



# Pella® 250 Series Standard and Premium Sliding Patio Door Installation Instructions

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## WARRANTY INFORMATION

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These instructions were developed and tested for use with wall systems designed to manage water. These instructions are not to be used with any other construction methods or door frame types. Installation instructions for use with other construction methods or frame types may be obtained from Pella® Corporation, your local Pella retailer or [www.installpella.com](http://www.installpella.com). Building designs, construction methods, building materials, and site conditions unique to your project may require an installation method different from these instructions and/or additional care. Determining the appropriate installation method is the responsibility of you, your architect, or construction professional.



Always read the Limited Warranty before purchasing or installing Pella® products. By installing this product, you are acknowledging that this Limited Warranty is part of the terms of the sale. Failure to comply with all Pella installation and maintenance instructions may void your Pella product warranty. See written Limited Warranty for details, including exceptions and limitations at [pella.com/warranty](http://pella.com/warranty), or contact Pella Customer Service at 877-473-5527.

BY PURCHASING, INSTALLING OR USING PELLA PRODUCTS (INCLUDES PELLA GOODS AND PELLA SERVICES), YOU AGREED TO THE TERMS OF THEIR RESPECTIVE LIMITED WARRANTIES AND YOU AND PELLA FURTHER AGREE TO ARBITRATE DISPUTES ARISING OUT OF OR RELATING TO YOUR PELLA PRODUCTS, AND YOU WAIVE ANY RIGHT TO PARTICIPATE IN A REPRESENTATIVE OR CLASS ACTION RELATED TO PELLA PRODUCTS unless you notify Pella of your decision to opt out of the Arbitration Agreement no later than ninety (90) calendar days from the date you purchased or otherwise took ownership of Your Pella Goods. Opting out of the Arbitration Agreement will not affect the coverage provided by any applicable limited warranty pertaining to Your Pella Products. For opt out information and additional details please read the Limited Warranty and Arbitration Agreement for your Pella Products at [www.Pella.com/arbitration](http://www.Pella.com/arbitration).

**IMPORTANT:** Consult a contractor or architect for recommendations on installation procedures that may vary from this manual depending on certain city, county or state codes.



## BEFORE BEGINNING FRAME ASSEMBLY AND INSTALLATION:

Read through and understand all the assembly steps and the installation process.  
Carefully remove shipping/packaging materials and check for any product damage.  
Confirm the correct product was received. (Size, color, handing, etc..)  
Confirm all parts as listed in the QC Checklist are present and accounted for.

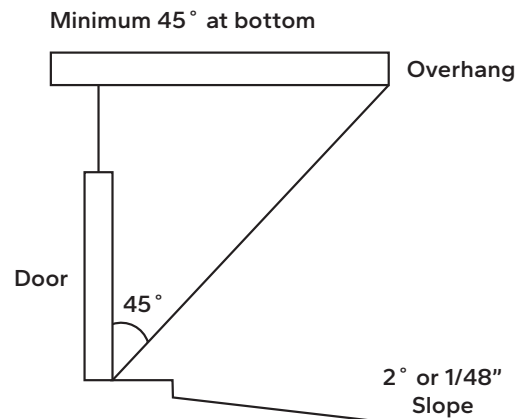
If there are any missing parts, product damage, wrong parts, or other issues...



**DO NOT assemble! Contact Pella Customer Service at: 877-473-5527.  
Or Contact your local sales representative or customer service team.**

Before purchasing and installing, verify performance of product meets the requirements of the application and region. Not all products or sill types are rated for water performance. To reduce the likelihood of water infiltration where application exceeds product performance, install doors under an overhang that extends to meet a 45-degree line from the door sill and slope the exterior 2 degrees away from the door or use a stepdown.

**FAILURE TO DO SO MAY RESULT IN DAMAGE TO THE INTERIOR OF THE STRUCTURE.**



### Tools List:

- #2 Phillips handheld screwdriver
- Pry bar
- 6", 2', 4', & 6' Level
- Square
- Safety glasses
- Utility knife
- Hammer
- Wood block
- Mallet
- Tape measure
- Drill with 3/8", 9/64", 3/4" bits
- Fine tooth chop saw
- Sealant gun
- Large hook tool
- Suction cups

### Supply List:

- Moisture resistant shims/spacers (12 to 20)
- 2" galvanized roofing nails (1/4 lb. or #8 x 2" screws to fasten nail fin)
- Masonry screws for concrete applications (Minimum of 3/16" diameter x 3")
- Closed cell foam backer rod/sealant backer (21 to 30 ft.)
- Pella® SmartFlash™ foil backed butyl window and door flashing tape or equivalent
- Pella Window and Door Installation Sealant or equivalent high quality, multi-purpose sealant
- Low expansion, low pressure polyurethane insulating window and door foam sealant. DO NOT use high pressure or latex foams
- Sill pan 6-5/8" x (Rough Opening Width +2)
- Pella aluminum sill support or wood blocking
- Interior trim and/or jamb extensions (15 to 40 ft.)
- Keeper screws
- Keepers
- Astragal keeper screws
- Keeper shim
- Fixed panel screws
- Frame install screws
- Bumper
- Standard hardware & standard hardware screws
- Hole plugs



# IMPORTANT SAFETY AND PRODUCT INFORMATION

**Safety Alert Symbol Reference:** These symbols are intended to alert you to potential injury hazards and information. Obey all safety messages.

<b>COULD</b> Result in:	 <b>WARNING</b> Major Injury/Death	<b>COULD</b> Result in:	 <b>CAUTION</b> Minor Injury	<b>COULD</b> Result in:	<b>NOTICE</b> Product or Property Damage	<b>COULD</b> Result in:	<b>IMPORTANT</b> Procedure and Product Info.
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**WARNING** To ensure safety and security and help prevent property damage, including possible damage to your window or door, close and lock windows and doors any time they are not being used for venting on a nice day, and particularly during high winds or rain. Ensure all windows and doors are properly fastened to the wall structure according to the product anchor instructions. It is the responsibility of the Buyer or User, the architect, contractor, installer, or other construction professional to ensure the appropriate windows and doors are chosen for the project and the wall construction is designed to resist all loads in accordance with local building code requirements.

**CAUTION** Many doors in older homes are painted with lead-based paint. Removal of old doors may disturb this paint. Proper precautions must be taken to minimize exposure to dust and debris. Consult state or local authorities and/or go to [www.epa.gov/lead](http://www.epa.gov/lead) for more information.

**NOTICE** Pella products must be stored in an upright, level position not exposed to weather. The storage must be ventilated and provide protection from direct sunlight and excessive temperature.

**IMPORTANT NOTICE** Because all construction must anticipate some water infiltration, it is important that the wall system be designed and constructed to properly manage moisture. Pella Corporation is not responsible for claims or damages caused by anticipated and unanticipated water infiltration; deficiencies in building design, construction and maintenance; failure to install Pella products in accordance with Pella's installation instructions; or the use of Pella products in wall systems which do not allow for proper management of moisture within the wall systems. The determination of the suitability of all building components, including the use of Pella products, as well as the design and installation of flashing and sealing systems are the responsibility of the Buyer or User, the architect, contractor, installer, or other construction professional and are not the responsibility of Pella.

Pella products should not be used in barrier wall systems which do not allow for proper management of moisture within the wall systems, such as barrier Exterior Insulation and Finish Systems (EIFS) (also known as synthetic stucco) or other non-water managed systems. Except in the states of California, New Mexico, Arizona, Nevada, Utah and Colorado, Pella makes no warranty of any kind on and assumes no responsibility for Pella windows and doors installed in barrier wall systems. In the states listed above, the installation of Pella Products in barrier wall or similar systems must be in accordance with Pella's installation instructions. Product modifications that are not approved by Pella Corporation will void the warranty.

**CARE AND MAINTENANCE:** Refer to the Pella Owner's Manual. Visit [www.pella.com](http://www.pella.com) or your local retailer for more information.

**CLEANING INSTRUCTIONS:** Refer to the Pella Owner's Manual for comprehensive maintenance and cleaning information. Visit [www.pella.com](http://www.pella.com) or your local retailer for more information.

**GLASS:** Remove any protective film and labels and clean the glass, using a soft, clean, grit-free cloth and mild soap or detergent. Be sure to remove all liquid by wiping dry or use a clean squeegee.

**NOTICE** DO NOT apply any other types of film to the glass. Doing so could void product warranty.

**PELLA® 250 SERIES DOOR FRAMES:** The vinyl frame may be cleaned using the same method as the glass. For stubborn dirt, a "non-abrasive" cleaner such as Bon-Ami® or Soft Scrub® may be used.

**NOTICE** Do not use solvents such as mineral spirits, toluene, xylene, naphtha or muriatic acid as they can dull the finish, soften the vinyl and/or cause failure of the insulated unit seal.

**NOTICE** Do not use Isopropyl Alcohol on laminated surfaces as it will damage the finish. Keep door tracks clear of dirt and debris. Keep weep holes open and clear of obstructions.

**NOTICE** DO NOT use abrasives. DO NOT scrape or use tools that might damage the surface.

**NOTICE** DO NOT use inappropriate solvents or brickwash or cleaning chemicals. If you do, permanent damage can result and the product failure, loss or damage would not be covered by the Limited Warranty.



# INSTALLATION INSTRUCTIONS FOR TYPICAL WOOD FRAME CONSTRUCTION

These instructions were developed and tested for use with typical wood frame wall construction in a wall system designed to manage water. **These instructions are not to be used with any other construction method.**

Building designs, construction methods, building materials, and site conditions unique to your project may require an installation method different from these instructions and additional care. Determining the appropriate installation method is the responsibility of you, your architect, or construction professional.

