

## Series 623 Sliding Glass Door 4-Panel, OXXO Assembly Instructions

(Reference Eastern Architectural Systems drawing A-0004 sheets 1 - 3)

### **1.0 Frame Assembly**

- 1.1 Apply stick on sill gasket to each cut end of the sill
- 1.2 Apply a bead of silicone to each cut end of the header
- 1.3 Assemble frame with #8 x 2 1/2" PPH Screw (3 per corner)
- 1.4 Apply silicone around butt joint of head and sill to jambs
- 1.5 Before frame is installed into the opening **make sure opening sill is level side to side and front to back.**
- 1.6 Apply large amount of silicone, non-shrink grout or other water barrier to opening sill
- 1.7 Install frame into opening per industry standards and applicable Installation Instructions from Eastern Architectural Systems. See Florida Product Approval Number FL 15864 or call Eastern Architectural Systems to obtain applicable Installation Instructions.
- 1.8 Apply silicone on the sill at both contact areas of the panel riser
- 1.9 Snap in the panel riser with fabricated end away from the jamb
- 1.10 Secure the panel riser with #8 x 1 1/4" PFH screws (4 per riser)
- 1.11 Install the snubbers (30" each) into the jambs equally spaced (2 per fixed panel) (see drawing A-0004 sheet 1)
- 1.12 Secure snubbers with #8 x 1 1/4" PFH screws (6 per snubber)

### **2.0 Operable Panel Assembly**

- 2.1 Snap the interlock onto the operable panels.
- 2.2 Secure the interlock with #8 x 5/8" PPH screws (8 per interlock)
- 2.3 Clean the interlock in the notched area at the top and bottom with rubbing alcohol (see figure 1 below, top shown bottom similar).

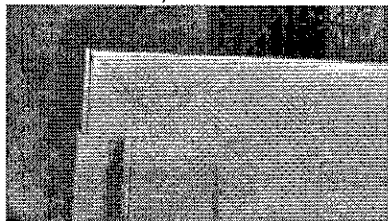


figure 1

- 2.4 Remove the white Fuzzy Weather Strip Pad from the hardware kit, two per panel. Peel the adhesive cover off of the back and place it on the notched interlock section (see figure 2 below, bottom shown top similar).

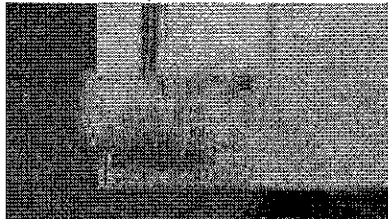


figure 2

- 2.5 Remove plastic grommets from hardware kit, two per active panel (see figure 3 below).

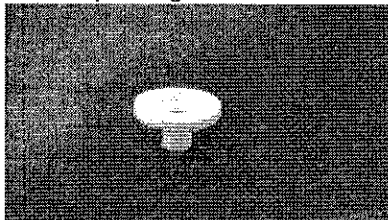


figure 3

- 2.6 Insert grommets into the top and bottom hole of the handle prep interior side of panel (see figure 4 below).

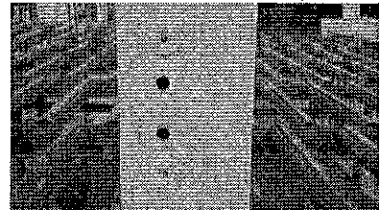


figure 4

- 2.7 Install the handle according to the manufacturers installation instructions packaged with handle.

### **3.0 Fixed Panel Installation**

- 3.1 Apply silicone on the panel riser at both contact points of the panel
- 3.2 Apply silicone on the snubbers at all contact points of the panel
- 3.3 Install panel into frame
- 3.4 Install the snubber between the frame head and panel top rail
- 3.5 Install L-Brackets at both top and bottom of the fixed panel interlock stile
- 3.6 Secure L-Bracket to panel with #8 x 1" PFH screws (2 per bracket)
- 3.7 Secure L-Bracket to the frame with #8 x 3/4" PFH screws (exterior row 2 each) and installation anchors per sill anchors from Eastern Architectural Systems Installation Instructions (interior row 2 each)
- 3.8 Snap the interlock onto the fixed panel
- 3.9 Secure the interlock to the fixed panel with #8 x 5/8" PPH screws (8 per interlock)
- 3.10 Install the threshold

### **4.0 Operable Panel Installation**

- 4.1 Install operable panel into frame
- 4.2 Adjust the rollers to appropriate height
- 4.3 Install plug over roller adjustment hole (1 per roller)
- 4.4 Install the Impact Bracket to the operable panel interlock stile, sliding the bracket into the frame leaving 1/8" gap
- 4.5 Secure the Impact Bracket to the operable panel with #8 x 2 1/2" PFH screws (3 per bracket)

### **5.0 Final Installation**

- 5.1 Install 4-Lite Astragal to dummy operable panel
- 5.2 Secure the Astragal with #8 x 2" PPH screws (7 per astragal)
- 5.3 Install the keeper with #8 x 3" PPH screws (4 per keeper)
- 5.4 Install the T-Bracket into the frame head operable track with the centerline of the bracket 14" from the head centerline (2 per operable panel)
- 5.5 Secure the T-Bracket with #8 x 2 1/2" PFH screws (8 per bracket)