

Appendix -A-

*Addendum for
Three (3) Panel
Patio Door*



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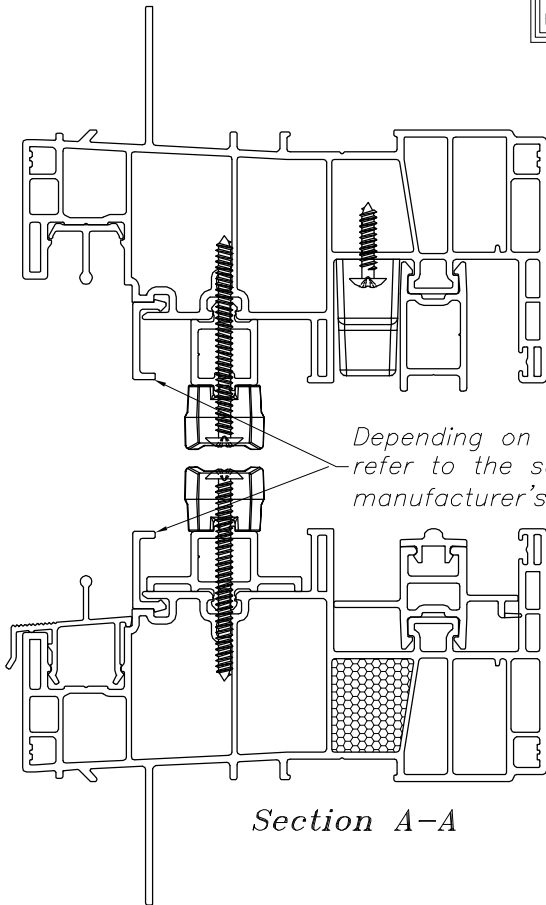
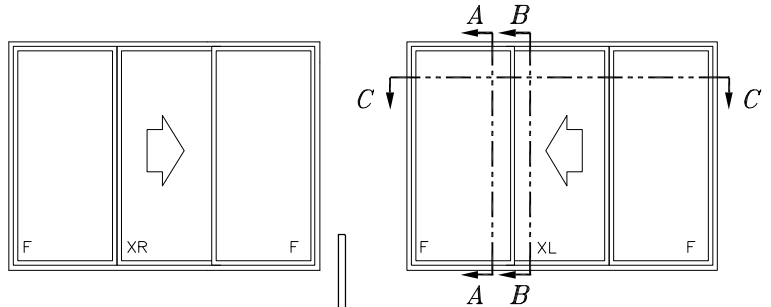
1.1 Introduction

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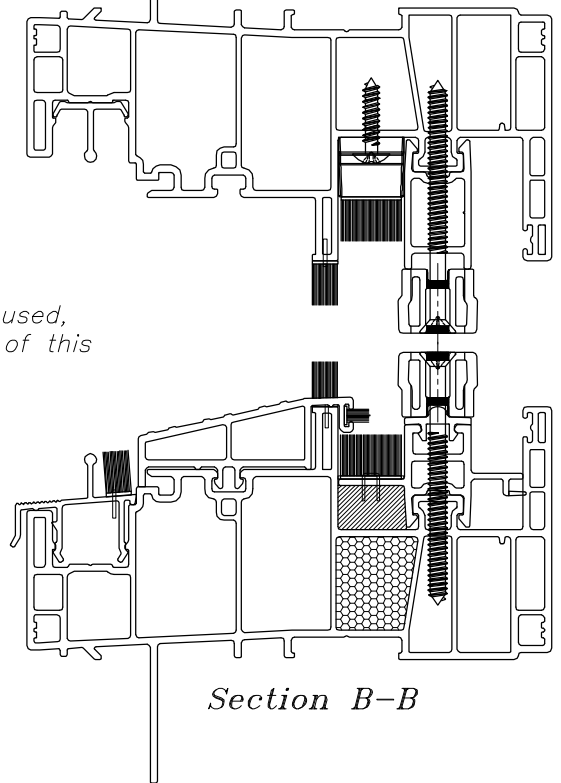
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1.1.1 All P.V.C. Welded Frame Section

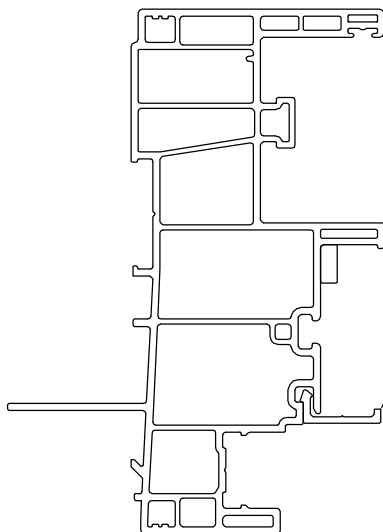
Three (3) Panel Patio Door



Section A-A



Section B-B



Section C-C

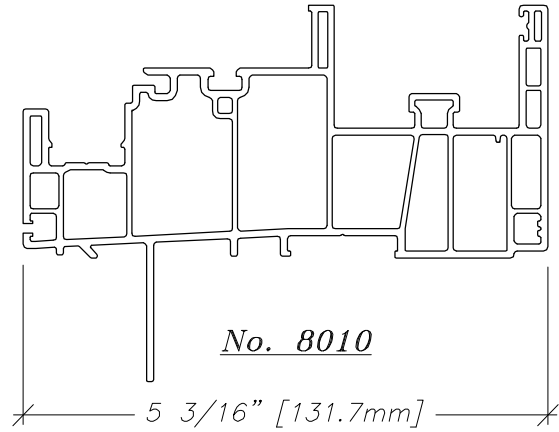
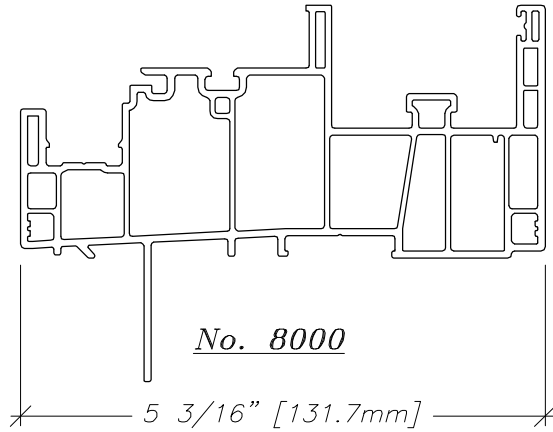
1.2 Catalog of Parts

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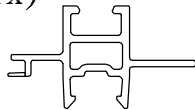
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1.2.1 Profiles for the Frame

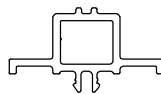
Main Frame (Sold in 16' [4.88m] length)



Operating Support Panel
No. 8021 (1x)



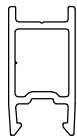
Bottom Fixed Support Panel
No. 8001/8101 (2x)



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



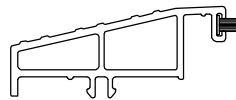
Head Track No. 8002 (1x)



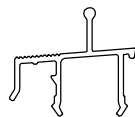
Head Screen Track No. 8012 (1x)



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

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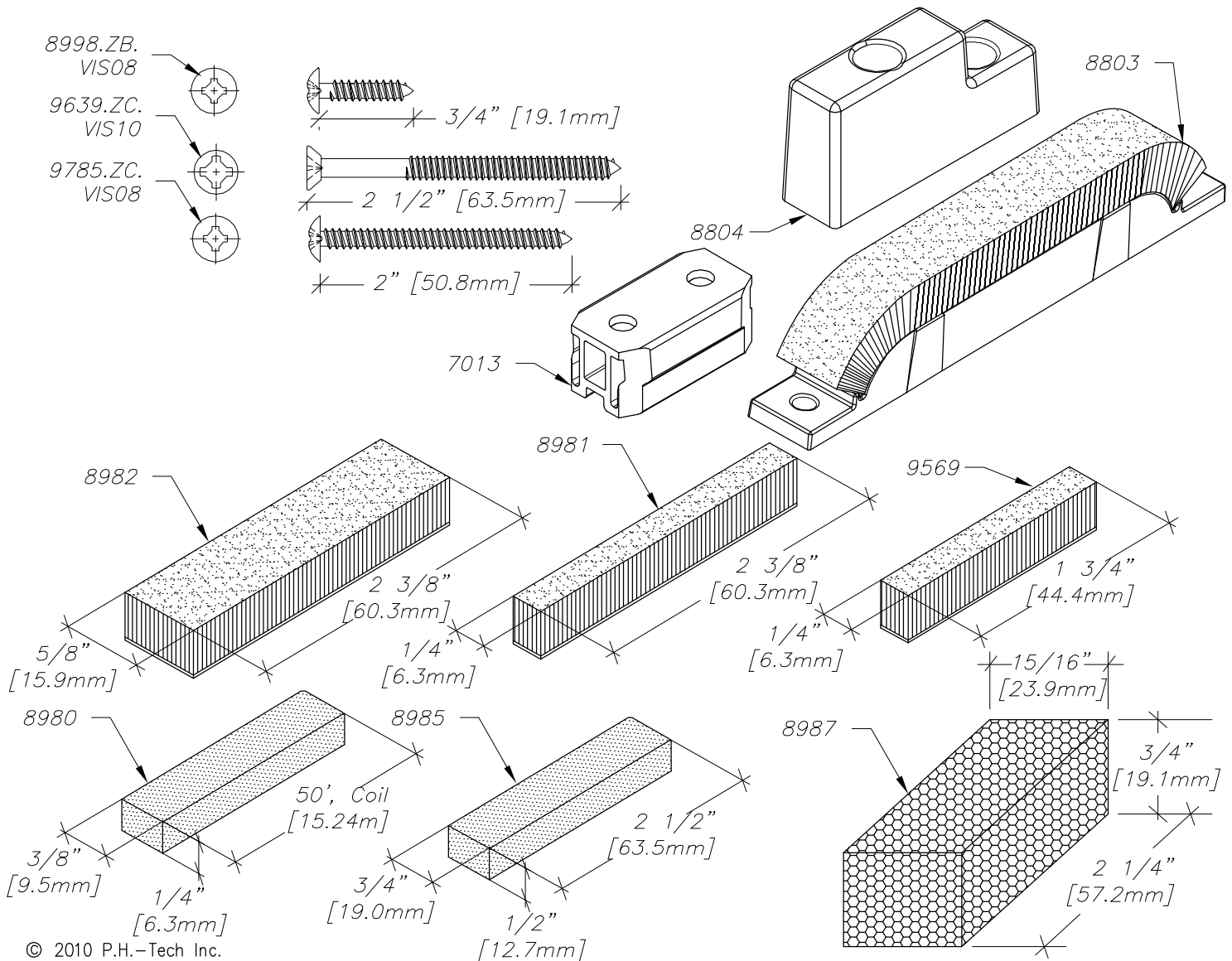
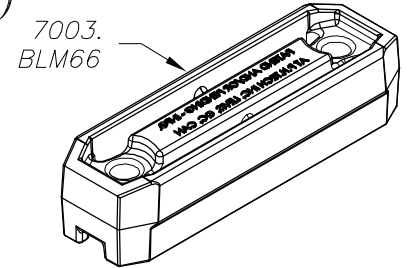
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1.2.2 Required Hardware for the Frame

Hardware List

- Molded fixed panel anchor block No. 7003.BLM66 (4x)
- Mullion anchor block No. 7013 (2x)
- Head weatherseal No. 8803 (2x)
- Sash stopper No. 8804 (1x)
- Foam tape No. 8980 (50', coil)
- Interlock dust plug No. 8981 (4x)
- Sill dust plug No. 8982 (2x)
- Insect stop foam No. 8987 (2x)
- Insect stop No. 9569 (2x)
- No. 8 x 3/4", truss head, Quadrex, screw No 8998.ZB.VIS08 (6x)
- No. 10 x 2 1/2", flat head, quadrex screw No. 9639.ZC.VIS10 (4x)
- No. 8 x 2", pan head, Quadrex, wood screw No 9785.ZC.VIS08 (16x)
- Sill foam block No. 8985 (2x)



1.2 Catalog of Parts

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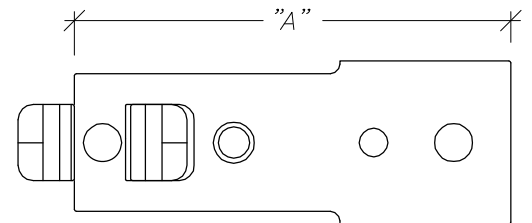
1.2.2 Required Hardware for the Frame (Continued)

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]



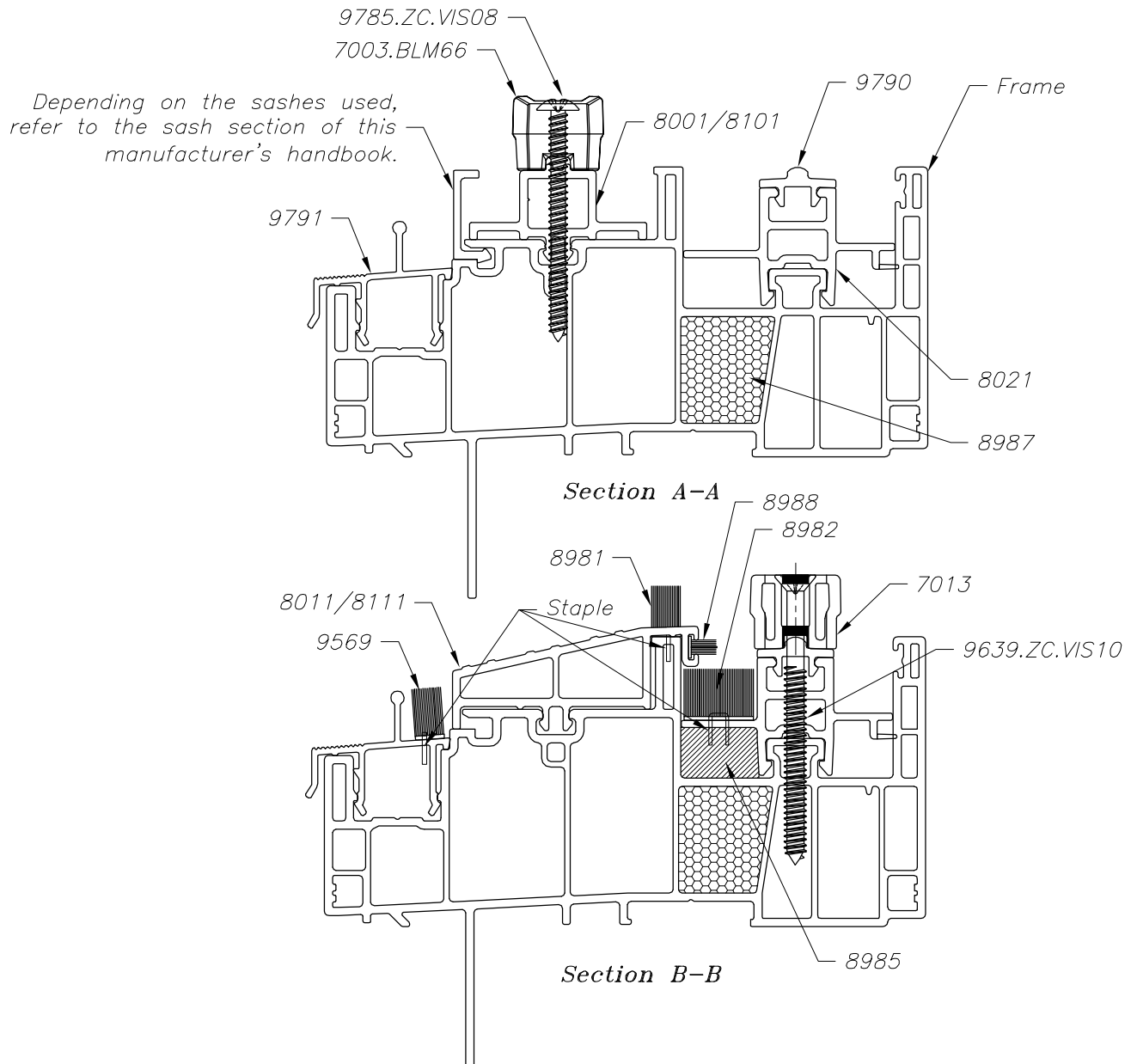
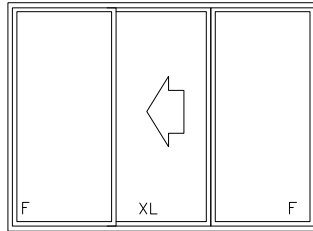
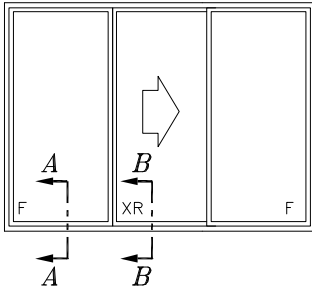
1.3 Assembly Drawings

