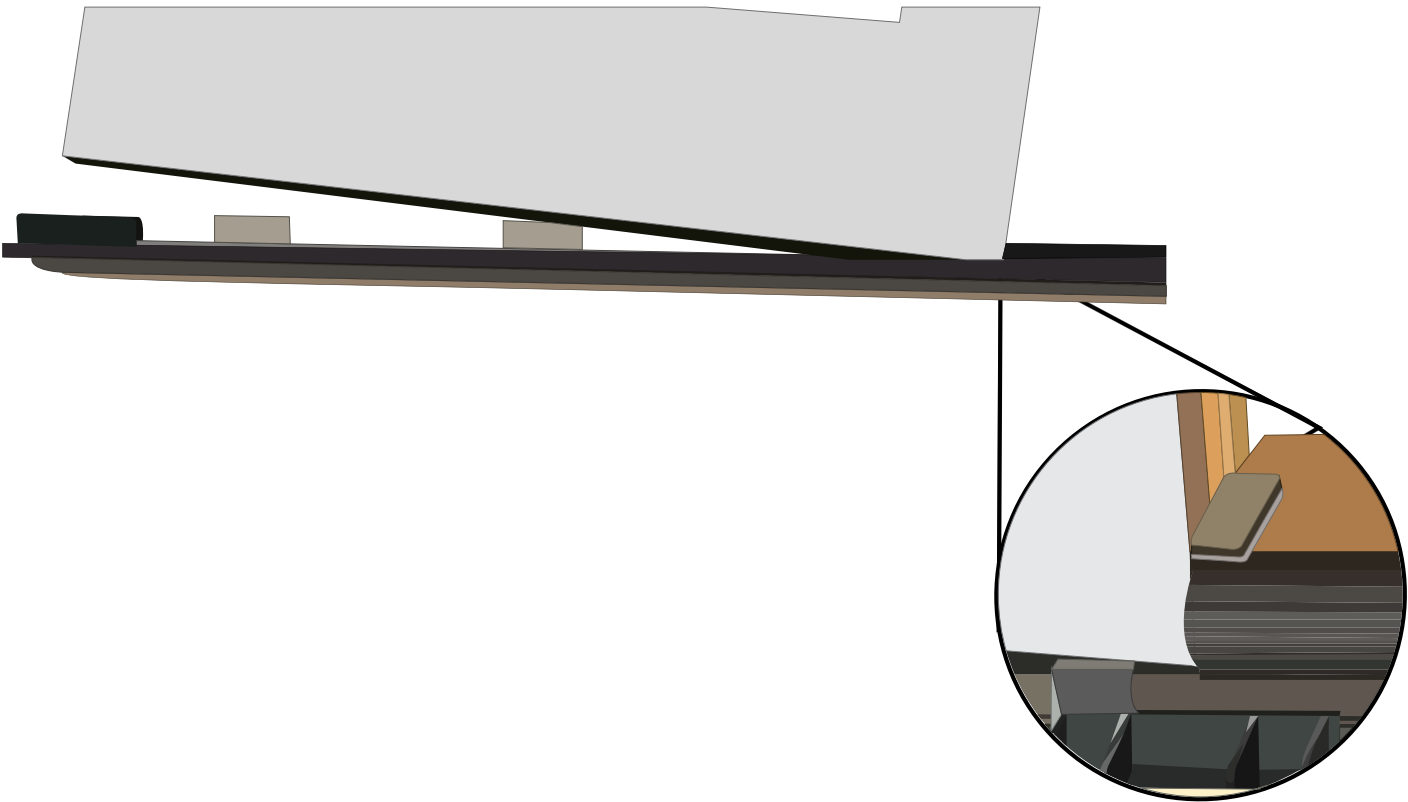
2

FIXED PANEL TO SILL ASSEMBLY: Place a bead of sealant in the groove across the length of the panel bottom.

