

# Imperial Series

## Series 6900/6800 Family of Inside Sliding Patio Door - Installation Instructions

### Installation Requires Knowledge of:

- AAMA Installation Instructions.
- Applicable Federal, State, Local Codes and Regulations.
- An Understanding of the Fundamentals of Residential Construction.
- A Working Knowledge of the Tools, Equipment and Methods Required for Installation.
- A Familiarity with Caulking, Sealing Procedures and Glass Handling Procedures.



### Tools Required

- Hammer
- Power drill
- .171 Dia. drill bit
- Utility knife
- Putty knife
- Caulking gun
- Measuring tape
- Carpenter's square
- Phillips head screwdriver
- Level (6' recommended)
- Shim material
- Caulking (One that's appropriate for your job)
- Locking pliers

Before you start: Read instructions thoroughly and double check the parts lists to make sure all necessary parts are present.

Flashing and/or an appropriate method of sealing shall be designed as a part of an overall weather resistive barrier system. It is not the responsibility of the door manufacturer to design or recommend a flashing system appropriate to each job condition. Responsibility for protecting any flashing material from damage caused by weather, other trades or vandalism and properly integrating the flashing system into the weather resistive barrier for the entire building will be the responsibility of the general contractor or his designated agent.

### 1. Measuring Door Openings

Check your opening for plumb and square. Check floor for flatness. Correct any problems with the rough opening or floor flatness before proceeding with the installation.

Measure rough opening at the ends and the center. See **Fig. 1**. Opening should read 1/2" larger than the actual door height and width. With new construction, trimmer studs on each side of the opening should remain loose until the door frame is installed.

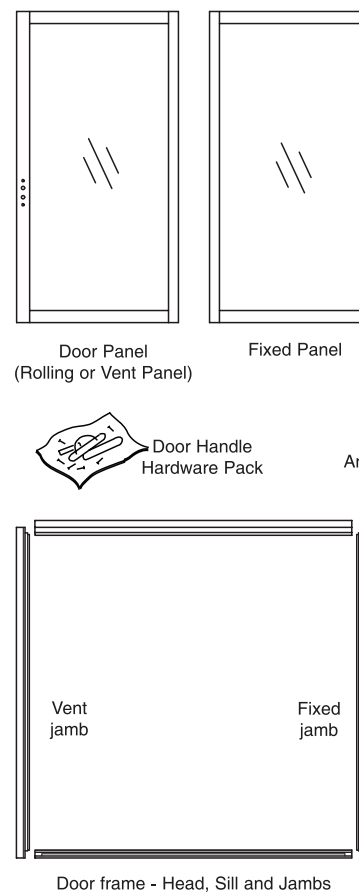
### 2. Frame Assembly

Before assembling the frame, it is very important to use the recommended sealant for your job. Assemble frame by applying a "Small Joint Sealer" to all contact surfaces of the corner joints prior to assembly, see **Fig. 2**. While the sealant is wet, align the screw holes in the jamb with the slotted ones on the head or sill. Fasten joint with #8 X 5/8" Ph. Pan Hd SMS. For best results, do one corner at a time. After the frame is assembled, run a bead of sealer along both sides (inside and out) of each corner joint. See **Fig. 3**. It is important that the corner joints are fully sealed to prevent water leakage. Seal over the screw heads with an appropriate sealant.

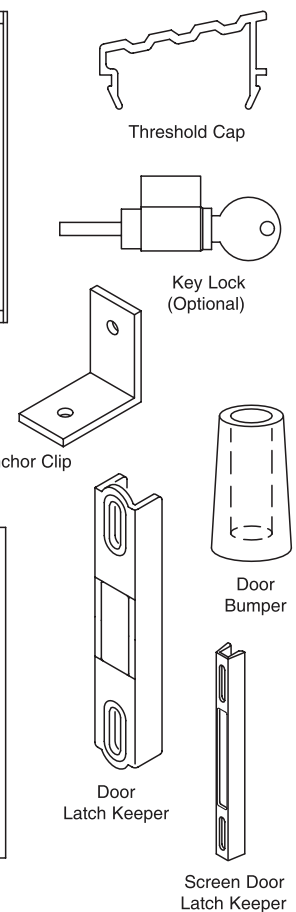
### 3. Preparing the Sill


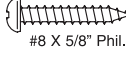
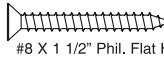

A sill pan is recommended for door installations. Sill pan flashing is used to ensure that incidental water that penetrates the building envelope will be collected and allowed to drain.

