

# Ultimate Sliding and Ultimate Sliding French G2 Door

## Knock Down Assembly

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**ABSTRACT:** The following instructions are used for assembling the Ultimate Sliding French Door G2 and Sliding French Door Products. These instructions tell you how to assemble the frame on all configurations and install stationary panels. **This instruction does not include operator panel installation.** The full instructions ([LINK](#)) include rough opening preparation, frame installation and operator panel installation, as well as integrating the door into the building's air and water management systems.

- Ultimate Sliding French Door G2 (USFD G2)
- Ultimate Sliding French Door 2.25 G2 (USFD2.25 G2)
- Ultimate Sliding French Door 2.25 G2 IZ3 (USFD 2.25 G2 IZ3)
- Ultimate Sliding French Door 2.25 G2 IZ3 (USFD 2.25 G2 IZ3)
- USD
- USD 2.25
- USD 2.25 IZ3



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# Hazard Notations



## Seek Assistance

Panels are heavy, get help to move and place panels in the frame where applicable.



## WARNING!

Older homes may contain lead-based paint, which may be disturbed when replacing windows or performing renovations. Consult state or local authorities for safe handling, disposal, or abatement requirements. For information, go to [www.epa.gov/lead](http://www.epa.gov/lead).

*NOTE: Please consult with local waste management authorities regarding proper disposal and/or recycling of all waste materials generated during installation, including any product being replaced, packaging materials, and other waste.*



## WARNING!

Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection. For more information go to [www.P65Warnings.ca.gov/wood](http://www.P65Warnings.ca.gov/wood).



## WARNING!

This product can expose you to chemicals including titanium oxide, which is known to the state of California to cause cancer. For more information, go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).



## WARNING!

This product can expose you to chemicals including methanol, which is known to the state of California to cause birth defects or other reproductive harm. For more information, go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).



## WARNING!

Always practice safety! Wear the appropriate eye, ear, and hand protection, especially when working with power tools.

# Tools/Equipment Needed

- Safety glasses
- Gloves
- Tape measure
- Power drill/driver or impact driver
- #2 Phillips bit 3" or longer
- Flexible putty knife or plastic card (to depress the meeting stile guide)
- Caulking gun
- Utility knife
- Pry bar
- Rubber mallet
- 1/8" drill bit (3")
- Suction cups
- Combination square
- Paper towel/rags for cleanup

# Parts Included

All fasteners needed for frame assembly and stationary panel installation are provided. Extra screws may be provided.

*NOTE: Part and part numbers subject to change without notice. Confirm with your Marvin representative if ordering replacements.*

*NOTE: Quantities vary on items marked with asterisk (\*) depending on size and or configuration.*

OXXO Configurations			
QTY	Part Number	Item	Where Used
2	Not Applicable	Operator panel	
2	Not Applicable	Stationary panel	
1	Not Applicable	Sill Assembly	
1	Not Applicable	Sill Liner with tape	
1	Not Applicable	Left Jamb Assembly	
1	Not Applicable	Right Jamb Assembly	
1	Not Applicable	Head Jamb Assembly	
2	11407038	CSL 302 Clear silicone sealant, 10.2 oz tube	Corner key injection
2	11869925	Corner Key, 4 9/16" for 1 3/4" doors	Head jamb to jamb on units with 4 9/16" jambs
2	11869926	Corner Key, 6 9/16" for 2 1/4" doors	Head jamb to jamb on units with 6 9/16" jambs
5	11800972	#8 x 1 1/2" Pan head screw	Sill to Jamb Cladding
5	11806167	#8 x 3" Pan head screw	Sill to Jamb (through wood)
9	11800731	#7 x 2" Phillips flat head 2/3 thread screw	Head jamb to jamb
14	11800903	#8 x 3" Phillips flat head 2/3 thread screw	Through head jamb and jamb frame into stationary panels
2	10899024	Stationary panel bolts	Stationary panel to head jamb and sill
1	11841024	Panel to sill bracket (right hand)	Stationary panel to sill on right hand configurations
1	11841025	Panel to sill bracket (left hand)	Stationary panel to sill on left hand configurations.
7	11800918	#8 x 3" Phillips flat head 2/3 thread screw-black	Through head jamb panel guide into rough opening.
22	11800918	#8 x 3" Phillips flat head 2/3 thread screw-black	Stationary panel bolts into panel and head jamb.
6	11860032	6 9/16" Structural brackets*	Used above stationary panels
6	11860036	4 9/16" Structural brackets*	Used above stationary panels
qty varies	11800499	#8 x 5/8" Phillips head screws	Attaching structural bracket to head jamb (2/bracket)
1	05700054	Screen stop	
7	11800753	#7 x 1/2" Phillips flat head self tapping screw	Attaching the screen track and screen stop

OX or XO Configurations			
QTY	Part Number	Item	Where Used
1	Not Applicable	Operator panel	
1	Not Applicable	Stationary panel	
1	Not Applicable	Sill Assembly	
1	Not Applicable	Sill Liner with tape	
1	Not Applicable	Left Jamb Assembly	
1	Not Applicable	Right Jamb Assembly	
1	Not Applicable	Head Jamb Assembly	
2	11407038	CSL 302 Clear silicone sealant, 10.2 oz tube	Corner key injection
2	11869925	Corner Key, 4 9/16" for 1 3/4" doors	Head jamb to jamb on units with 4 9/16" jambs
2	11869926	Corner Key, 6 9/16" for 2 1/4" doors	Head jamb to jamb on units with 6 9/16" jambs
5	11800972	#8 x 1 1/2" Pan head screw	Sill to Jamb Cladding
5	11806167	#8 x 3" Pan head screw	Sill to Jamb (through jamb)
9	11800731	#7 x 2" Phillips flat head 2/3 thread screw	Head jamb to jamb
7	11800903	#8 x 3" Phillips flat head 2/3 thread screw	Through head jamb and jamb frame into stationary panels
1	10899024	Stationary panel bolt	Stationary panel to head jamb and sill
1	11841024	Panel to sill bracket (XO)	Stationary panel to sill
1	11841025	Panel to sill bracket (OX)	Stationary panel to sill
7	11800918	#8 x 3" Phillips flat head 2/3 thread screw-black	Through head jamb panel guide into rough opening.
4	11800918	#8 x 3" Phillips flat head 2/3 thread screw-black	Stationary panel bolts into panel and head jamb.
6	11860032	6 9/16" Structural brackets*	Used above stationary panels
6	11860036	4 9/16" Structural brackets*	Used above stationary panels
qty varies	11800499	#8 x 5/8" Phillips head screws	Attaching structural bracket to head jamb (2/bracket)

OXO Configurations			
QTY	Part Number	Item	Where Used
1	Not Applicable	Operator panel	
1	Not Applicable	Stationary panel	
1	Not Applicable	Sill Assembly	
1	Not Applicable	Sill Liner with tape	
1	Not Applicable	Left Jamb Assembly	
1	Not Applicable	Right Jamb Assembly	
1	Not Applicable	Head Jamb Assembly	
2	11407038	CSL 302 Clear silicone sealant, 10.2 oz tube	Corner key injection
2	11869925	Corner Key, 4 9/16" for 1 3/4" doors	Head jamb to jamb on units with 4 9/16" jambs
2	11869926	Corner Key, 6 9/16" for 2 1/4" doors	Head jamb to jamb on units with 6 9/16" jambs
5	11800972	#8 x 1 1/2" Pan head screw	Sill to Jamb Cladding
5	11806167	#8 x 3" Pan head screw	Sill to Jamb
9	11800731	#7 x 2" Phillips flat head 2/3 thread screw	Head jamb to jamb
7	11800903	#8 x 3" Phillips flat head 2/3 thread screw	Through head jamb and jamb frame into stationary panels
2	10899024	Stationary panel bolts	Stationary panel to head jamb and sill
1	11841024	Panel to sill bracket (right hand operating)	Stationary panel to sill
1	11841025	Panel to sill bracket (left hand operating)	Stationary panel to sill
7	11800918	#8 x 3" Phillips flat head 2/3 thread screw-black	Through head jamb panel guide into rough opening.
4	11800918	#8 x 3" Phillips flat head 2/3 thread screw-black	Stationary panel bolts into panel and head jamb.
6	11860032	6 9/16" Structural brackets*	Used above stationary panels
6	11860036	4 9/16" Structural brackets*	Used above stationary panels
qty varies	11800499	#8 x 5/8" Phillips head screws	Attaching structural bracket to head jamb (2/bracket)
1	10899021	Mull post reinforcement-head jamb (LH operating units only)	Head jamb to mull post on left hand configurations
1	10899022	Mull post reinforcement-head jamb (RH operating units only)	Head jamb to mull post on right hand configurations.
1	10899019	Mull post reinforcement-sill (LH operating units only)	Sill to mull post on left hand configurations
1	10899020	Mull post reinforcement-sill (RH operating units only)	Sill to mull post on right hand configurations.
4	02058017	#8 x 1 7/8 Phillips pan head screw	Mull post reinforcement into panel
3	11800806	#8 x 1 1/4" Phillips pan head screw	Mull post reinforcement (top and bottom) into astragal base and into panel
3	11800222	#8 x 3/8" Phillips flat head	Sill mull post reinforcement into sill
2	Varies per color	#8 x 3/8" Phillips pan head (color matched)	Mull cover to mull post reinforcement top and bottom.

OOX or XOO Configurations			
QTY	Part Number	Item	Where Used
2	11407038	CSL 302 Clear silicone sealant, 10.2 oz tube	Corner key injection
1	Not Applicable	Sill Assembly	
1	Not Applicable	Sill Liner with tape	
1	Not Applicable	Left Hand Jamb Assembly	
1	Not Applicable	Right Hand Jamb Assembly	
1	Not Applicable	Head Jamb Assembly	
2	11869925	Corner Key, 4 9/16" for 1 3/4" doors	Head jamb to jamb on units with 4 9/16" jambs
2	11869926	Corner Key, 6 9/16" for 2 1/4" doors	Head jamb to jamb on units with 6 9/16" jambs
5	11800972	#8 x 1 1/2" Pan head screw	Sill to Jamb Cladding
5	11806167	#8 x 3" Pan head screw	Sill to Jamb (through wood)
9	11800731	#7 x 2" Phillips flat head 2/3 thread screw	Head jamb to jamb; Through mull base to wood astragal.
6	11860032	6 9/16" Structural brackets*	Used above stationary panels
6	11860036	4 9/16" Structural brackets*	Used above stationary panels
14	11800499	#8 x 5/8" Phillips head screws	Attaching structural bracket to head jamb (2/bracket)
1	Not Applicable	Stationary panel-interlock	includes vinyl interlock and alignment bolts
1	Not Applicable	Stationary panel-jamb side	includes wood astragal base and alignment receivers
1	Not Applicable	Operator panel	
7	11800903	#8 x 3" Phillips flat head 2/3 thread screw	Through head jamb and jamb frame into stationary panels;
3	10899024	Stationary panel bolts	Stationary panel to head jamb and sill
1	11844040	Stationary panel strap-may be applied at the factory	Interlock stationary panel to sill
1	11841024	Panel to sill bracket (XOO)*	Stationary panel to sill
1	11841025	Panel to sill bracket (OOX)*	Stationary panel to sill
7	11800918	#8 x 3" Phillips flat head 2/3 thread screw-black	Through head jamb panel guide into rough opening.
4	11800918	#8 x 3" Phillips flat head 2/3 thread screw-black	Stationary panel bolts into panel and head jamb.
1	02540665	Screen bumper	

# Frame Assembly

## Head Jamb to Side Jamb Assembly

1. Align both head jamb keys into the hollows of the head jamb clad until fully seated. Orient the key with the taller ribs toward the exterior. [See Figure 1.](#)

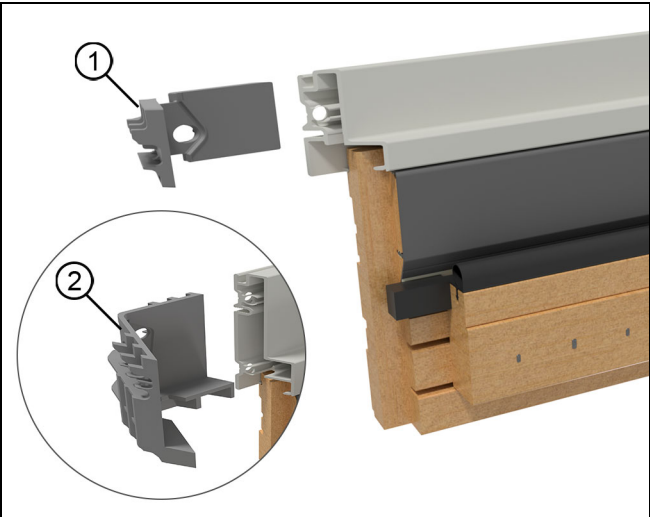


Figure 1

1	4 9/16" corner key
2	6 9/16" corner key

2. Assemble the head jamb into the side jambs being careful not to pinch the gaskets at the corners. [See Figure 2](#) and [Figure 3.](#)

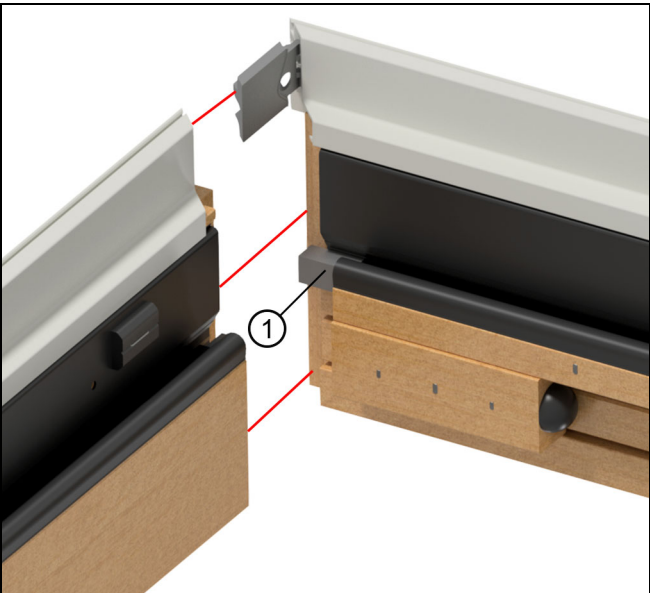


Figure 2 4 9/16"

1	Gasket
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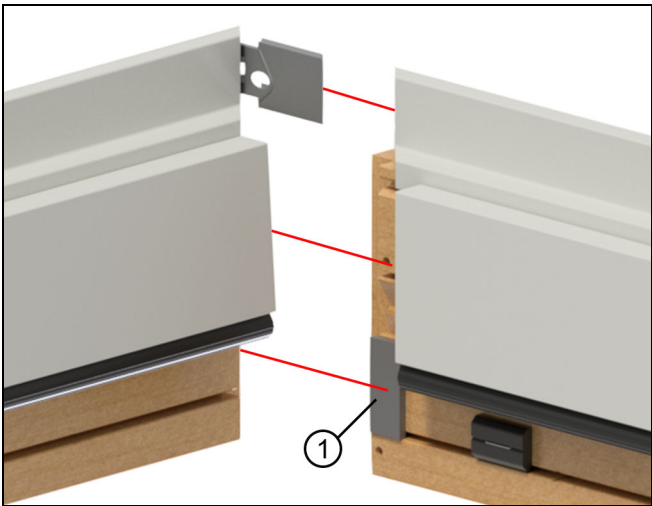


Figure 3 6 9/16"

1	Gasket
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3. Align the joint on the corners, then use a #7 x 2" flat head screw (unpainted) through the hole closest to the end and into the screw boss of the jamb cladding. The inner-most holes on each side are used for injection. [See Figure 4.](#) 6-9/16" jambs will require two #7 x 2" flat head screws through the head jamb cladding.