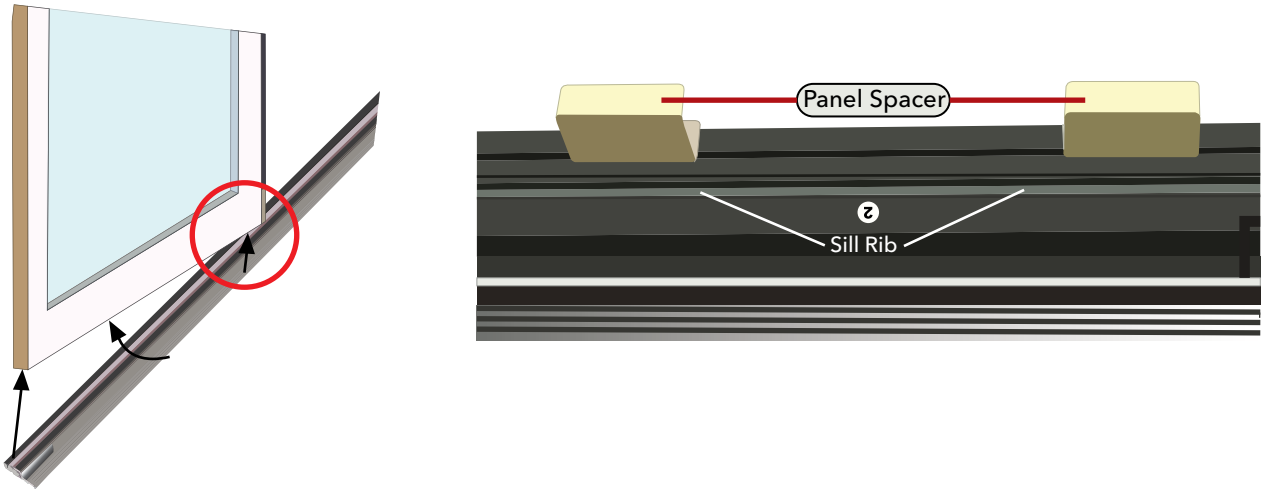
Note: Sealant must reach edge of wood on both ends.



Position panel corner in the threshold/sill corner first.

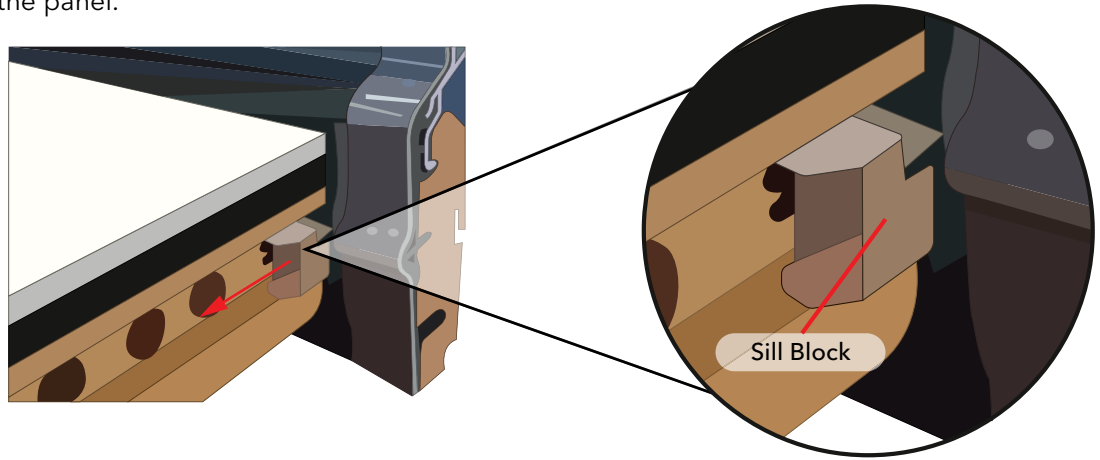


Rotate the rest of the sill against the panel-aligning the sill rib with the groove in the bottom of the panel where sealant was placed.