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1.3.1 Sill Assembly Section

Three (3) Panel Patio Door



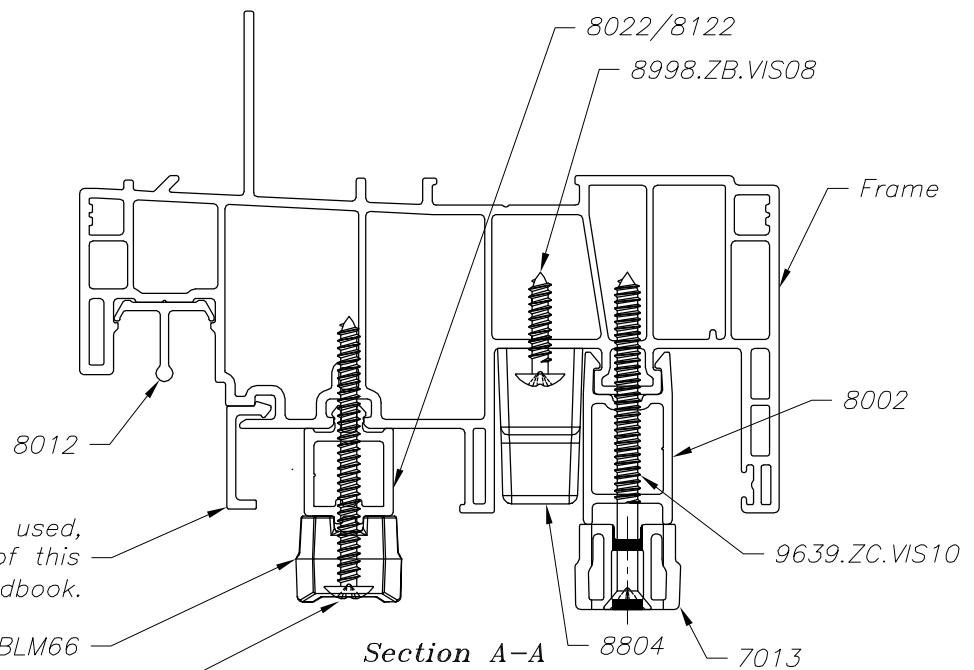
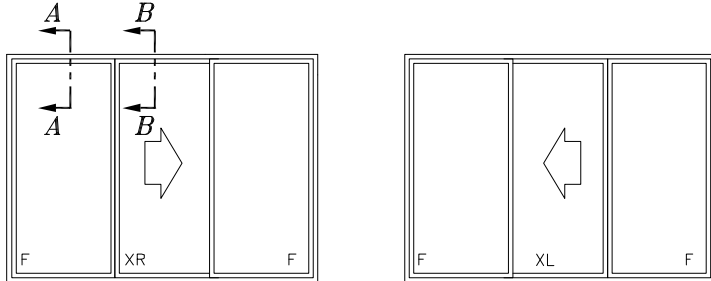
1.3 Assembly Drawings

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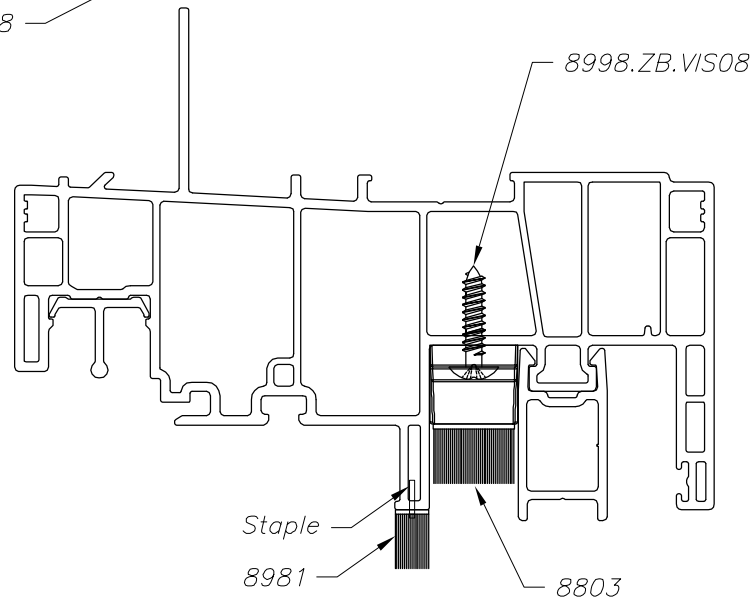
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1.3.2 Head Assembly Section

Three (3) Panel Patio Door



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



1.3 Assembly Drawings

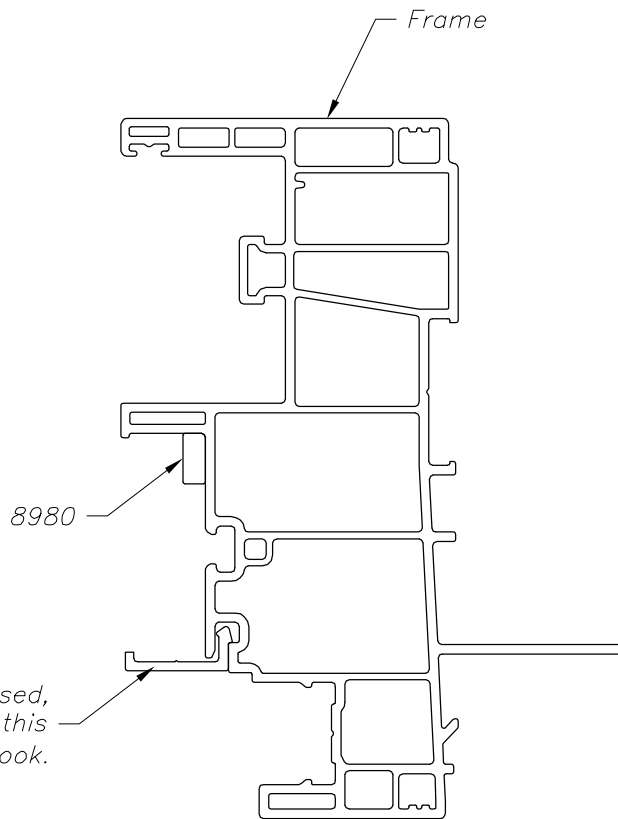
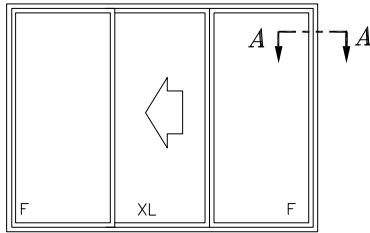
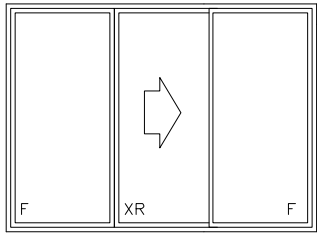
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1.3.3 Jamb Assembly Section, Right Panel Side

Three (3) 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

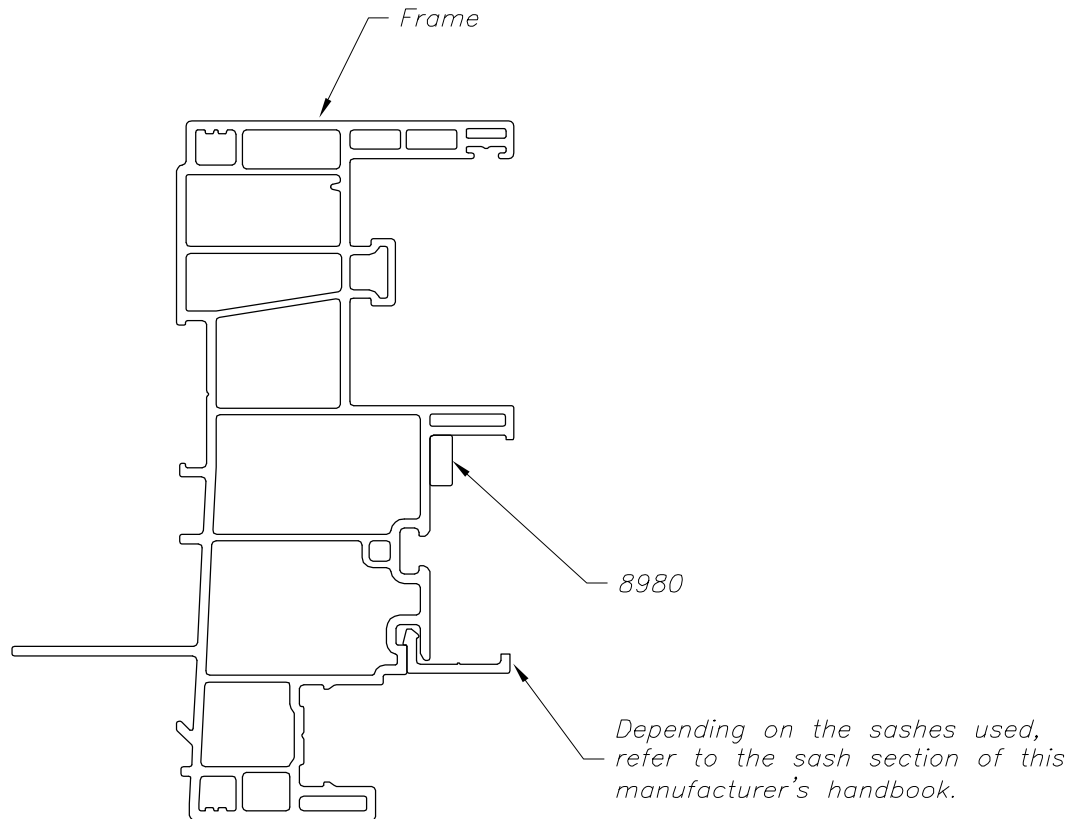
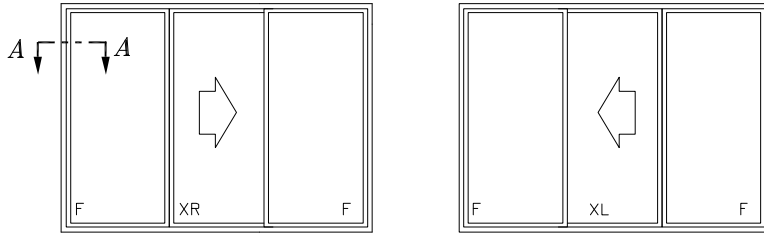
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1.3.4 Jamb Assembly Section, Left Panel Side

Three (3) Panel Patio Door



Section A-A

2.1 Manufacturing

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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

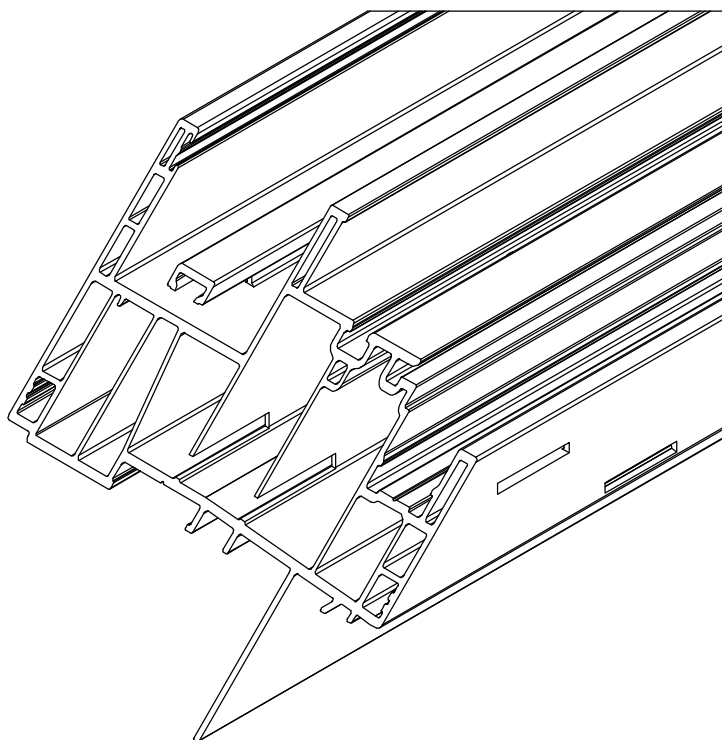
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2.1.2 Frame Drainage

- *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.*



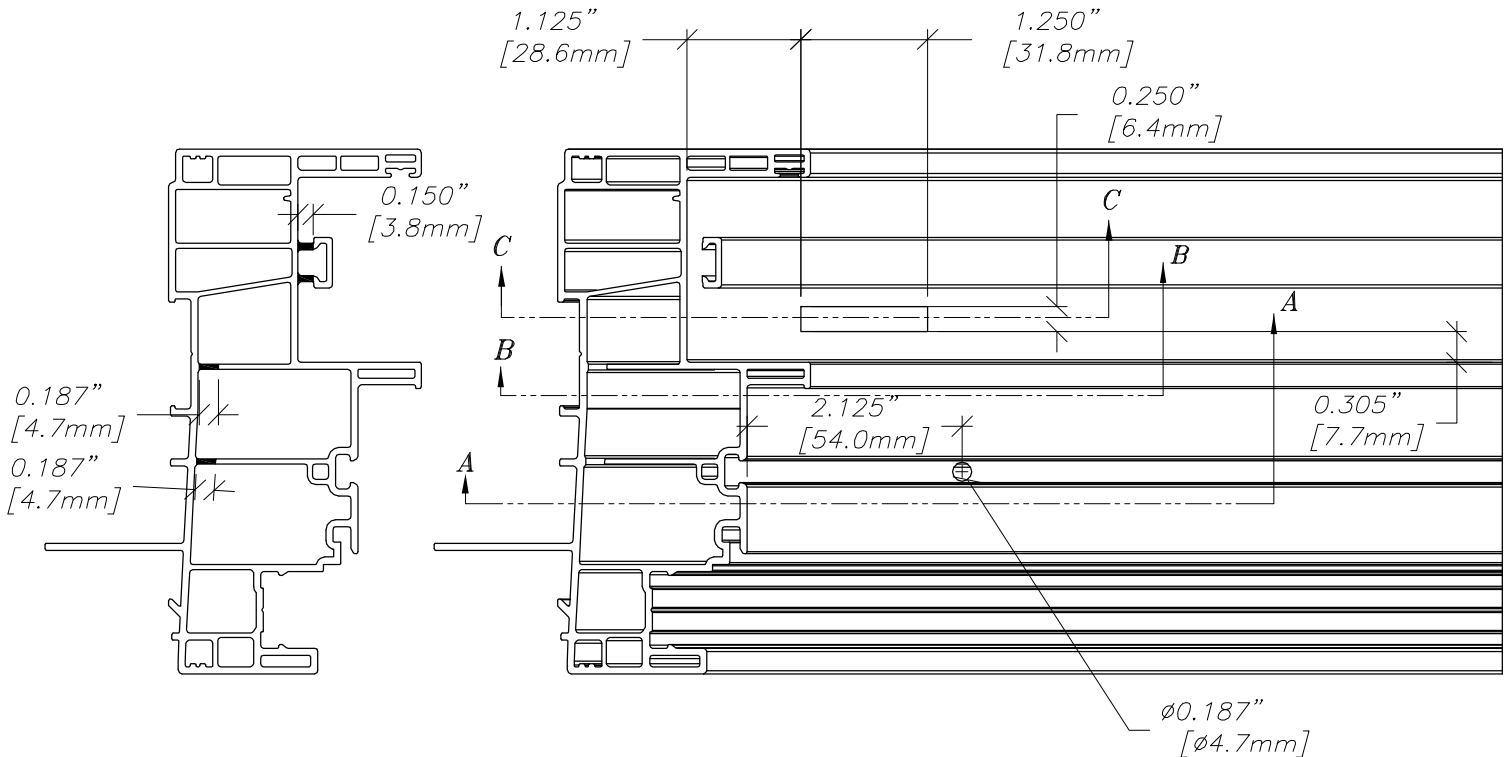
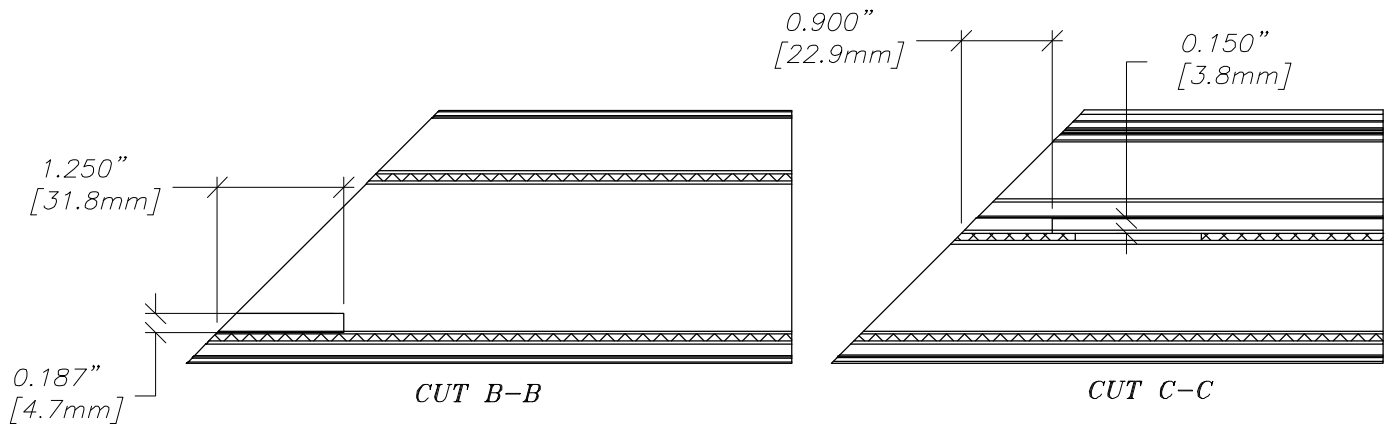
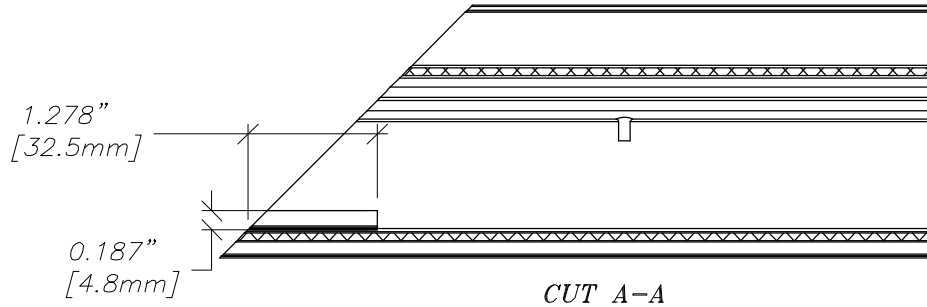
Operation(s) to do at both ends.

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2.1.2 Frame Drainage (Continued)



Operation(s) to do at both ends.

