

Appendix –B–

*Addendum for
Four (4) Panel
Patio Door*



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Table of Contents

REVISION:

PAGE:

B-i

SECTION 1 INTRODUCTION

1.1 Introduction

1.1.1 All P.V.C. Welded Frame Section.....B-1

1.2 Catalog of Parts

1.2.1 Profiles for the Frame.....B-2
1.2.2 Required Hardware for the Frame.....B-3

1.3 Assembly Drawings

1.3.1 Sill Assembly Section.....B-5
1.3.2 Head Assembly Section.....B-6
1.3.3 Jamb Assembly Section, Right Panel Side.....B-7
1.3.4 Jamb Assembly Section, Left Panel Side.....B-8

SECTION 2 MANUFACTURING

2.1 Manufacturing

2.1.1 Introduction to Manufacturing Instructions.....B-9
2.1.2 Frame Drainage.....B-10
2.1.3 Operating Support Panel Drainage.....B-14
2.1.4 Bottom and Top Fixed Support Panel Cut-out.....B-15
2.1.5 Sill Protector Drainage.....B-16

2.2 Assembly Procedure

2.2.1 Introduction to Assembly Procedure.....B-17
2.2.2 Head Screen Track Installation.....B-18
2.2.3 Operating Support Panel Installation.....B-19
2.2.4 Head Track Installation.....B-20
2.2.5 Foam Tape Installation.....B-21
2.2.6 Bottom Fixed Support Panel Installation.....B-22
2.2.7 Fixed Panel Installation.....B-23
2.2.8 Top Fixed Support Panel Intallation.....B-24
2.2.9 Molded Fixed Panel Anchor Block Installation.....B-25
2.2.10 Sealing Jamb, Fixed Side.....B-26
2.2.11 Fixed Panel, Final Installation.....B-27
2.2.12 Sealing Fixed Panel.....B-28
2.2.13 Mullion Fabrication and Assembly.....B-29
2.2.14 Operating Panel Installation.....B-30
2.2.15 Sill Protector Installation.....B-31
2.2.16 Aluminum Outside Sill Cladding Installation.....B-32
2.2.17 Head Weatherseal Installation.....B-33
2.2.18 Sash Stopper Installation.....B-34



Table of Contents

REVISION:

PAGE:

B-ii

2.3 Bill of Material

2.3.1 Required Material for Four (4) Panel Door.....B-35

2.4 Standard Dimensions

2.4.1 Standard Widths for Four (4) Panel Door.....B-36

2.4.2 Standard Heights for Four (4) Panel Door.....B-37

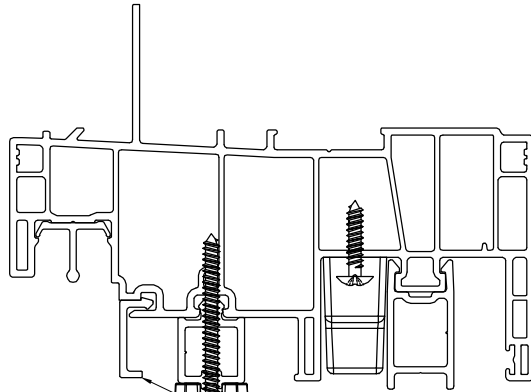
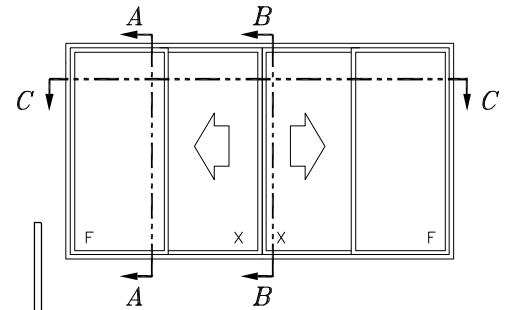
1.1 Introduction

REVISION:
2012/02/02

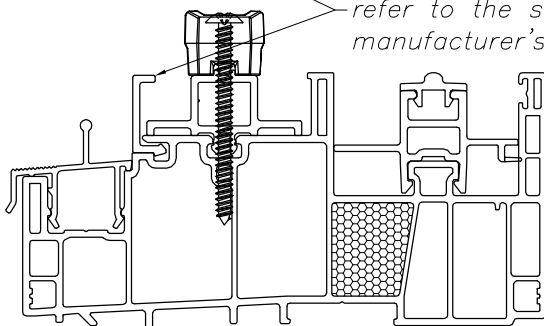
PAGE:
B-1

1.1.1 All P.V.C. Welded Frame Section

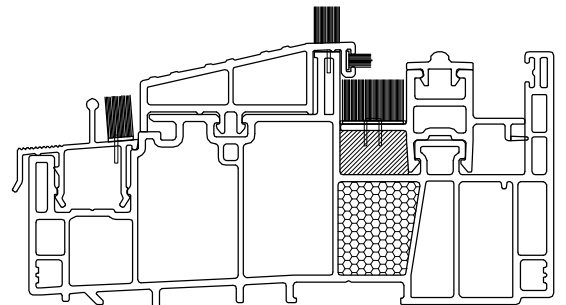
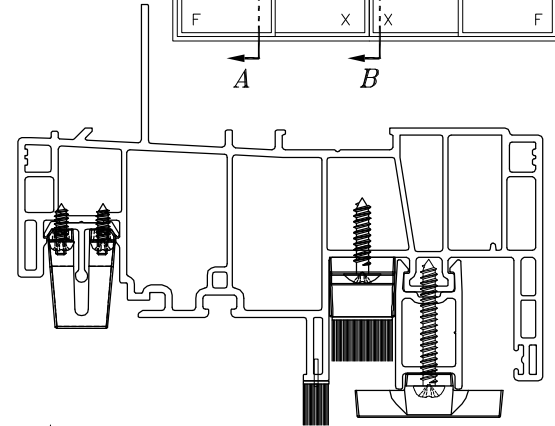
Four (4) Panel Patio Door



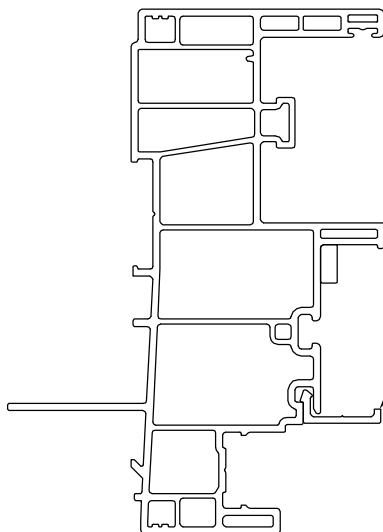
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refer to the sash section of this
manufacturer's handbook.*



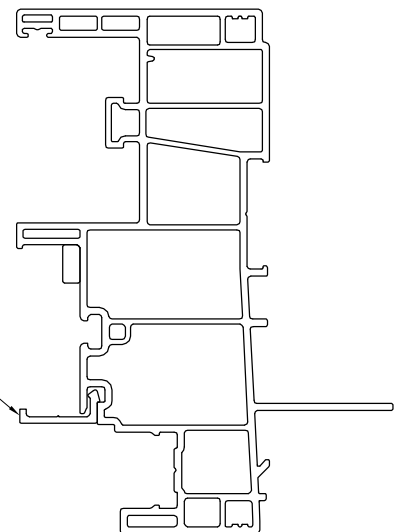
Section A-A



Section B-B



*Depending on the sashes used,
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Section C-C

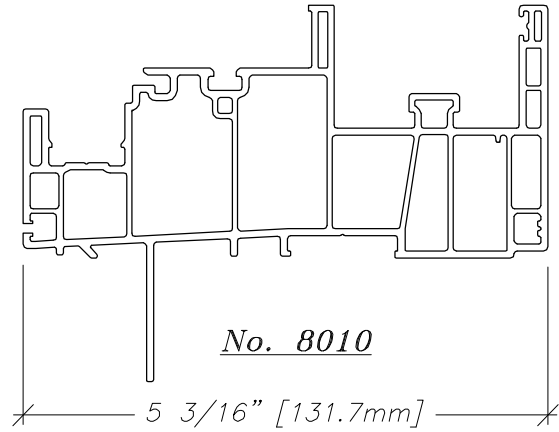
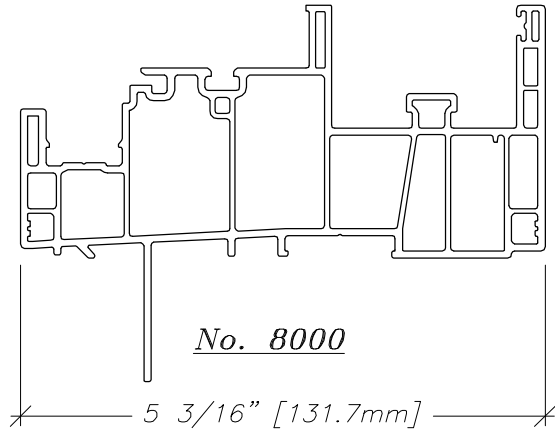
1.2 Catalog of Parts

REVISION:
2011/04/28

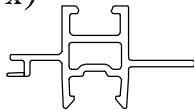
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B-2

1.2.1 Profiles for the Frame

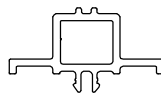
Main Frame (Sold in 16' [4.88m] length)



Operating Support Panel
No. 8021 (1x)



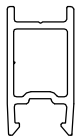
Bottom Fixed Support Panel
No. 8001/8101 (2x)



Top Fixed Support Panel
No. 8022/8122 (2x)



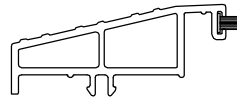
Head Track No. 8002 (1x)



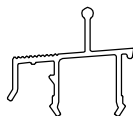
Head Screen Track No. 8012 (1x)



Sill Protector No. 8011/8111(1x)
-Weatherstrip No. 8988
(Schlegel No. FS-7630-187) (1x)



Aluminum Outside Sill Cladding
No. 9791 (1x) (Sold in 16' [4.955m] length)



Aluminum Rolling Rail No. 9790 (1x)
(Sold in 16' [5.400m] length)



1.2 Catalog of Parts

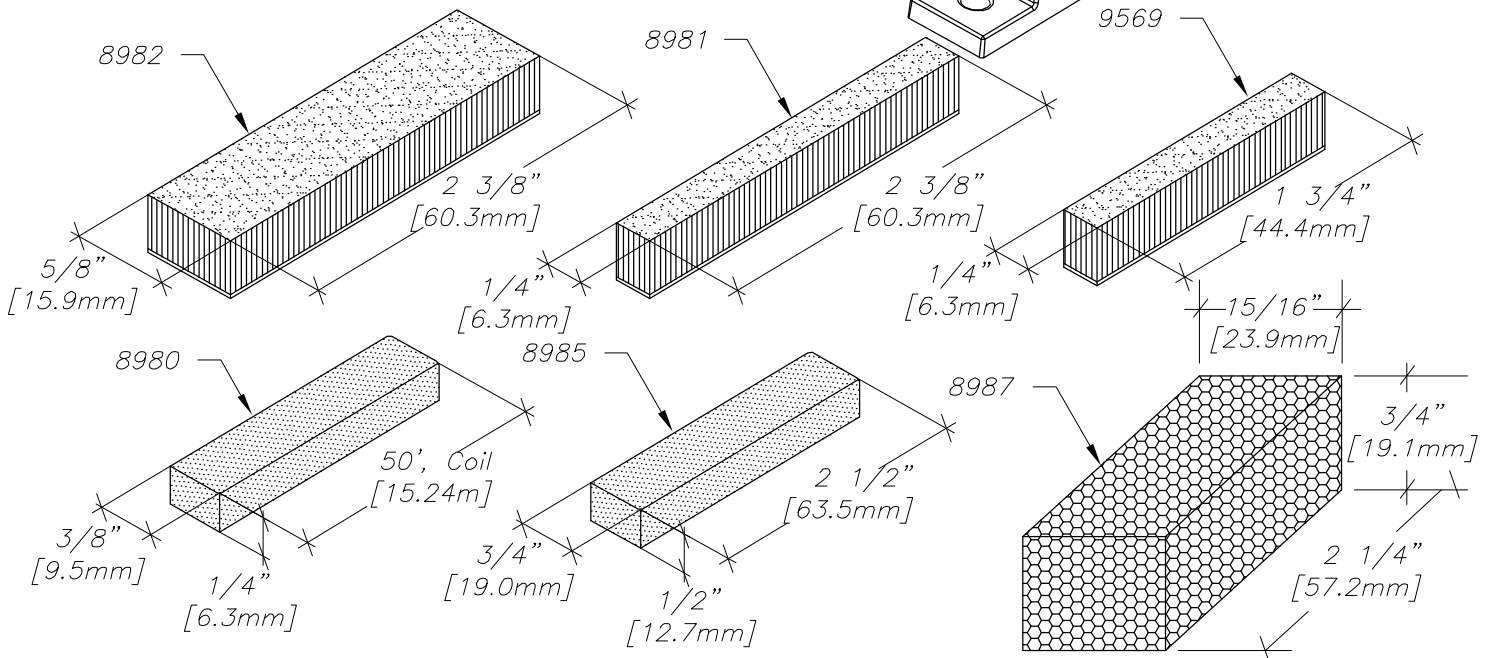
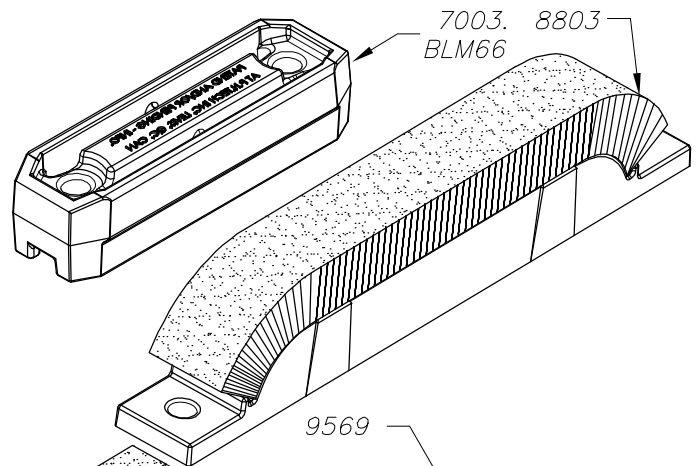
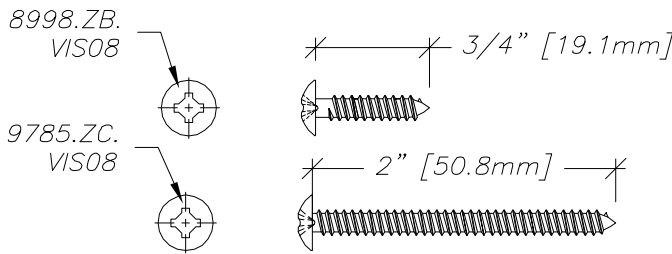
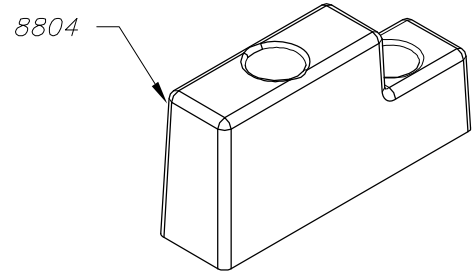
REVISION:
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PAGE:
B-3

1.2.2 Required Hardware for the Frame

Hardware List

- Molded fixed panel anchor block No. 7003.BLM66 (4x)
- Head weatherseal No. 8803 (3x)
- Sash stopper No. 8804 (2x)
- Foam tape No. 8980 (50', coil)
- Interlock dust plug No. 8981 (4x)
- Sill dust plug No. 8982 (3x)
- Sill foam block No. 8985 (2x)
- Insect stop foam No. 8987 (2x)
- Insect stop No. 9569 (3x)
- No. 8 x 3/4", truss head, quadrex, screw No 8998.ZB.VIS08 (8x)
- No. 8 x 2", truss head, quadrex, wood screw No 9785.ZC.VIS08 (16x)



1.2 Catalog of Parts

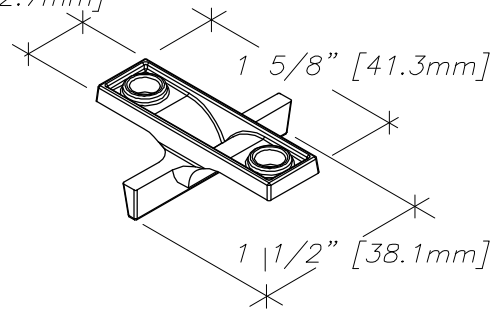
REVISION:
2012/02/02

PAGE:
B-4

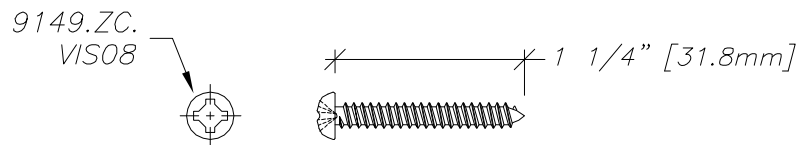
1.2.2 Required Hardware for the Frame

Fasco Kit No. 90781782

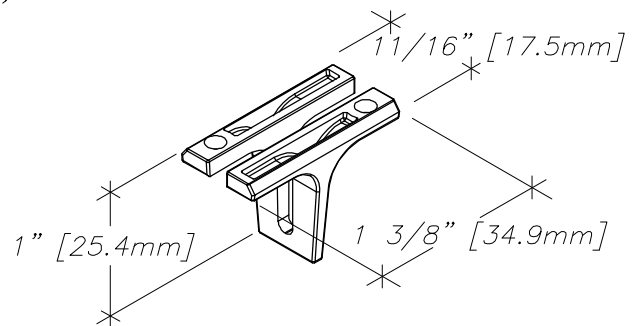
-Central Sash Stopper No. 9719(1x) $1/2"$ [12.7mm]



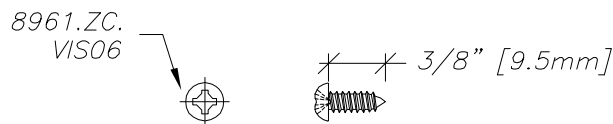
-No. 8 x 1 1/4", pan head, quadrex screw No. 9149.ZC.VIS08 (2x)



Outside Screen Stopper No. 9725 (1x)



