

INSTRUCTIONS FOR

ASSEMBLING A 4-LITE

550 DOOR



Tools and Hardware	2
Frame Assembly	4
Fixed Panel Installation OXXO	5
Operating Panel Installation OXXO	6
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Installing the Panel and Screen stops.....	8

TOOLS REQUIRED















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

KIT CONTENTS

1. Kit consisting 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	2		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	162148	1		SCREEN KEEPER
③	162444	2		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	2		#8-10 x 1" PAN QUADREX FOR HEAD FIXATION (FIXED SASH)
⑧	161020	2		#8-10 x 3" PAN WASHER FOR FRAME ASS. + FIXATION (FIXED SASH)
⑨	161133	2		#8-10 x 2 1/4" PAN WASHER FOR HEAD FIXATION
⑩	161144	2		#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: 31/03/2016

550 KIT D



Ref. #	PROFILE	QTY	DRAWING	DESCRIPTION
①		2		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: 31/03/2016

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: 18/03/2021

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: 23/01/2014

550 KIT H

Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	166195	2		HEAD OXOXO DUSTPLUG
②	161041	2		#8 x 3/4" TRUSS QUAD WHITE FOR DUST PLUG AND SAFETY BAR
③	161096	7		#8 x 1 1/2" PAN SELF DRILL H CONNECTOR FOR OXOXO
④	150141	1		OXOXO SASH STOPPER
⑤	150108	1		OXOXO SCREEN STOPPER
⑥	161021	3		#8 x 1 1/4" FLAT CARRÉ ZINC FOR SASH STOPPER
⑦	161029	3		#8 x 1 1/4" TRUSS QUADREX ZINC FOR HDPE BLOCK (STOPPER)
⑧	161005	3		#6 x 1" FLAT QUADREX SCREEN STOPPER
⑨	162349	1		HDPE BLOCK (OXOXO STOPPER)

BAG 6 X 10

DRAWING:

H

REVISION: 29/01/2014

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) Bottom Rail
 - 3) Vertical side casing
 - 4) Vertical side casing
 See **Figure 1**.

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

- 3 Use the #8 - 3" washer head screws to attach the side casings to the head and bottom rail (4 screws at the head and 3 at the bottom rail). 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 cove 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**. Pay attention to the placement of the screw for the fixed-panel support at the center of the door. See **Figure 4A**. Install the frame filler on the end of the panel support, 3-1/2" from the edge. See **Figure 5-A**.

Install the block sill for the operating panel. Fix the block sill with the #6 - 1" screw. See **Figure 5-B**.

