
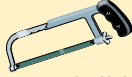


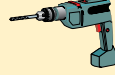






3-PANEL (OX|O, O|XO, O|OX, XO|O) KNOCK-DOWN SLIDING DOOR ASSEMBLY

Tools Required:

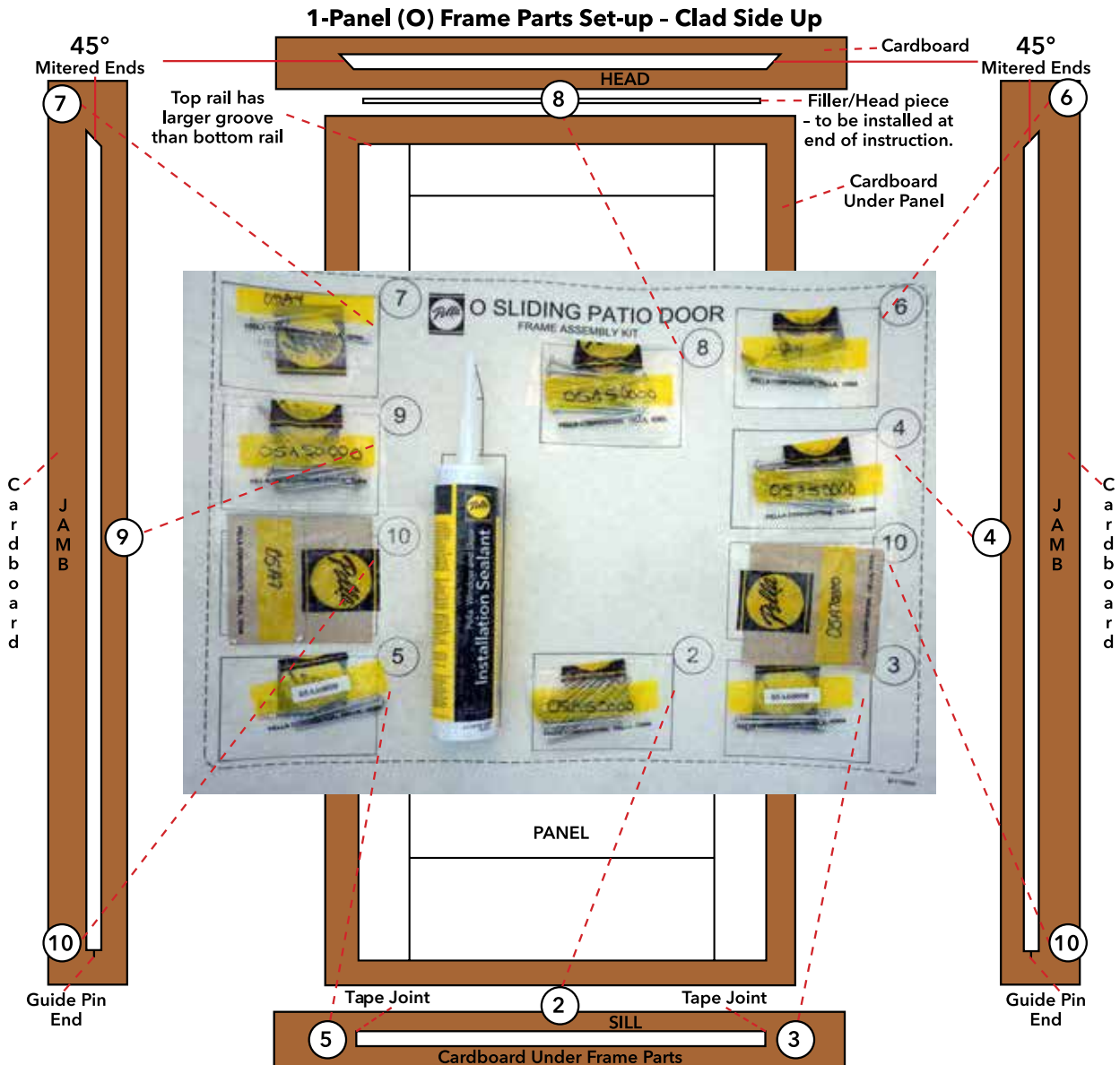
- Tape measure 
- Hacksaw 
- Pliers 
- Hammer or rubber mallet 
- Drill with 3/32" drill bit 
- Quick grip clamps 
- Wood block
- #2 Phillips screwdriver 

3-Panel Knock Down Assembly Table Of Contents:

1-Panel Knock Down AssemblyPage 1
 2-Panel Knock Down AssemblyPage 11
 3-Panel (OX|O, O|XO, O|OX, XO|O) Sliding Door Mullion Assembly.....Page 23

**REMEMBER TO
USE APPROPRIATE
PERSONAL PROTECTIVE
EQUIPMENT**

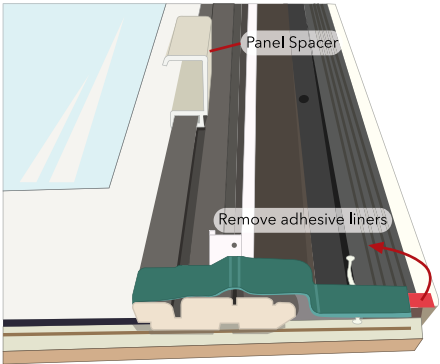
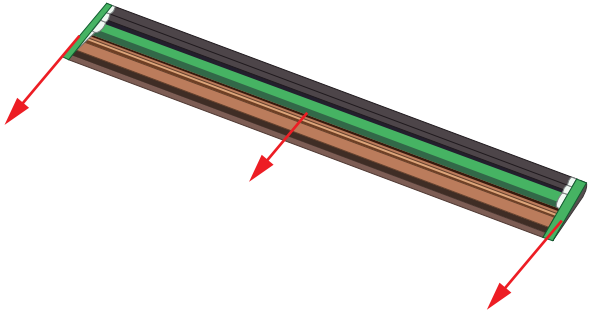
Lay parts on a flat hard surface with exterior cladding side up. Pella recommends keeping the panel and the frame parts on the cardboard to protect the interior surface during the assembly process. Frame parts have plastic spacers installed which help in panel alignment. The step numbers of the following 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.



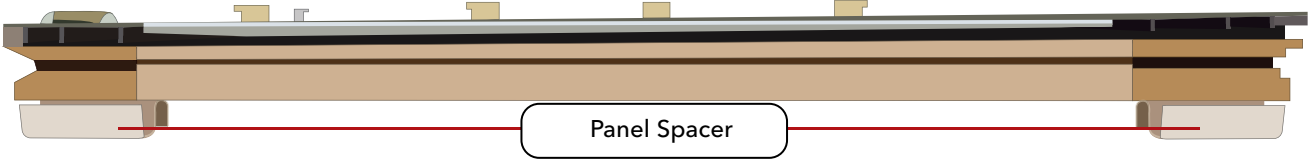
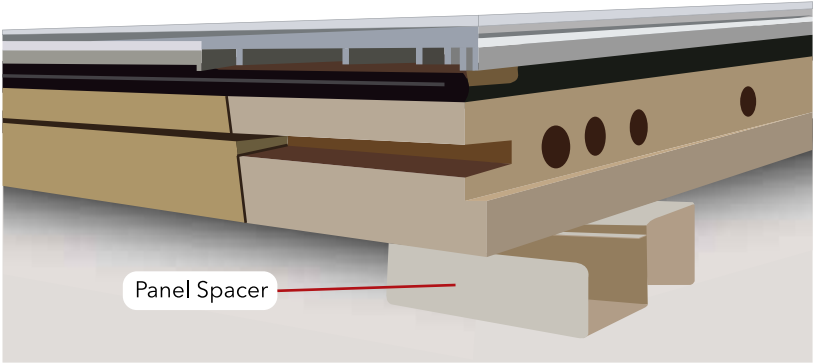
Frame numbered labels match the hardware item number and assembly step number.

1

SILL ATTACHMENT: Remove the 3 adhesive liners from the sill. (1 on each end of the sill; 1 from across the length of the sill.)

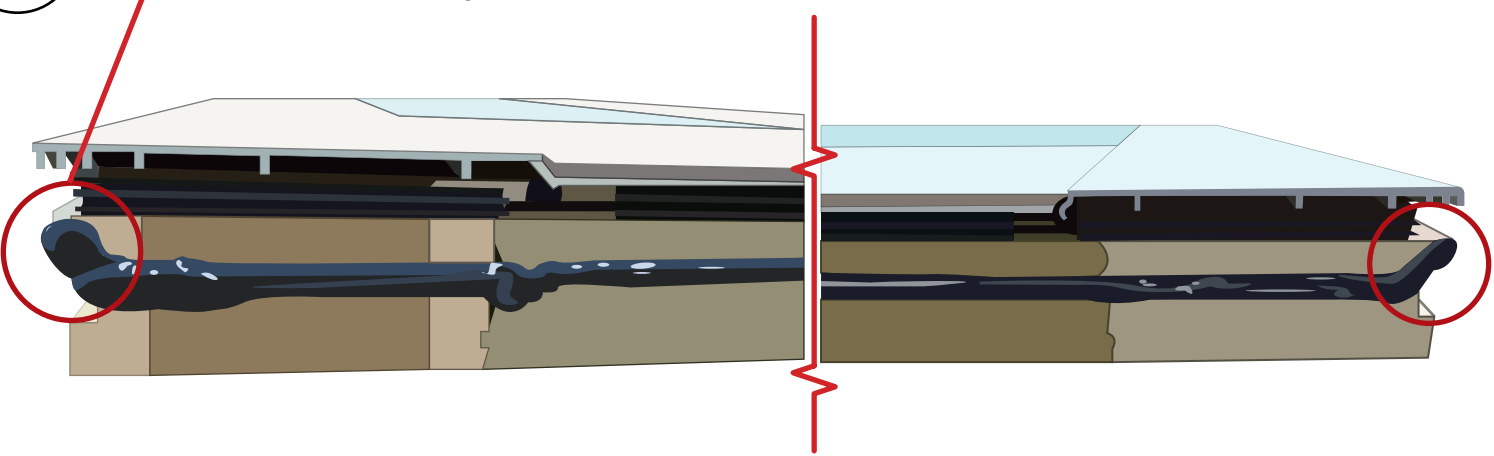


Remove the panel spacers from each end of the head (leaving the center panel spacer attached to the head) and place them under the bottom end of the panel.

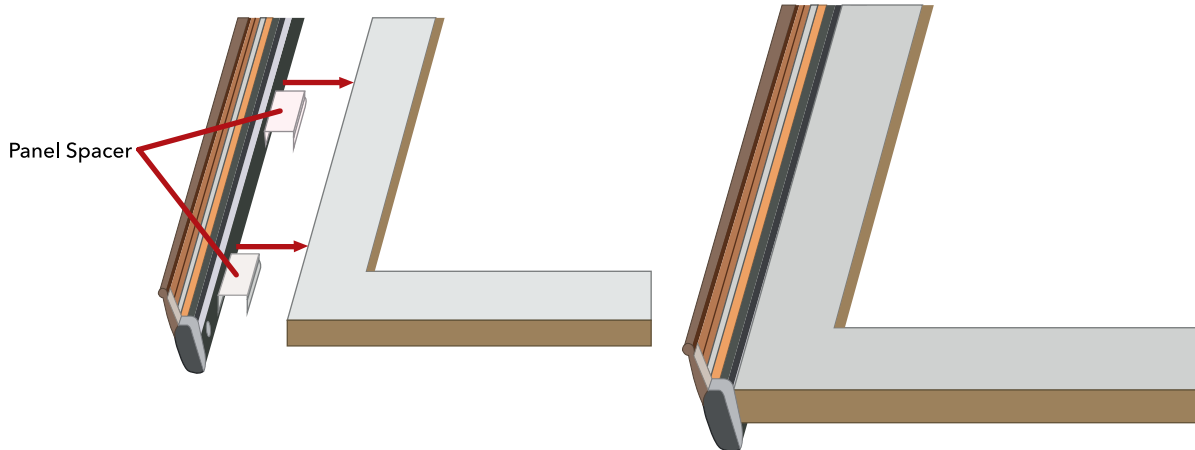
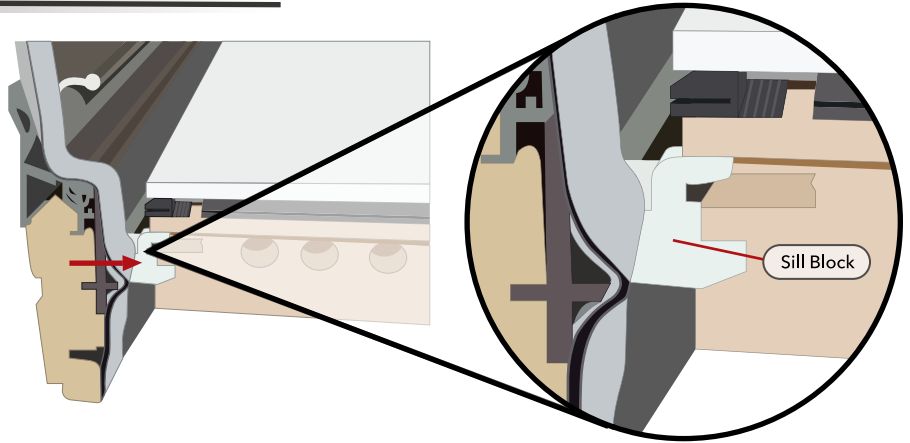
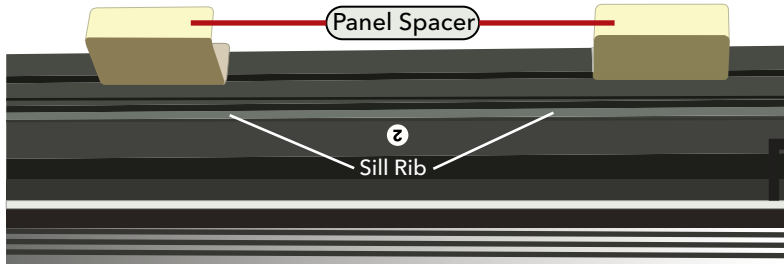


2

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.