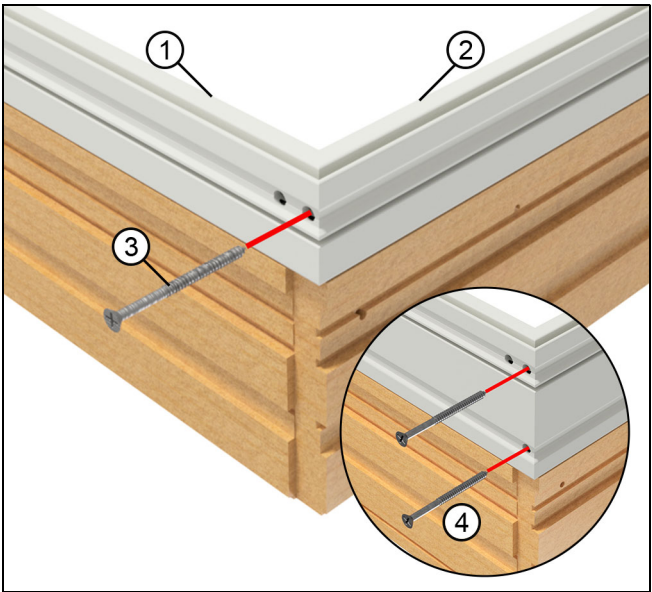
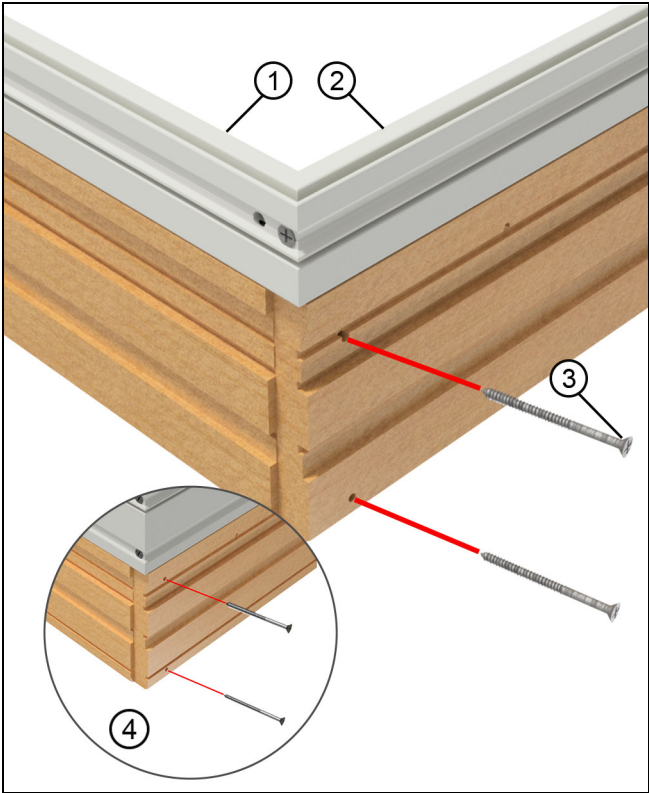


Figure 4

1	Head jamb
2	Side jamb
3	#7 x 2" flat head screw
4	6 9/16" jamb uses two screws into the corner key

4. Use two #7 x 2" flat head screws to screw through the pre-drilled holes located on the side of the side jamb wood into the head jamb wood. Push the head jamb down towards the jamb to fully seat it prior to screwing. See [Figure 5](#).

*NOTE: The pre-drilled holes are angled toward the head jamb.*



**Figure 5 Pre-drilled screw holes are angled**

1	Head jamb
2	Jamb
3	#7 x 2" flat head screws
4	6 9/16"

*NOTE: You will inject the frame corners in a later step.*

# Sill to Side Jamb Assembly

Layout the parts exterior side up on a clean flat surface. Protect the interior finish from damage.



## Hint

Place 2x4's on the floor or use saw horses to prop the frame up off the floor. This will protect the interior surface and allow better access for assembly.

1. Align the side jamb sub assembly into sill key until fully seated. See Figure 6.

## ATTENTION

Take care when assembling the side jamb to the sill to not roll, or cut, the sill gasket. See Figure 6.



Figure 6

2. Once seated, use the provided #8 x 1-1/2" pan head screw (painted head) through the sill key into the jamb cladding. See Figure 7.

**NOTE:** On 6-9/16" jambs, each side will require two #8 x 1-1/2" pan head screws provided.

3. Use two #8 x 3" pan head screws to screw through the sill key into jamb wood. See Figure 7.

**NOTE:** You may need a longer shank Phillips bit to fully seat these screws. If a shorter bit is used, the screw may not fully seat and the screw could strip out.

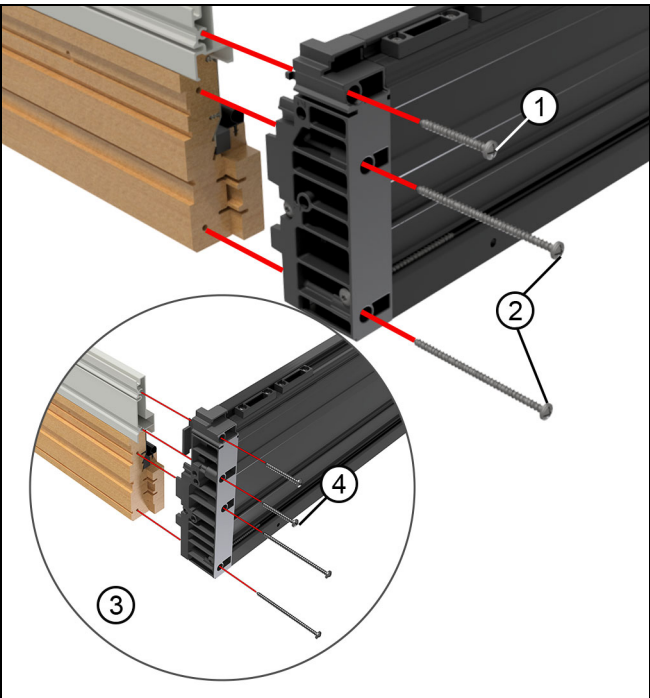


Figure 7

1	#8 x 1 1/2" pan head screw
2	#8 x 3" pan head screws
3	6 9/16" jamb
4	Use two 1 1/2" screws for 6 9/16" jambs

4. Repeat the previous steps for the opposing side jamb.

**NOTE:** You will inject the frame corners in a later step.

# Injecting the Frame Assembly



## Hint

Cut the tip on the provided sealant tube so that you can insert the tip into the injection holes. Don't cut too much off or you will likely have sealant contamination around the injection hole.

1. On 4-9/16" jambs, locate the injection hole on the side of the sill key labeled "2". Inject the provided sealant into the key until you see squeeze out in the inspection hole shown below. [See Figure 8](#).
2. On 6-9/16" jambs, locate the injection hole on the side of the sill key labeled "3". Inject the provided sealant into the key until you see squeeze out in the inspection hole shown below. [See Figure 8](#) (inset)

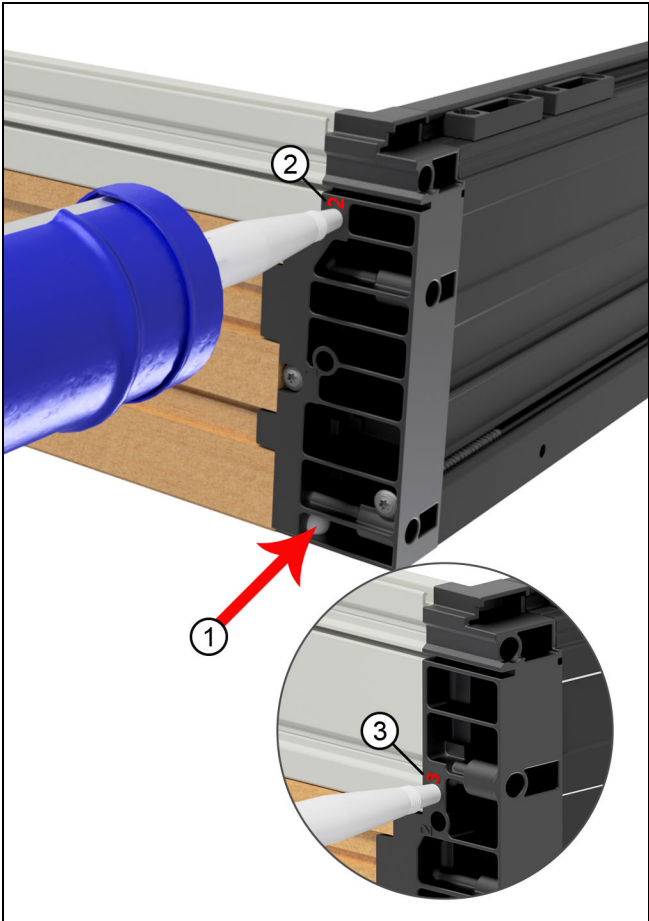


Figure 8

1	Squeeze out inspection hole (same for 4 9/16 and 6 9 1/6 jambs)
2	Injection hole #2 for 4 9/16" jambs
3	Injection hole #3 for 6 9/16" jambs

3. Use the remaining hole in the head jamb cladding to inject the keys. Inject until you see squeeze out in the image shown below. [See Figure 9](#).

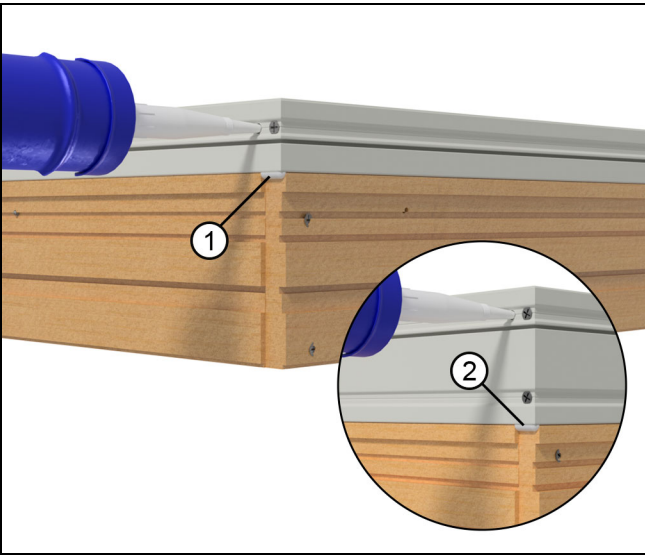


Figure 9

1	4 9/16" jamb squeeze out location
2	6 9/16" jamb squeeze out location.

## IMPORTANT

Minimize excess sealant contamination on the cladding.

# Stationary Panel Installation

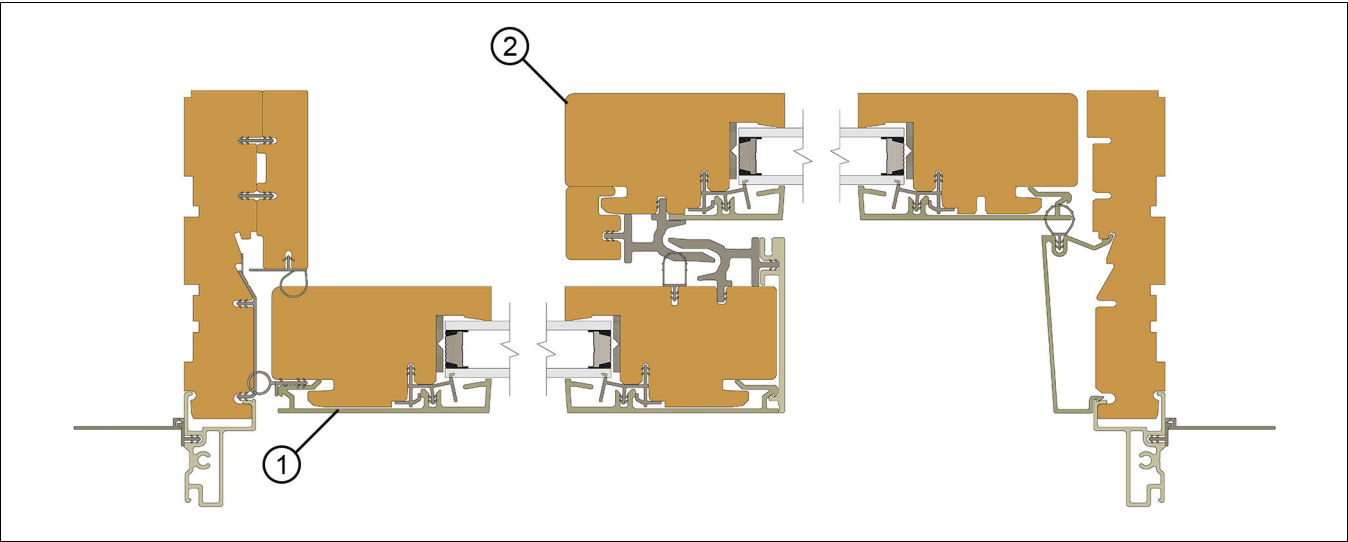
Use the following individual sections ([OX/XO and OXXO Stationary Panel Installation on page 13](#) , [OXO Stationary Panel Installation on page 18](#), and [OOX/XOO Panel Installation on page 26](#)) to install your stationary panel(s). Before proceeding make sure you have completed all the steps needed for Frame Assembly including injecting the corners.

