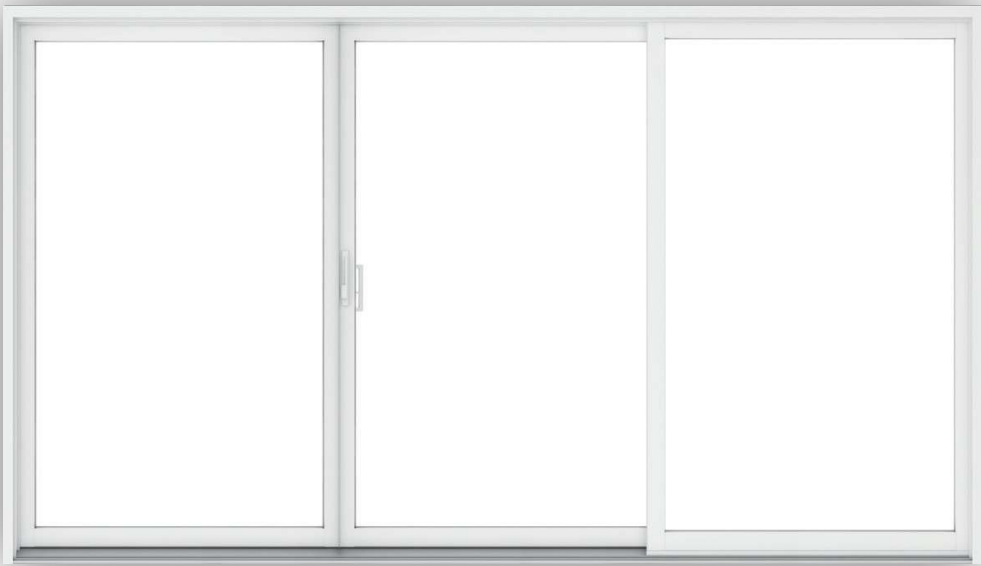


INSTRUCTIONS FOR

ASSEMBLING A 3-LITE

550 DOOR



Tools and Hardware	2
Frame Assembly	4
Fixed Panel Installation OXO	5
Astragal assembly OXO	6
Operating Panel Installation OXO	7
Handle and Screen Assembly OXO	8
Fixed Panel Installation X00-00X	9
Operating Panel Installation X00-00X	11
Handle and Screen Assembly X00-00X	12

TOOLS REQUIRED















- 1- Level
- 2- Measuring tape
- 3- Rubber mallet
- 4- Robertson screwdriver with head sizes # 1 and 2
- 5- Philips screwdriver with head sizes # 1 and 2
- 6- Flat head screwdriver
- 7- Utility knife
- 8- Square
- 9- Caulking gun

KIT CONTENTS

1. Kit consists of the four pieces of the frame, meeting rails, fixed panel support and set of hardware.
2. Kit consisting of the operating panel and the screen.
3. Kit for the fixed panel.

HARDWARE SET

550 KIT A











Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	166031	1		DUST PLUG INTERLOCK UP
②	166122	1		FOAM GASKET
③	166129	1		FOAM GASKET LEFT
④	166129	1		FOAM GASKET RIGHT
⑤	190033	1		SILL BLOCK
⑥	166205	1		HEAD DUSTPLUG
⑦	166313	1		SILL CAPPING
⑧	166131	1		HEAD CAPPING
⑨	162442	1		BOTTOM CAP (XO)
⑩	162441	1		BOTTOM CAP (OX)
⑪	162457	1		BUMPER
⑫	162471	1		WEEP HOLE COVER
⑬	161005	1		#6 x 1" FLAT QUAD SILL BLOCK
⑭	161041	1		#8 x 3/4" TRUSS QUAD WHITE FOR DUST PLUG AND SAFETY BAR
⑮				

BAG 6 X 10

DRAWING:
A

REVISION: 18/03/2021

550 KIT B





Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	162166	1		DOUBLE POINT KEEPER
②	162348	1		KEEPER (STEEL) (R-3xx/4xx AND R-5xx) (2 AND 3 LIGHT)
③	162444	1		HEAD FIXATION
④	162082	4		3/8" HOLE PLUG
⑤	161088	4		#10 x 1 1/4" PAN PHILIPS SS INCLUDE WITH DOUBLE POINT KEEPER
⑥	161084	2		#6 x 1/2" PAN HEAD QUAD SCREEN KEEPER
⑦	161049	1		#8-10 x 1" PAN QUADREX FOR HEAD FIXATION (FIXED SASH)
⑧	161020	1		#8-10 x 3" PAN WASHER FOR FRAME ASS. + FIXATION (FIXED SASH)
⑨	161133	1		#8-10 x 2 1/4" PAN WASHER FOR HEAD FIXATION
⑩	161144	1		#6 x 1" FLAT GREY HEAD FIXED SASH

BAG 6 X 10

DRAWING:
B

REVISION: 18/03/2021

550 KIT C


Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	162071	1		FOOT LOCK
②	162443	1		FOOT LOCK KEEPER
③	161039	4		#8 x 1/2" PAN QUADREX WHITE HEAD FOR FOOT LOCK (SASH)
④	161098	2		#8 x 1" PAN QUADREX WHITE HEAD FOR FOOT LOCK KEEPER

BAG 6 X 10

DRAWING:
C

REVISION: 24/03/2016

550 KIT D



Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①		1		LOOK HANDLE

BAG 6 X 10

DRAWING:
D

REVISION: 18/03/2021

550 KIT E

Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	161020	14		#8-10 x 3" PAN WASHER FOR FRAME ASS. + FIXATION (FIXED SASH)
②	161059	4		#8 x 2" FLAT QUADREX FIXED SASH SUPPORT









BAG 3 X 4

DRAWING:
E

REVISION: 30/01/2014

HARDWARE SET (CONT.)