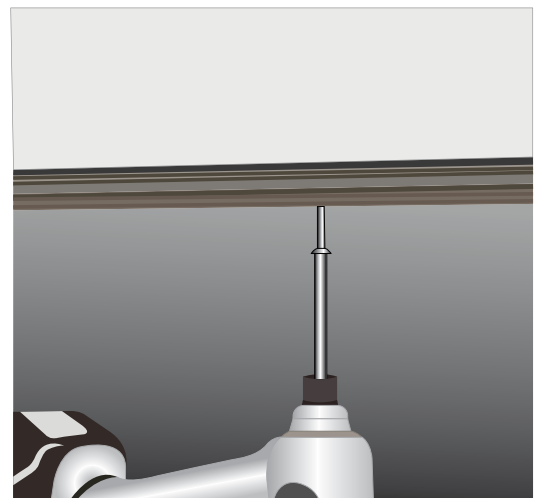
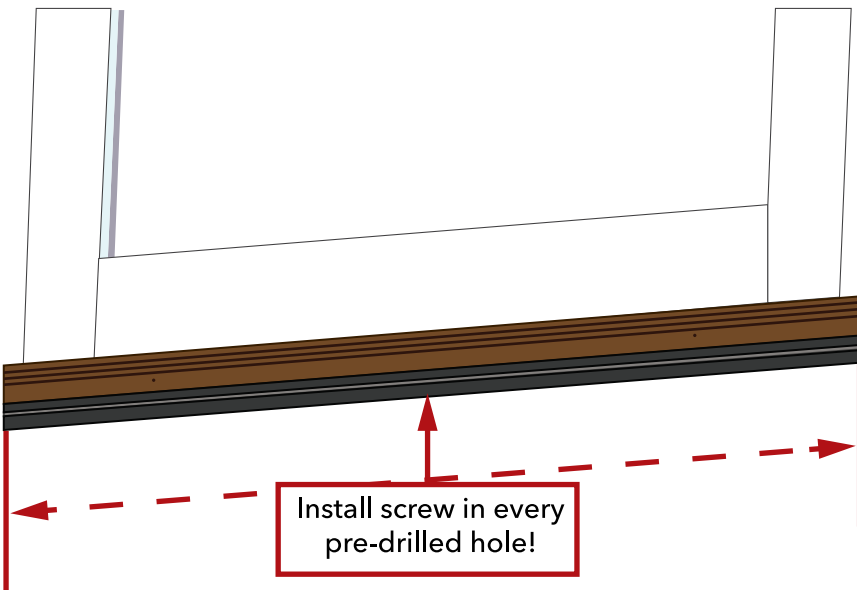


Align the sill block on the end of the sill to the slot on the panel edge and push the sill against the bottom of the panel. Rotate the rest of the sill against the panel-aligning the sill rib with the groove in the bottom of the panel where sealant was placed.



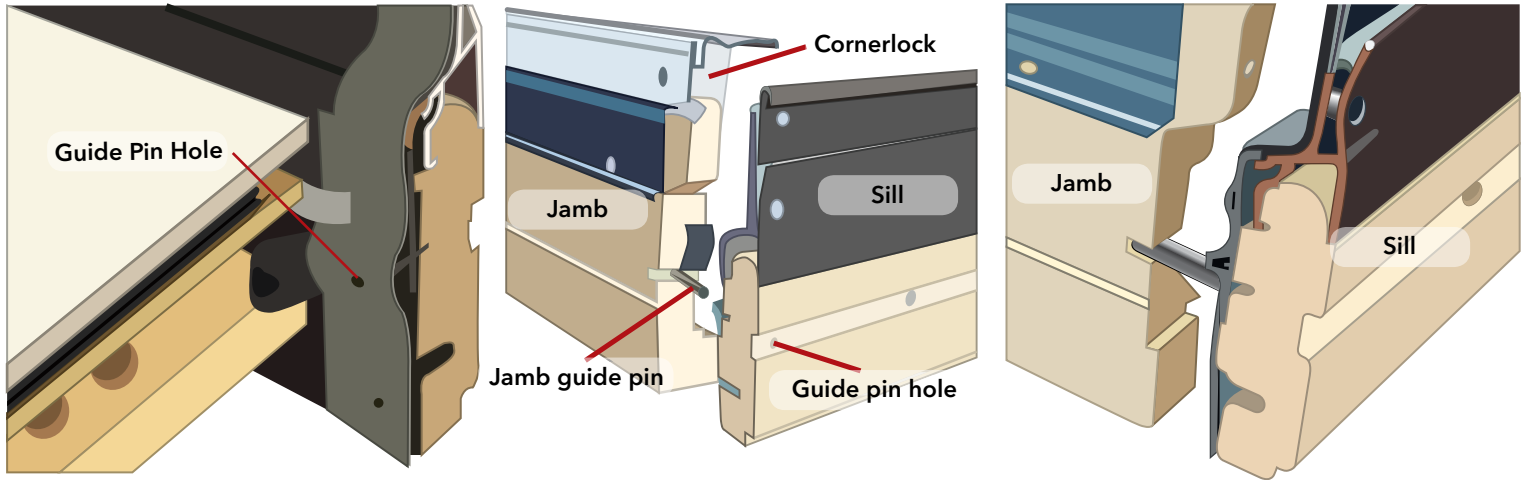
2
Continued

Install screws into the pre-drilled holes.

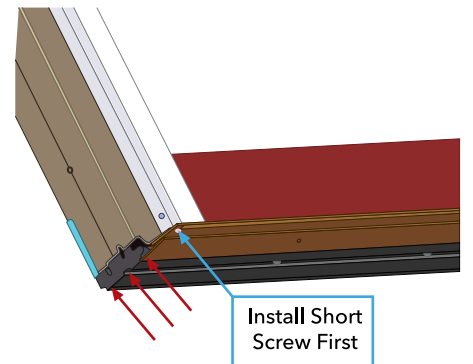
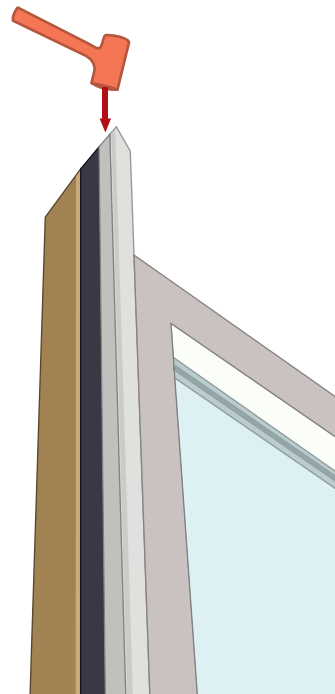
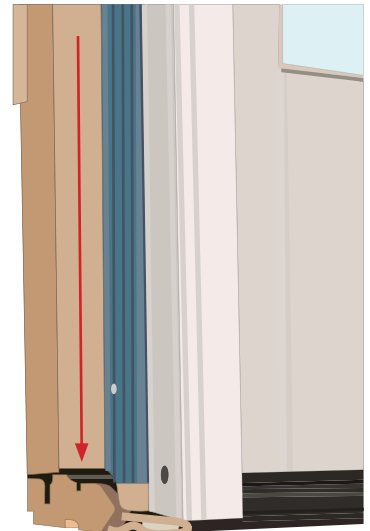
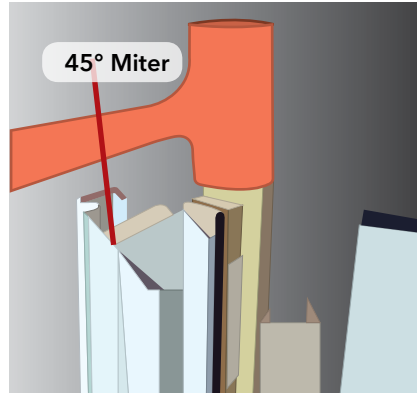
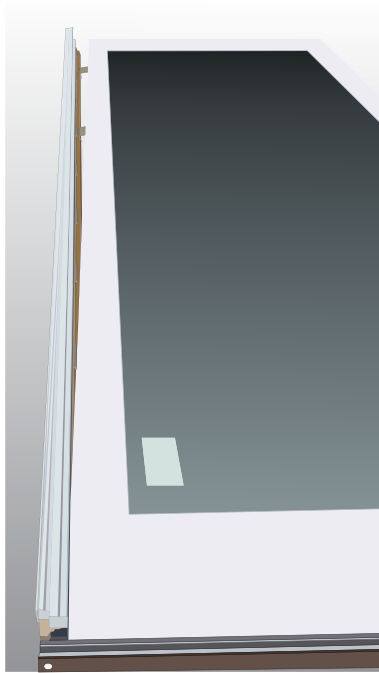


3

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



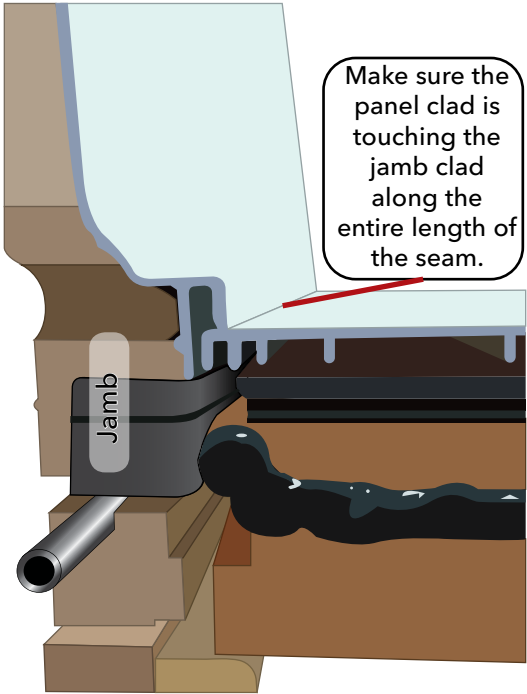
TIP: Keep the top end of the jamb partially away from the panel to facilitate the guide pin going into the sill guide hole. If needed, use a mallet on the wood portion of the jamb to fully seat the jamb guide pin in the sill guide pin hole and the jamb against the sill.



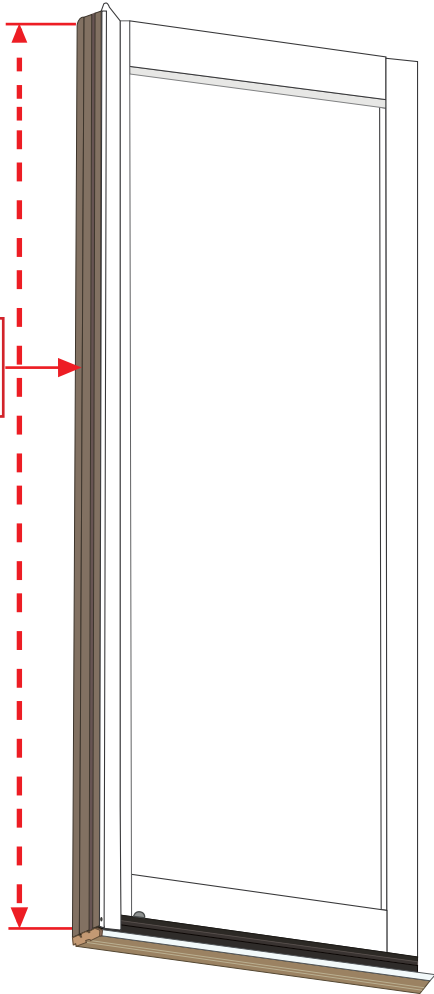
Install sill corner screws through the sill into the jamb. **Install short screw first** into the exterior cornerlock hole. Then install the three long screws.

4

JAMB TO PANEL ASSEMBLY: Align one jamb to panel and install jamb screws into each pre-drilled hole. Screw heads must be flush with exterior surface of the jamb.

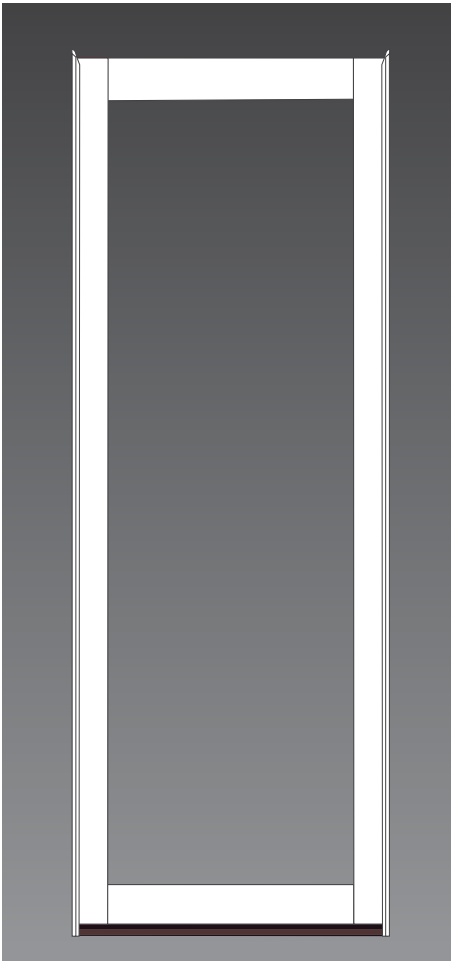
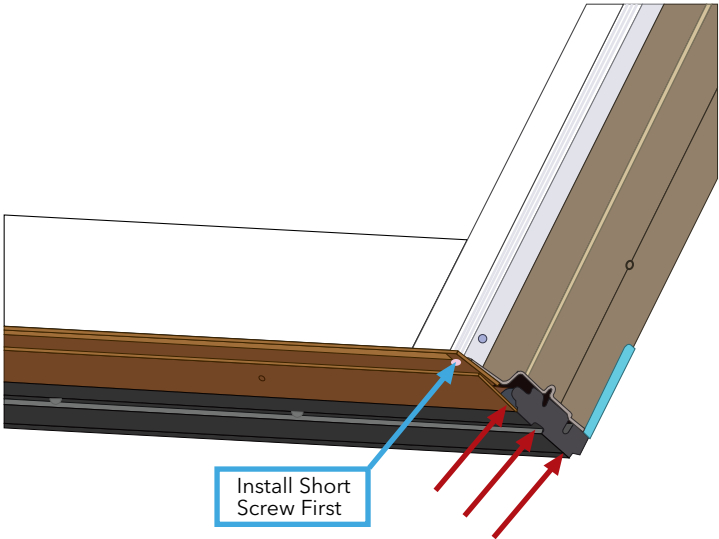


Install screw in every pre-drilled hole



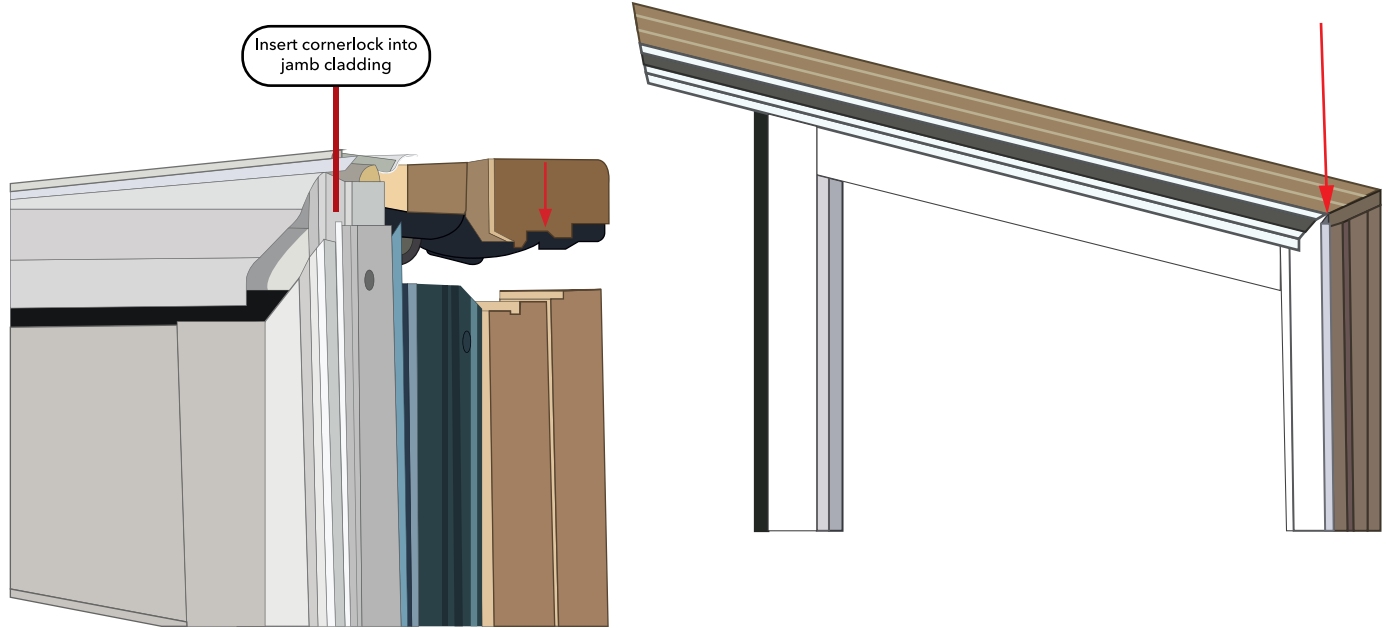
5

Repeat Step 3 & 4 on the opposite side of the panel.