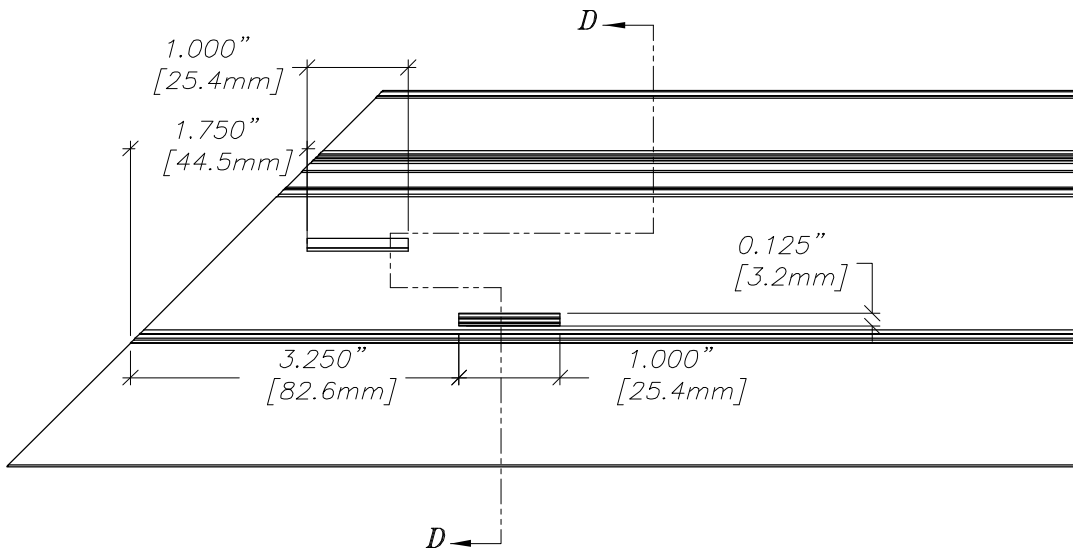
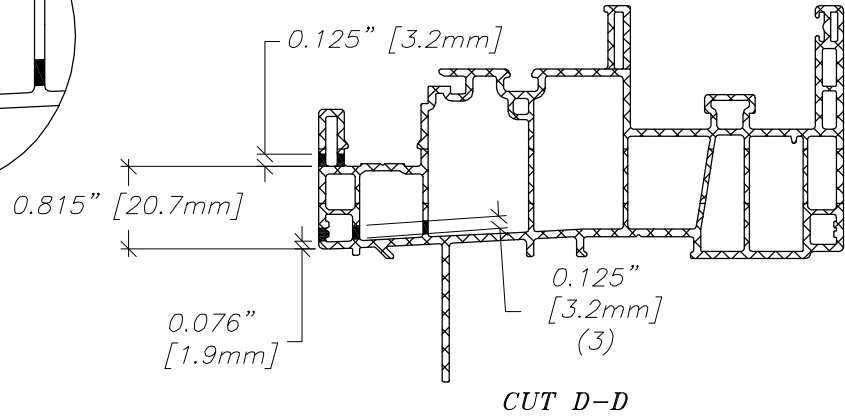
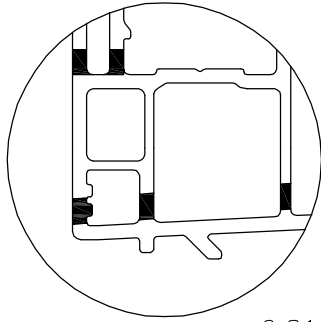
2.1 Manufacturing

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2.1.2 Frame Drainage (Continued)



Operation(s) to do at both ends.

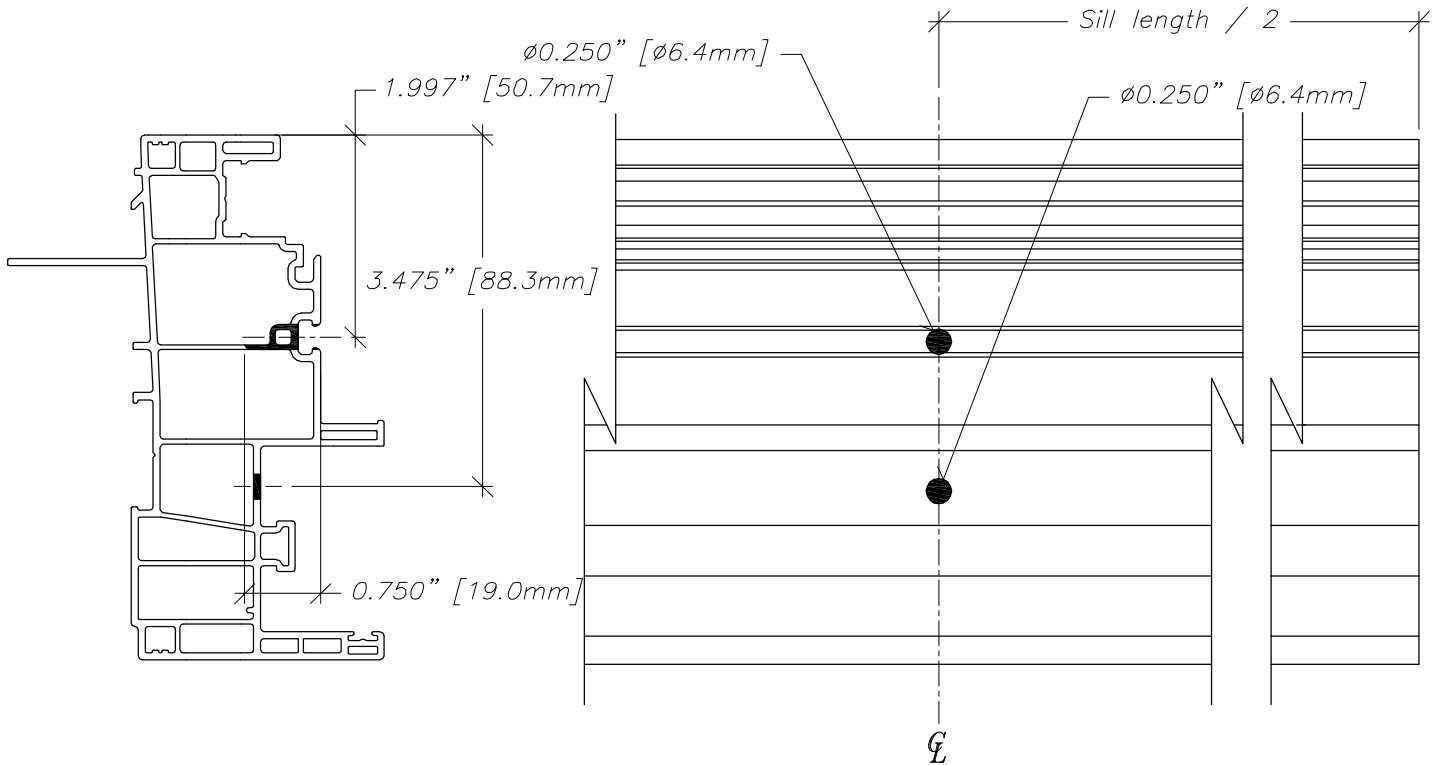
2.1 Manufacturing

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2.1.2 Frame Drainage (Continued)



2.1 Manufacturing

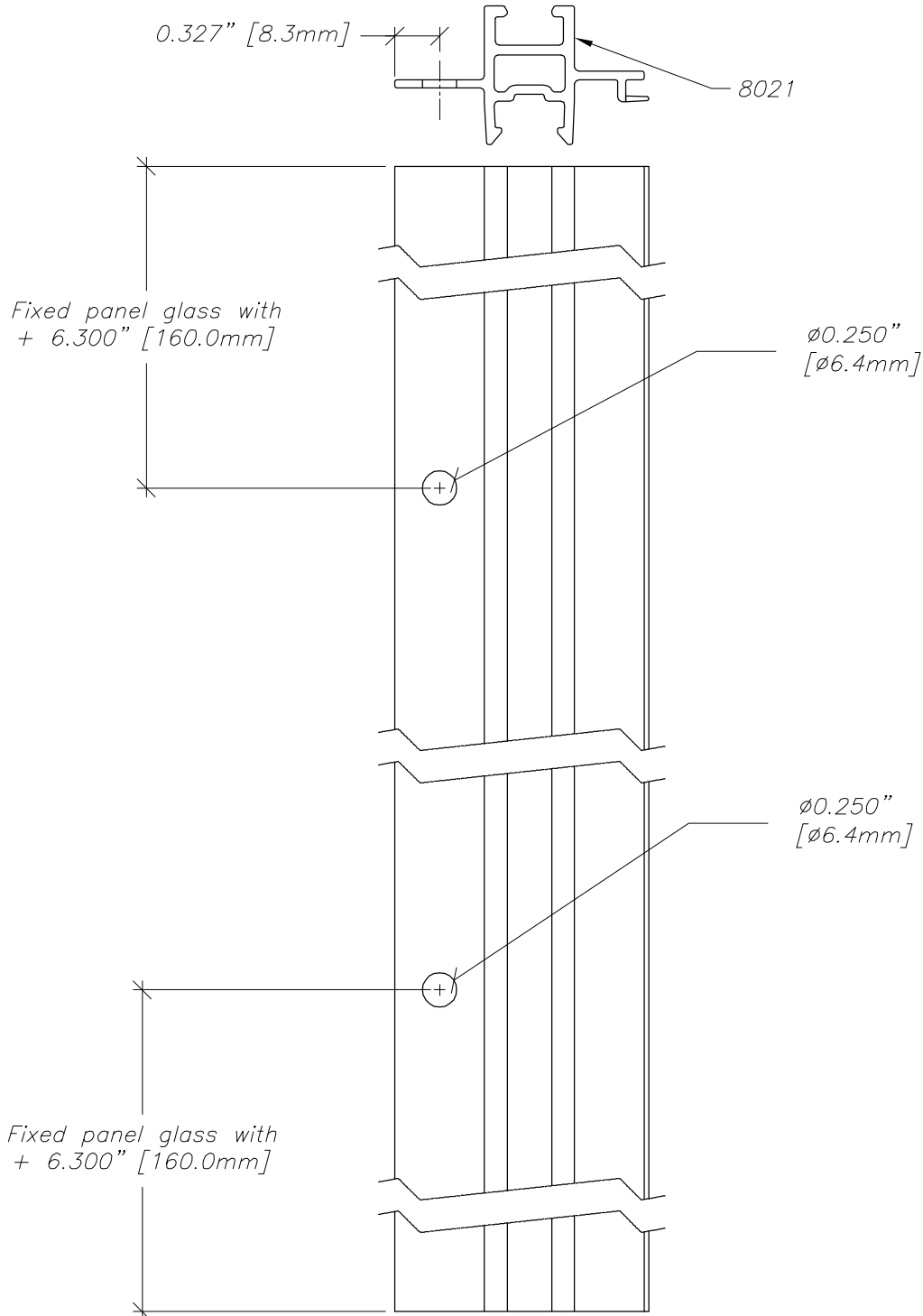
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2.1.3 Operating Support Panel Drainage

- Drill the operating support panel as per drawing specifications.



Operation(s) to do at both ends.

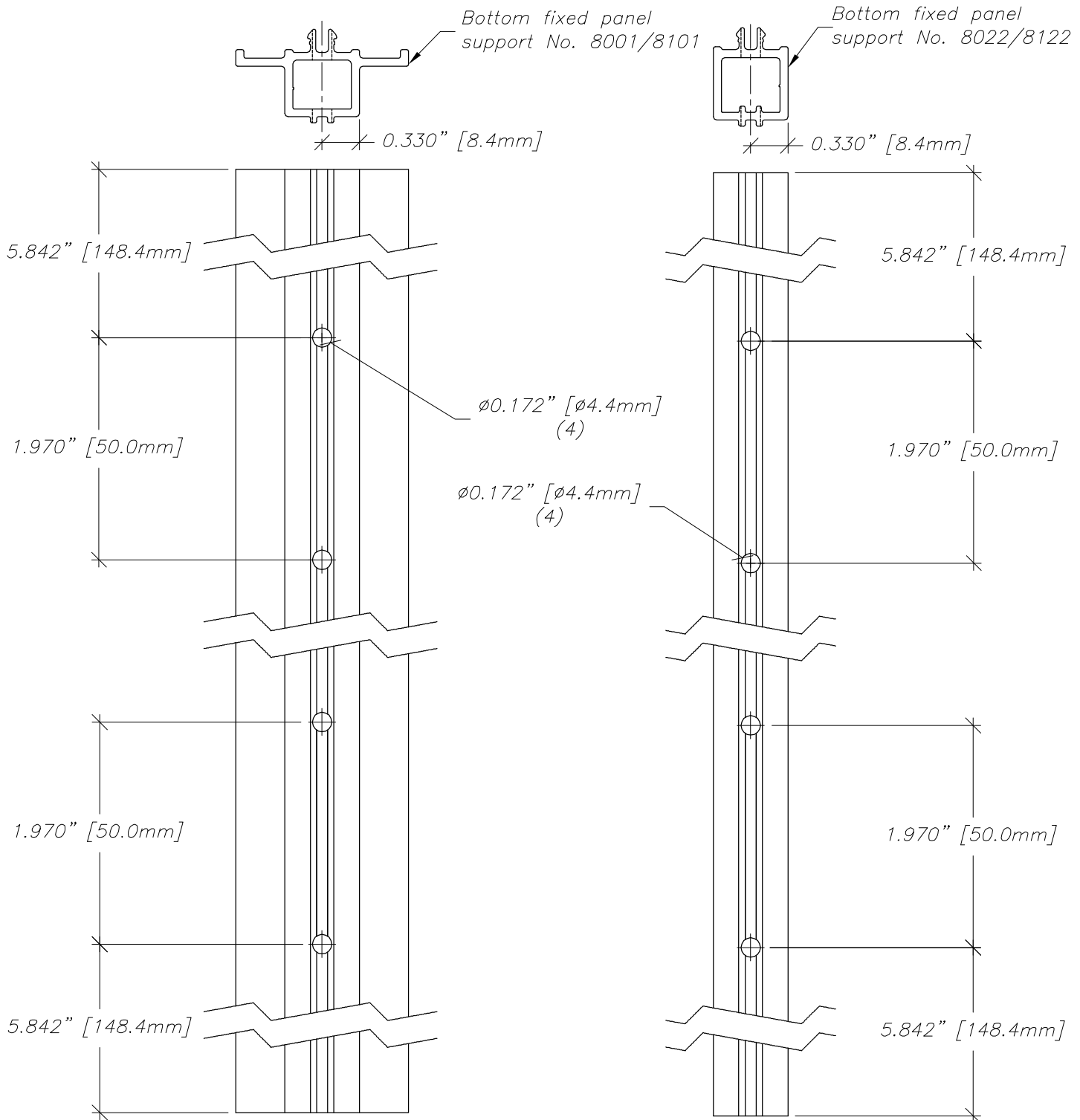
2.1 Manufacturing

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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

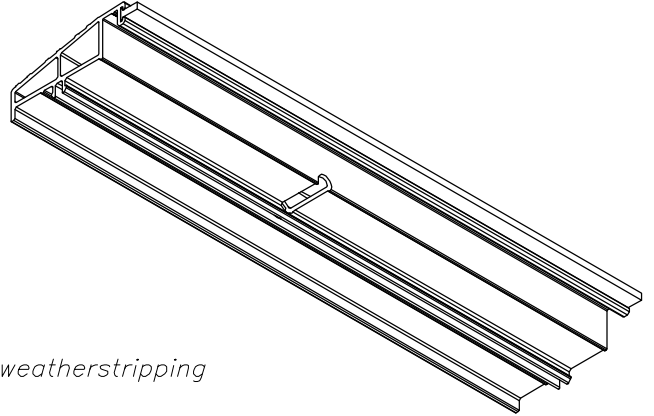
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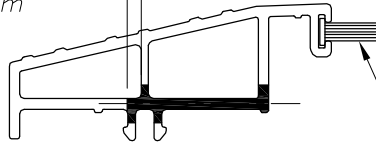
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2.1.5 Sill Protector Drainage

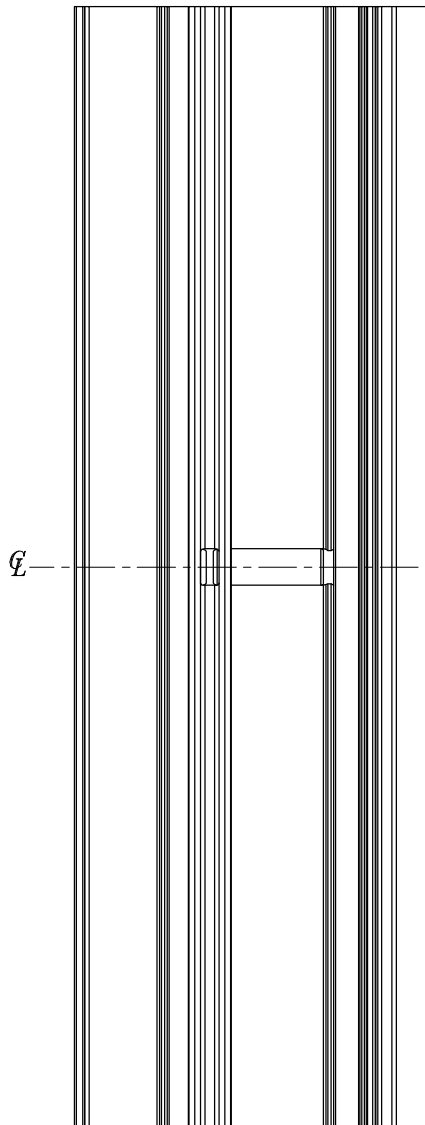
- Drill the operating sill protector as per drawing specifications.