550 KIT F

Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	161041	1		#8 x 3/4" TRUSS QUAD WHITE FOR DUST PLUG AND SAFETY BAR
②	161084	1		#6 x 1/2" PAN HEAD QUAD SCREEN KEEPER
③	161049	1		#8-10 x 1" PAN QUADREX FOR HEAD FIXATION (FIXED SASH)
④	162082	1		3/8" HOLE PLUG
⑤	161039	1		#8 x 1/2" PAN QUADREX WHITE HEAD FOR FOOT LOCK (SASH)
⑥	161098	1		#8 x 1" PAN QUADREX WHITE HEAD FOR FOOT LOCK KEEPER
⑦	161010	1		#10-12 (TÊTE NO:7) x 5/8" FLAT SS QUADREX UNDERCUT FOR ROLLER
⑧	161144	1		#6 x 1" FLAT GREY HEAD FIXED SASH



BAG 3 X 4

DRAWING:

F

REVISION: 16/03/2021

550 KIT G

Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	162082	10		3/8" HOLE PLUG
②	161020	10		#8-10 x 3" PAN WASHER FOR FRAME ASS. + FIXATION (FIXED SASH)






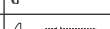





BAG 3 X 4

DRAWING:

G

REVISION: 30/01/2014

550 KIT H

Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	161107	4		#10 x 3" PAN SELF DRILL FOR OXO DOOR + BUMPER XOX
②	162472	1		HEAD FIXATION
③	161049	1		#8-10 x 1" PAN QUADREX FOR HEAD FIXATION (FIXED SASH)
④	161020	1		#8-10 x 3" PAN WASHER FOR FRAME ASS. + HEAD FIXATION (FIXED SASH)
⑤	161144	1		#6 x 1" FLAT GREY HEAD FIXED SASH
⑥	161096	7		#8 x 1 1/2" PAN SELF DRILL H CONNECTOR FOR OXOX
⑦	161133	1		#8-10 x 2 1/4" PAN WASHER FOR HEAD FIXATION
⑧	162471	1		WEEP HOLE COVER
⑨	130280	1		BUMBER
⑩	161047	1		#8 x 2 1/2" PAN QUADREX ZINC FOR BUMPER
⑪	162082	2		3/8" HOLE PLUG

BAG 6 X 10

DRAWING:

H

REVISION: 24/03/2016

STEP 1 FRAME ASSEMBLY

NOTE: The frame must be assembled on a flat, clean surface close to the opening made in the wall.

1 Find the **PRE-DRILLED** frame pieces:

- 1) Head Casing**
 - 2) Sill**
 - 3) Vertical Side Casing**
 - 4) Vertical Side Casing**
- See **Figure 1**.

2 Seal the edges of the sill at the wood and PVC junction. Apply a bead of sealant approx. 1/4" in diameter on the sill mortises. See **Figure 2**.

3 Use the #8 - 3" washer head screws to attach the side casings to the head and sill (4 screws at the head and 3 at the sill). Use the pre-drilled holes for this, in the proper sequence. Always screw in the vertical side casings first. See **Figure 3**.

4 Fix the panel supports, drain hole cover with flap towards the interior, using 4 x #8 - 2" screws. Add a bead of sealant along the edge of the support where it meets the frame. See **Figure 4**. Make sure to place the screw for the fixed-panel support at the center of the door. See **Figure 4A**. Install the gasket on the end of the panel support. 3 1/2" from the edge **Figure 5-A**. Install the block sill for the operating panel. Fix the block sill with the #6 - 1". See **Figure 5-B**.