 **Seek Assistance**

Panels can be very heavy. Get assistance to avoid injury and/or damage to the door. You will need another person to install your stationary panels.

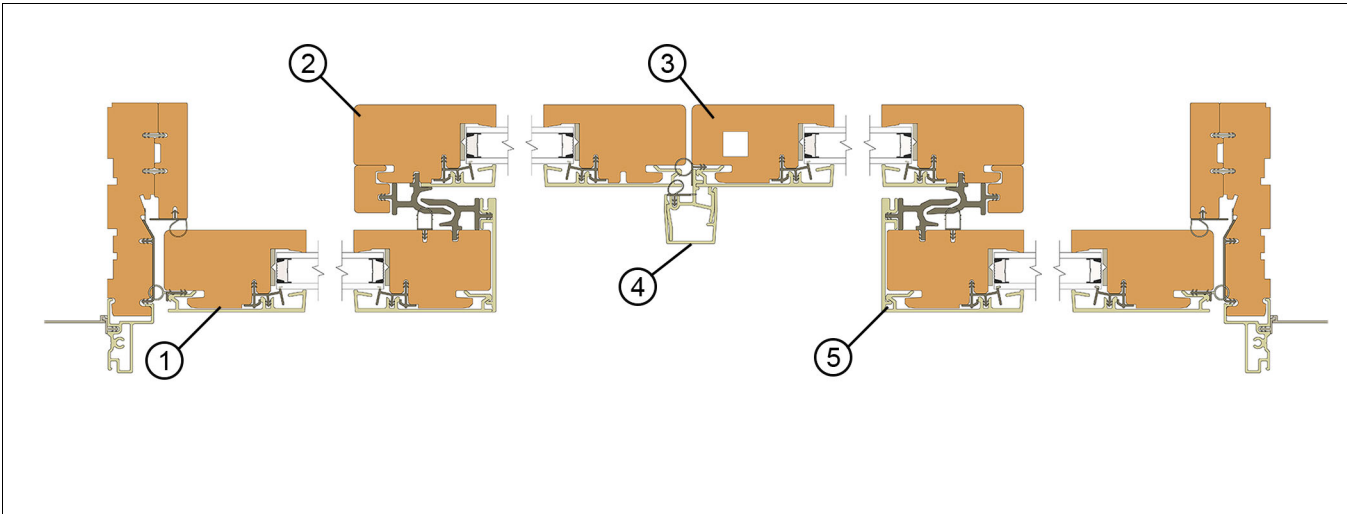
## ***OX/XO and OXXO Stationary Panel Installation***

On OX/XO and OXXO configurations, the stationary panel(s) are situated at the exterior plane of the frame.



**Figure 10 OX LH Configuration**

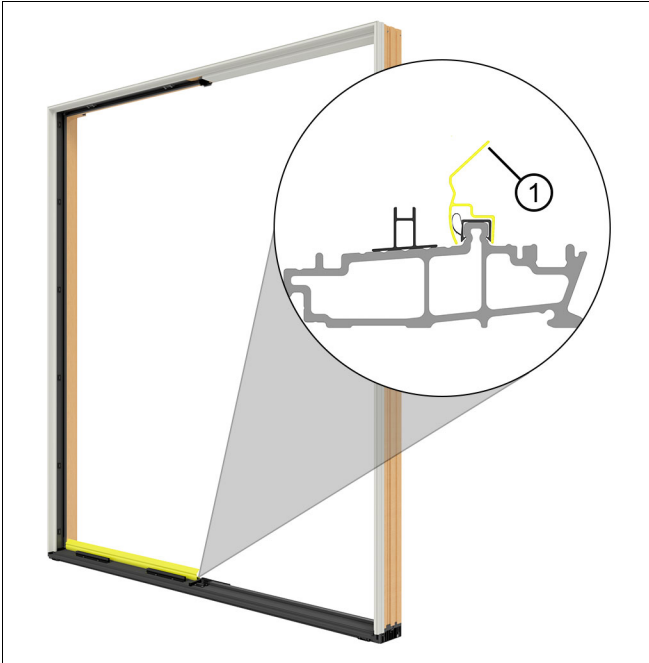
1	Stationary Panel (LH)
2	Primary operator



**Figure 11 OXXO LH Configuration**

1	Stationary panel (LH)
2	Active operator
3	Inactive operator
4	Astragal attached to inactive operator panel
5	Stationary panel (RH)

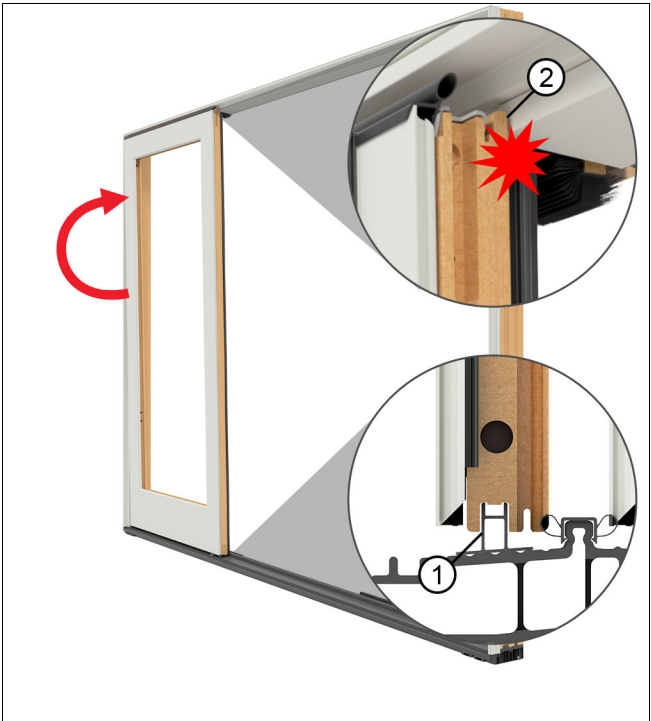
1. Tip the frame up and have at least one other person hold the frame in place.
2. Install the weatherstrip jig. Install the leading edge of the jig under the weather strip bulb, then rotate the jig so the back edge snaps onto the exterior leg of the weather strip. [See Figure 12.](#)



**Figure 12**

1	Stationary panel weatherstrip jig
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3. From the exterior, set the stationary panel onto the sill stationary block close to the jamb. The stationary block corresponds to a groove in the bottom of the panel. Tip the panel in until it hits the aluminum parting stop. [See Figure 13.](#)



**Figure 13**

1	Sill stationary block.
2	Panel will contact the aluminum stop at the head jamb

4. Slide the panel over to the side jamb and then push the top in until it contacts the wood parting stop. See Figure 14. Clips at the head jamb will hold the panel in place and aid in alignment.

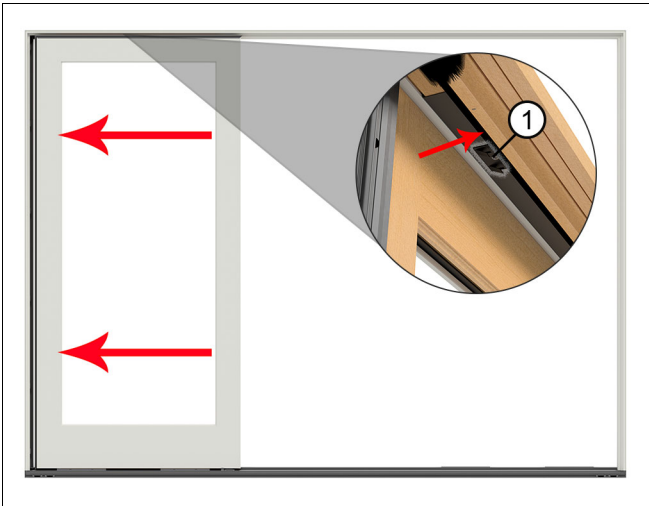


Figure 14

1	Panel retention clip
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5. Install the end of the stationary bolt into the head jamb strike plate. Slide the bolt into place and fasten to the stationary panel with the two #8 x 3" flat head screws. Note that the top screw is installed at an angle. You will need to push up on the head jamb to allow clearance for the stationary bolt to engage in the plate. See Figure 15.

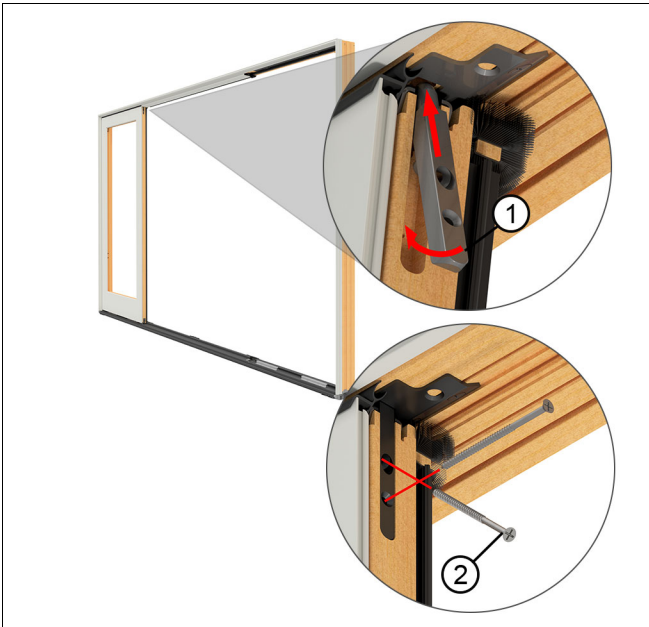


Figure 15

1	Stationary bolt
2	#8 x 3" screws

6. Install the sill to panel bracket. Slide the sill to panel bracket under the frame sill bracket (already attached to the sill). Fasten to the stationary panel with #8 x 3" flat head screws provided. See Figure 16.

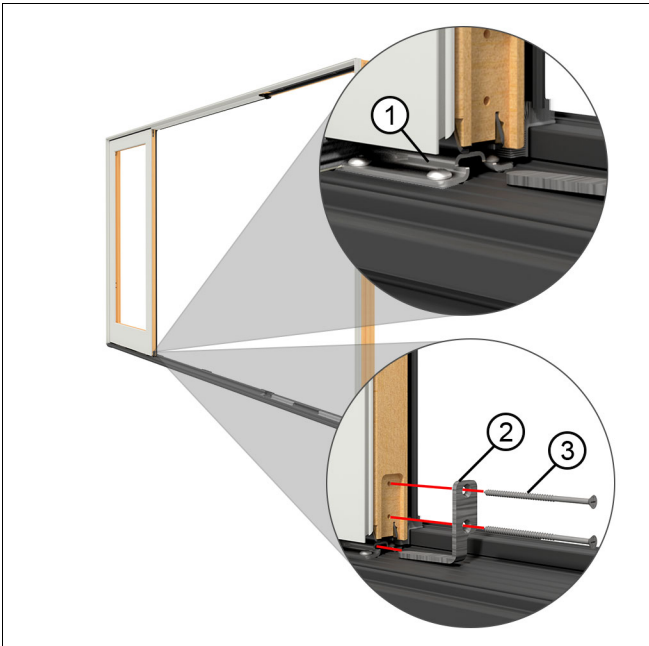


Figure 16

1	Frame sill bracket
2	Sill to panel bracket
3	#8 x 3" screws



### Hint

Use a combination square along the jamb to maintain a consistent panel depth. Check the depth at the bottom first to set your combination square dimension. Check along the length of the side jamb before pre-drilling and fastening. 4 9/16 jambs will be about 2 5/8" and 6 9/16 jambs will be about 3 3/16". See Figure 17.

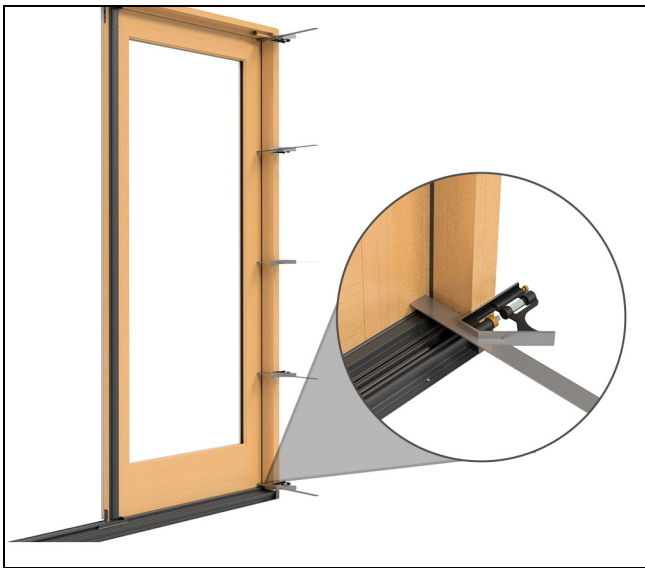


Figure 17

Hold the panel in place and use the holes in the side jamb to pre-drill into the panel with a 1/8" drill bit. See Figure 18.



Figure 18

## ⚠ CAUTION!

Do not drill deeper than 3". If you drill deeper than 3" you will break the glass.

7. Fasten the jamb to the panel with the #8 x 3" flat head screws along the entire jamb.

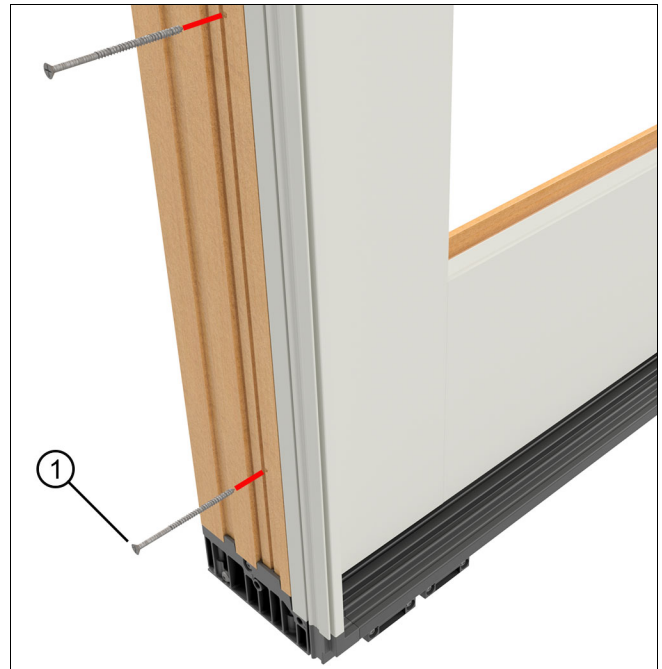


Figure 19

1	#8 x 3" flat head screw
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8. Remove the weather strip jig. Pull up on one end and work your way along the jig.