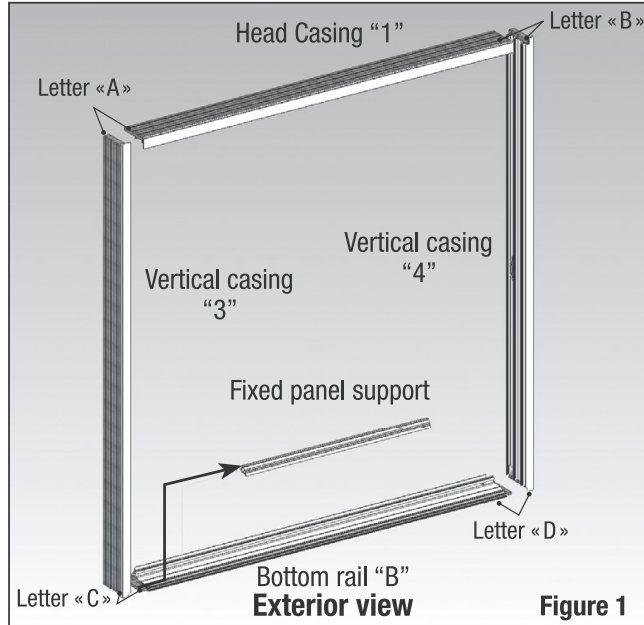


Figure 1

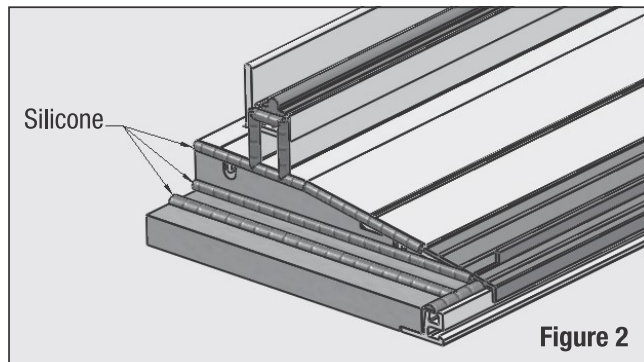


Figure 2

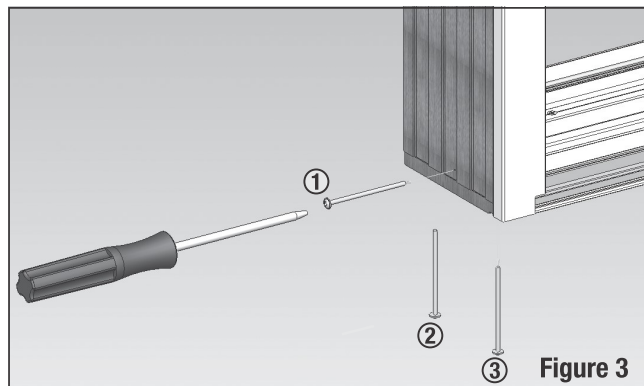


Figure 3

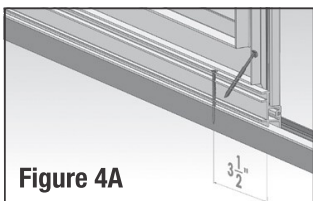


Figure 4A

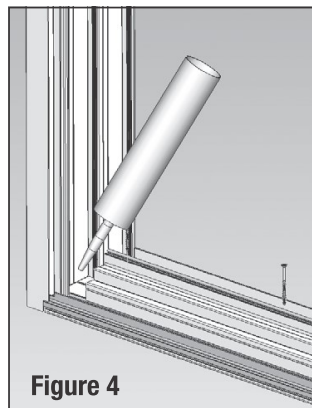


Figure 4

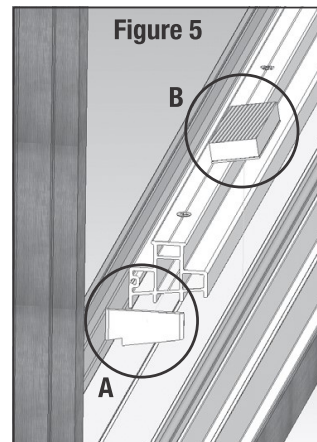


Figure 5

NOTE TO ASSEMBLE THE FRAME:

See Step 1 on Page 4.

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**.

2 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 above the fixed panel. Fix it to the panel, first with a #8 - 1" screw, and then to the frame with a #8 - 2-1/4" screw. Make sure that the panels are well seated in the bottom of the frame before proceeding. See **Figure 3**.

Install the fixed meeting rails, starting at the bottom and working upwards. See **Figure 4**. Install the dust plug interlock up, 3/4" under the meeting rail. See **Figure 11A**.