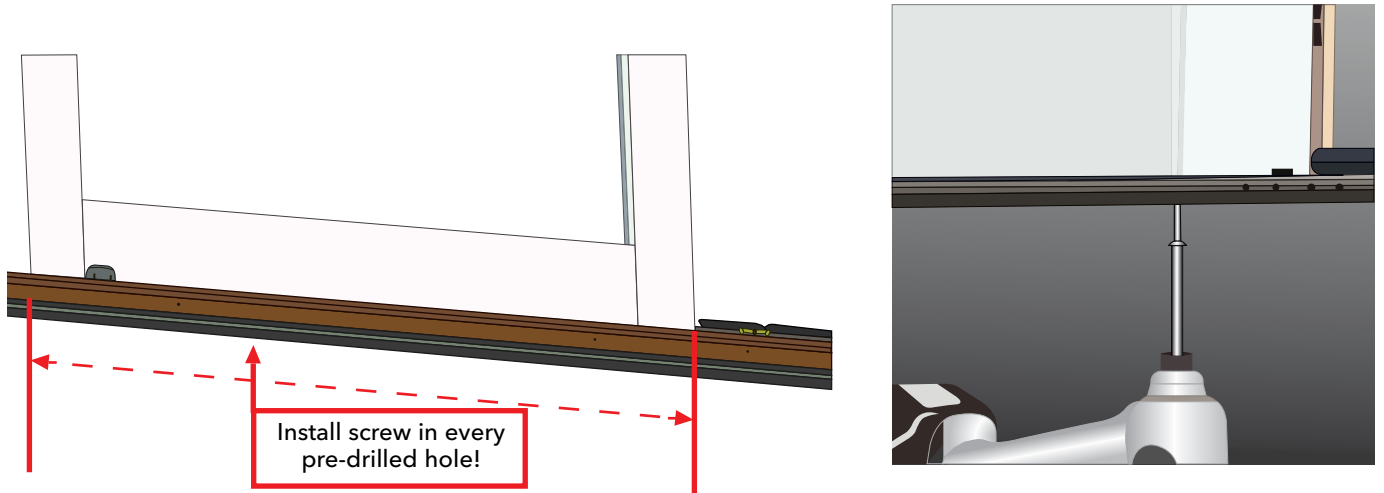


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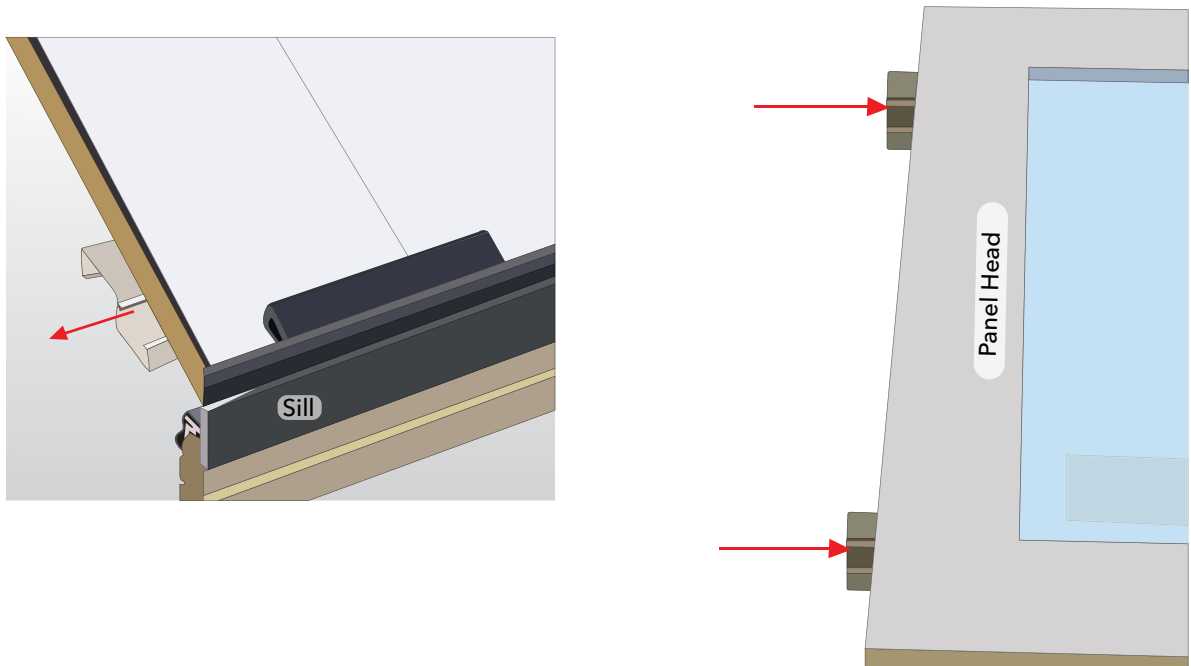
Align the sill block on the end of the sill to the slot on the panel edge and push the sill against the bottom of the panel.



Install screws into the pre-drilled holes.