9. Install the aluminum stationary stile edge cover. The edge cover will slide up in between the head jamb parting stop and the stationary panel. Tap into place with a rubber mallet. See Figure 20.

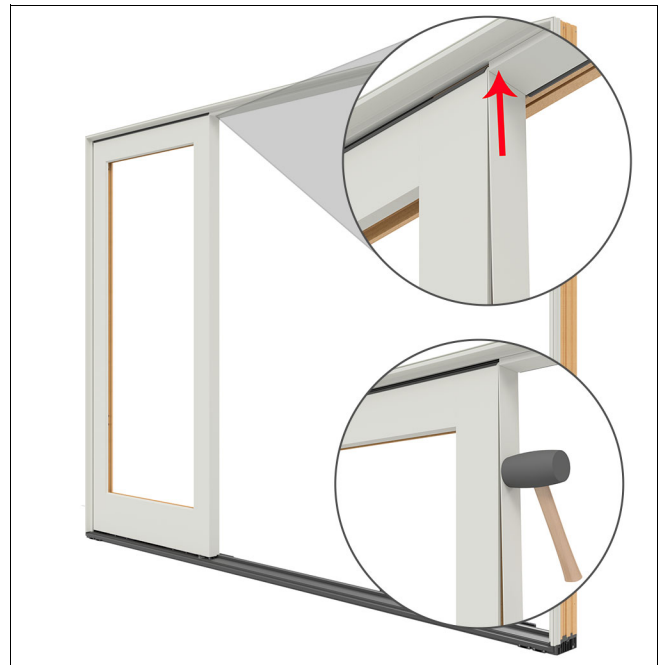


Figure 20

**10.** On OXXO configurations repeat the previous steps to install the other stationary panel.

**11.** Follow installation instructions for installation into the rough opening.

# OXO Stationary Panel Installation

There are two stationary panels. One on the exterior plane and one on the interior plane. Note the position of the panels as shown in [Figure 21](#) below.

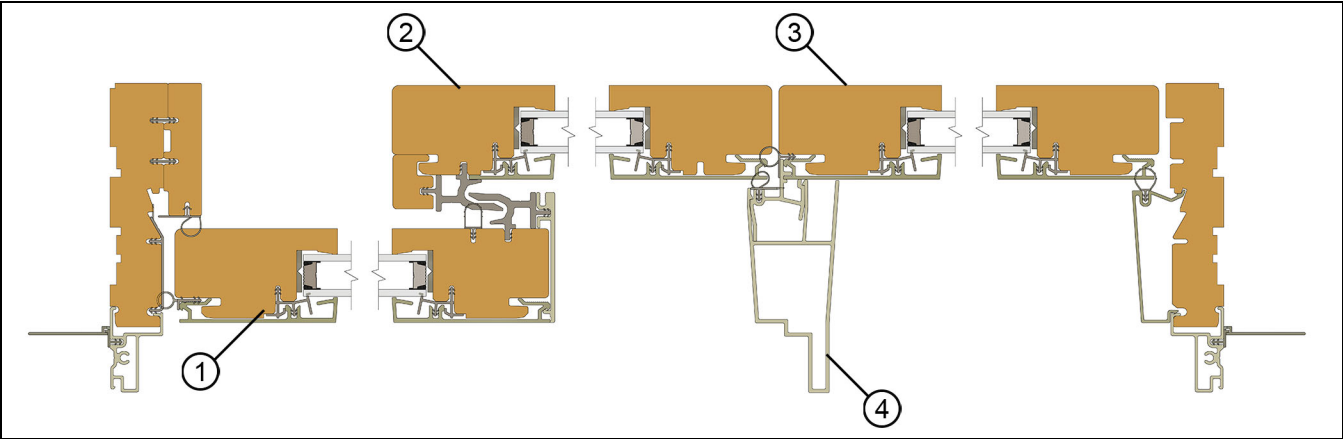


Figure 21 OXO (LH Shown)

1	Stationary panel (at exterior plane)
2	Operator Panel
3	Stationary panel (at interior plane)
4	Screen stop

**NOTE:** You will install the exterior stationary panel first (panel with the interlock) and the interior stationary panel second (with panel alignment bolts and keepers installed). [See Figure 22](#) and [Figure 23](#).

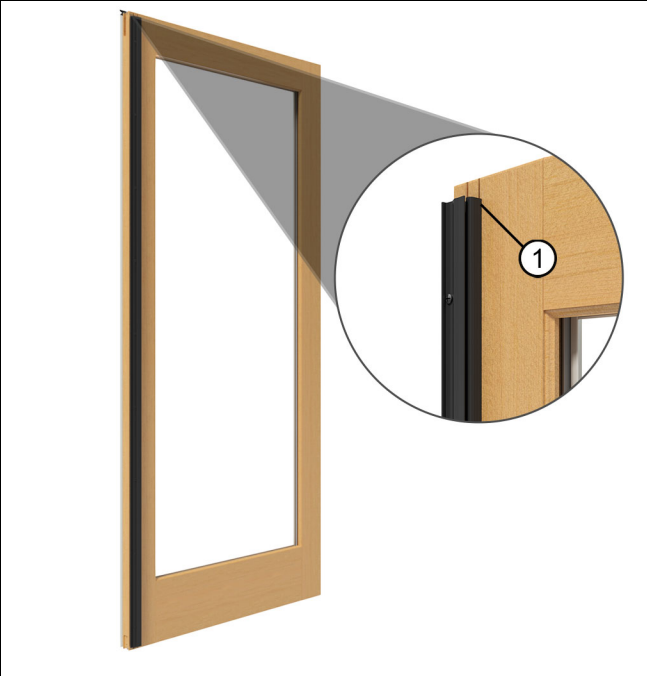


Figure 22 Stationary panel with interlock (exterior plane)

1	Interlock
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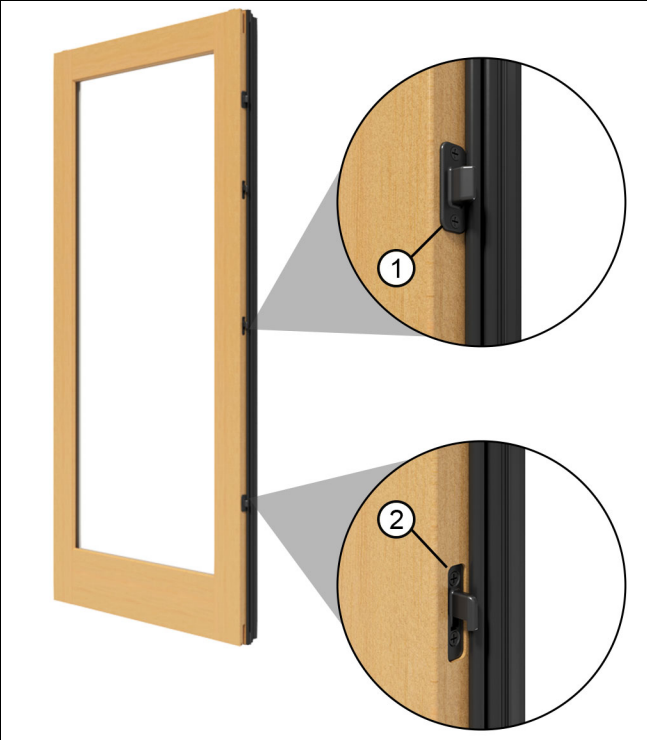


Figure 23 Stationary panel (interior plane)

1	Alignment bolt(s)
2	Keeper(s)

1. Temporarily remove the operator panel guide from the head jamb. Discard these screws, you will reinstall the panel guide with longer screws later once the door is installed in the opening. See Figure 24.

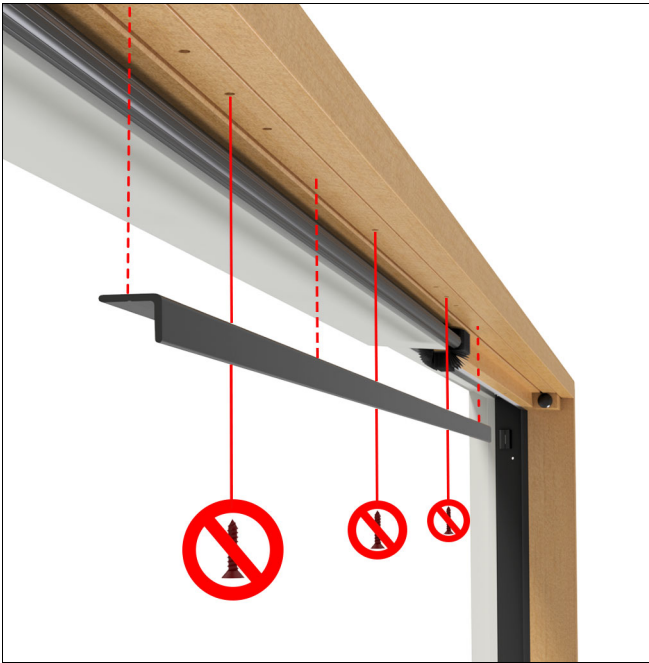


Figure 24

2. Install the weatherstrip jig. Install the leading edge of the jig under the weather strip bulb, then rotate the jig so the back edge snaps onto the interior leg of the weather strip. See Figure 25.

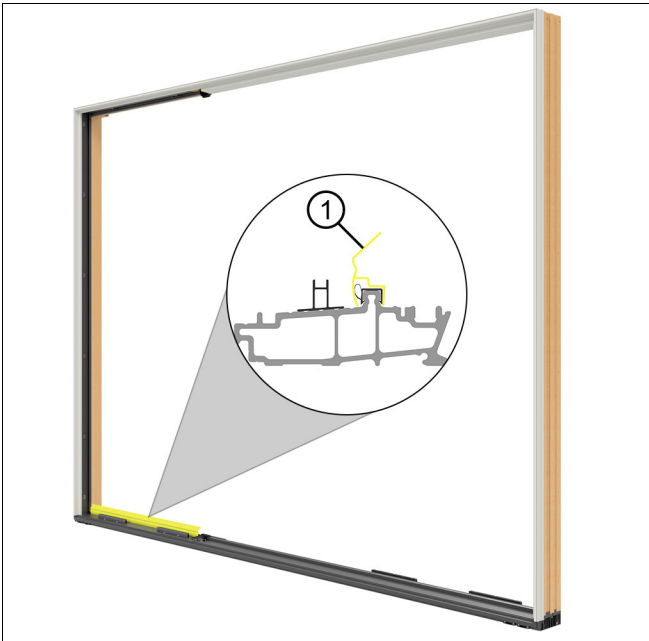


Figure 25

1	Stationary panel weatherstrip jig
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3. Tip the frame up and have at least one other person hold the frame in place.

4. From the exterior set the stationary panel (with interlock) onto the sill stationary blocks, close to the jamb. The block corresponds to a groove in the bottom of the panel.

5. Tip the panel in until it hits the aluminum parting stop. See Figure 26 and Figure 27.

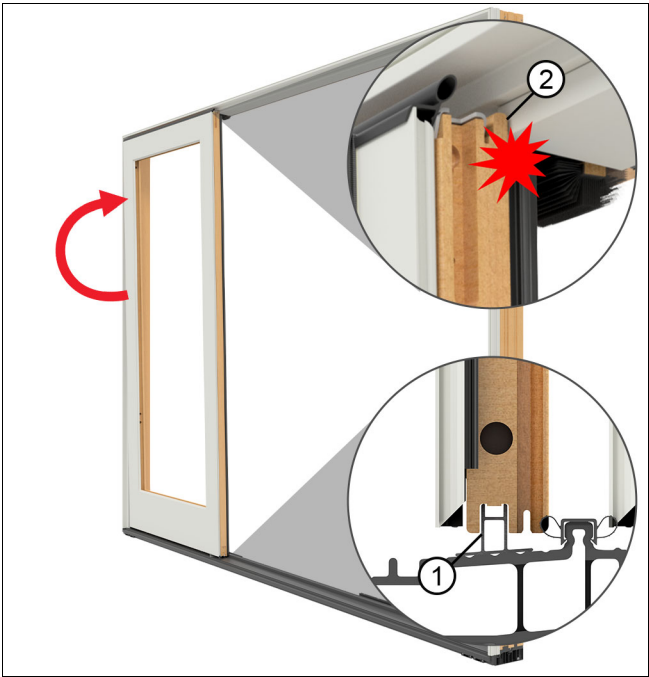


Figure 26

1	Sill stationary block.
2	Panel will contact the aluminum parting stop at the head jamb

6. Slide the panel past the aluminum parting stop to the jamb. Now push the panel in until it contacts the wood parting stop. Clips at the head jamb will hold the panel in place and aid in alignment. See Figure 27.

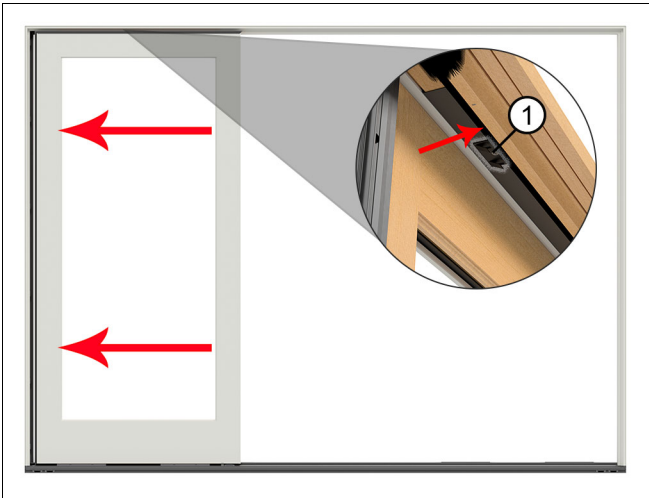


Figure 27

1	Panel retention clip
---	----------------------

7. Install the end of the stationary bolt into the head jamb plate. Slide the bolt into place and fasten to the stationary panel with the two #8 x 3" screws. Note that the top screw is installed at an angle. You will need to push up on the head jamb to allow the stationary bolt to engage in the plate. See Figure 28.

