INSTALLATION INSTRUCTION - INSTRUCCIONES DE INSTALACION 350 SERIES SLIDING PATIO DOOR WITH PANELS SHIPPED OUT OF FRAME

Lea las instrucciones en español en el reverso.

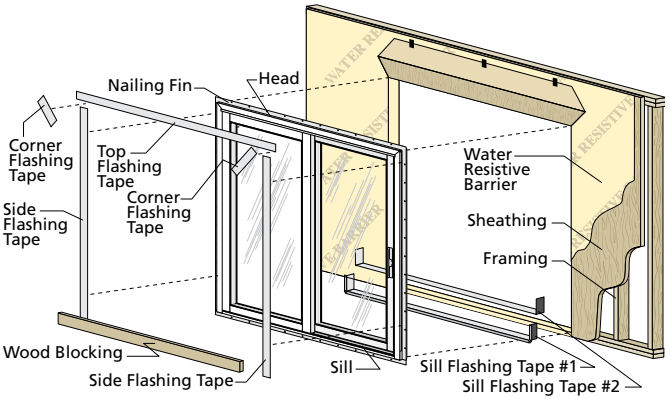
Table Of Contents

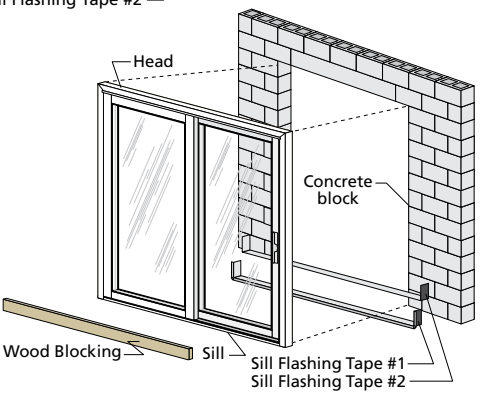
Installation Instructions for Typical Wood Frame Construction and Concrete Block Constructions. These instructions were developed and tested for use with typical wood frame wall and concrete block constructions in a wall system designed to manage water. **Installation details specific to replacement of Aluminum Sliding Doors in Hard Coat Stucco applications can be found at the end of this instruction.** These instructions are not to be used with any other construction method. Installation instructions for use with other construction methods or multiple units may be obtained from Pella Corporation or local Pella retailer. 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.

The performance of any building is dependent upon the design, installation, and workmanship of the entire building system. Pella Corporation strongly recommends consulting an experienced architect, contractor, or structural engineer prior to installation of Pella products. The individual (building owner, architect, contractor, installer and/or consumer) responsible for the project must take into account local conditions, building codes, inherent component limitations, the effects of aging and weathering on building components, and other design issues relevant to each project. The determination of the suitability of all building components for each project, as well as the design and installation of flashing and sealing systems, are the responsibility of the building owner, architect, contractor, installer and/or consumer.

Handling and Storage: Provide full support under the framework while storing, moving and installing the product. **DO NOT** lift the product by the head member only. Remove the plastic shipping material prior to storing or installing the product. **DO NOT** store in direct sunlight. Allow sufficient spacing between products for ventilation.

REMEMBER TO USE APPROPRIATE PERSONAL PROTECTIVE EQUIPMENT.





LIMITED LIFETIME WARRANTY

Always read the Vinyl Window and Door Limited Warranty before purchasing or installing Vinyl Windows and Doors manufactured by Pella Corporation. 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 Limited Warranty for complete details at ***http://warranty.pella.com***.

YOU WILL NEED TO SUPPLY:

- Cedar/impervious shims/spacers (24 to 40)
- 2" galvanized roofing nails (Nail-fin only) (1/4 lb.)
- #10 x 2" Pan Head Screws for wood construction (70-130)
- 1/4" x 2" masonry screws for concrete application (70-130)
- Closed cell foam backer rod/sealant backer (20 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 (2 to 3 tubes per door)
- Low expansion, low pressure polyurethane insulating window and door foam sealant - **DO NOT** use high pressure or latex foams.
- Pella aluminum sill support or 2 x 4 wood blocking
- Pella sill pan or equivalent
- Interior trim and/or jamb extensions (20 to 40 ft.)

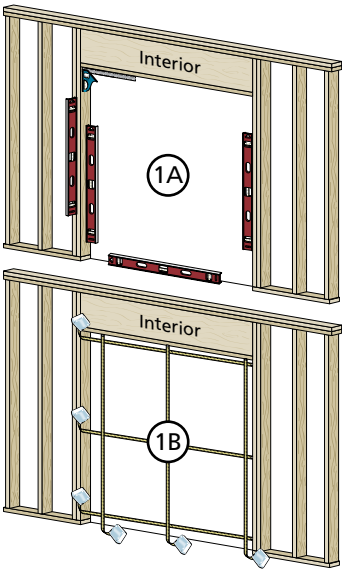
TOOLS REQUIRED:

- Tape measure
- Level
- Square
- Rubber Mallet
- Hammer
- Stapler
- Sealant gun
- Scissors or utility knife
- Screwdrivers (#2 Phillips with small flat blade)
- 3"-5" Wide putty knife
- Drill
- #2 Phillips driver
- 5/16" Socket driver

Installation will require two or more persons for safety reasons.

1 ROUGH OPENING PREPARATION

If replacing an aluminum sliding door in hardcoat stucco, see Step 10 Flush Flange Applications : Opening Preparation on page 16.



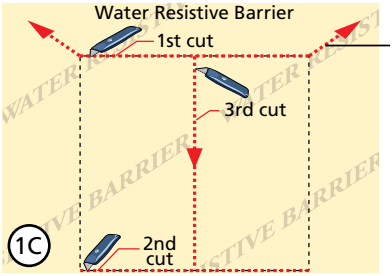
A. **Confirm the opening is plumb and level.** Ensure the bottom of the rough opening does not slope toward the interior.

Note: For peak water performance it is critical the bottom be level within +/- 1/16".

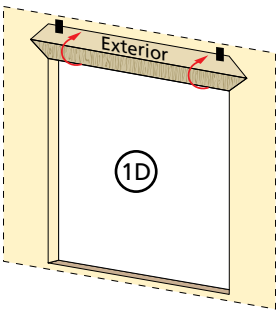
B. **Confirm the door will fit the opening.** Measure all four sides of the opening to make sure it is 1/2" larger than the door in width and height. Measure the width at the top, bottom, and center. Measure the height at the far left side, the far right side, and in the center.

Note: 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.

C. **Nail-fin only: Cut the water resistive barrier** (1C).



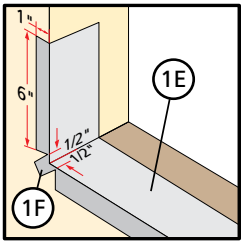
4th cut:
Make a 6" cut up from each top corner at a 45° angle to allow the water resistive barrier to be lapped over the fin at the head of the door.



D. **Nail-fin Only:** Fold the water resistive barrier (1D). Fold side flaps into the opening and staple to inside wall. Fold top flap up and temporarily fasten with flashing tape.

E. **Apply sill flashing tape #1.** Cut a piece of flashing tape 12" longer than the opening width. Apply at the bottom of the opening as shown (1E) so it overhangs 1" to the exterior.

Note: The tape is cut 12" longer than the width of the opening so that it will extend up each side approximately 6".

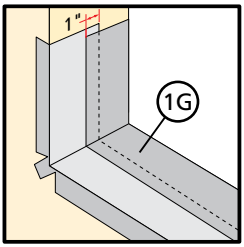


F. **Tab the sill flashing tape and fold.** Cut 1" wide tabs at each corner (1/2" from each side of corner) (1F). Fold tape to the exterior and press firmly to adhere it to the water resistive barrier.