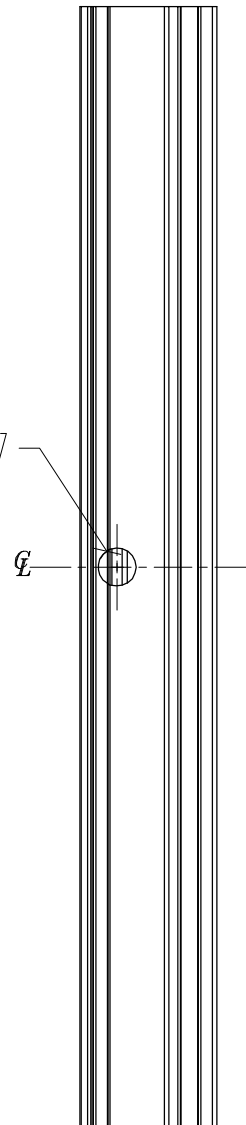
0.093" [2.4mm]
Minimum



Pile weatherstripping



∅0.250" [∅6.4mm]



2.2 Assembly Procedure

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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

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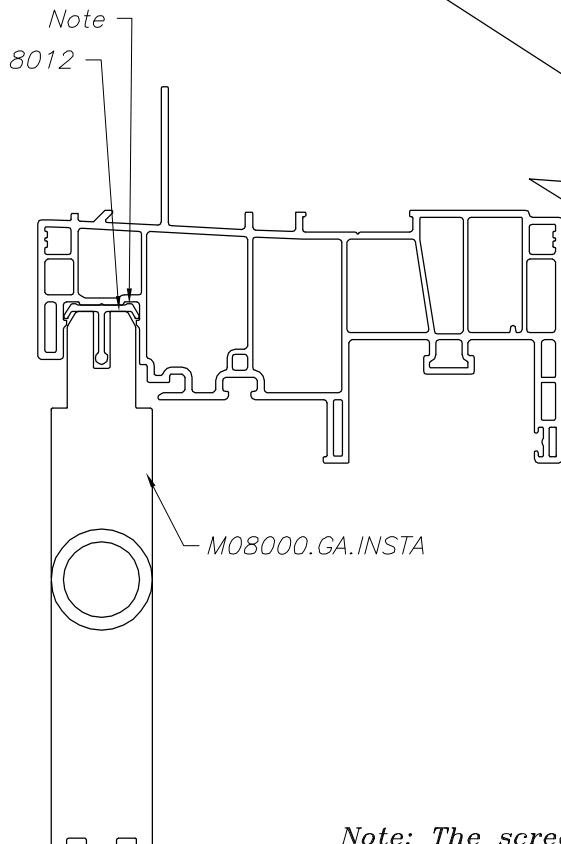
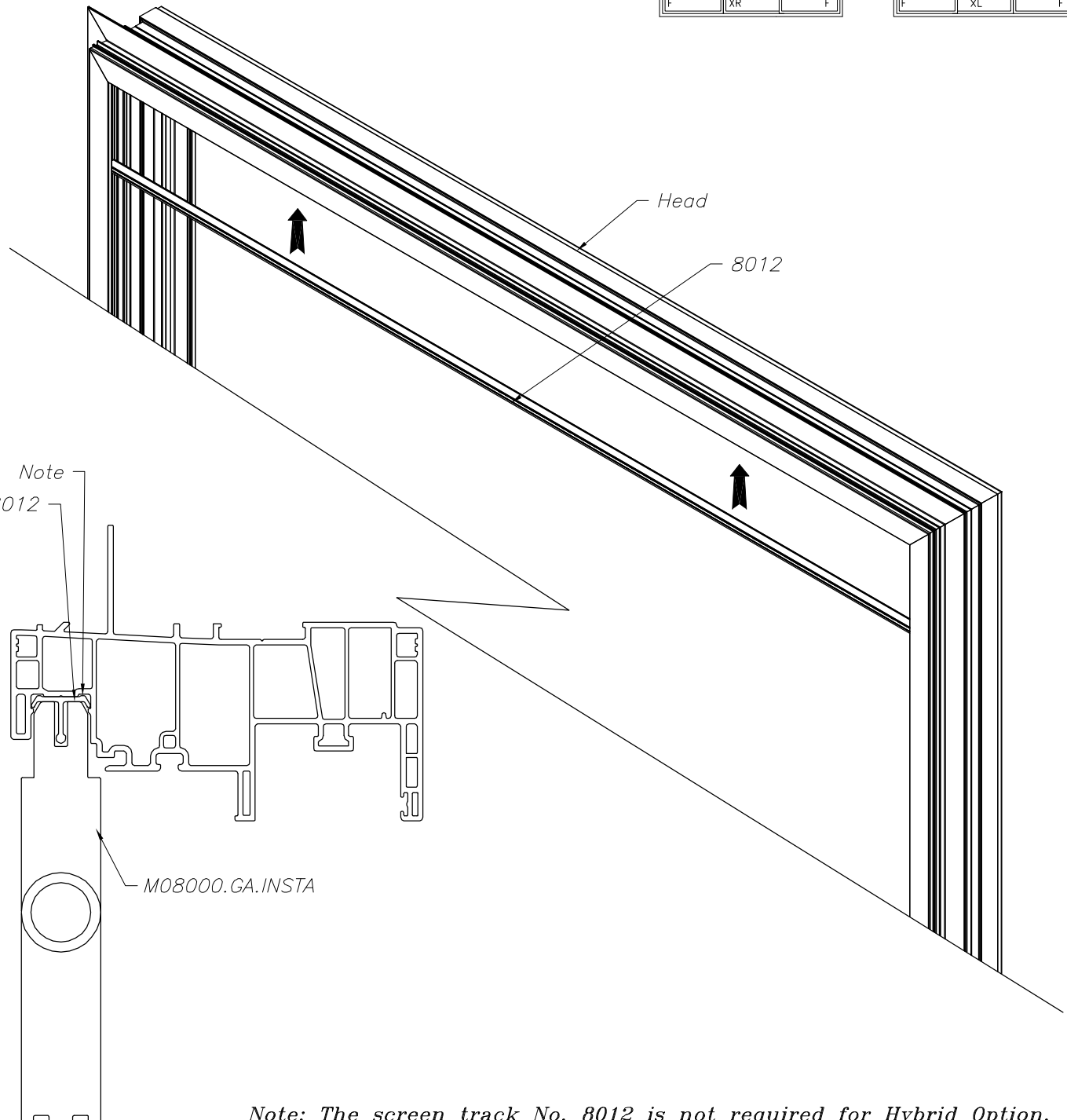
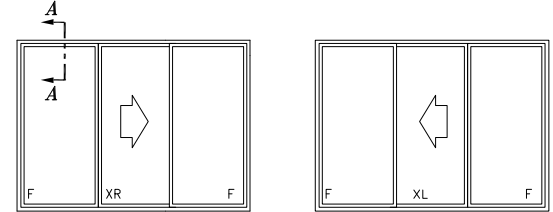
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2.2.2 Head Screen Track Installation

Assembly Sequence

- Using a jig M08000.GA.INSTA and a rubber mallet, insert No. 8012 screen track in the head.

Three (3) Panel Patio Door



Note: The screen track No. 8012 is not required for Hybrid Option.

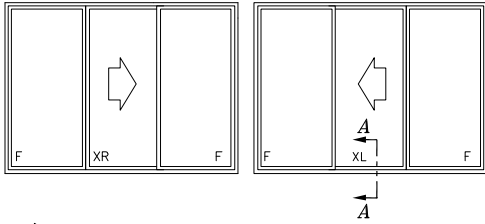
2.2 Assembly Procedure

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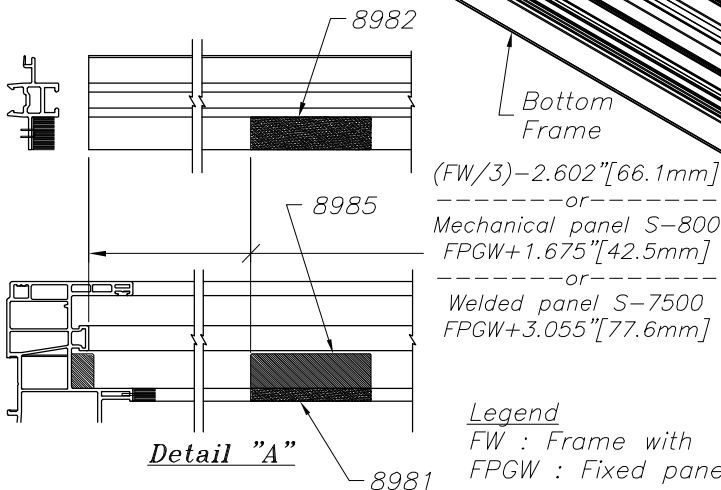
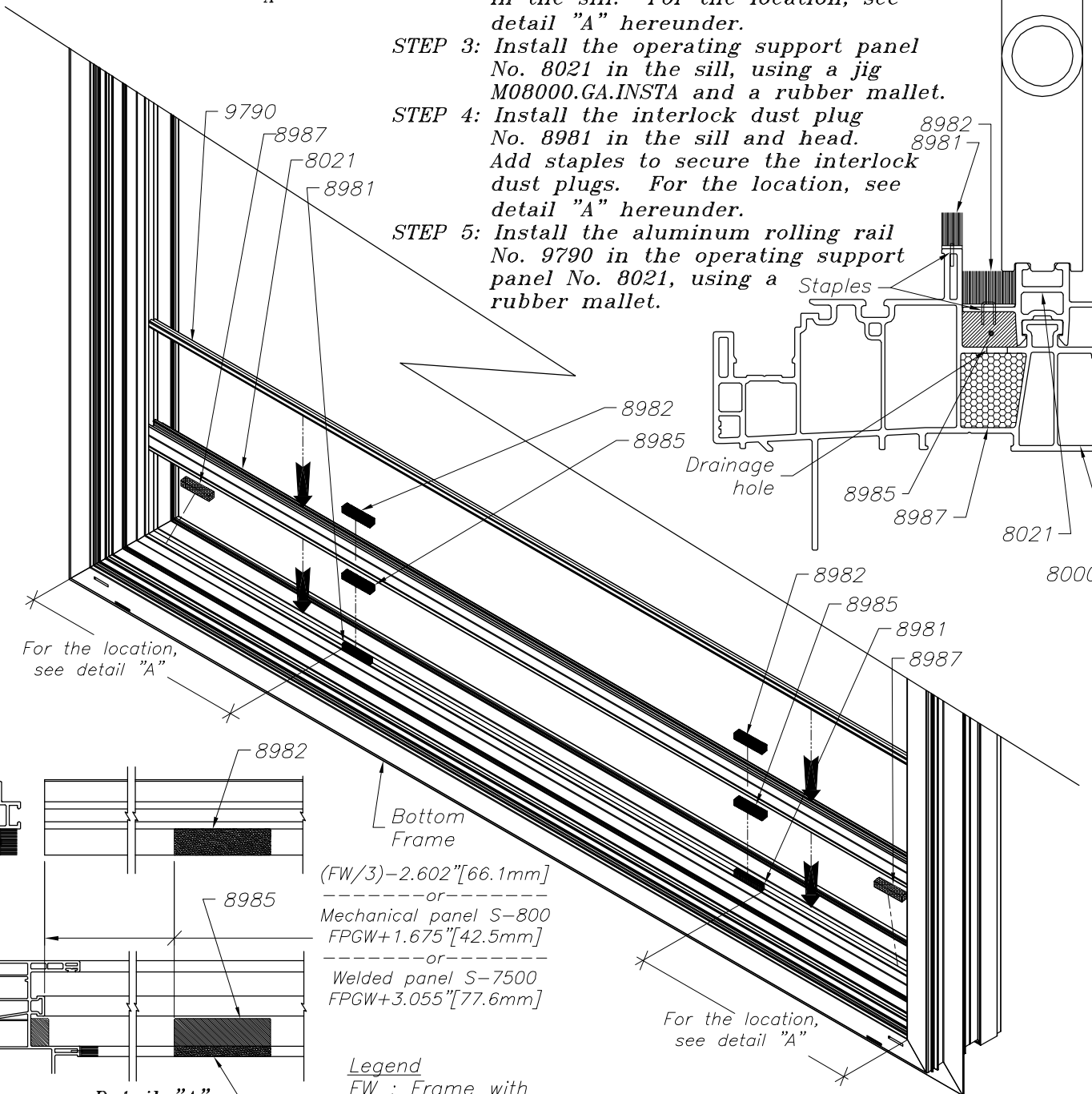
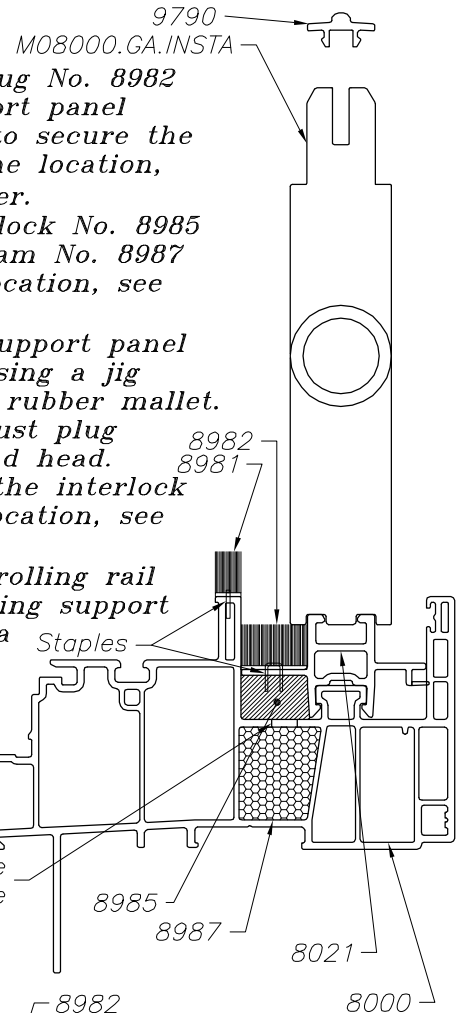
2.2.3 Operating Support Panel and Dust Plugs Installation

Three (3) Panel Patio Door



Assembly Sequence

- STEP 1:** Install the sill dust plug No. 8982 on the operating support panel No. 8021. Add staples to secure the sill dust plugs. For the location, see detail "A" hereunder.
- STEP 2:** Install the sill foam block No. 8985 and the insect stop foam No. 8987 in the sill. For the location, see detail "A" hereunder.
- STEP 3:** Install the operating support panel No. 8021 in the sill, using a jig M08000.GA.INSTA and a rubber mallet.
- STEP 4:** Install the interlock dust plug No. 8981 in the sill and head. Add staples to secure the interlock dust plugs. For the location, see detail "A" hereunder.
- STEP 5:** Install the aluminum rolling rail No. 9790 in the operating support panel No. 8021, using a rubber mallet.



2.2 Assembly Procedure

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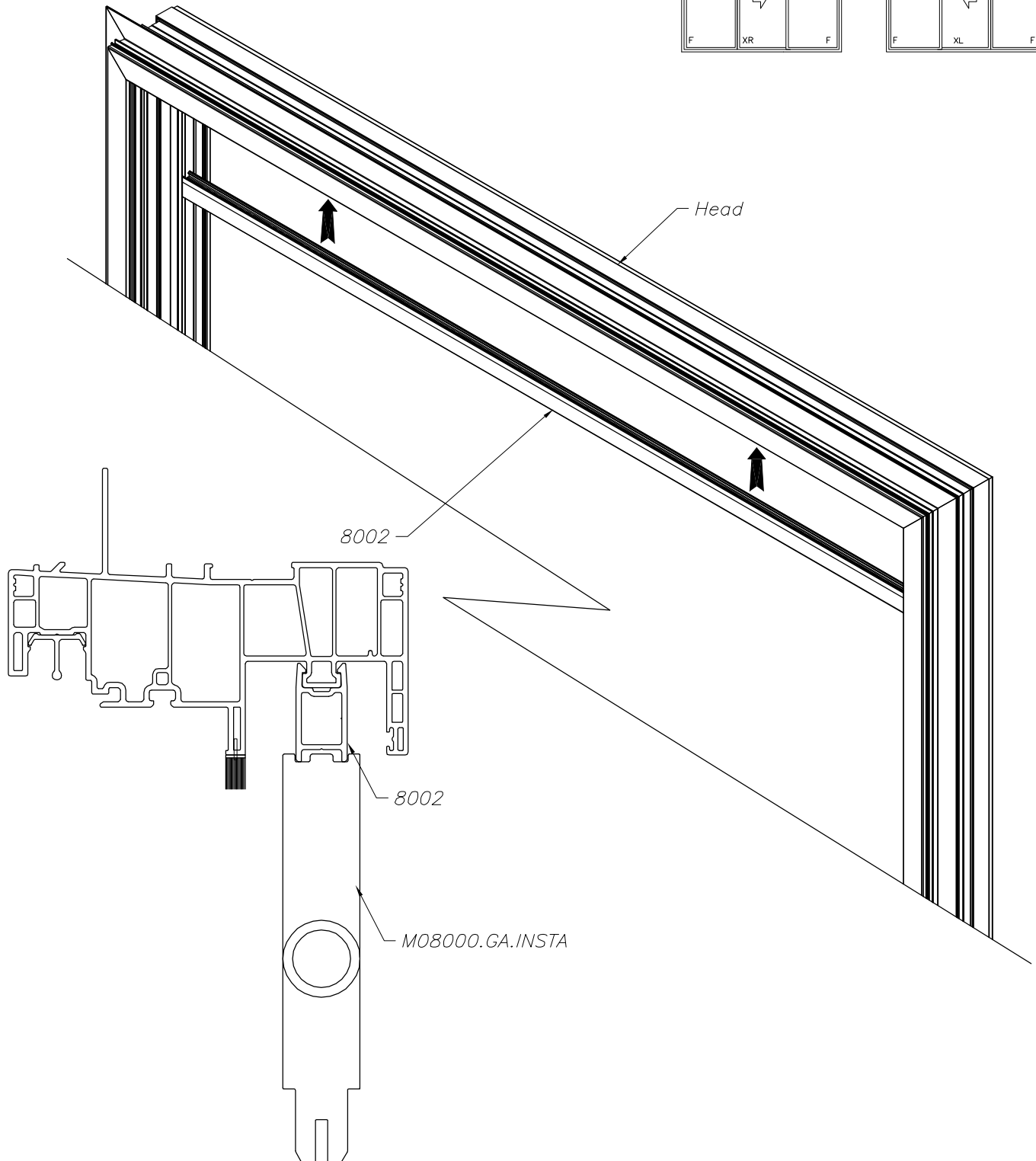
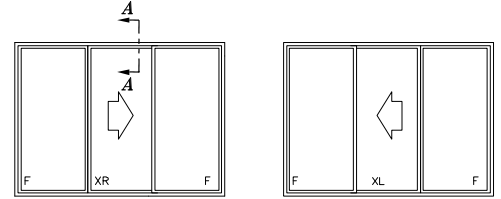
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2.2.4 Head Track Installation