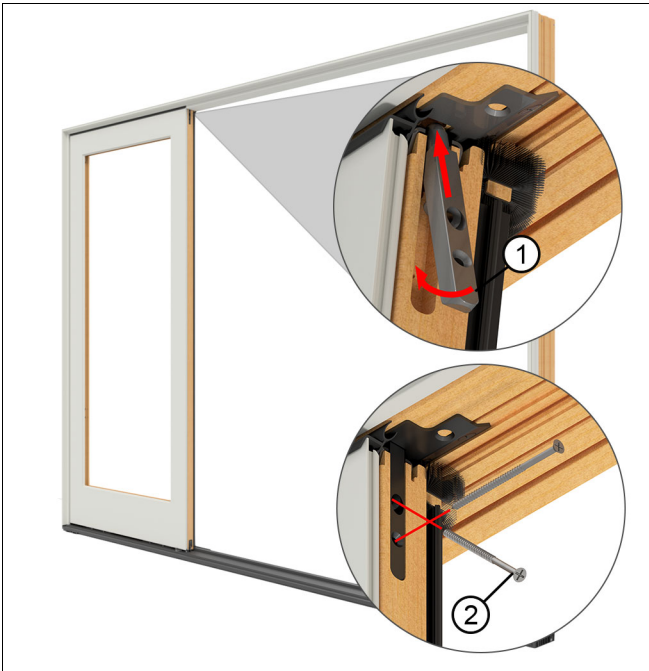


Figure 28

8. Install the sill to panel bracket. Slide the bracket under the sill bracket (attached to the sill). Then fasten to the stationary panel with #8 x 3" screws provided. See Figure 29.

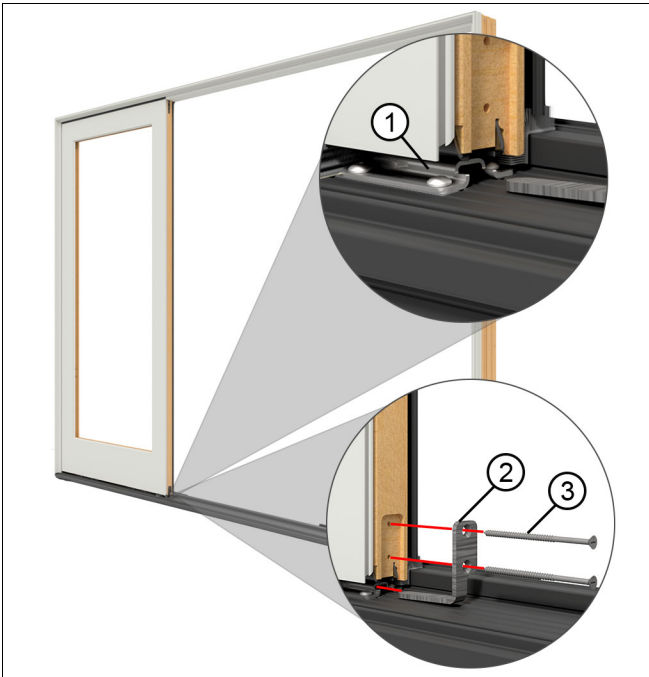


Figure 29

1	Sill frame bracket
2	Sill to panel bracket
3	#8 x 3" screws

### Hint

Use a combination square along the jamb to maintain a consistent panel depth. Check the depth at the bottom first to set your combination square dimension. Check along the length of the side jamb before pre-drilling and fastening. 4 9/16 jams will be about 2 5/8" and 6 9/16 will be about 3 3/16". See Figure 30.

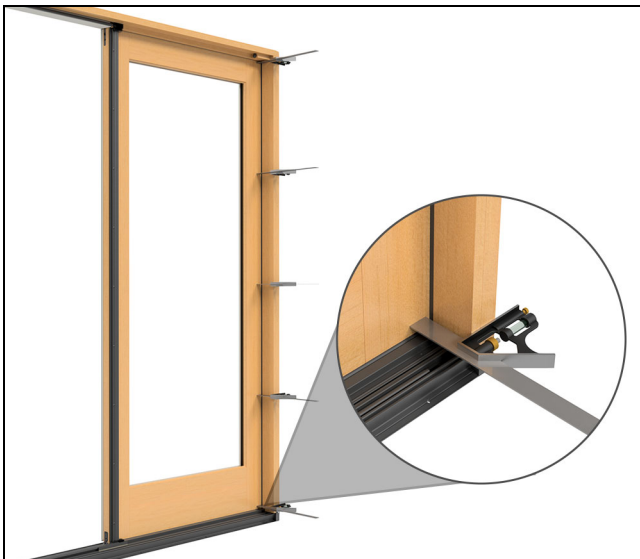


Figure 30

Hold the panel in place and use the holes in the side jamb to pre-drill into the panel with a 1/8" drill bit. See Figure 31.

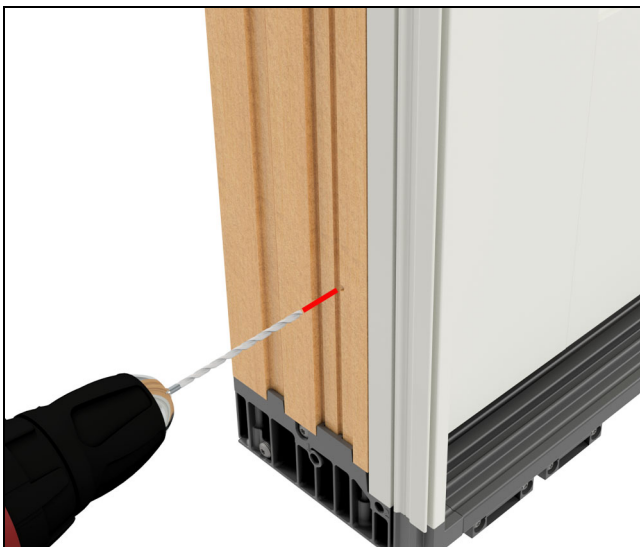


Figure 31

## ! CAUTION!

Do not drill deeper than 3". If you drill deeper than 3" you will break the glass.

9. Fasten the jamb to the panel with the #8 x 3" flat head screws. See Figure 32.

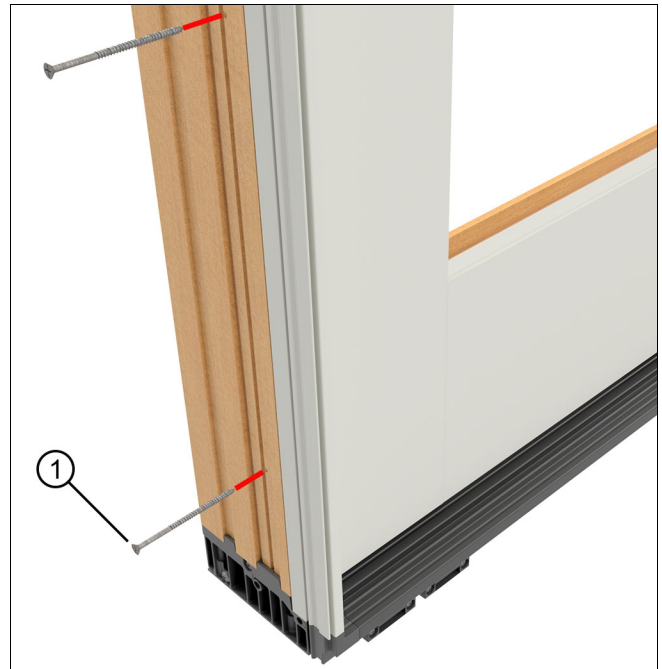


Figure 32

1	#8 x 3" flat head screw
---	-------------------------

10. Remove the weather strip jig. Pull up on one end and work your way along the jig.

11. Install the aluminum stationary stile edge cover. The edge cover will slide up in between the head jamb parting stop and the stationary panel. Tap into place with a rubber mallet. See Figure 33.

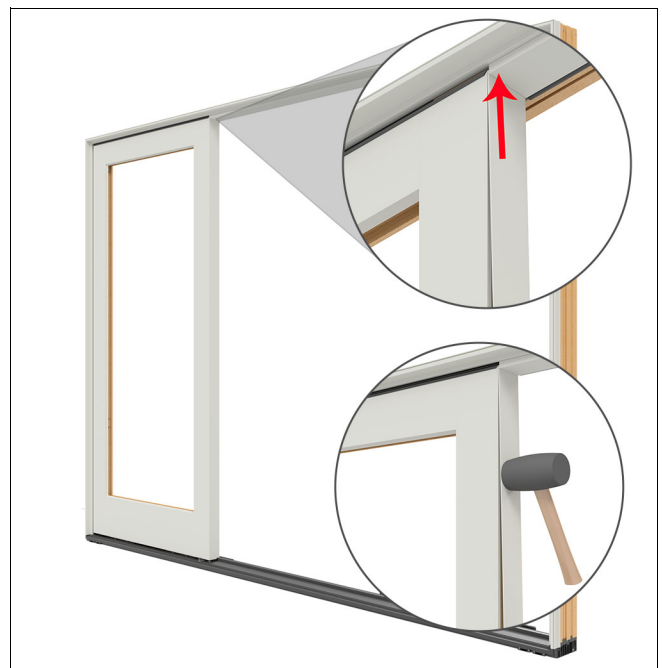


Figure 33

**12.** Install weatherstrip jig on the interior side. Install the leading edge of the jig under the weather strip bulb, then rotate the jig to the exterior so the back edge snaps onto the exterior leg of the weather strip. [See Figure 34.](#)

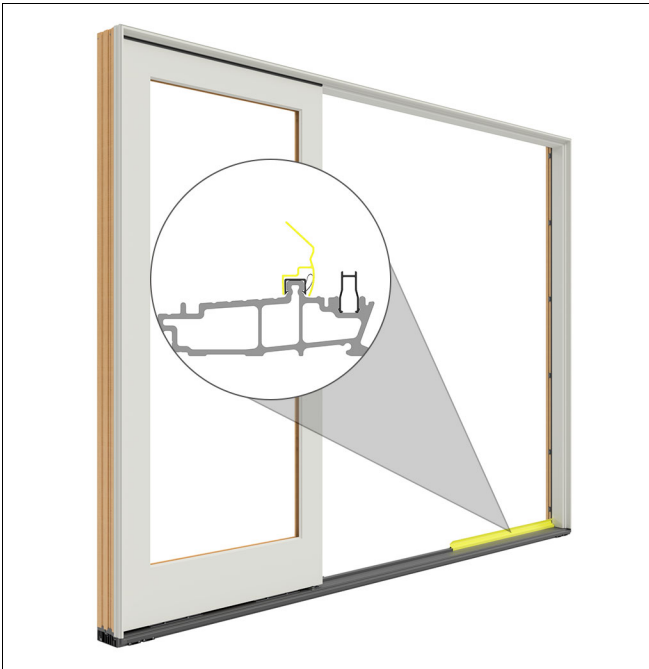


Figure 34

**13.** From the interior, set the inboard stationary panel (with alignment bolts) onto the interior sill stationary block. The block corresponds to a groove in the bottom of the panel. Tip the panel in until it locks into place, then slide the panel over to the side jamb. [See Figure 35](#)

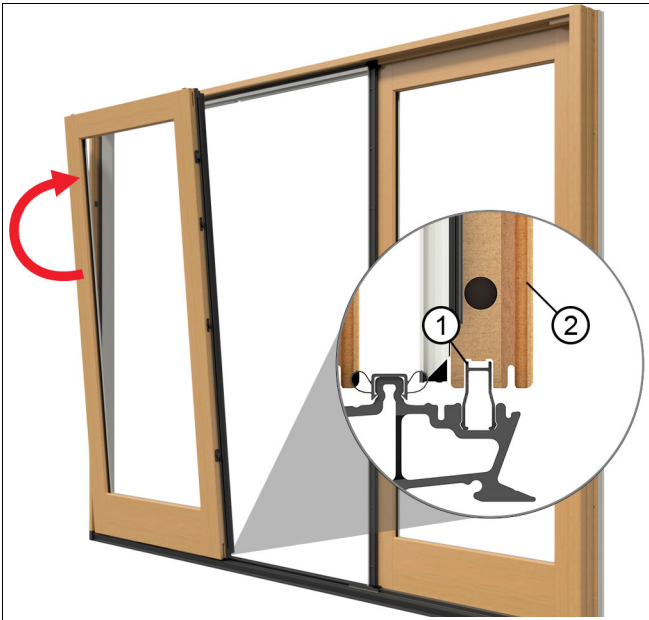


Figure 35

1	Stationary block
2	Stationary panel

**14.** Install the end of the stationary bolt into the head jamb plate. Slide the bolt into place and fasten to the stationary panel with the two #8 x 3" screws. Note that the top screw is installed at an angle. [See Figure 36.](#)

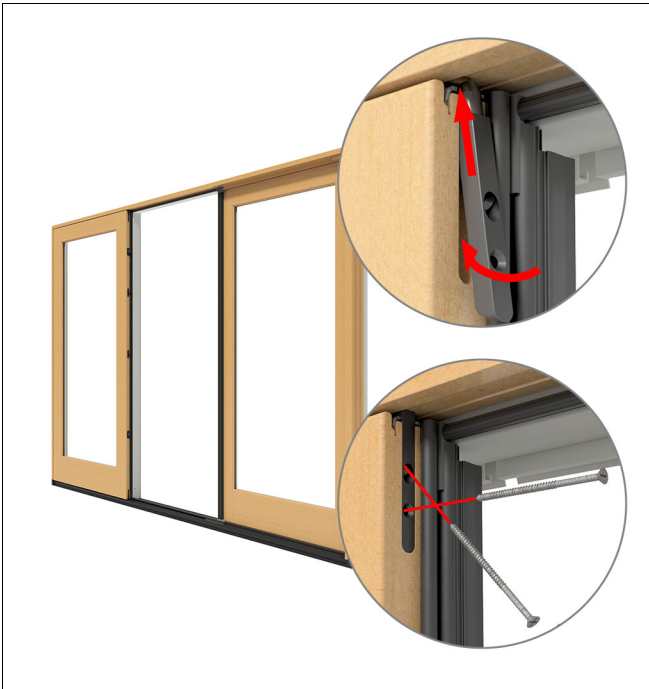


Figure 36

15. Install the end of the stationary bolt into the sill. Slide the bolt into place and fasten to the stationary panel with one #8 x 3" screw. [See Figure 37.](#)

## IMPORTANT

DO NOT use the bottom angled hole to fasten the stationary bolt at the sill.