**Understand ALL manufacturer's instructions before beginning to install your product.**

- Do not work alone. Use safe lifting techniques.
- Always wear your P.P.E. (e.g. safety glasses, gloves, ear protection, etc.).
- Use caution when handling glass.
- Operate hand/power tools safely and follow the manufacturer's operation instructions.
- Do not put stress on corners of frames.
- Store door in a well-ventilated area in a vertical, leaning position to allow air circulation.
- Protect from exposure to direct sunlight during storage.
- Install only into vertical walls and when conditions and sheathing are dry.

**NOTICE** With multiple tracks it's very important to make sure the threshold is level the entire length of the opening and the distance from the interior to the exterior.

**NOTICE** FAILURE TO PROVIDE ADEQUATE ROUGH OPENING SILL PROTECTION FOR WOOD THRESHOLDS WILL VOID PRODUCT WARRANTY.

**NOTICE** Proper steps must be taken when flashing and applying sealant to ensure proper waterproofing of the unit.

## 1 Opening Preparation:

A. **Confirm the opening is plumb and level.**

**NOTICE** It is critical the bottom is level and does not slope to the interior or exterior.

B. **Remove dirt, oil or debris** from the opening and surrounding wall surfaces.

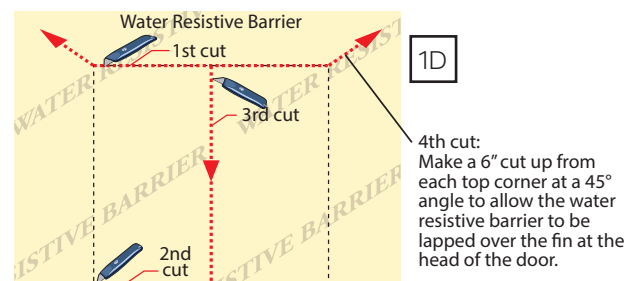
C. **Confirm the door will fit the opening.** Measure all four sides of the opening to make sure it is 1/2" to 3/4" larger than the door in width and 1/2" larger in height. Measure the width and height in several places to ensure the header or studs are not bowed.

**NOTICE** 1-1/2" or more of solid wood blocking is required around the perimeter of the opening. Fix any problems with the rough opening before proceeding.

**NOTICE** It is important to consider the door's exposure to weather, the exterior landing surface type and its proximity to the door sill, and to confirm impervious exterior surfaces properly slope away from the door prior to continuing with installation.

D. **Cut the building wrap.**

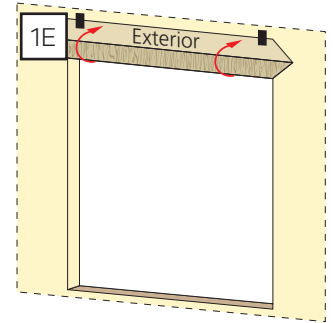
E. **Fold the building wrap in at the jambs** and staple it in place. Fold the top flap up and temporarily fasten with flashing tape.



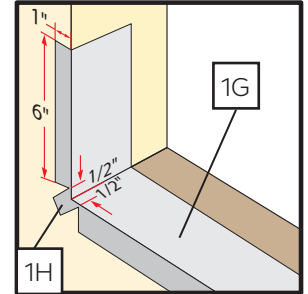
# 1 Opening Preparation (continued):

**NOTICE** If using a sill pan or if the door will be installed on a concrete slab, refer to the instruction page at the end of this instruction.

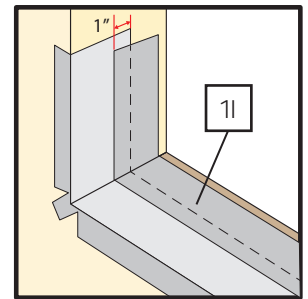
- F. Cut two pieces of flashing tape 12" longer than opening width.
- G. Apply sill flashing tape #1 at the sill extending 1" to the exterior and 6" up each jamb.



- H. Cut 1" wide tabs at each corner by tearing the foil 1/2" each way from the corner.
- I. Apply sill flashing tape #2 overlapping tape #1 by at least 1".

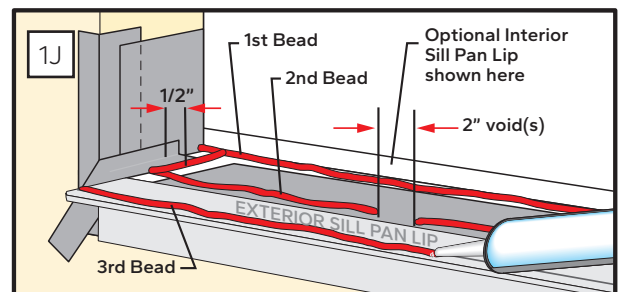
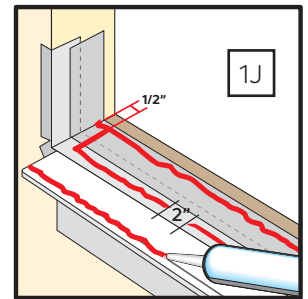


- J. Place three 3/8" beads of sealant across the opening sill. Place the interior-



most bead 1/2" from where the interior of the door sill will remain after installation. Continue this bead up the sill pan lip, if applicable.

- K. Place a second bead beginning from the interior bead 1/2" from each side, out to the exterior of the framing and along the opening. Leave 2" voids 4" from the corner and at center. Place a third bead where the exterior of the door sill will remain after installation.



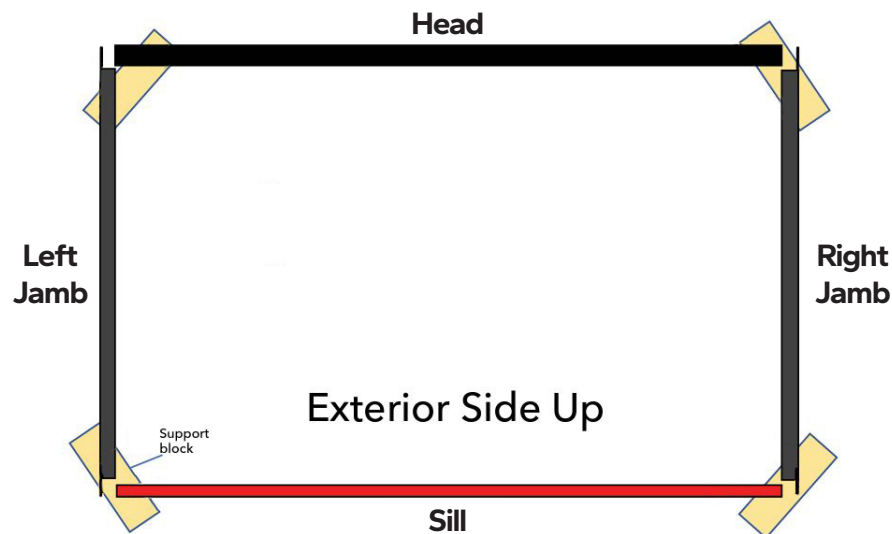
## 2 Frame Assembly:

**NOTICE** Doors which come as knock down come with the frame caps installed in the frame. The caps need to be removed to access the outer track to install frame installation screws.

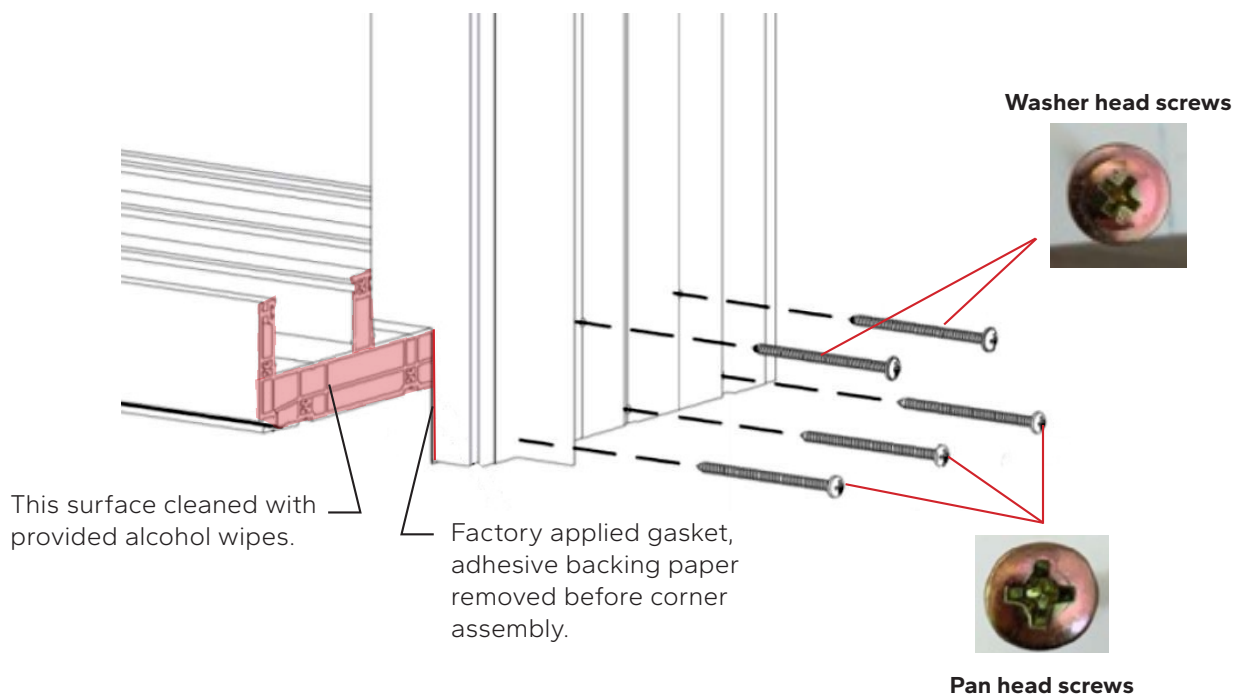
A. **Identify frame parts necessary** (head, 2 jambs and a sill). The sill can be identified by the weep holes.