Assembly Sequence

- Insert No. 8002 head track in the head, using a jig M08000.GA.INSTA and a rubber mallet

Three (3) Panel Patio Door



2.2 Assembly Procedure

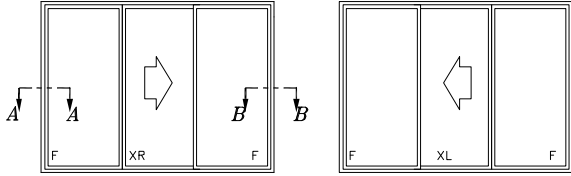
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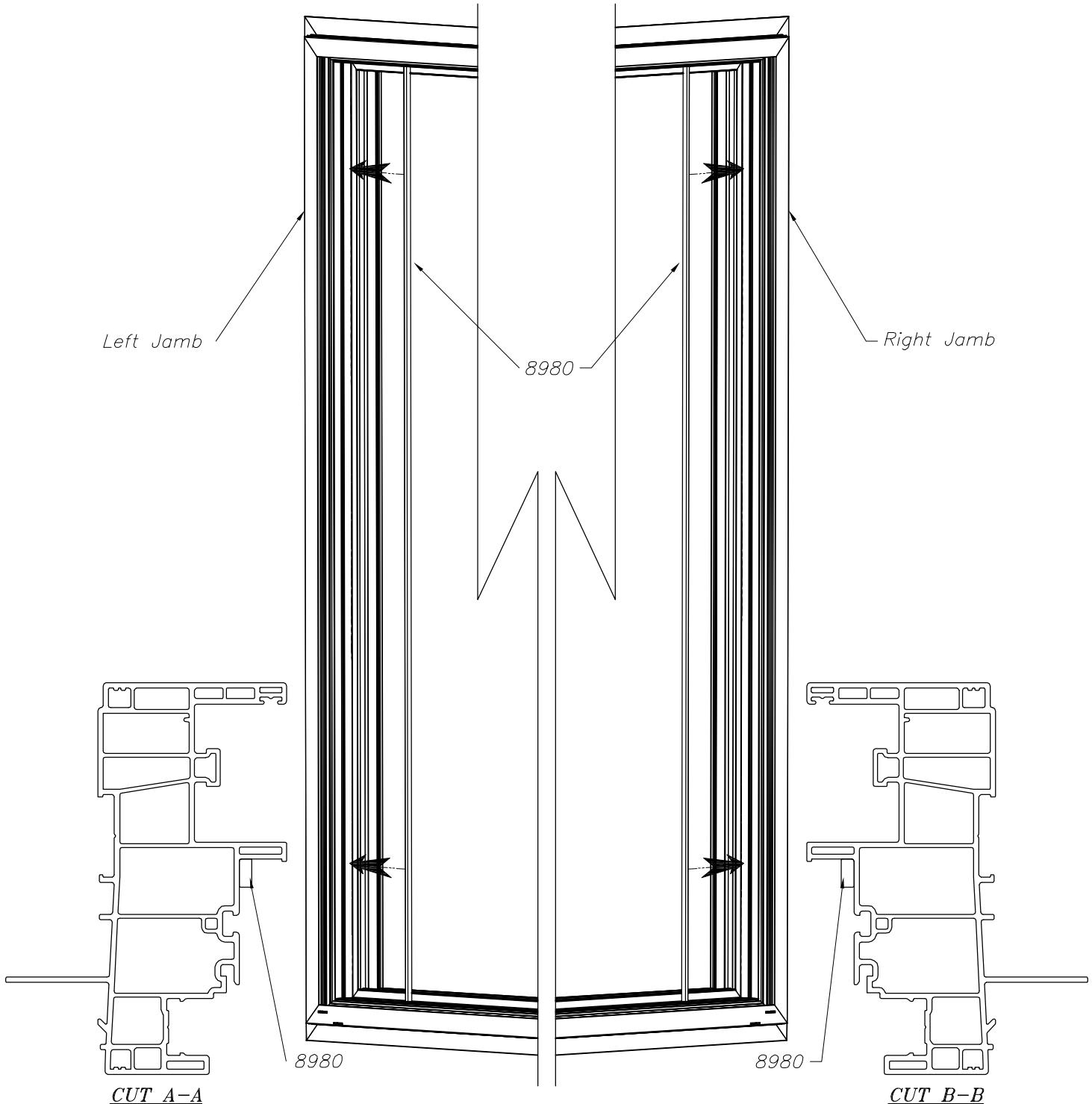
2.2.5 Foam Tape Installation

Three (3) 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

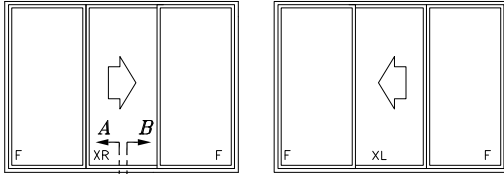
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2.2.6 Bottom Fixed Support Panel Installation

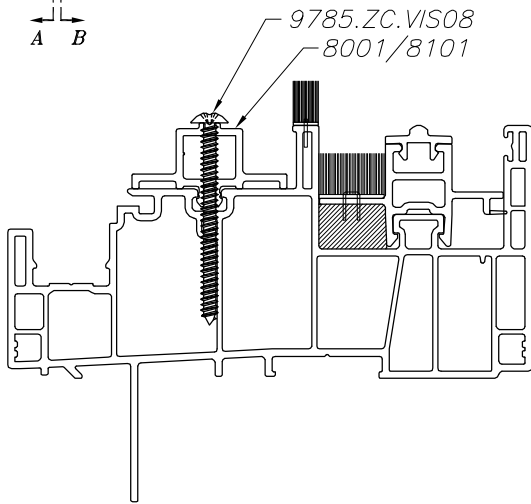
Three (3) Panel Patio Door

Assembly Sequence

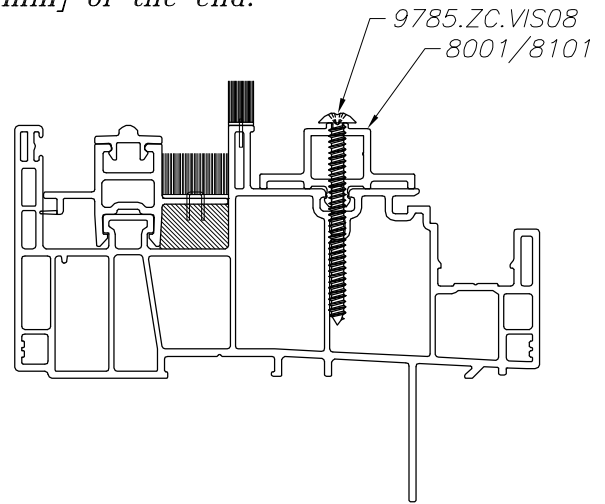


STEP 1: On the fixed panel sides, install 2 (two) No. 8001/8101 bottom fixed panel support, using a rubber mallet.

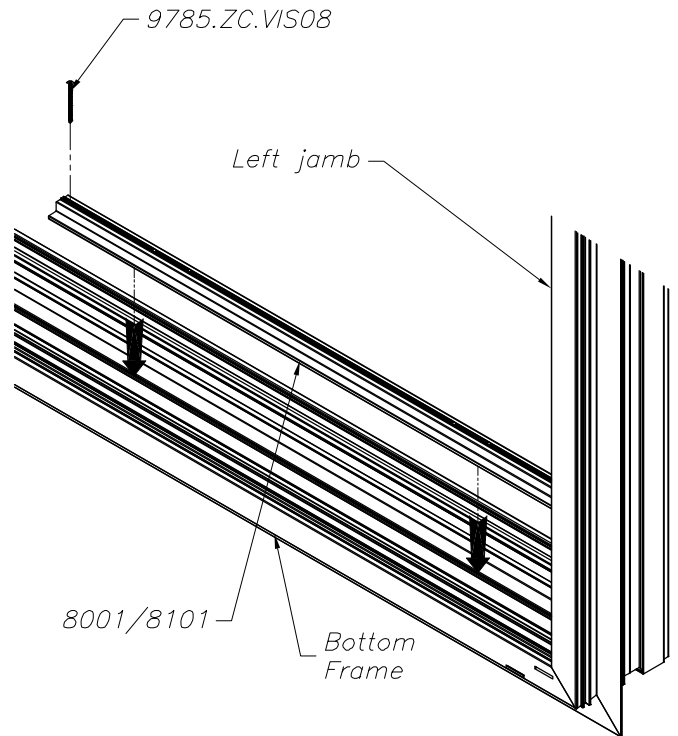
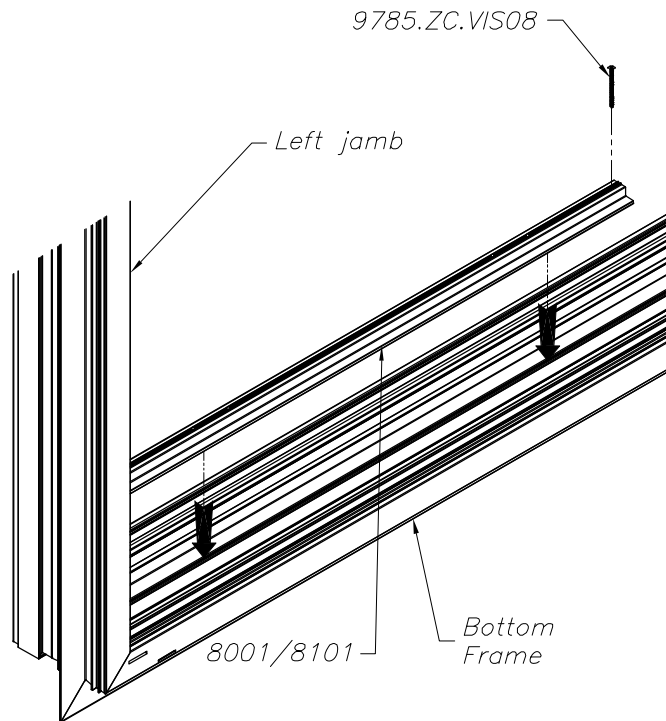
STEP 2: Add 1 (one) screw No. 9785.ZC.VIS08 to fasten each bottom fixed support panel No. 8001 to 3/4" [19mm] of the end.



CUT A-A



CUT B-B



2.2 Assembly Procedure

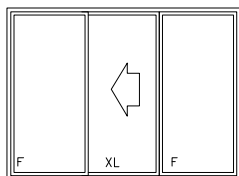
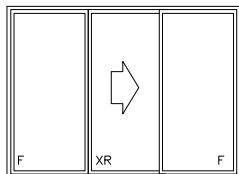
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2.2.7 Fixed Panel Installation

Three (3) Panel Patio Door

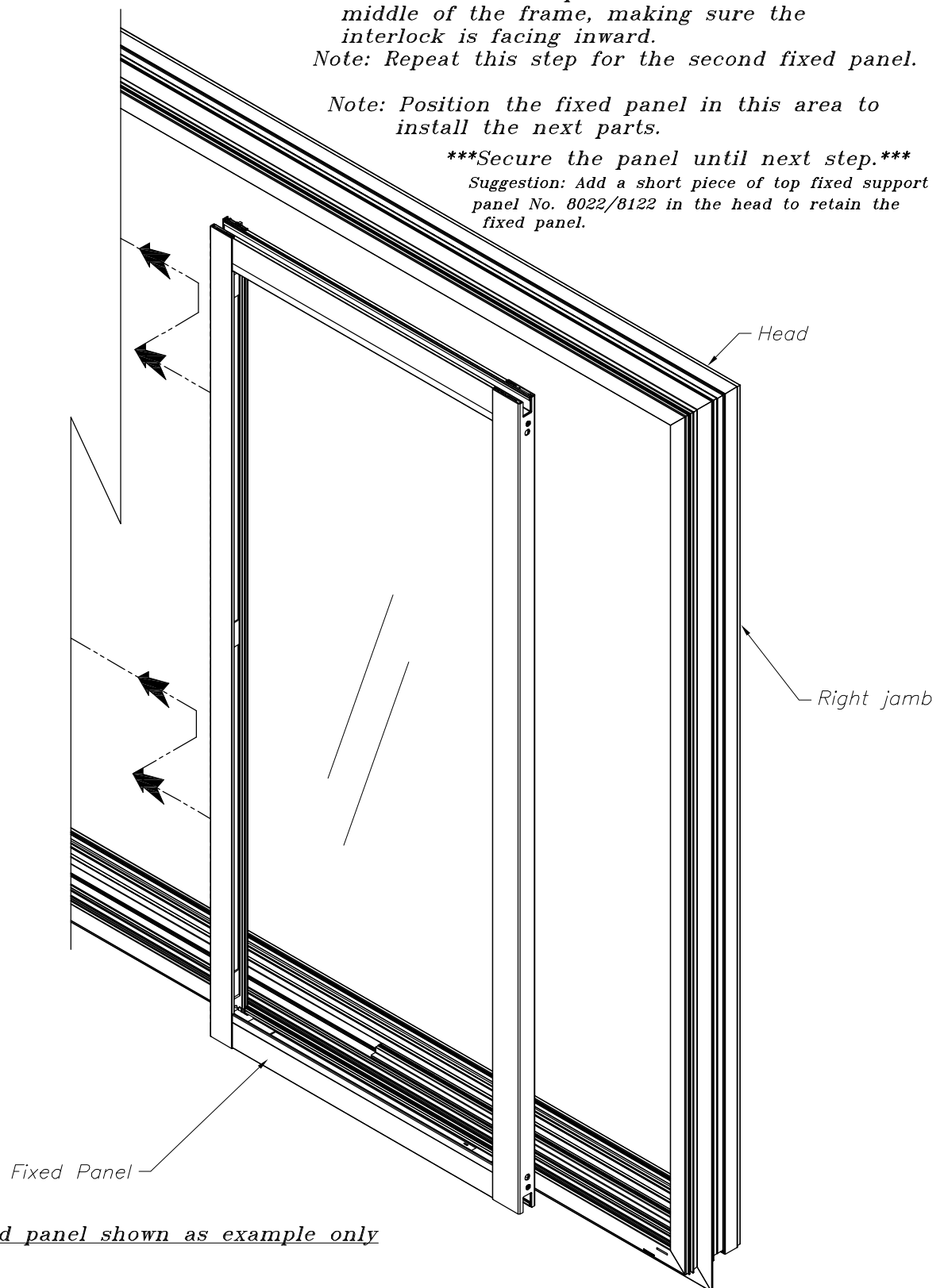
Assembly Sequence



- 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

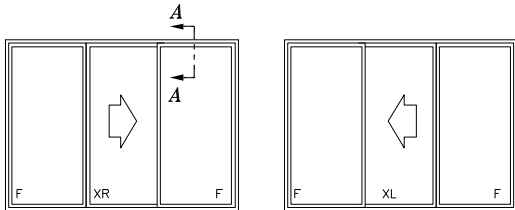
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2.2.8 Top Fixed Support Panel Installation

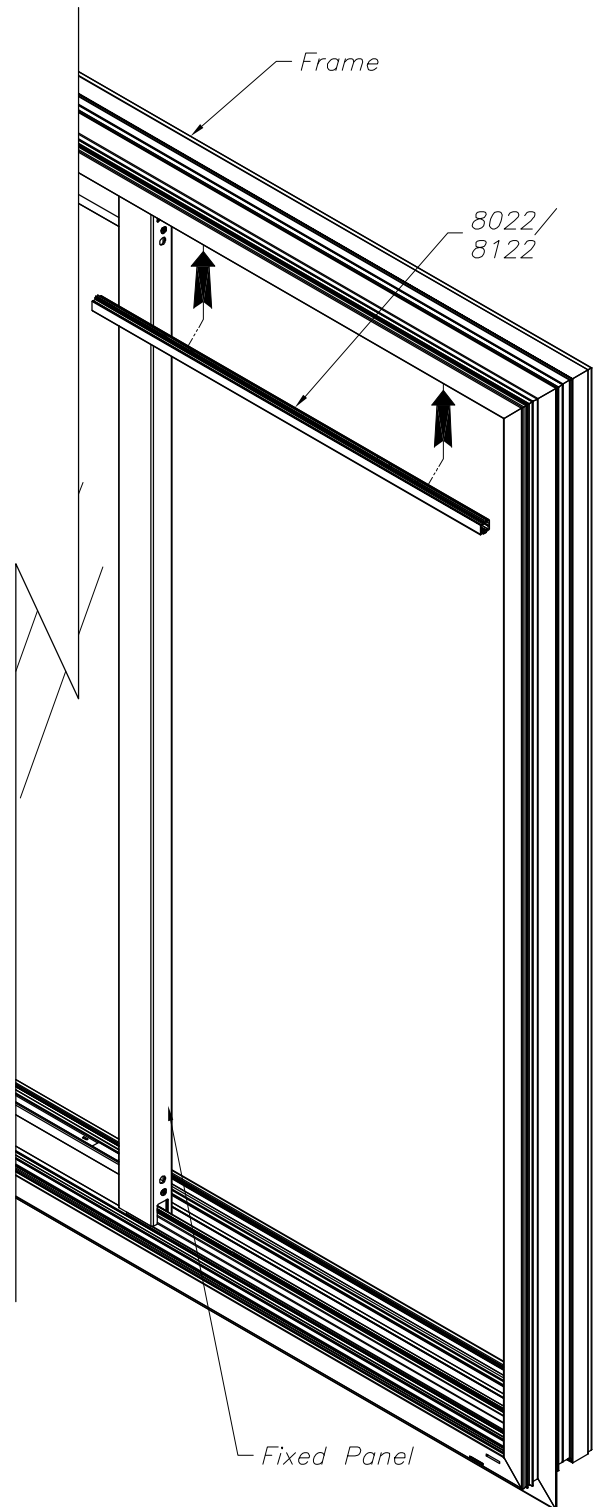
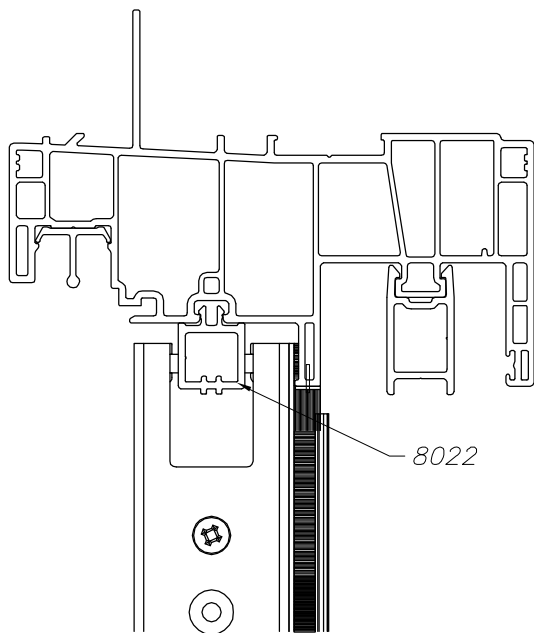
Three (3) Panel Patio Door