### Door Frame Package Supplied Includes:

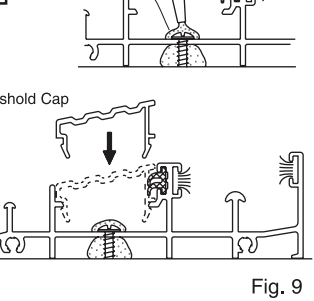
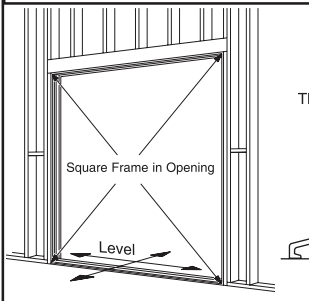
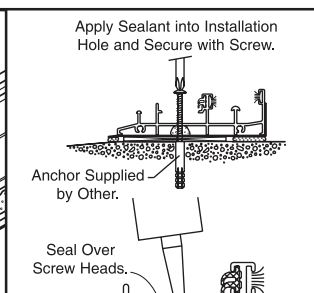
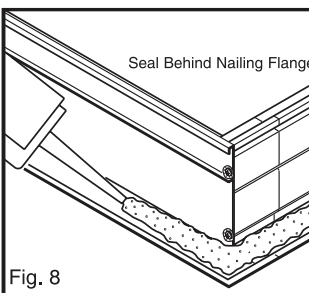
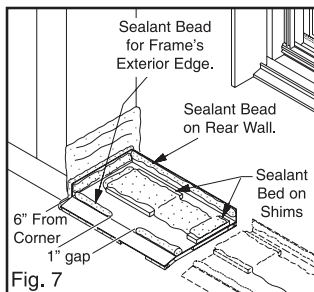
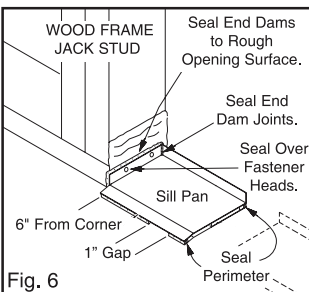
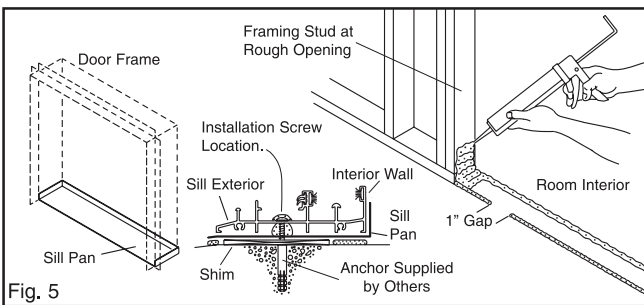
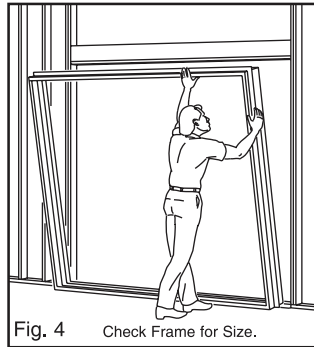
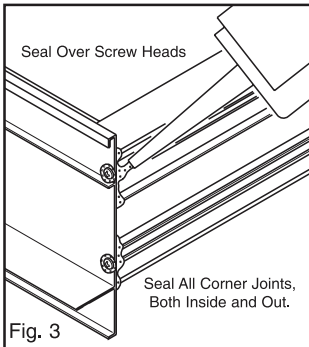
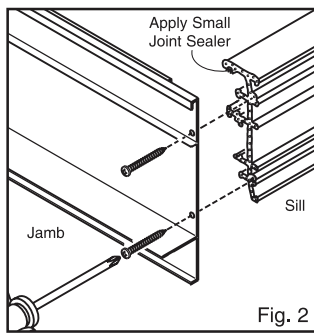
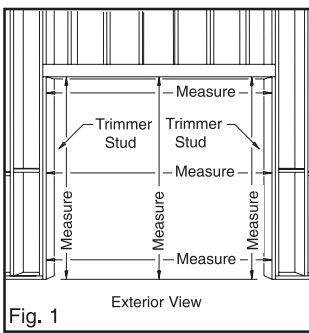