Position the head, sill and 2 side jambs exterior side up on a clean flat surface in the orientation in which they will be assembled. Insert wood blocks under each corner to support and level the corners on an uneven surface. Or position the frame parts on sawhorses.

Be sure to assemble one frame corner at a time. Joining the sill to the jambs first, followed by joining the head to the jambs.



**NOTICE** Use care if using an impact driver during the Frame Assembly Process. If not careful, impact drivers can cause screw head breakage.

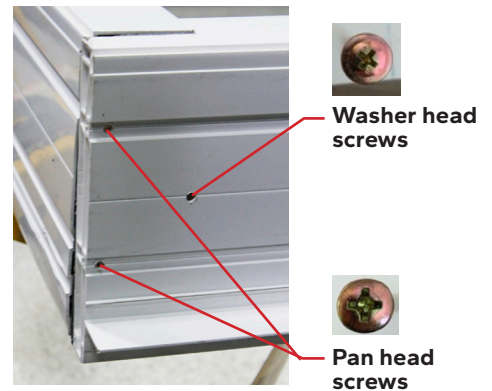


## 2 Frame Assembly (continued):

- B. Using the provided alcohol wipes, clean the area where the jamb gaskets will be adhering to on the head and sill.



- C. Remove the adhesive backing paper from the gasket on one jamb frame corner near the sill. Position the jamb and sill together.



- D. Insert the packaged frame assembly screws into the predrilled holes in the jamb. Pan head screws will go in the recessed sections of the frame. The washer head screw will go in the holes with the flat surface. One corner at a time, make sure each screw is aligned with the proper screw boss, and tighten each screw sequentially and evenly until the jamb is tightened firmly against the sill and/or head. Be careful not to over torque and strip out the vinyl or pull through the jamb's walls. There should be a slight dimple in the frame where the washer head screws are applied.

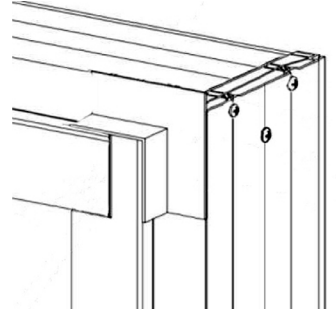
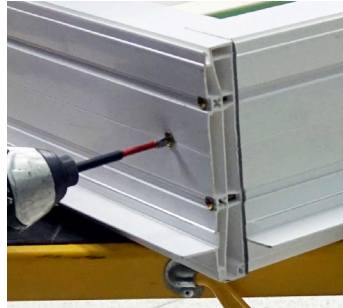
**NOTICE** Use care if using an impact driver during the Frame Assembly Process. If not careful, impact drivers can cause to screw head breakage.



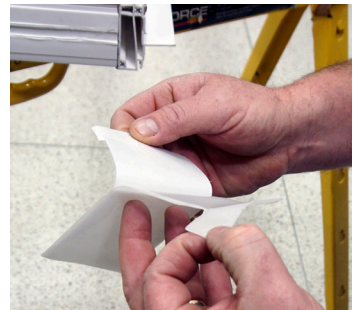


## 2 Frame Assembly (continued):

- E. Repeat 2C-2D on the other sill jamb/sill corner and then on the two head/jamb corners.



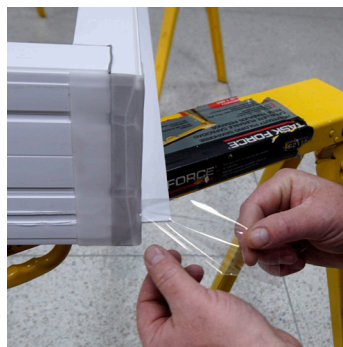
- F. Remove the adhesive backing paper of the seal tape to expose the sticky side of the tape.



- G. Apply the provided seal tape to the outside of the jamb-sill joint on both sides. Press the tape firmly in place.



- H. Once the tape has been applied, remove the Mylar backing. Once the Mylar backing has been removed, work the tape into any voids in the frame to ensure a good seal.

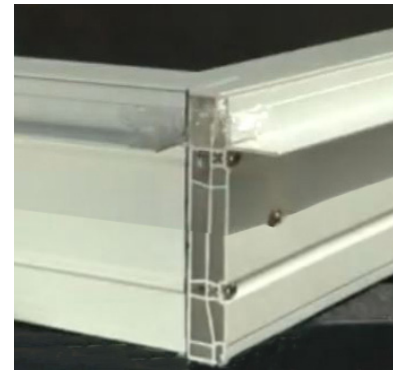


## 2 Frame Assembly (continued):

- I. If needed flip the frame over, so the exterior side is facing up.



- J. **Apply the nail fin corner.** Using the provided sealant, fill the outer most hole on top of the frame as well as apply a bead of provided sealant to the nail fin on the jamb and head. Firmly apply the nail fin corner into place. Make sure the nail fin corner is on the outer portion of the frame mounted to the face of the frame.



# 3 Frame Installation:

- A. **Center the bottom of the door in the opening and tilt the door into position.** Do not slide the door into the opening. Sliding will damage the sealant lines. Check the jambs for plumb and confirm there is room for shimming between the jambs and opening on each side.



- B. **Walk across the sill** to compress the sealant and confirm the frame is firmly on the threshold, free of any humps due to the sealant under it.



- C. **Confirm the sill is level.** Place a level on the sill to confirm the sill is level. Add shims to level the sill as needed.



For Doors without a nail fin, proceed to step 35.

# 3 Frame Installation (continued):

## Doors with a Nail Fin:

D. Place shims between the frame and rough opening at the sill to wedge the bottom of the frame in place.



E. Insert a screw through the exterior nail fin near the sill on each side of the frame.



F. Place shims between the frame and rough opening at the head to wedge the top of the frame in place.

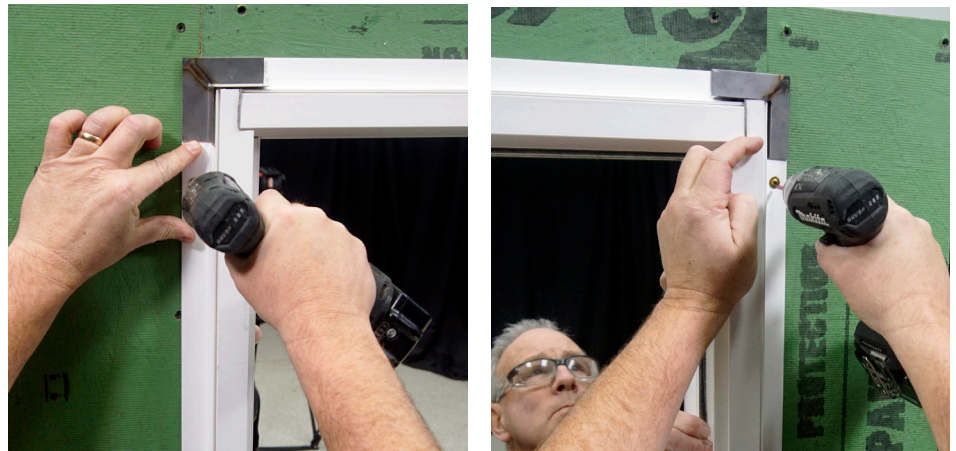


# 3 Frame Installation (continued):

G. Measure the frame diagonally to confirm the frame is square in the opening.



H. Insert a screw through the exterior nail fin near the head on each side of the frame.



## Doors With or Without a Nail Fin:

I. If not completed during frame assembly, remove the frame head, jamb and sill threshold cap(s). If needed use a large hook tool to start the cap removal.

**NOTICE** Doors which come as knock down come with the frame caps installed in the frame. The caps need to be removed to access the outer track to install frame installation screws.

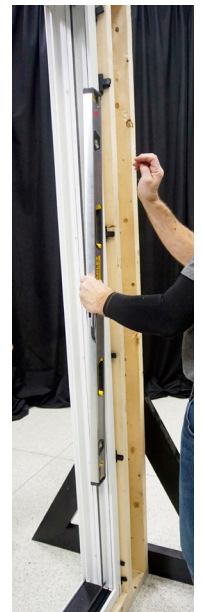


### 3 Frame Installation (continued):

J. Remove the frame jamb caps.



K. **On one jamb**, starting near the sill, 3"-6" from the corner, insert and fasten an installation screw with shim(s) between the frame and rough opening. Work up the jamb spacing the installation screws & shims no more than 16" apart. Check the jamb with a level while moving up toward the frame head. Finish installing the top screw 3"-6" from the corner.