-No. 6 x 3/8", pan head, quadrex, screw No. 8961.ZC.VIS06 (2x)

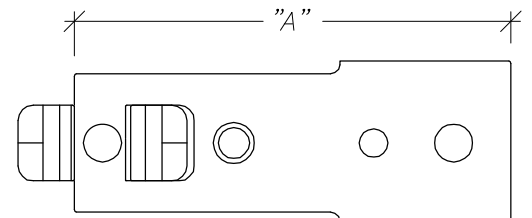


Metal Anchor (not included)

No. 9832: A= 7 3/4" [197mm]

No. 9858: A= 2 7/8" [74mm]

No. 9859: A= 4 3/4" [120mm]



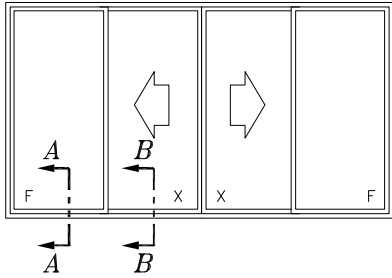
1.3 Assembly Drawings

REVISION:
2012/02/02

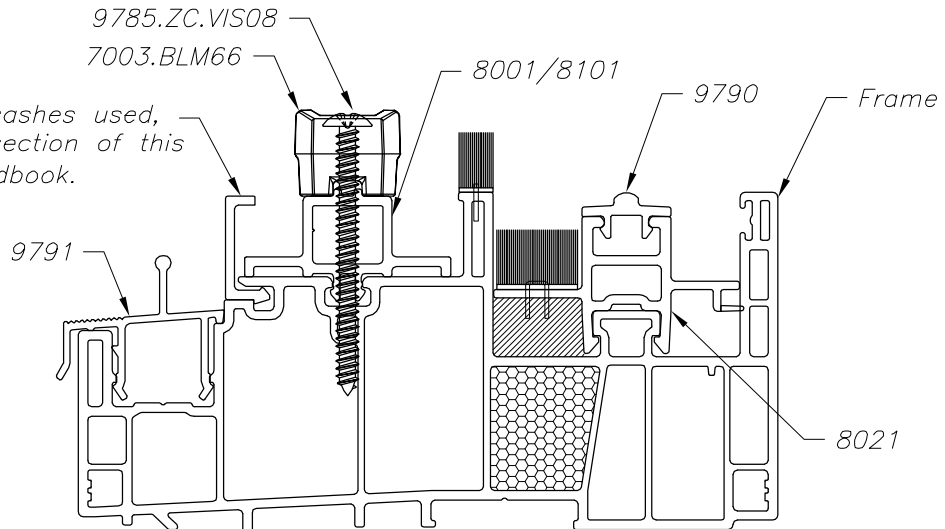
PAGE:
B-5

1.3.1 Sill Assembly Section

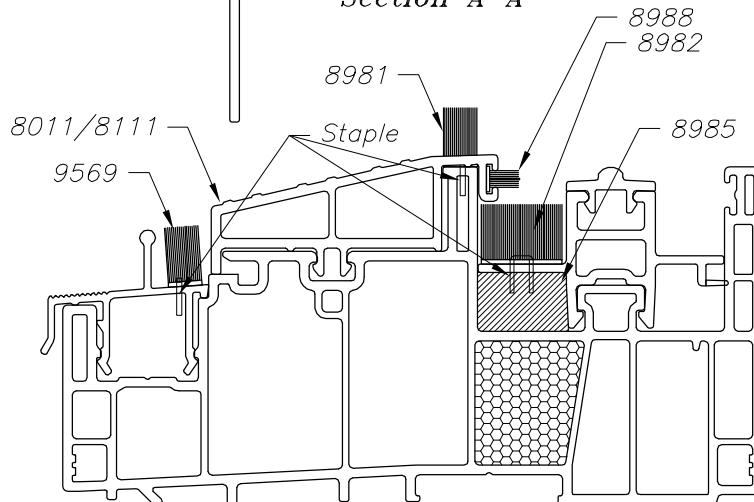
Four (4) Panel Patio Door



Depending on the sashes used,
refer to the sash section of this
manufacturer's handbook.



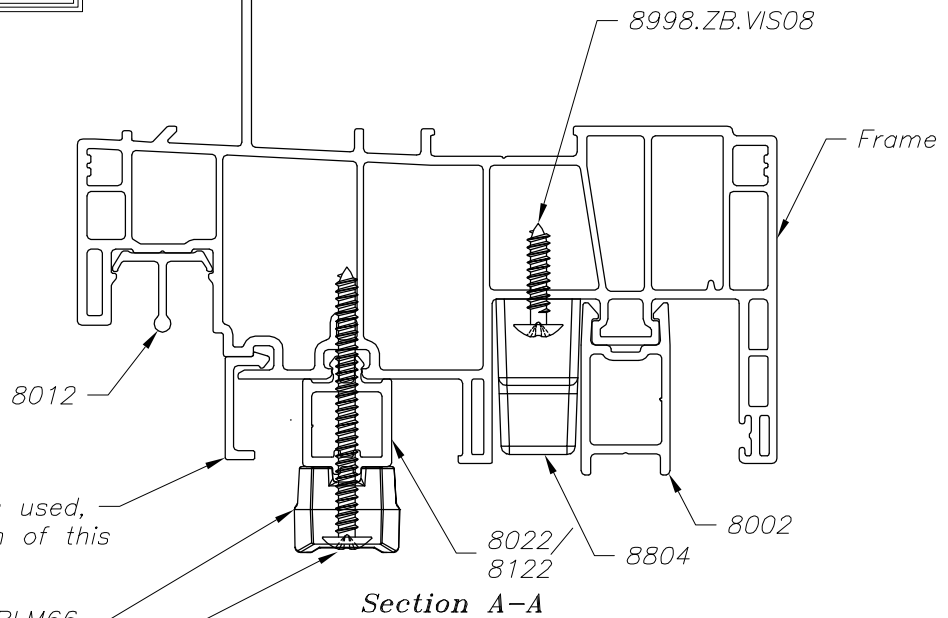
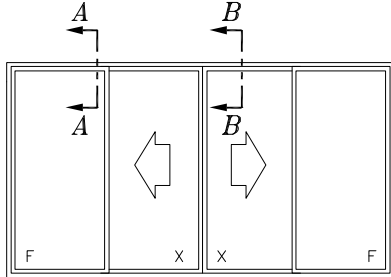
Section A-A



Section B-B

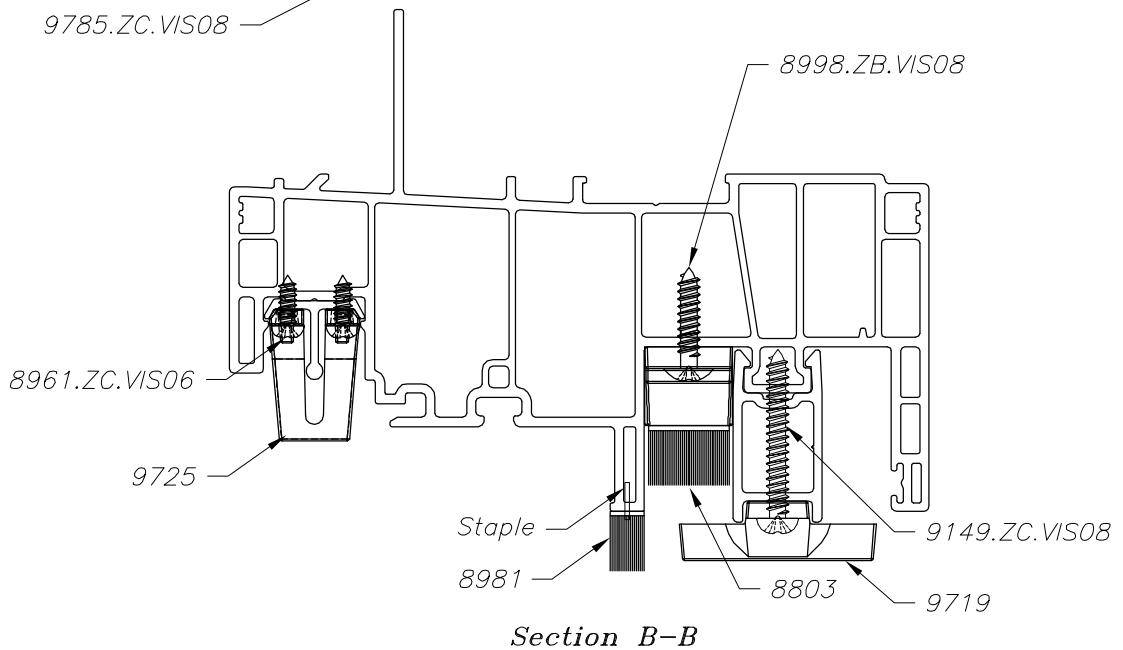
1.3.2 Head Assembly Section

Four (4) Panel Patio Door



7003.BLM66

9785.ZC.VIS08



1.3 Assembly Drawings

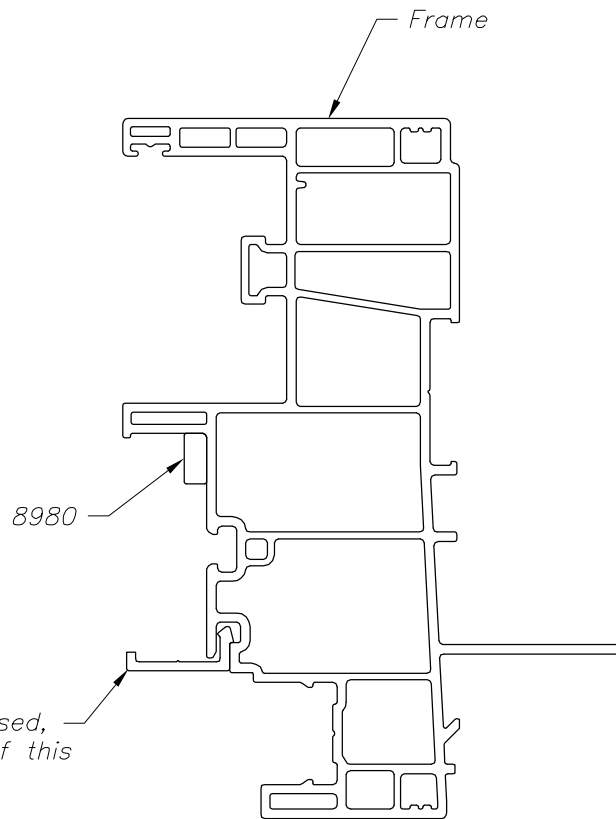
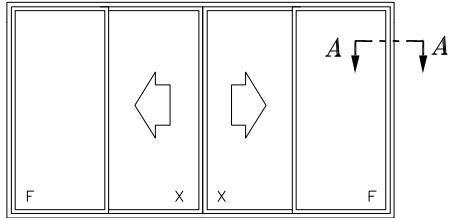
REVISION:

PAGE:

B-7

1.3.3 Jamb Assembly Section, Right Panel Side

Four (4) Panel Patio Door



Depending on the sashes used, refer to the sash section of this manufacturer's handbook.

Section A-A

1.3 Assembly Drawings

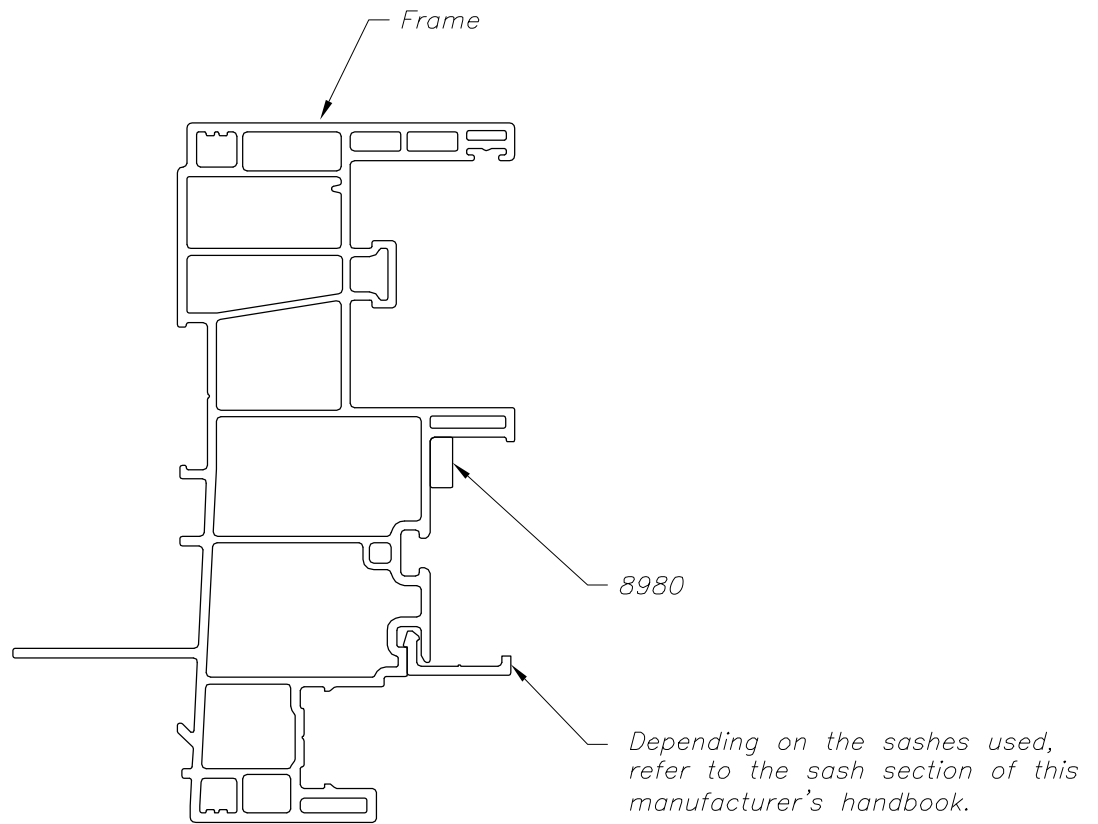
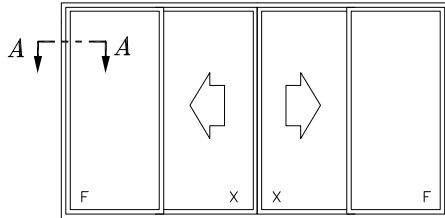
REVISION:

PAGE:

B-8

1.3.4 Jamb Assembly Section, Left Panel Side

Four (4) Panel Patio Door



Section A-A

2.1 Manufacturing

REVISION:

PAGE:

B-9

2.1.1 Introduction to Manufacturing Instructions

This section describes procedures, step by step, for all P.V.C. welded patio door frame manufacturing. All fabrication procedures that are different from those mentioned in this document may alter performances and/or the quality of finished product.

Note:

Depending on the sash used, refer to the sash section of this manufacturer's handbook for the manufacturing instructions.

2.1 Manufacturing

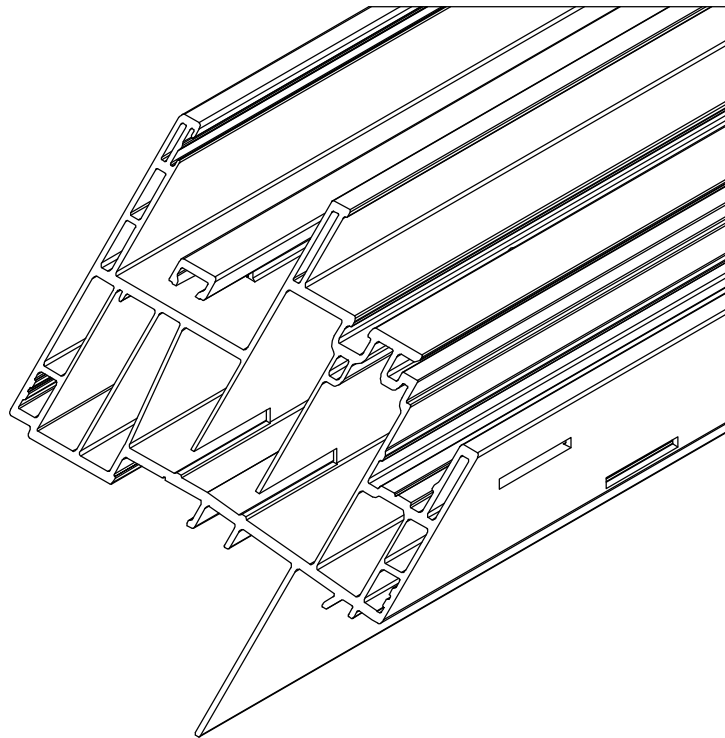
REVISION:

PAGE:

B-10

2.1.2 Frame Drainage

- Only the lower profile (sill) of the frame must be machined.
- Machine drain holes on the frame as per drawing specifications on the three (3) next pages.