### Hardware Package Supplied includes:



QUANTITY	DESCRIPTION	USAGE
4 Each	 #8 X 3/8" Phil. Truss Hd sms "Ab"	Anchor Clips
8 Each	 #8 X 5/8" Phil. Pan Hd sms "Ab"	Frame Assembly
22 Each	 #8 X 1 1/2" Phil. Flat Hd sms "Ab"	Installation
2 Each	 #8 X 3 1/2" Phil. Pan Hd sms "Ab"	Door Latch Keeper

**Note:** Be sure to remove all Packing Material including the wood support beneath the sill.



A sill pan is a rigid piece of flashing with an interior wall and side end dams. The sill pan prevents water from flowing into the wall or interior finishes. The sill pan flashing material and fasteners are provided by others. Sill pan must be formed to fit around the door frame at the sill. The flashing should also fit the sill condition, sloping if needed to the exterior, see **Fig. 5**.

#### 4. Installing the Sill Pan

After fabricating the sill pan, dry fit the pan in the sill opening to check for size and fit. The sill condition must be level. If not level, use shims under the sill pan to correct this. Dry fit the door frame on the sill pan also for size and fit, see **Fig. 4**. Center frame in rough opening. If frame sill is not level, shim between frame and sill pan. Also check the rest of the frame for square and plumb. Installation screws will be installed through the center channel in the sill, see **Fig. 5**. If holes have not been pre drilled in the sill, determine the number and location of fasteners to be used and drill them. The sill needs a minimum of 3 fasteners, based on a maximum of 16" apart, on center. Installation holes should have a .171 diameter, big enough for a #8 screw. If door is being installed on a concrete floor, mark the location of the installation holes on the sill pan below for reference. Remove door frame from opening to expose the sill pan. Pre-drill two pilot holes in each end dam for fastening the sill pan to the frame studs in the rough opening, see **Fig. 6**.

For concrete floor installation, pre-drill installation holes in the sill pan. Install masonry screw anchors at this point.

Determine the proper sealant to use for the materials and building condition you are working with. Remove the sill pan and lay a sealant bed at both corners of the sill opening where the floor and framing studs meet, see **Fig. 5**. Apply sealant up both studs about 6 inches. Then run a generous bead of sealant between the two studs, along the Interior edge of the sill where the sill pan will set. Apply a 3/8" diameter bead of sealant to the exterior edge of the sill. Leave two 1" gaps, approximately 6" from each jamb. These gap allow for any water drainage. Replace sill pan in the opening, on top of sealant and shims. Line up installation holes and apply even pressure to the pan to ensure contact. Check pan for straight and level. Secure sill pan to opening with fasteners through the end dams. Seal over the fastener heads and all joints between the sill pan and the wall condition, see **Fig. 6**.

#### 5. Installing the Door Frame

With sill pan secured, apply a generous, full length, continuous bead of sealant to the rear, upright wall of the sill pan. This bead will make contact with the door frame to create an air seal along the back side of the frame and sill condition. Apply a 3/8" diameter bead of sealant to the top of the sill pan where the exterior edge of the door frame will come in contact. Leave two 1" gaps, approximately 6" from each jamb for drainage, see **Fig. 7**.

With an appropriate sealant, apply a generous bead to the back side of the nailing flange of the frame, see **Fig. 8**. Set the door frame into the rough opening and align installation holes in the sill. Check frame for level, square and plumb and shim where needed. Secure sill with #8 X 1 1/2" Phil. Flat head screws. Square the frame by measuring diagonally across the corners and adjusting the frame until the measurements are equal, see **Fig. 9**. Secure one of the upper jamb corners first with a #8 X 1 1/2" Phil. Flat head screw. Check for level and plumb again. With the remaining installation screws, determine the location of the other fasteners in the head and jambs of the frame. The Vent Panel Bumper will be installed in the center of the fixed jamb with one of the installation screws, see **Fig. 10**. Position shims as close to installation screws as possible. Secure the remainder of the frame. When installing the fasteners to the head portion of the frame, caution should be taken not to over tighten and distort the frame. Leave about a 1/2" space between frame and rough opening for deflection. Once the frame is secure, apply sealant over the screw heads on sill.