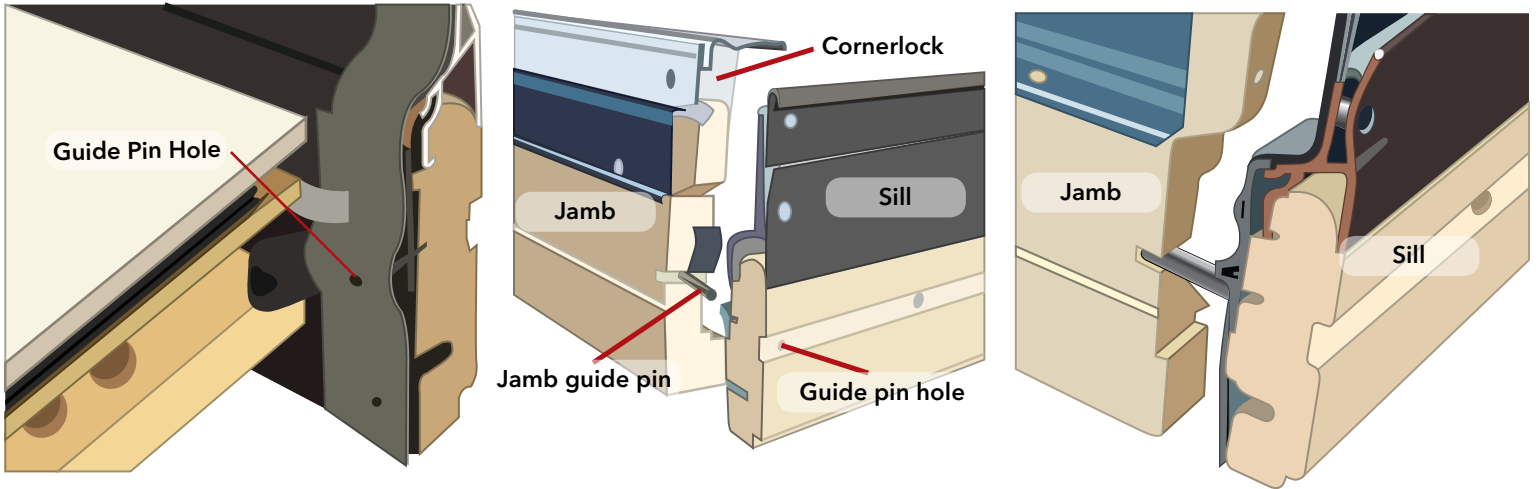


After screws are installed, remove panel spacers from the sill end of the panel and move to the head end of the panel.



3

FIXED JAMB TO SILL: Position fixed jamb against the panel, align the jamb guide pin with the sill guide pin hole.

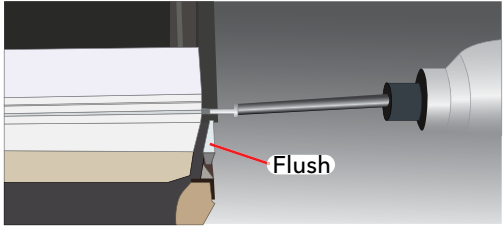
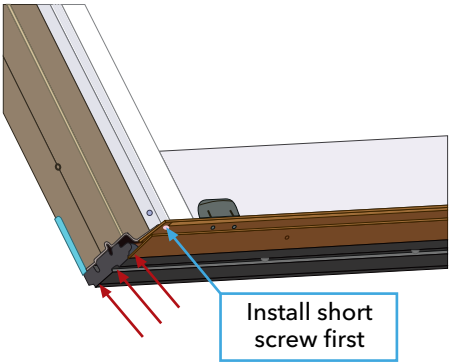


TIP: Keep the top end of the jamb partially away from the panel to facilitate the guide pin going into the sill guide hole. If needed, use a mallet to fully seat the jamb guide pin into the sill guide pin hole and to press the jamb against the sill.



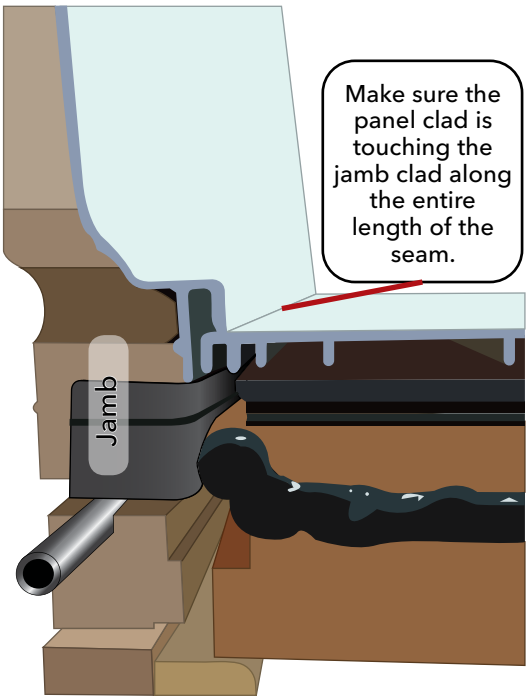
3
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Install sill corner screws through the sill into the jamb. Install short screw first into the exterior cornerlock hole. Then install the three long screws. Hold the jamb cladding flush to sill metal end while driving screws.