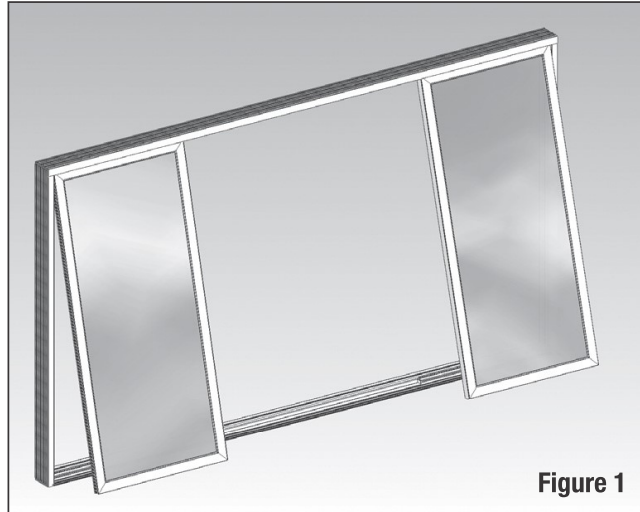


Figure 1

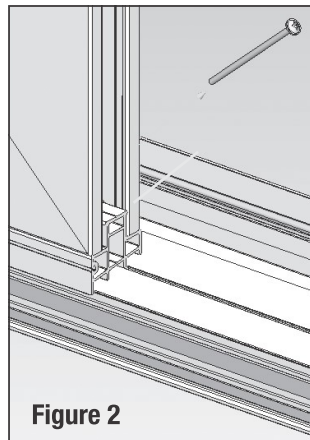


Figure 2

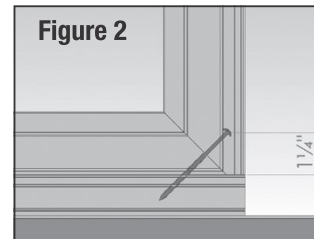


Figure 2



Figure 2A

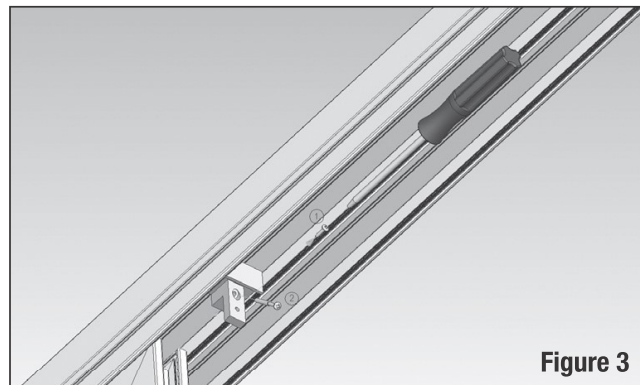


Figure 3

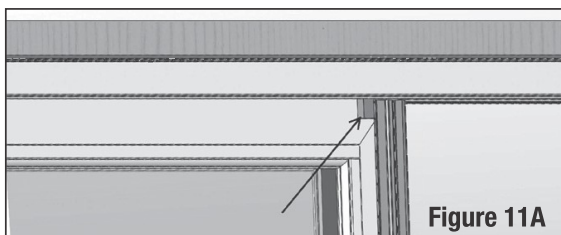


Figure 11A

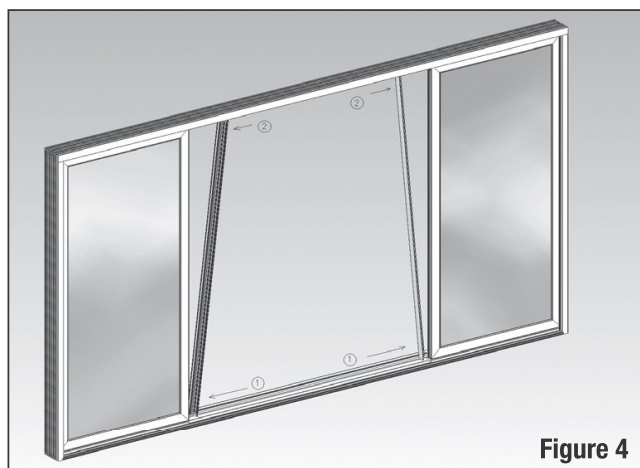
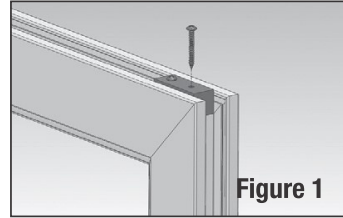


Figure 4

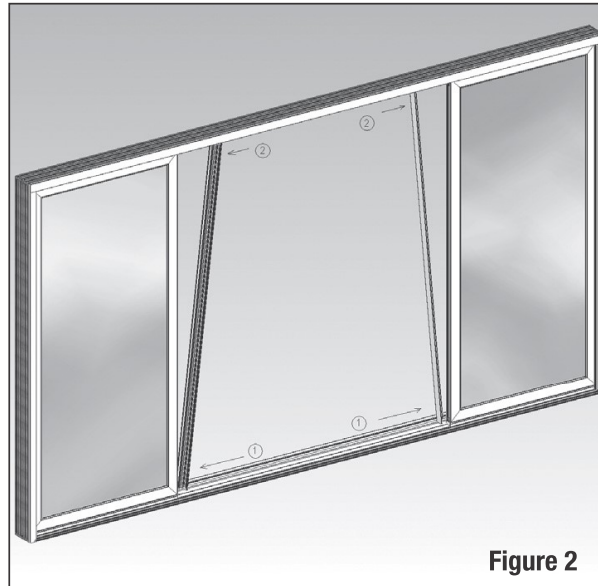
STEP 3

INSTALLING THE OPERATING PANEL (OXXO)

1 Install the HDPE block on the top of the operating panel on the mortise side using #8 - 1 1/4" Truss head screws. See **Figure 1**.