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

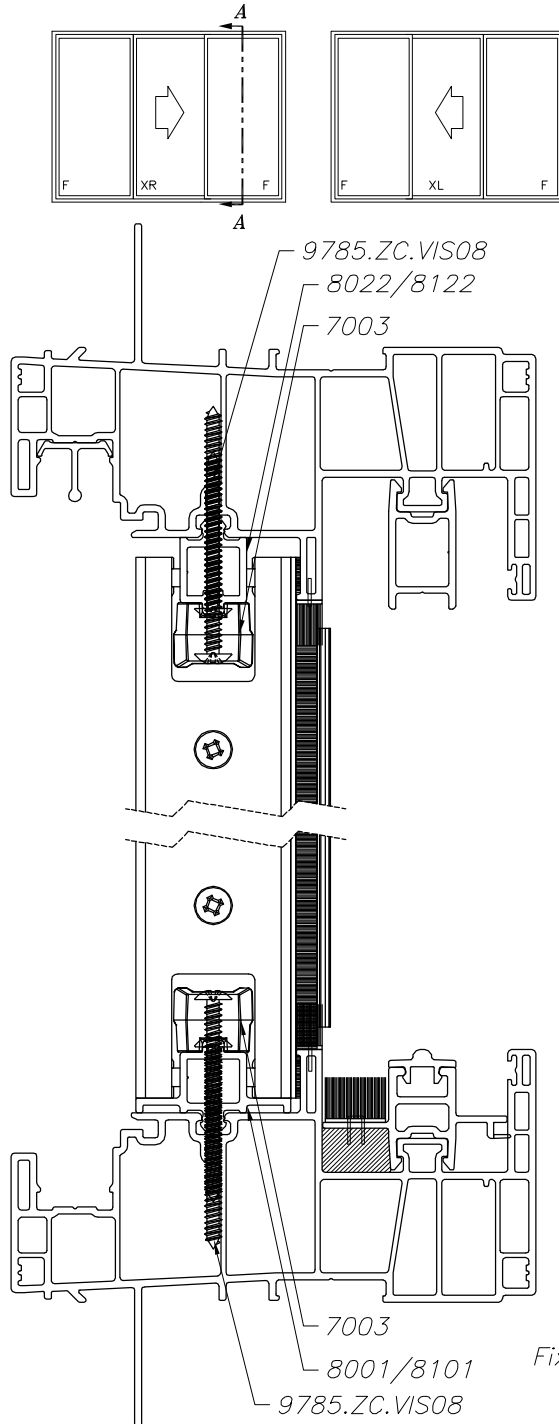
2.2 Assembly Procedure

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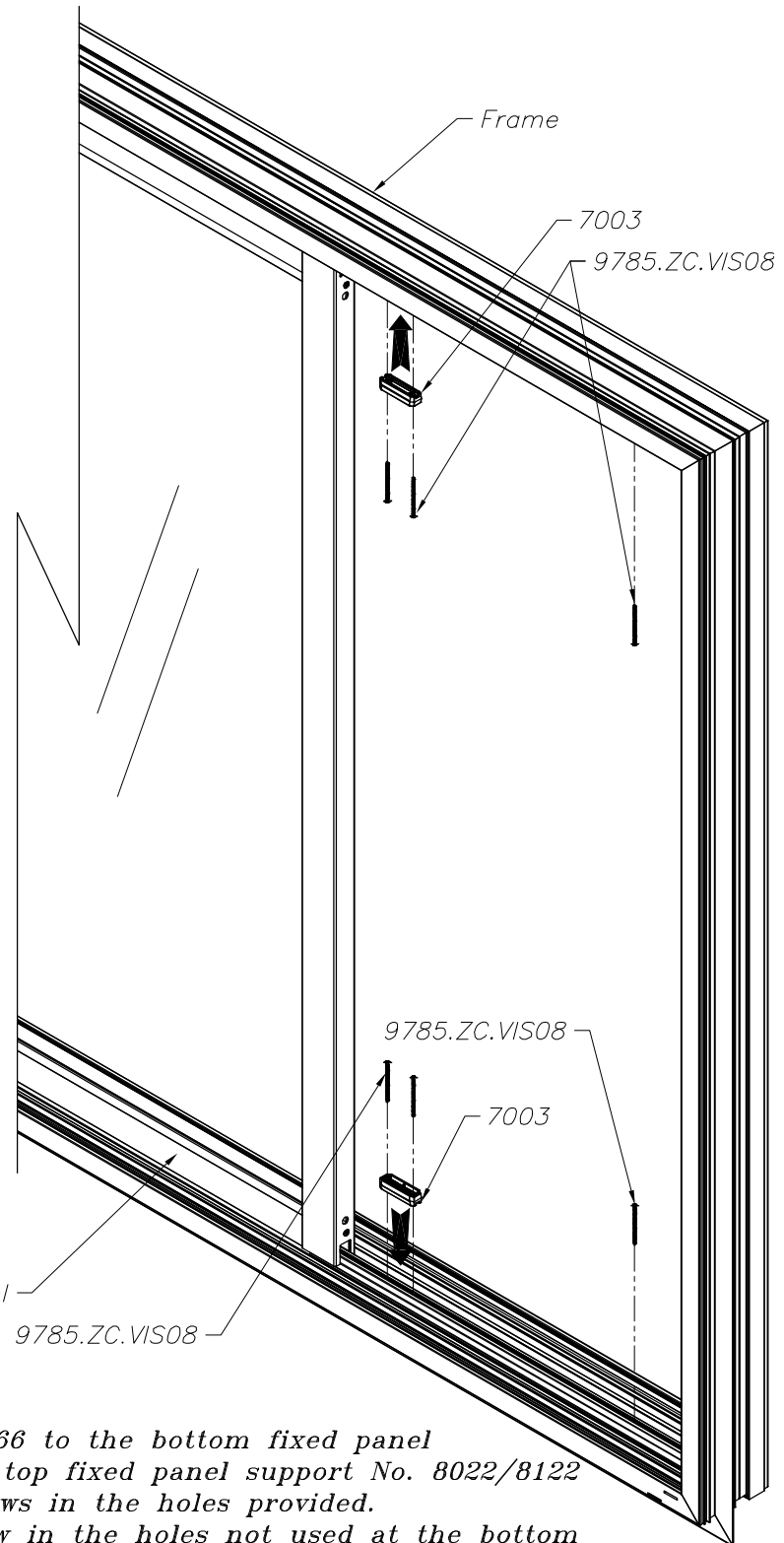
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2.2.9 Molded Fixed Panel Anchor Block Installation

Three (3) 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.

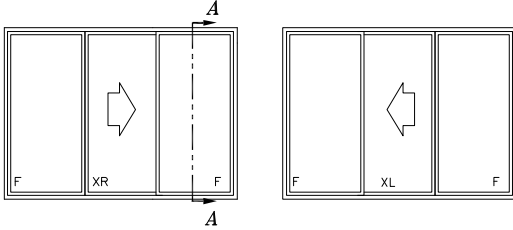
2.2 Assembly Procedure

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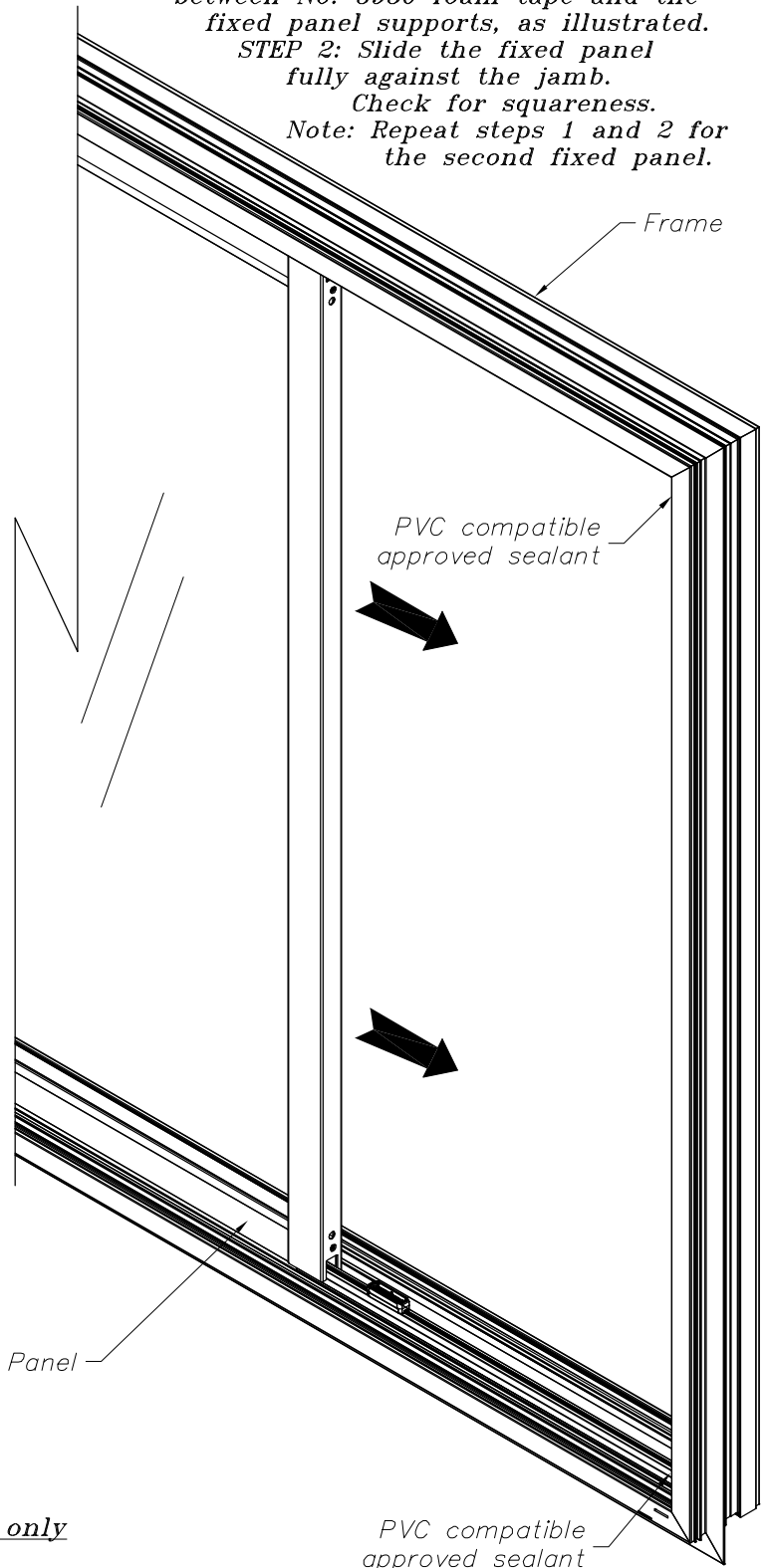
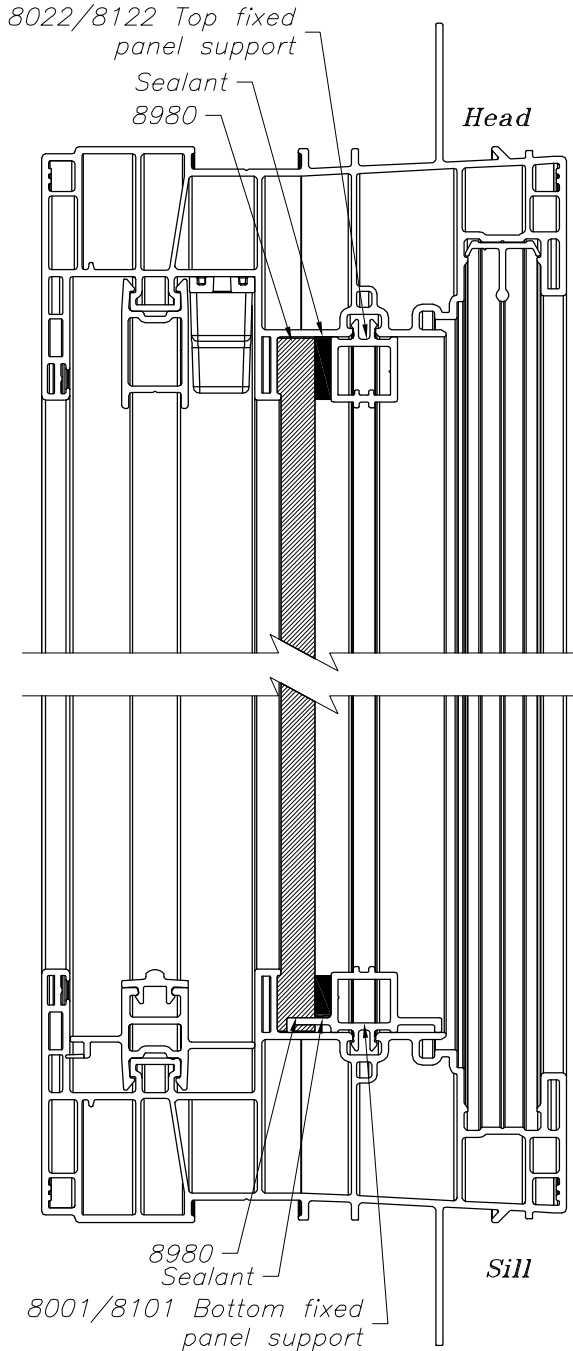
2.2.10 Sealing Jamb, Fixed Side

Three (3) 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

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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 Assembly Procedure

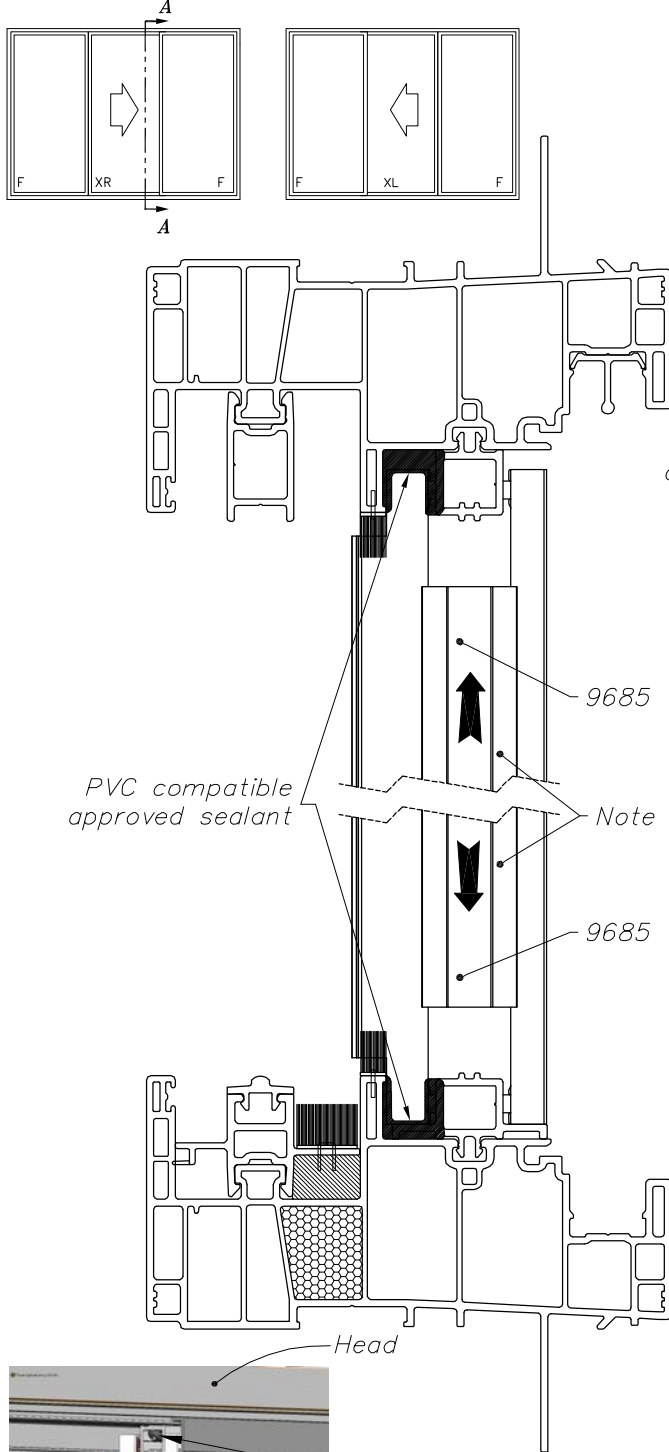
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2.2.12 Sealing Fixed Panel

Three (3) 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.