1 ROUGH OPENING PREPARATION (CONTINUED)

G. **Apply sill flashing tape #2**. Cut a piece of flashing tape 12" longer than the opening width. Apply at the bottom, overlapping tape #1 by at least 1". **DO NOT** allow the tape to extend past the interior face of the framing (1G).

Note: The flashing tape does not need to extend all the way to the interior of the framing.



If using optional sill pan, see Step 12 Sill Pan Fabrication and Installation on page 21.

2 PREPARE THE DOOR FOR INSTALLATION

TWO OR MORE PEOPLE WILL BE REQUIRED TO HANDLE THE DOOR SAFELY

A. **Remove the packaging from the door.** Inspect the frame and panels for damage. **DO NOT** install damaged units.

Note: If screens or hardware are removed from the door at this time, label them and store them in a protected area.

3 SETTING AND FASTENING THE DOOR

TWO OR MORE PEOPLE WILL BE REQUIRED TO HANDLE THE PANEL SAFELY

If installing in a block replacement or a concrete floor, go to Step 3A to remove the bottom fin. If NOT removing the bottom fin go to Step B.

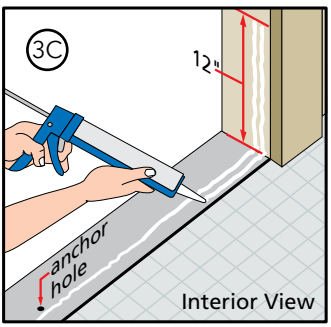
A. **To remove the bottom fin,** lay the door down with the interior facing up. With a utility knife, carefully score the entire length of the fin three times where it meets the sill. Bend the fin back and forth a few times, then peel the fin off.

Note: Keep the body of the knife against the frame to prevent gouging the sill.

B. **Dry fit the door.** Make sure the door is plumb, square and level. Drill anchor locations with 1/8" masonry bit. Mark the interior of the door frame at the sill to show a boundary for sealant placement. Carefully remove and set the door aside.

C. **Apply two continuous 1/4" to 3/8" diameter beads of sealant** across the sill of the opening and 12" up the jambs, towards the interior side of the door (between the anchor holes and interior edge of door). **DO NOT** apply sealant between the anchor holes and the exterior side of the sill plate or floor.

Note: Failure to properly seal the sill attachment screws and sill plate may allow water to penetrate the interior of the home.



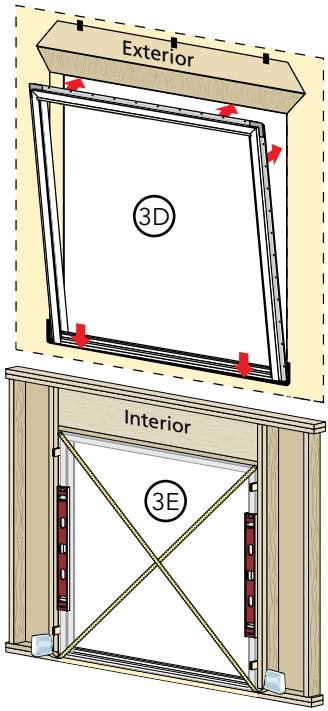
3 SETTING AND FASTENING THE DOOR (CONTINUED)

D. **Insert the door from the exterior of the building.** Place the bottom of the door at the bottom of the opening, then tilt the top into position. Center the door between the sides to allow equal clearance for shimming. Make sure the door is plumb, level and square.

Door Frames with Nail Fin: Insert one 2" galvanized roofing nail into the top of each jamb nailing fin.

Door Frames without Nail Fin: Insert one screw in the top hole of each jamb.

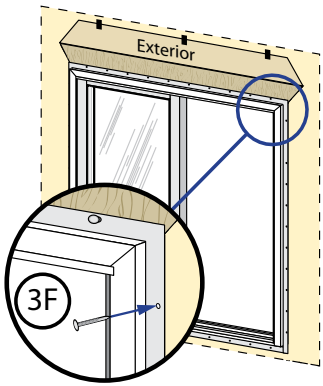
Note: When installing doors without a bottom fin, DO NOT slide the bottom of the door into the opening, as sliding will damage the sealant lines. Insert sill anchor screws prior to shimming.



E. **Plumb and square the door.** Insert shims at the jambs between the door and the sides of the rough opening. Place shims behind each of the pre-drilled installation holes. **DO NOT** place shims at the sill. **DO NOT** place shims at the head until Step 4I.

F. **Fasten the door to the opening:**

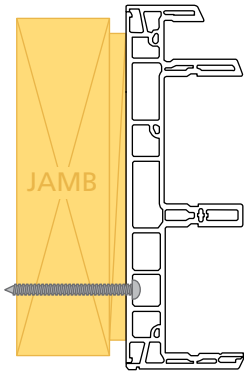
Door Frames with Nail Fin Only: Insert one 2" galvanized roofing nail into every other pre-punched hole in the nailing fin. **DO NOT FASTEN THE HEAD UNTIL IT IS VERIFIED THE PANELS WILL FIT IN THE FRAME. GREATER THAN 1/16" OF HEAD SAG WILL PREVENT THE PANELS FROM FITTING INTO THE FRAME.**



3 SETTING AND FASTENING THE DOOR (CONTINUED)

All Frame Types:

Jambs: At each pre-drilled installation hole, drill 1/8" pilot holes through the outer frame wall, shims and the rough opening. Drive #10 x 2" corrosion resistant pan head screws (wood rough openings) or 1/4" x 2" masonry screws (masonry rough openings) into each pre-drilled hole.



Sill: Place a dab of sealant in each pre-drilled hole in the sill prior to installing the sill screws. Place a #10 rubber washer on each sill screw. Drive the screw until the head contacts the frame, however **DO NOT** sink the head.

Note: At the sill, it is imperative that sealant be applied under the screw heads and that it surrounds them to prevent water leakage. Failure to properly seal the sill attachment screws may allow water to penetrate the interior of the home.

Head: DO NOT FASATEN THE HEAD UNTIL STEP 4I.

4 DOOR ASSEMBLY AND ASSEMBLY VIEWS

Installation from interior - all directional references are "As viewed from the interior".

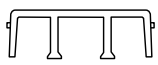
Parts to be assembled in door frame in order as listed below:

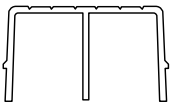
Note: Provided parts may be labeled with letters as indicated below.

2-PANEL (OX/XO)

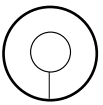
A - Spacer Block
B - Fixed Panel Riser
C - Fixed Panel
D - Threshold / Pocket Cover
E - Interlock End Seals
F - Snap Interlocker
G - Panel Track
H - Panel Bumper
  * Frame screws in head
I - Vent Panel
J - Fixed Panel Screws
K - Anti-Lift Clips
  * Hardware/fasteners

