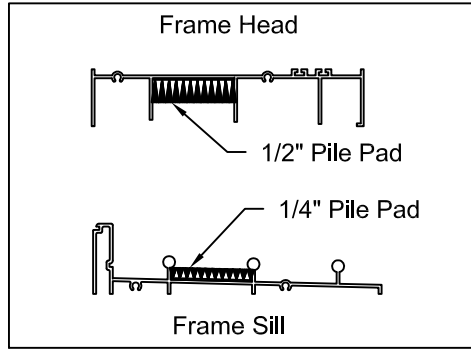


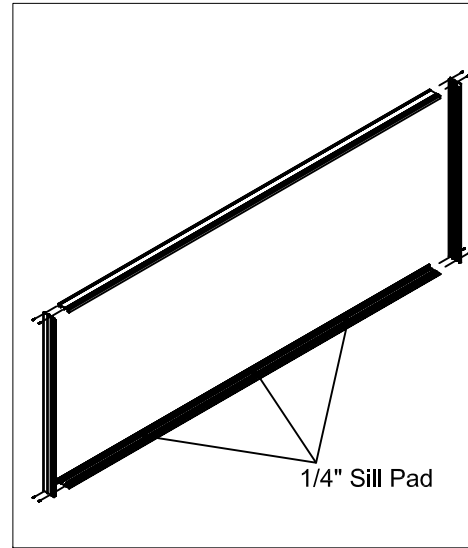
Series 4780 OXXO 4 Panel Patio Door



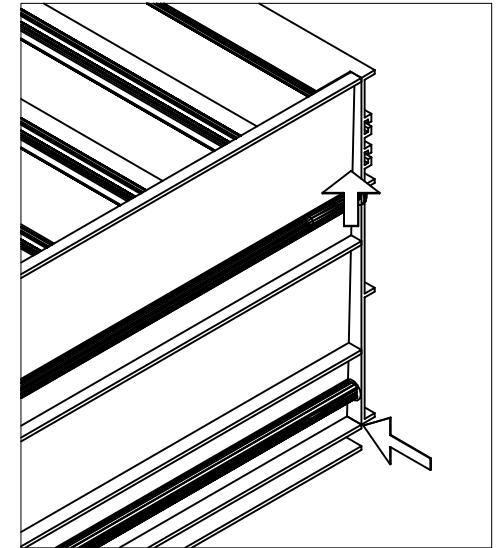
1. Install one 1/2" tall adhesive weather-strip pad 1/4 from each end and in center of the frame head between the vertical guides legs as shown above. Where XX adaptor will be add a second pad.

2. Install one 1/4" tall adhesive weather-strip pad 1/4 from each end and in center of the frame sill between the two roller tracks as shown above. Where XX adaptor will be add a second pad.

Note: The weatherstrip pads should be in line with the interlocks and in line with the XX adaptor when the door is completely assembled.

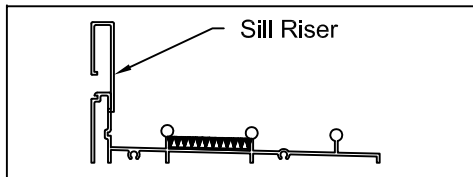
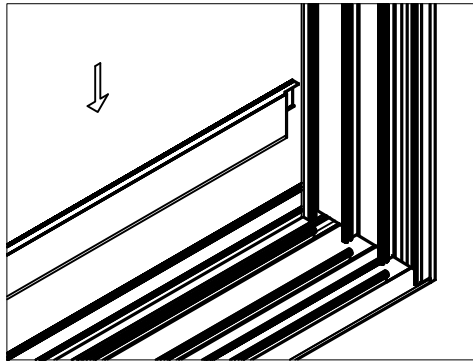