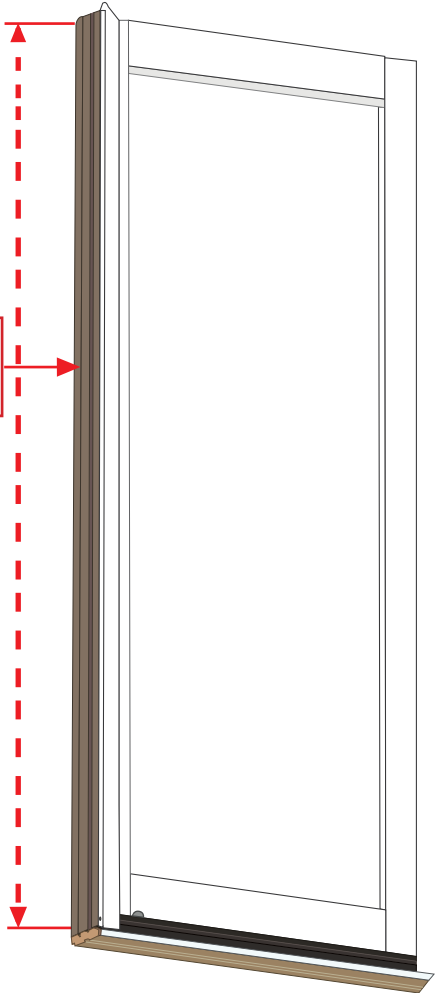


4

FIXED JAMB TO FIXED PANEL ASSEMBLY: Align fixed jamb to panel and install screws into pre-drilled holes.

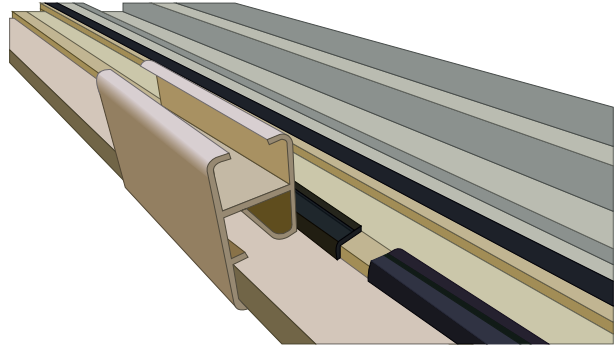
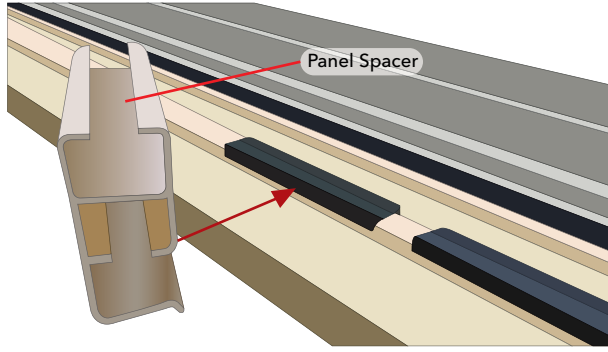


Install screw in every pre-drilled hole



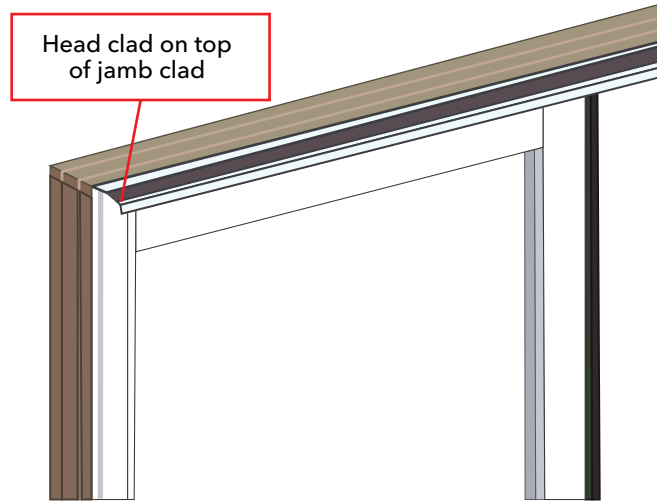
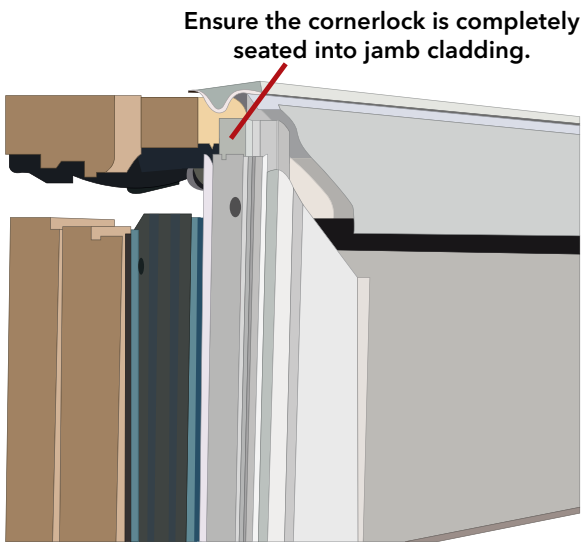
5

HEAD SPACER ATTACHMENT: Attach one of the panel spacers found loose in the Head & Sill Package to the head at approximately the center of the panel span.