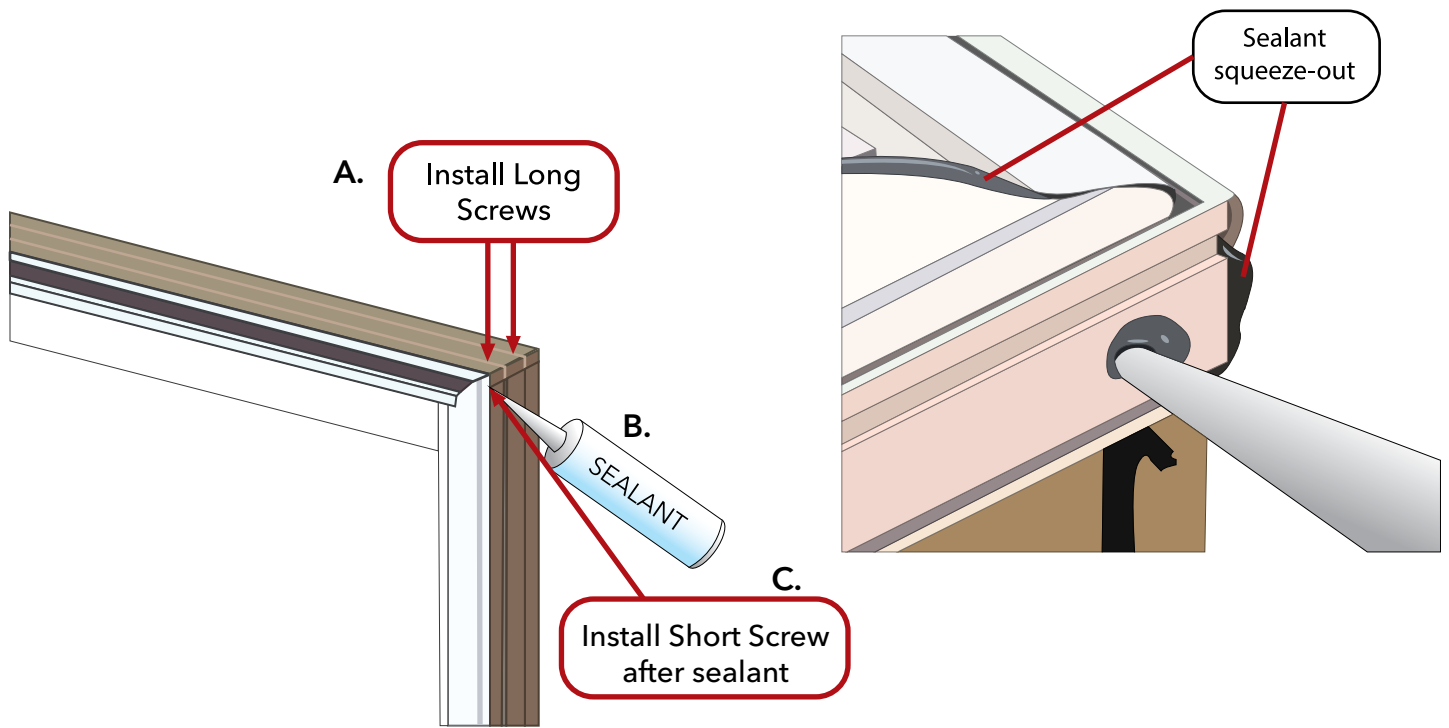


6

HEAD/JAMB ASSEMBLY Attach the head by inserting the cornerlocks on each end of the head into the jamb cladding.



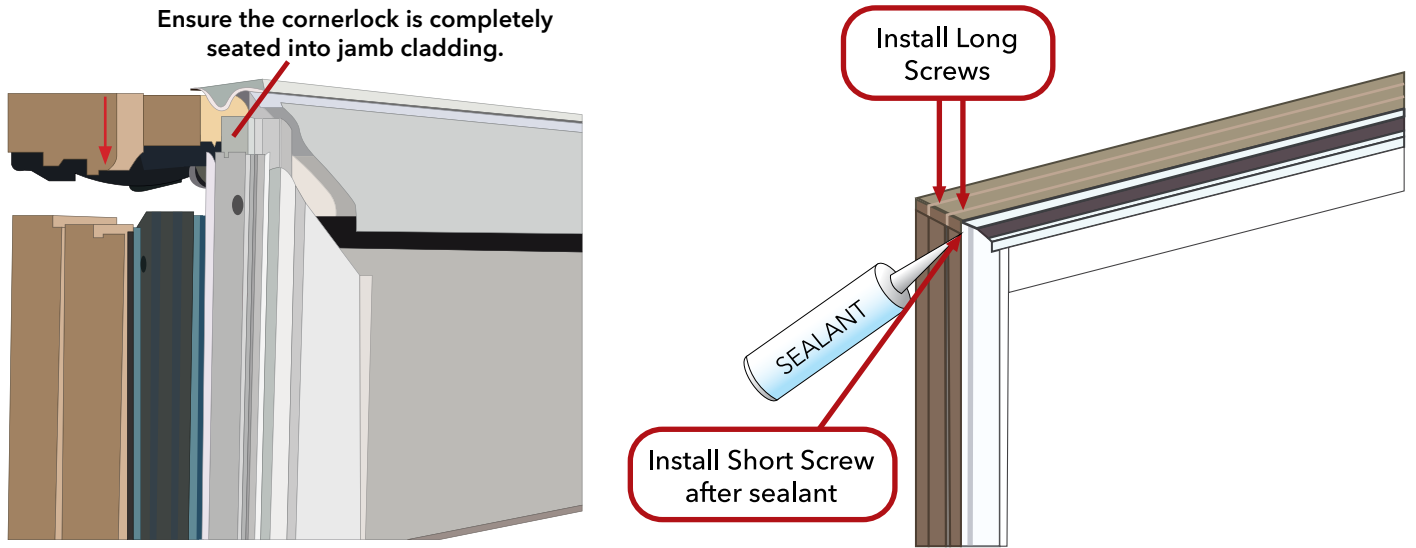
- A. Install the long screws into the wood frame of the other jamb.
- B. Inject sealant into the jamb cornerlock screw hole until sealant squeezes-out at miter seam.
- C. While holding the seam closed with hand pressure or corner clamp, install short screw into the cornerlock hole.



7

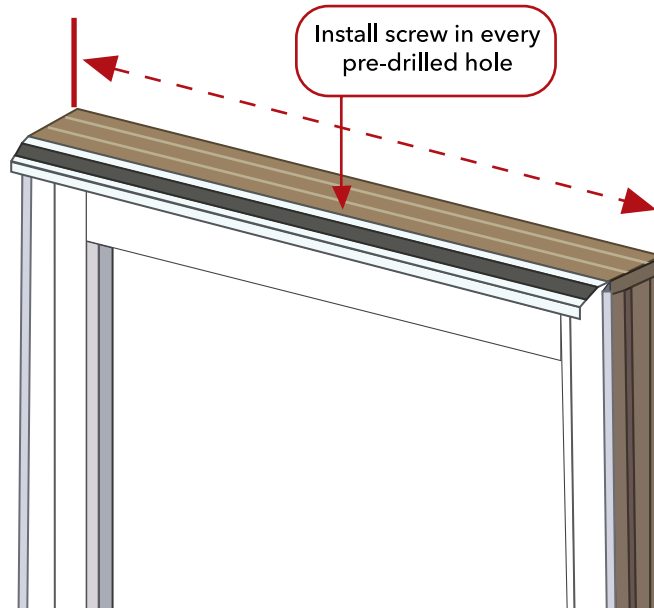
HEAD/JAMB ASSEMBLY (OTHER SIDE):

- A. Install the long screws into the wood frame of the other jamb.
- B. Inject sealant into the jamb cornerlock screw hole until sealant squeezes-out at miter seam.
- C. While holding the joint closed, install short screw into the cornerlock hole.



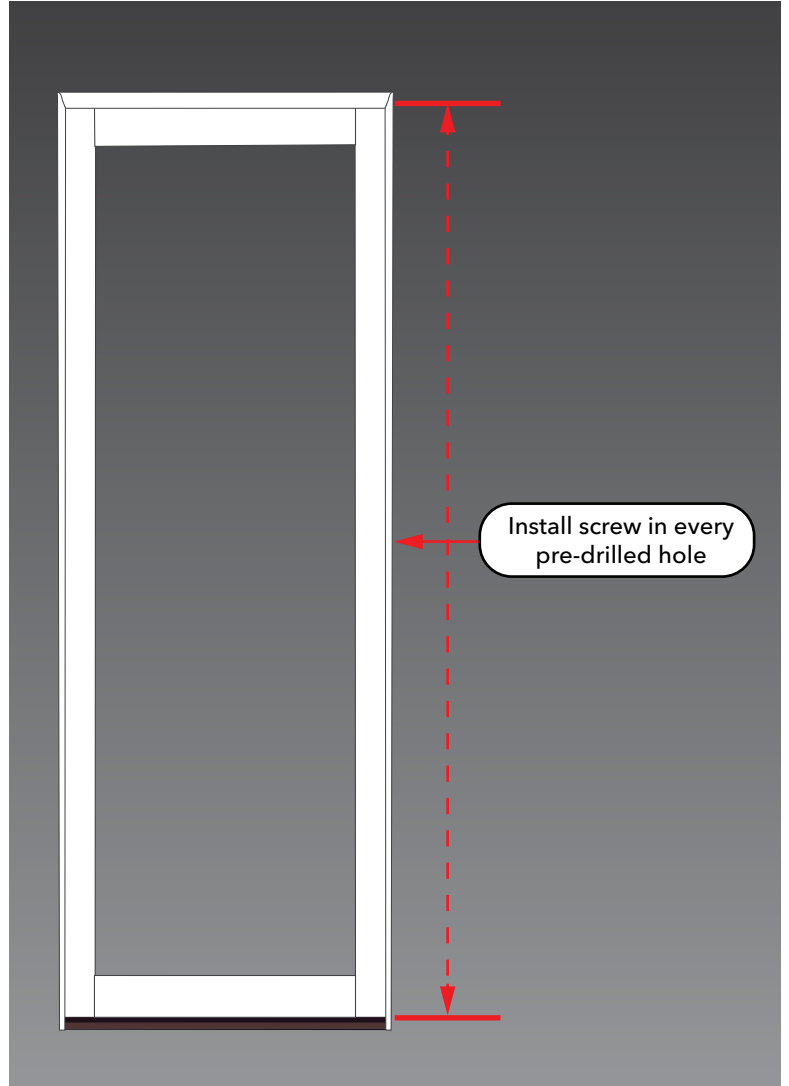
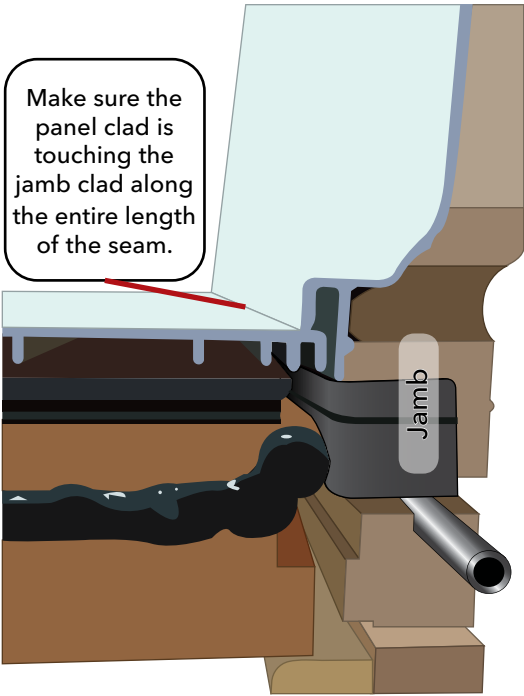
8

HEAD TO PANEL ASSEMBLY: Install the head screws into the pre-drilled holes.



