



PATIO SLIDING DOOR KNOCK-DOWN FIELD ASSEMBLY

Addendum Guide

IMPORTANT NOTICES & INFORMATION

The building envelope must be correctly prepared with weather resistant barriers – that meet local and state codes. All frame and sill surfaces must be correctly prepared for air, water, and structural integrity by the builder or contractor before attempting installation. In order to meet warranty requirements, all systems are required to be installed by a certified installer.

- Read these instructions in their entirety prior to installing windows. Contact Loewen at 1.800.563.9367 for clarification.
- Loewen is not responsible for site measurements nor the structural and architectural requirements for the installation.
- Building design, construction methods, building materials and site conditions unique to your project may require methods different from these instructions.
- Choosing the appropriate method is the responsibility of you, your architect, or your construction professional.
- Confirm with sealant/foam/barrier manufacturers that all materials used are compatible with one another.
- Remove shipping blocks and related staples prior to installation.
- All drawings are shown not to scale.
- To ensure accuracy, make sure you have the latest approved shop drawings and assembly and installation guides.
- Any local, regional or national building code requirements supersede these instructions.
- Safety is top priority for Loewen. Use proper work procedures and protective equipment.

Notes on Building Envelopes

Improper design and/or non-conforming application of building envelope materials has been demonstrated to cause premature building envelope failure. Even with premium materials, shortcuts and errors in the final installation can impact budgets, time frames, building life span, and increase legal liabilities.

As one of the elements that bisect the interior/exterior plane, window and door integrations are a critical element of the building envelope as a whole. Poor installations can carry significant liability, due to building envelope failure.

PATIO SLIDING DOOR KNOCK-DOWN FIELD ASSEMBLY GUIDE ADDENDUM

Material Required

Quantity	Part Number	Description
2 per fixed panel	297837A	Sealant - Dymonic FC Buff
1	70006A	Sealant - TremGlaze S600
2	49819A	Sealant - Bostik Pro MS50
2	44903KEYALA	Corner key for 116mm frame
2	49501A	Corner key for 166mm frame
2	444518MMA	White foam track gasket
46	316139A	#8 x 2 1/2"
4	70201A	#6 x 1 1/2" screw
2	70200A	#6 x 3/4" screw
1 per 6"	308723A	#8x 1/2" screw (nailing flange through metal)
1 per 6"	71461A	#8 x 5/8 screw (nailing flange through wood)
2	49808BLKA	Foam jamb block
1	714559A	Masking tape
2	N/A	Drain caps
2	264938A	Interior fixed panel molding 2400mm (8')
1 per fixed panel	44417SILL3950A	Sill trough cover

Tools Required

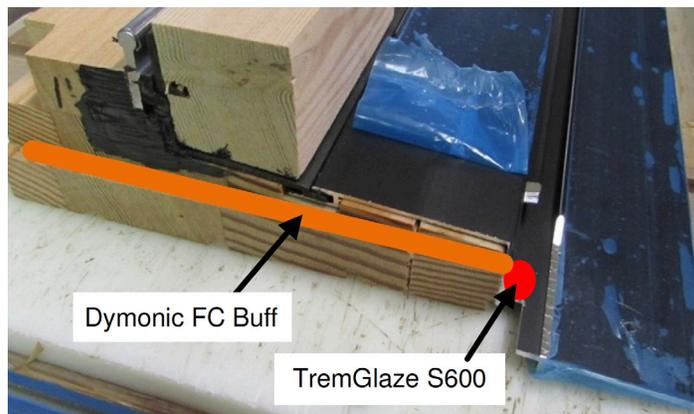
- a. Drill
- b. Drill bits
- c. Driver bits
- d. Sealant Gun
- e. Putty Knife
- f. Dead Blow Hammer