L. Repeat fastening the installation screws and shims on the other jamb.

### 3 Frame Installation (continued):

M. Measure the frame diagonally to confirm the frame is still square in the opening.



N. Beginning in the center of the head shim and install a frame screw, checking the head with a level.

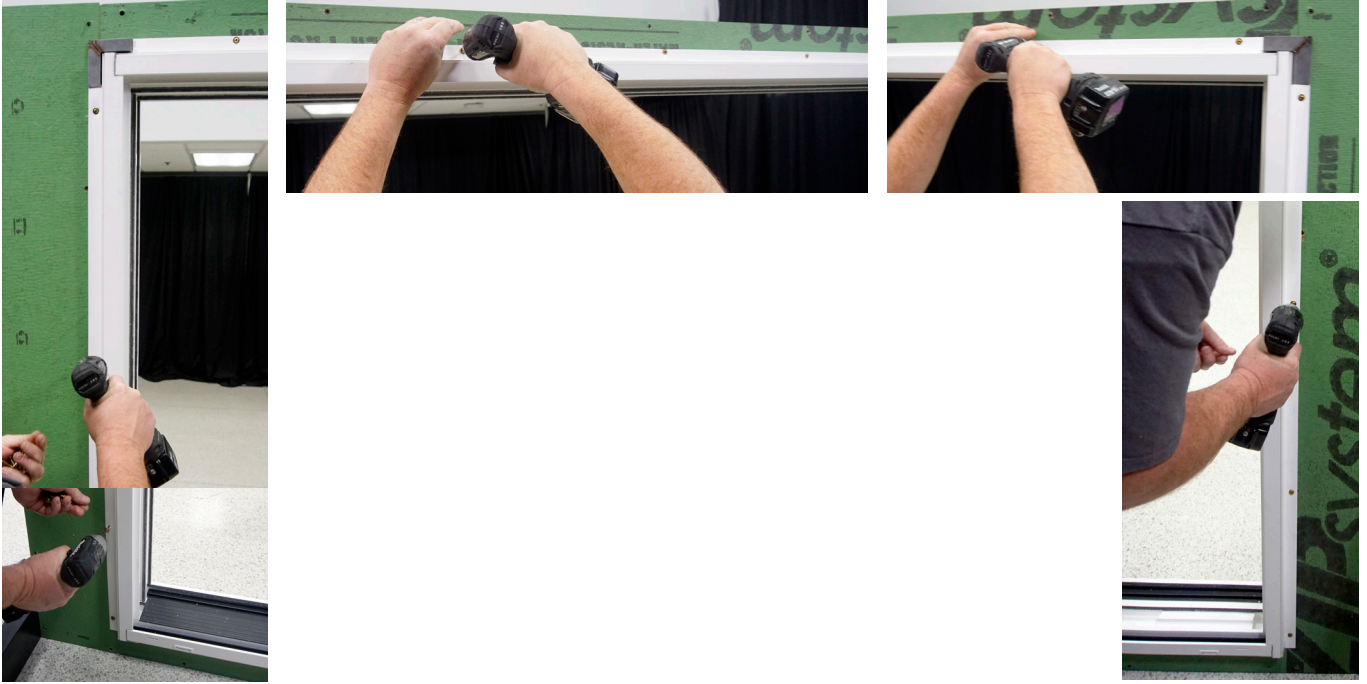


O. Finish installing the head frame screws and shims spaced no more than 16" apart and 3"- 6" from the corners.



### 3 Frame Installation (continued):

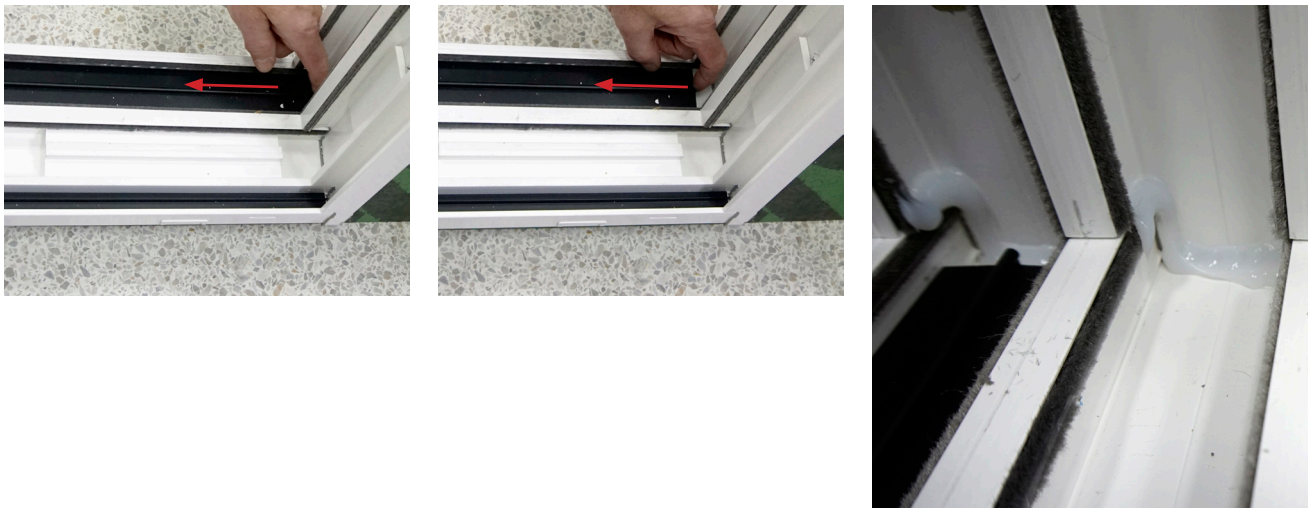
P. Complete the frame install by inserting screws through the nail fin spaced every 12".



Q. Apply sealant to both sides of the frame where the jamb and sill meet in the location shown. Make sure all meeting locations are covered with sealant.



R. It may be necessary to slide the sill tracks out of the way to have adequate room for sealant application.





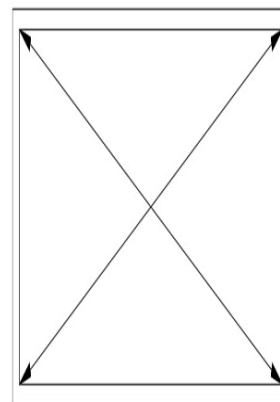
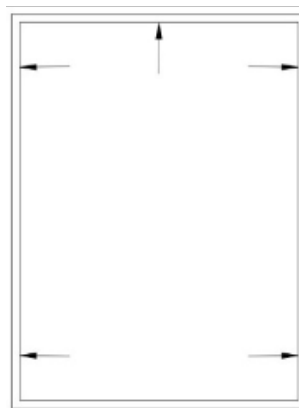
### 3 Frame Installation (continued):

- S. Tool Sealant to ensure proper coverage.



#### Doors without a Nail Fin (Block Frame only):

- T. **With the frame screws provided**, and shims behind each screw, secure the four corners and one screw in the middle of the head outer track to eliminate sagging and misreadings when taking diagonal measurements to check for squareness. (Place screws in the outer most track so they will be hidden behind caps and the fixed panel.) Measure the frame diagonally to confirm it is square.
- U. **Place a level on each jamb to make sure they are plumb interior to exterior.**



- V. **Finish securing the jamb and head of the frame** by placing the screws in the pre-drilled holes in the outer track, no more than 16" apart and roughly 3" from the corners. Shim behind each screw as needed. Place shims between the framing and door frame every 16" on the jambs and head. Use a level to make sure the jamb side-to-side is plumb and there is no daylight between the level and the frame. Follow the same method on the head.

# 4 Vent Panel Installation:

A. Apply suction cup(s) to the vent panel.



B. Install the vent panel (the panel onto which the handle hardware will be installed) into the inner track.



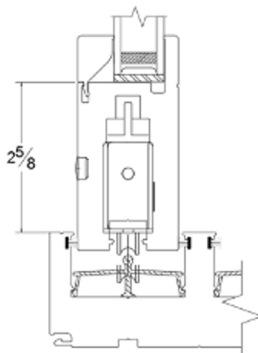
C. Slide the vent panel over to the lock side jamb.



D. **On a Standard door;** raise the roller adjustment to its maximum height using a #2 Philips hand screwdriver.

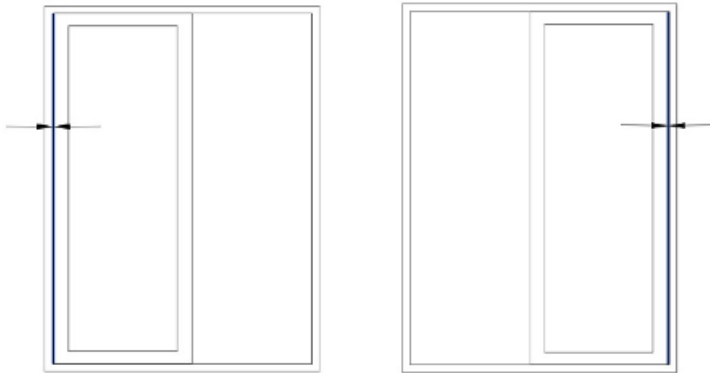
**On a Premium door;** raise the roller until the measurement from the top of the threshold leg to the bottom of the glazing bead is 2-5/8". Be careful not to over tighten the screws.

**Tip:** Lift one corner up to take the weight off the roller.



# 4 Vent Panel Installation (continued):

E. Slide the vent panel to each jamb and look at the reveals.



F If the reveals are not even down the length of the jamb and not consistent with both sides of the jamb, first try roller adjustment to see if this corrects the reveals. If roller adjustment does not correct the reveal issue, the frame may need to be adjusted.

**NOTICE** The goal is for both reveals to mirror each other and be perfectly straight the length of the jamb. If they are not; to first check plumb, level and squareness of the frame before continuing onto troubleshooting the issues.