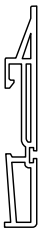
CROSS SECTIONS


B - Fixed Panel Riser


D - Threshold/Pocket Cover

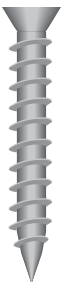

A - Spacer Block
K - Anti-Lift Clips


H - Panel Bumper


F - Snap Interlocker


E - Interlocker End Seal

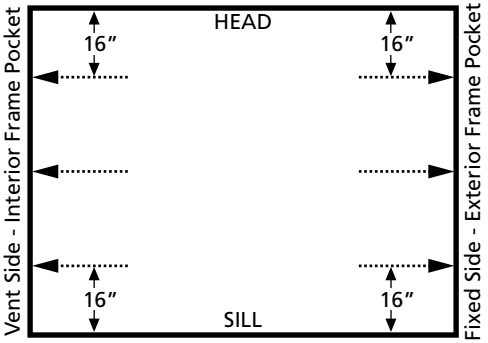

G - Panel Track

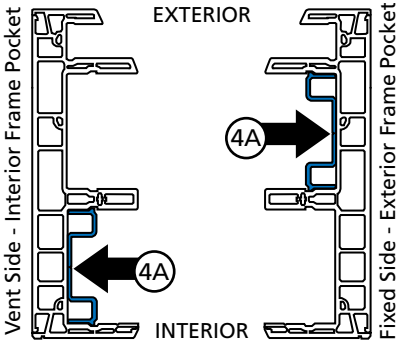

J - Fixed Panel Screw, 1-1/2" (Approximate Size)


* - Frame Installation Screw, 2" (Approximate Size)

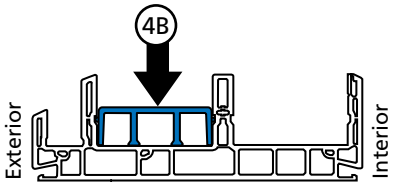
4 DOOR ASSEMBLY AND ASSEMBLY VIEWS (CONTINUED)

A. **Install spacer blocks.** Insert three spacer blocks in the jamb of each frame pocket that will contact a panel. Space the blocks as illustrated in the graphic below.



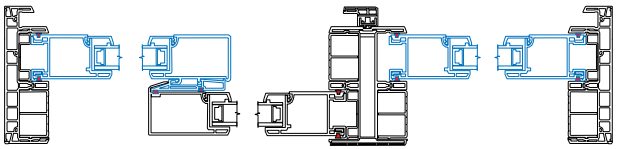


B. **Install fixed panel riser.** Install the fixed panel riser in the exterior sill panel pocket where the fixed panel(s) will be located. Make sure the riser does not block the weep holes.



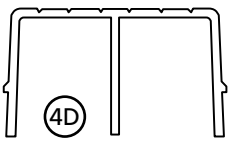
C. **Install fixed panel(s).** Slide the fixed panel into the exterior pocket so the weather strip faces the frame jamb. The panel glazing stop (bead) faces the exterior.

For 3-panel (OXO) panel with interlocker is located on the left side (as viewed from the interior).



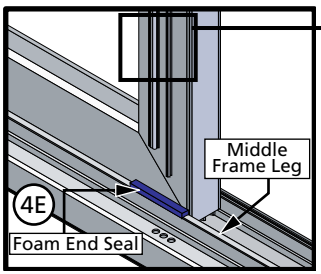
D. **Install the thresholds.** Make sure the fixed panel is pushed tight into the jamb pocket.

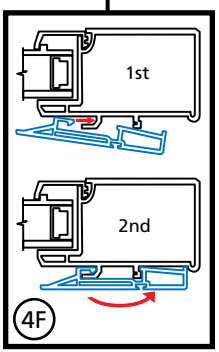
Note: Thresholds have mitered ends, install in head and sill of the exterior frame pocket.



E. **Place the foam end seals** against the panel at the bottom (sill) and top (head) of the interior of the fixed panel as shown.

Note: Remove adhesive release paper and adhere to the top of the middle frame leg.



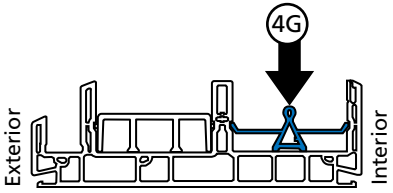


F. **Install the snap on interlocker(s).** Place one end of the snap on interlocker on the foam pad at the sill and one against the foam pad at the head. Starting at the end, use a rubber mallet to snap the interlocker in place in the order as shown.

4 DOOR ASSEMBLY AND ASSEMBLY VIEWS (CONTINUED)

G. **Install the panel track.** Clean the pocket of any debris and snap the track into the interior panel pocket.

Note: For 3-panel (OXO) door - verify the panel track is installed on the left end of the pocket as viewed from the interior.

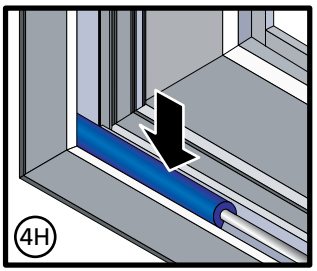


H. **Install the panel bumpers.** Locate the slit on the bumper(s) and place it on the track. Press down to seat the bumper onto the panel track cap.

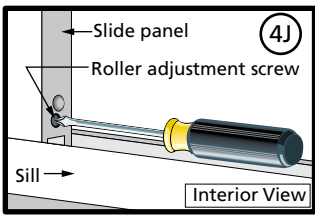
I. **Shim and fasten the frame head.**

Use vertical support brace (provided and labeled) to gauge head height.

Note: Fasten as described in Step 3F.

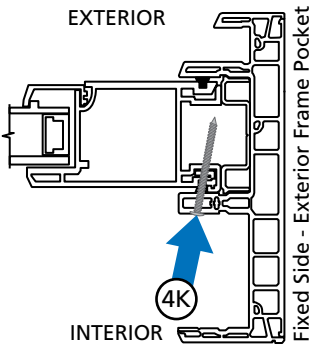


J. **Install the vent panel(s).** Rollers will need to be raised to clear the frame. After the panel is installed adjust the rollers for equal reveal on the top and bottom panel rails. A wide putty knife may be needed to raise rollers above the sill when installing panel.



K. **Secure the fixed panel(s)** by driving in the #10 x 1-1/2" fixed panel screws. Install the screws from the interior at an angle as shown. Space one screw 16" from the top and one 16" from the bottom then one screw in the center.

L. **Open the vent panel(s) and install the two spacer blocks** (anti-lift clips) over each panel.



If installing 2-panel door proceed to Step 6, Lock Keeper, Pocket Cover and Screen Track Installation.

5 ASTRAGAL INSTALLATION (3-PANEL OXO AND 4-PANEL OXXO DOORS ONLY)

Parts to be assembled in the door frame in the order as listed below:

Note: Provide parts may be labeled with letters as indicated below.

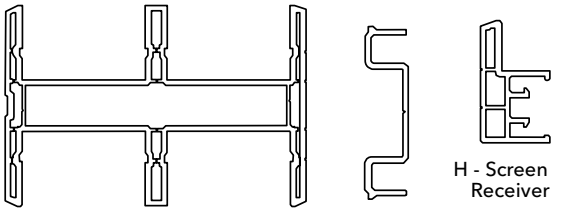
3-PANEL (OXO)

A - (Process Step)
B - Astragal
C - (Process Step)
D - Spacer Blocks
E - (Process Step)
F - Astragal Fasteners
G - Astragal Brackets and Screws
H - Screen Receiver (optional)

4-PANEL (OXXO)

I - (Process Step)
J - Astragal
K - Spacer Blocks
L - (Process Step)
M - (Process Step)
N - Astragal Screws
O - Screen Stop and Screws

CROSS SECTIONS

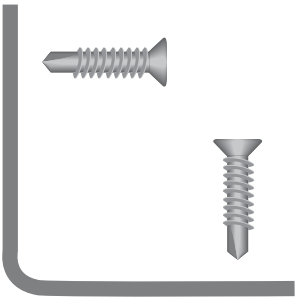


A and J - Astragal

D and H - Spacer Block

H - Screen Receiver

F and N - Astragal Fasteners, 3" (Approximate Size)



G - Astral Brackets and Screws, 5/8" (Approximate Size)

O - Screen Stop and Screws, 5/8" (Approximate Size)

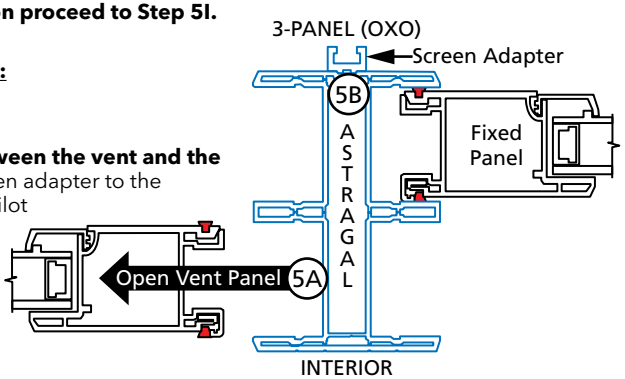
4-Panel (OXXO) configuration proceed to Step 5I.