FRAME ASSEMBLY

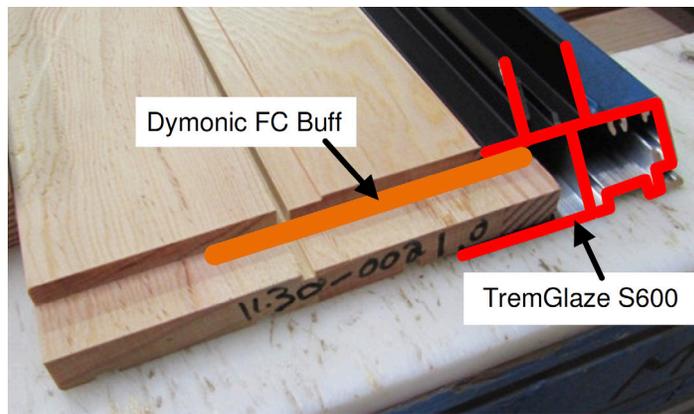
1. Sill Sealant Application

- a. Apply a continuous 5mm bead of Dymonic FC Buff (#297837) on sill end tenon as shown.
- b. Apply a 1/2" dab of TremGlaze S600 clear sealant as shown.



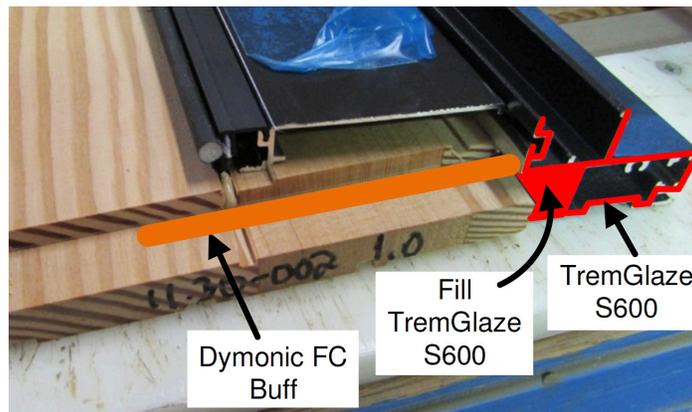
2. Jamb Head Sealant Application

- a. Apply a continuous 5mm bead of Dymonic FC Buff on jamb tenon as shown, where jamb and head will mate.
- b. Apply a continuous 4mm bead of TremGlaze S600 clear on profile edge of frame cladding as shown.



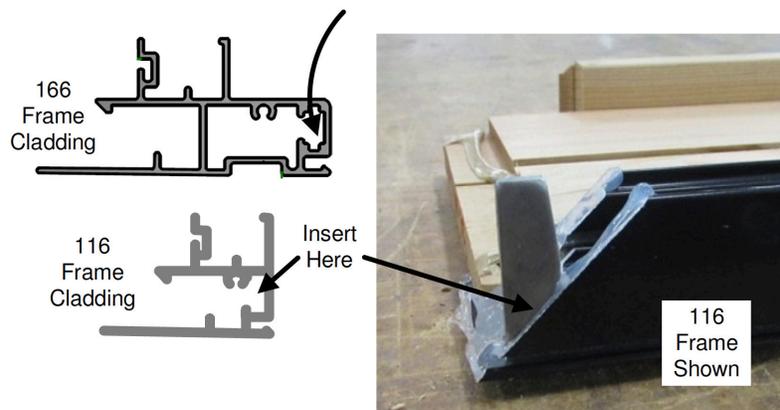
3. Jamb Bottom Sealant Application

- a. Apply a continuous 5mm bead of Dymonic FC Buff on jamb tenon as shown, where jamb and sill will mate.
- b. Fully fill 50mm (2") deep into end of frame cladding with TremGlaze S600 clear sealant and apply a continuous 4mm (1/8") bead on profile edge as shown.
- c. Repeat with opposite jamb.



4. Corner Key and Gasket Application

- a. Insert corner key into top end of jamb frame cladding.
- b. Repeat with opposite jamb.



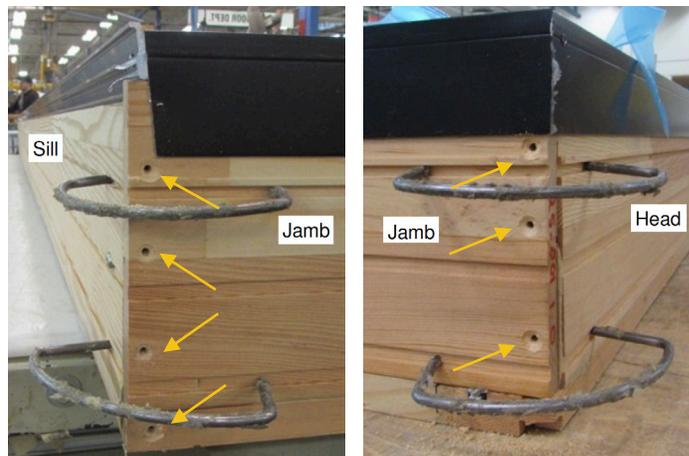
- c. Apply white foam gasket (#444517MMA) onto end of sill track.
- d. Repeat on opposite end of sill.