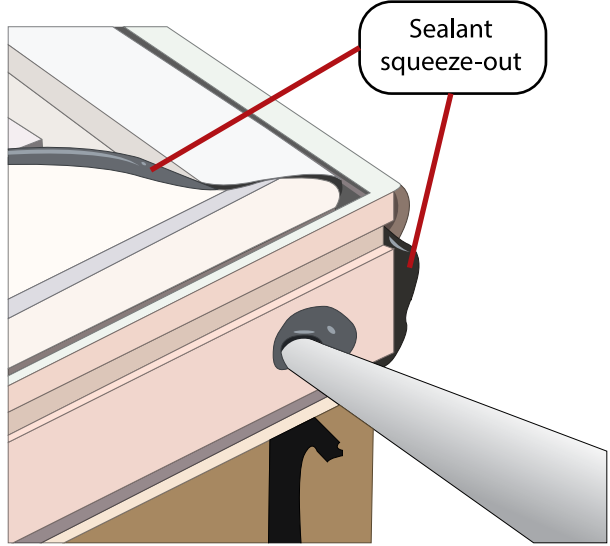
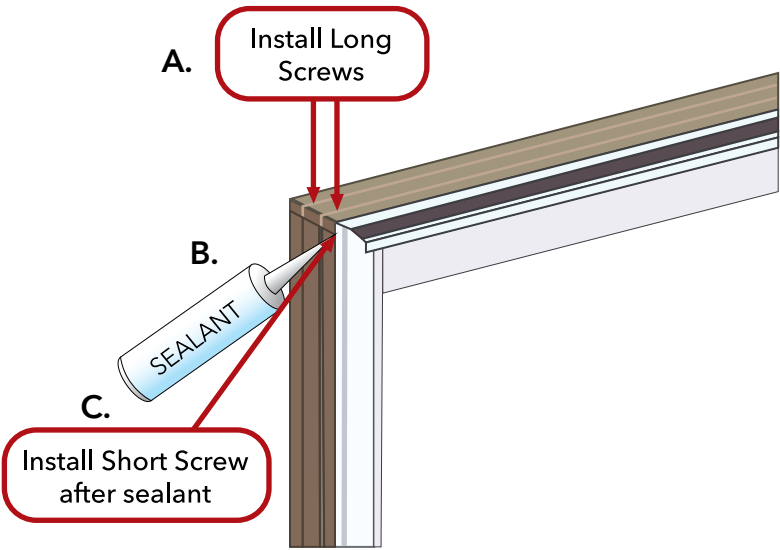
6

HEAD/FIXED JAMB ASSEMBLY: Attach the head by inserting the cornerlock on the head into the jamb cladding.



6
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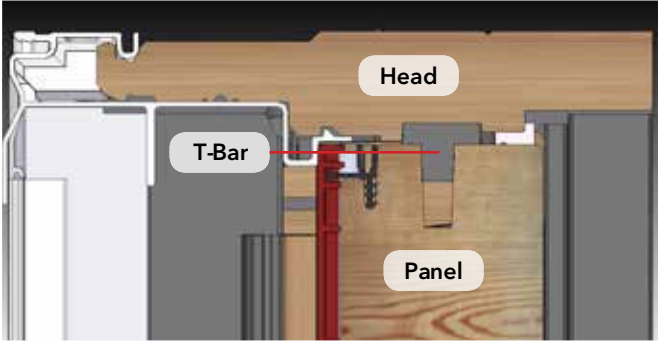
- A. Install the long screws into the wood frame of the jamb.
- B. Inject sealant into the jamb cornerlock screw hole until sealant squeezes-out at miter seam.
- C. While holding the seam closed with hand pressure or corner clamp, install short screw into the cornerlock hole.



7

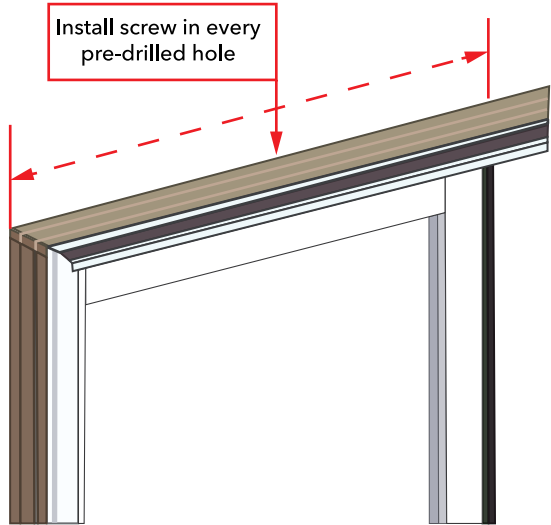
HEAD TO FIXED PANEL ASSEMBLY: Verify the alignment of the T-Bar reinforcement in head to groove in panel.