PVC compatible approved sealant

PVC compatible approved sealant

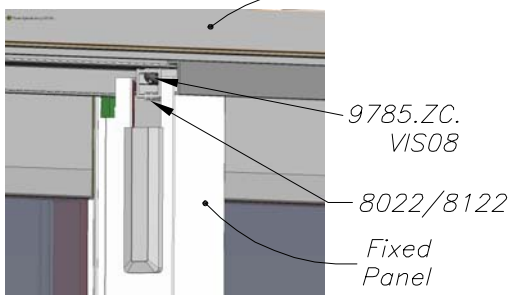
9685

Note

9685

PVC compatible approved sealant

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

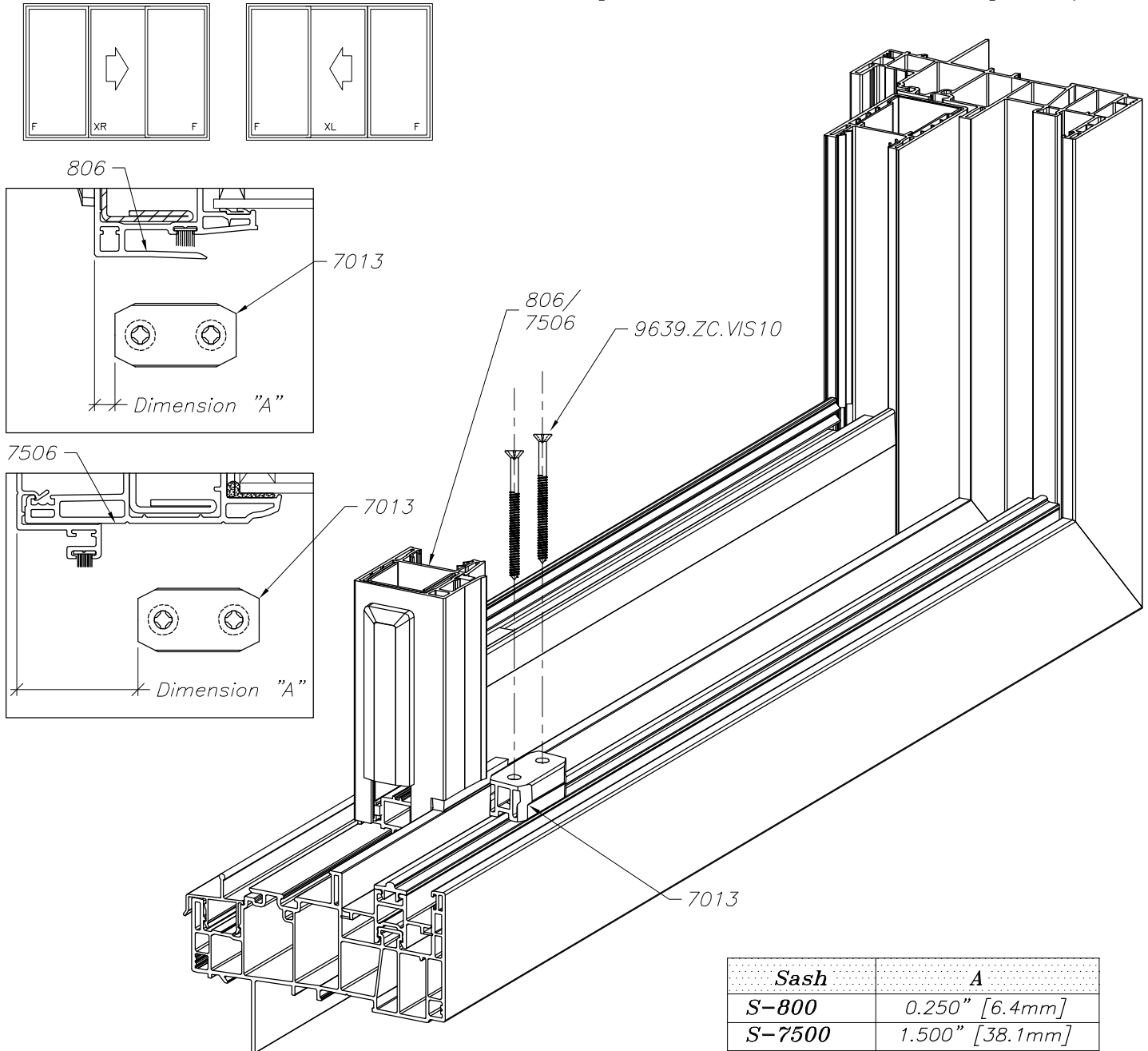
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2.2.13 Mullion Anchor Block Installation

Three (3) Panel Patio Door

Important : Panels shown as example only



Assembly Sequence

- STEP 1: On the head track, locate No. 7013 mullion anchor block from the top of the left meeting stile (fixed panel) as shown (FXLF), or right meeting stile (fixed panel) (FXRF) (Use Dimension A).
- STEP 2: On the sill, locate and drill two (2) 0.140" [3.6mm] diameter pilot holes through No. 9790 operating panel rail (Use Dimension A).
- STEP 3: Fix No. 7013 mullion anchor blocks to the head and sill, using two (2) screws No. 9639.ZC.VIS10

2.2 Assembly Procedure

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2.2.14 Mullion Fabrication and Assembly

Note:

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

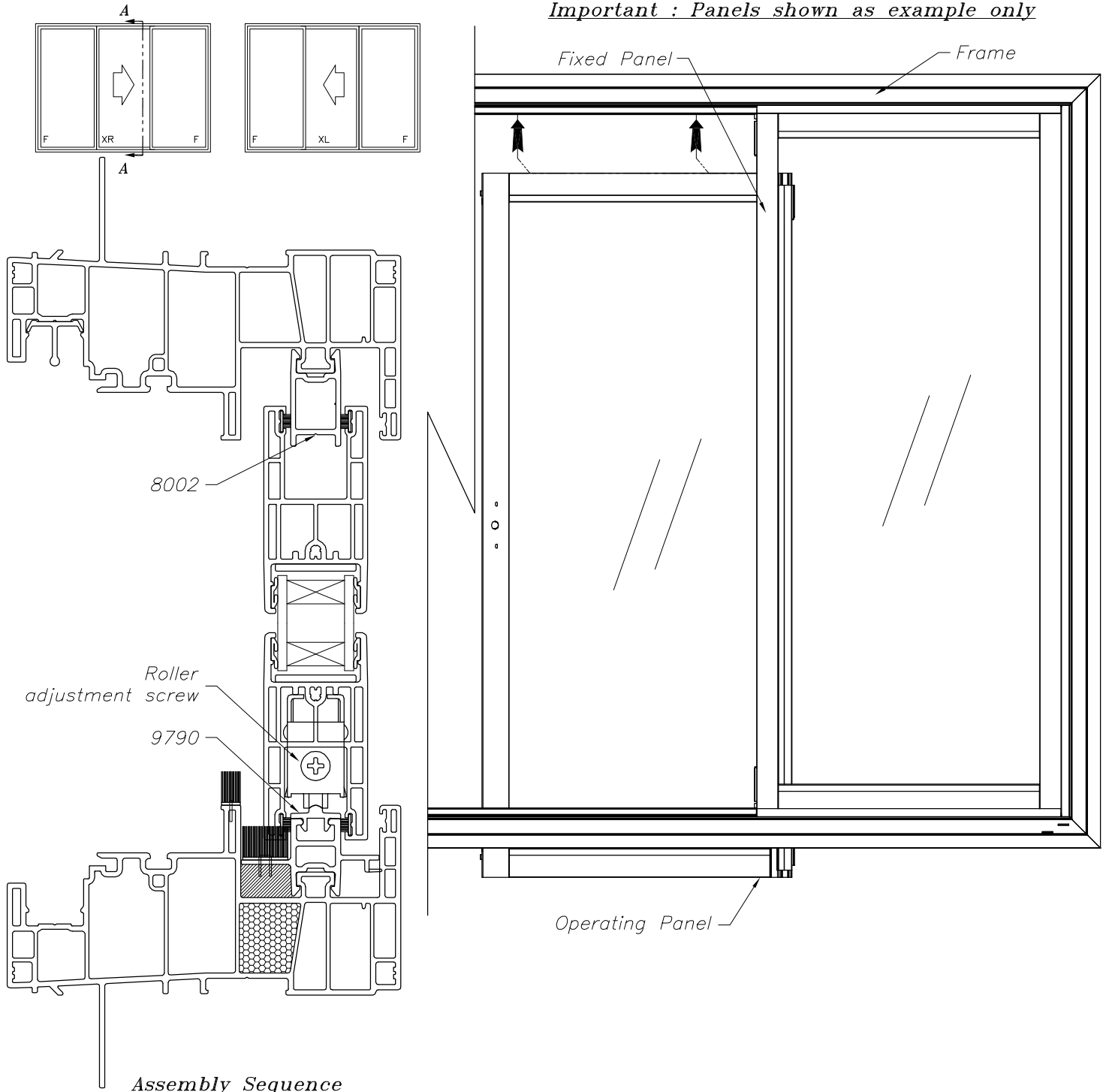
2.2 Assembly Procedure

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2.2.15 Operating Panel Installation

Three (3) 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).

2.2 Assembly Procedure

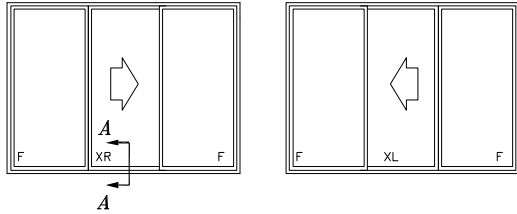
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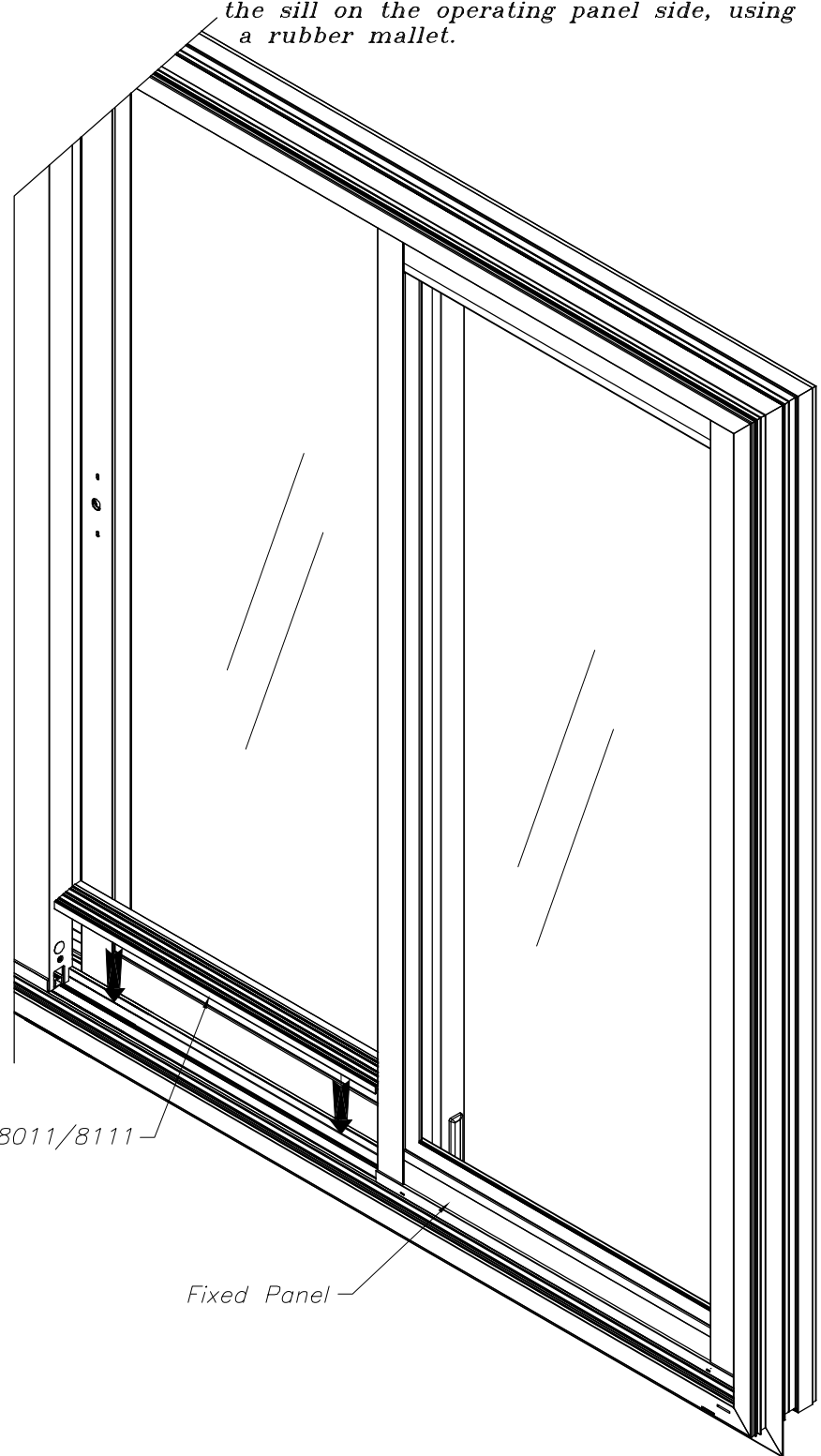
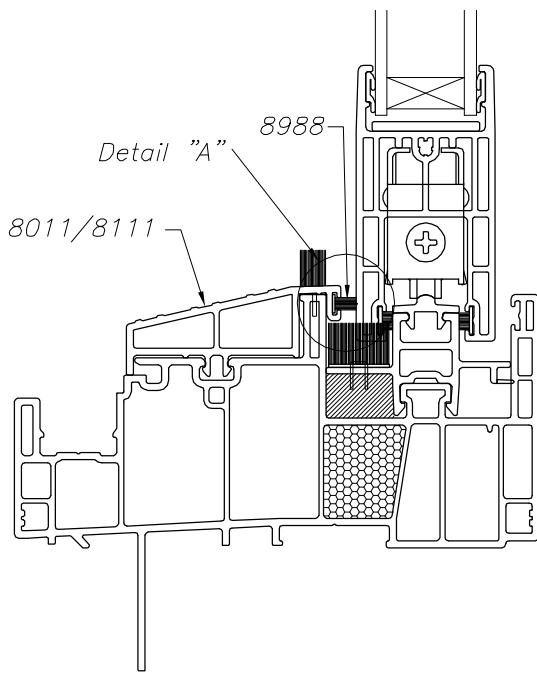
2.2.16 Sill Protector Installation

Three (3) Panel Patio Door

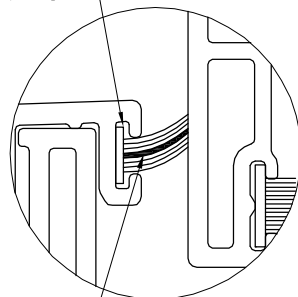
Assembly Sequence



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



Add either PVC cement or silicone to hold the pile weatherstripping.



Install the fin of pile weatherstripping No. 8988 to the top.

Important : Fixed panel shown as example only

2.2 Assembly Procedure

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2.2.17 Aluminum Outside Sill Cladding Installation