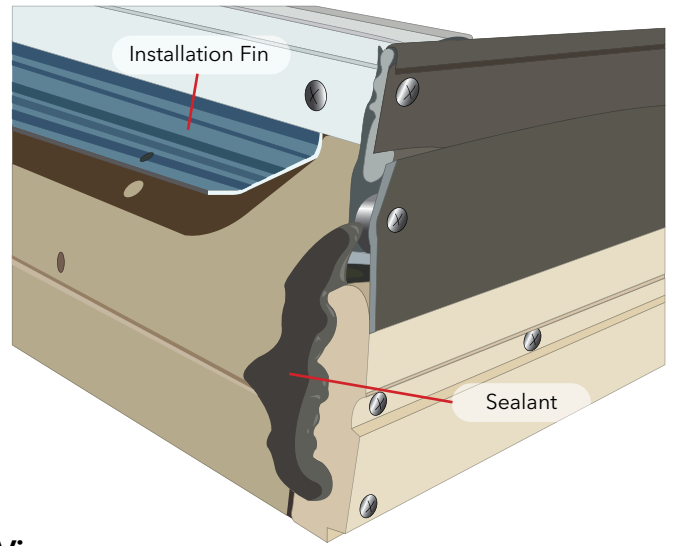
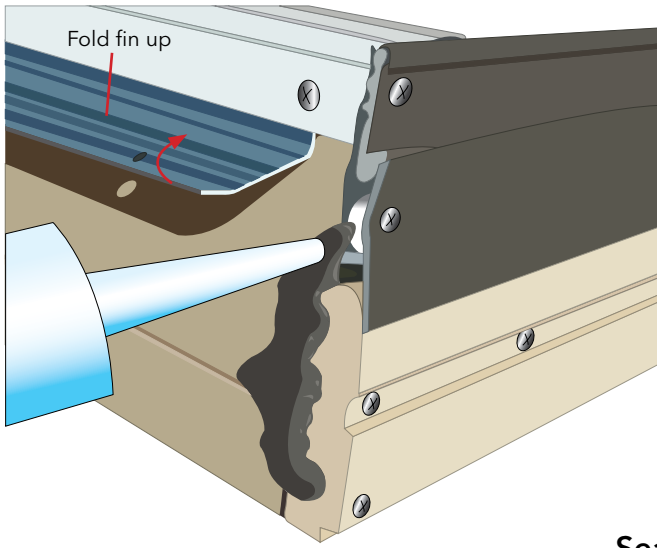
9

Position and install fixed jamb screws in to pre-drilled holes.

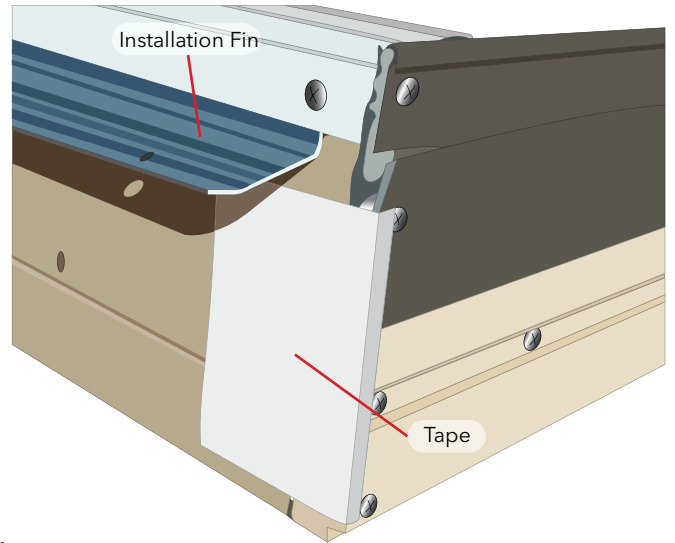
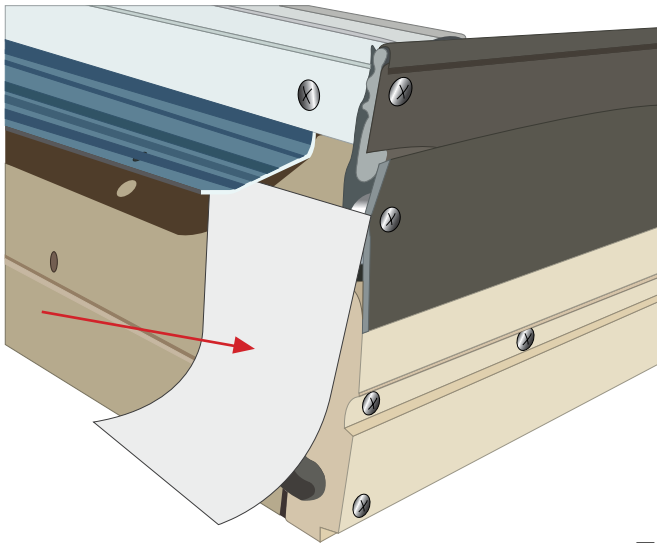


10

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



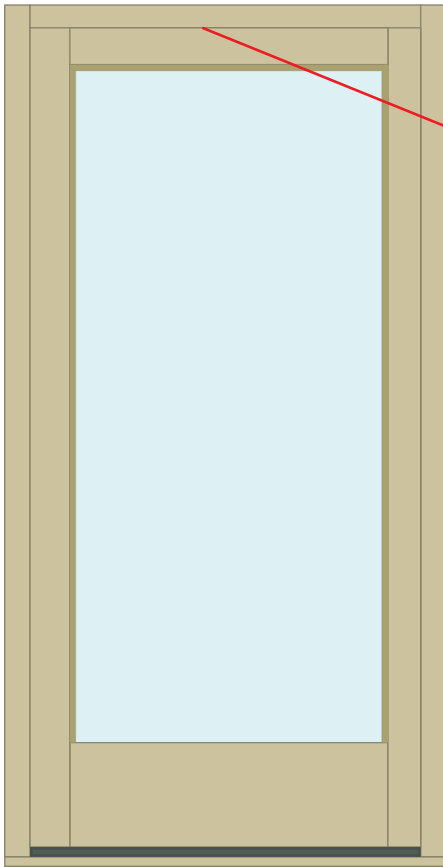
Tape View

11

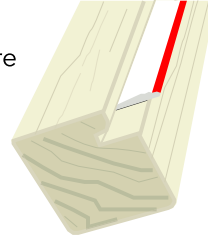
Lift unit up and stabilize to remove panel spacers.

12

Install the filler strip by aligning the barbs with the interior accessory groove formed between the top edge of the fixed panel and the head frame. Press the strip into place, by making sure the barb is fully seated into the groove. It may be necessary to adjust the barbs in the filler to not interfere with the spacers on top of the fixed panel

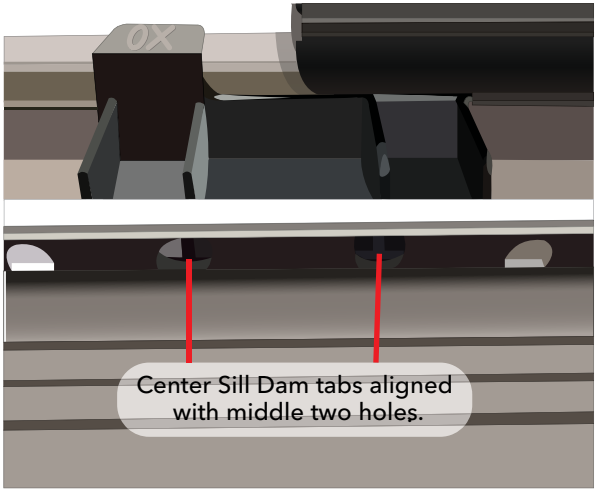
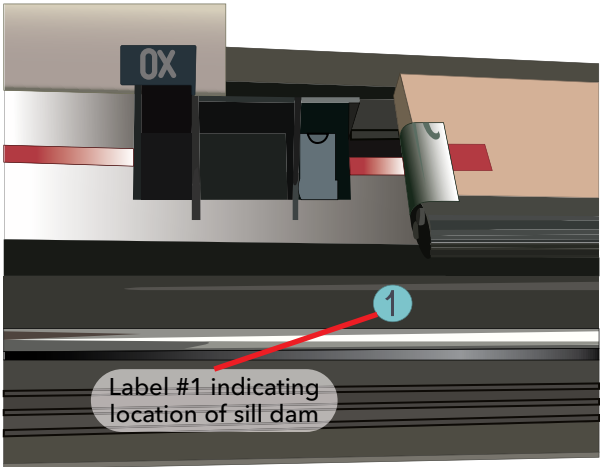


Install filler strip here

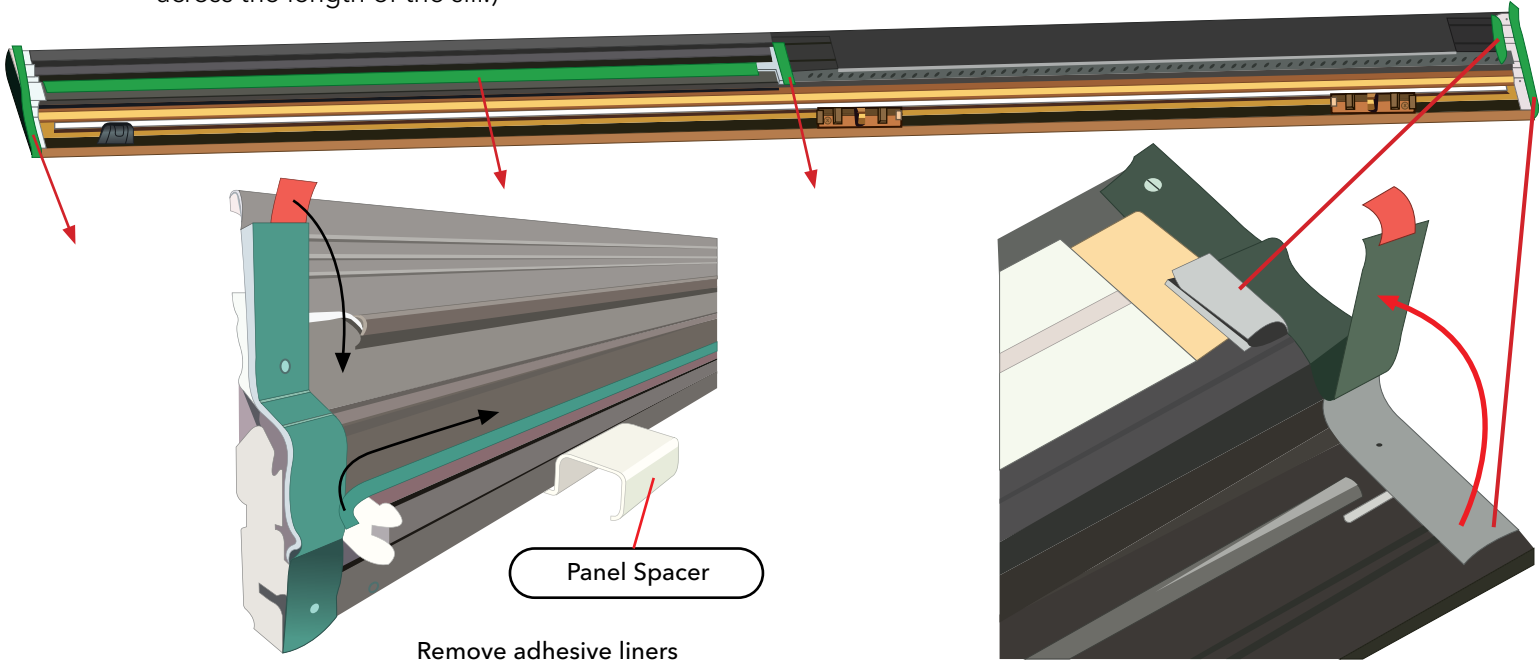


1

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.

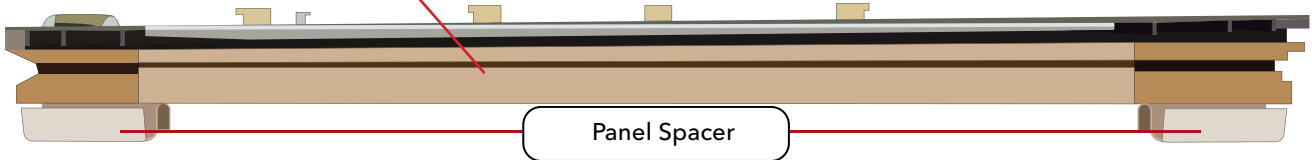
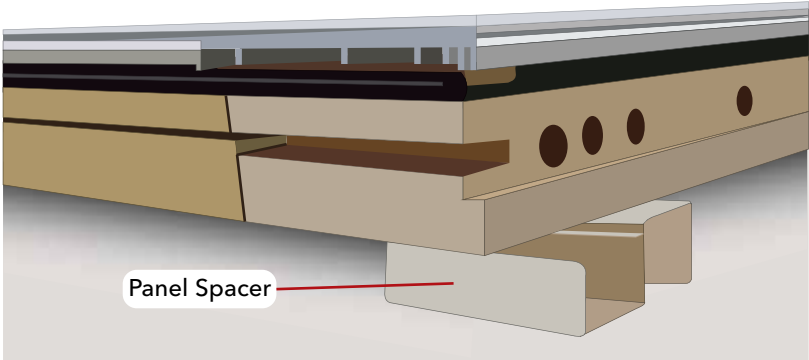


Remove (5) adhesive liners from the sill. (1 on each end of the sill; 1 on each end of the threshold; 1 across the length of the sill.)



Remove two panel spacers from the lock jamb or use two of the loose panels spacers found in the Head & Sill Package and place under the bottom end of the panel.

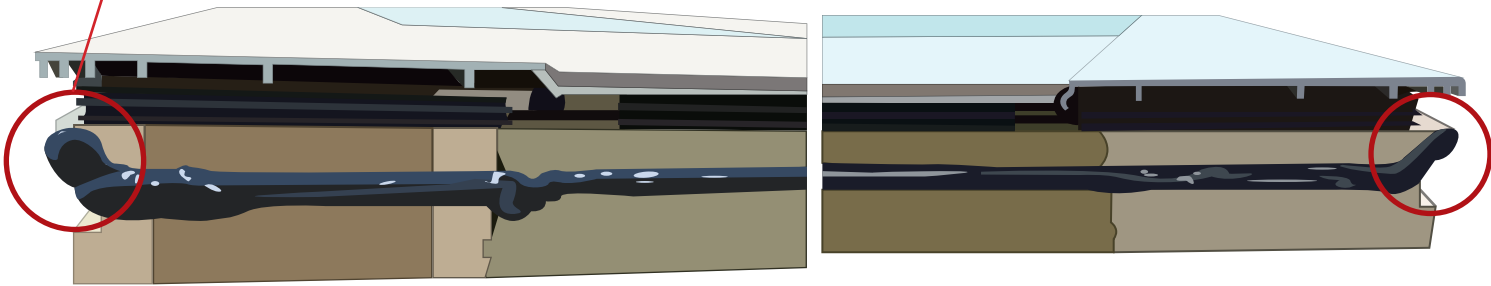
Bottom of panel at sill end has smaller rail groove.