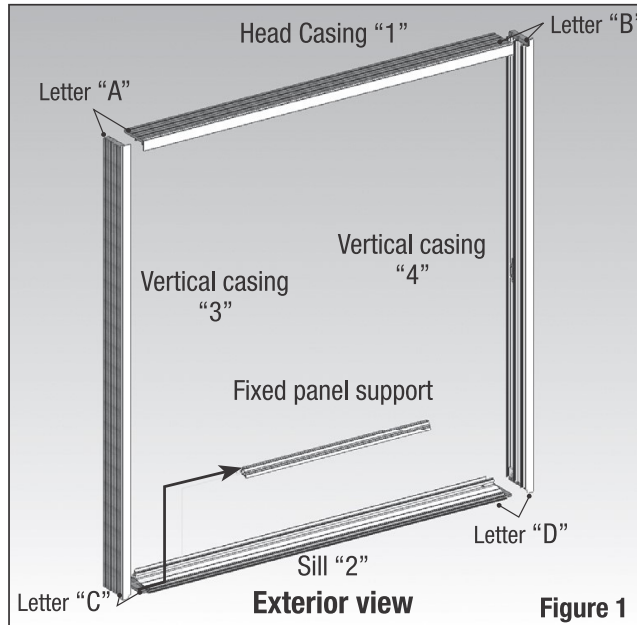


Figure 1

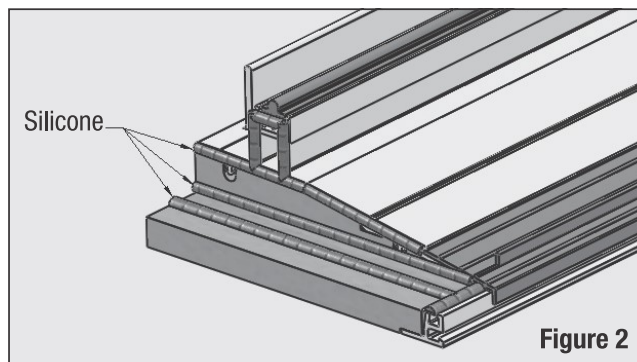


Figure 2

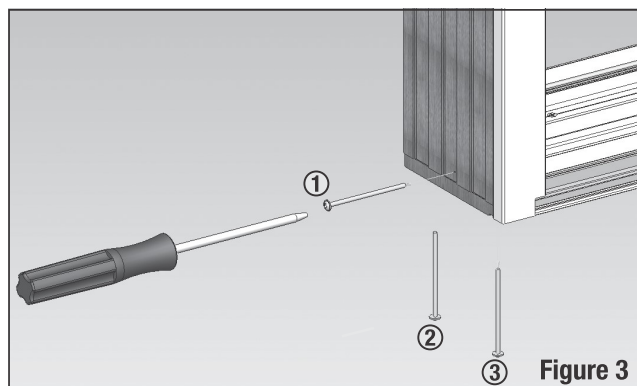


Figure 3

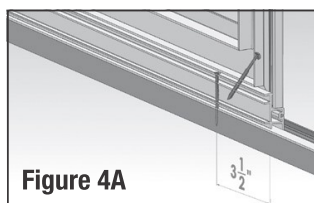


Figure 4A

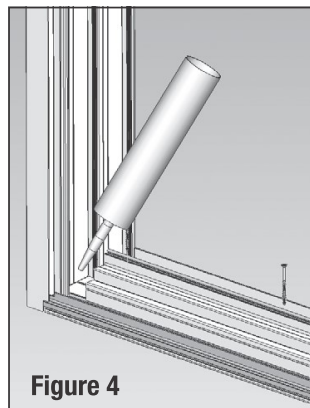


Figure 4

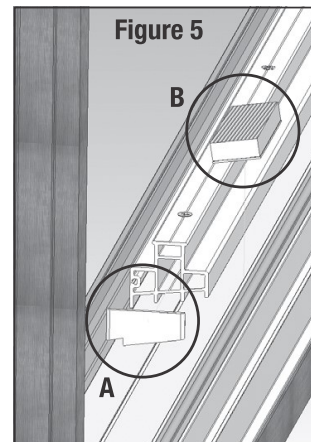


Figure 5

NOTE TO ASSEMBLE THE FRAME:

See Step 1 on Page 3.

- 1 Insert the fixed panels in the frame, making sure that the inside surfaces face the interior. Next, insert the tops and then the bottoms. The identification labels for the fixed panels must be on the inside of the frame. See **Figure 1**.

Fix the bottoms of the panels using #8-3" screws. See **Figure 2**.

Fix the panel in place using a #6 - 1" screw. See **Figure 2A**. Line the screw up with the height of the glazing stop at the bottom of the panel and in the frame's weatherstrip groove.

Insert the head fixing block (with no finishing strip) above the fixed panel where the astragal will be fixed. Fix it to the panel, first with a #8 - 1" screw, and then to the frame with a #8 - 2-1/4" screw. See **Figure 3**.

Insert the second fixing block above the other fixed panel and fix it to the panel, first with a #8 - 1" screw, and then to the frame with a #8 - 2-1/4" screw. See **Figure 4**.

- 2 Install the gasket at the end of the fixed panel. See **Figure 5**.

Install the fixed meeting rail, starting at the bottom and working upwards. See **Figure 5**.

- 3 Install the dust plug interlock up 3/4 under the meeting rail. See **Figure 11A**.

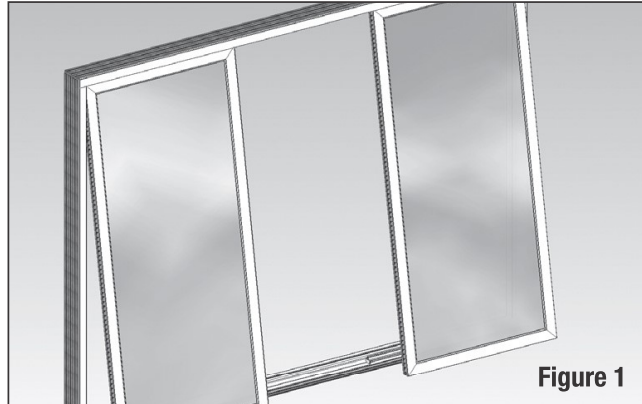


Figure 1

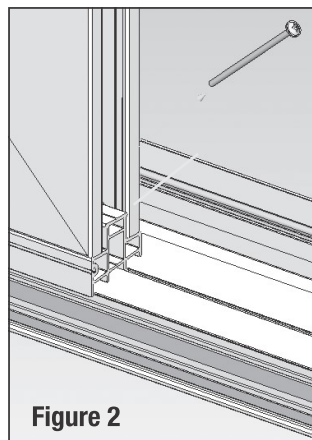


Figure 2

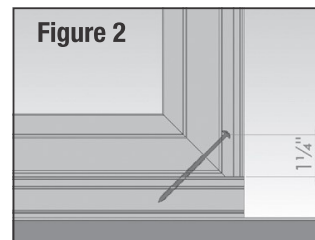


Figure 2



Figure 2A

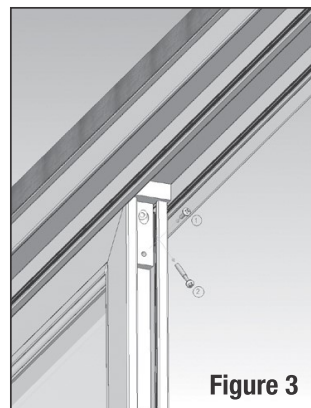


Figure 3

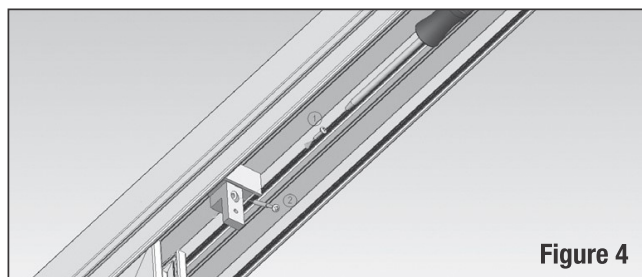


Figure 4

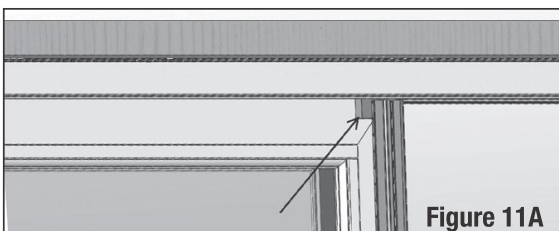


Figure 11A

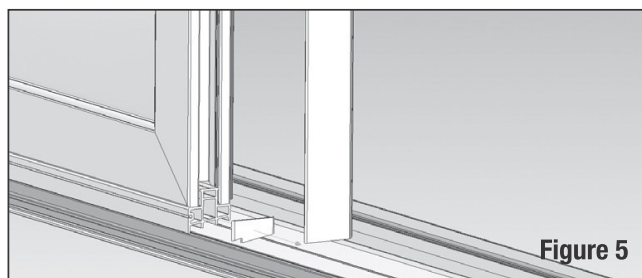


Figure 5

STEP 3 ASTRAGAL ASSEMBLY (OXO)

- 1** Insert the astragal into the frame, first at the bottom and then at the top. Use a hammer and a piece of wood to “knock” the piece into place. Make sure that the piece is properly inserted along its entire length. The piece must remain firmly in place. See **Figure 1**.
- 2** Use a 1/8” bit to drill the 4 holes in the casing and the panel reinforcement. **Be careful not to damage the exterior surface.** See **Figure 2**.
- 3** Fix the astragal to the panel with 4 x #10 - 3” self-tapping screws into the holes pre-drilled for this purpose. See **Figure 2**.
- 4** Install the groove cover. See **Figure 2**.
- 5** Seal the joints between the astragal meeting rail and the sill and head casing with silicone. See **Figure 3**.
- 6** Install the foam seal, the “U”-shaped piece next to the rail and the square piece next to the head. See **Figure 4**.