## Possible issues:

Reveal on the right, panel to jamb, has 1/4" gap on the top corner but bottom corner has no gap. Left, panel to jamb, has a perfect reveal top to bottom. In this case pull the top of the frame to the left to split the difference and mirror the reveals. Now there is 1/8" gap on top and zero on the bottom on the right side and left side. Place an appropriate shim under the sill in the middle of the frame. This will fix both reveals at the same time.

Reveal on the right, panel to jamb, has zero gap on the top corner but the bottom corner has 1/4" gap. Left, panel to jamb, is perfect top to bottom.

Check for humps in the center of the sill or even dips in the corners.

**Any time you do any adjustments to the sill with shims or just moving it one side to the other, always put the level back down and check the threshold for any humps or dips before continuing.**

# 5 Vent Panel Hardware Installation:

**NOTICE** When installing any hardware always use a #2 Philips hand screwdriver.

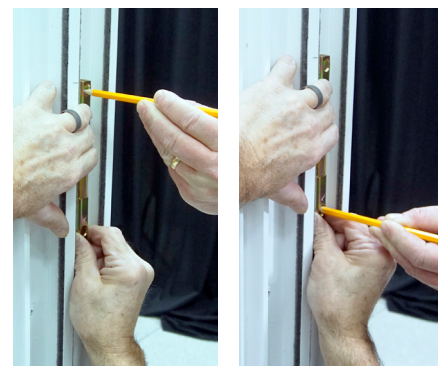
**NOTICE** If installing standard hardware with no key lock, this must be used in place of the key lock. Failure to do so could compromise the security of the product.



A. **Assemble and install the hardware on the vent panel.**  
(See instructions included with hardware.)



B. **Lock the keeper onto the door panel.** Slide the door near the locking side jamb and mark the frame where the height of the keeper is positioned.



C. **Unhook the keeper from the panel** and set it in the jamb aligning it with the pencil mark transferred to the frame. Use the dye line in the center of the pocket for the center reference; mark the center of the top and bottom holes of the keeper onto the frame.



D. **Use the attachment screws** to start a hole at each of the marked locations.

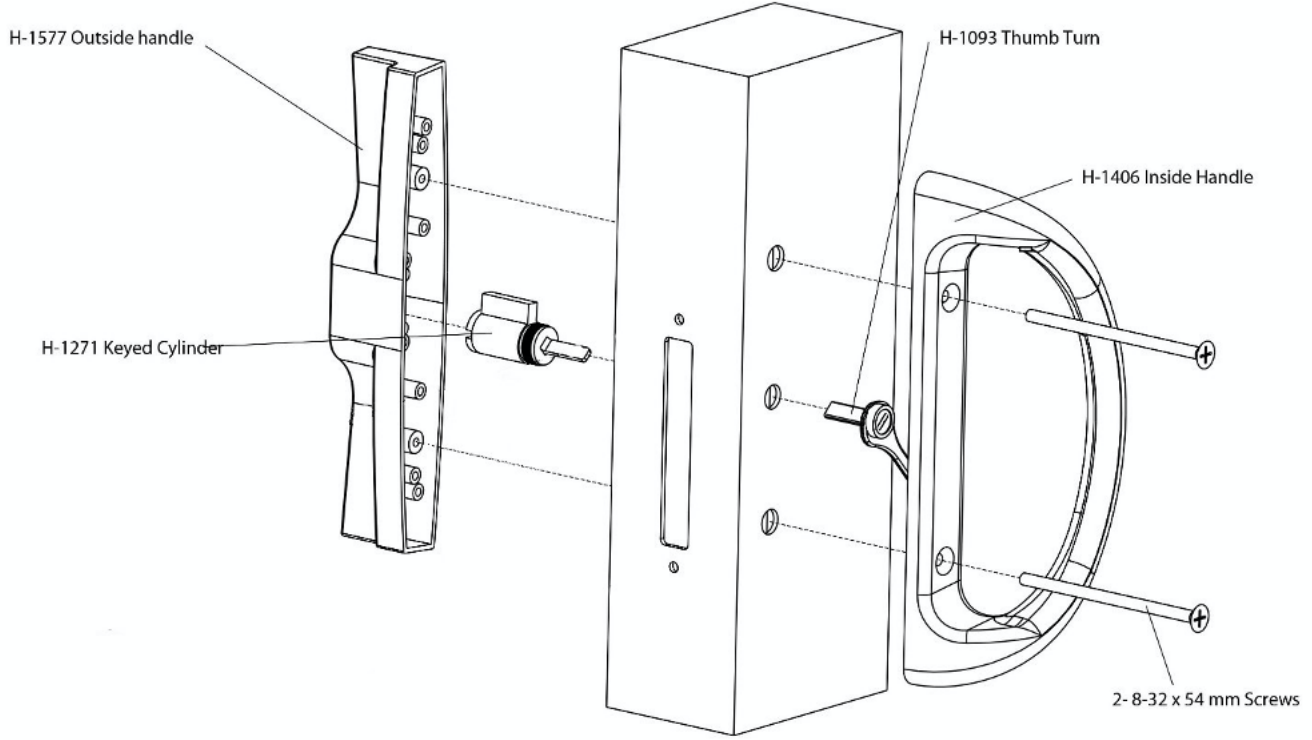
E. **Secure the keeper onto the frame** with the keeper screws provided. **Place shims between the framing** of the opening and the doors frame. Make sure shims are in nice and snug to eliminate any movement.

Slide the panel close to the frame to confirm the frame reveal is still perfectly straight with the panel.

**NOTICE** Do not over tighten and bow the frame. Check the jamb for any bows.



# Standard Hardware with Key Lock:



		UNLESS OTHERWISE SPECIFIED:		NAME	DATE			
		DIMENSIONS ARE IN INCHES		DRAWN		TITLE:		
		TOLERANCES:		CHECKED				
		FRACTIONAL ±		ENG APPR.				
		ANGULAR: MACH ± BEND ±		MFG APPR.				
		TWO PLACE DECIMAL ±		Q.A.				
		THREE PLACE DECIMAL ±		COMMENTS:				
		INTERPRET GEOMETRIC TOLERANCING PER:				SIZE	DWG. NO.	REV
		MATERIAL				<b>A</b>	S-1550 install	
NEXT ASSY	USED ON	FINISH				SCALE: 1:8	WEIGHT:	SHEET 1 OF 1
APPLICATION		DO NOT SCALE DRAWING						

# Signature Series with Key Lock:

**STEP 1**  
MEASURE DOOR THICKNESS.

**STEP 2**  
DETERMINE THE PROPER LENGTH OF MOUNTING SCREWS.

#8-32 x 1.75  
 #8-32 x 2.125  
 #8-32 x 2.5

DOOR THICKNESS RANGE	#8-32 PHILLIPS SCREW LENGTH
1 3/16 TO 1 9/16	1.750
1 9/16 TO 1 15/16	2.125
1 15/16 TO 2 5/16	2.500

INSTALLATION INSTRUCTIONS

HANDLES, KEEPERS AND OTHER COMPONENTS MAY NOT BE AN EXACT MATCH WITH WHAT YOU ARE INSTALLING BUT THE INSTALLATION PROCEDURE IS BASICALLY THE SAME.

**STEP 3**  
LOCK CYLINDER / ESCUTCHEON ASSEMBLY

**STEP 4**  
SIZE TAIL PIECES TO SUIT DOOR THICKNESS

DETERMINING TAIL PIECE BY FINDING BREAK MARK CLOSEST TO 1/2 DOOR THICKNESS MAX.

**STEP 5**  
BREAK OFF TAIL ENDS WITH PLIERS

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GIF-000002947- Part Number: V989417

# 5 Vent Panel Hardware Installation (continued):

- F. **Close the vent panel and test out the lock.**  
Do this multiple times to make sure the door is sliding and locking easily.



- G. **With the keeper installed and locking correctly, finish installing the last screw(s).**

- **4 hole keeper:** Place the upper middle screw at the bottom of the oval hole and the lower middle screw at the top of the oval hole.
- **3 hole keeper:** Place the screw at the top of the middle hole.

Installing the last screw(s) will secure the keeper in place which in turn will help eliminate service issues in the future.



**NOTICE** On the panel lock mechanism there is an adjustment to move the hooks in or out. There should be some play in the lock. If there is not, then there is a possibility there will be locking issues in the future due to thermal expansion.

- H. **Adjusting the play in the lock.** On the face of the lock there will be a flat head adjustment screw. Depending on the lock, there may be one or two adjustment screws.

**NOTICE** NEVER USE A DRILL. USE A 3/16" HAND SCREWDRIVER AND DO NOT OVER TIGHTEN.

**Single screw adjustment:** Clockwise will move both hooks tighter to the panel and counterclockwise will move them further from the panel.

**Double screw adjustment:** Each adjustment works independently for each hook. Clockwise will move the one hook tighter to the panel and counterclockwise will move it further from the panel.

## Standard Lock



# 6 Fixed Panel and Cap Installation:

- A. **Make sure the fixed panel setting blocks are positioned correctly.** One should be positioned near the jamb at the corner and the other block should be placed approximately where the other edge of the fixed panel will sit.



- B. **Install the fixed panel in the outer track** on top of the setting blocks. Before securing the panel in place make sure the vent panel is completely in the strike side jamb pocket. Slide the fixed panel back so the interlocks are engaged but the vent panel is still fully in the pocket. Adjust the fixed panel accordingly so the vent panel has enough clearance to lock properly.

**NOTICE** There is a possibility the fixed panel 1/4" shim MAY need to be removed from the jamb pocket. (See step 8 and page 26.)