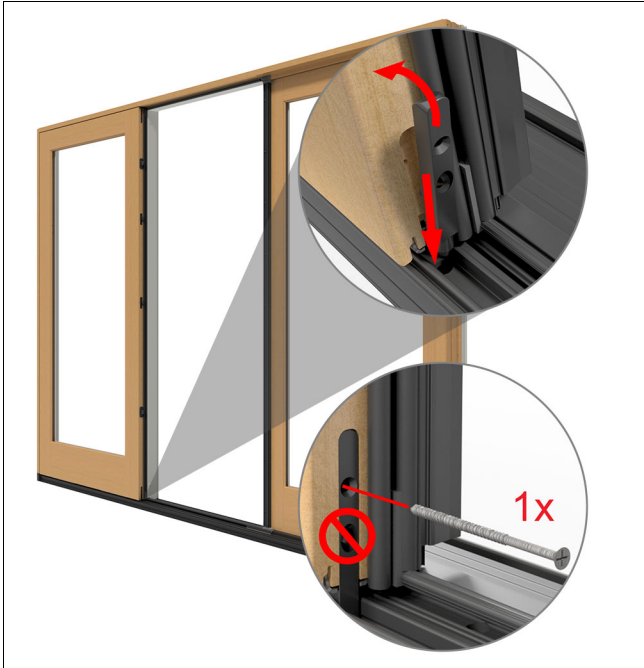


Figure 37

16. Hold the panel in place and use the holes in the side jamb to pre-drill into the panel with a 1/8" drill bit. [See Figure 38.](#)

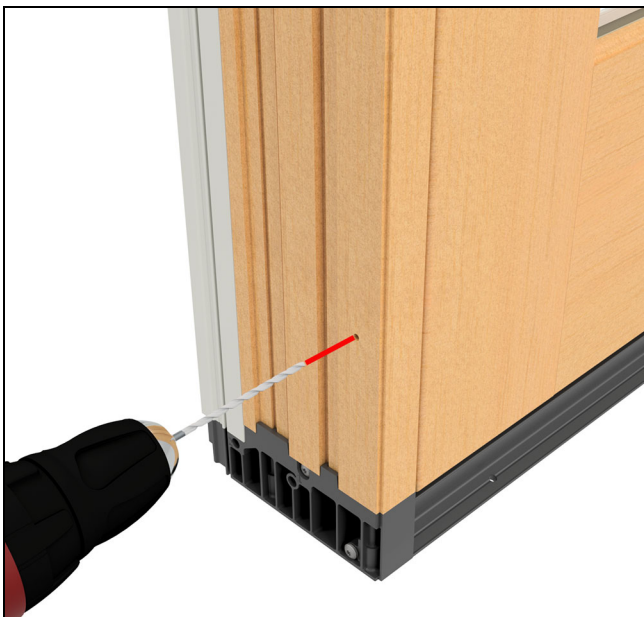


Figure 38

## ! CAUTION!

Do not drill deeper than 3". If you drill deeper than 3" you will break the glass.

17. Fasten the jamb to the panel with the #8 x 3" flat head screws. [See Figure 39.](#)

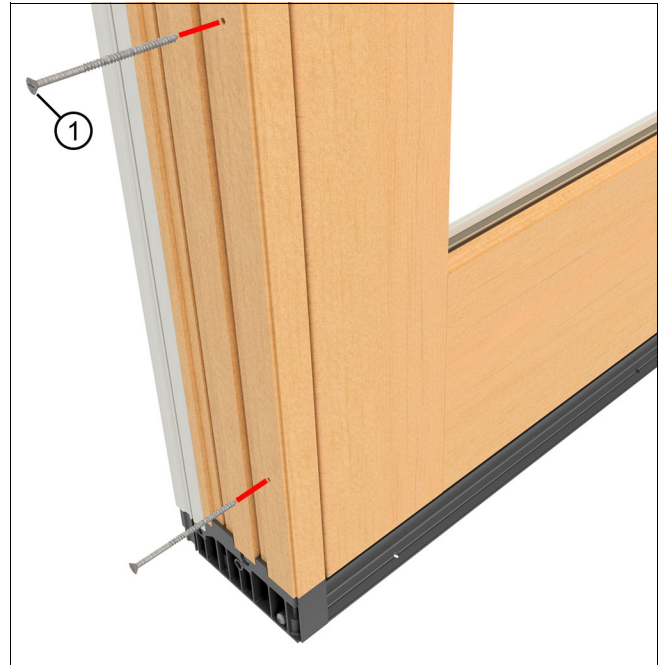


Figure 39

1	#8 x 3" flat head screw
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18. Remove the weather strip jig. Pull up on one end and work your way along the jig.

19. Install the head jamb mull end bracket. Slide the bracket into place above the mull base. Pre drill into the surface of the part stop cladding with a 1/8" drill bit and fasten with #8 x 1 7/8" screws into the head jamb frame. Fasten to the panel with one #8 x 1 1/4" screw. Note that the screw goes in at a slight angle at the end of the slot. See Figure 40.

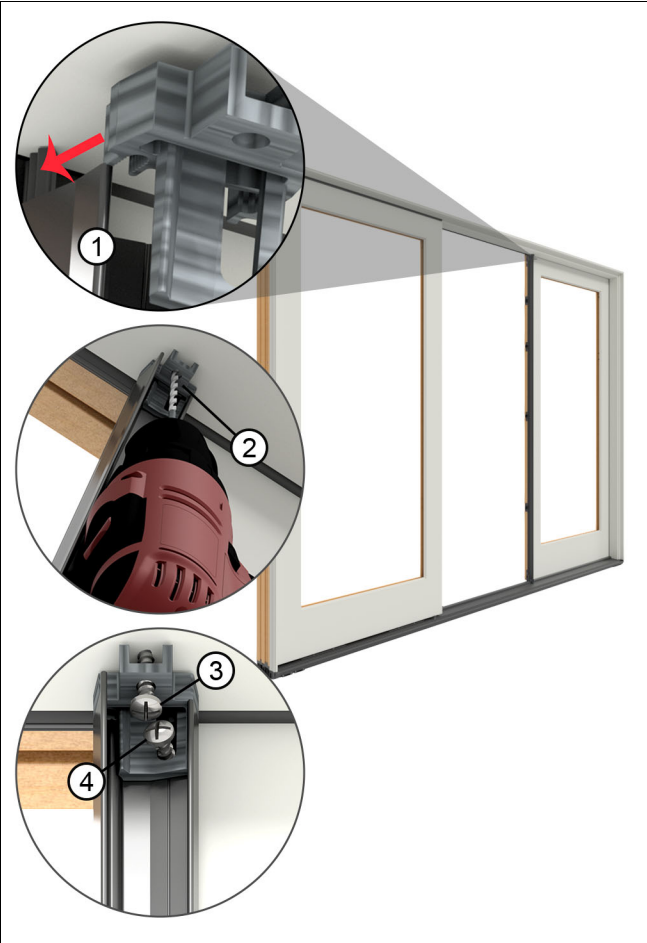


Figure 40

1	Jamb mull end bracket
2	1/8" drill bit
3	#8 x 1 7/8" pan head screw
4	#8 x 1 1/4" pan head screw

20. Install the sill mull end bracket by aligning it into the mull base, then sliding it down to rest against the sill. Pre-drill with a 1/8 " drill bit through the top wall of the sill and fasten with a #8 x 3/8" flat head screw into the bottom of the mull base and sill. Fasten to the panel with a 3/8 x 1 1/4" pan head screw. See Figure 41.



# CAUTION!

When pre-drilling avoid puncturing the bottom layer of the sill.

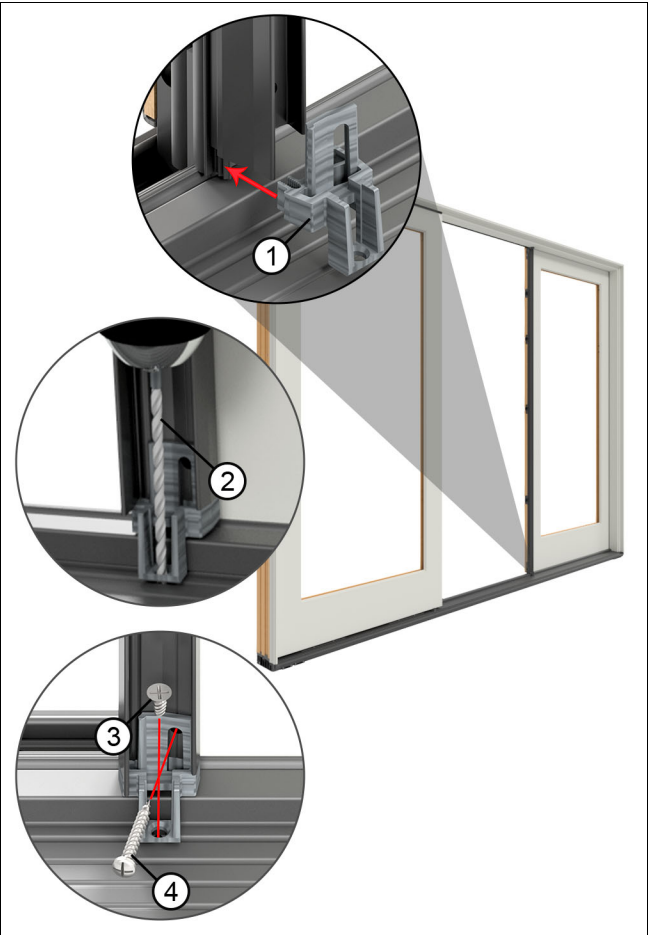


Figure 41

1	Sill mull end bracket
2	1/8" drill bit
3	#8 x 3/8" flat head screw
4	#8 x 1 1/4" pan head screw

21. Install the screen stop onto the mull base and pound into place with a heavy rubber mallet. See [Figure 42](#).

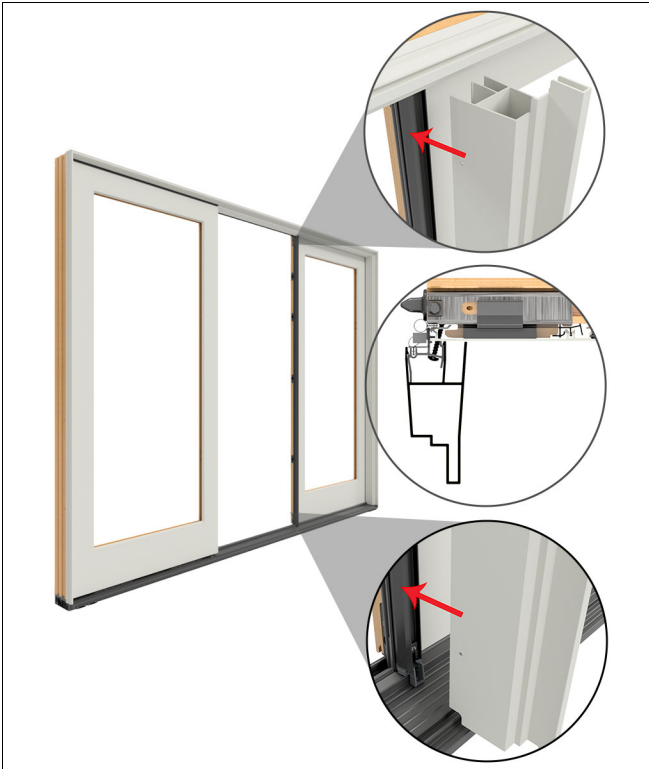


Figure 42

22. Fasten at the top and bottom with the provided #8 x 3/8" pan head, color matched, self tapping screws into the mull base. The holes in the cover are pre-drilled. See [Figure 43](#) and [Figure 44](#).



Figure 43

1	#8 x 3/8" pan head, color matched, self tapping screws
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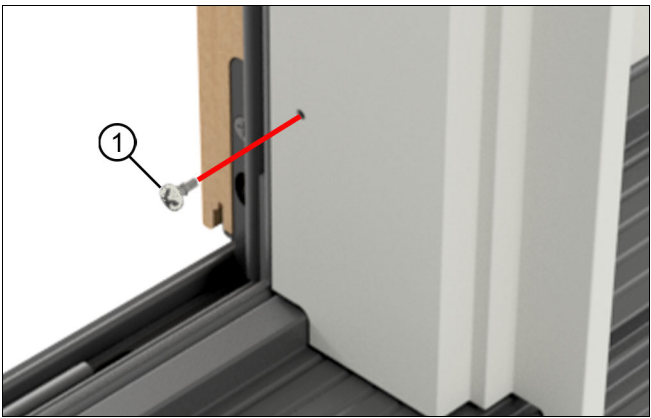


Figure 44

1	#8 x 3/8" pan head, color matched, self tapping screws
---	--

23. Follow installation instructions to install the door into the rough opening. [Install the Screen Track on page 32](#) after the door has been installed.

# OOX/XOO Panel Installation

There are two stationary panels at the exterior plane. The second panel is installed in the center of the configuration. You can identify this panel as it has the interlock attached and panel alignment bolts installed. See [Figure 46](#) below.