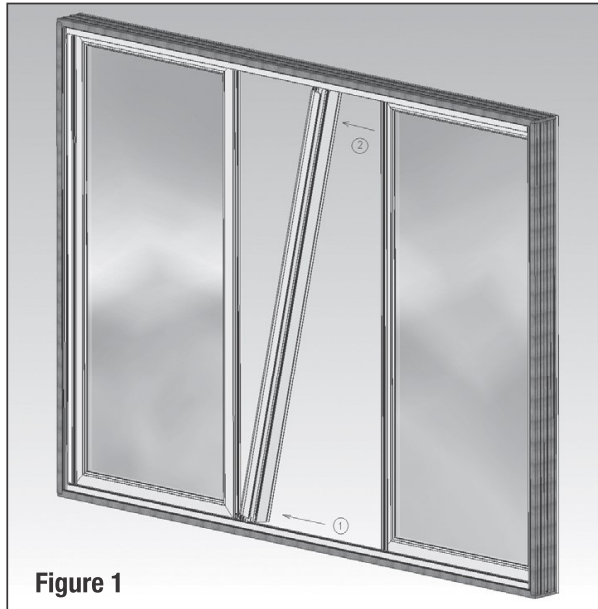


Figure 1

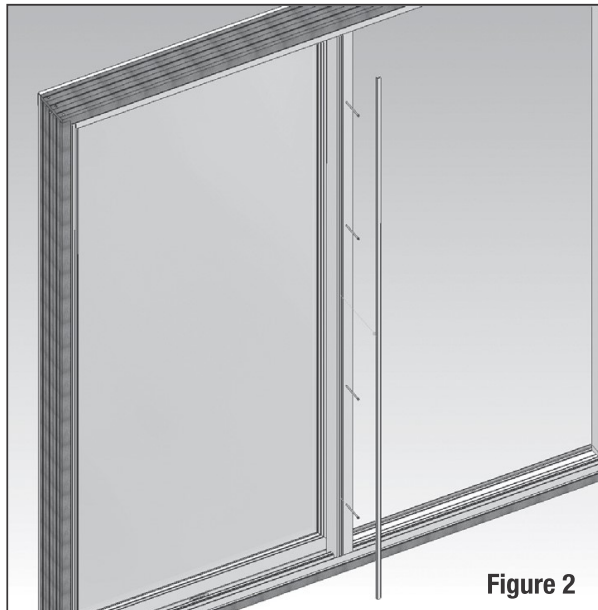


Figure 2

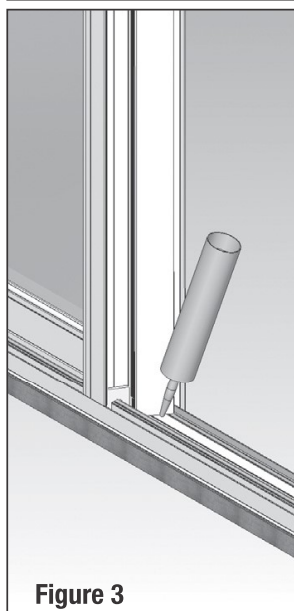


Figure 3

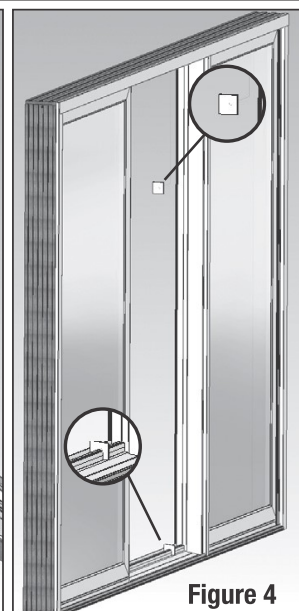


Figure 4

STEP 4

OPERATING PANEL INSTALLATION (OXO)

1 Insert the operating panel into the frame, making sure that the inside surface faces the interior. Insert the top and then the bottom of the panel. See **Figure 1**.

2 Adjust the panel rollers to the third position and check that the panel is square with the frame casing. See **Figure 2**.

Make any necessary adjustments and install the finishing “plugs” on the bottom rail. See **Figure 2**.

3 Install the operating meeting rail, starting at the bottom and working upwards. Make sure that it is parallel to the bottom of the panel. Install the finishing caps on the meeting rail. It must move freely. See **Figure 3**.

Install the stop latch on the fixed panel. See **Figure 4**.

4 Close the operating panels and install the head pile weatherstrip above them. Fix everything in place with a #8 - 3/4” screw. See **Figure 5**.