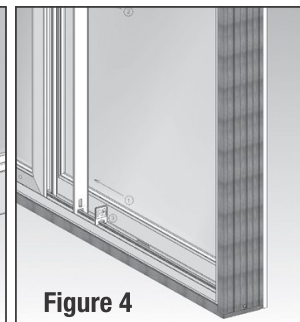
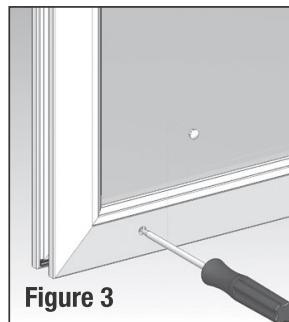
2 Insert each operating panel into the frame, making sure that the inside surface faces the interior. Next, insert the heads and then the bottoms of the panels. See **Figure 2**.



3 Adjust the panel rollers to the third position and check that the 2 panels line up where they meet at the center of the frame. See **Figure 2**.

Adjust as necessary and install the finishing "plugs" on the bottom rail. See **Figure 3**.

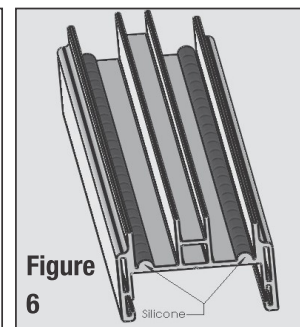
4 Install the meeting rails on the operating panels, starting at the bottom and working upwards. Make sure they line up with the bottom rails on the panels. Install the finishing cap on the meeting rail. It must move freely. See **Figure 4**.



Install the stop latches, one at each end of the frame.

See **Figure 5**.

5 Apply sealant to the "H"-shaped connector. See **Figure 6**.



6 Fix the "H" connector to the semi-opening panel. Place the piece so that it can move freely within the frame. Use #8 - 1 1/2" self-tapping screws. See **Figure 7**.



Close the operating panels and install the head pile weatherstrip above each panel, and 1 at the center of the 2 panels. Fix everything in place using #8 - 3/4" screws. See **Figure 8**.

STEP 3

INSTALLING THE OPERATING PANEL (OXXO) (CONT.)

- 7 Attach the latch to the “H” connector, using a #8 - 1 1/2” screw. See **Figure 9**.

Attach the foam seals to the “H” connector, placing the square piece at the head and the piece with the slope at the bottom. See **Figure 9**.

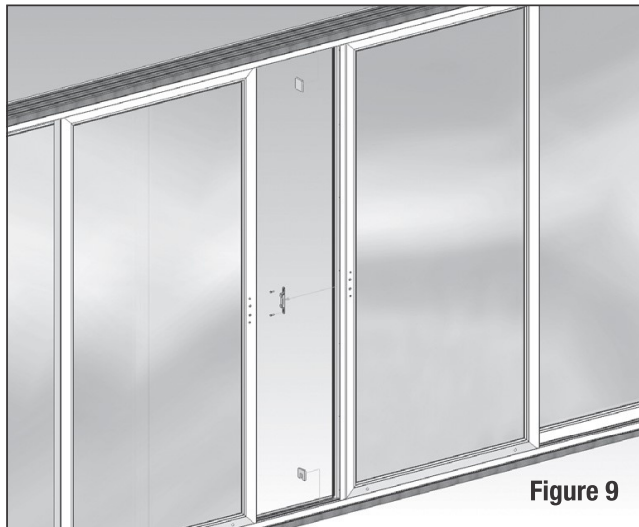


Figure 9

STEP 4

HANDLE AND SCREEN ASSEMBLY (OXXO)

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**.