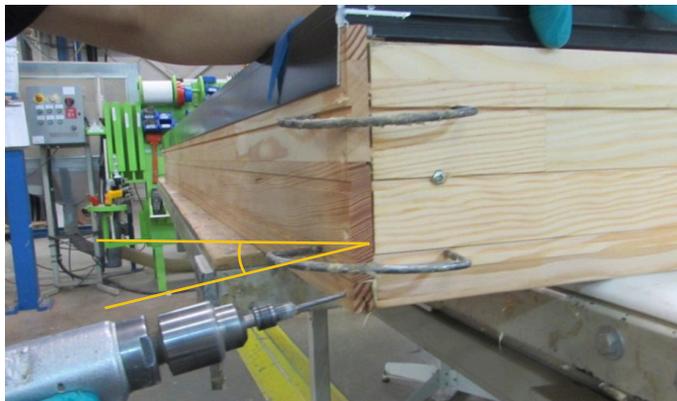
5. Frame Corner Assembly

- a. Bring frame parts together. Hold together using corner clamps.
- b. Pre-drill 3 - 3/32" countersunk holes, 2 1/2" deep, through jamb into head/sill at each corner.

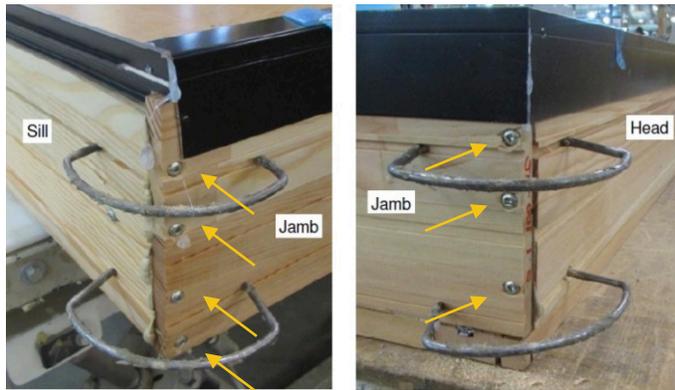
Note: Locate holes 9mm from ends of jamb.



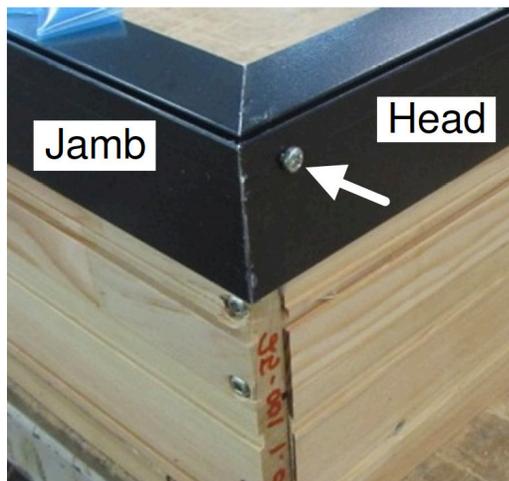
- c. Pre-drill 3/32" countersunk hole, 1 1/2" deep, through interior side stop into sill.
Note: Pre-drill at an angle as shown
- d. Repeat with opposite side stop.