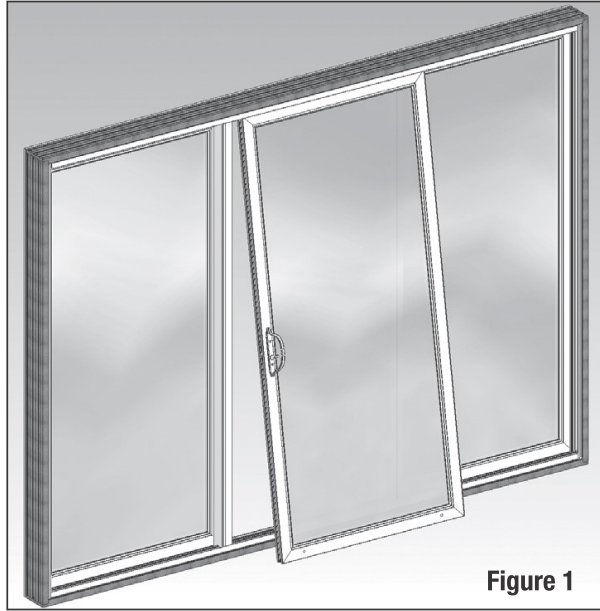


Figure 1

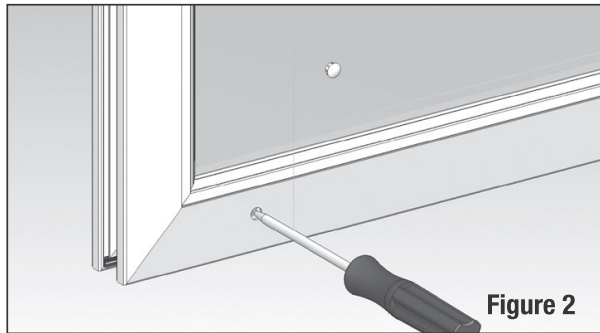


Figure 2

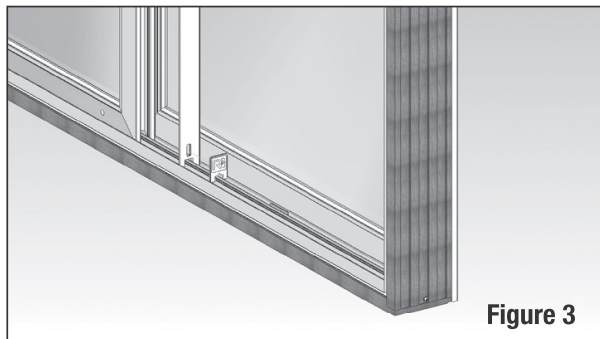


Figure 3



Figure 4



Figure 5

Panel handle

- 1 Insert the exterior handle into the holes in the panel and insert the interior handle. Make sure that the latch operates properly before tightening the screws. See **Figure 1**.

Attaching the latches

- 2 Locate the positioning marks on the frame casings. Attach the latch with #10 - 1 1/4" screws. See **Figure 2**.
- 3 Close the operating panel and check that it operates smoothly. Adjust as needed. Repeat the operation for the screen latch, using #6 - 1/2" screws.

Stand outside the opening and insert the screen into the head sliding rail, making sure that the black weatherstrip is on the interior side of the screen and that the screen rests on the exterior aluminum rail of the sill. See **Figure 3**.

- 4 Slide the screen and check its alignment with the vertical casing. Adjust the lower rollers as needed, using the adjusting screws at either end of the screen.

- 5 Once the door installation is complete, install the foot lockset on the meeting rail of the operating panel at the location indicated in **Figure 4**, using #8 - 1/2" screws, and with the door closed, install the foot lockset latch in the ideal location, using #8 - 1" screws.

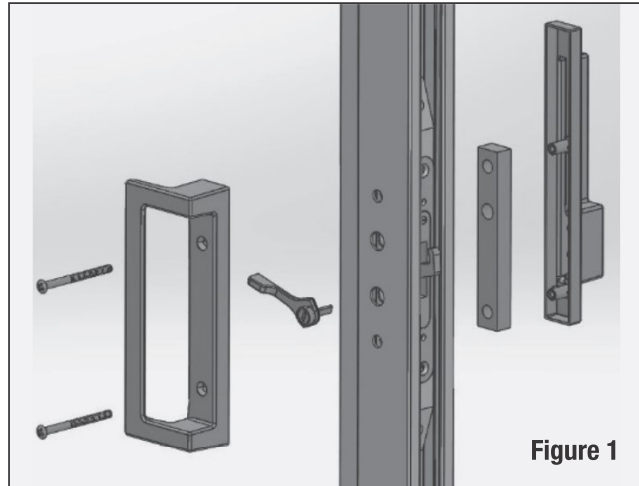


Figure 1

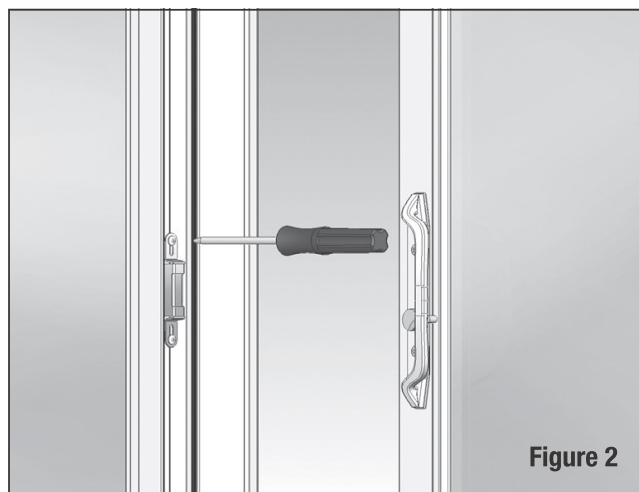


Figure 2

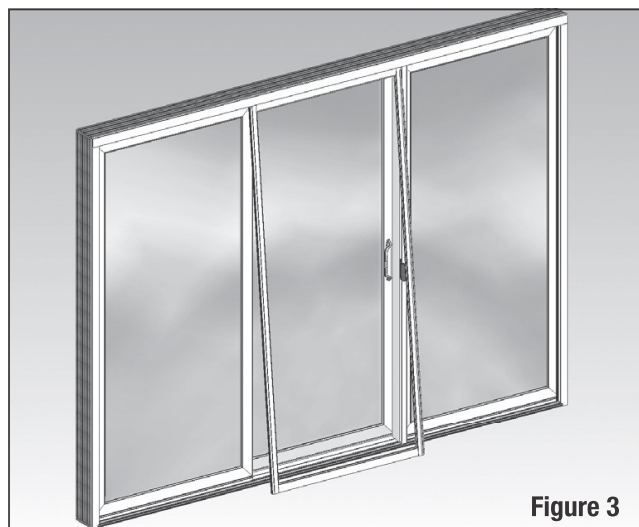


Figure 3

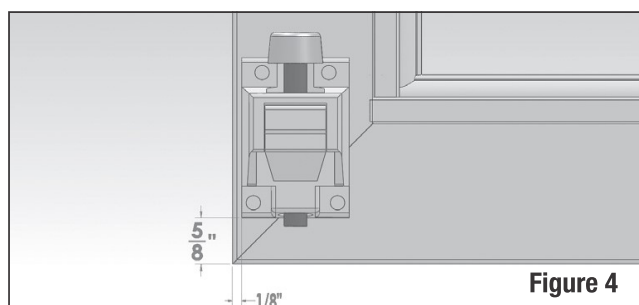


Figure 4

NOTE: FRAME ASSEMBLY:

See Step 1 on Page 4.