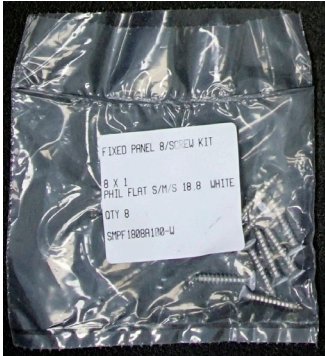
- C. **Check the panel reveals** by making sure the interlockers align on both the vent and fixed panel.





# 6 Fixed Panel and Cap Installation (continued):

D. With the fixed panel screws provided, secure the fixed panel. Place screws evenly spaced into the frame leg where the weatherstrip is located at the top middle and bottom.



E. Apply sealant around the exterior perimeter of the fixed panel where the fixed panel meets the frame. Tool the sealant as needed.



**NOTICE** The interior fixed panel side jamb cap and exterior vent panel side jamb cap are two different profiles.

Make sure these two are not mixed up and they are installed in the correct pocket.



**Fixed Panel Side Jamb Cap**



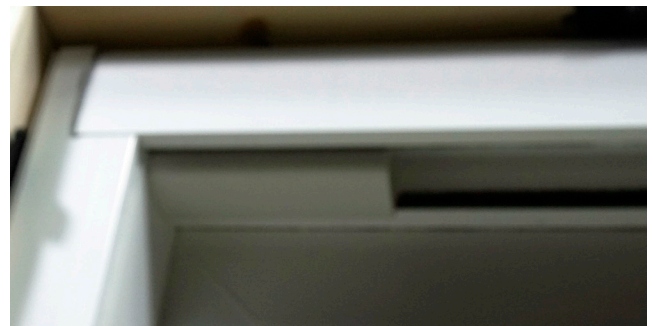
**Vent Panel Side Jamb Cap**

## 6 Fixed Panel and Cap Installation (continued):

- F. **Install the interior jamb fixed panel cap**, this will cover the frame installation screws making for a clean finish. Insert one end and apply pressure along the length of the cap to snap the cap into place.



- G. **Install the patio door bumpers**. Insert the top and bottom bumpers into the outer track and against the interior jamb fixed panel cap.



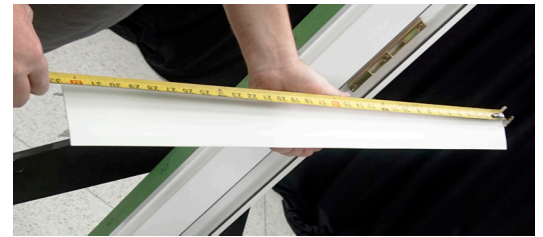
## 6 Fixed Panel and Cap Installation (continued):

- H. **Install the exterior vent side jamb cap** in the exterior pocket. Insert one end and apply pressure along the length of the cap to snap the cap into place.

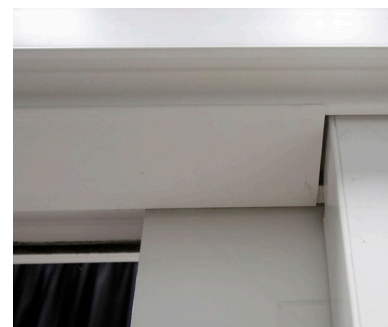


**Make sure the threshold and head cap is cut 1/8" under** the max dimension (the measurement between the fixed panel and jamb, minus 1/8" for thermal expansion is max dimension in the cavity a particular cap is to be installed).

- I. **Measure the distance between** the vent jamb and fixed panel to confirm the head cap is 1/8" under that dimension. If not, trim the cap to be 1/8" under the dimension.



- J. **Install the head cap.** Insert one end and apply pressure along the length of the cap to snap the cap into place.



## 6 Fixed Panel and Cap Installation (continued):

K. Install hole plugs in the roller adjustment holes.



## 7 OOX/XOO Fixed Panel Installation:

When installing OOX/XOO doors, the fixed panels will be installed differently than a simple XO/OX.

A. Install the fixed panel into the jamb pocket in the interior track with the interlock facing the exterior.

To secure the fixed panel, a fixed panel screw will need to be placed at the top and bottom of the panel in the frame leg into the mohair of the weatherstrip from the exterior looking in. This screw should be located about 1/2" from the edge of the panel so that the screw will be hidden from view behind the next fixed panel and so it won't be accessible from the exterior once the second fixed panel is installed.

B. Install the second fixed panel, this panel will be installed into the exterior track with the interlocks facing the interior. The interlock should not be fully engaged it should be roughly 1/8" off for thermal expansion.

Secure this panel in place with the fixed panel screws provided. Install one screw at the top and bottom about 1/2" from the pocket side fixed panel, in the mohair of the weatherstrip in the frame leg from the interior looking out. Install one screw at the top and bottom about 1/2" from the other end of the panel from the interior looking out.

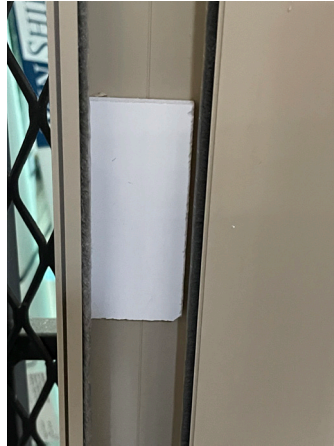
C. Install the primary panel and lock as noted on pages 5-6.

D. Apply sealant around the exterior perimeter of the interior most fixed panel where the fixed panel meets the frame. Tool the sealant as needed.



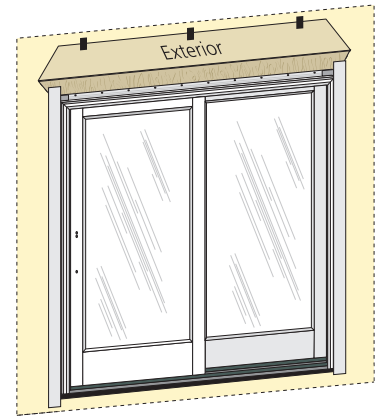
## 8 Adjusting Play in the Panels:

In some cases, there may be more play in the panels than needed. Keep in mind some play is necessary for thermal expansion. If the panels on any door are interlocking too tight there can be issues during different seasons resulting in damage to the frame or faulty operation. If there is more than 3/8" play between panels, remove the blocks installed in the fixed panel pocket. These blocks are held in place with silicone and are easy to remove. Make sure any install screws are pre-drilled and recessed into the frame so they do not interfere with the depth the panel will sit in the pocket. Removing these blocks will gain 1/4" travel.

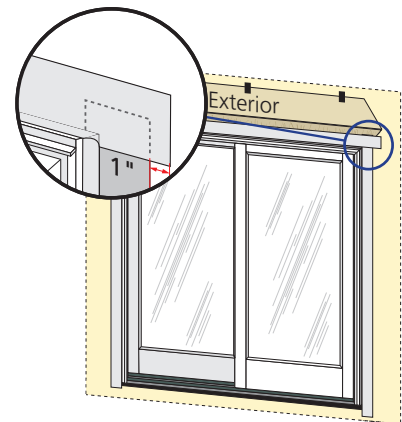


# 9 INTEGRATING WITH THE BUILDING WRAP:

- A. **Apply straight side flashing tape.** Cut two pieces of flashing tape 4" taller than straight sides. Apply tape over the fin and onto weather resistive barrier. Extend tape 2" above and below straight sides.



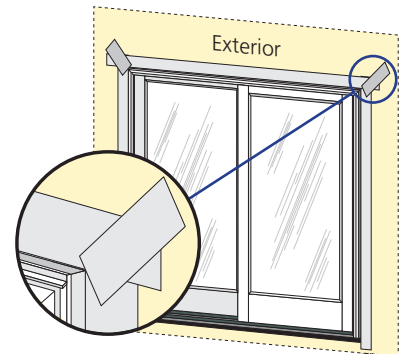
- B. **Apply top flashing tape.** Cut one piece of flashing tape to extend 1" past both side flashing tapes.