#### 6. Installing the Fixed Panel

The fixed panel is installed from the exterior. As per your door order, determine what side of the frame will house the fixed panel, the stationary panel. Hold the fixed panel with the interlock in the center of the door opening facing inward. See exploded view of door for orientation.

Lift the panel up into the center channel in the head of the frame and lower it into the sill's channel, see **Fig. 11**. Trim the excess material from the interlock bug strip so that it fits tightly between the head and sill, see **Fig. 12**. Push the panel into the fixed jamb as far as it will go, see **Fig. 13**.

### 7. Installing the Rolling Panel

Install the rolling panel or vent panel from the interior. With the weather strip side of the rolling panel facing to the outside, stand in the middle of the frame opening and lift the panel into the channel closest to you in the frame's head, see **Fig. 14**. Swing the bottom in and tuck the panel down into the sill channel. If panel does not clear sill, the rollers may be dangling below the bottom edge of the panel. Roller wheels must be tucked into the bottom rail of the panel to clear the sill. To adjust rollers, turn the adjustment screw through the holes at the bottom of both ends of the panel with a Phillips head screwdriver, see **Fig. 15**. Turn counter clockwise to retract the wheels. When panel is installed, make sure rollers are resting on the roller track.

### 8. Door Handle and Latch Keeper Installation

The vent panel is shipped without handles and have to be installed at the job site. In the hardware pack that's included, the large "C" shape handle goes on the interior side of the door. Start by inserting the flat tab on the thumb turn into the hub slot of the mortise lock already installed in the lead stile. Insert the anti knock out plug into the exterior handle, see **Fig. 16**. This plug is used if a lock cylinder is not installed in the handle. Attach both handles to the lead stile with two ring gaskets and two #8-32 X 1 5/8" Phillips oval head screws.

Install the latch keeper to the vent jamb with two #8 X 3 1/2" Phillips pan head screws, see **Fig. 17**. Use shims between frame and rough opening at latch keeper location. The elongated holes on the keeper allows for strike adjustment. Do not tighten screws completely. Close the door and use the thumb turn to extend the strike. Adjust the latch keeper up or down to the proper height for full hook engagement. Tighten screws on the keeper to maintain correct height.

Check the panels for proper spacing in the frame by pushing the vent panel into the vent jamb. Both panels should penetrate their corresponding jambs and the interlock, where the panels meet, should be fully engaged.

Adjust vent panel for operating ease by turning the roller adjustment screws clockwise a couple of turns until panel moves freely. Close the door and check the alignment of the panel with the frame jamb. Both should meet evenly at the head and sill, if not, adjust rollers up or down to align panel.

**Note:** Relieve pressure on roller cam by lifting the panel while turning the adjustment screw.

With the panels properly spaced in the frame, secure the fixed panel by slipping two "L" clips into the interlock at the sill and head of the frame, see **Fig. 18**. Fasten the "L" clip to the interlock and sill with #8 X 3/8" Phillips Truss head screws, see **Fig. 19**. Use the existing hole in the interlock to line up the hole on the clip. Drill a pilot hole in the sill using the hole in the clip. Seal screw heads with sealant. Repeat the procedure at the head section. Now, install the threshold cap into the center channel of the sill along side the fixed panel, see **Fig. 20**. The length may have to be shorten to fit your frame. The cap should slope to the exterior of the door. Also, the threshold cap will have to be notched slightly to accommodate the "L" clip at the interlock. Notch the leg tips off 1 1/2" on the side by the interlock, see **Fig. 21**. When installing the cap, start at the interlock and work down towards the fixed jamb. With an appropriate sealant, seal the fixed panel to the frame from the interior, see **Fig. 22**. Run a perimeter bead along the head, jamb and sill. Seal the joint between the threshold cap, jamb and interlock.

### 9. Screen Door Installation (6800 Roll Form Panel Not Shown)

Hold the screen door with the screen spline to the outside. Lift the panel into the screen channel in the head of the door frame. Roller wheels must ride on track in the head to operate properly, see **Fig. 23**. Swing bottom of screen panel onto sill track. Push bottom rollers up into the frame and guide them onto the sill's screen track. You may need a flat screw driver or putty knife for this. Adjust bottom rollers so screen panel is vertically parallel with door frame. The roller can be adjusted by taking a Phillips screw driver and turning the screws through the holes in the frame, see **Fig. 24**. Turning the screws clockwise will extend the rollers. Don't over tighten, screen door must operate smoothly.