- 1 Insert the fixed panels into the frame, making sure that the inside surfaces face the interior. Insert the top first, and then the bottom. The identification labels for the fixed panels must be on the inside of the frame. See **Figure 1**.

Fix the bottom of the panel in place using #8 - 3" screws. See **Figure 2**.

Fix the panel in place using a #6 - 1" screw. See **Figure 2A**. Line the screw up with the height of the glazing stop at the bottom of the panel and in the frame's weatherstrip groove.

Insert the head fixing block (with no finishing strip) above the fixed panel where the astragal will be fixed. Screw it to the panel, first with a #8 - 1" screw, and then to the frame with a #8 - 2-1/4" screw. See **Figure 3**.

Apply sealant to the "H"-shaped connector piece. See **Figure 4**.

Fix the "H"-shaped connector piece to the fixed panel. Use a #8 - 1 1/2" self-tapping screw. See **Figure 5**.

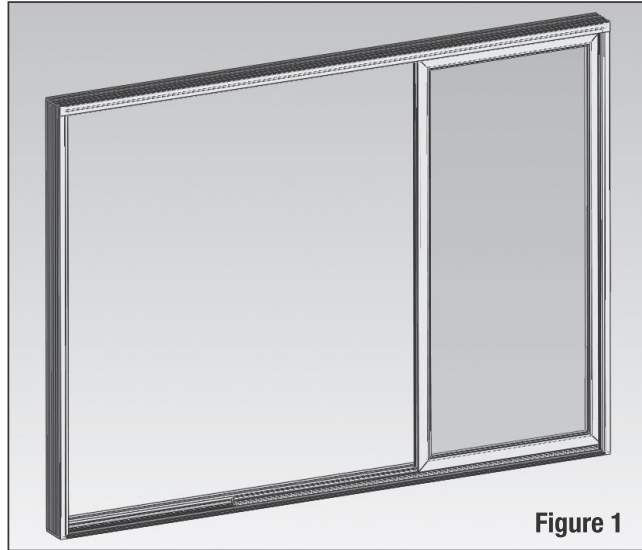


Figure 1

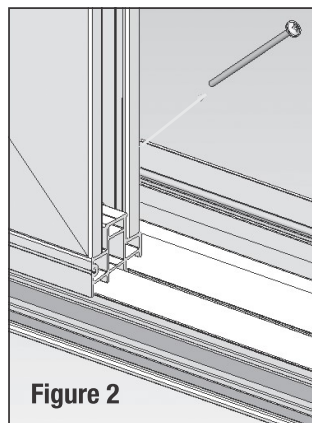


Figure 2

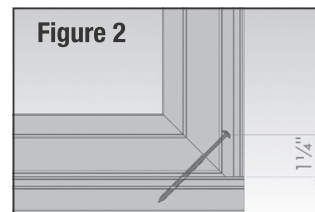


Figure 2

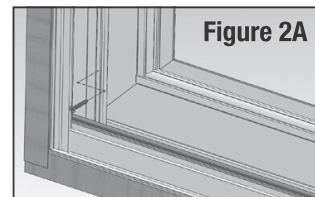


Figure 2A

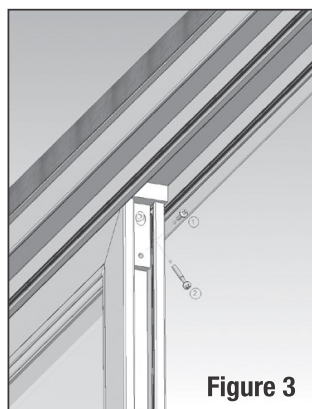


Figure 3

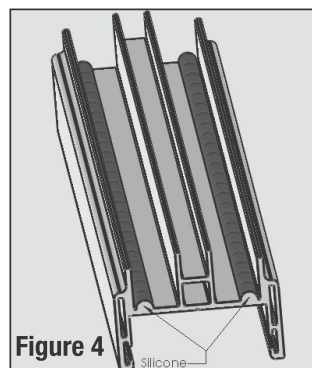


Figure 4

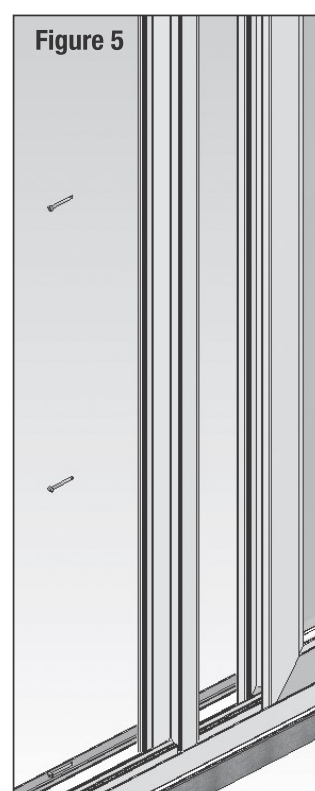


Figure 5

STEP 1

INSTALLATION OF 2 FIXED PANELS (X00 - 00X) (CONT.)

1 Insert the second fixed panel into the frame, making sure that the inside surface faces the interior. Insert the second fixing block above the other fixed panel. Fix it in place using a #8 - 1" screw, and then to the frame using a #8 - 2-1/4" screw. See **Figure 6**.

2 Install the gasket on the end of the fixed panel. See Figure 5. Install the fixed meeting rail starting at the bottom and working upwards. See **Figure 7**. Install the dust plug interlock up 3/4 under the meeting rail. See **Figure 11A**.

Install the pile block sill for the sill. Fix the block sill with the #6 - 1" screw.