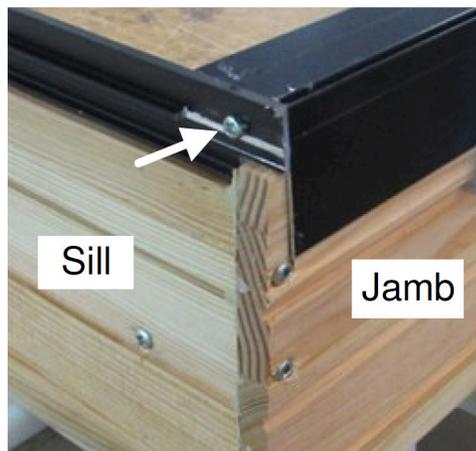
- e. Pre-drill and secure frame corners with #8 x 2 1/2" deep screws (#316139).
- f. Fasten interior side stop to sill with #6 x 1 1/2" screw (#70201).
- g. Repeat with opposite side stop.



- h. Secure head cladding to jamb cladding with #6 x 1 1/2" screw (#70201).
Note: Ensure there is ooze out along entire corner joint seam.
- i. Repeat step with entire corner joint seam.



- j. Secure sill cladding to jamb cladding with #6 x 3/4" screw (#70200).
- k. Repeat with opposite sill/jamb joint.
- l. Clean excess sealant.



- m. Attach foam block (#49808BLK) onto lock side jamb.
Note: Step m. applies to 2 wide or 3 wide units only.



6. Fixed Panel Installation Prep

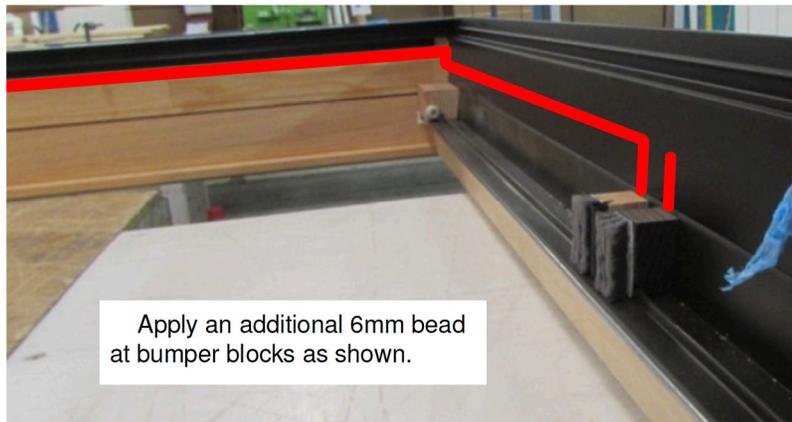
- a. Apply a continuous 6mm (1/4") bead of Dymonic FC Buff (#297837) onto head as shown.



- b. Continue with a 6mm (1/4") from head onto jamb.
- c. Continue with 6mm bead from jamb onto sill. Ensure jamb and sill bead touch.



- d. Continue bead across sill to blocks, as shown.



7. Fixed Panel Installation

- a. Lay the fixed panel into frame beginning with top end against head extension and lowering bottom end onto sill blocks.

Note: Keep panel as close to jamb as possible without rubbing the jamb cladding

- b. Slide panel against jamb.



- c. Ensure panel is tight to jamb and tight to frame cladding lip, clamp as required.



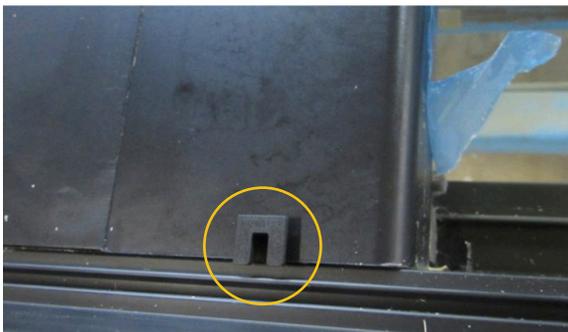
- d. Pre-drill 7/64" holes through frame into panel along top, side and bottom. Pre-drilling 150mm from each corner and evenly spaced every 400mm.



- e. Secure fixed panel in frame with #8 x 2 1/2" screws (#316139) in each hole.
Note: Begin inserting screws along side first, then head, then sill.