NOTE: If T-bar is not properly seated in panel, the frame head will be bowed up at panel and cause door to malfunction.



8

Install the head screws into the pre-drilled holes.

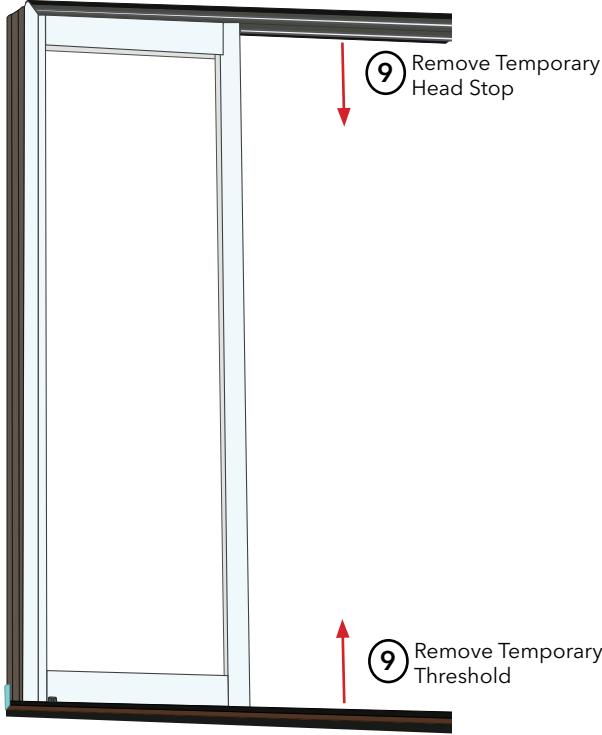


9

Remove screws holding Temporary Head Stop to head, discard screws and temporary head stop.

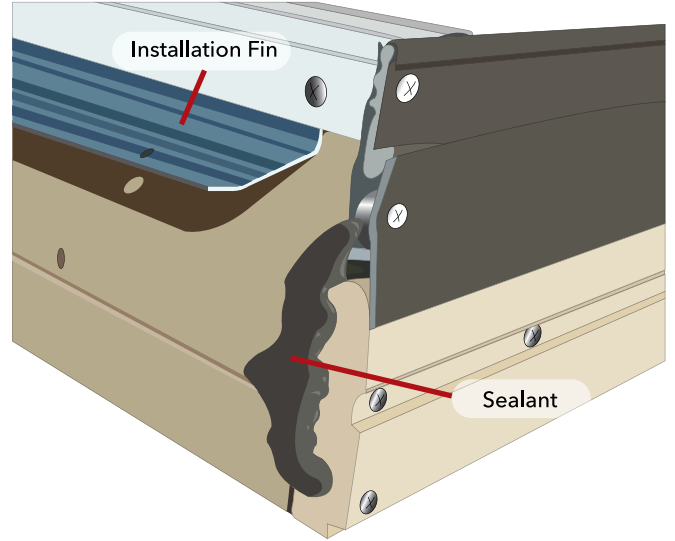
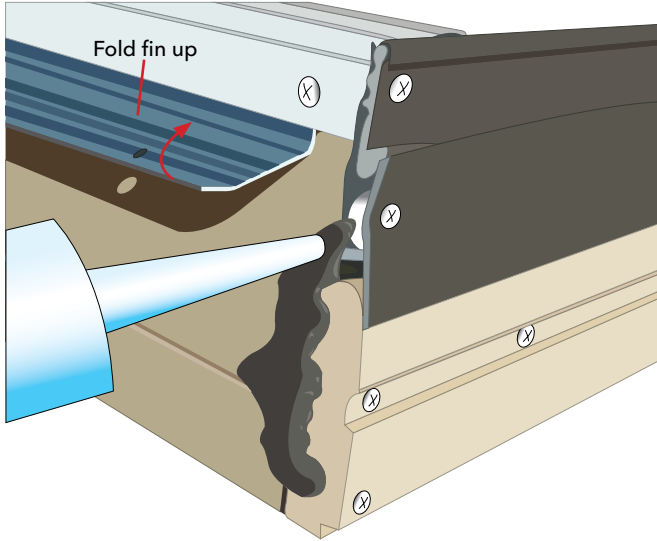
Remove screws holding Temporary Threshold to sill, discard screws and temporary threshold.

NOTE: Only remove Temporary Head Stop and Threshold after panel has been secured to head and sill with screws.