### 10. Screen Door Strike (6800 Screen Door Strike Not Shown)

Install the screen door strike to the vent jamb with one #6 X 1/2" Phillip pan

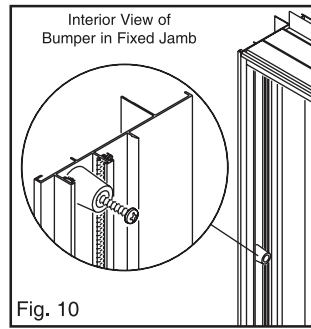


Fig. 10

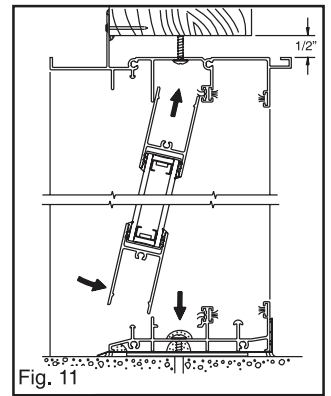


Fig. 11

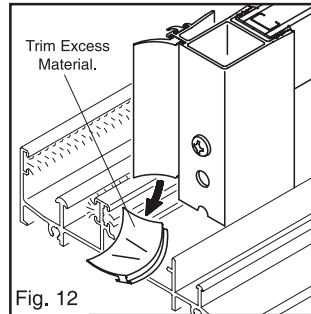


Fig. 12

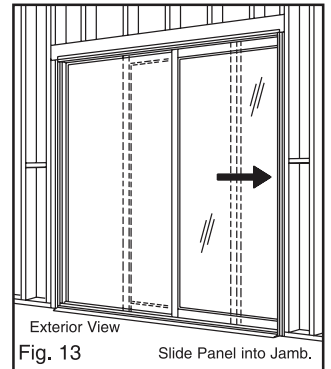


Fig. 13 Slide Panel into Jamb.