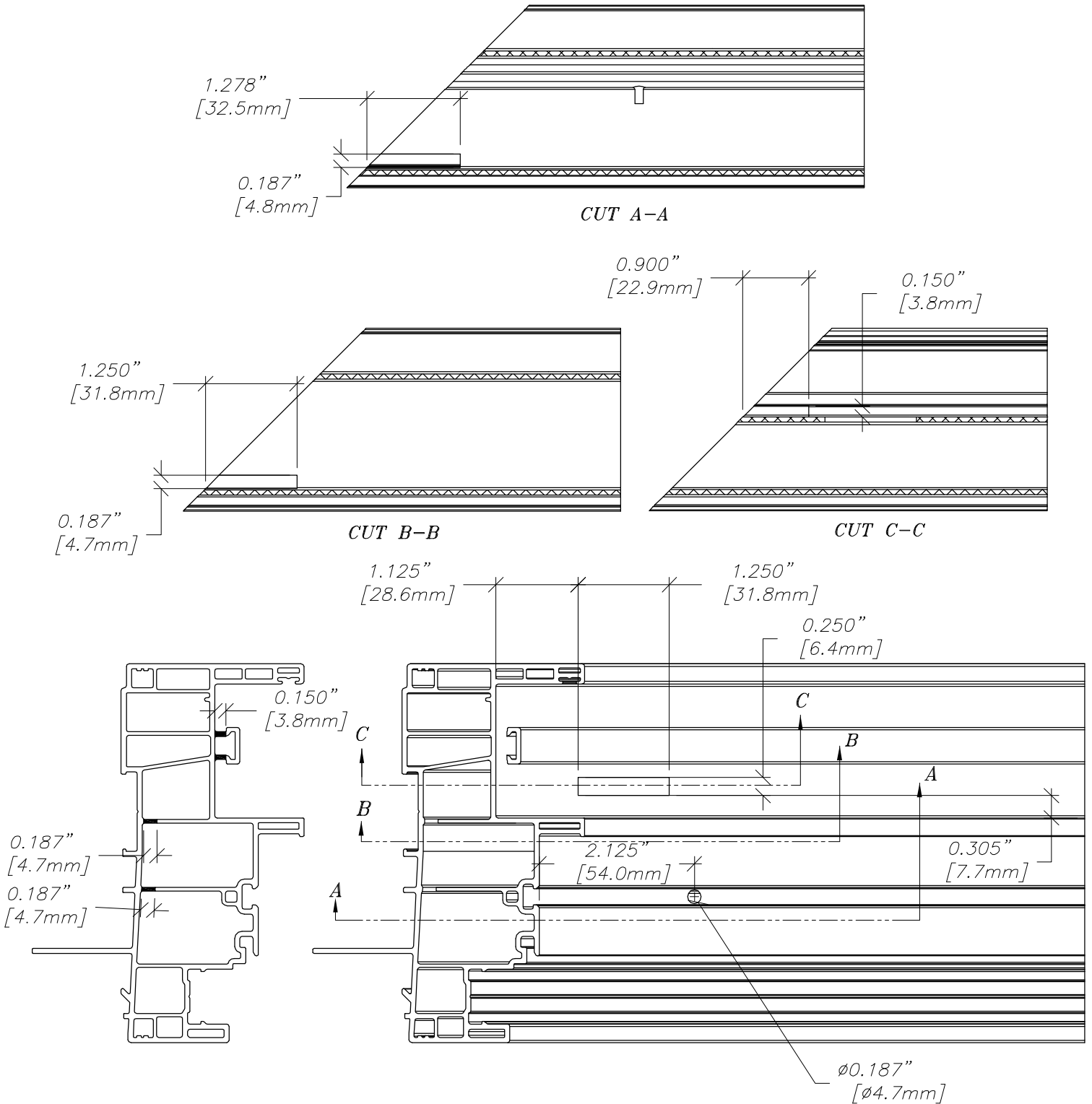
Operation(s) to do at both ends.

2.1 Manufacturing

REVISION:
2012/02/02

PAGE:
B-11

2.1.2 Frame Drainage (Continued)



Operation(s) to do at both ends.

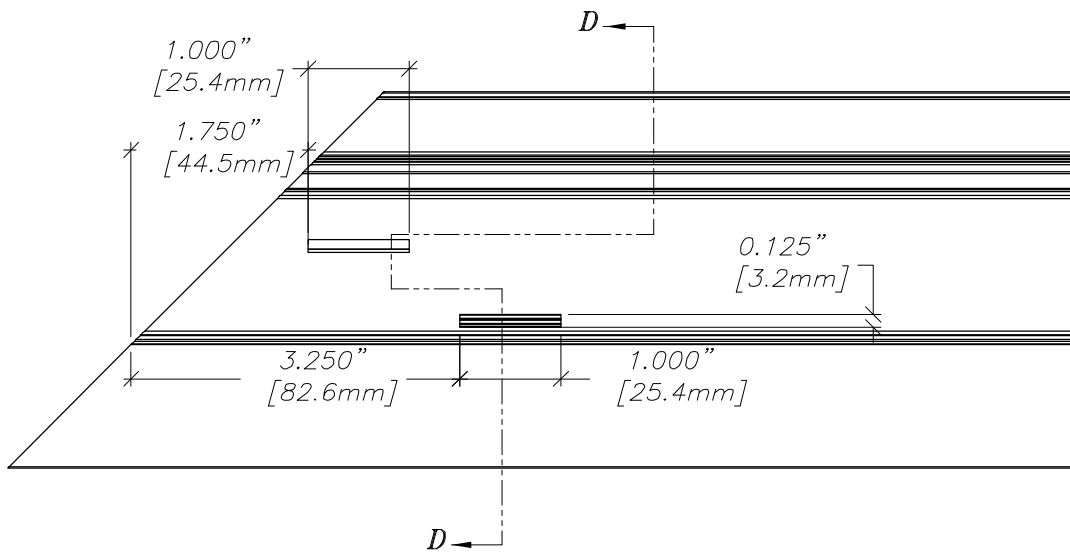
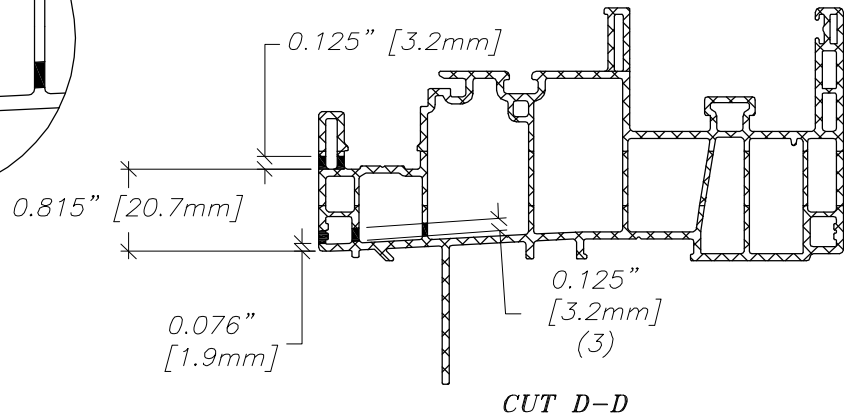
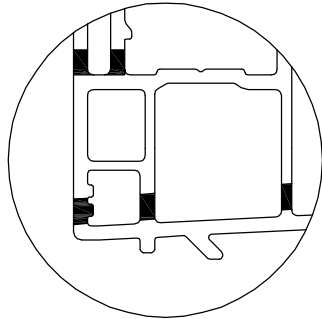
2.1 Manufacturing

REVISION:

PAGE:

B-12

2.1.2 Frame Drainage (Continued)



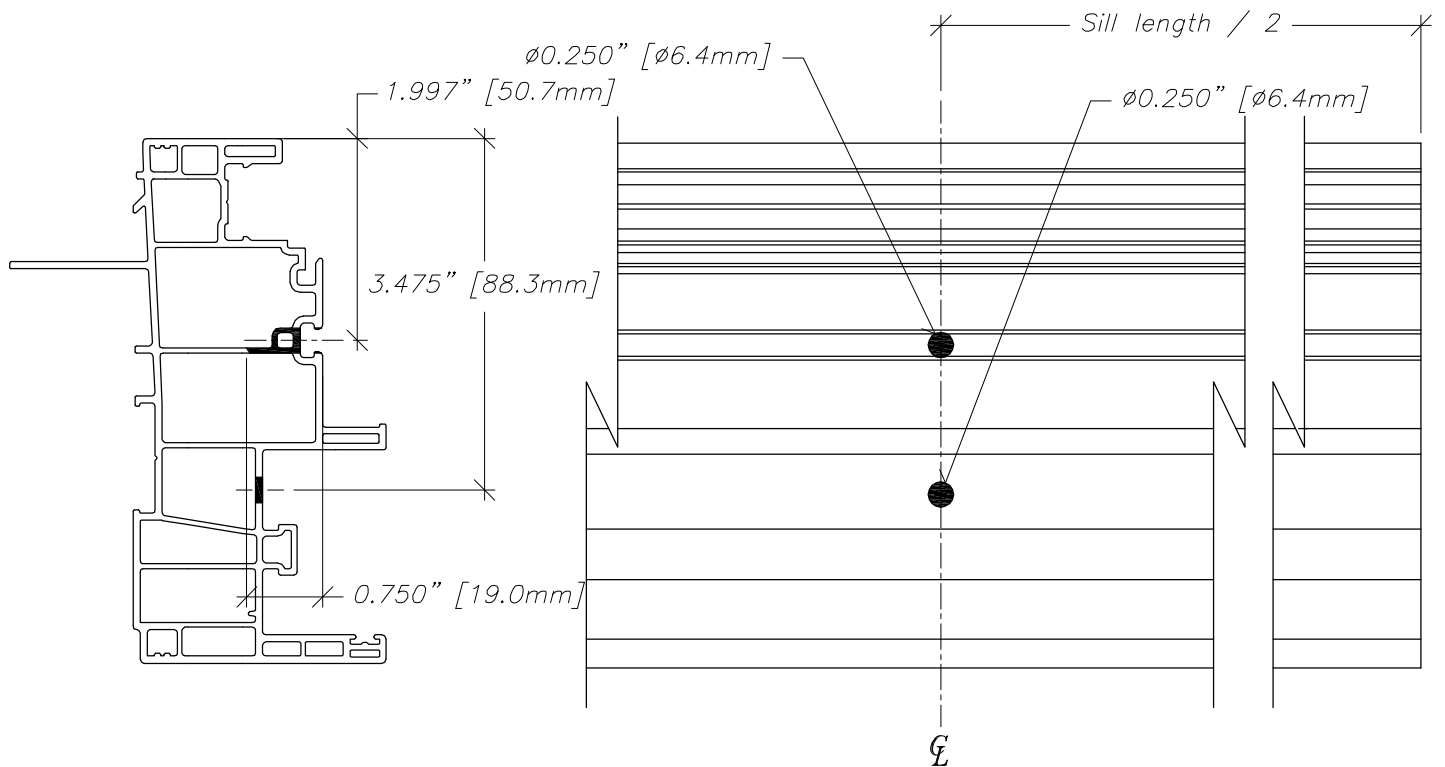
Operation(s) to do at both ends.

2.1 Manufacturing

REVISION:
2012/02/02

PAGE:
B-13

2.1.2 Frame Drainage (Continued)



2.1 Manufacturing

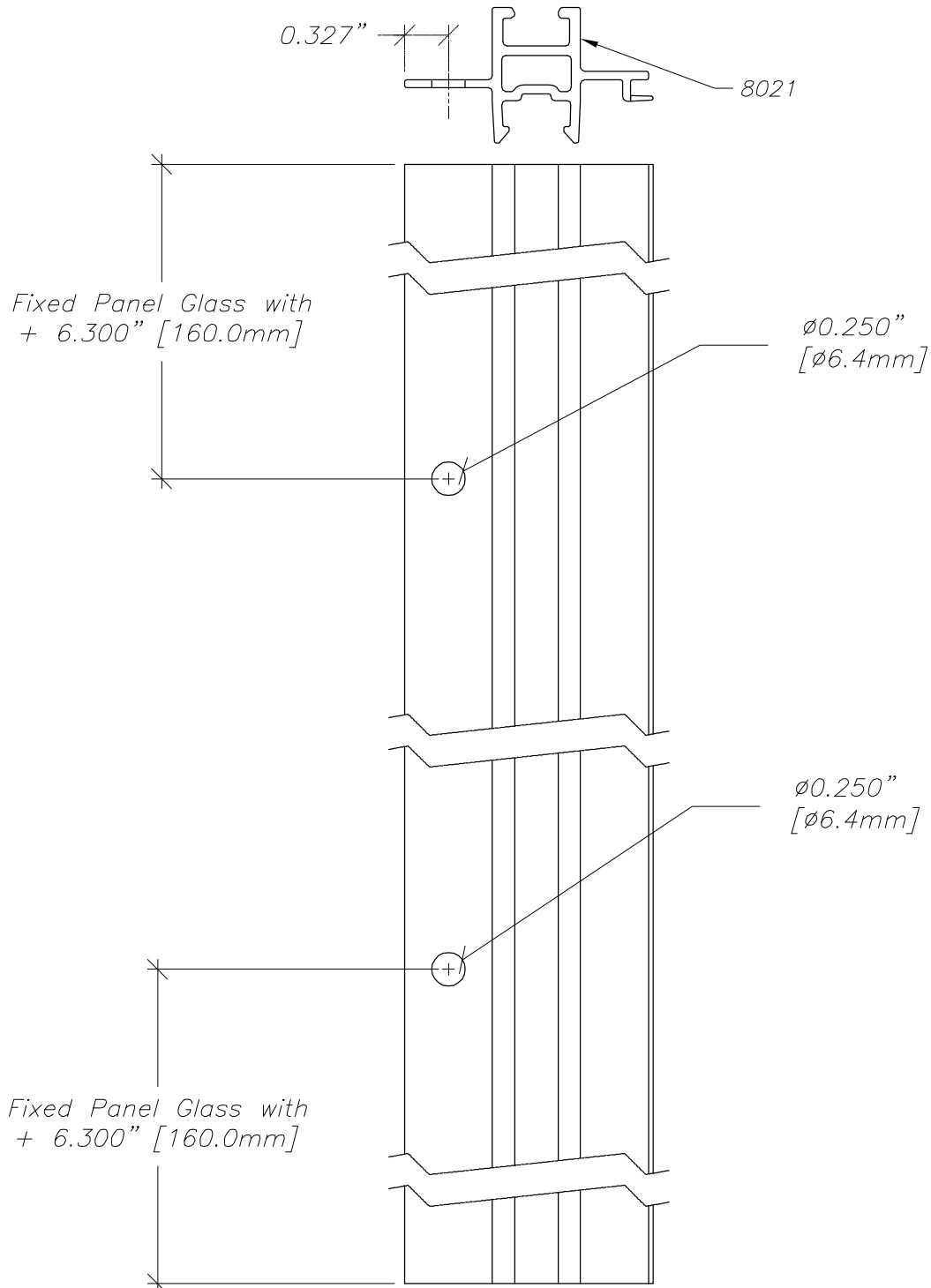
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PAGE:

B-14

2.1.3 Operating Support Panel Drainage

- Drill the operating support panel as per drawing specifications.



Operation(s) to do at both ends.

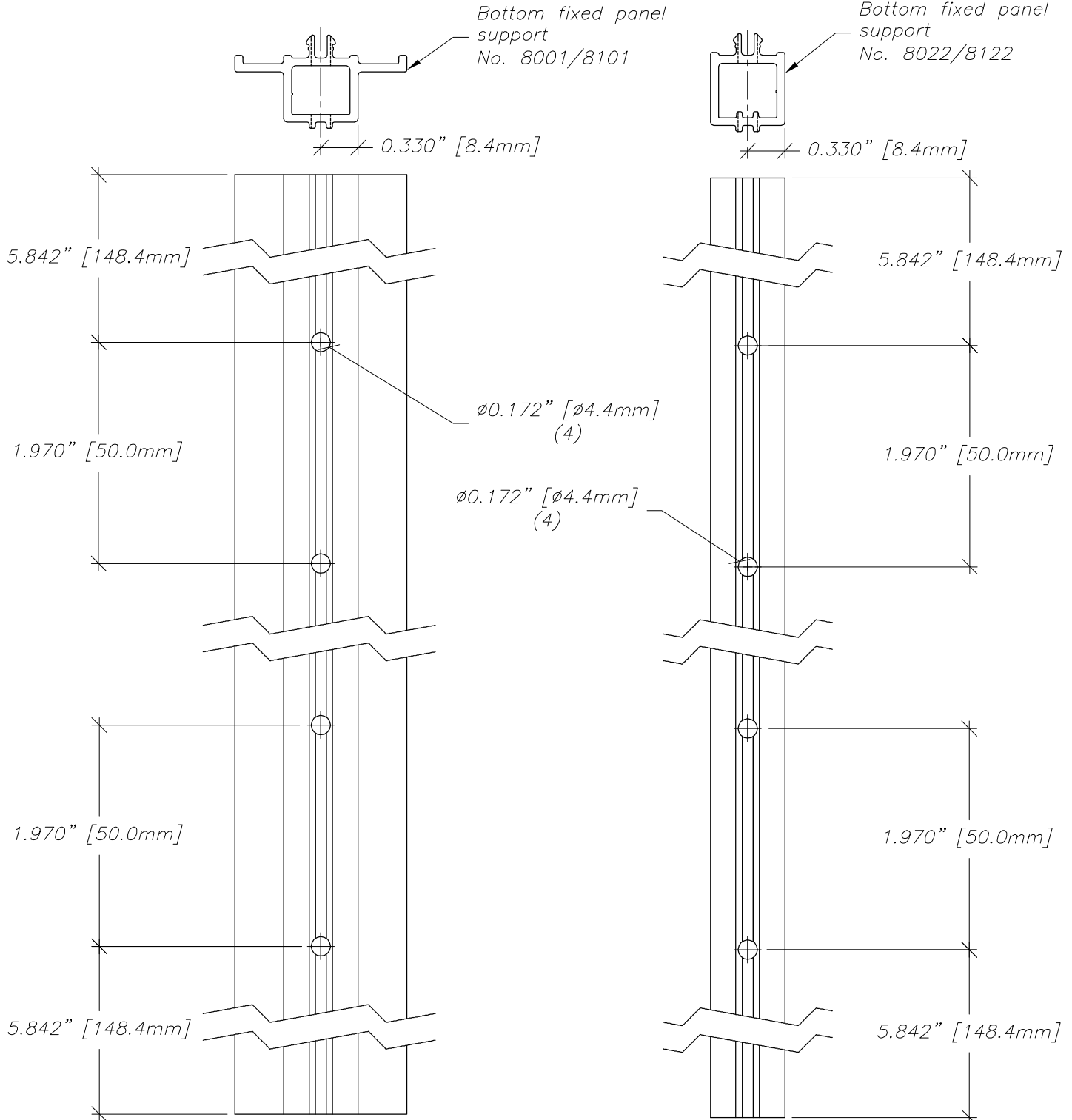
2.1 Manufacturing

REVISION:
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PAGE:
B-15

2.1.4 Bottom and Top Fixed Support Panel Cut-out

- Cut-out bottom and fixed panel support as per drawing specifications.



Operation(s) to do at both ends.