3-Panel (OXO) configuration:

A. **Open the vent panel.**

B. **Position the astragal between the vent and the fixed panels** with the screen adapter to the exterior. The lock keeper pilot holes are adjacent to the vent panel.

Note: The pocket with the keeper/strike pilot holes should be adjacent to the vent panel with the lock.

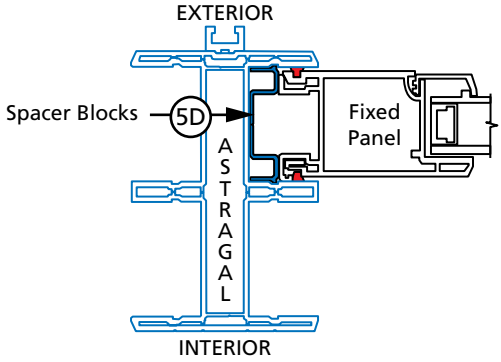


C. **Insert the bottom to the astragal between the panel track and the fixed panel.**

5 ASTRAGAL INSTALLATION (3-PANEL OXO AND 4-PANEL OXXO DOORS ONLY) (CONTINUED)

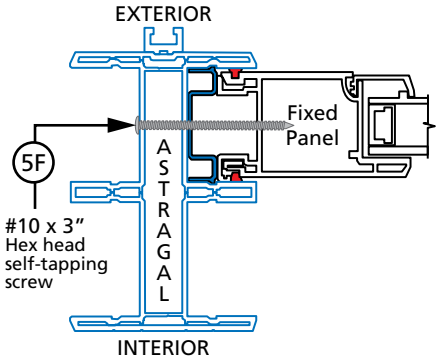
D. **Place three spacer blocks** into the exterior pocket of the astragal where it will meet the fixed panel. Position the spacer blocks 16" from the top and bottom and one at the center along the height of the astragal.

E. **Tilt the astragal into place** against the fixed panel.

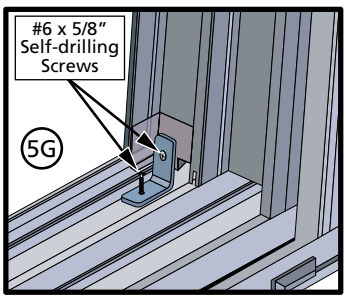


F. **Secure the astragal** by fastening to the fixed panel using three #10 x 3" hex head self-tapping screws (provided). Place the fasteners at the same place the spacer blocks were installed.

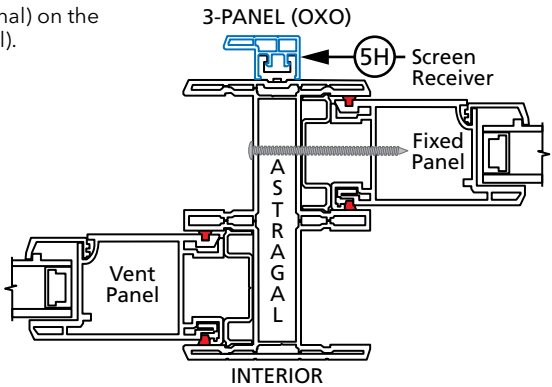
Note: Astragal and panel have metal reinforcement.



G. **Attach the astragal brackets** to the interior pockets at the head and sill. Use the #6 x 5/8" self-drilling screw to attach the bracket to the right side of the astragal as shown in the image. Align the astragal so it is flush with the frame and secure the bracket to the sill using the screw. DO NOT use longer than 5/8" screw in the sill. A longer screw will allow water to penetrate the building.



H. **Install the screen receiver** (optional) on the screen bracket (exterior of astragal).



4-Panel (OXXO) configuration:

I. **Open the vent panels.**

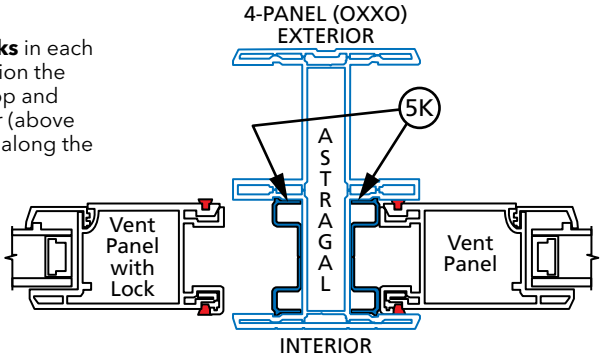
J. **Position the astragal** next to the panel that does not have a lock installed.

Note: The pocket with the keeper/strike pilot holes should be adjacent to the vent panel with the lock.

5 ASTRAGAL INSTALLATION (3-PANEL OXO AND 4-PANEL OXXO DOORS ONLY) (CONTINUED)

K. **Place the three spacer blocks** in each interior astragal pocket. Position the spacer blocks 16" from the top and bottom and one at the center (above the pre-drilled keeper holes) along the height of the astragal.

L. **Tilt the astragal into the vertical position.**

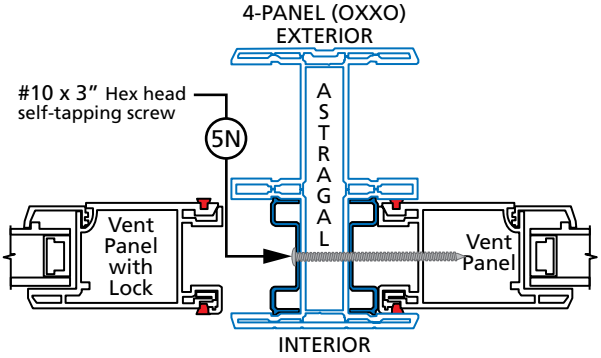


M. **Provide sliding clearance for the astragal** by centering it between the head and sill. Shim the astragal up for equal spacing at the head and sill.

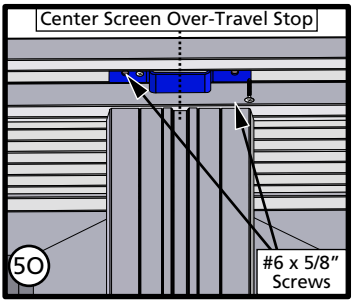
Note: Check the panel reveal to make sure the astragal is completely attached before securing.

N. **Secure the astragal** by fastening to the non-locking vent panel using three #10 x 3" self-tapping screws (provided). Place the fasteners at the same place the spacer blocks were installed.

Note: Astragal and panel have metal reinforcement.



O. **Install the screen over-travel** in the head and sill of the screen pocket. Center the screen stop with the center of the astragal with the vent panels in the closed position. Use #6 x 5/8" screws to attach the screen stop.