3. Assemble the door frame using the #8 X 1" zinc pan head screws (8).

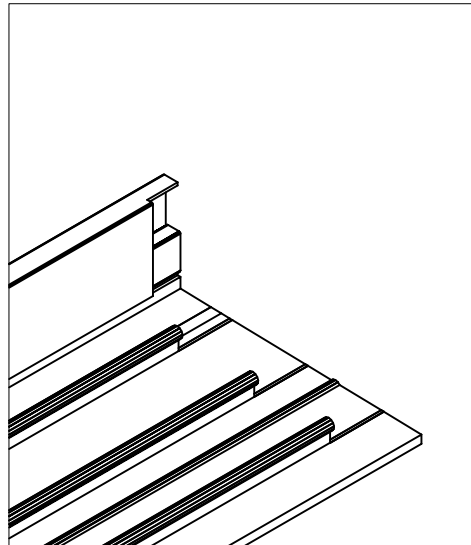


4. Caulk the bottom of the frame sill to jamb joint making sure all joints between sill and jamb are filled with sealant.

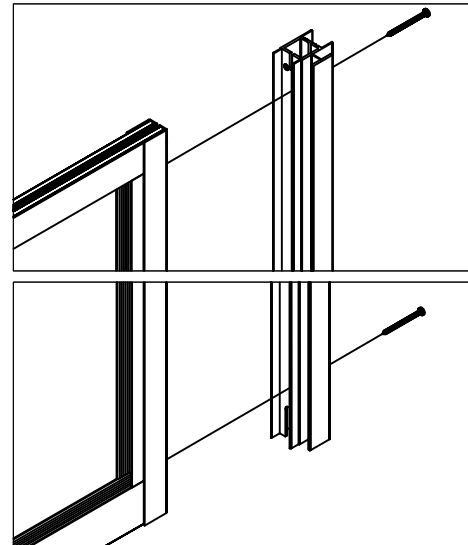
5. Install the frame in the opening per Alenco instruction detail I-4780-1 (finless frame) or I-4780-2 (nail fin version)



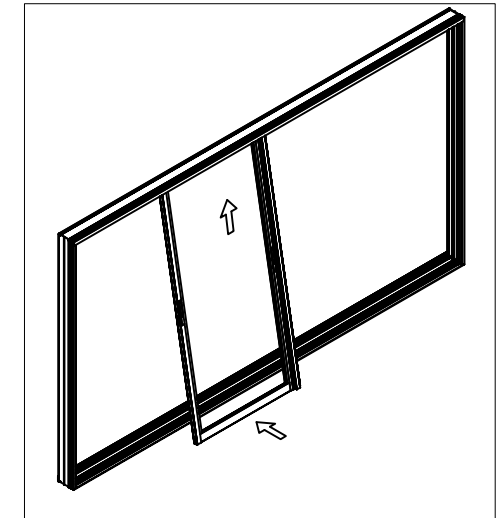
6. If the sill riser is required use a rubber mallet to drive it over the dam of the frame sill.



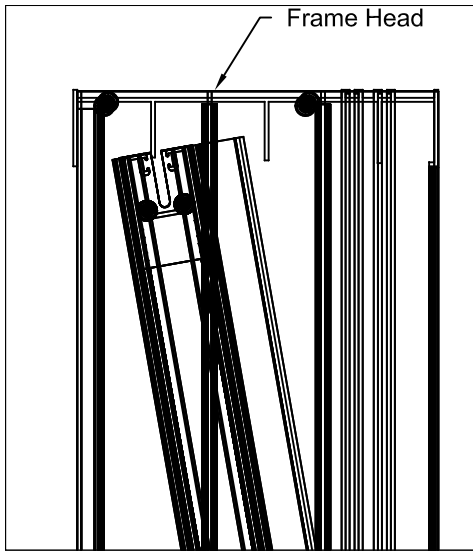
7. If the sill riser is added sealant must be applied from the top of the riser to jamb joint down to the frame sill.