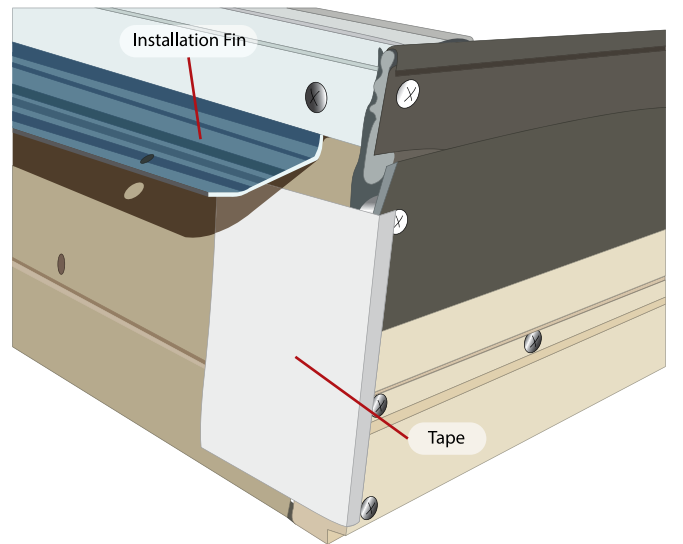
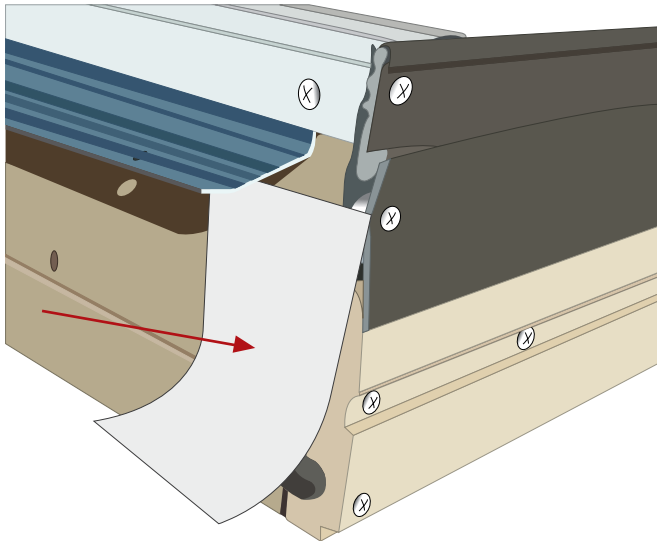


10

SILL END SEAL: On each end of the sill; fold jamb installation fin up at corner, apply sealant at the end of the sill as shown, (fill the grooves with sealant). Place tape over the end of the sill and over the sealant. Make sure tape is not positioned over the installation fin.



Sealant View



Tape View

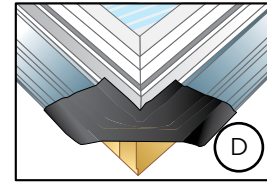
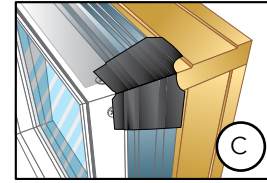
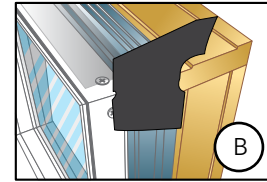
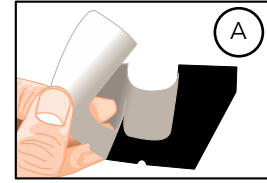
11

Repeat Steps 1-10 on the other half of the door frame.

12

INSTALLING THE FIN CORNERS ON THE ASSEMBLED COMBINATION

- A. **Remove the outer portion of the backing** from a new fin corner by pulling on the tab at the corners.
- B. **Align** the front edge of the fin corner with the center of the corner lock screws and the front locating notch with the corner of the product frame.
- C. **Fold the fin corner over** the corner of the product and rub firmly over the entire surface to activate the adhesive and ensure a good seal.
- D. **Lift the installation fin just enough to fold under and adhere the tab** of the fin corner to the back of the installation fin.
- E. **Repeat Steps A - D for the opposite corner** of the product.
- F. **When ready to install, fold out the fin**, stretching the fin corner.



13

Lift unit up and stabilize to remove panel spacers.

14

When both units halves are assembled, flip each half over so cladding side is down and halves align for splicing. Be sure to use cardboard or other material to protect the cladding. Proceed to Type-4 Sliding Patio Door For Field Assembly Instruction for splicing the two halves together.

15

INSTALLING SCREEN TRACK/HEAD TRIM: Determine if screen is to be installed. If so, follow screen installation instructions. If no screen is installed follow the below steps:

Remove screw package from screen track/head trim. Position screen track with flat side towards frame. Install screw in every pre-punched holes in screen track/head trim.

NOTE: Mate track ends at head splice to minimize visible gap.