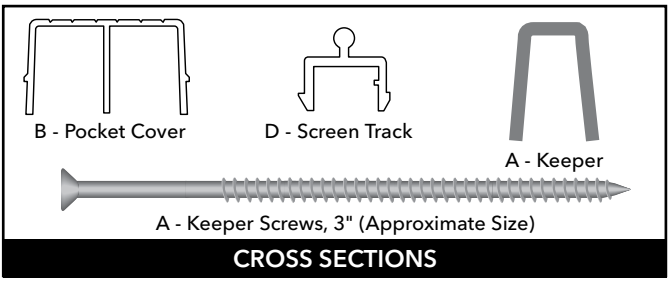


6 LOCK KEEPER/STRIKE, POCKET COVER AND SCREEN TRACK INSTALLATION

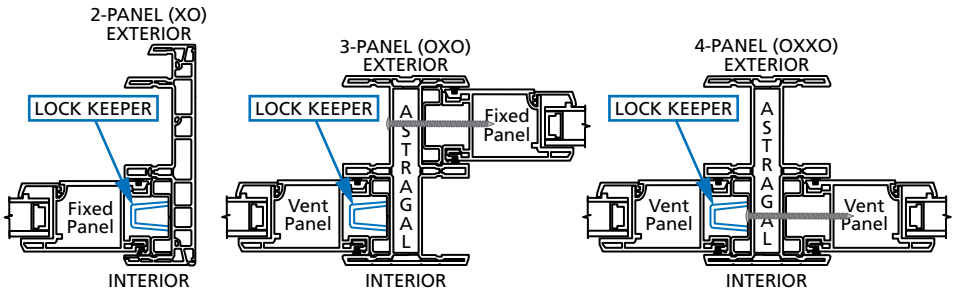
Parts to be assembled in door frame in order as listed below:

Note: Provided parts may be labeled with letters as indicated below.

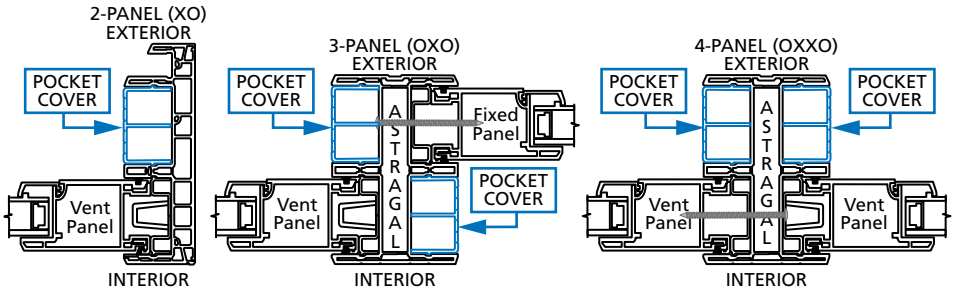
A - Keeper and Screws
B - Pocket Covers
C - Weep Hoods
D - Screen Track



A. **Install the lock keeper/strike.** Position the keeper/strike at the pre-drilled pilot holes. Insert a shim between the frame jamb and rough opening at the keeper/strike location. Fasten using #10 x 3" screws (provided).

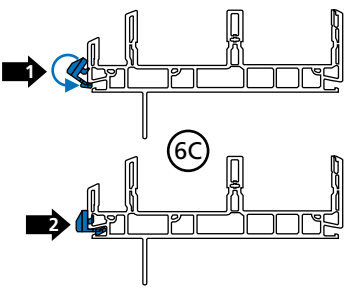


B. **Install the pocket covers** in all exposed jamb and astragal pockets. **DO NOT** install where the keeper is installed. The 3-panel (OXO) frame will have pocket covers for the head and sill on the right side of the astragal (as viewed from the interior).



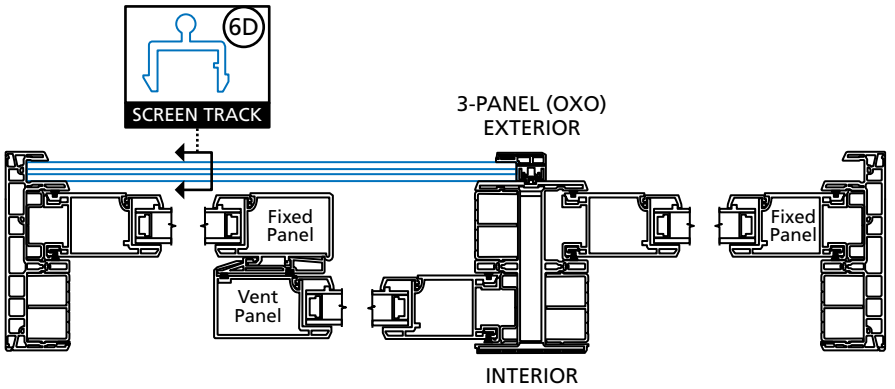
C. **Install the weep hoods** in the weep slots on the sill. Place the top of the weep hood against the sill then swing the bottom into the latched position.

Note: The screen track ends do not need weep hoods. This is where the screen track weeps.



6 LOCK KEEPER/STRIKE, POCKET COVER AND SCREEN TRACK INSTALLATION (CONTINUED)

D. **3-panel (OXO): Install the screen track** against the left jamb (as viewed from the interior).

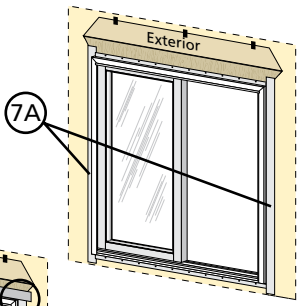


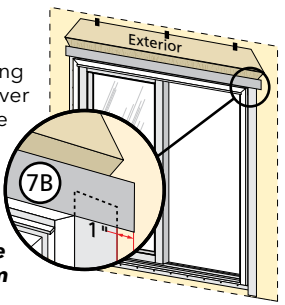
7 INTEGRATING THE DOOR TO THE WATER RESISTIVE BARRIER

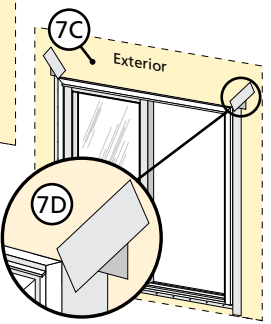
A. **Apply the side flashing tape.** Cut two pieces of flashing tape 4" longer than the frame height of the door. Apply one piece to each side over the nailing fin and onto the water resistive barrier. The tape should extend 2" above the top of the door and 2" below the bottom of the door. Press the tape down firmly.

B. **Apply the top flashing tape.** Cut a piece of flashing tape long enough to go across the top of the door and extend at least 1" past the side flashing tape on both sides. Apply the tape over the top nailing fin as shown. Press the tape down firmly.

Note: The tape should cover the entire nailing fin, but not extend onto the door frame. The top flashing tape must overlap the side flashing tape to prevent water from getting behind it.





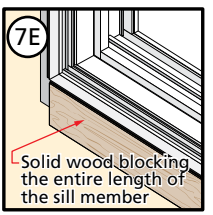


C. **Fold down the top flap** of the water resistive barrier.

D. **Apply flashing tape to the diagonal cuts.** Cut pieces of flashing tape at least 1" longer than the diagonal cuts in the water resistive barrier. Apply the tape, covering the entire diagonal cut in the water resistive barrier at both upper corners of the door. Press the tape down firmly.

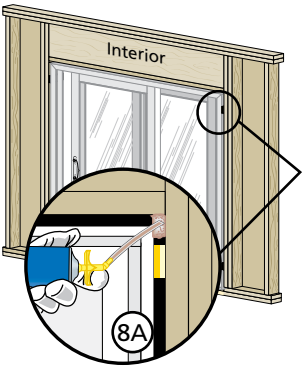
Note: Be sure to overlap the top corners.

E. **Attach wood blocking or aluminum sill support** to the exterior of the opening to support the edge of the door sill.