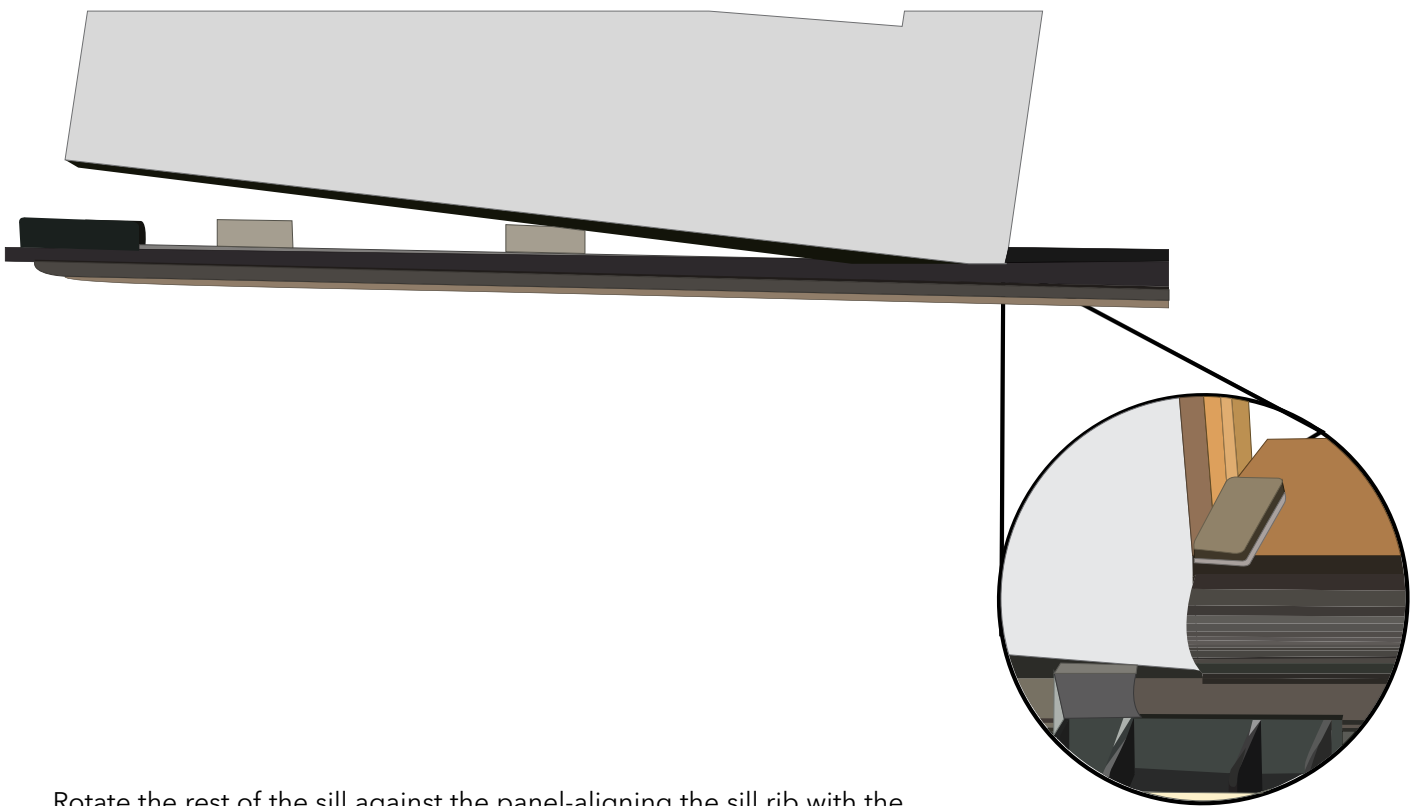
2

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

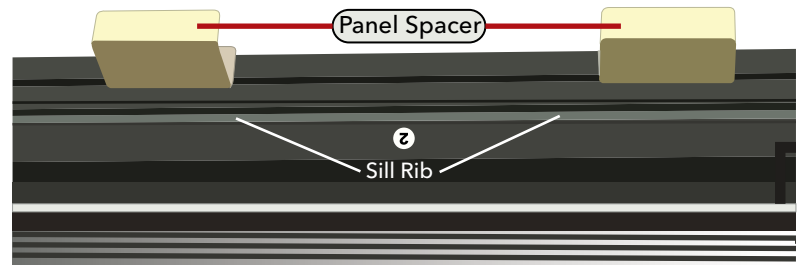
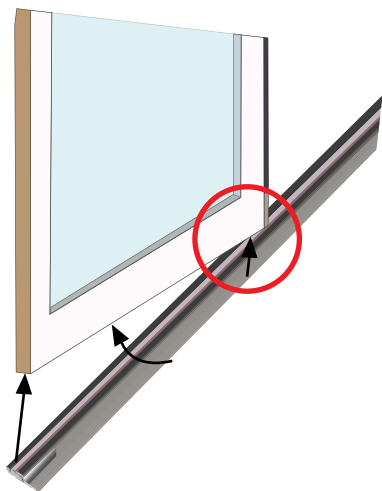
Note: Sealant must reach edge of wood on both ends.



Position panel corner in the threshold/sill corner first.

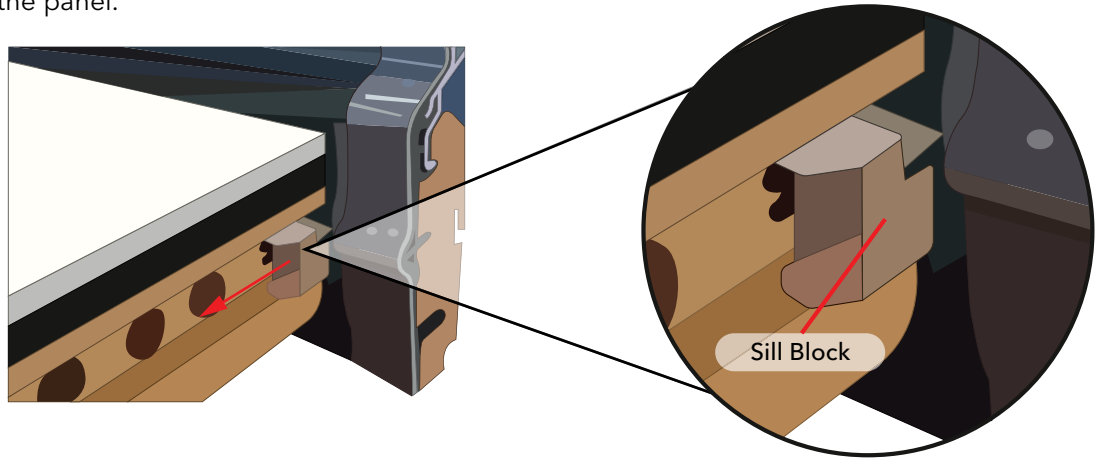


Rotate the rest of the sill against the panel-aligning the sill rib with the groove in the bottom of the panel where sealant was placed.

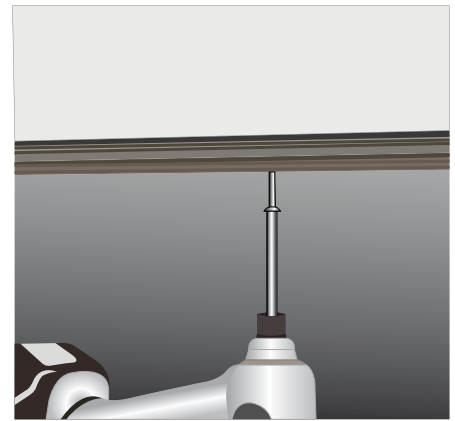
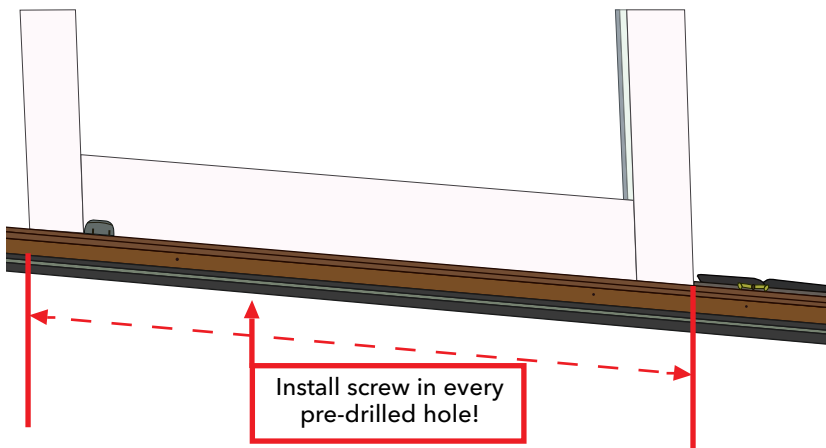


2
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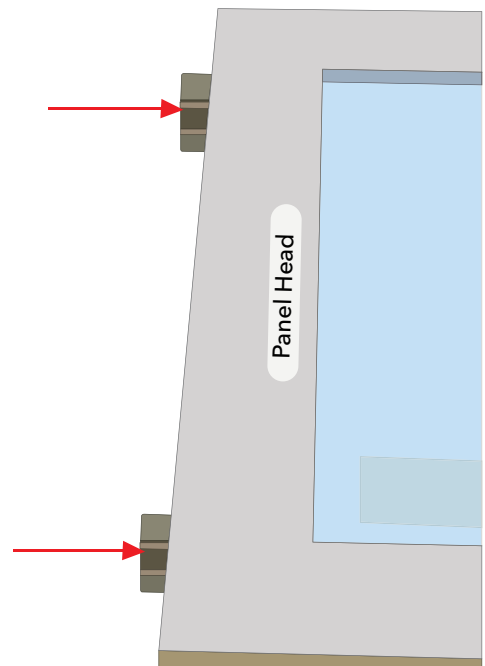
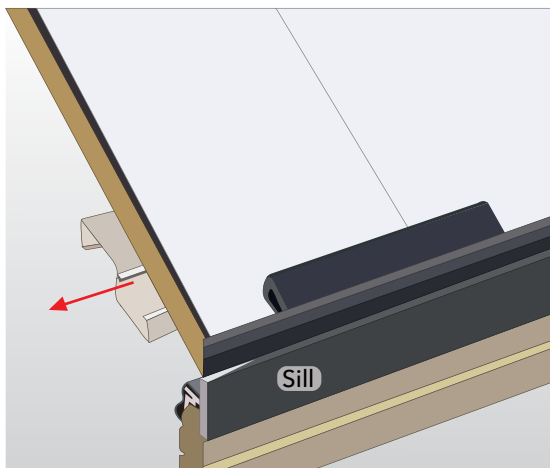
Align the sill block on the end of the sill to the slot on the panel edge and push the sill against the bottom of the panel.



Install screws into the pre-drilled holes.

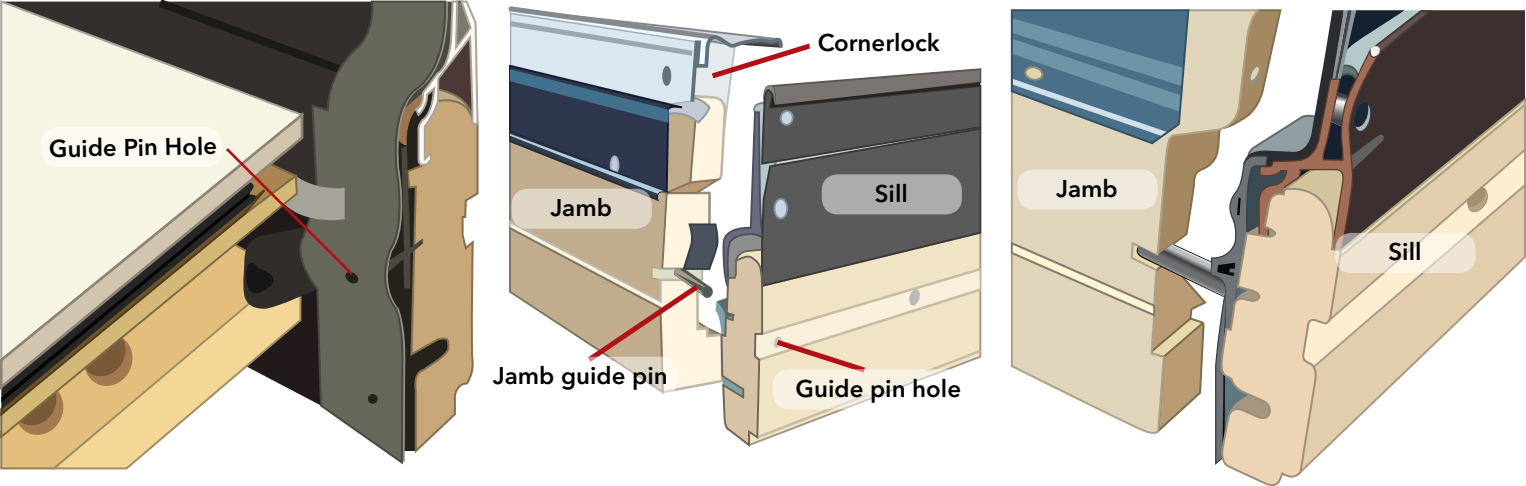


After screws are installed, remove panel spacers from the sill end of the panel and move to the head end of the panel.



3

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

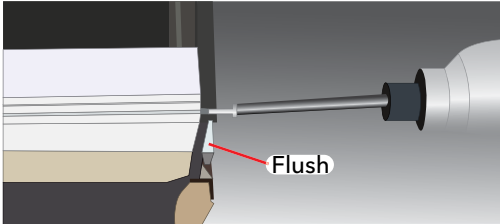
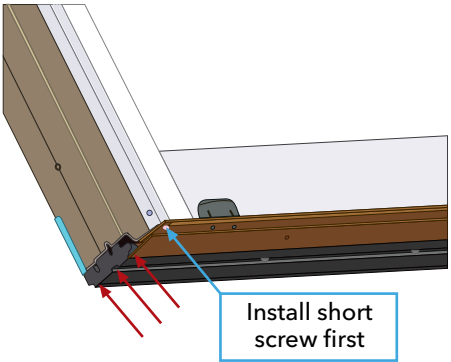


TIP: Keep the top end of the jamb partially away from the panel to facilitate the guide pin going into the sill guide hole. If needed, use a mallet to fully seat the jamb guide pin into the sill guide pin hole and to press the jamb against the sill.