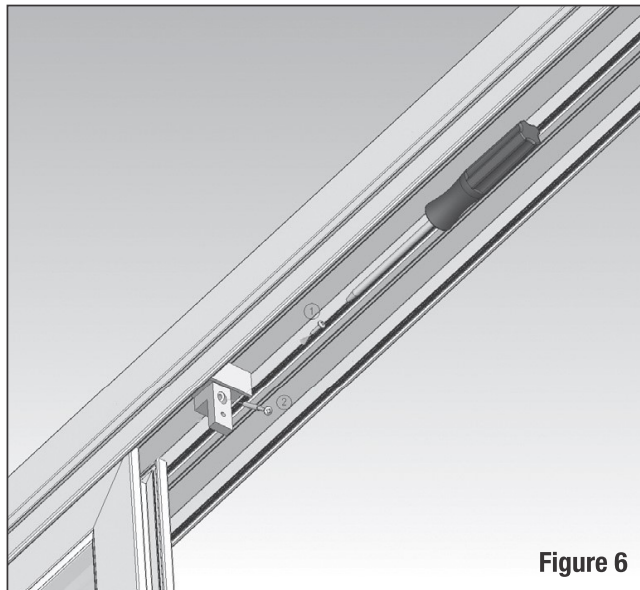
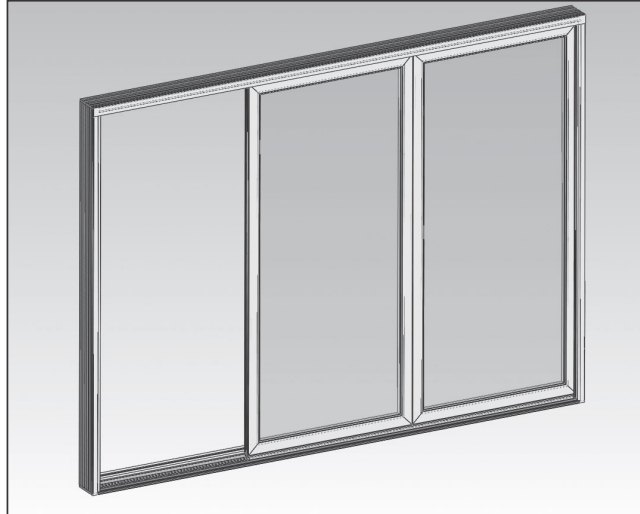


Figure 6

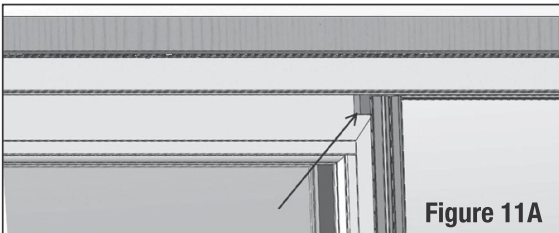


Figure 11A

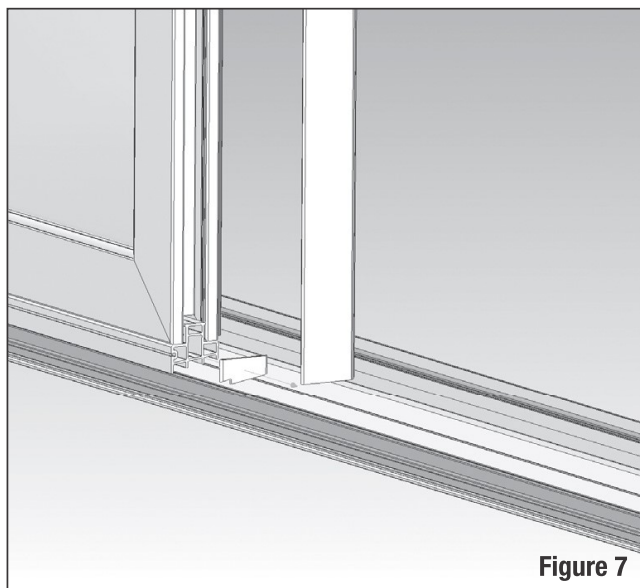


Figure 7

STEP 2 OPERATING PANEL INSTALLATION (X00 - 00X)

1 Insert the operating panel into the frame, making sure that the inside surface faces the interior. Insert the top and then the bottom of the panel. See **Figure 1**.

2 Adjust the panel rollers to the third position and check that the panel is square with the frame casing. See **Figure 2**.

Make any necessary adjustments and install the finishing “plugs” on the bottom rail. See **Figure 2**.

3 Install the operating meeting rail, starting at the bottom and working upwards. Make sure that it is parallel to the bottom of the panel. Install the finishing caps on the meeting rail. It must move freely. See **Figure 3**.

Install the stop latch on the fixed panel using a #8 - 2-1/2” screw. See **Figure 4**. Install the head stop latch. Line the back of the latch up with the center of the “H”-shaped connector for the fixed panel, using a #8 - 2-1/2” screw.

Repeat the operation for the sill stop latch by pre-drilling the sill using a 1/8” bit. See **Figures 4 and 4A**

4 Close the operating panels and install the head pile weatherstrip above them. Fix everything in place with a #8 -3/4” screw. See **Figure 5**.