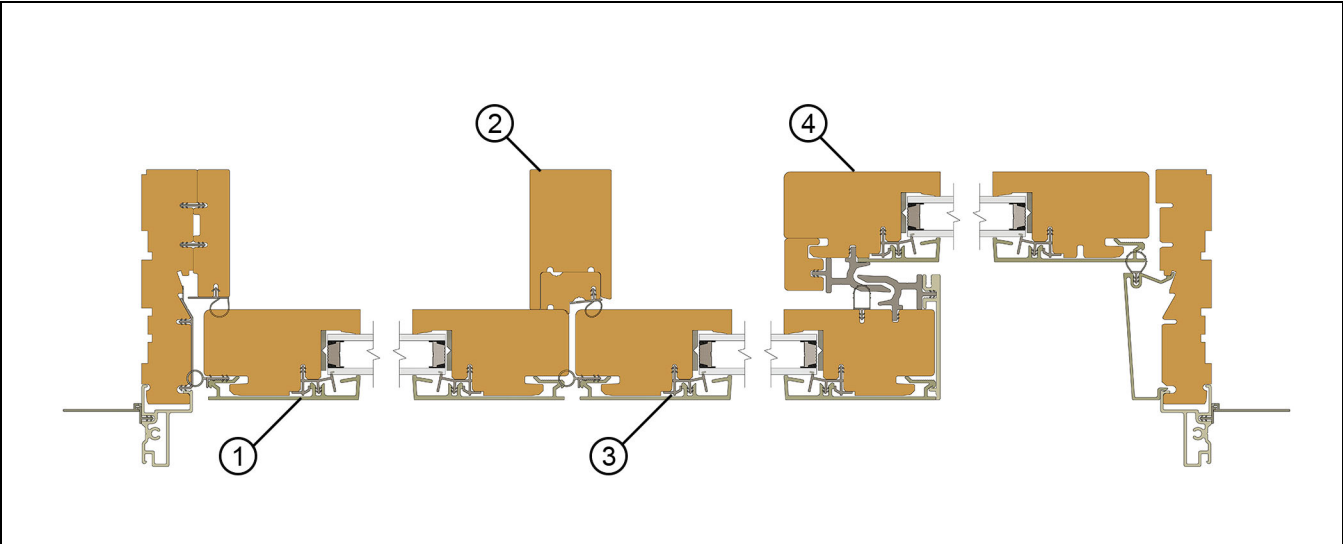


Figure 45 OOX/XOO (OOX shown)

1	Stationary panel (at jamb)
2	Astragal cover on stationary panel (at jamb)
3	Stationary panel (with interlock)
4	Operator panel

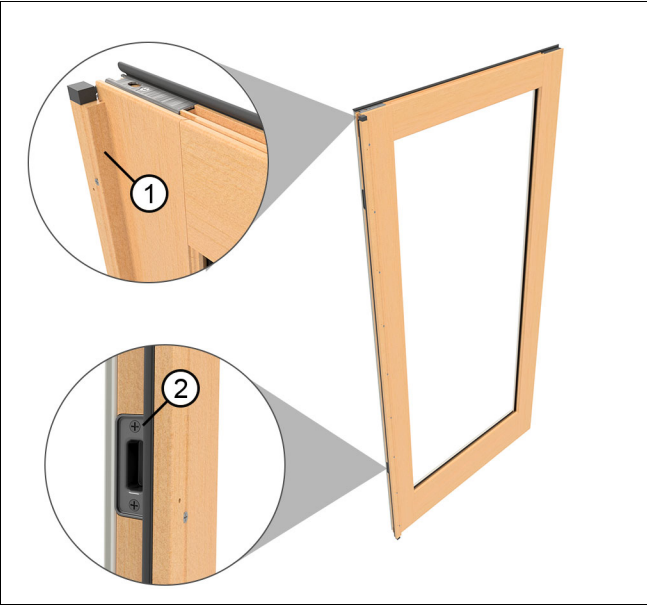


Figure 46 Non interlocking (jamb side) stationary panel with wood astragal base

1	Wood astragal base
2	Alignment bolt receiver

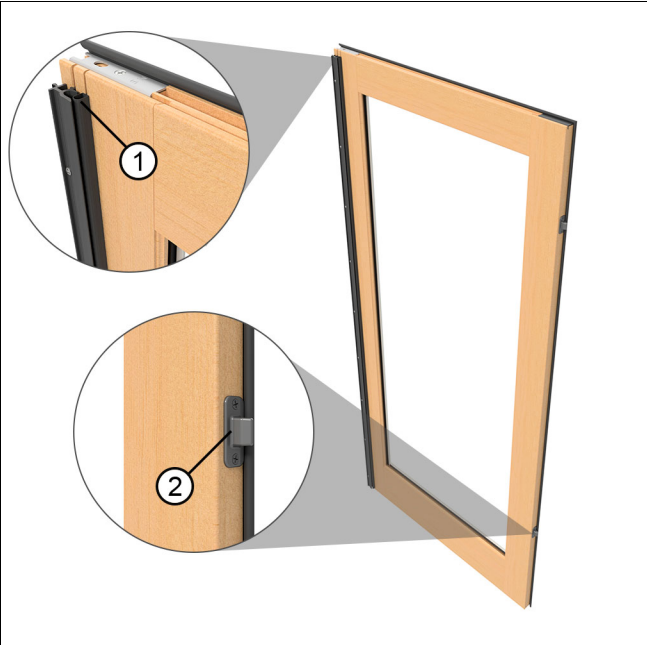


Figure 47 Interlock stationary panel (center stat panel)

1	Interlock
2	Panel alignment bolts

1. Install the weatherstrip jig. Install the leading edge of the jig under the weather strip bulb, then rotate the jig so the back edge snaps onto the interior leg of the weather strip. [See Figure 48.](#)

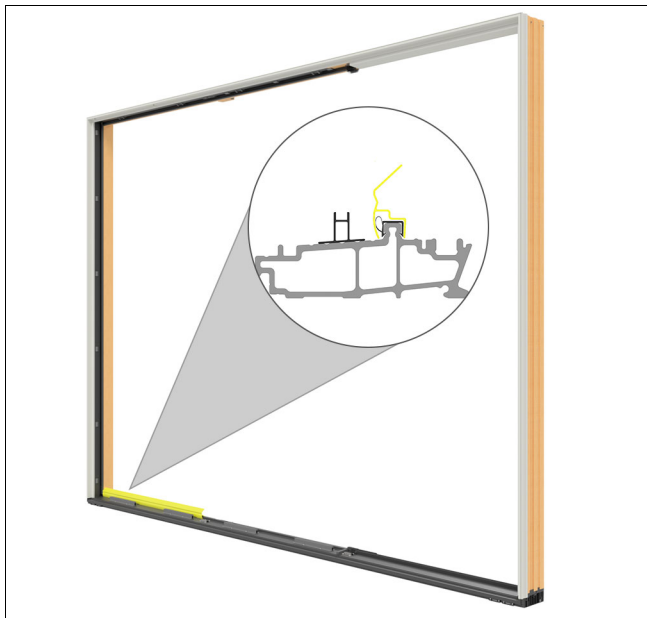


Figure 48

2. From the exterior, set the stationary panel (with the alignment bolt receivers and wood astragal base) onto the sill stationary block close to the jamb. The block corresponds to a groove in the bottom of the panel.

3. Tip the frame up and have at least one other person hold the frame in place.

4. From the exterior set the stationary panel (with interlock) onto the sill stationary blocks, close to the jamb. The block corresponds to a groove in the bottom of the panel. [See Figure 49.](#)



Figure 49

1	Exterior stationary block
---	---------------------------

5. Slide the panel past the aluminum parting stop to the jamb. Now push the panel in until it contacts the wood parting stop. Clips at the head jamb will hold the panel in place and aid in alignment. [See Figure 50.](#)

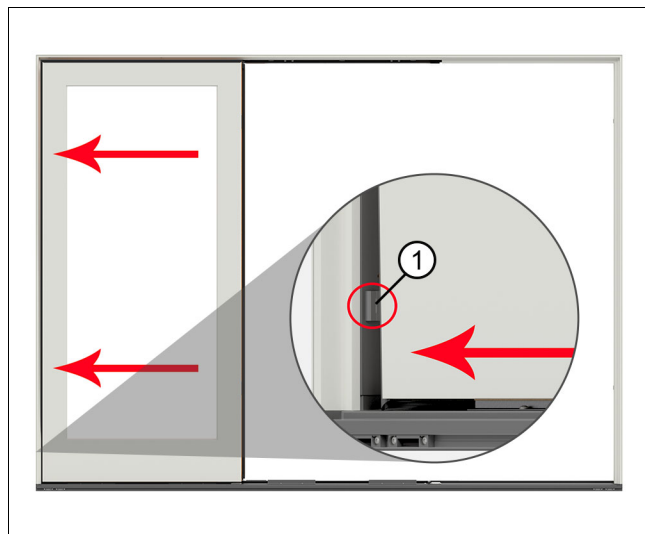


Figure 50

1	Frame spacers
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6. Install the end of the stationary bolt into the head jamb plate. Fasten to the stationary panel with the two #8 x 3" screws. Note that the top screw is installed at an angle. See Figure 51.

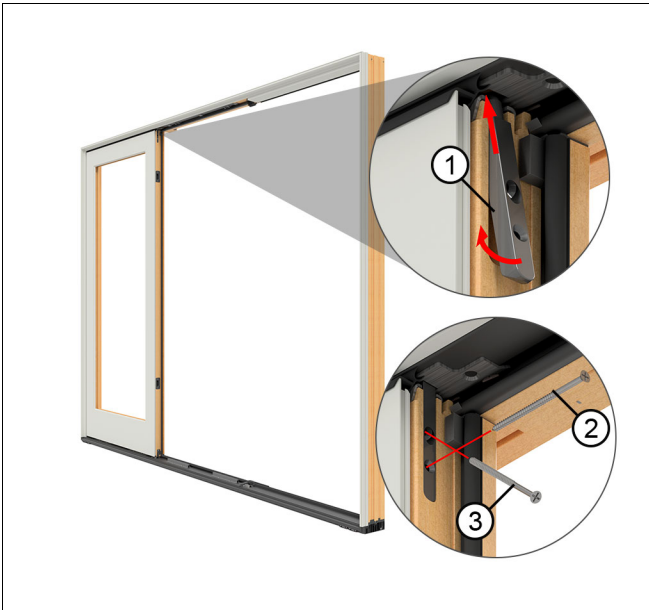


Figure 51

1	Top stationary bolt
2	#8 x 3" screw(2x)
3	Install at an angle

7. Install the sill to panel bracket. Slide the bracket under the sill bracket (attached to the sill). Then fasten to the stationary panel with #8 x 3" screws provided. See Figure 52.

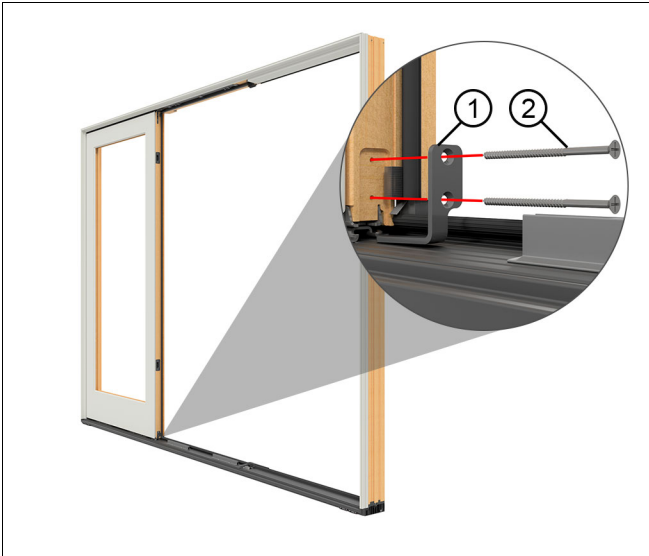


Figure 52

1	Sill to panel bracket
2	#8 x 3" screws

8. Hold the panel in place and use the holes in the side jamb to pre-drill into the panel with a 1/8" drill bit. See Figure 53.

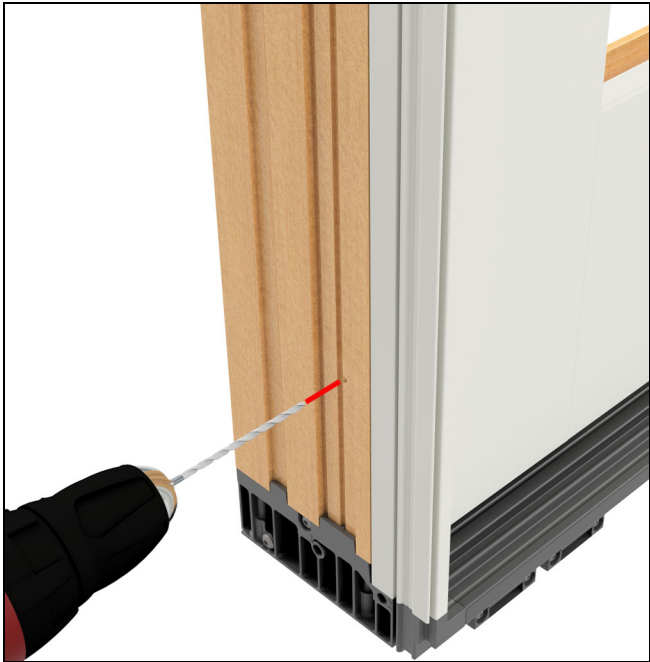


Figure 53

**CAUTION!**

Do not drill deeper than 3". If you drill deeper than 3" you will break the glass.

**Hint**

Use a combination square along the jamb to maintain a consistent panel depth. Check the depth at the bottom first to set your combination square dimension. Check along the length of the side jamb before pre-drilling and fastening. 4 9/16 jams will be about 2 5/8" and 6 9/16 will be about 3 3/16". See Figure 54.

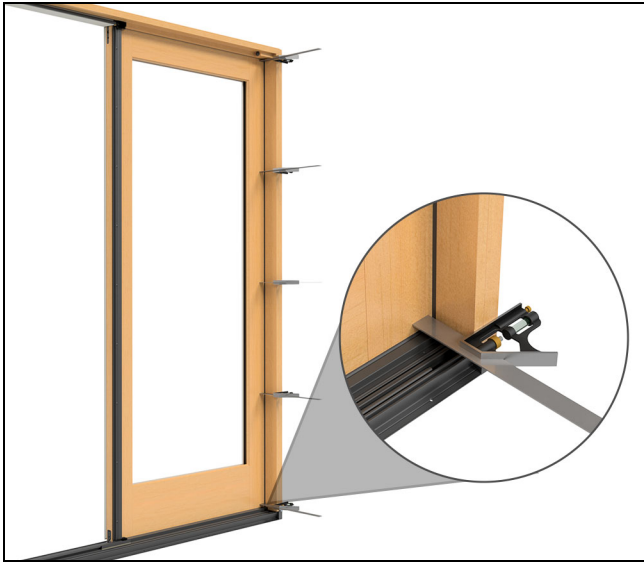


Figure 54

9. Fasten the jamb to the panel with the #8 x 3" flat head screws. [See Figure 55.](#)

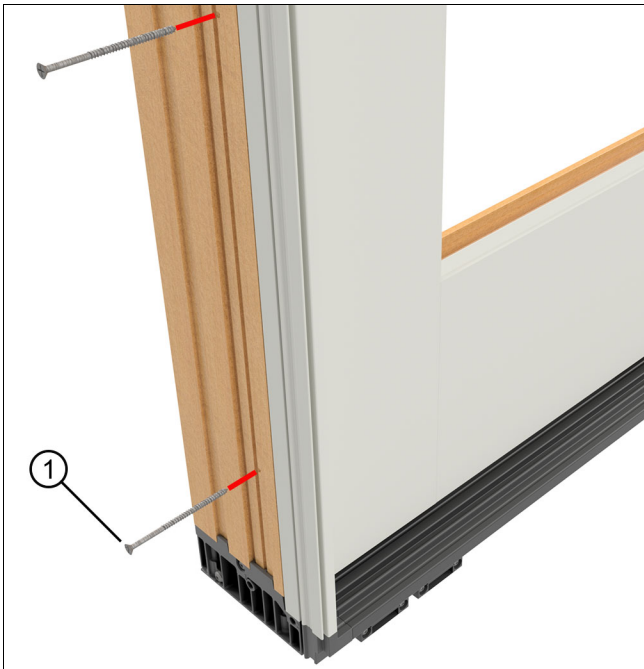


Figure 55

1	#8 x 3" flat head screw
---	-------------------------

10. Remove the weatherstrip jig from the exterior side and install on the interior side. [See Figure 56.](#)

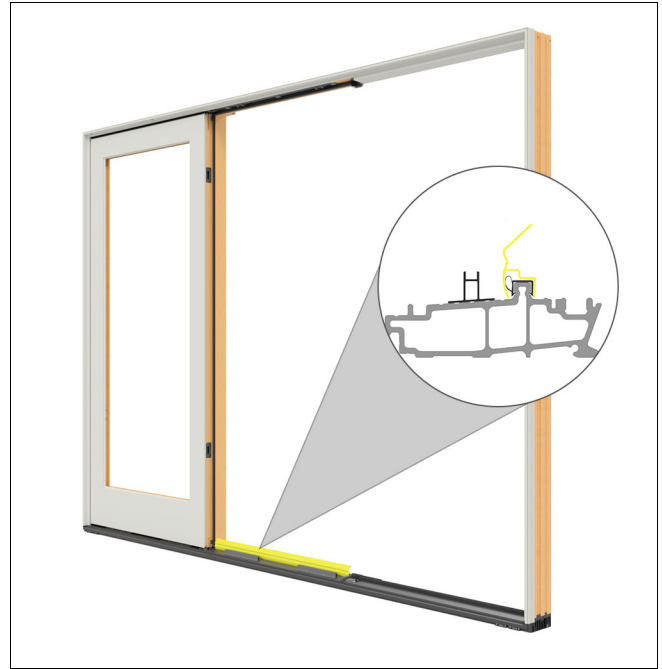


Figure 56

11. Before installing the second panel, attach the mull cover to the mull base with #7 x 2" screws. Use the pre-drilled holes in the astragal base as a guide. See Figure 57.