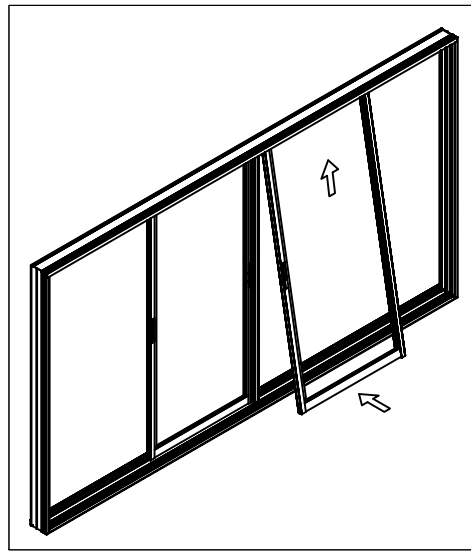
8. Attach XX adaptor (II) to vent with two #8 x 2" truss screws at prepunched holes at top and bottom.



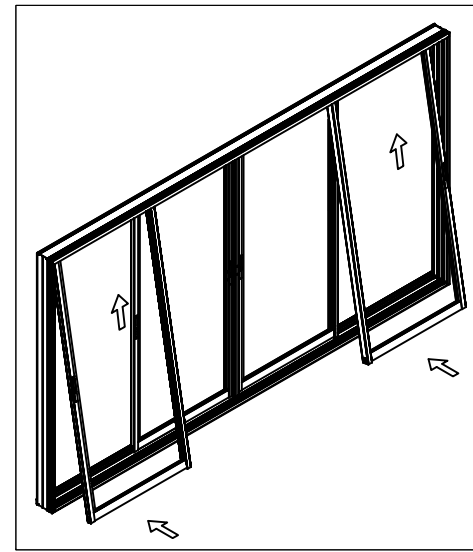
9. Install the inside vent first, the one with the XX adaptor attached. The vent installs from the outside. Push the top of the vent up into the head and swing the bottom onto the sill.



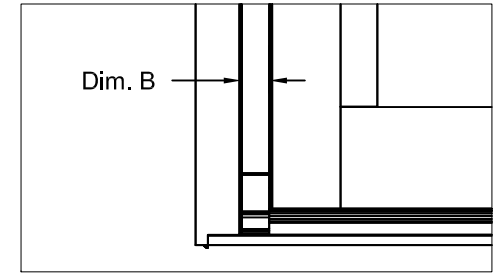
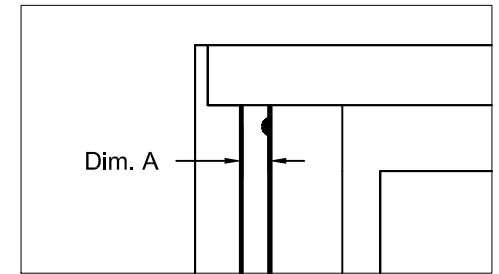
Note: The figure above shows the inside vent being inserted into the interior track.



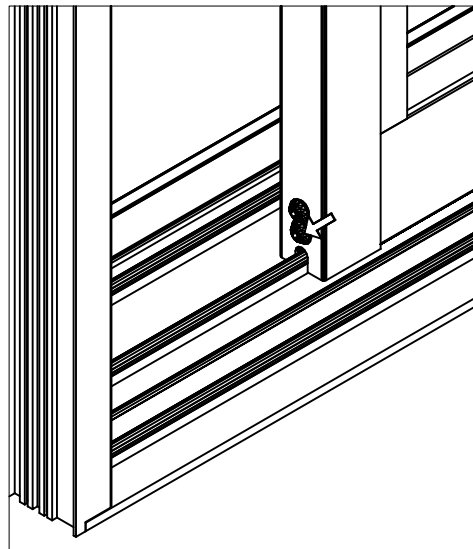
10. Install second inside track vent. From the outside push the top of the vent up into the head and swing the bottom onto the sill.