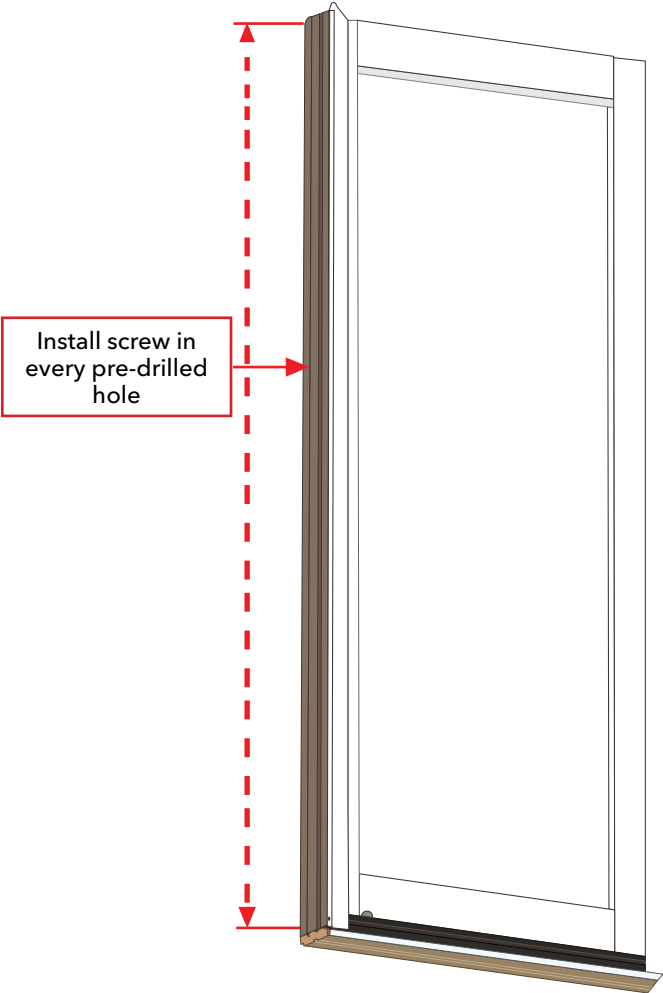
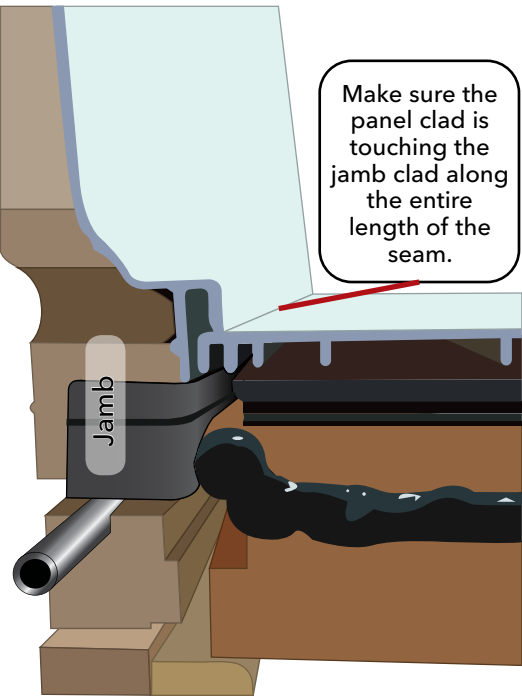
3
Continued

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.



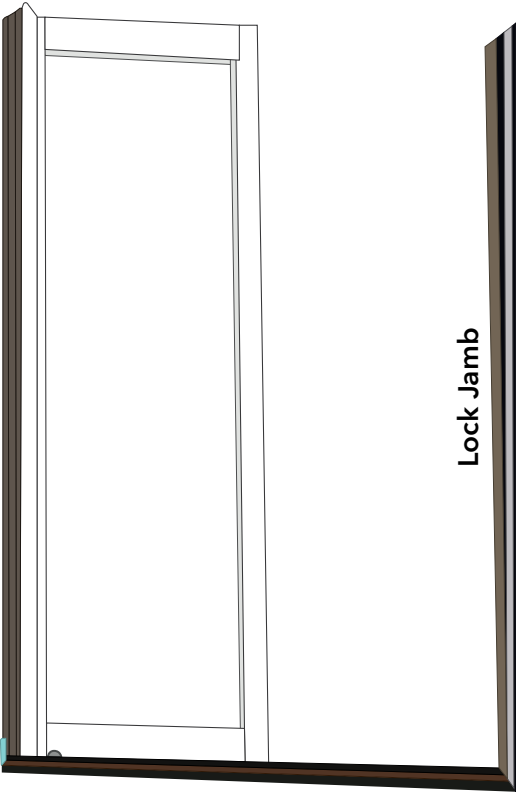
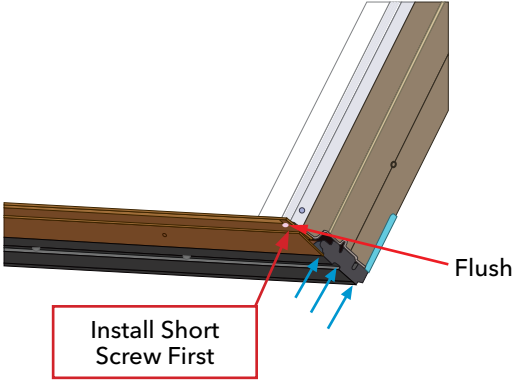
4

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



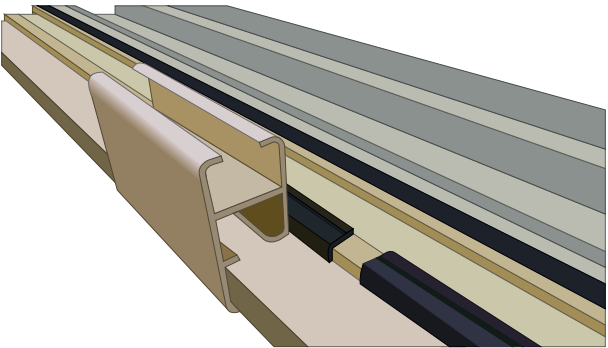
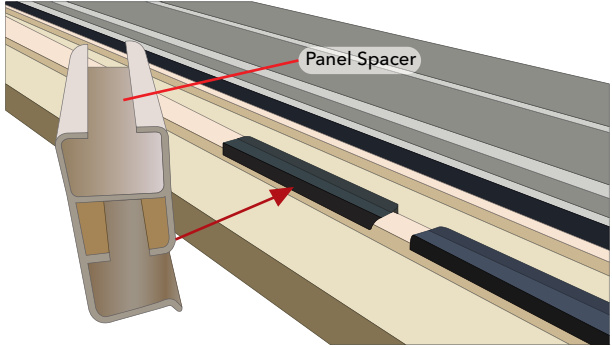
5

LOCK JAMB TO SILL ASSEMBLY: Install lock jamb by aligning lock jamb guide pin with sill guide pin hole. Install short screw first into the exterior cornerlock hole, then install the three long screws.



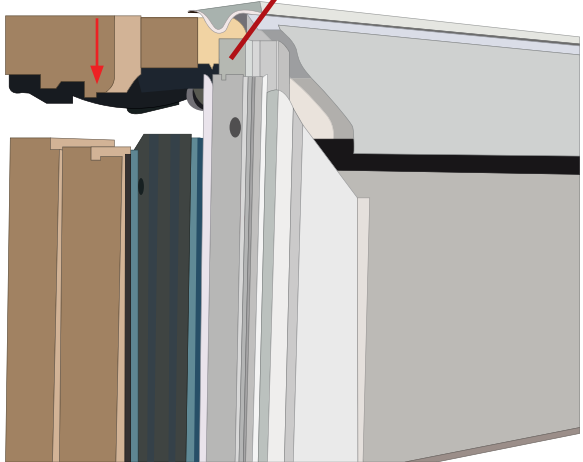
6

HEAD/FIXED JAMB ASSEMBLY: Attach one of the panel spacers found loose in the Head & Sill Package to the head at approximately the center of the panel span.

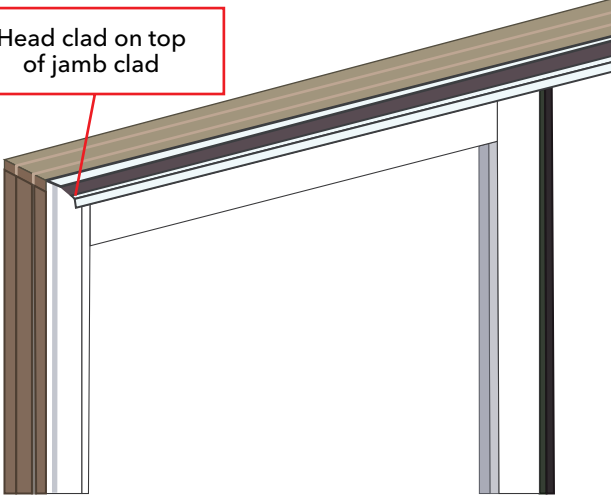


Attach the head by inserting the cornerlocks on each end of the head into the jamb cladding.

Ensure the cornerlock is completely seated into jamb cladding.

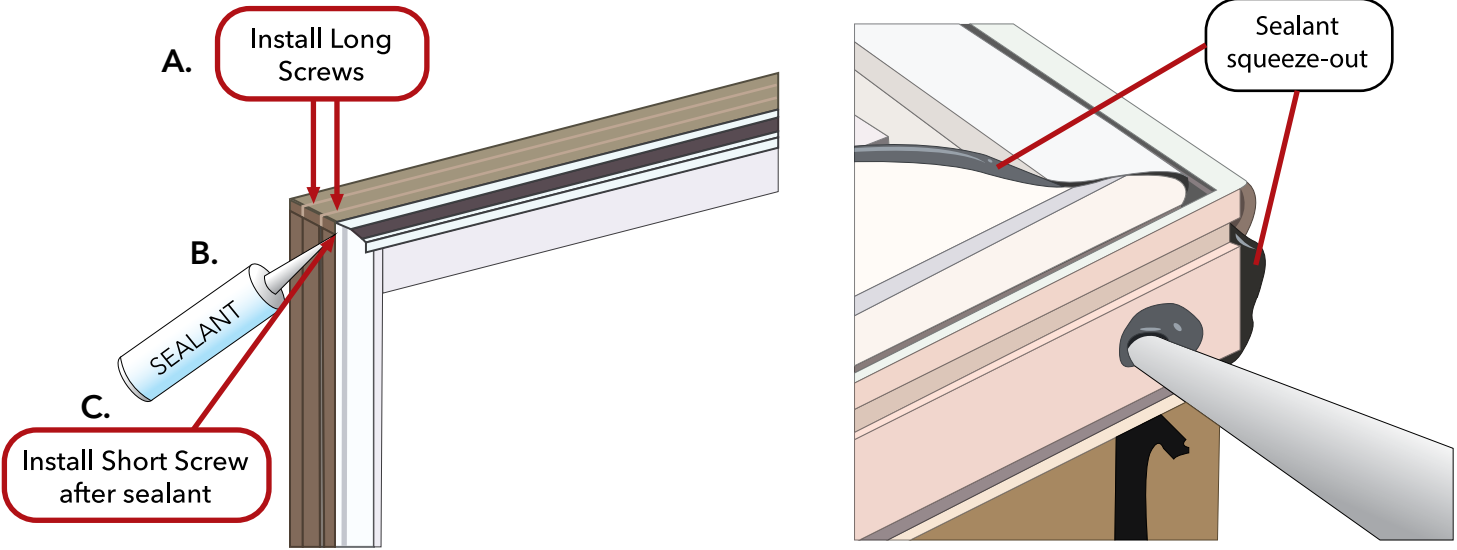


Head clad on top of jamb clad



6
Continued

- 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/LOCK JAMB ASSEMBLY:

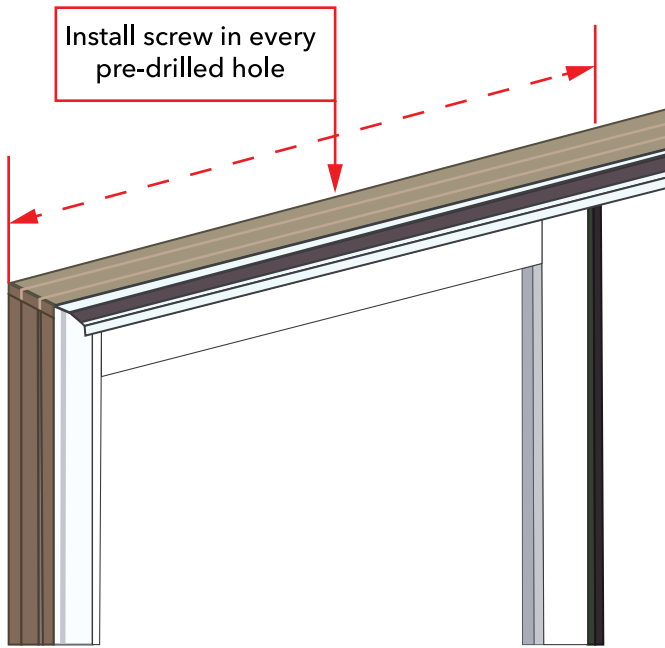
- A. Install the long screws into the wood frame of the lock jamb.
- B. Inject sealant into the jamb cornerlock screw hole until sealant squeezes-out at miter seam.
- C. While holding the seam closed with hand pressure or corner clamp, install short screw into the cornerlock hole.



Ensure the cornerlock is completely seated into jamb cladding.

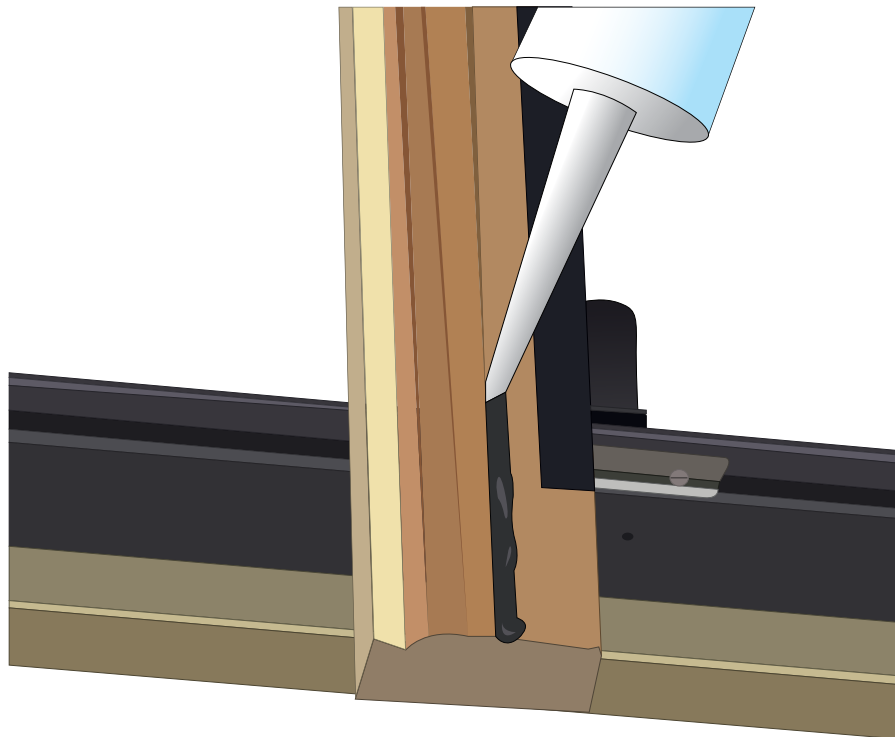
8

HEAD TO FIXED PANEL ASSEMBLY: Install the head screws into the pre-drilled holes.