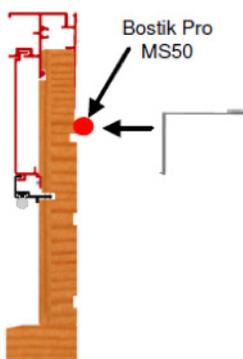


- f. Insert drain cap into fixed panel drain hole as circled



8. Galvanized Nailing Flange Application

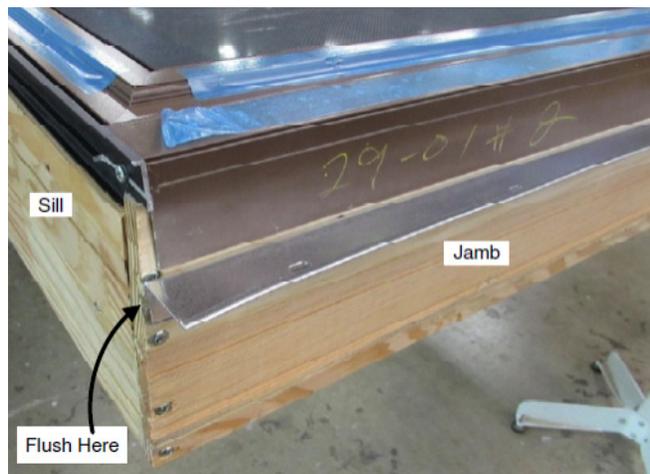
- a. Apply a continuous 5mm bead of Bostik Pro MS50 sealant (#49819) along jambs and head where the flange will be attached, between frame and flange.



- b. Secure side flange to jamb, placing screws 25mm from each end and through each pre-punched hole
 - i. If screws go through frame cladding then use #8 x 1/2" screws (#308723A).
 - ii. If screws go into frame wood only then use #6 x 5/8" screws (#71461A).
 - iii. Note: Ensure flange is consistently tight against the unit on all sides.



- c. If flange is too long, cut bottom end flush with bottom of unit.
- d. Repeat step b and c with opposite side flange.



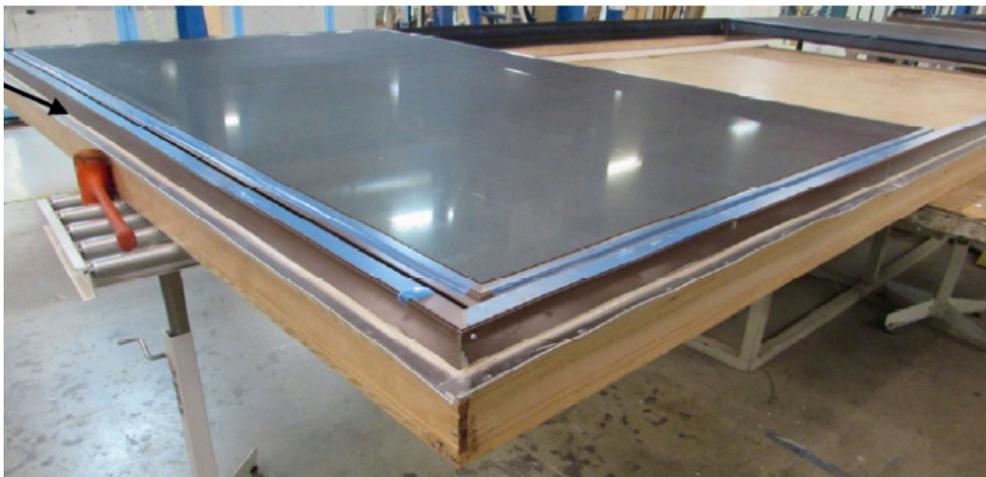
- e. Apply a 5mm bead of Bostik Pro MS50 sealant (#49819) in X pattern on side flange, as shown below, where head flange will overlap.



- f. Secure head flange to head ensuring ends lap over side flange ends, compressing the sealant applied in step e.



- g. Apply a continuous 5mm bead of Bostik Pro MS50 along exterior where flange and frame meet.
Note: Ensure there are no voids in the sealant between flange and frame.
- h. Clean excess sealant at overlap.



9. Fixed Panel Interior Moulding Installation

- a. Apply a 3mm bead of Dymonic FC Buff sealant (#297837) along interior joint between fixed panel and jamb.