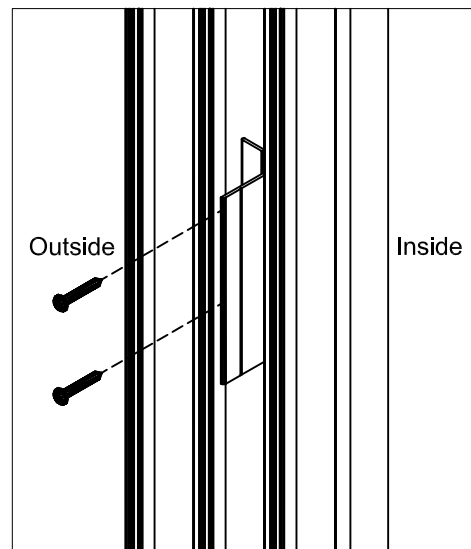
11. Install vents three and four in center track. From the outside push the top of the vent up into the head and swing the bottom onto the sill.



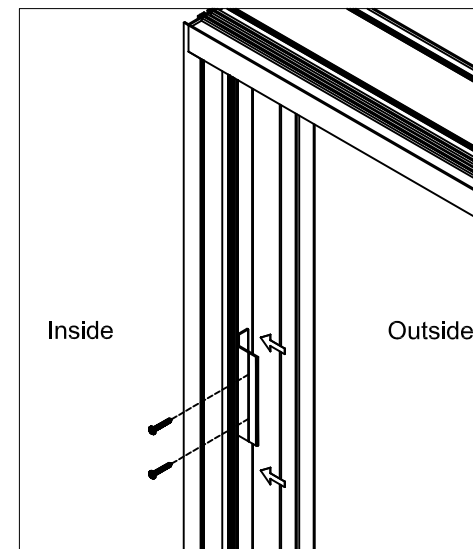
12. Move a vent up to the frame and measure the gap at the head and at the sill. (Dim. A and Dim. B)



13. Use the roller height adjustment screws to raise and lower either end of the vent until Dim. A and Dim. B are equal. Repeat steps 12 and 13 for the other vents.

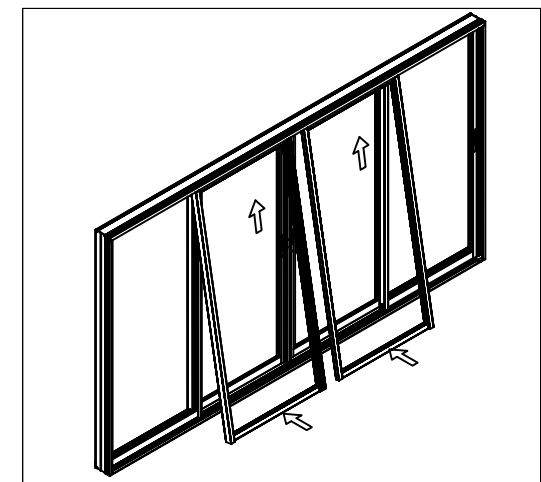


14. Install two O-Panel Clips in the frame jamb as shown. Space the clips approximately 1/4 of the door height down from the head and 1/4 of the door height up from the sill. Use 2 #8 X 1" self drilling screws per clip.



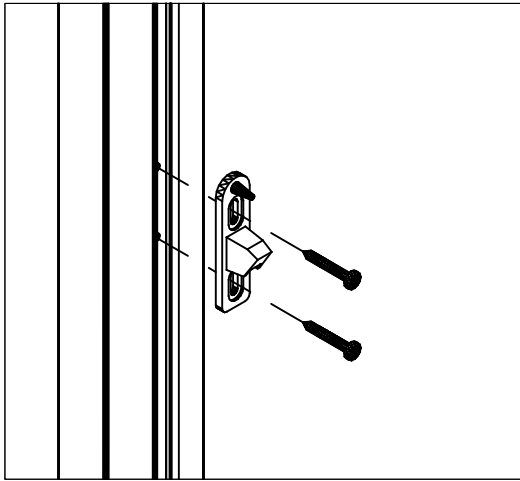
15. Complete the O-Panel installation by inserting the panel into the frame jamb and attaching the clip to the panel using 2 #8 X 1" self drilling screws per clip.