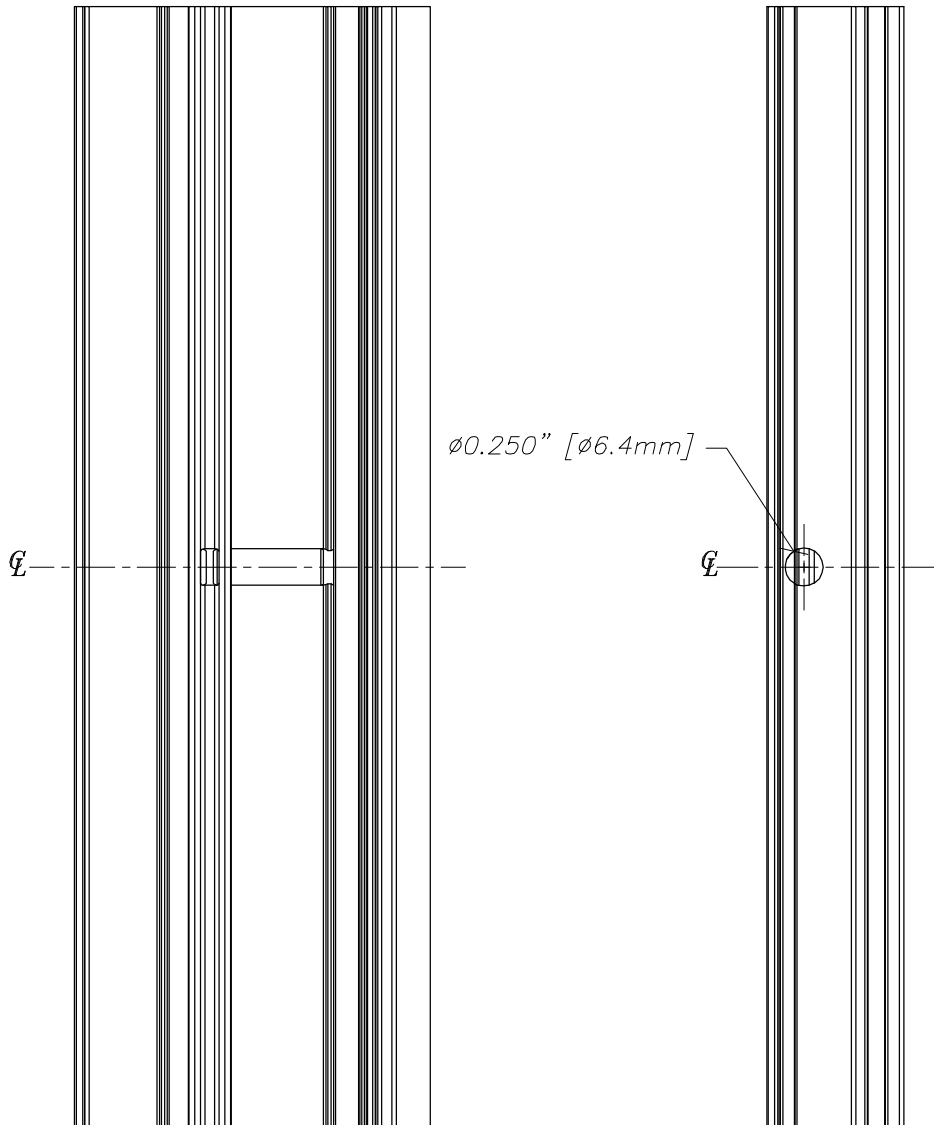
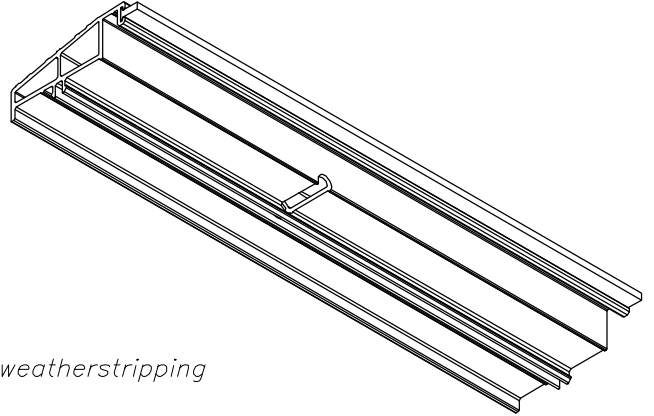
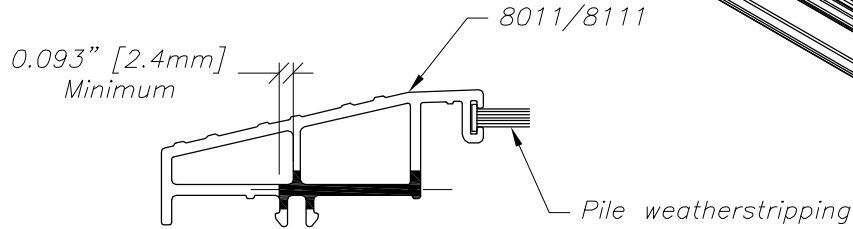
2.1 Manufacturing

REVISION:
2011/04/28

PAGE:
B-16

2.1.5 Sill Protector Drainage

- Drill the operating sill protector as per drawing specifications.



2.2 Assembly Procedure

REVISION:

PAGE:

B-17

2.2.1 Introduction to Assembly Procedure

This section describes procedures, step by step, for all P.V.C. welded patio door frame manufacturing. All assembly procedures that are different from those mentioned in this document may alter performances and/or the quality of finished product.

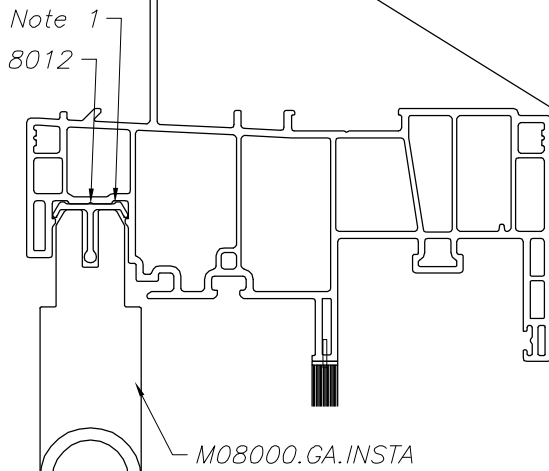
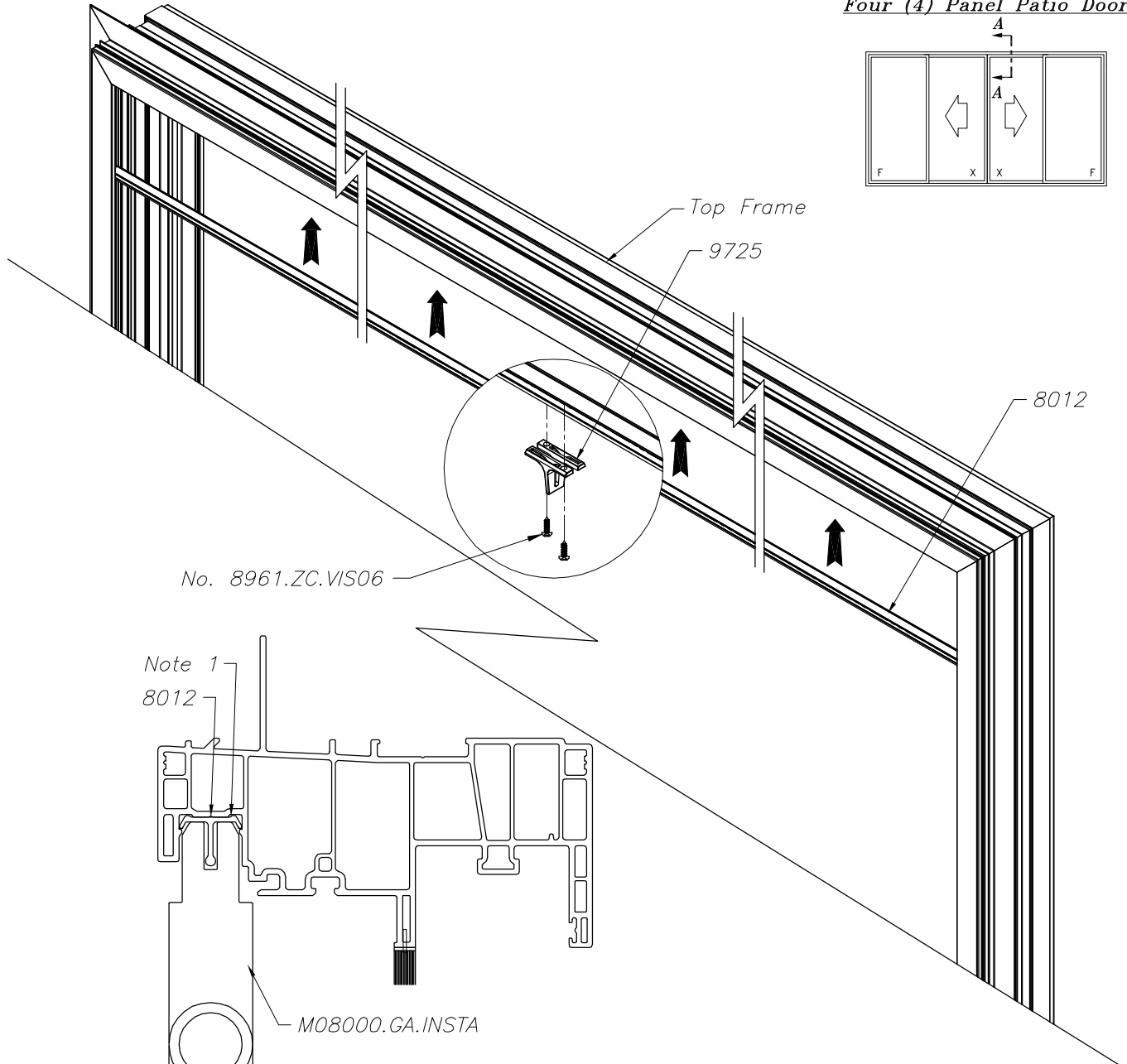
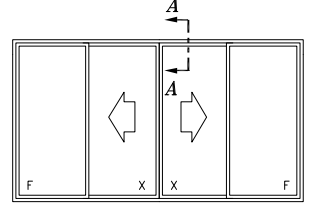
2.2 Assembly Procedure

REVISION:
2012/02/02

PAGE:
B-18

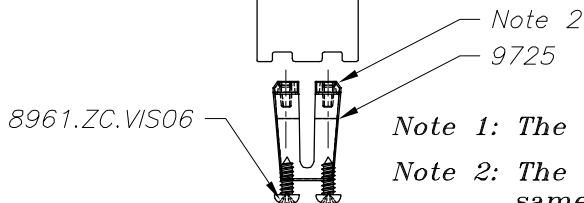
2.2.2 Head Screen Track Installation

Four (4) Panel Patio Door



Assembly Sequence

- Insert No. 8012 head screen track in the head, using a jig M08000.GA.INSTA and a rubber mallet
- Install outside screen stopper No. 9725 with 2 (two) screws No. 8962.ZC.VIS06 in the middle of head screen track No. 8012.



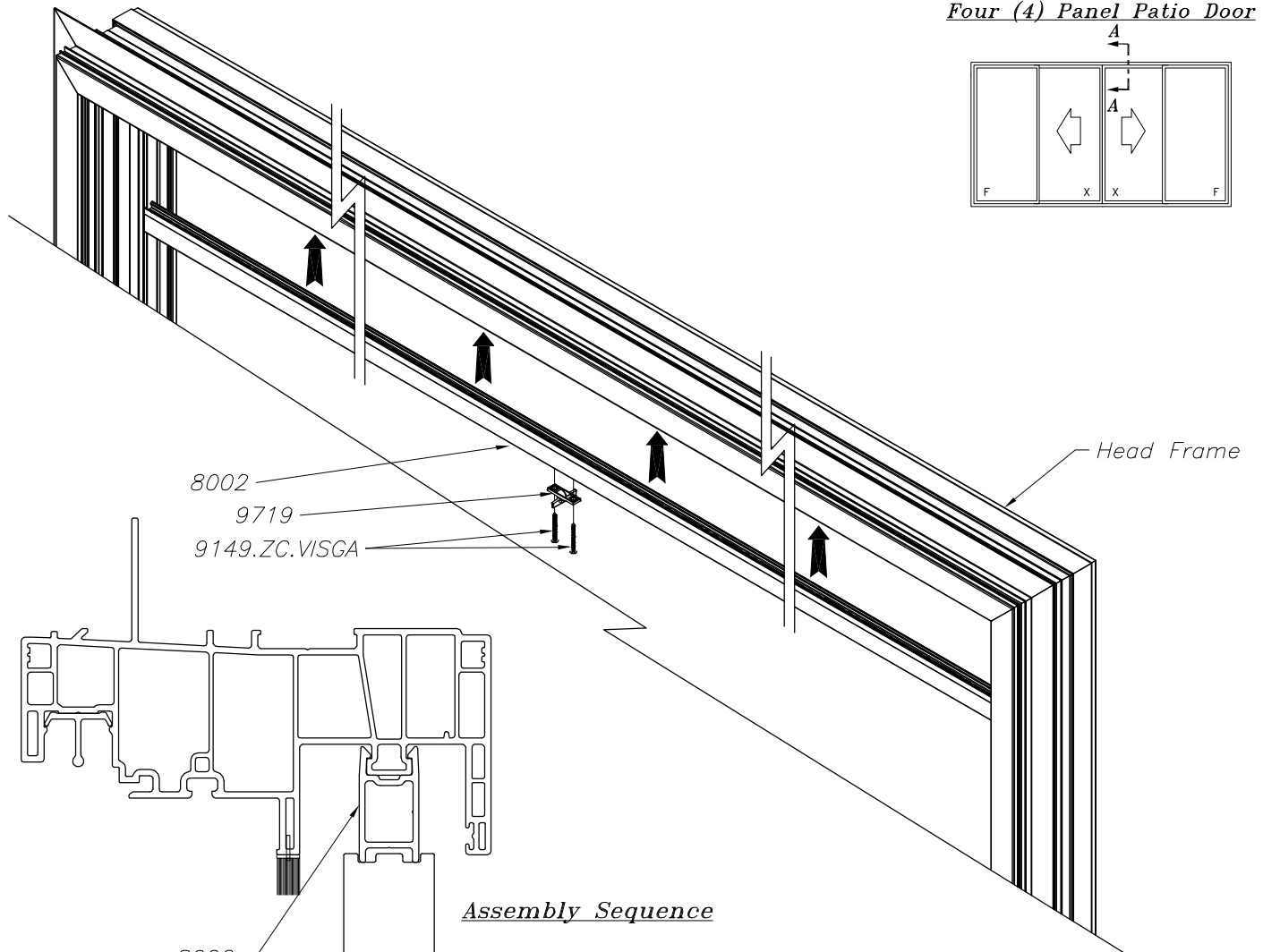
Note 1: The screen track No. 8012 is not required for Hybrid Option.
Note 2: The outside screen stopper No. 9725 is not installed at the same position for hybrid option.

2.2 Assembly Procedure

REVISION:
2010/12/02

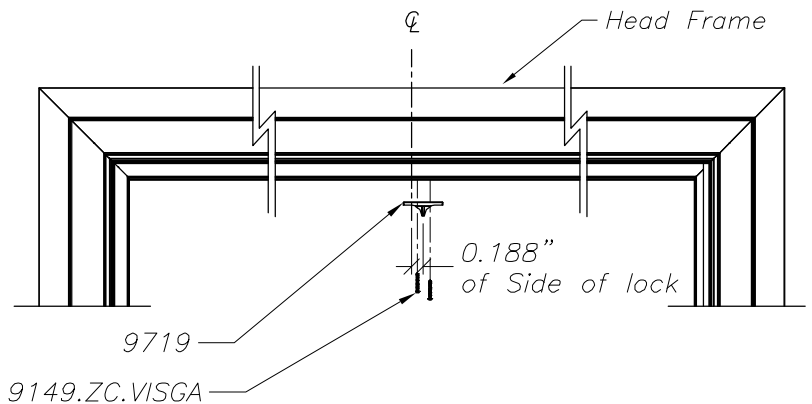
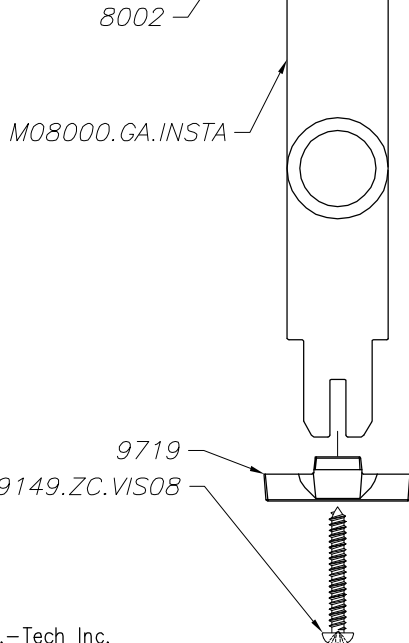
PAGE:
B-20

2.2.4 Head Track Installation



Assembly Sequence

- Insert No. 8002 head track in the head, using a jig M08000.GA.INSTA and a rubber mallet
- Install central sash stopper No. 9719 with 2 (two) screws No. 9149.ZC.VISGA in the middle of head track No. 8002.