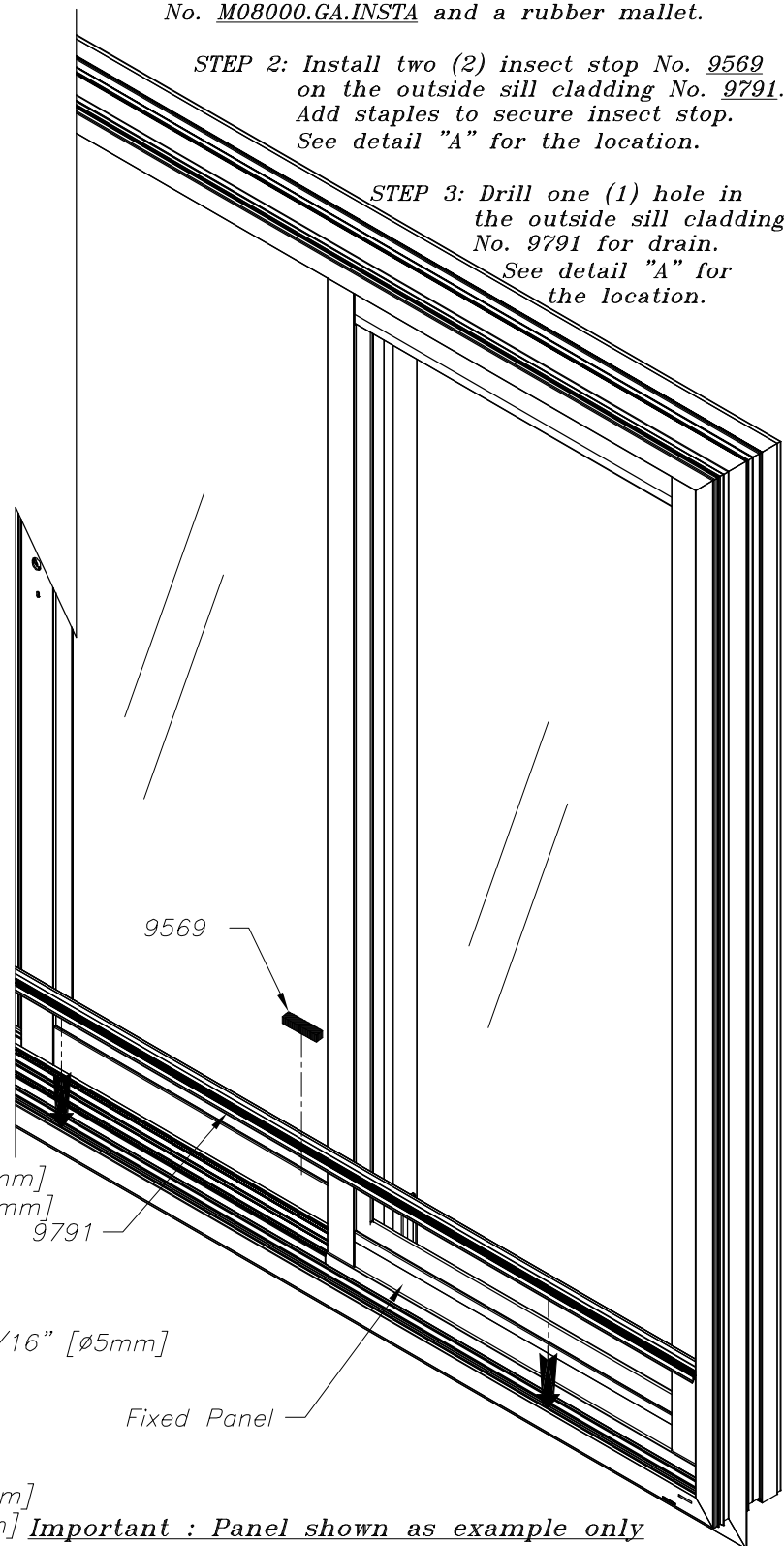
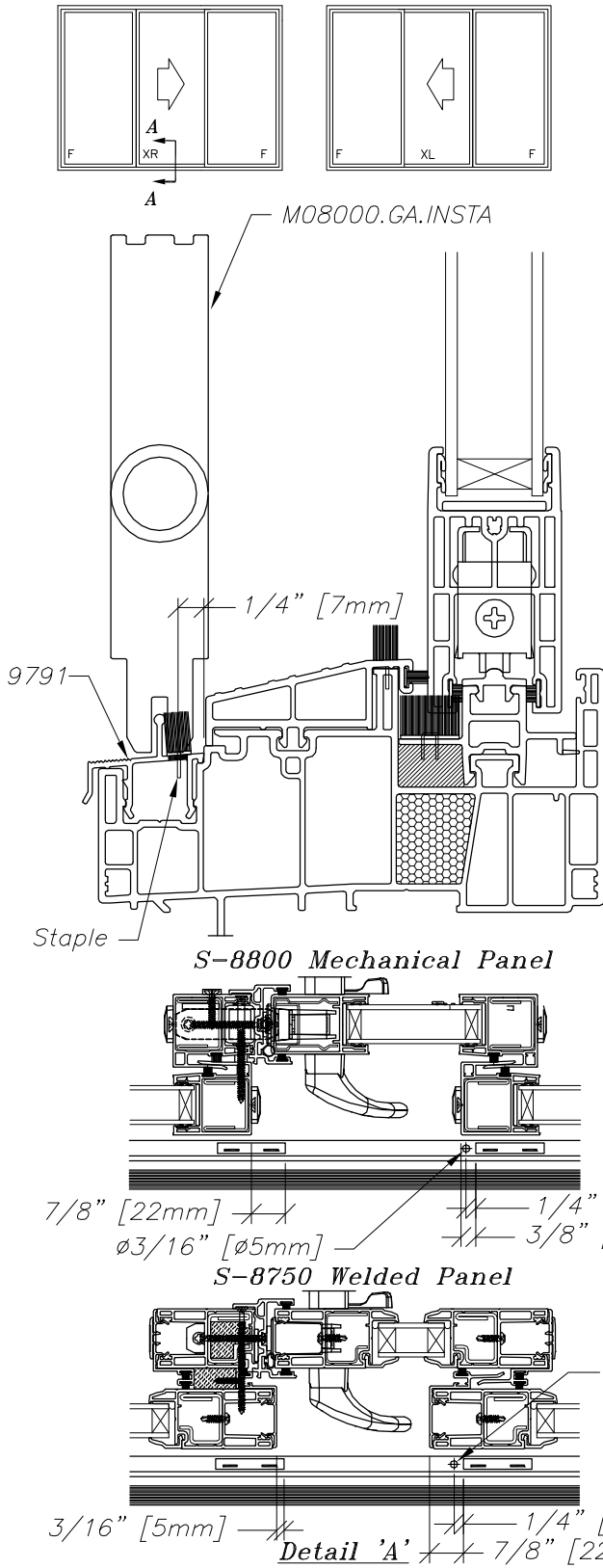
Three (3) Panel Patio Door

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 two (2) 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 one (1) hole in the outside sill cladding No. 9791 for drain. See detail "A" for the location.



Detail 'A' *Important : Panel shown as example only*

2.2 Assembly Procedure

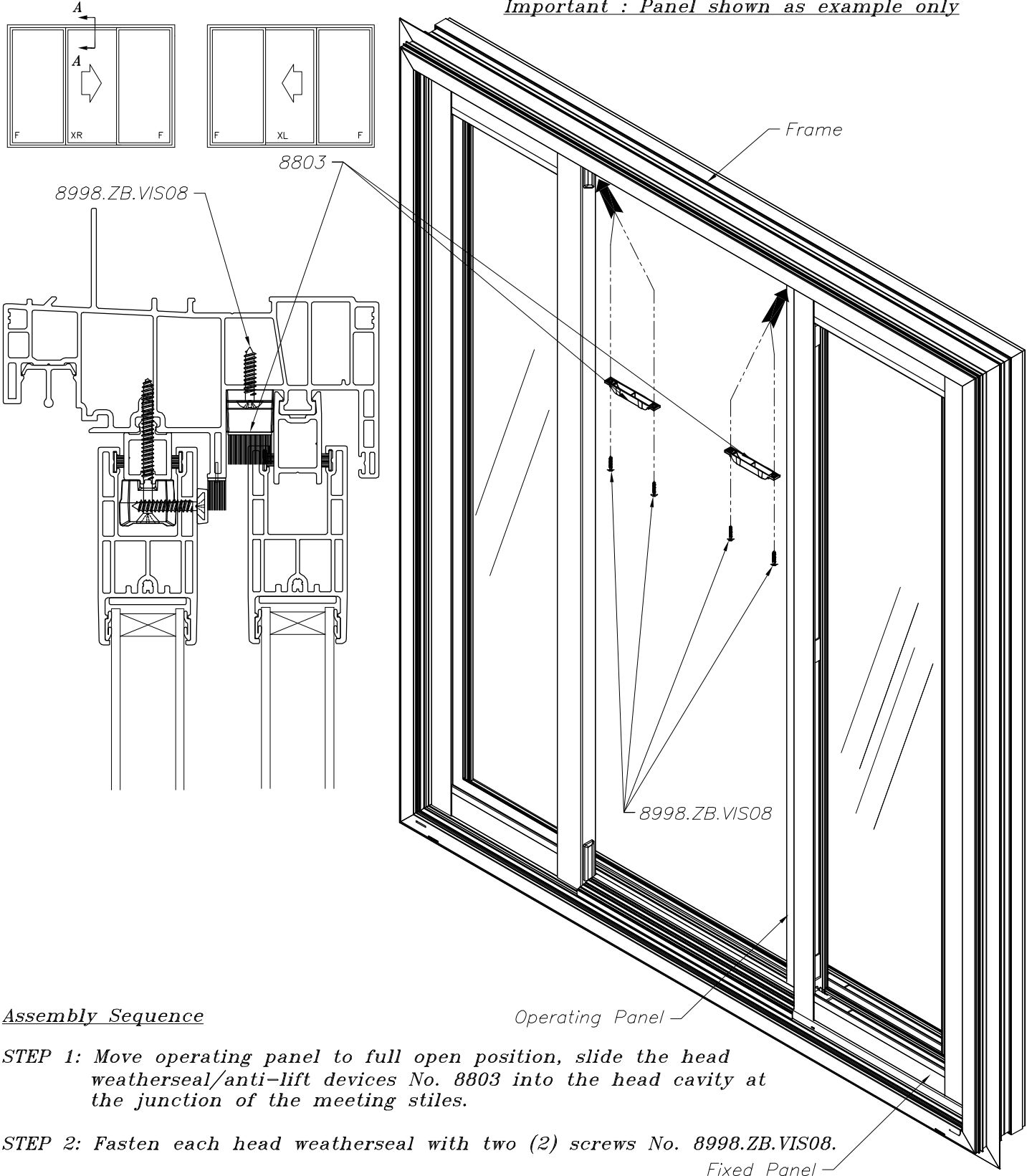
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2.2.18 Head Weatherseal Installation

Three (3) Panel Patio Door

Important : Panel shown as example only



Assembly Sequence

STEP 1: Move operating panel to full open position, slide the head weatherseal/anti-lift devices No. 8803 into the head cavity at the junction of the meeting stiles.

STEP 2: Fasten each head weatherseal with two (2) screws No. 8998.ZB.VIS08.

2.2 Assembly Procedure

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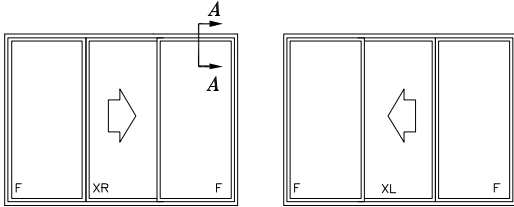
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2.2.19 Sash Stopper Installation

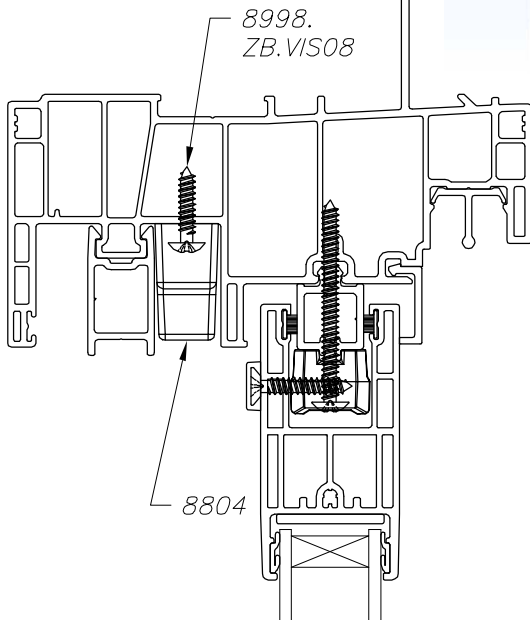
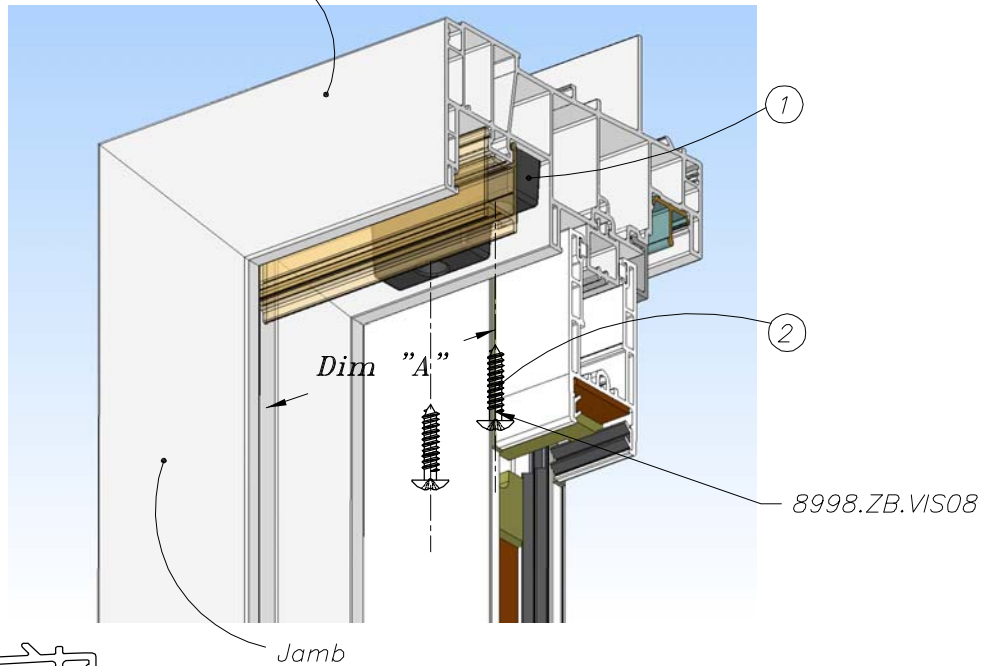
Three (3) Panel Patio Door

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.



Head



Mortise lock	Dim "A"
With exterior straight pull 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]

Assembly Sequence

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



2.3 Bill of Material

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2.3.1 Required Material for Three (3) Panel Door

<i>Description</i>	<i>Qty</i>	<i>Contents</i>
<i>Sill</i>	<i>1</i>	8000 <i>Sill profile</i> 7003 <i>Molded fixed panel anchor block</i> 7013 <i>Mulion anchor block</i> 8001/8101 <i>Bottom fixed support panel</i> 8011/8111 <i>Sill protector</i> 8021 <i>Operating panel support</i> 8981 <i>Interlock dust plug (Ultrafab No. TF4427AHG)</i> 8982 <i>Sill dust plug (Ultrafab No. TF4465AHG)</i> 8985 <i>Sill foam block for 8021</i> 8987 <i>Insect stop foam for 8000</i> 9639.ZC. <i>No. 10 x 2 1/2", flat head, quadrex, screw</i> VIS10 9785.ZC. <i>No. 8-15 x 2", truss head, quadrex, wood screw</i> VIS08 9790 <i>Aluminum rolling rail</i> 9791 <i>Outside sill cladding</i> 9569 <i>Insect stop</i>
<i>Head</i>	<i>1</i>	8000 <i>Head profile</i> 7003 <i>Molded fixed panel anchor block</i> 7013 <i>Mulion anchor block</i> 8002 <i>Head track</i> 8012 <i>Head screen track</i> 8022/8122 <i>Top fixed support panel</i> 8803 <i>Head weatherseal</i> 8804 <i>Sash stopper</i> 8998.ZB. <i>No. 8 x 3/4", truss head, quadrex screw.</i> VIS08 8981 <i>Interlock dust plug (Ultrafab No. TF4427AHG)</i> 9639.ZC. <i>No. 10 x 2 1/2", flat head, quadrex, screw</i> VIS10 9785.ZC. <i>No. 8-15 x 2", truss head, quadrex, wood screw</i> VIS08
<i>Jamb fixed side</i>	<i>2</i>	8000 <i>Jamb profile</i> 8980 <i>Foam tape</i>

2.4 Standard Dimensions

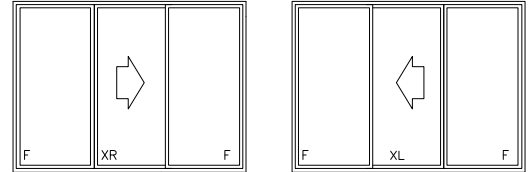
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2.4.1 Standard Widths for Three (3) Panel Door



Three (3) Panel Patio Door

Horizontal parts (S-8750)

Description	Part	Qty	2725		Formula
1 Actual width			107.324" 2726.0 mm		
2 Frame (cut to 45°)	8000/8010	2	107.324" 2726.0 mm		Actual width Actual width
3 Operating support panel	8021	1	104.064" 2643.2 mm		Actual width - 3.260" Actual width - 82.8 mm
4 Head track	8002	1	104.064" 2643.2 mm		Actual width - 3.260" Actual width - 82.8 mm
5 Screen track	8012	1	105.384" 2676.7 mm		Actual width - 1.940" Actual width - 49.3 mm
6 Bottom fixed support panel	8101	1	35.488" 901.4 mm		(Actual width / 3) - 0.287" (Actual width / 3) - 7.3 mm
7 Top fixed support panel	8122	1	35.488" 901.4 mm		(Actual width / 3) - 0.287" (Actual width / 3) - 7.3 mm
8 Sill protector	8111	1	32.224" 818.5 mm		(Actual width / 3) - 3.551" (Actual width / 3) - 90.2 mm
9 Operating panel rail	9790	1	104.064" 2643.2 mm		Actual width - 3.260" Actual width - 82.8 mm
10 Outside sill cladding	9791	1	104.294" 2649.1 mm		Actual width - 3.030" Actual width - 76.9 mm

Horizontal parts (S-8800)

Description	Part	Qty	2725		Formula
1 Actual width			107.324" 2726.0 mm		
2 Frame (cut to 45°)	8000/8010	2	107.324" 2726.0 mm		Actual width Actual width
3 Operating support panel	8021	1	104.064" 2643.2 mm		Actual width - 3.260" Actual width - 82.8 mm
4 Head track	8002	1	104.064" 2643.2 mm		Actual width - 3.260" Actual width - 82.8 mm
5 Screen track	8012	1	105.384" 2676.7 mm		Actual width - 1.940" Actual width - 49.3 mm
6 Bottom fixed support panel	8001	1	34.931" 887.2 mm		(Actual width / 3) - 0.844" (Actual width / 3) - 21.4 mm
7 Top fixed support panel	8022	1	34.931" 887.2 mm		(Actual width / 3) - 0.844" (Actual width / 3) - 21.4 mm
8 Sill protector	8011	1	33.036" 839.1 mm		(Actual width / 3) - 2.739" (Actual width / 3) - 69.6 mm
9 Operating panel rail	9790	1	104.064" 2643.2 mm		Actual width - 3.260" Actual width - 82.8 mm
10 Outside sill cladding	9791	1	104.294" 2649.1 mm		Actual width - 3.030" Actual width - 76.9 mm

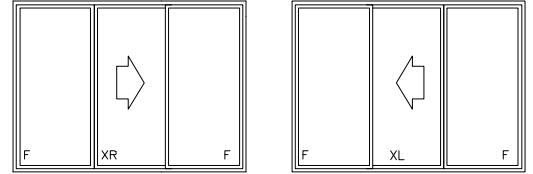
2.4 Standard Dimensions

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2.4.2 Standard Heights for Three (3) Panel Door



Three (3) 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	Actual height			79.278" 2013.7 mm	81.652" 2074.0 mm	94.267" 2394.4 mm	
51	Frame (cut to 45°)	8000/8010	2	79.278" 2013.7 mm	81.652" 2074.0 mm	94.267" 2394.4 mm	Actual height Actual height
52	Vertical groove cover	5771	2	75.829" 1926.1 mm	78.203" 1986.4 mm	90.818" 2306.8 mm	Actual height - 3.449" Actual height - 87.6 mm