8 INTERIOR SEAL

Caution: Ensure use of low pressure polyurethane window and door insulating foams and strictly follow the foam manufacturer's recommendations for application. Use of high pressure foams or improper application of the foam may cause the door frame to bow and hinder operation.



A. **Apply insulating foam sealant.** From the interior, insert the nozzle of the applicator approximately 1" deep into the space between the door and the rough opening and apply a 1" deep bead of foam. This will allow room for expansion of the foam and will minimize squeeze out. If using foam other than Great Stuff ™ Window and Door Insulating Foam Sealant by the Dow Chemical Company, allow the foam to cure completely (usually 8 to 24 hours) before proceeding to the next step.

   Note: It may be necessary to squeeze the end of the tube with pliers to be able to insert into the space between the door frame and the rough opening. DO NOT completely fill the space from the back of the fin to the interior face of the door.

B. **On the interior, seal the door sill to the floor** with a corner bead of sealant. Connect this bead of sealant to the insulating foam at both door jambs.

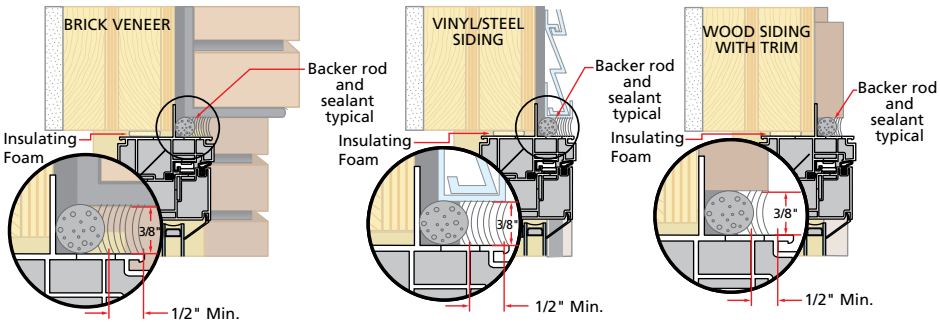
C. **Check the door operation** by opening and closing the door.

   Note: If the door does not operate correctly, check to make sure it is still plumb, level, square and the sides are not bowed. If adjustments are required, remove the foam with a serrated knife. Adjust the shims, and reapply the insulating foam sealant.

9 SEALING THE DOOR TO THE EXTERIOR WALL CLADDING

NAIL-FIN FRAME:

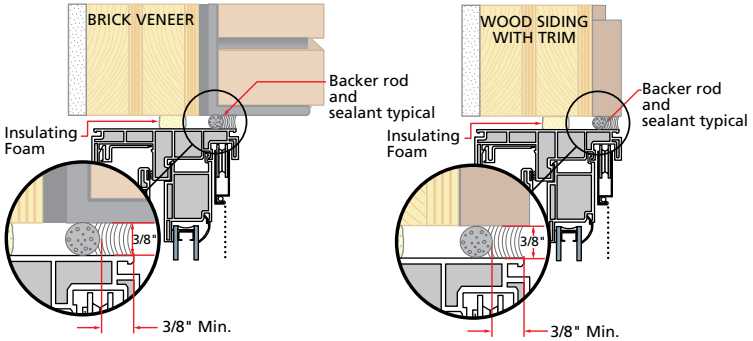
Note: When applying siding, brick veneer or other exterior finish materials, leave adequate space between the door frame and the material for sealant. Refer to the illustration that corresponds to your finish material. Not allowing adequate space or not using backer rod may cause the sealant to break down prematurely and allow water to infiltrate.



9 SEALING THE DOOR TO THE EXTERIOR WALL CLADDING (CONTINUED)

REPLACEMENT FRAME:

Note: When applying siding, brick veneer or other exterior finish materials, leave adequate space between the door frame and the material for sealant. Refer to the illustration that corresponds to your finish material. Not allowing adequate space or not using backer rod may cause the sealant to break down prematurely and allow water to infiltrate.



NAIL-FIN FRAME AND REPLACEMENT FRAME:

A. **Insert closed cell foam backer rod** into the space around the door approximately 1/2". This should provide at least a 1/2" clearance between the backer rod and the exterior face of the door.

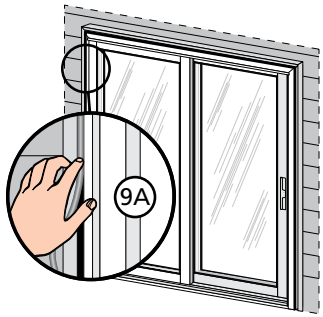
B. **Apply a bead of high quality exterior grade sealant** to the entire perimeter of the door. On doors where the bottom fin has been removed, insert sealant into the spaces between the bottom of the door and the sill support and connect it to the perimeter sealant.

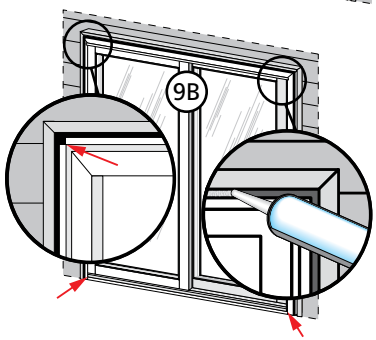
Note: Refer to the sealant manufacturer's label to verify compatibility with vinyl and the adjoining building components and priming requirements.

C. **Seal the exterior drainage weeps at the head only** with high quality exterior grade sealant. DO NOT seal the drainage weeps at the sill.

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

Note: This method creates a more flexible sealant line capable of expanding and contracting.

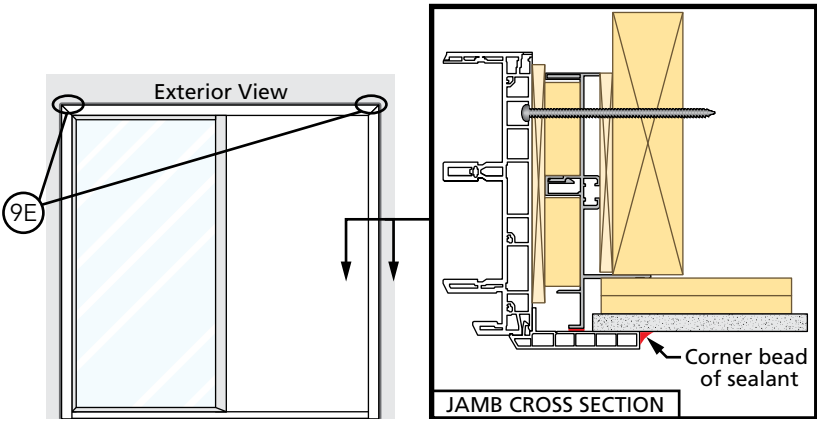




9 SEALING THE DOOR TO THE EXTERIOR WALL CLADDING (CONTINUED)

FLUSH FLANGE FRAME:

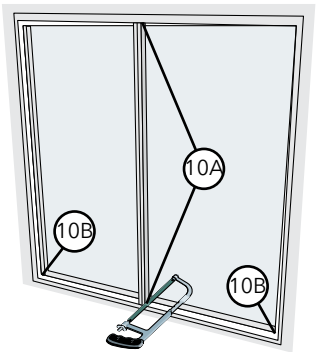
E. **Place a corner bead of sealant** on the edge of the door flush flange on top and sides. **DO NOT** seal the sill of the door frame to the opening.