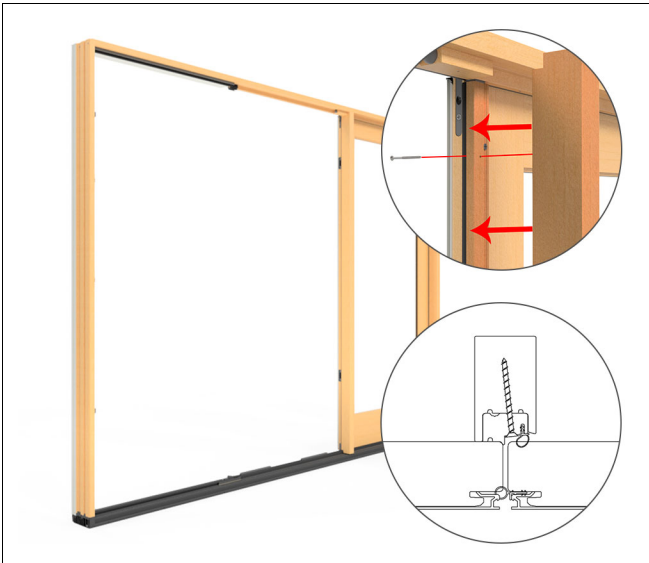


Figure 57

12. Set the stationary panel (with interlock) onto the sill stationary block. The block corresponds to a groove in the bottom of the panel. Tip the panel in until it hits the head jamb parting stop. Slide the panel over as the alignment bolts engage in the receivers from the first panel. See Figure 58 and Figure 59.

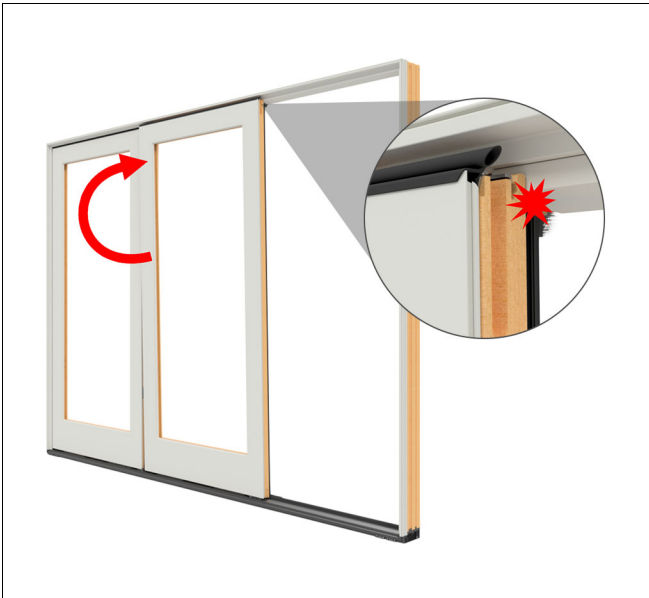


Figure 58

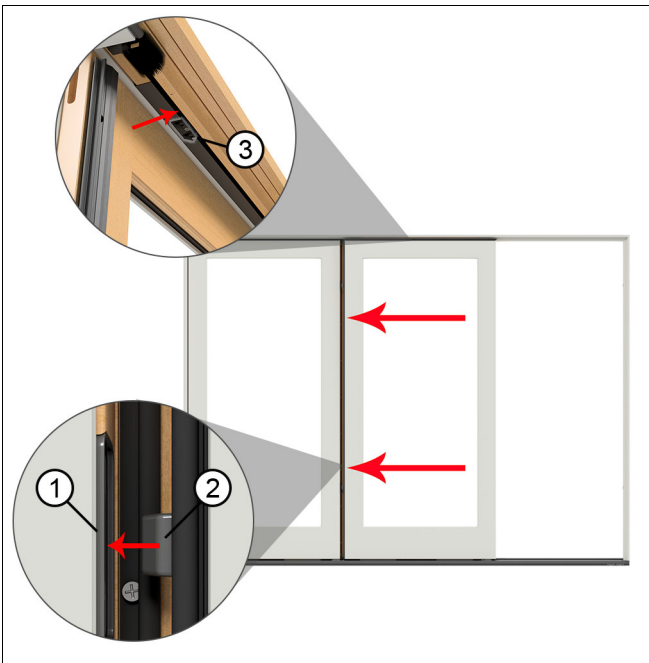


Figure 59

1	Stationary panel bolt receiver
2	Interlock stationary panel alignment bolt
3	Panel retainment clips

13. Install the end of the stationary bolt into the head jamb plate. Rotate the bolt into place and fasten to the stationary panel with the two #8 x 3" screws. Note that the top screw is installed at an angle. See Figure 60.

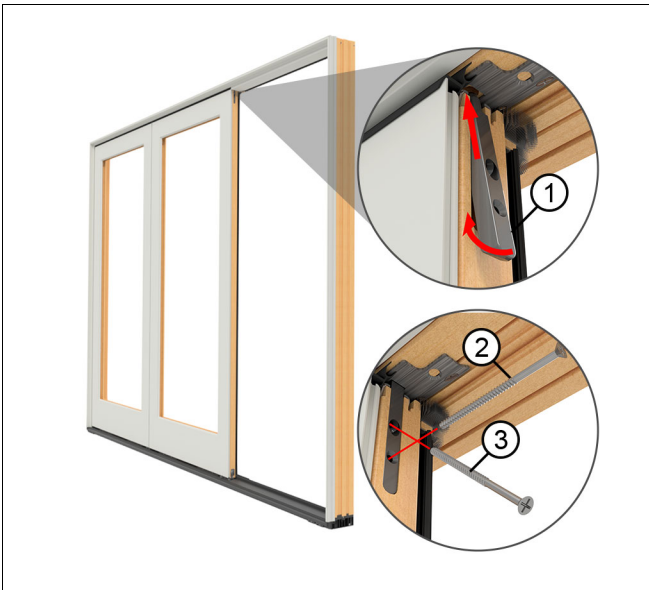
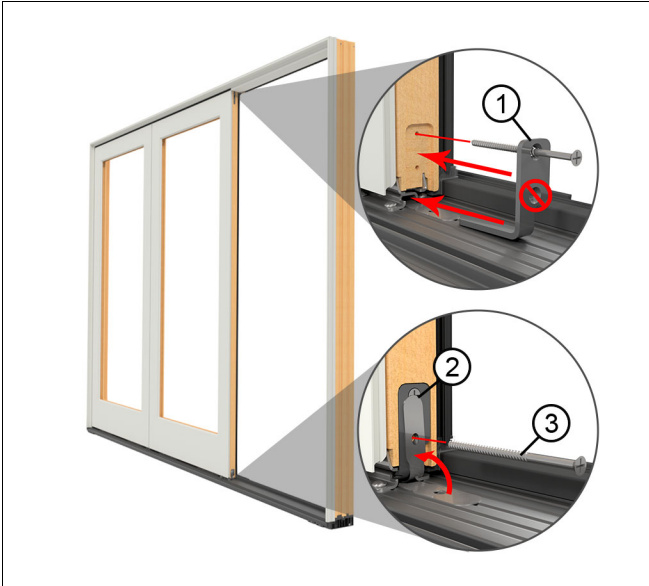


Figure 60 REMOVE ICON

1	Top stationary bolt
2	#8 x 3" screw
3	#8 x 3" screw (installed at and angle)

**14.** Install the sill to panel bracket. Slide the bracket under the sill bracket (attached to the sill). Then fasten to the stationary panel through the top screw hole with #8 x 3" screws. Bend the panel strap up and fasten using the bottom screw on the sill bracket. See [Figure 61](#).

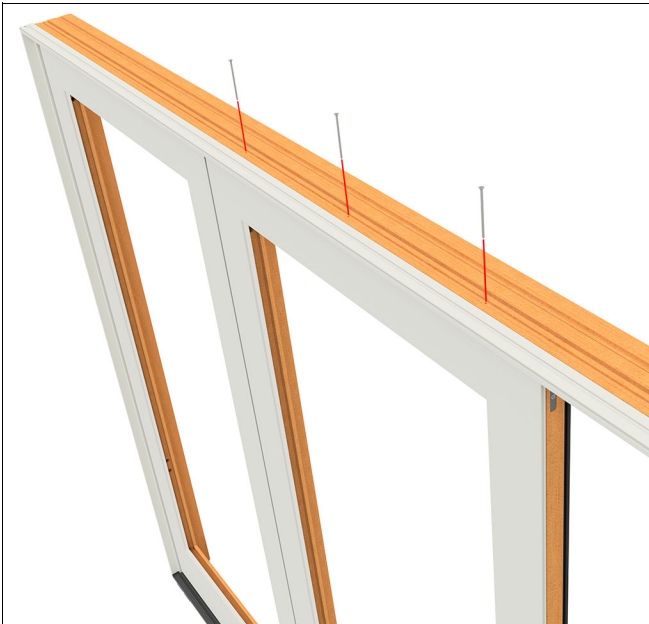


**Figure 61**

1	Sill to panel bracket
2	Panel strap
3	#8 x 3" screw

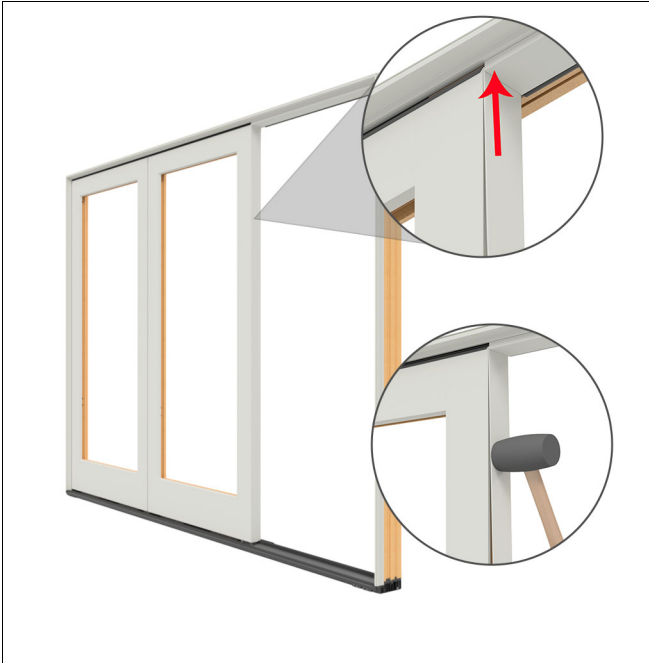
**15.** Remove the weather strip jig. Pull up on one end and work your way along the jig

**16.** Fasten the center stationary panel with #8 x 3" screws at the head jamb. See [Figure 62](#).



**Figure 62**

**17.** Install the aluminum edge cover on the stile of the interlock stationary panel. The cover will snap onto the interlock and edge of the secondary panel. Seat the cover with a rubber mallet. See [Figure 63](#).



**Figure 63**

**18.** Follow installation instructions for installation into the RO and operator panel installation.

---

## Install the Screen Track

1. On OXXO and OXO configurations, the screen track will come in two parts. OX/XO configurations have one screen track. Install with #7 x 3/8" self tapping screws through the pre-drilled holes in the track. [See Figure 64.](#)

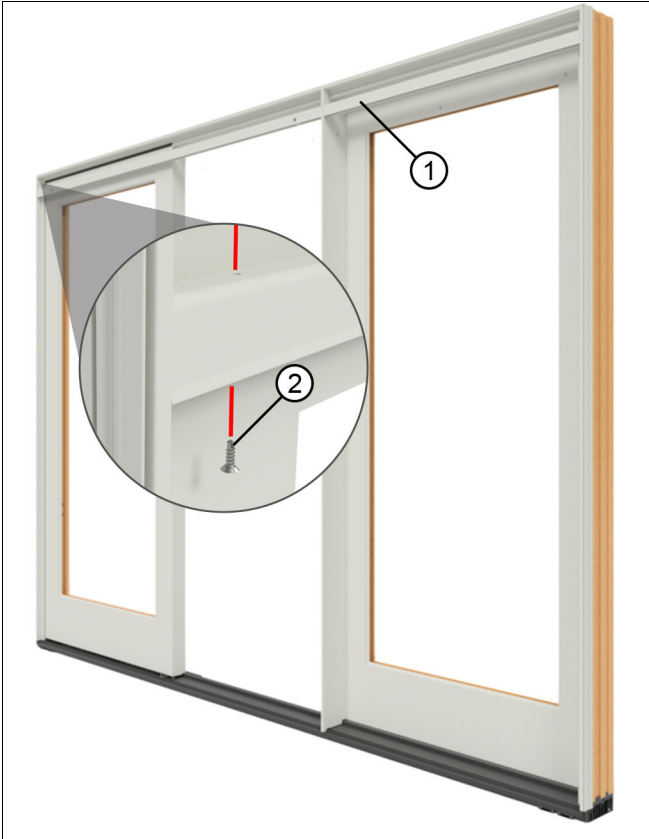


Figure 64 OXO shown.

1	Screen track
2	#7 x 3/8 self tapping screws.