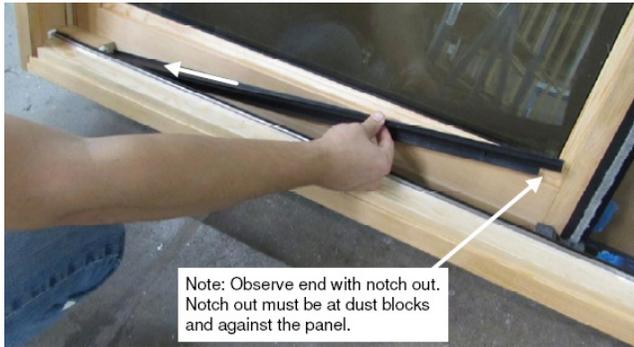


- b. Fasten interior moulding to jamb with 1 1/4" light finishing or pin nails, spaced 150mm (6") apart. (Not included).



10. Sill Trough Cover Installation

- a. Slip end of sill trough cover under bumper



- b. Bow sill trough cover and place notched end against dust block



- c. Allow sill trough cover to drop into place.



11. Operating Panel Installation

- a. Guide top of panel into head track directly behind fixed panel, then rest bottom rollers onto sill track.

Note: Ensure rollers are riding on metal track, not vinyl track

- b. Adjust panel rollers, as required, for easy rolling.



- c. Assembly complete



11. Operating Panel Installation

Tools Required

- a. Suction Cups
- b. Driver (if an astragal needs to be removed)
- c. Flat Screwdriver



2 Wide OX

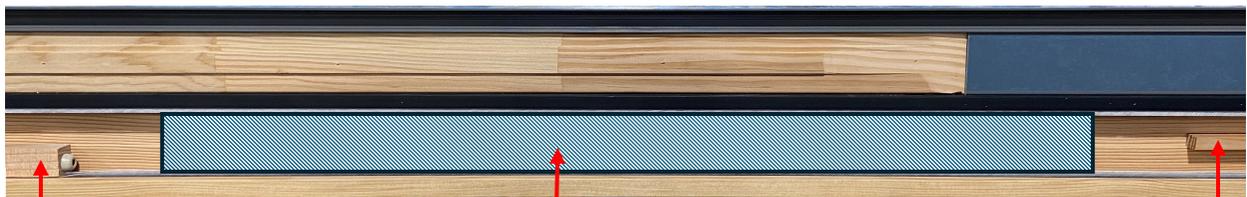


4 Wide OXXO



2 Wide XO

When installing the panels, ensure they are positioned between the sash bumper and the security rail.



Sash bumper

panel

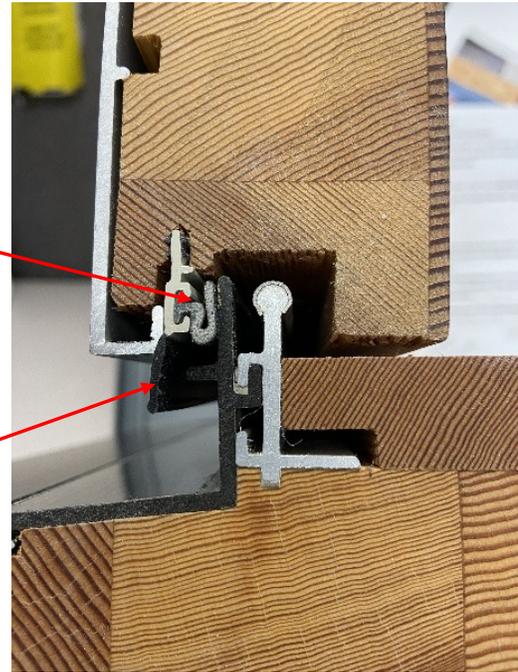
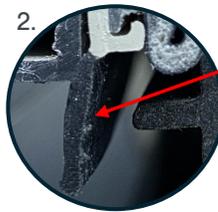
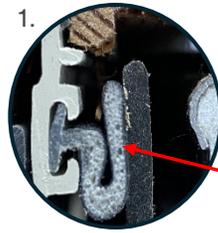
security rail

- a. Maintain an even, vertical lift until there is enough clearance to seat the bottom of the panel onto the sill track.



b. Ensure the panel is properly seated on the rollers before sliding.