Repeat steps 14 and 15 for other side.

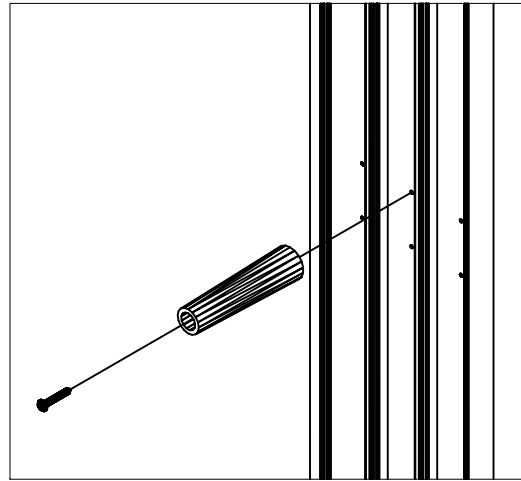


16. Install the two screens from the outside so that it operates in the same direction as the center vent. To install the screen push the top of the vent up into the outer most track of the head and swing the bottom onto the sill.

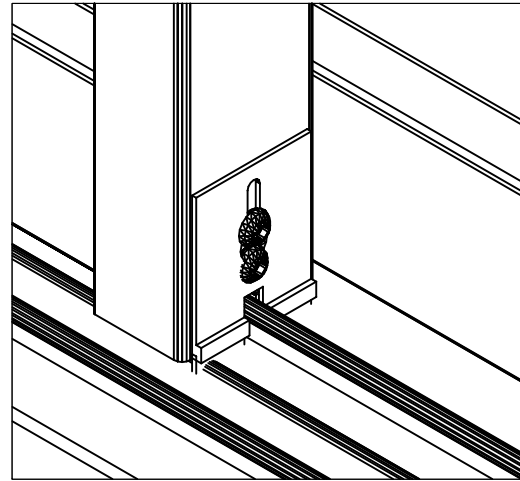
Adjust the screen just as you did the panels earlier in steps 12 & 13.



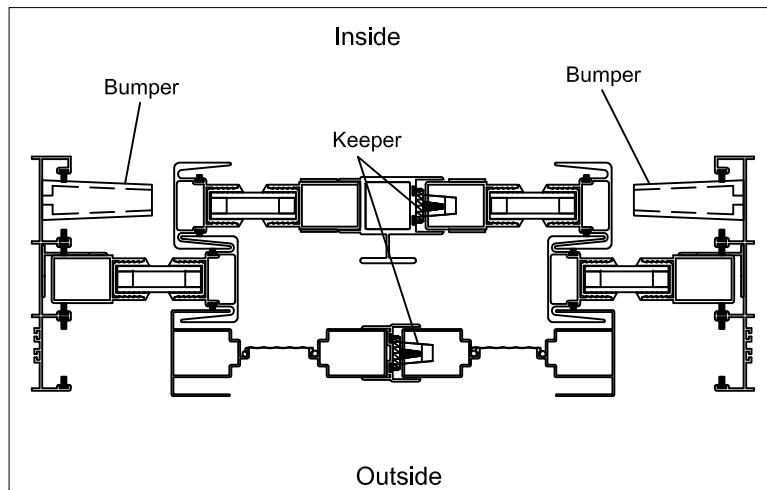
17. Install the keeper in the XX adaptor with two #8 x 1" self drilling screws. Install keeper in screen XX adaptor with two #7 x 7/16" self drilling screws. Adjust the keepers vertically until the throw of the lock fully engages the keepers.



18. Install the frame bumpers in the jamb track opposite operating vents with #8 x 1" self drilling screws.



19. Optional: Add bug sweeps at bottom ends of interlocks at interior and exterior. To install back out bottom panel screw 2-3 turns or enough to slip bug sweep over and under screw head. Adjust and then tighten screw.



Note: Above picture shows bumper and keeper locations for OXXO door.