- C. **Fold down top flap of weather resistive barrier.**

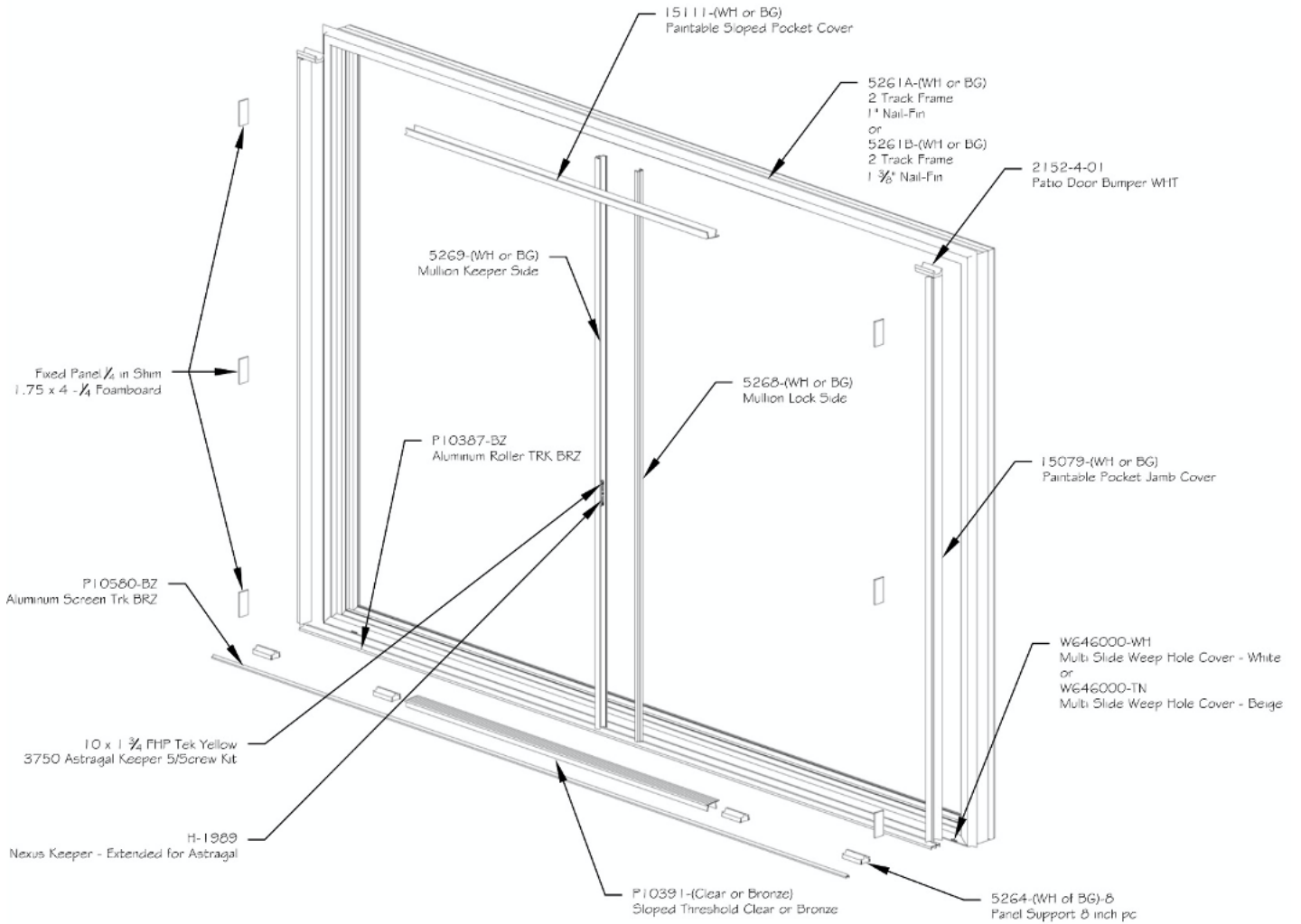
- D. **Apply flashing tape to top diagonal cuts.** Cut pieces of flashing tape at least 1" longer than each diagonal cut. Lap tape 1" past end of cut onto weather barrier. Overlap multiple pieces of tape by 1" when necessary.

**NOTICE** PRESS ALL FLASHING TAPE DOWN FIRMLY.

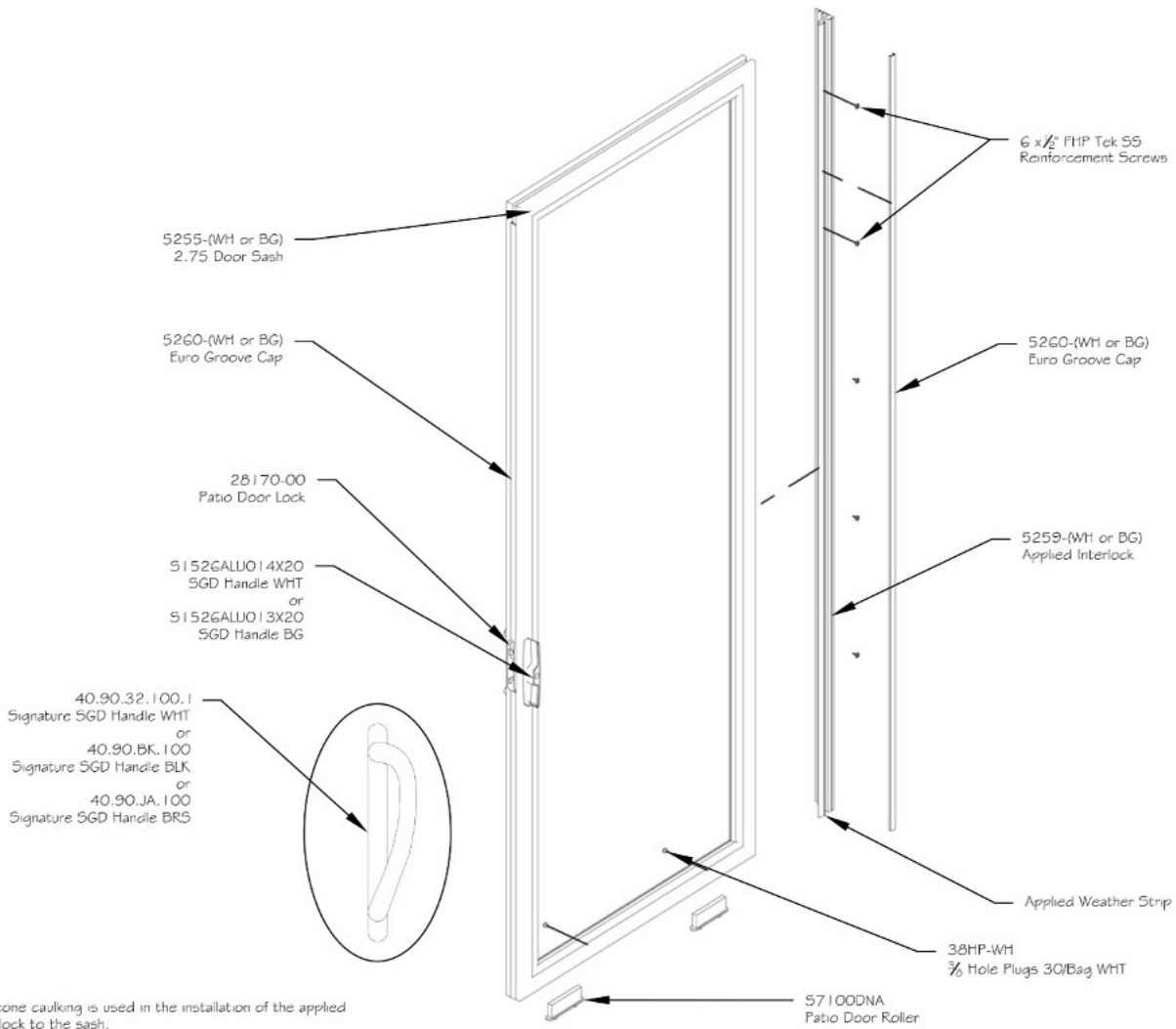


- E. **Install interior sealant.** Refer to the interior sealant instructions at the end of this booklet.
- F. **Install head flashing,** properly incorporating it with the siding and building wrap according to applicable code requirements.
- G. **Install exterior sealant.** (After wall cladding is installed.) Refer to the exterior sealant instructions at the end of this booklet.

# Frame-Exploded View:



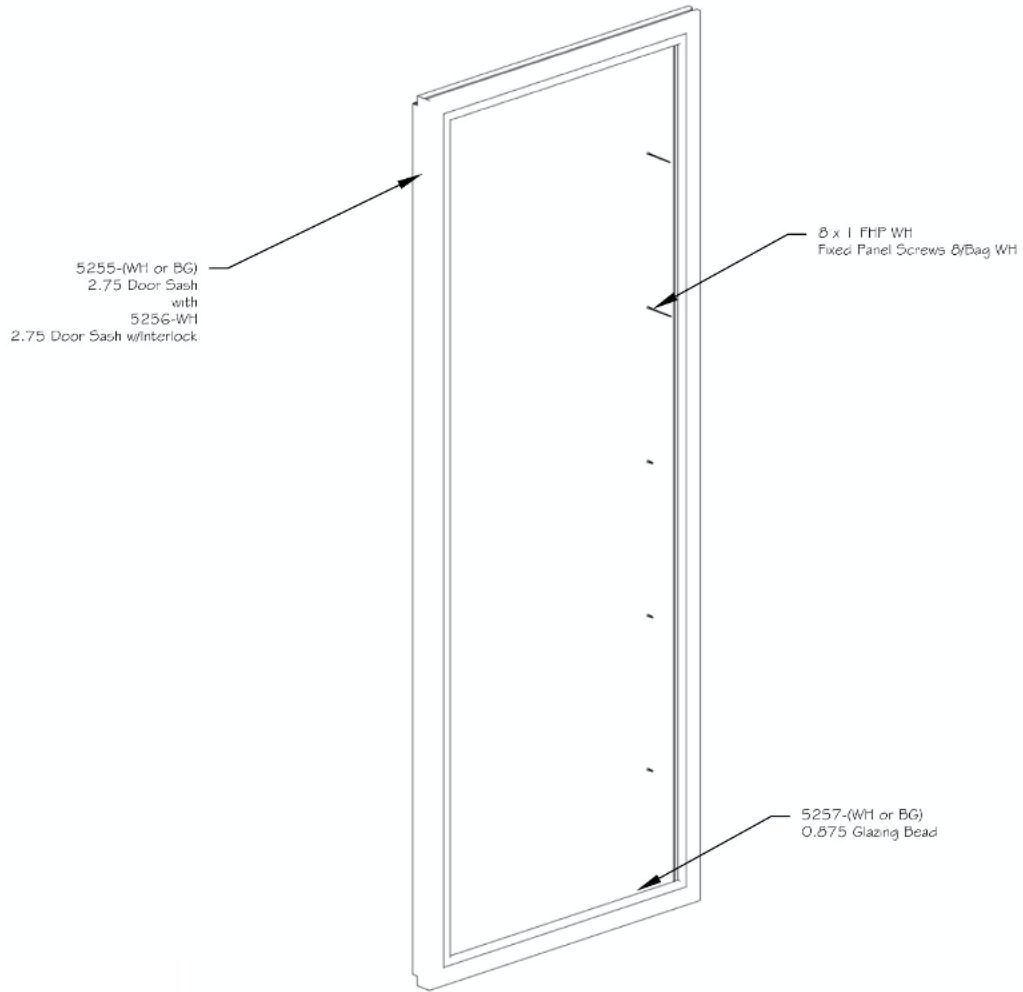
# Vent Panel-Exploded View:



\*Silicone caulking is used in the installation of the applied interlock to the sash.