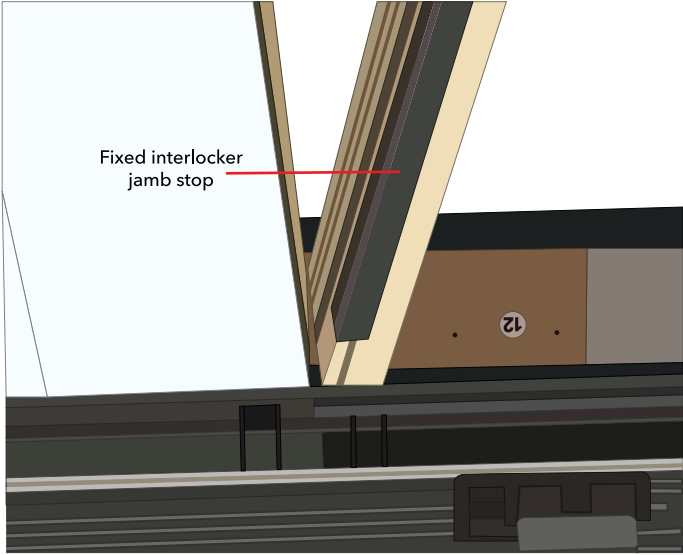


9

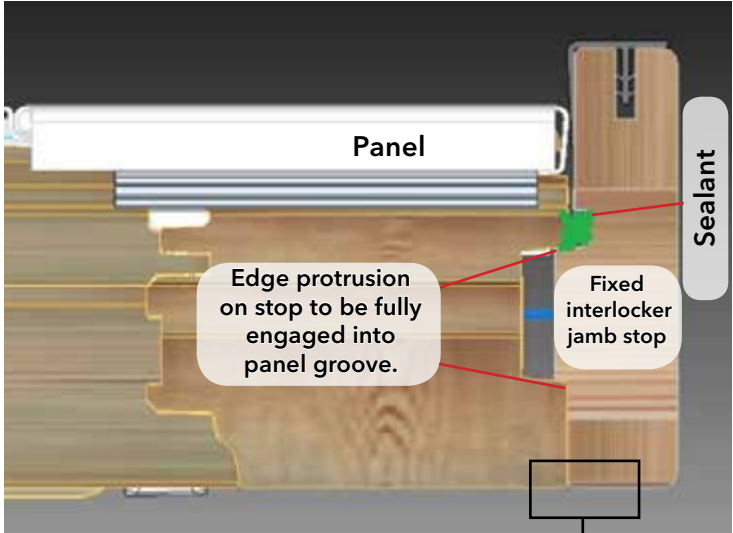
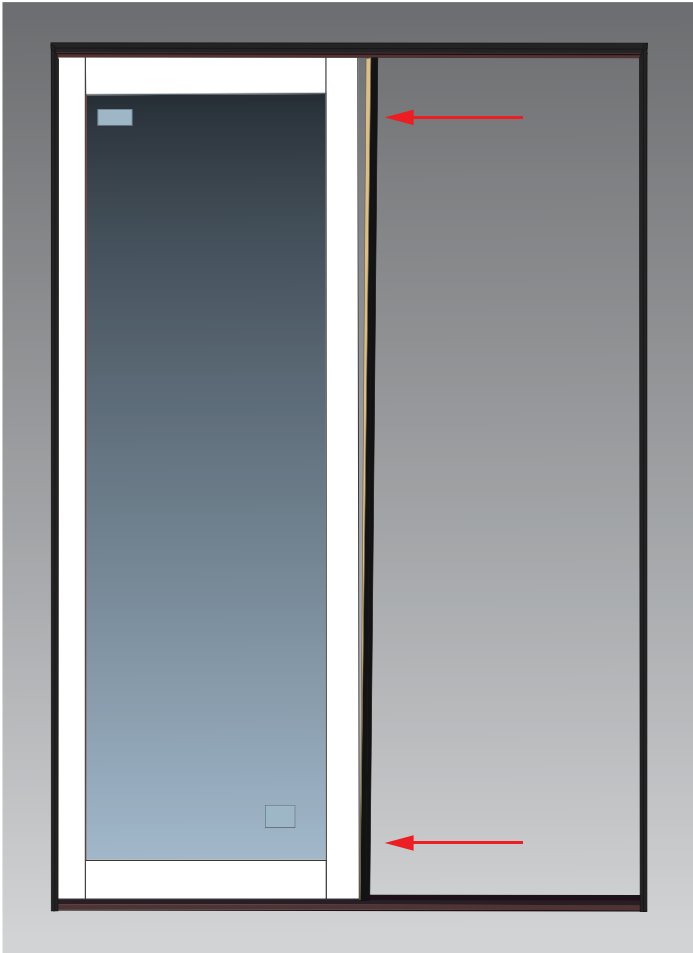
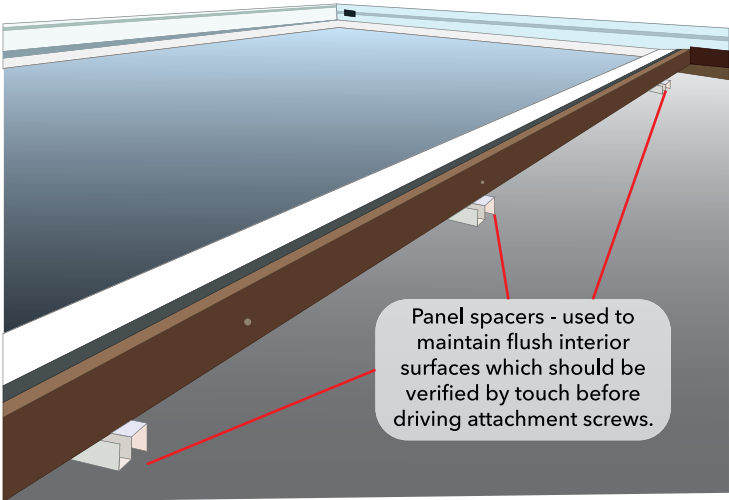
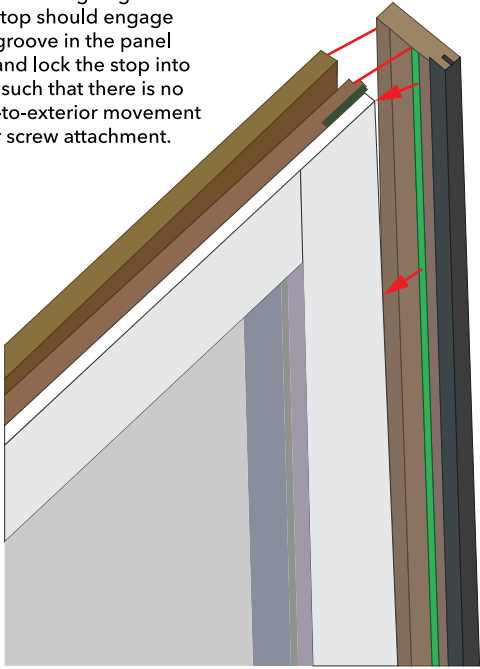
Apply sealant to the fixed interlocker jamb stop groove (fill groove completely with sealant - 1/8" from top and flush to sill).



Install Fixed Interlocker Jamb Stop to edge of fixed panel; install sill end first, then the head end. It is necessary to bow the stop away from the panel in the middle while pushing into the panel at the top. Use panel spacers under the panel and the stop to make sure the interior face of the stop is flush with the interior face of the panel.

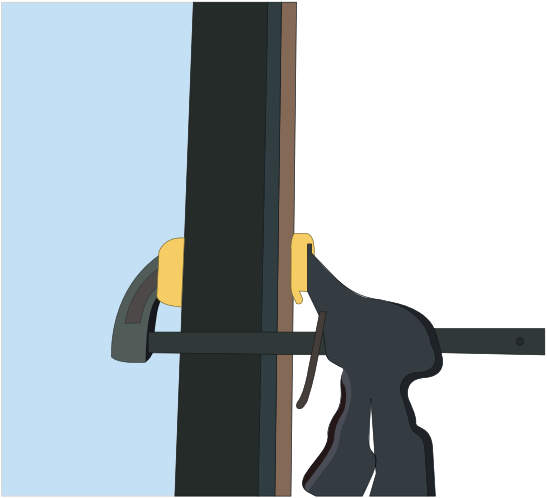
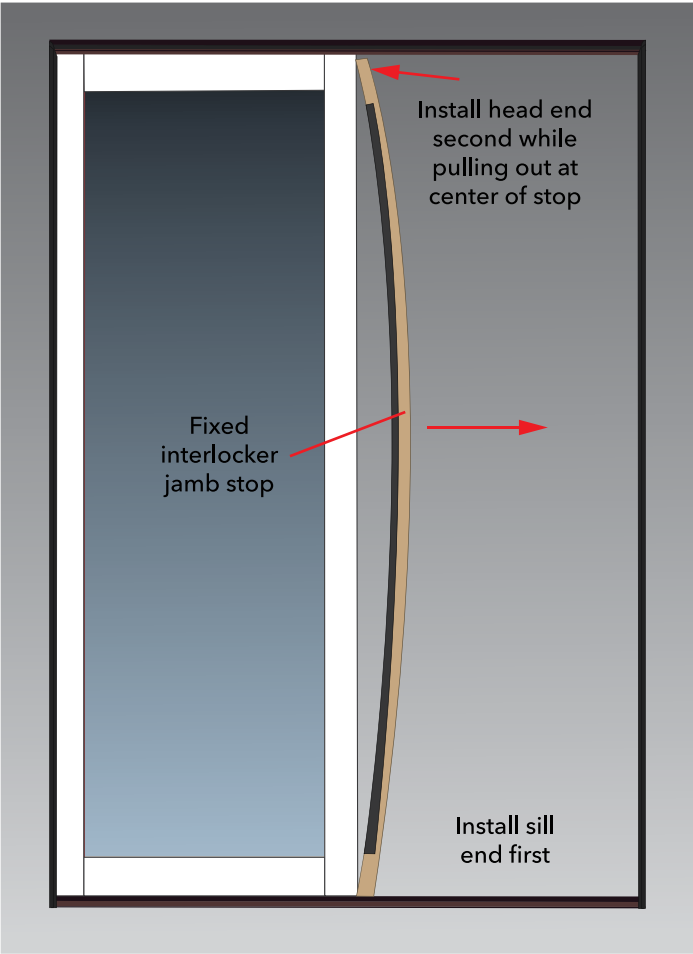


The protruding edges on the stop should engage the groove in the panel edge and lock the stop into place such that there is no interior-to-exterior movement after screw attachment.

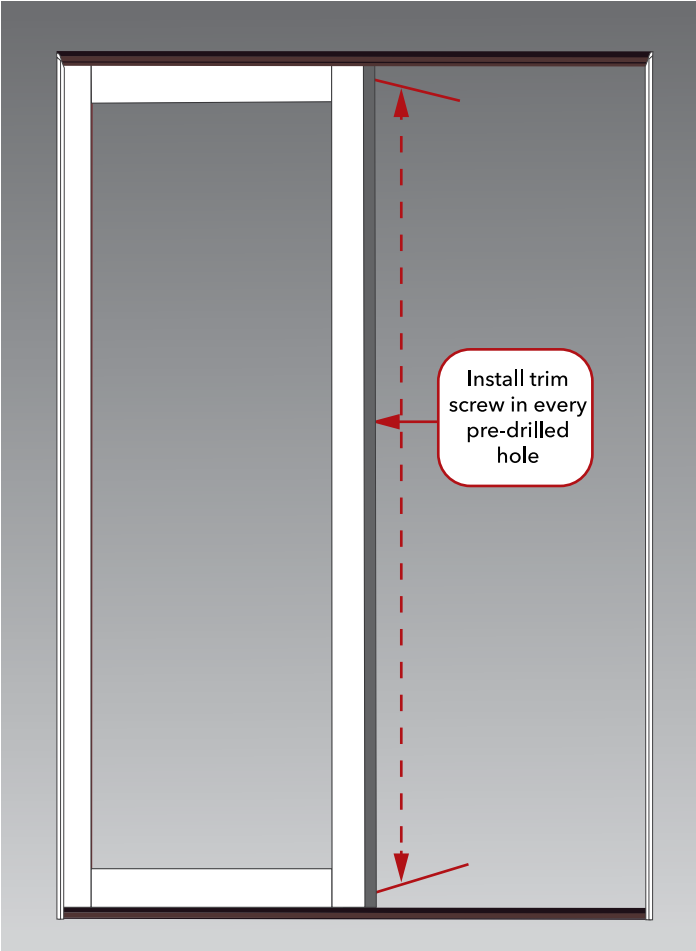


Interior face of Fixed interlocker jamb stop flush with interior face of panel.

Attach with trim screws in every pre-drilled hole. Use clamps to make sure the stop is fully seated.