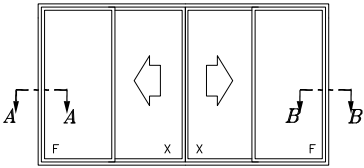
2.2 Assembly Procedure

REVISION:

PAGE:
B-21

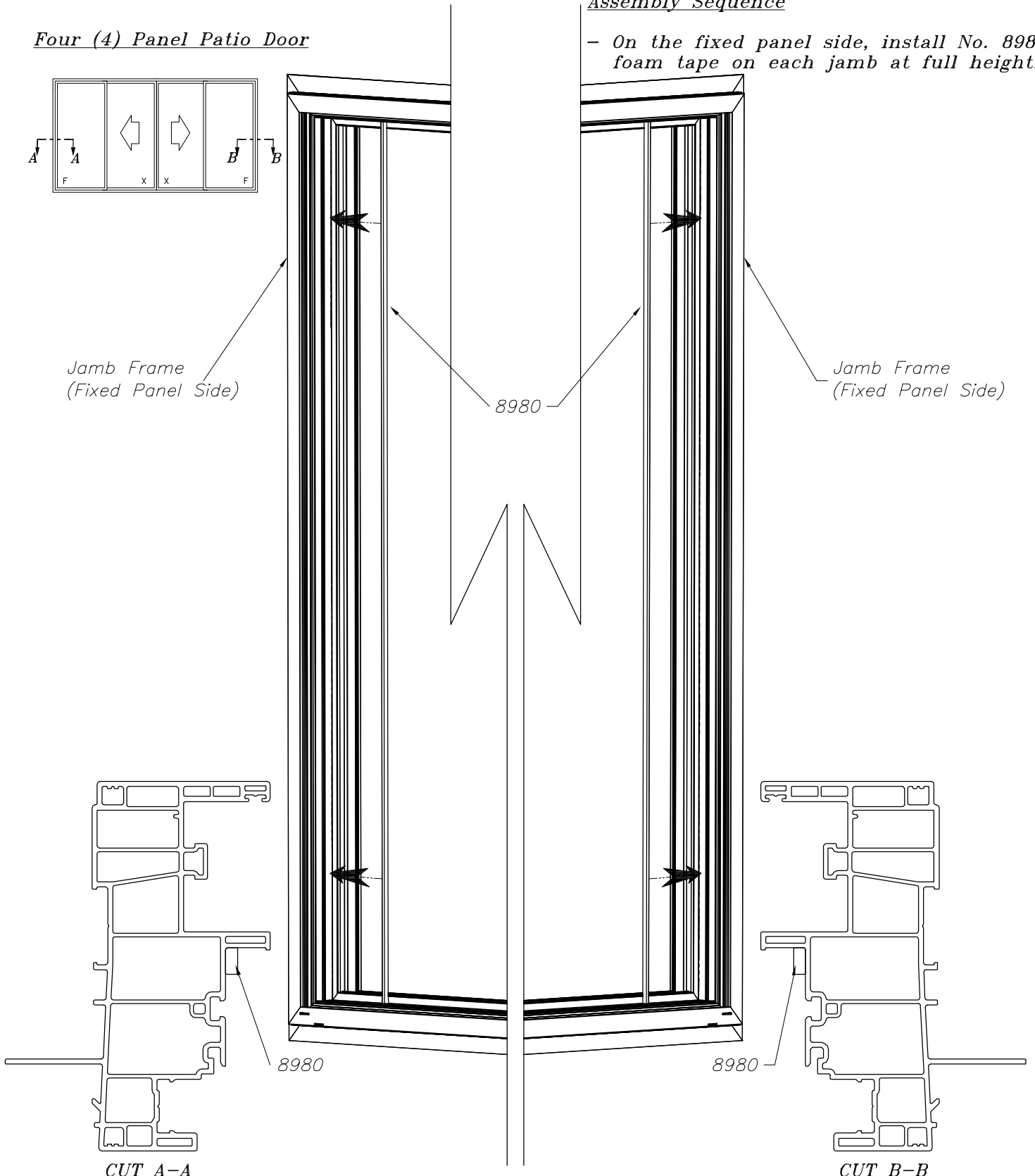
2.2.5 Foam Tape Installation

Four (4) Panel Patio Door



Assembly Sequence

- On the fixed panel side, install No. 8980 foam tape on each jamb at full height.



2.2 Assembly Procedure

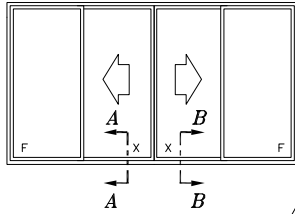
REVISION:
2012/02/02

PAGE:
B-22

2.2.6 Bottom Fixed Support Panel Installation

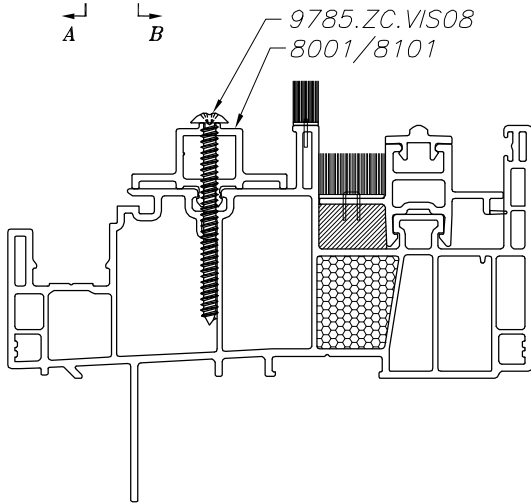
Four (4) Panel Patio Door

Assembly Sequence

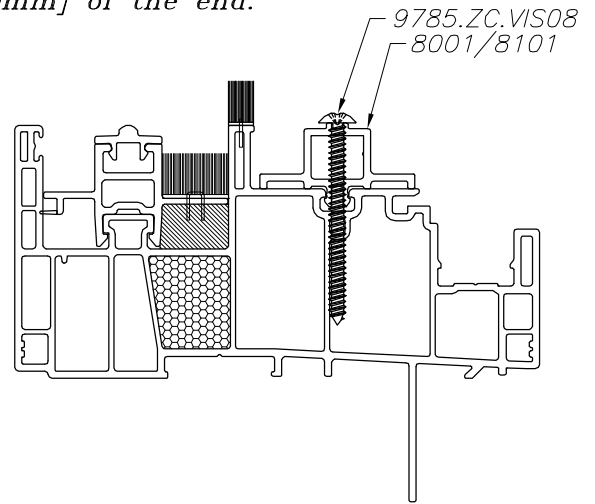


STEP 1: On the fixed panel sides, install 2 (two) No. 8001/8101 bottom fixed panel support, using a rubber mallet.

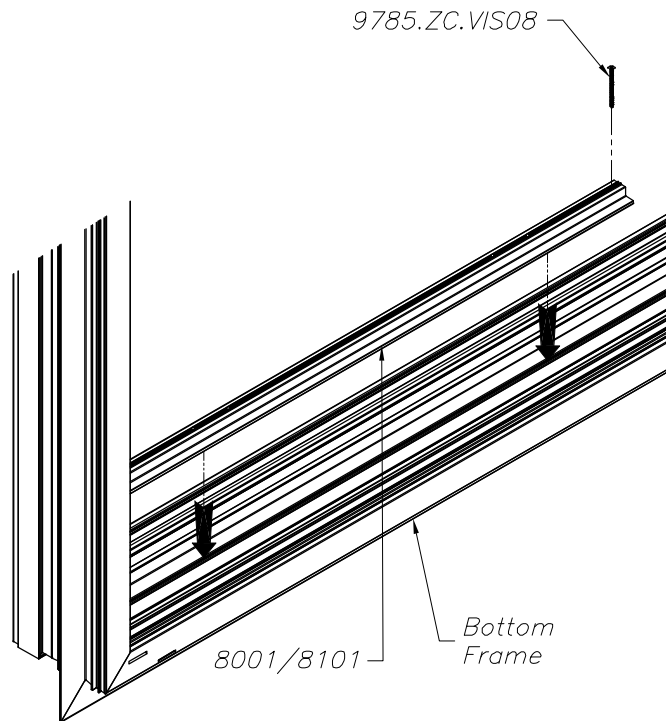
STEP 2: Add 1 (one) screw No. 9785.ZC.VIS08 to fasten each bottom fixed support panel No. 8001/8101 to 3/4" [19mm] of the end.



CUT A-A

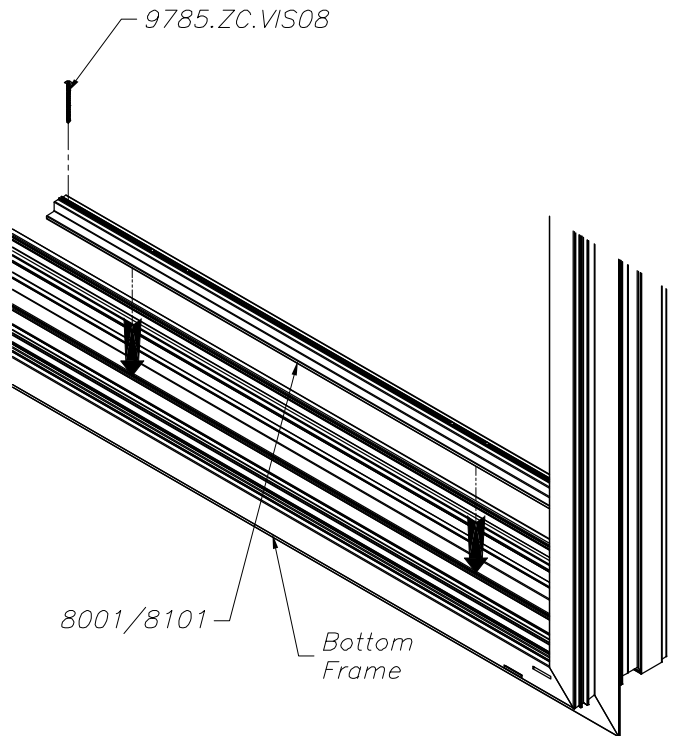


CUT B-B



8001/8101

Bottom
Frame



8001/8101

Bottom
Frame

2.2 Assembly Procedure

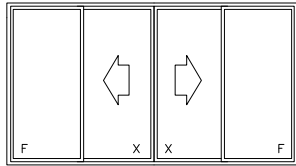
REVISION:
2011/04/28

PAGE:
B-23

2.2.7 Fixed Panel Installation

Four (4) Panel Patio Door

Assembly Sequence

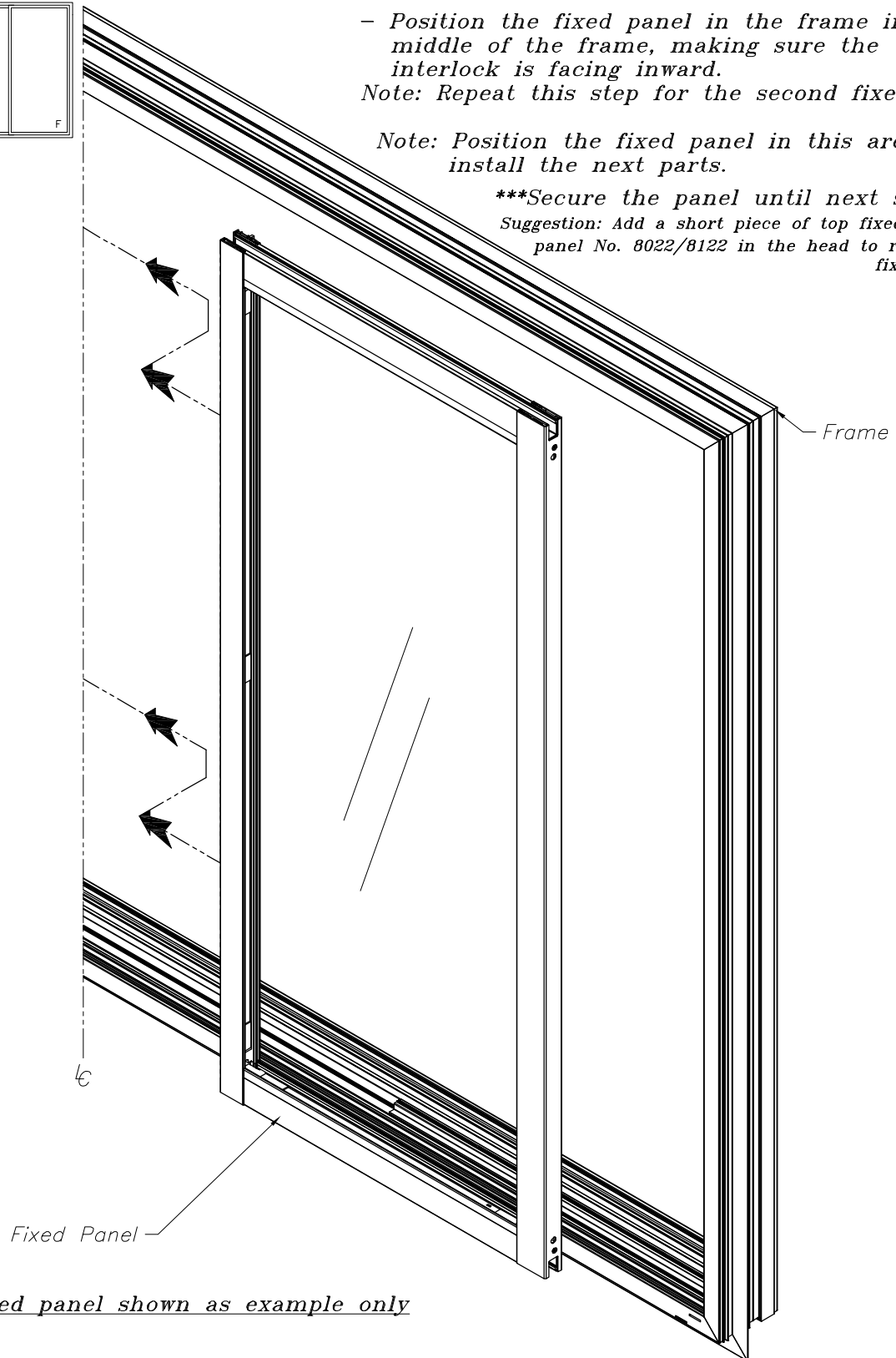


- Position the fixed panel in the frame in the middle of the frame, making sure the interlock is facing inward.
- Note: Repeat this step for the second fixed panel.

Note: Position the fixed panel in this area to install the next parts.

*****Secure the panel until next step.*****

Suggestion: Add a short piece of top fixed support panel No. 8022/8122 in the head to retain the fixed panel.



Important : Fixed panel shown as example only

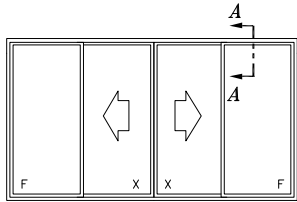
2.2 Assembly Procedure

REVISION:
2012/02/02

PAGE:
B-24

2.2.8 Top Fixed Support Panel Installation

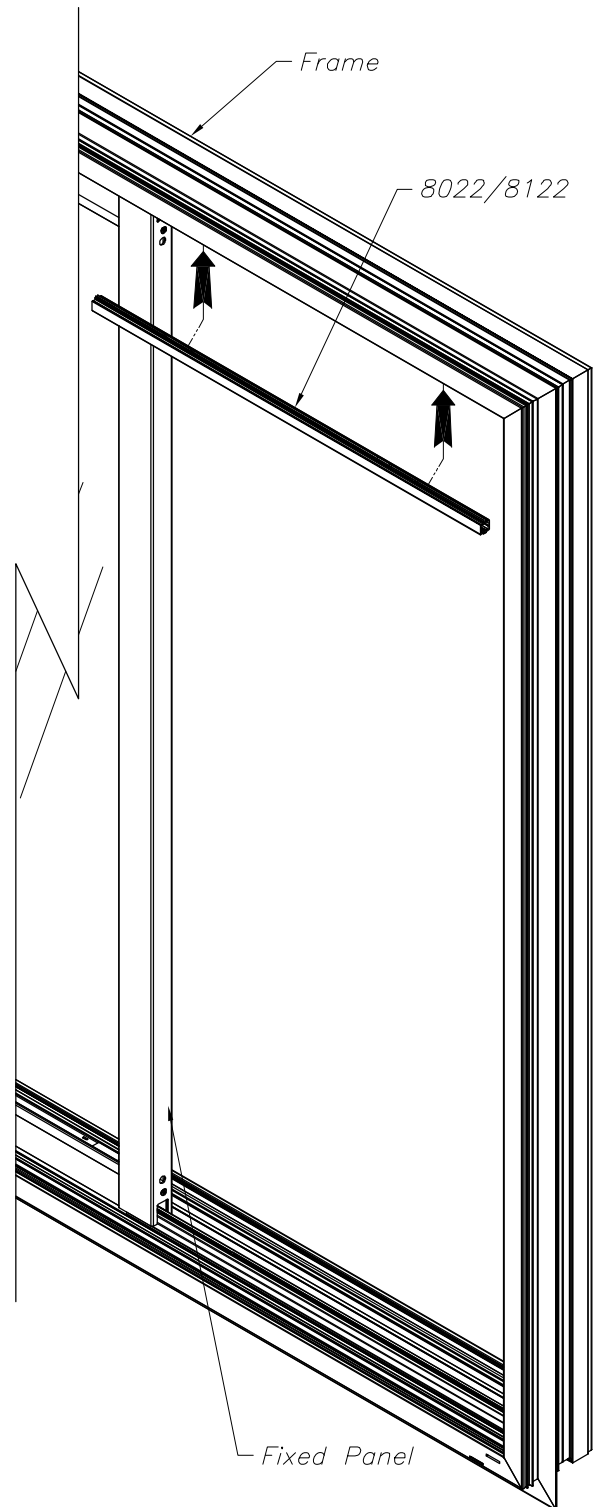
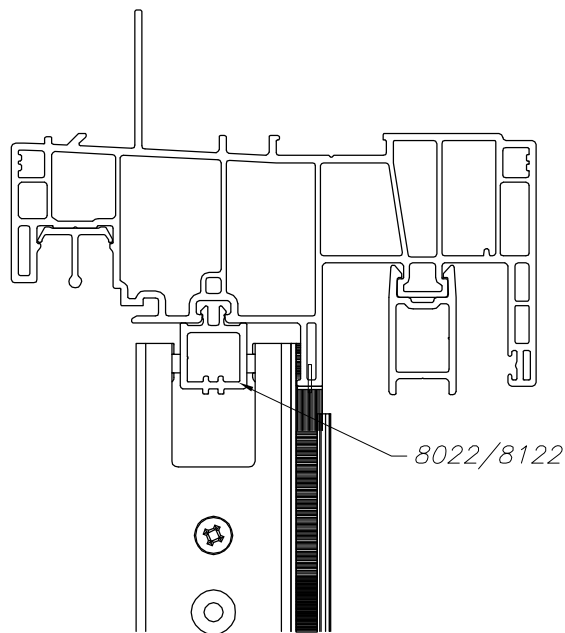
Four (4) Panel Patio Door



Assembly Sequence

- On the head, install No. 8022/8122 top fixed panel support, using a rubber mallet.

Note : Repeat this step for the second fixed panel.