- A-Weatherstrip tight against sill thermal break.
- B-Fin is sitting completely outside of sill thermal break. (not folded under)
- Panel is sitting centered on the sill track.



c. Measure both ends of the sash to ensure the dimensions are consistent.



d. If panel is not positioned correctly, remove panel and reinstall

12. Removing Astragals (Astragal needs to be removed before installing panel or removing panel)

- a. Remove all screws through the astragal and strike plate



- b. Starting from the bottom of panel, remove astragal

- Using both hands, pull the astragal away from the panel. Maintain a firm grip, as the astragal may release suddenly

- c. Panel is ready to install, follow same procedure as on pages 21 and 22



13. Re-applying Astragal

- a. Fit on astragal
- b. Ensure astragal and panel are flush at the bottom of the panel
- c. Align and press the astragal evenly onto door edge



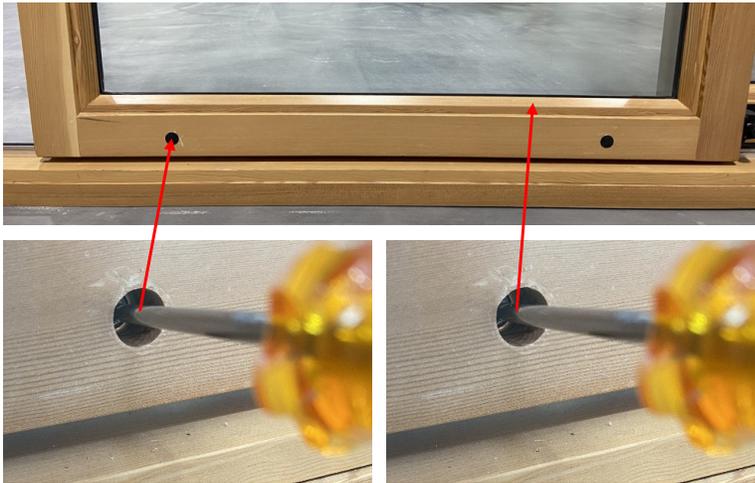
14. Refasten Astragal

- a. Drive the 3 screws back into their designated positions on the astragal
- b. Drive 2 screws into the center point of the elongated holes to allow for future adjustment.
- c. See anchoring strike plate Page 26
- d. See page 25 for roller adjustment and page 26 for strike plate alignment.



15. Roller Adjustments

- a. Use a flathead screwdriver
- b. Rotate clockwise to raise panel
- c. Rotate counterclockwise to lower panel



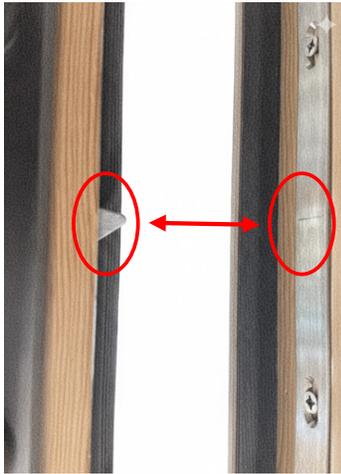
- d. Raise both rollers approximately 10mm (3/8" of an inch).
- e. Test the panel for smooth operation. It should slide smoothly.
- f. Readjust slightly if necessary to achieve the best sliding ease.
- g. Caution- Do not over raise the panel. Lifting it too high will prevent
- h. the weatherstripping from sealing properly against the sill.



IMPORTANT - While adjusting rollers, alleviate the weight of the panel, some of the ways this may be done is to manually lift panel by hand, or with suction cups.

16. Strike Plate Adjustments

- a. Align pin on panel hardware with the line on the strike plate
 - Slide the panel toward the strike plate on the side jamb or astragal until the hardware aligns visually with the plate. As seen below.
 - Ensure the panel hardware pin is centered on the alignment marking located on the side jamb or astragal strike plate.
 - Screws in the elongated holes can be loosened for adjustment before being retightened



- b. Anchoing strike plate
 - a. Install two 8x 2 1/2 inch stainless steel screws into the outer holes of the strike plate (located on either the astragal, or the side jamb). These screws are supplied in hardware package



Astragal

Side Jamb



IMPORTANT - Ensure the side jamb is properly shimmed between the door frame and the rough opening to maintain alignment.

Information subject to change without notice.

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