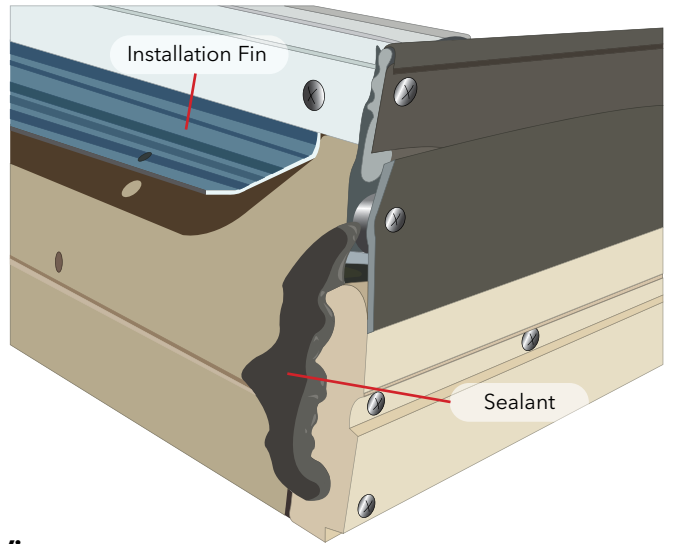
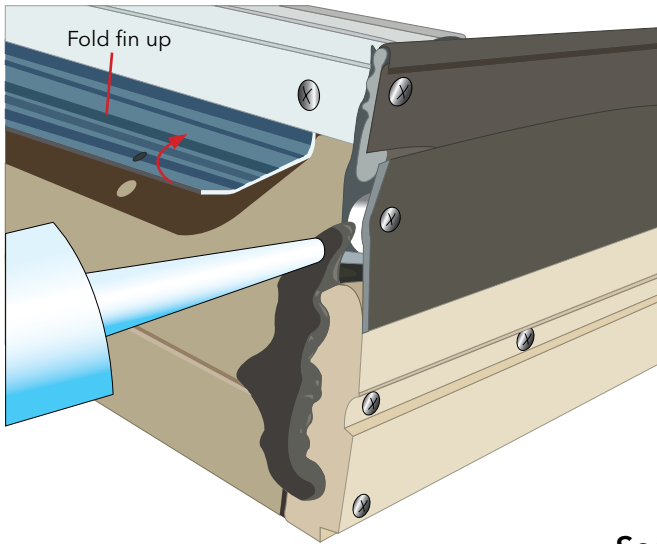


Clamp stop at every screw location

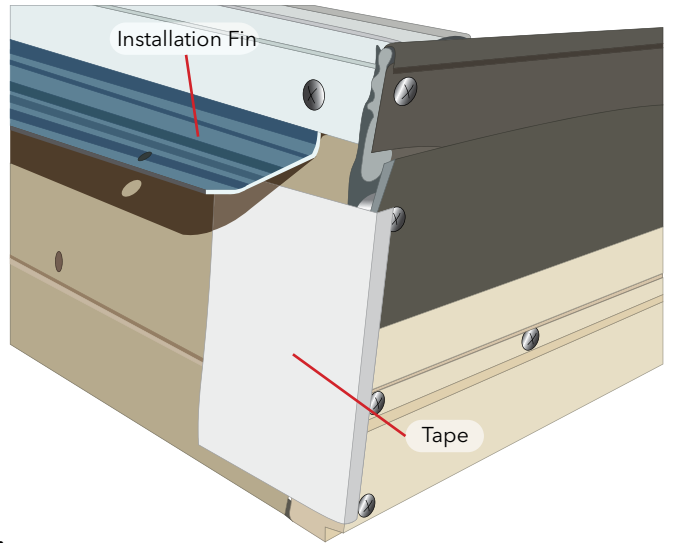
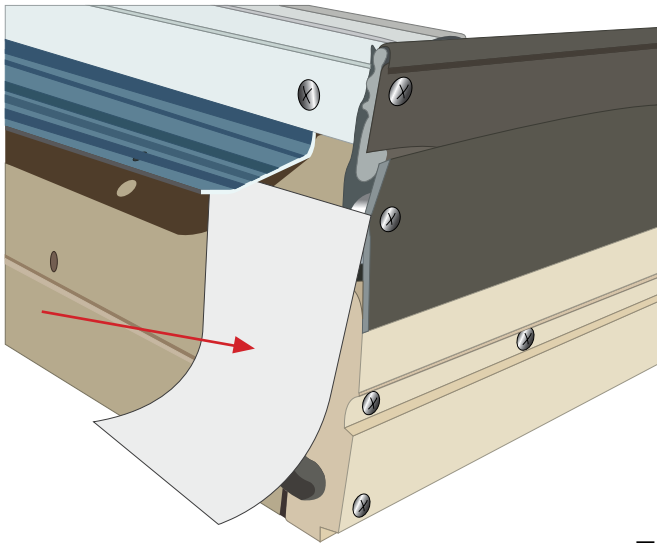


10

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.

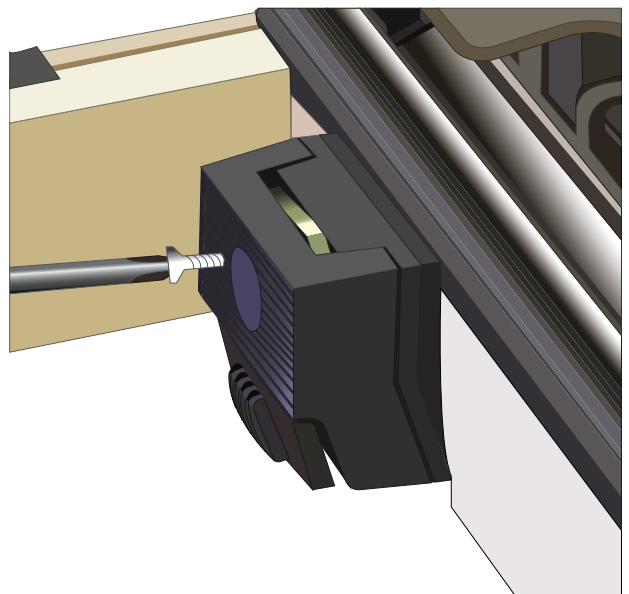


Sealant View



Tape View

Install footbolt using included attachment screws.



3-PANEL (OX|O, O|XO, O|OX, XO|O) KNOCK-DOWN SLIDING DOOR MULLION ASSEMBLY

Note: If the products to be mullied have installation fins on the surfaces to be mullied, the installation fins must be removed prior to mulling products together.

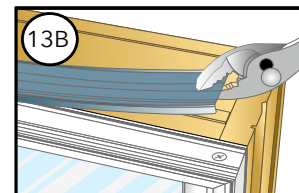
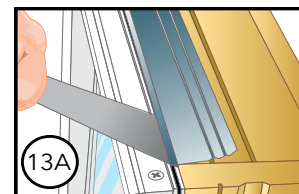
13

REMOVING THE INSTALLATION FIN

A. **Identify the joining sides of each unit.** Place the flat end of a pry bar against the front edge of the fin. Strike the pry bar with a hammer and pry up.

Note: Remove only the fin from the surfaces to be mullied.

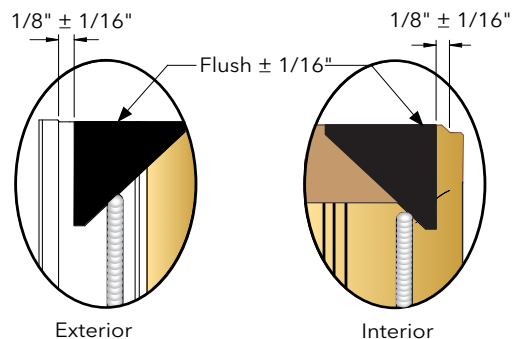
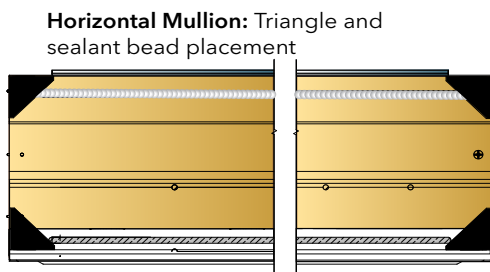
B. **Grasp the end of the fin with pliers or vise grips and pull up on the end of the fin.** Continue pulling up along the full length of the fin until it is completely removed from the product.



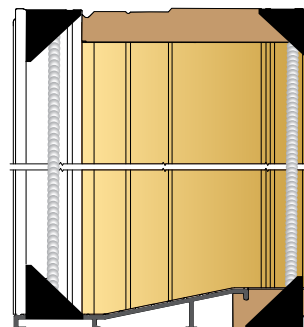
14

POSITION BUTYL TRIANGLES

A. **Place 4 butyl triangles onto one of the two products.** Position them on each end of the mull, orient as shown.



Vertical Mullion: Triangle and sealant bead placement

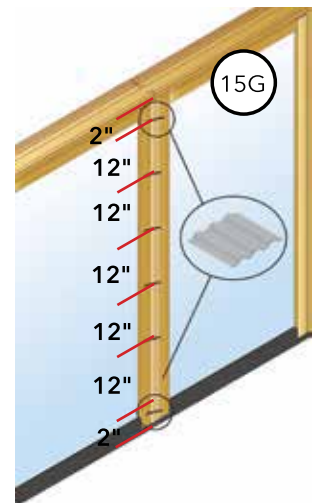
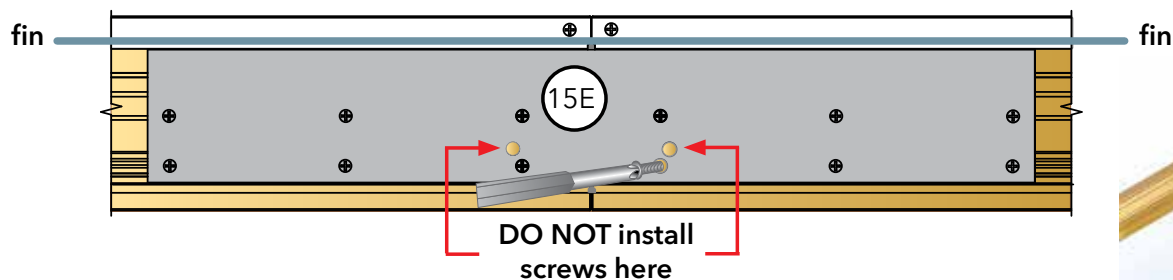
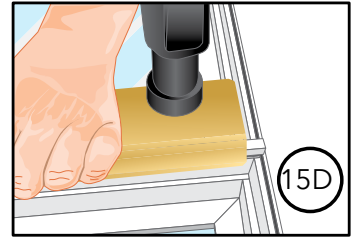


B. **Place a 3/8" sealant bead along the fin groove,** beginning at the approximate midpoint of the triangle. Continue along the fin groove to the opposite corner of the product. Place another 3/8" sealant bead 9/16" from the interior bead running bead from triangle to triangle.

15

MULLING THE PRODUCTS TOGETHER

- Measure the frame dimension** of the surface to be mullied when using lineal mullion covers. Using a hacksaw, cut the mullion covers $\frac{3}{8}$ " shorter than the frame dimension.
- Place the products, exterior (clad) side up** on a clean flat surface.
- Align the two products** and squeeze or clamp tightly together.
Note: Use clamps with padded jaws to bring the frames together.
- Insert the end of the exterior mullion cover into the accessory groove** of both products. Tap the end into the groove with a rubber mallet. Drive the mullion cover into position with a rubber mallet or a rounded wood block and hammer.
- Attach a gusset plate at the head (top) mullion joint.** Fold up the nailing fin to 90° and position and secure the plate in place using six (12) #8 x $\frac{5}{8}$ " flat head wood screws (provided) for gusset plate. No gusset plate is required at the sill.

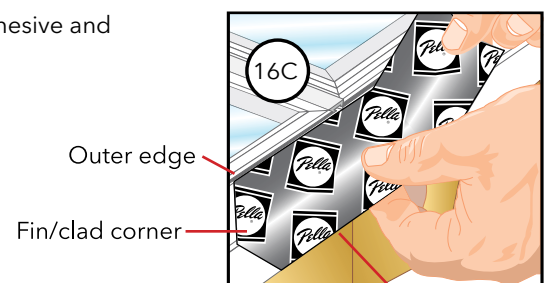
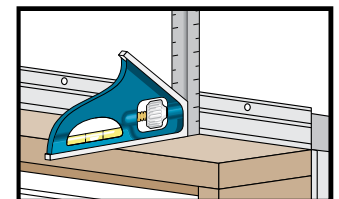


- Turn the products over carefully**, making sure the products stay together.
Note: When turning doors over, lift at the head of each mullied unit and not the jambs.
- Fasten the interior of the units together; using wave nails**, 2" from head and sill, and every 12" on center.
- Install interior mullion cover** by measuring from floor to trim at the head, cutting to length and finish nailing in place.

16

PLACE FLASHING TAPE OVER INSTALLATION FIN SEAMS

- Fold fins on both units out to 90°.**
- Cut a 12" piece of flashing tape.**
- Apply flashing tape** over fin splice extending to outer edge of frame cladding and wrapped back into corner of fin/clad then up fin and over top of fin to interior.
- Press the tape down firmly** over the entire surface to activate the adhesive and ensure a good seal.

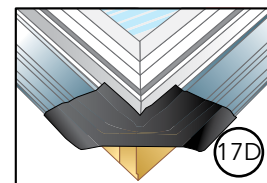
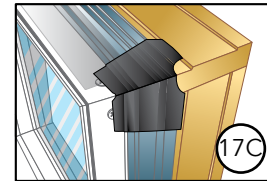
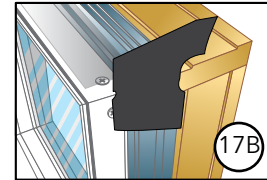
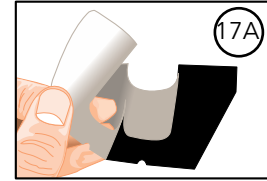


Tape wrapped over top to interior

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.



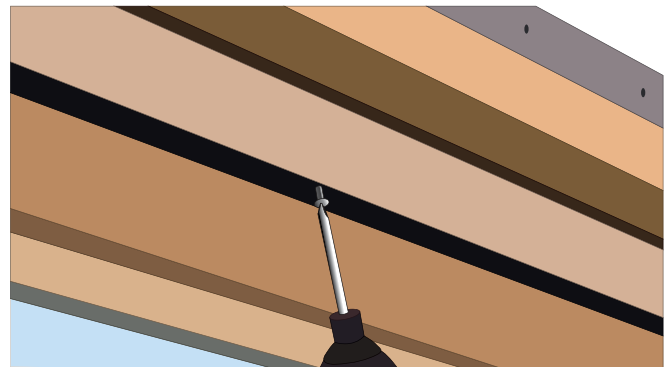
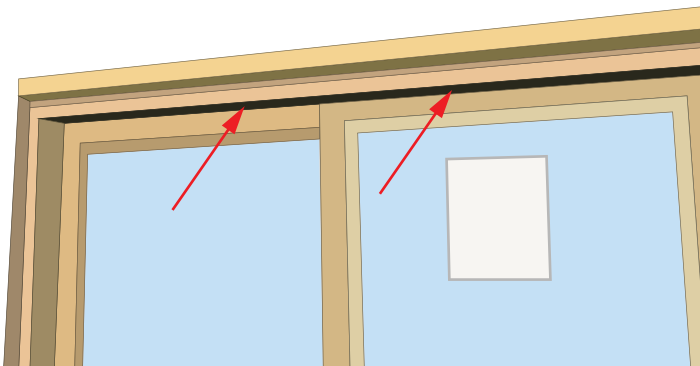
13

Lift unit up and stabilize to remove panel spacers.

14

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.



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