Important : Fixed panel shown as example only

2.2 Assembly Procedure

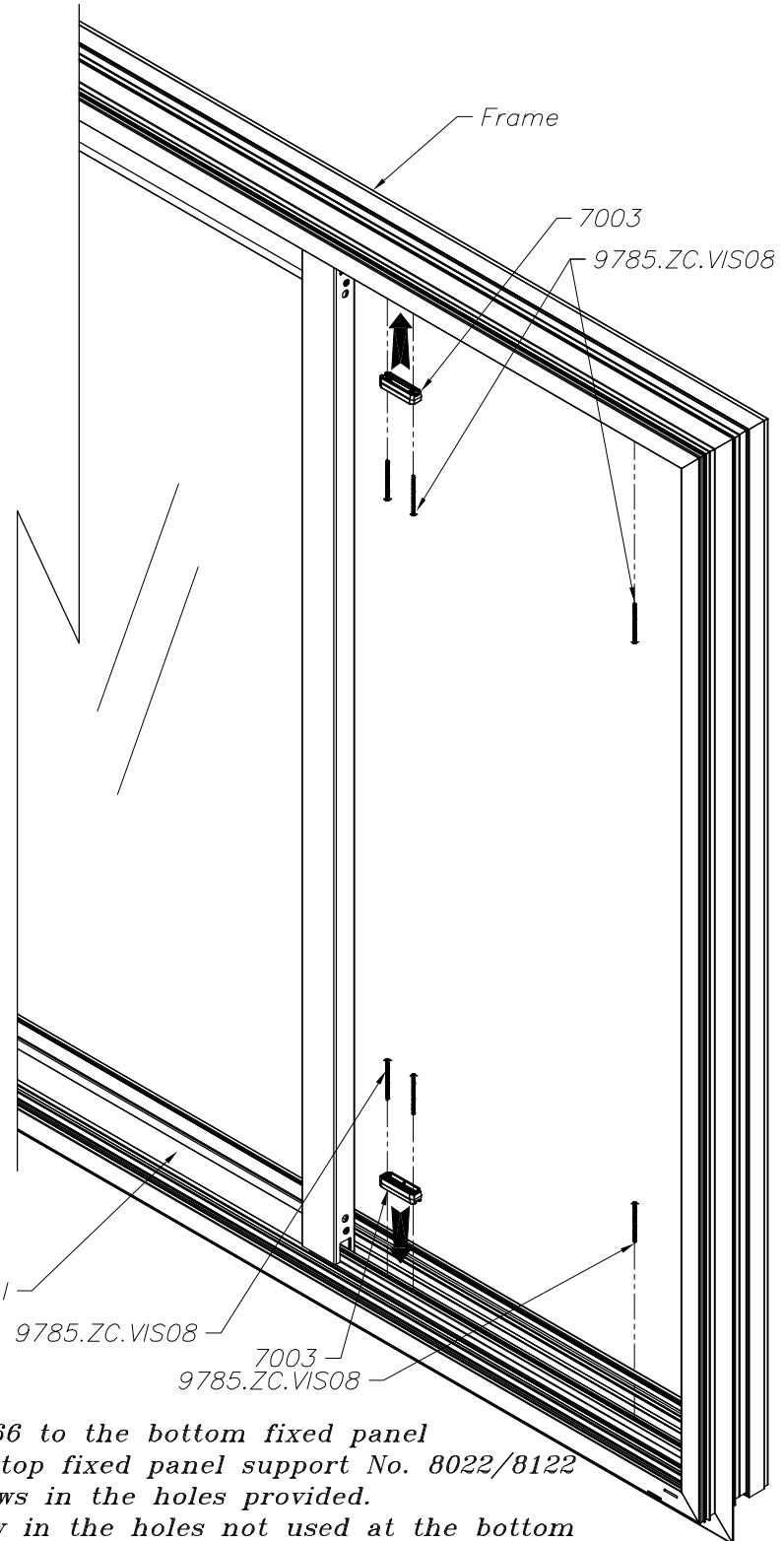
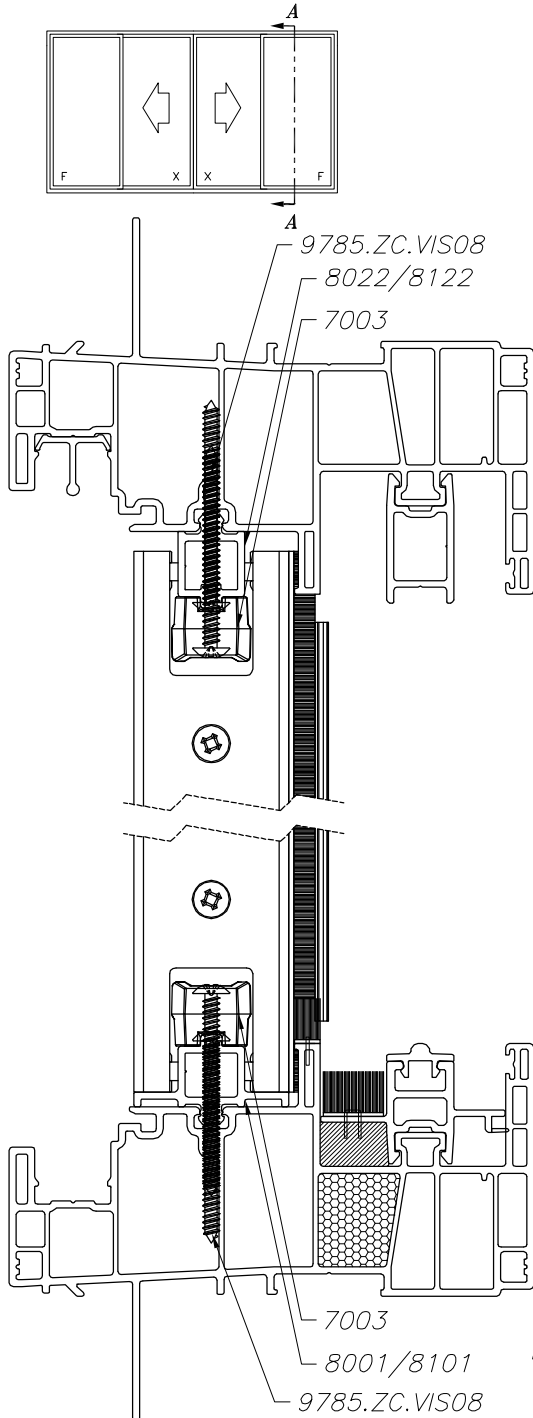
REVISION:
2012/02/02

PAGE:
B-25

2.2.9 Molded Fixed Panel Anchor Block Installation

Four (4) Panel Patio Door

Important : Fixed panel shown as example only



Assembly Sequence

- STEP 1-** Fix the anchor block No. 7003.BLM66 to the bottom fixed panel support No. 8001/8101 and to the top fixed panel support No. 8022/8122 with two (2) No. 9785.ZC.VIS08 screws in the holes provided.
- STEP 2-** Add one (1) No. 9785.ZC.VIS08 screw in the holes not used at the bottom fixed panel support No. 8001/8101 and top fixed panel support No. 8022/8122, near of jamb.

2.2 Assembly Procedure

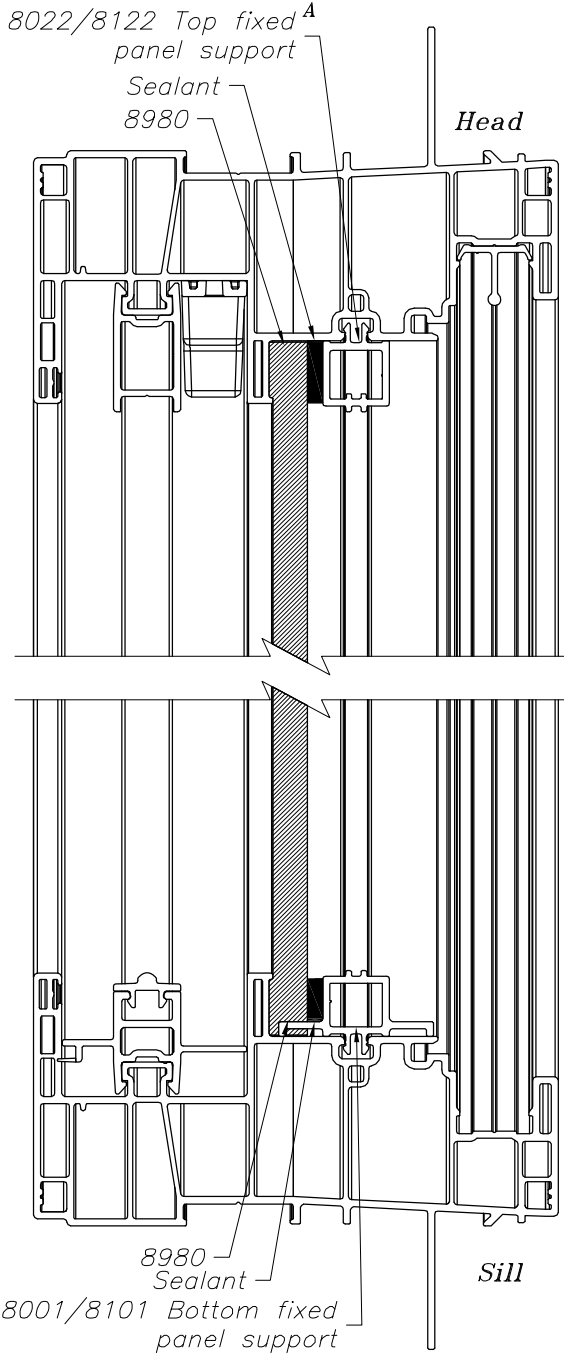
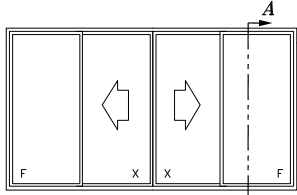
REVISION:
2011/04/28

PAGE:
B-26

2.2.10 Sealing Jamb, Fixed Side

Four (4) Panel Patio Door

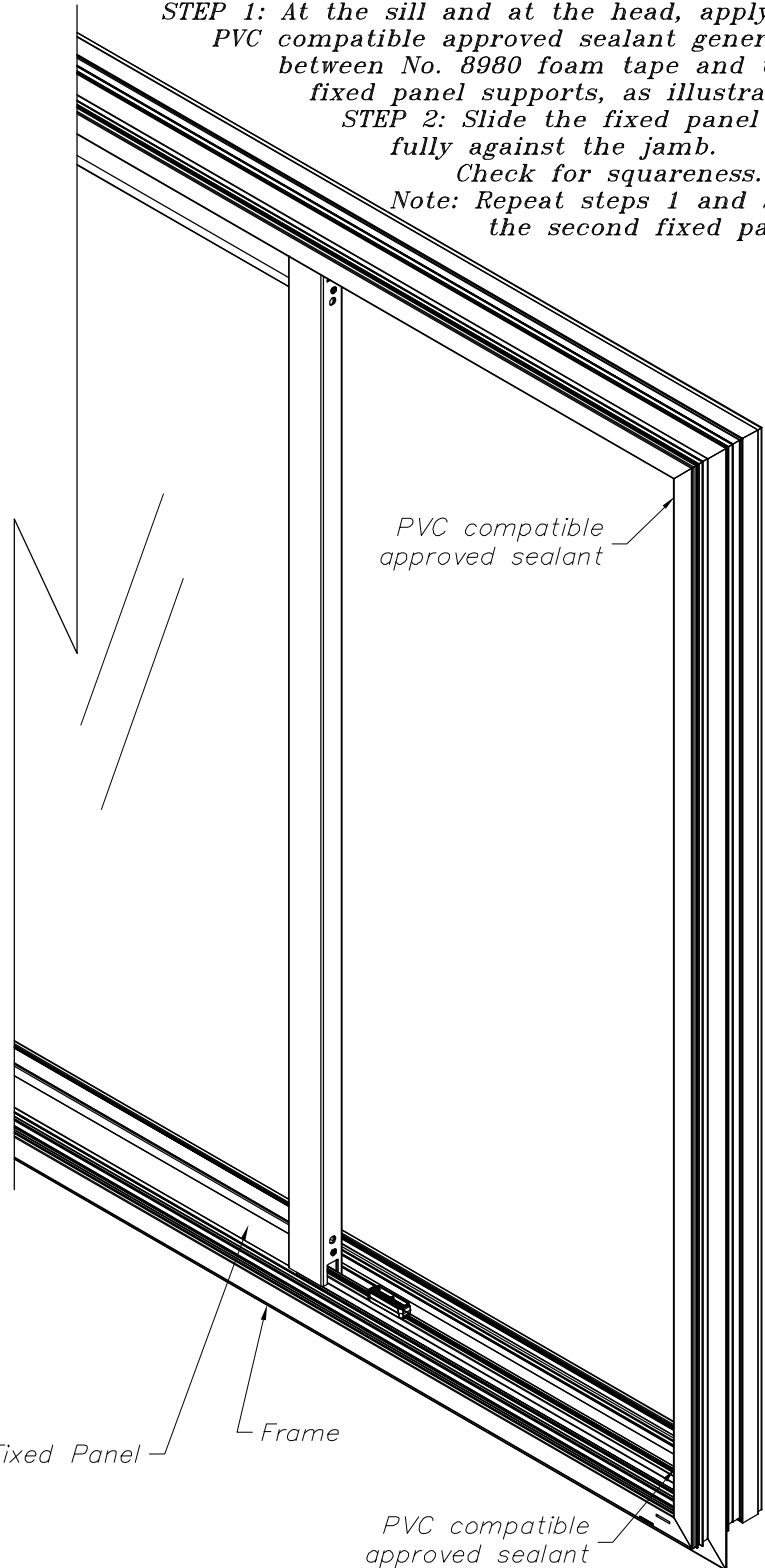
Assembly Sequence



STEP 1: At the sill and at the head, apply some PVC compatible approved sealant generously, between No. 8980 foam tape and the fixed panel supports, as illustrated.

STEP 2: Slide the fixed panel fully against the jamb. Check for squareness.

Note: Repeat steps 1 and 2 for the second fixed panel.



Important : Fixed panel shown as example only

2.2 Assembly Procedure

REVISION:

PAGE:

B-27

2.2.11 Fixed Panel, Final Installation

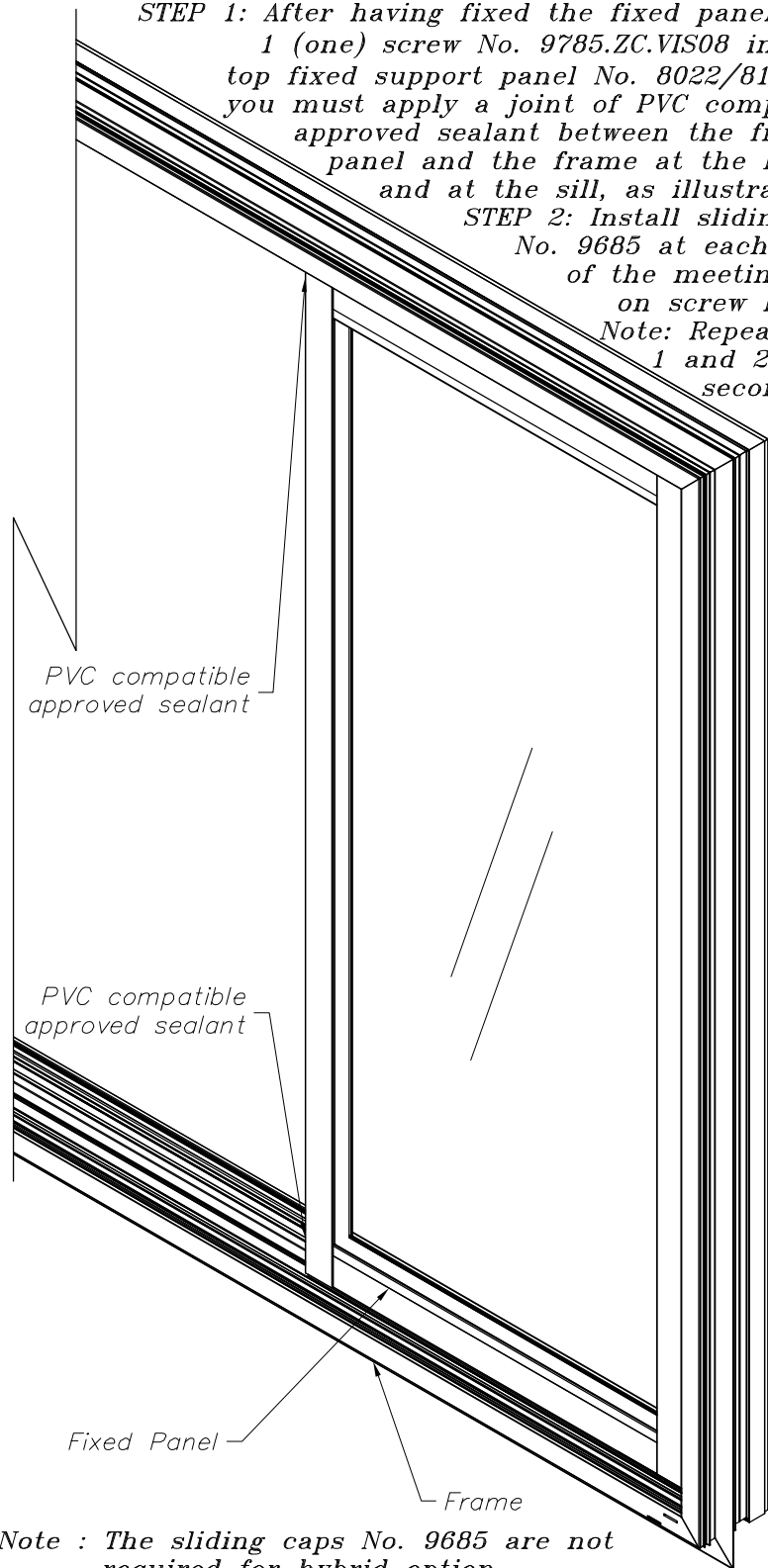
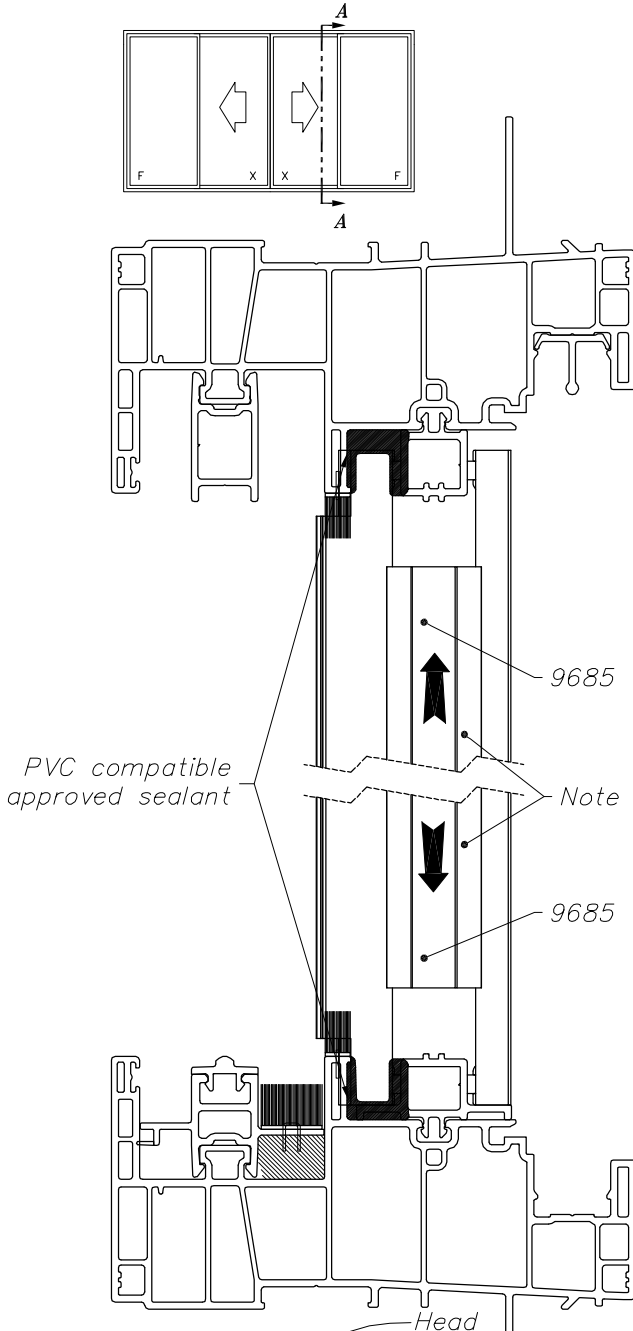
Note:

Depending on the sash used, refer to the sash section of this manufacturer's handbook for this step.