10 FLUSH FLANGE OPENING PREPARATION

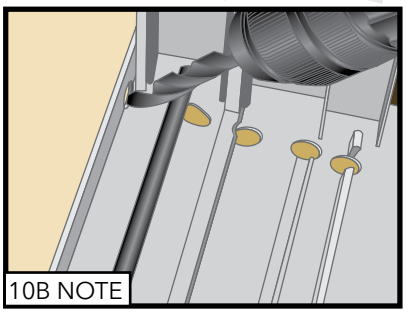
A. **Prepare the door opening** by removing the venting panel and the glass from the existing fixed side of the aluminum door frame.

Note: It may be necessary to cut the divider between the venting panel and fixed glass areas with a hacksaw. The existing aluminum frame is left in place so as not to disturb the existing exterior stucco flashing or drainage system.



B. **Cut the existing door sill out of the opening.** Using a hacksaw or side grinder, cut the existing sill as close to the longest leg of the jamb extrusion as possible.

Note: Be careful to avoid damage to the interior flooring materials. Drilling holes in the sill prior to cutting may make the removal of the existing sill easier. If existing sill has a stainless steel cap on the sill, removing the cap prior to cutting will make cutting easier.



10 FLUSH FLANGE OPENING PREPARATION (CONTINUED)

C. **Clean old sealant and other debris** from the door opening.

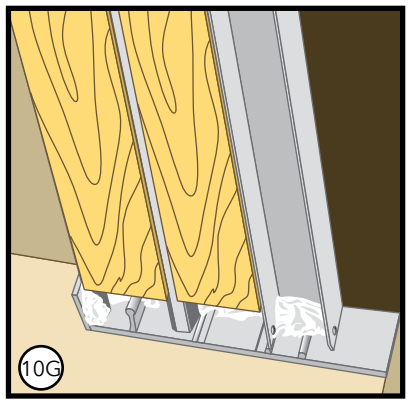
D. **Remove the door lock strike** from the lock jamb of the existing door frame.

E. **Place a bead of sealant at each joint** where the existing door frame jambs meet the existing door sill pieces. Fill any holes in the jamb and head with sealant.

F. **If the weep holes of the existing sill have been cut away, drill new weep holes** in the existing door jambs. Be sure to drill weep holes in all vertical jamb legs, except the most interior leg.

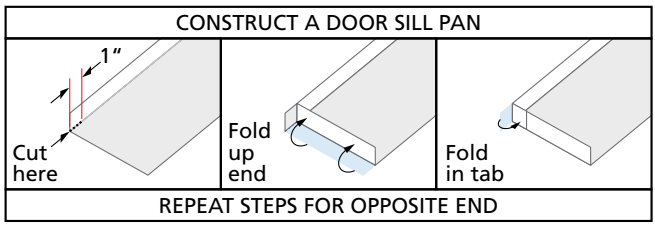
Note: Ensure that all new or existing weep holes are open before proceeding with the installation.

G. **Cut wood blocking to fill the vent and fixed panel cavities** in the head and jamb of the existing door frame. The depth of the blocking should be the same height as the tallest leg of the existing jamb extrusion. Cut the head blocking to fill the entire length of the head in both channels. Cut the jamb blocking to fill both jamb channels to within approximately 1" of the bottom of the jamb.



H. Install the wood blocking in the head existing door frame. Place a 3/16" bead of sealant in the door panel cavities, then insert the wood blocking into the head cavities. Next insert the wood blocking into the jamb panel cavities of the existing door frame.

I. **Construct a door sill pan for the door**. Measure the distance between the cut ends of the existing door sill and add 2". Measure 1" from each end and cut through the vertical leg of the pan material. Bend bottom flaps of the pan material up, then bend the back leg around the end of the pan.



TWO OR MORE PERSONS ARE REQUIRED FOR THE FOLLOWING STEPS.

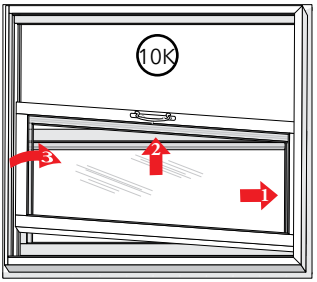
J. **Remove the packaging from the door.** Inspect the frame and panels for damage. **DO NOT** install damaged units.

Note: If screens or hardware are removed from the door at this time, label them and store them in a protected area.

10 FLUSH FLANGE OPENING PREPARATION (CONTINUED)

K. **Remove the panel(s).** With the jamb side of the door down, slide each panel all the way to the right or left, while lifting the panel out to the bottom frame pocket, swing the panel out of the frame.

Note: Door may have fixed panel fully installed. If so, remove the vent panel only.



Interior View

L. **Dry fit the sill pan and the door** into the opening.

Note: If the new door frame is deeper than the existing door frame, it will be necessary to cut the interior flooring material back to allow the door flush flanges to contact the existing aluminum door frame.

M. **From the exterior, set the door into the opening.** Set the sill of the door on the sill pan and tilt the door into position.

N. **Insert shims around the door temporarily** while you verify that the door will fit into the opening and that the door flanges will overlap the stucco or existing aluminum door frame by a minimum of 3/4" on all sides.

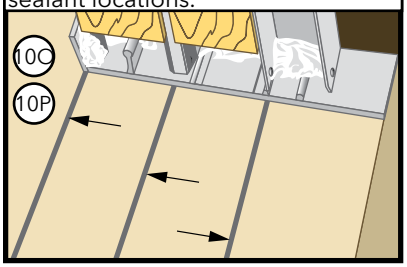
Note: Fix any problems with the opening before proceeding.

O. **Using a pencil, mark the interior and exterior edges of the sill pan** on the sill of the rough opening. Remove the door and sill pan.

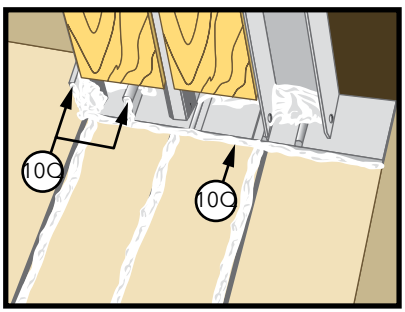
P. **Place a 1/4" diameter bead of sealant in the following locations:**

- The exterior side of the interior pencil mark.
- The interior side of the exterior pencil mark.
- Midway between the exterior and interior sealant beads.

Sealant Placement, arrows indicate sealant locations.



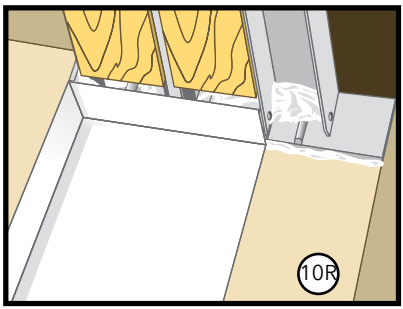
Q. **Place a bead of sealant across the ends of the three sealant beads**, connecting the three beads and sealing the exposed ends of the existing aluminum sill. Also place a bead of sealant on the vertical legs of the existing sill.



10 FLUSH FLANGE OPENING PREPARATION (CONTINUED)

R. **Install the sill pan** into the opening, aligning the interior and exterior edges with the pencil marks from Step O. Press down on the sill pan to seal it into the opening.