Semi-opening panel

Repeat the step for the semi-opening panel. **Except don't install the thumbturn. See **Figure 2**.

Attaching the latches

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

Attaching the latches

- 3 Insert the 2 screens in the frame and close to the center of the frame. See **Figure 3**.

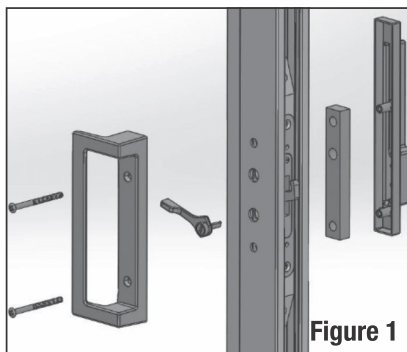


Figure 1



Figure 2

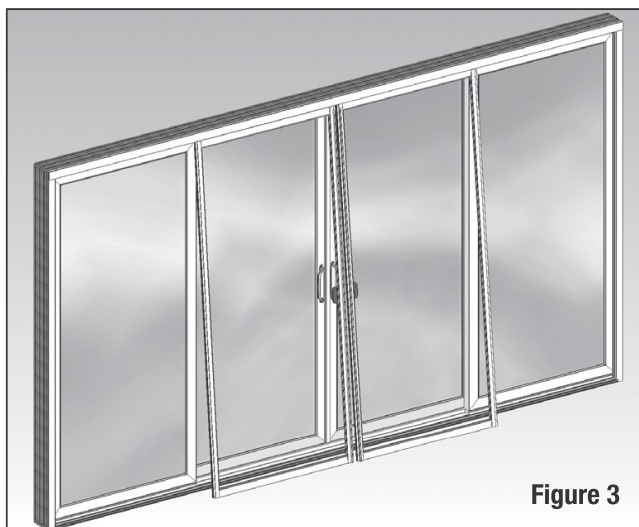


Figure 3

STEP 4 HANDLE AND SCREEN ASSEMBLY (OXXO) (CONT.)

Adjust height so that the screens are seated firmly on the stop latch. See **Figure 4**.

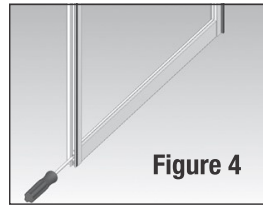


Figure 4

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

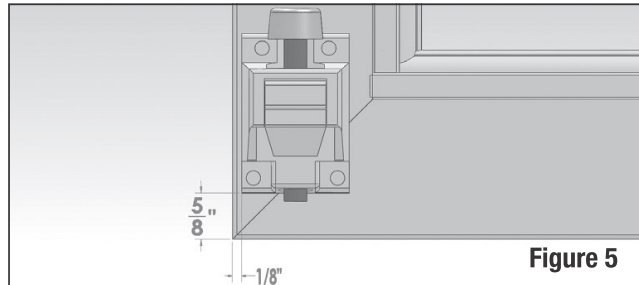


Figure 5

STEP 5 INSTALLING THE PANEL AND SCREEN STOPS

- 1 To install the panel stop, close the semi-opening panel, place the stop in the proper location, mark the spot where the stop will be installed, open the panel and fix the stop in place with 2 x #8 - 1 1/4" flat square zinc screws. Close the 2 panels to see if everything is OK, and adjust as needed. See **Figure 1**.



Figure 1

- 2 Insert the foam seals in the frame cavity and slide them towards the stop. See **Figure 2**.

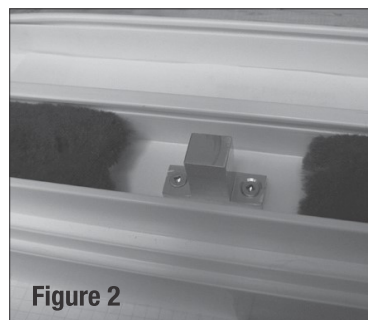


Figure 2

- 3 Using 2 x #8 - 3/4" white truss head Quadrex screws, fix the 2 foam seals in place. See **Figure 3**.



Figure 3

- 4 Repeat the operation for the screen stop, using #6 - 1" screws.

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