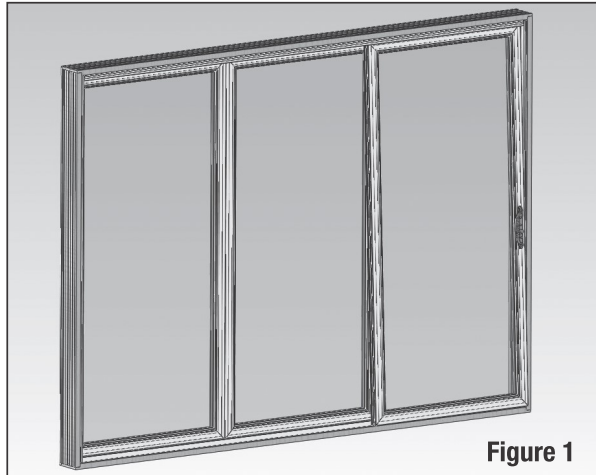


Figure 1

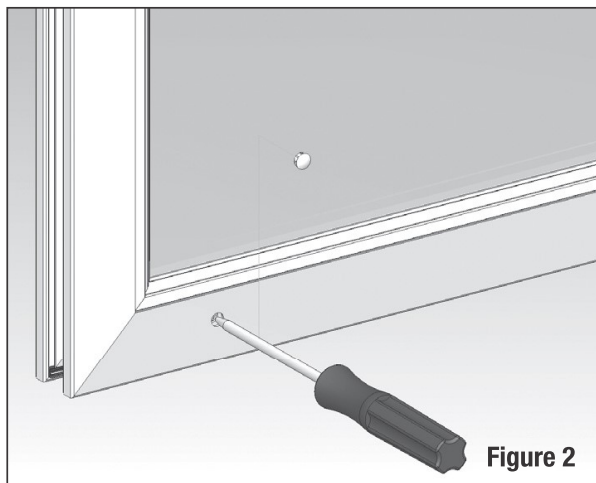


Figure 2

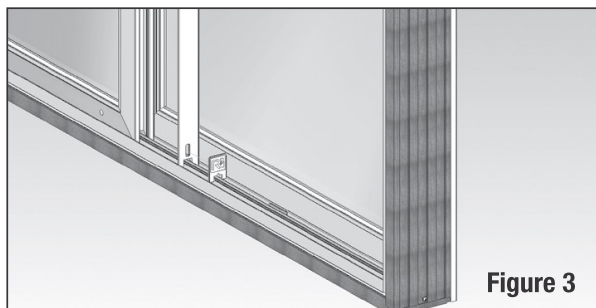


Figure 3



Figure 4



Figure 5

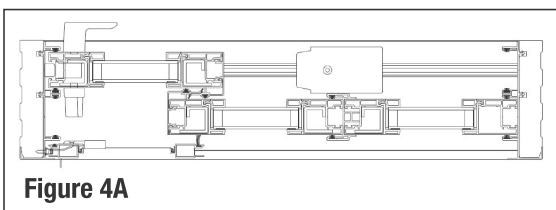


Figure 4A

STEP 3

HANDLE AND SCREEN ASSEMBLY (X00-00X)

Panel handle

- 1 Insert the exterior handle into the holes in the panel and insert the interior handle. Make sure that the latch operates properly before tightening the screws. See **Figure 1**.

Attaching the latches

- 2 Locate the positioning marks on the frame casings. Attach the latch with #10 - 1 1/4" screws. See **Figure 2**.

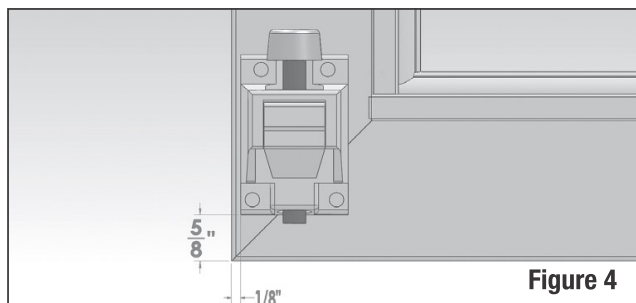
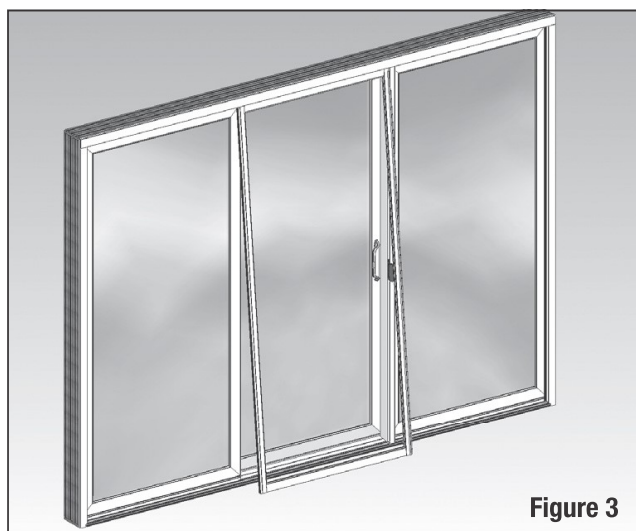
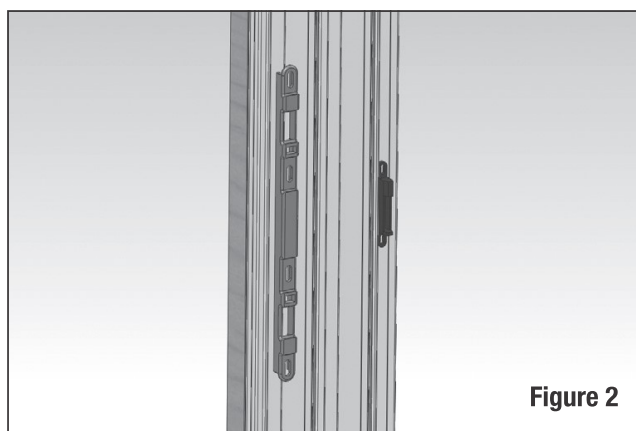
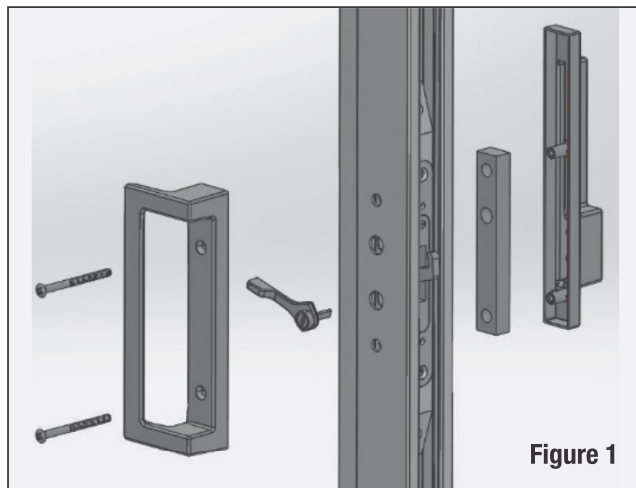
Close the operating panel and check that it operates smoothly. Adjust as needed.

Repeat the operation for the screen latch, using #6 - 1/2" screws.

- 3 Stand outside the opening and insert the screen into the head sliding rail, making sure that the black weatherstrip is on the interior side of the screen and that the screen rests on the exterior aluminum rail of the sill. See **Figure 3**.

- 4 Slide the screen and check its alignment with the vertical casing. Adjust the lower rollers as needed, using the adjusting screws at either end of the screen.

- 5 Once the door installation is complete, install the foot lockset on the meeting rail of the operating panel at the location indicated in **Figure 4**, using #8 - 1/2" screws, and with the door closed, install the foot lockset latch in the ideal location, using #8 - 1" screws.



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