S. **Check all visible sealant lines for voids** and fill any voids with sealant.

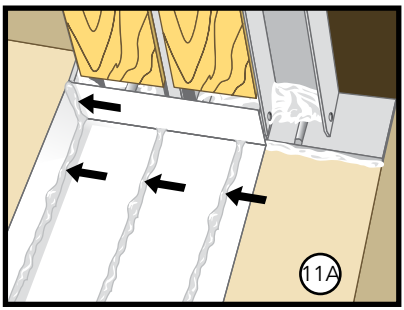


11 SETTING AND FASTENING THE DOOR IN FLUSH FLANGE APPLICATIONS

A. **Place one 1/4" diameter bead of sealant in the following locations:**

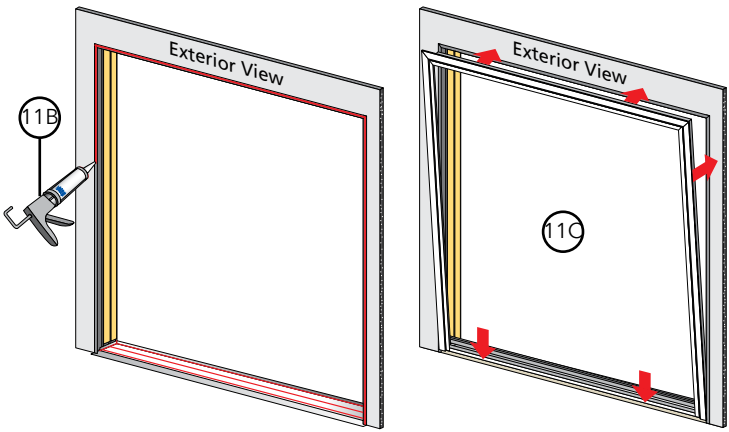
- In the bend at the back of the sill pan.
- 1/2" from the exterior edge of the sill pan.
- Midway between the interior and exterior beads of sealant.

Also seal the joint between the back and side legs of the sill pan with sealant.



B. **Place a 1/4" diameter continuous bead of sealant** on the face of the existing door frame jambs and head.

C. **From the exterior, set the door into the opening.** Set the sill of the door onto the sill pan and tilt the door into position, centering it in the opening. **DO NOT** slide the door on the sill pan.

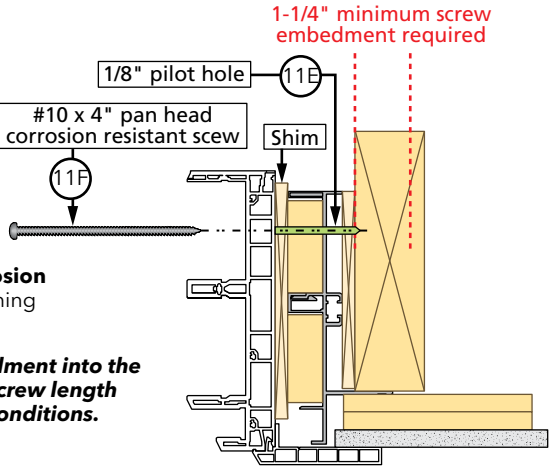


11 SETTING AND FASTENING THE DOOR IN FLUSH FLANGE APPLICATIONS (CONTINUED)

D. **Insert shims** between the door and the sides of the opening at the top two anchor hole locations in the door.

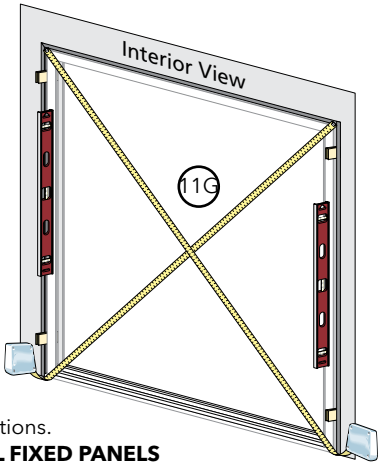
Note: Keep the exterior of the door pressed against the existing door frame to ensure a good sealant line.

E. **At the top pre-drilled installation hole of each jamb, drill a 1/8" pilot hole** through the frame shims, wood blocking and aluminum door frame.



F. **Drive a #10 x 4" pan head corrosion resistant screw** through the opening at the installation hole locations.

***Note: A minimum of 1-1/4" embedment into the wood blocking is required. Adjust screw length accordingly based on the existing conditions.**



G. **Plumb and square the door.** Insert shims between the new door frame and the existing door frame at the pre-drilled anchor hole locations in the door jambs. **DO NOT SHIM THE HEAD UNTIL ALL FIXED PANELS ARE INSTALLED.** Move the door in the opening until the flanges are tight against the existing aluminum door frame.

Note: DO NOT over shim.

H. **Drill a 1/8" pilot hole** through the door frame, shims, blocking and aluminum frame at each pre-drilled installation screw hole location.

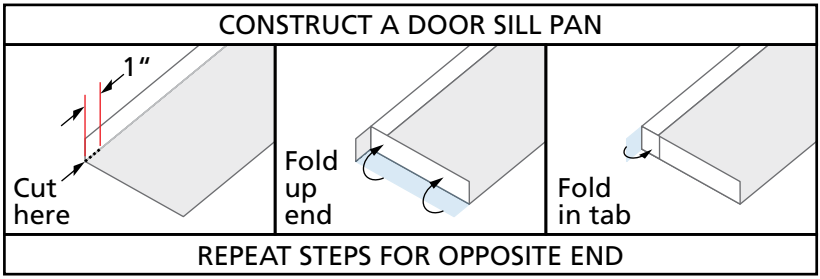
I. **Drive a #10 pan head corrosion resistant screw into the rough opening** at the installation hole locations. **DO NOT INSTALL FASTENERS IN HEAD UNTIL ALL FIXED PANELS HAVE BEEN INSTALLED.**

Go to Step 4

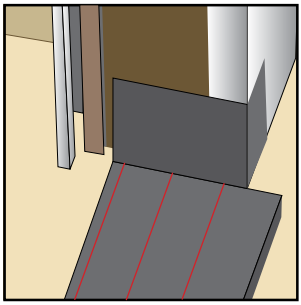
OPTIONAL SILL PAN FABRICATION AND INSTALLATION

Construct a door sill pan for the door. Measure the distance between the cut ends of the existing door sill and add 2". Measure 1" from each end and cut through the vertical leg of the pan material. Bend bottom flaps of the pan material up, then bend the back leg around the end of the pan.

Dry fit the sill pan and the door into the opening.



From the exterior, set the door into the opening. Set the sill of the door on the sill panel and tilt the door into position.

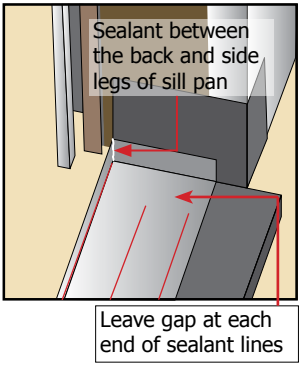


Using a pencil, mark the interior and exterior edges of the sill pan on the sill of the rough opening. Remove the door and sill pan.

Place a 1/4" diameter bead of sealant in the following locations:

- The exterior side of the interior pencil mark.
- The interior side of the exterior pencil mark.
- Midway between the exterior and interior sealant beads.

Install the sill pan into the opening, aligning the interior and exterior edges with the pencil marks from above. Press down on the sill pan to seal it into the opening.



Place one 1/4" diameter bead of sealant in the following locations:

- In the bend at the back of the sill pan.
- 1/2" from the exterior edge of the sill pan.
- Midway between the interior and exterior beads of sealant.
- Leave a 2" sealant gap at each end of the two exterior lines of sealant for drainage.

Also seal the joint between the back and side legs of the sill pan with sealant.

Go to Step 2

CLEANING INSTRUCTIONS

Remove 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. The vinyl frame may be cleaned as described above. For stubborn dirt, a "non-abrasive" cleaner such as Bon-Ami® or Soft Scrub® may be used. **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. Keep door tracks clear of dirt and debris. Keep weep holes open and clear of obstructions.

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 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 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 installation instructions.**

Product modifications that are not approved by Pella Corporation will void the Limited Warranty.

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