2.2.12 Sealing Fixed Panel

Four (4) Panel Patio Door

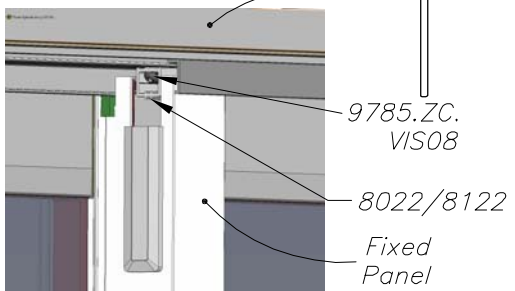
Assembly Sequence



STEP 1: After having fixed the fixed panel, Add 1 (one) screw No. 9785.ZC.VIS08 in the top fixed support panel No. 8022/8122 and you must apply a joint of PVC compatible approved sealant between the fixed panel and the frame at the head and at the sill, as illustrated.

STEP 2: Install sliding caps No. 9685 at each end of the meeting stiles on screw heads.

Note: Repeat steps 1 and 2 for the second fixed panel.



Note : The sliding caps No. 9685 are not required for hybrid option

Important : Fixed panel shown as example only

2.2 Assembly Procedure

REVISION:

PAGE:

B-29

2.2.13 Mullion Fabrication and Assembly

Note:

Depending on the sash used, refer to the sash section of this manufacturer's handbook for this step.

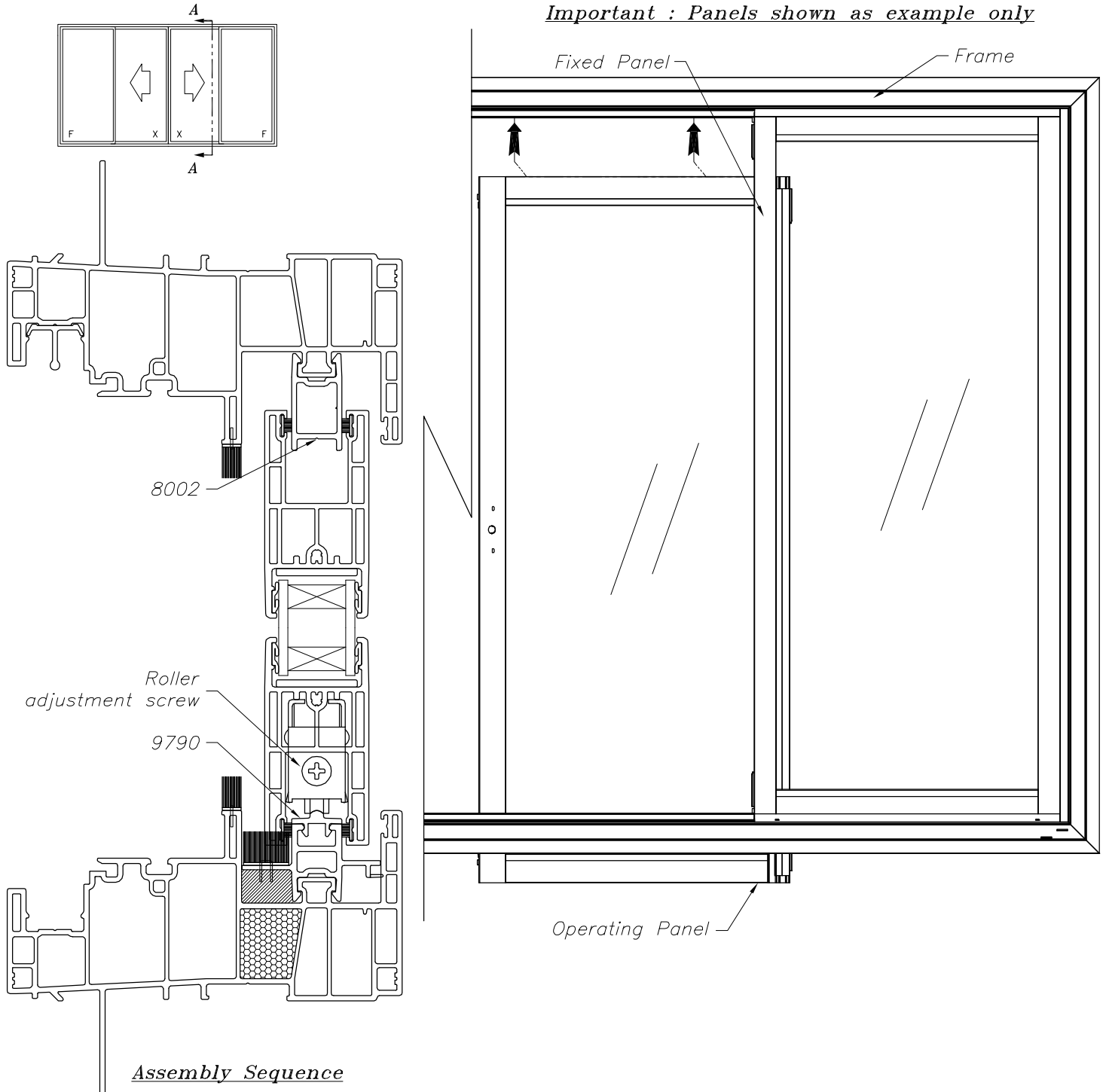
2.2 Assembly Procedure

REVISION:
2012/02/02

PAGE:
B-30

2.2.14 Operating Panel Installation

Four (4) Panel Patio Door



Assembly Sequence

- STEP 1:** From the inside, insert the top of the operating panel into the head track No. 8002 making sure the interlock is facing outward.
 - STEP 2:** Set operating panel onto the rolling rail No. 9790.
 - STEP 3:** If necessary, adjust height and squareness of the operating panel with adjustment screws (Clockwise to raise /Counter-clockwise to lower).
- Note:** Repeat step 1 to 3 for the second operating panel.

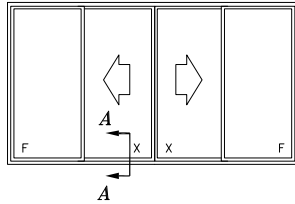
2.2 Assembly Procedure

REVISION:
2012/02/02

PAGE:
B-31

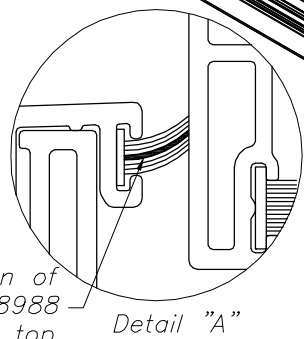
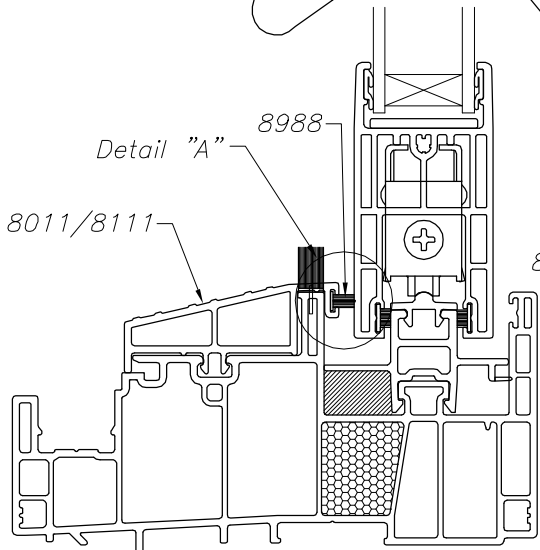
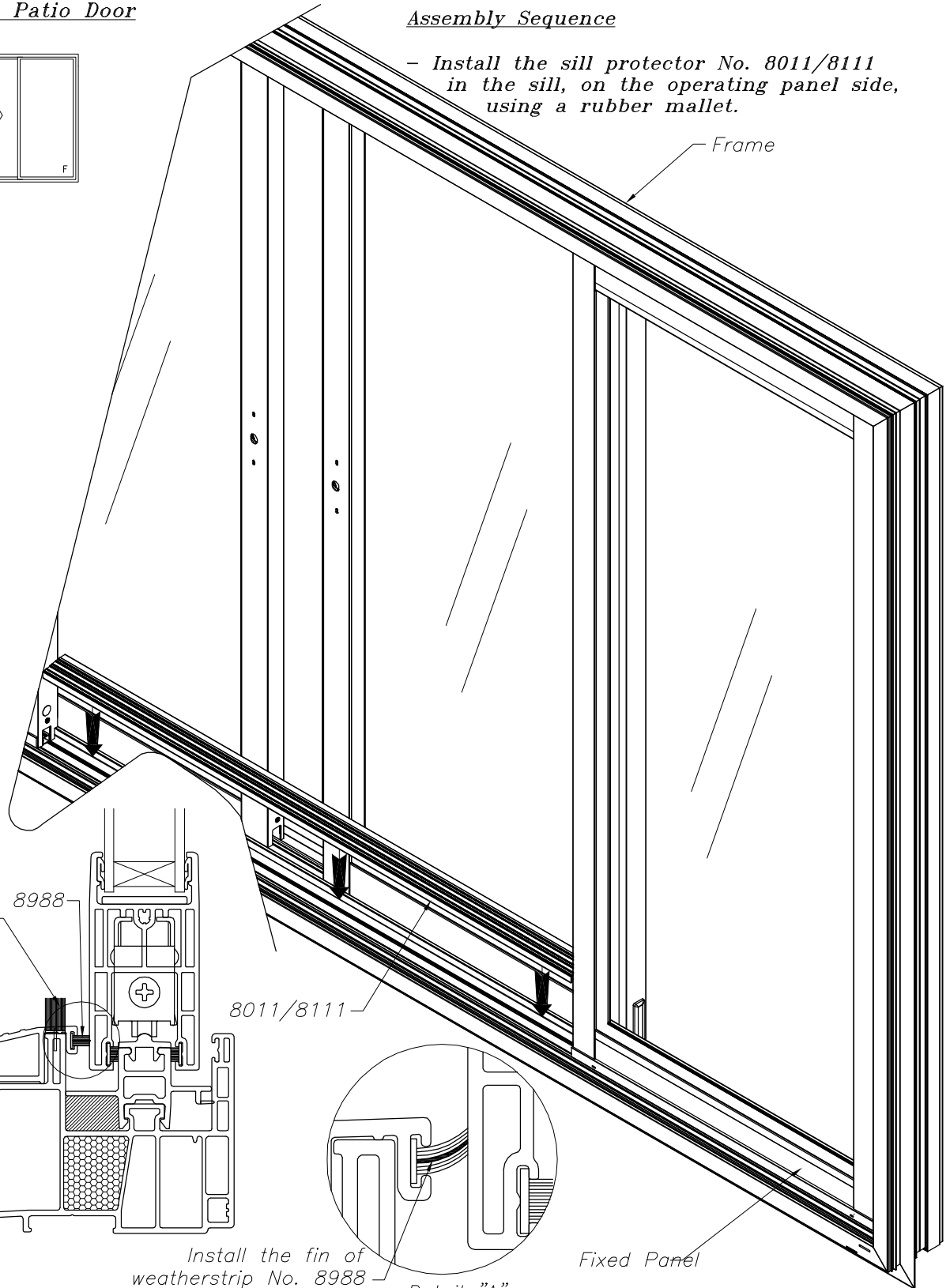
2.2.15 Sill Protector Installation

Four (4) Panel Patio Door



Assembly Sequence

- Install the sill protector No. 8011/8111 in the sill, on the operating panel side, using a rubber mallet.



Install the fin of weatherstrip No. 8988 to the top.

Detail "A"

Fixed Panel

2.2.16 Aluminum Outside Sill Cladding Installation

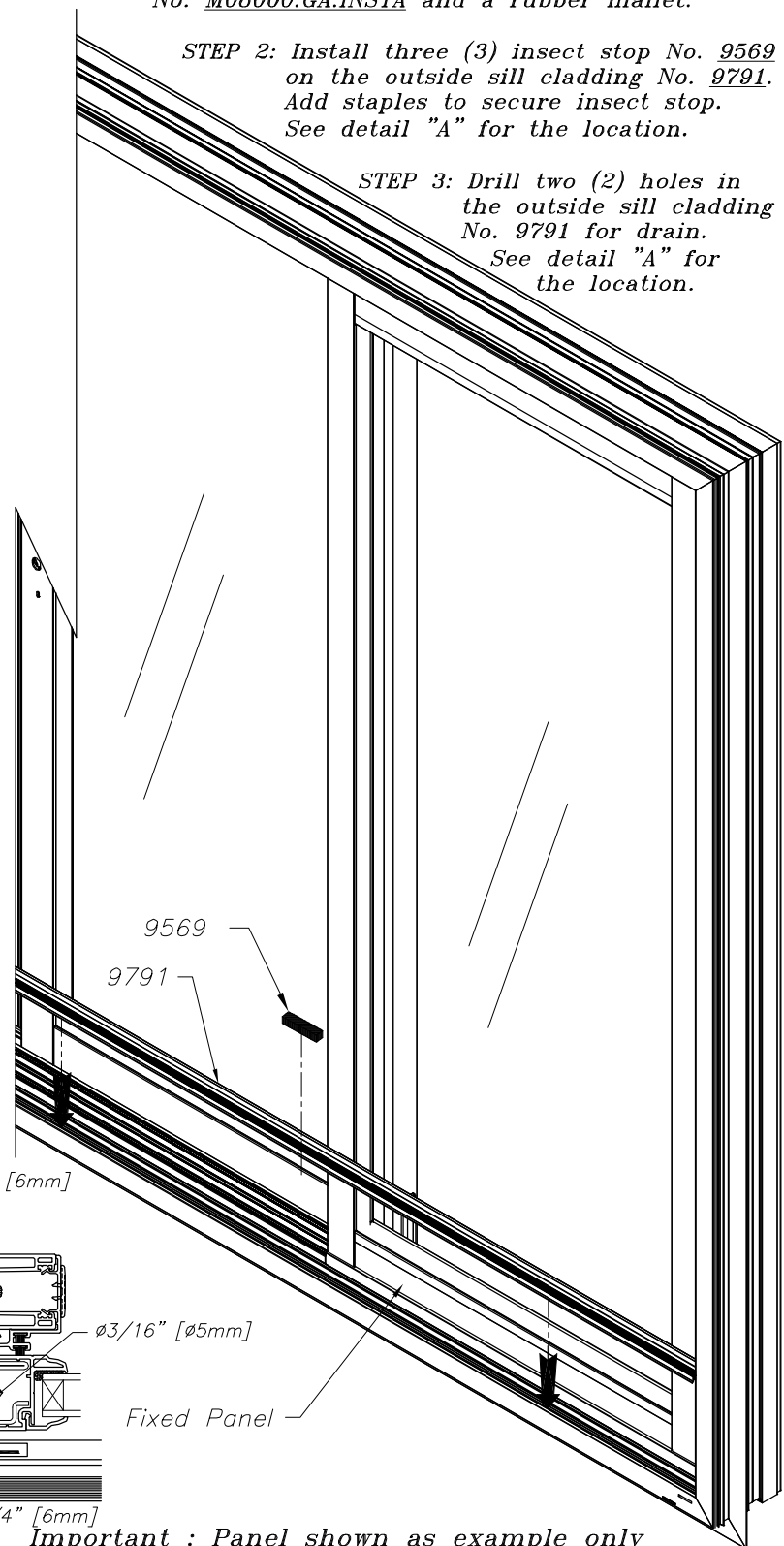
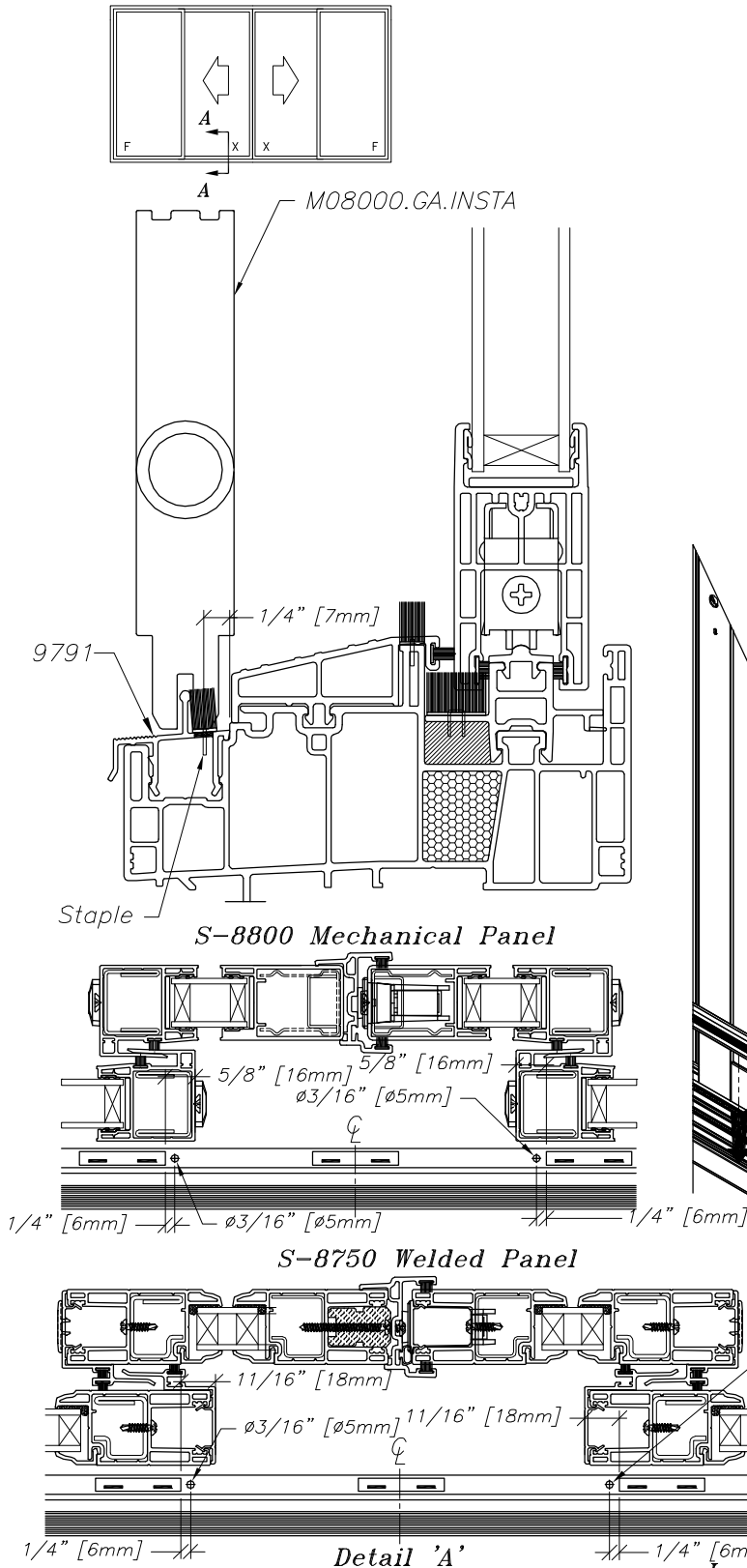
Four (4) Panel Patio Door