# Fixed Panel—Exploded View:





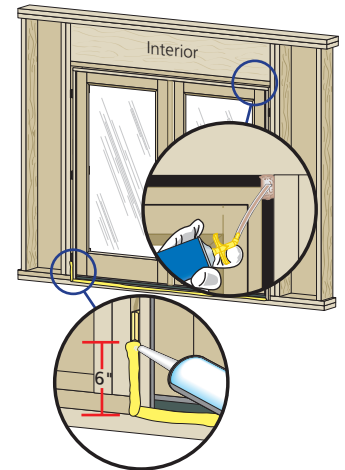
### Interior Sealant Instructions

**CAUTION:** Continuous backer rod (as necessary) and a high quality, low-odor interior sealant such as Pella Window and Door Installation Sealant (or equivalent) is recommended for commercial or high performance installations to create the continuous interior seal. Follow the directions on the cartridge. For standard performance or products with factory applied jamb extensions, use low pressure polyurethane insulating foams. Follow the directions on the can. Do not use high pressure or latex foams. Fiberglass batt or similar insulation is not recommended as it can absorb water and does not act as an air seal.

- A. Insert the nozzle or straw between the rough opening and door frame from the interior. Use pliers (if necessary) to compress the end of a straw tube to allow it to fit in tight openings.
- B. Place a 1" deep bead of foam approximately 1" from the interior of the frame to allow for expansion. DO NOT fill the entire depth of the rough opening cavity.

**NOTE:** Apply foam between the frame and rough opening, NOT between jamb extensions and the rough opening.

- C. Re-check door operation and remove remaining shipping spacers after foam installation. Excess foam may be removed with a serrated knife after it cures.
- D. To ensure a continuous interior seal, apply sealant over or around any shims or clips interrupting the foam seal.
- E. Place a continuous bead of sealant across the inner sill at the intersection of the door sill and subfloor. Continue the sealant 6" up each jamb.



### Exterior Sealant Instructions

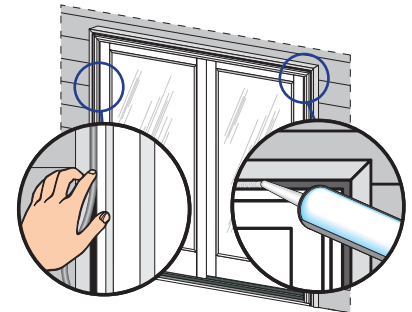
**CAUTION:** Use a high quality, multi-purpose exterior sealant such as Pella Window and Door Installation Sealant. Follow the directions on the cartridge.

When applying siding, brick veneer, flashing, or other exterior finish materials, leave adequate space between the door frame and the material for sealant application of sealant.

- A. Insert backer rod 3/8" deep in the space around the door. Backer rod adds shape and controls the depth of the sealant line.
- B. Apply a continuous bead of sealant to the entire perimeter of the door.

**NOTICE** For sill pans designed to drain moisture directly to the exterior, voids in the exterior seal may be required.

- C. Shape, tool and clean excess sealant. When finished, the sealant should be the shape of an hourglass.





## OPTIONAL SILL PAN INSTRUCTIONS

**NOTICE** The method of pan construction, flashing, and sealant application may vary depending on the design of the opening sill and exterior landing surface conditions. It is important to consider the exposure to weather, the exterior landing surface's proximity to the door sill, and to confirm impervious exterior surfaces properly slope away from the door.

A. Cut the sill pan to the width of the rough opening plus 2".

**NOTE: The 2" added onto the rough opening width is for a 1" bend on each end.**

B. Make a 1" cut in each fold at both end of the sill pan.

**NOTE: These cuts will allow the edges of the sill pan to be bent.**

C. Cut 1" off each end of the interior sill pan lip.

D. Bend each end of the center panel up.

E. Install the sill pan by sliding into place until the exterior sill pan lip is flush with the exterior of the rough opening.

F. Apply sill flashing tape. Cut a piece of flashing tape 2" longer than the opening width. Apply at the bottom of the opening, covering the exterior sill pan lip as shown.

**NOTE: If applicable, apply spray adhesive to building felt prior to applying the flashing tape.**

G. Cut a piece of flashing tape to the width of the opening. Install tape to the sill pan and overlap the flashing tape from step 1F by 1". If needed add a second or third piece of flashing tape until the sill pan is covered to the interior sill pan lip.

**NOTE: The purpose of this tape is to seal the sill screws when installing the door.**

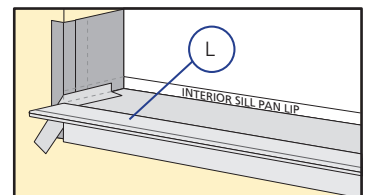
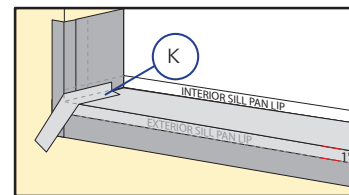
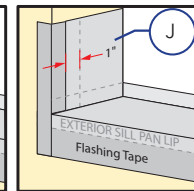
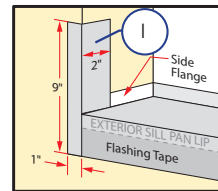
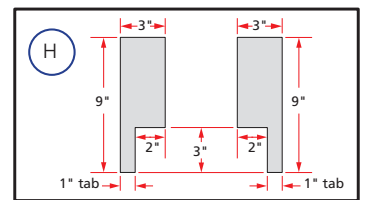
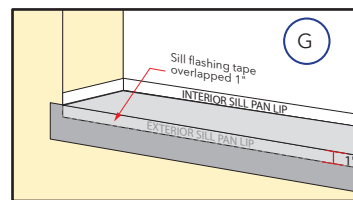
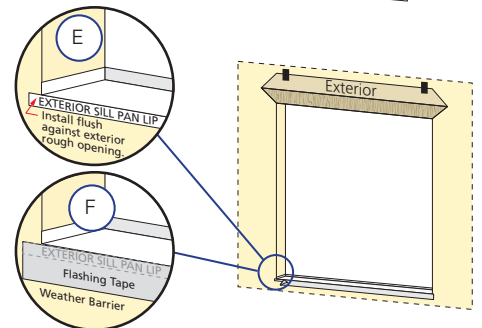
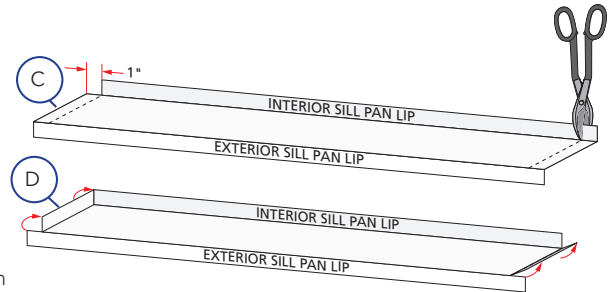
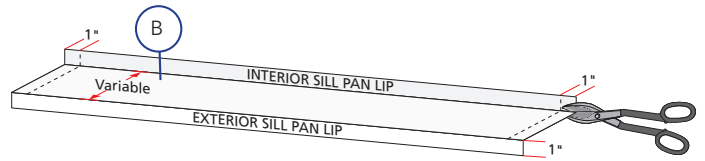
H. Cut two 9" pieces of flashing tape with a 1" x 3" tab at the bottom, on opposite corners as shown.

I. Apply the tabbed 9" pieces of flashing tape. The tape is applied so 2" will cover the inside of the rough opening and lap over the side flange of the sill pan. The 1" x 3" tab laps over the bottom flashing tape as shown.

J. Cut two 6" pieces of flashing tape and apply to each side of the rough opening, overlapping the first piece by 1" and lapping the bottom over the side flange of the sill pan as shown.

K. Cut two pieces of flashing tape 1-1/2" x 6" and apply to the bottom corners of the opening by beginning in the corner of the sill pan, with 3/4" of the tape applied to the sill pan and 3/4" of the tape applied to the side flange. The remainder of the tape is to be at a 45 degree angle onto the exterior.

L. Attach the aluminum sill support or wood blocking to the exterior of the box plate to support the edge of the door sill. Place the sill support flush with the subfloor.



### Concrete Slab (without sill pan) Instructions

**NOTE: Thoroughly clean the slab where sealants will be installed. Instead of installing flashing tape across the bottom of the rough opening, complete the following:**

- Install flashing tape at the bottom 6" of the rough opening jambs.
- Cut two 9" pieces of flashing tape as shown in step 1H above.
- Install them overlapping the flashing tape installed in step A by 1".
- Place a 3/8" bead of sealant where the bottom edge of the flashing tape meets the concrete slab.
- When folding building wrap in at the jambs, cut at a 30 degree angle as illustrated.

Follow the applicable installation method pages to complete the installation except seal the door sill directly to the slab.