Assembly Sequence

STEP 1: Install the outside sill cladding No. 9791, on the sill, using a jig No. M08000.GA.INSTA and a rubber mallet.

STEP 2: Install three (3) insect stop No. 9569 on the outside sill cladding No. 9791. Add staples to secure insect stop. See detail "A" for the location.

STEP 3: Drill two (2) holes in the outside sill cladding No. 9791 for drain. See detail "A" for the location.



Important : Panel shown as example only

2.2 Assembly Procedure

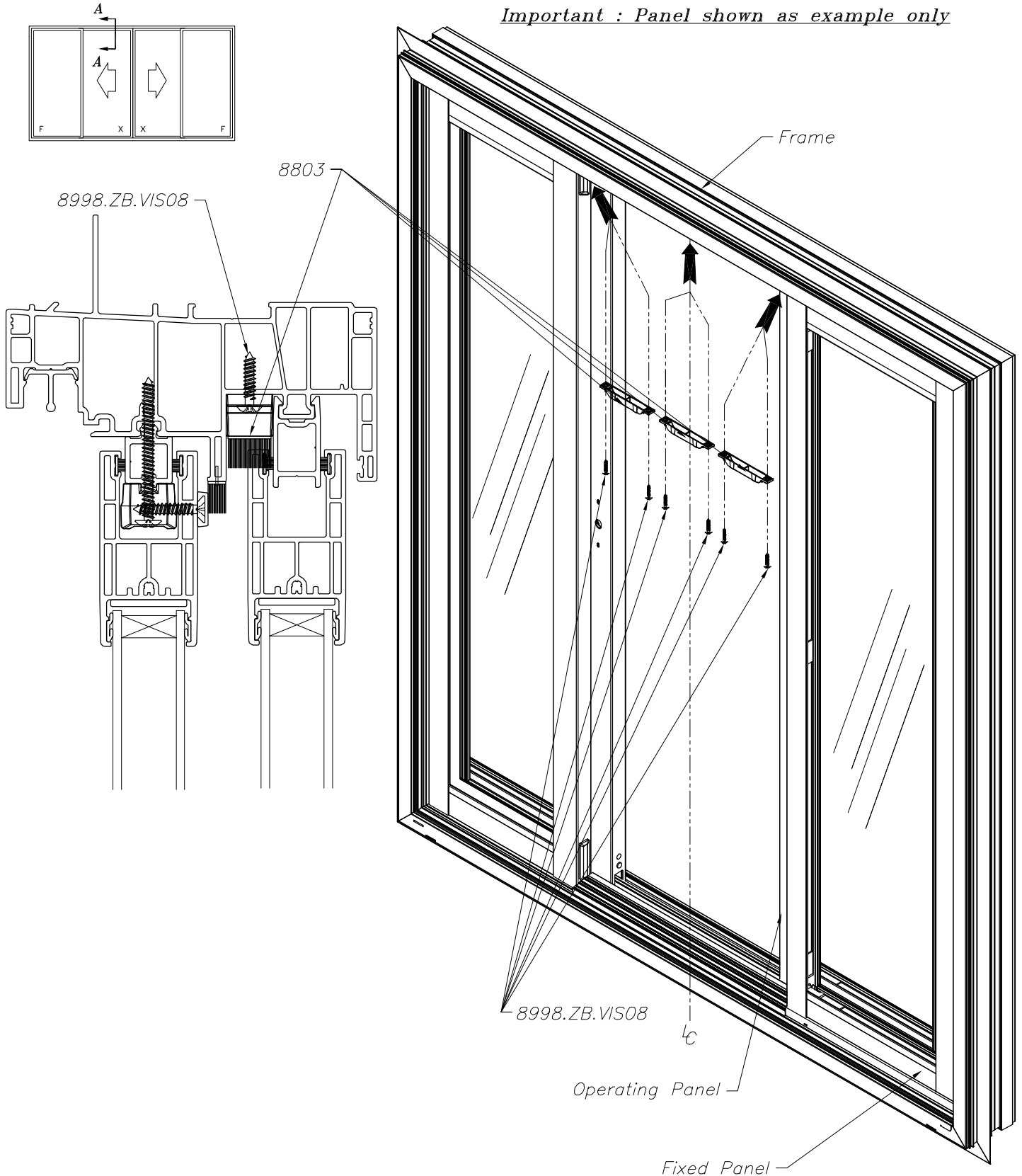
REVISION:
2012/02/02

PAGE:
B-33

2.2.17 Head Weatherseal Installation

Four (4) Panel Patio Door

Important : Panel shown as example only



2.2 Assembly Procedure

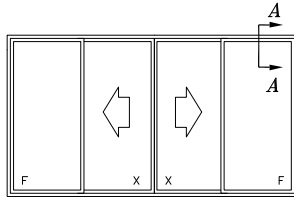
REVISION:

PAGE:

B-34

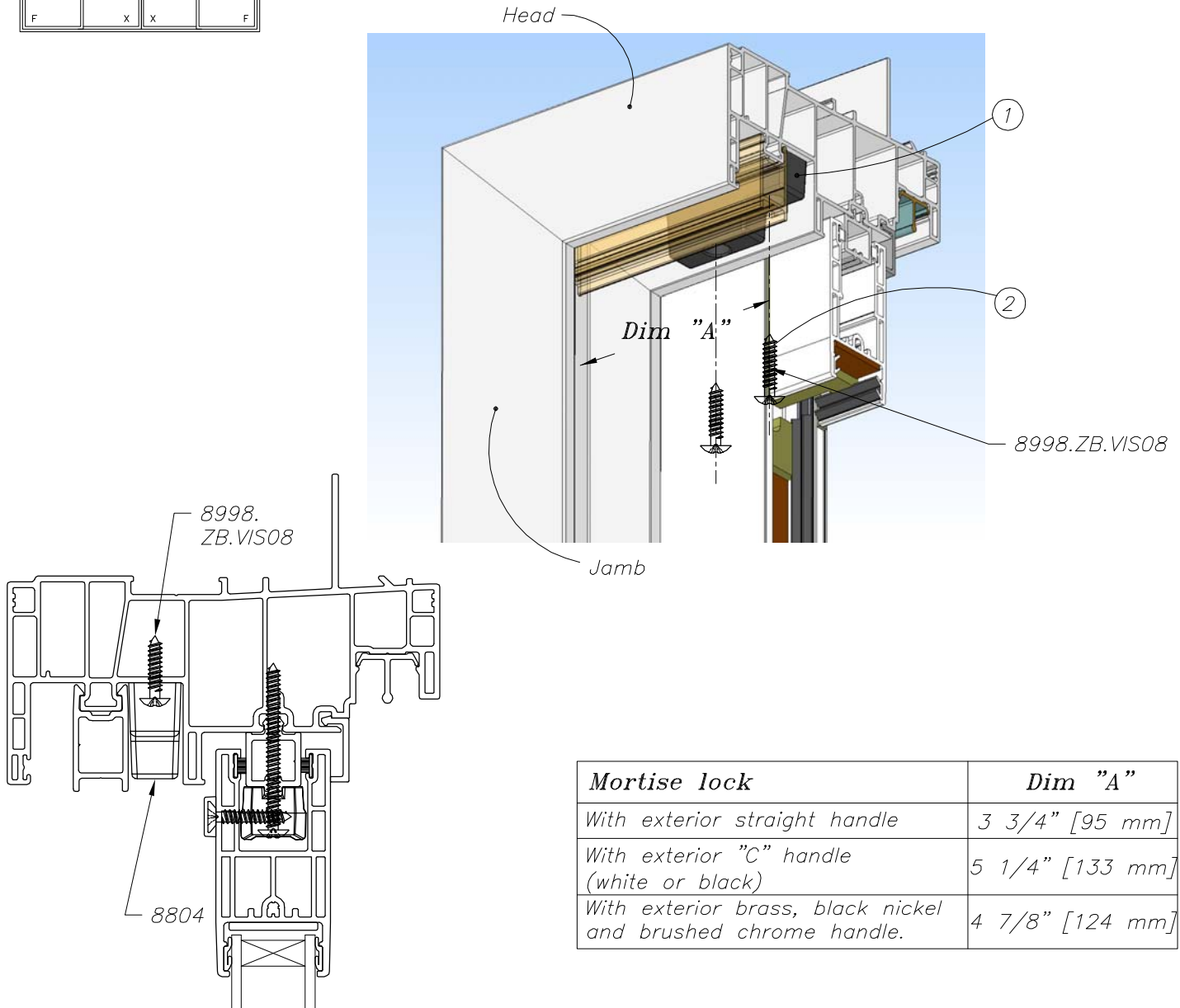
2.2.18 Sash Stopper Installation

Four (4) Panel Patio Door



Important : Panel shown as example only

Note : Depending on the sashes used, refer to the sash section of the technical manual for installation details regarding the handle.



Mortise lock	Dim "A"
With exterior straight handle	3 3/4" [95 mm]
With exterior "C" handle (white or black)	5 1/4" [133 mm]
With exterior brass, black nickel and brushed chrome handle.	4 7/8" [124 mm]

Steps for Proper Assembly

- 1- Locate sash stopper depending on type of handle chosen. (See table above)
- 2- On the fixed panel side, place the sash stopper at the indicated place.
(See drawings above).
- 3- Fasten the sash stopper with (2) screws No. 8998.ZB.VIS08.
- 4- Repeat the steps 1, 2 and 3 to install the sash stopper on the other side.



2.3 Bill of Material

REVISION:

2011/07/04

PAGE:

B-35

2.3.1 Required Material for Four (4) Panel Door

Description	Qty	Contents
<i>Sill</i>	1	<ul style="list-style-type: none"> 8000 Sill profile 7003 Molded fixed panel anchor block 8001/8101 Bottom fixed support panel 8011/8111 Sill protector 8021 Operating panel support 8981 Interlock dust plug (Ultrafab No. TF4427AHG) 8982 Sill dust plug (Ultrafab No. TF4465AHG) 8985 Sill foam block for 8021 8987 Insect stop foam for 8000 9785.ZC. No. 8-15 x 2", truss head, quadrex, wood screw VIS08 9790 Aluminum rolling rail 9791 Outside sill cladding 9569 Insect stop
<i>Head</i>	1	<ul style="list-style-type: none"> 8000 Head profile 7003 Molded fixed panel anchor block 8002 Head track 8012 Head screen track 8022/8122 Top fixed support panel 8803 Head weatherseal 8804 Sash stopper 8998.ZC. No. 8-18 x 3/4", truss head, quadrex VIS08 8981 Interlock dust plug (Ultrafab No. TF4427AHG) 9785.ZC. No. 8-15 x 2", truss head, quadrex, wood screw VIS08 9750.00. Kit of central stopper SAC95 - 9719 Central Sash Stopper - 9725 Outside Screen Stopper - 8961.ZC. No. 6-20 x 3/8", pan head, quadrex VIS06 - 9149.ZC. No. 8 x 1 1/4", pan head, quadrex VIS08
<i>Jamb fixed side</i>	2	<ul style="list-style-type: none"> 8000 Jamb profile 8980 Foam tape

2.4 Standard Dimensions

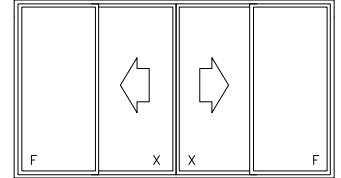
REVISION:

2012/04/18

PAGE:

B-36

2.4.1 Standard Widths for Four (4) Panel Door



Four (4) Panel Patio Door

Horizontal parts (S-8750)

Description	Part	Qty	3565			Formula
¹ Actual width			140.308" 3563.8 mm			
² Frame (cut to 45°)	8000/8010	2	140.308" 3563.8 mm			Actual width Actual width
³ Operating support panel	8021	1	137.048" 3481.0 mm			Actual width - 3.260" Actual width - 82.8 mm
⁴ Head track	8002	1	137.048" 3481.0 mm			Actual width - 3.260" Actual width - 82.8 mm
⁵ Screen track	8012	1	138.368" 3514.5 mm			Actual width - 1.940" Actual width - 49.3 mm
⁶ Bottom fixed support panel	8101	1	35.488" 901.4 mm			(Actual width / 4) + 0.411" (Actual width / 4) + 10.4 mm
⁷ Top fixed support panel	8122	1	35.488" 901.4 mm			(Actual width / 4) + 0.411" (Actual width / 4) + 10.4 mm
⁸ Sill protector	8111	1	65.210" 1656.3 mm			(Actual width / 2) - 4.944" (Actual width / 2) - 125.6 mm
⁹ Operating panel rail	9790	1	137.048" 3481.0 mm			Actual width - 3.260" Actual width - 82.8 mm
¹⁰ Outside sill cladding	9791	1	137.278" 3486.9 mm			Actual width - 3.030" Actual width - 76.9 mm

Horizontal parts (S-8800)

Description	Part	Qty	3565			Formula
¹ Actual width			140.308" 3563.8 mm			
² Frame (cut to 45°)	8000/8010	2	140.308" 3563.8 mm			Actual width Actual width
³ Operating support panel	8021	1	137.048" 3481.0 mm			Actual width - 3.260" Actual width - 82.8 mm
⁴ Head track	8002	1	137.048" 3481.0 mm			Actual width - 3.260" Actual width - 82.8 mm
⁵ Screen track	8012	1	138.368" 3514.5 mm			Actual width - 1.940" Actual width - 49.3 mm
⁶ Bottom fixed support panel	8001	1	34.931" 887.2 mm			(Actual width / 4) - 0.146" (Actual width / 4) - 3.7 mm
⁷ Top fixed support panel	8022	1	34.931" 887.2 mm			(Actual width / 4) - 0.146" (Actual width / 4) - 3.7 mm
⁸ Sill protector	8011	1	66.407" 1686.7 mm			(Actual width / 2) - 3.747" (Actual width / 2) - 95.2 mm
⁹ Operating panel rail	9790	1	137.048" 3481.0 mm			Actual width - 3.260" Actual width - 82.8 mm
¹⁰ Outside sill cladding	9791	1	137.278" 3486.9 mm			Actual width - 3.030" Actual width - 76.9 mm

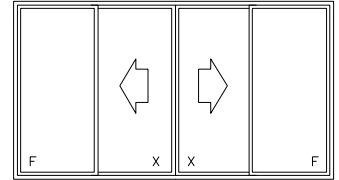
2.4 Standard Dimensions

REVISION:

PAGE:

B-37

2.4.2 Standard Heights for Four (4) Panel Door



Four (4) Panel Patio Door

Vertical parts

	<i>Description</i>	<i>Part</i>	<i>Qty</i>	<i>2015</i>	<i>2075</i>	<i>2395</i>	<i>Formula</i>
50	<i>Actual height</i>			<i>79.278"</i> <i>2013.7 mm</i>	<i>81.652"</i> <i>2074.0 mm</i>	<i>94.267"</i> <i>2394.4 mm</i>	
51	<i>Frame (cut to 45°)</i>	<i>8000/8010</i>	<i>2</i>	<i>79.278"</i> <i>2013.7 mm</i>	<i>81.652"</i> <i>2074.0 mm</i>	<i>94.267"</i> <i>2394.4 mm</i>	<i>Actual height</i> <i>Actual height</i>
52	<i>Vertical groove cover</i>	<i>5771</i>	<i>2</i>	<i>75.829"</i> <i>1926.1 mm</i>	<i>78.203"</i> <i>1986.4 mm</i>	<i>90.818"</i> <i>2306.8 mm</i>	<i>Actual height - 3.449"</i> <i>Actual height - 87.6 mm</i>