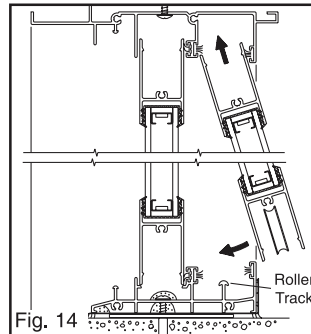


Fig. 14

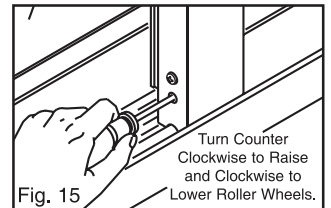


Fig. 15

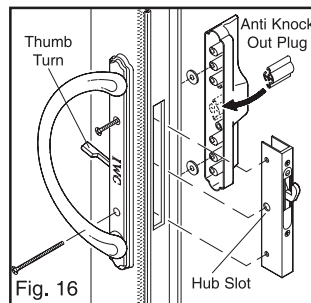


Fig. 16

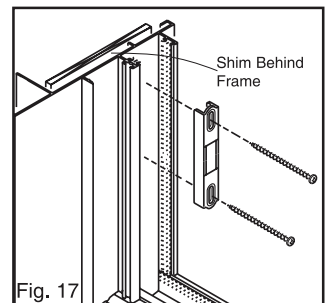


Fig. 17

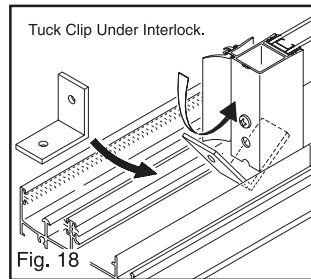


Fig. 18

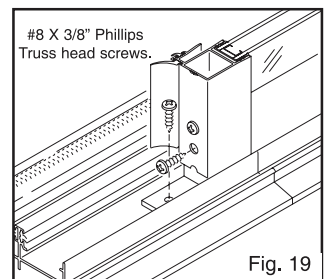


Fig. 19

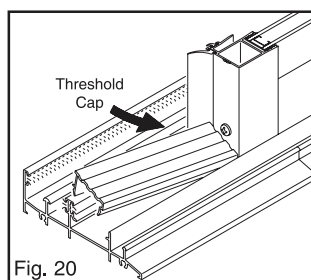


Fig. 20

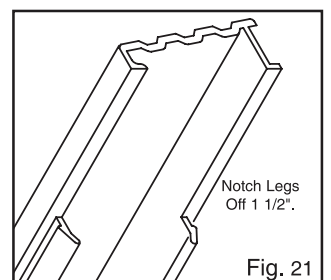
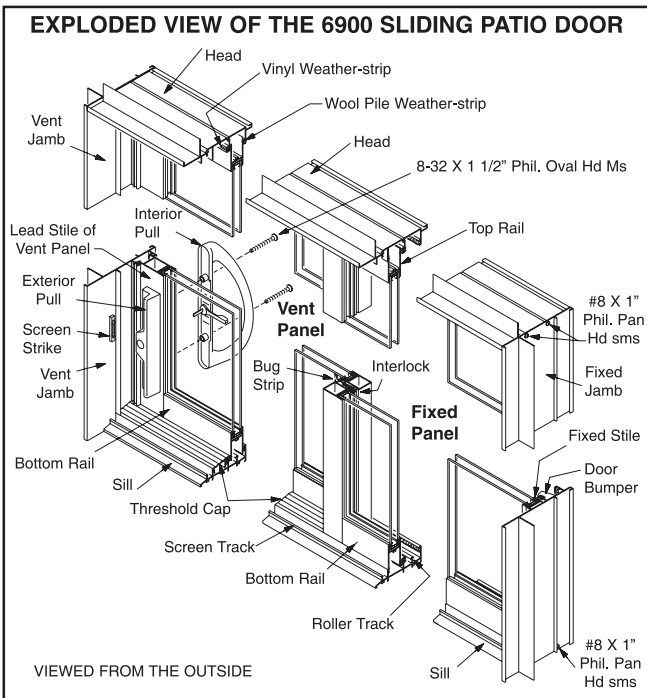
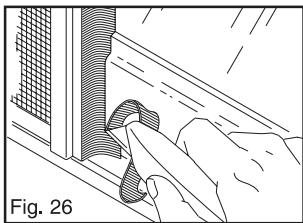
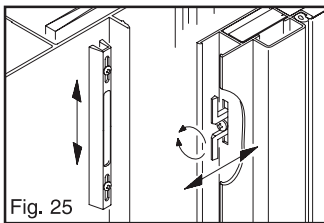
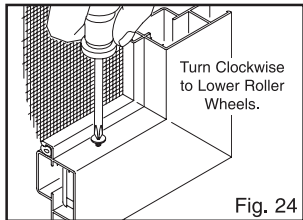
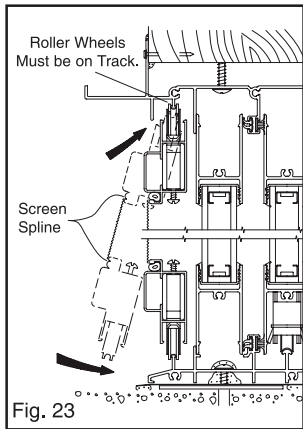
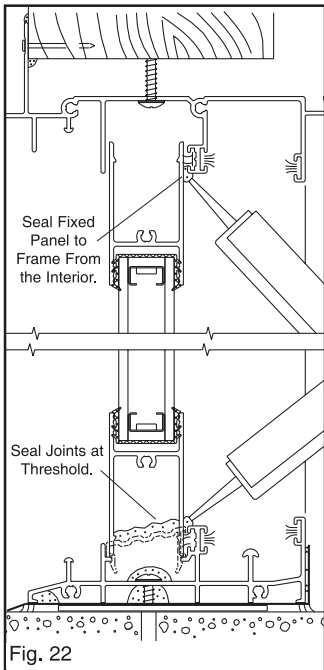


Fig. 21



head Tek screw, see **Fig. 25**. Adjust the strike, up or down, to determine the correct height to engage the screen door latch. Once latch and strike operate smoothly, secure strike with a second Tek screw.

**11. Trimming the Bug Seal**

Trim the Bug Seal vinyl on the screen panel for a better fit. Use a sharp utility knife or razor blade to trim the excess vinyl away from the fixed panel's top and bottom rails only. Follow the contours along the top and bottom rail, see **Fig. 26**. Care should be taken not to scratch any painted surface with the blade.

- Wood trim, plant-ons, and pot shelves all require special precautions. When necessary under these conditions use metal flashing. Use metal flashing on any surfaces where water may not drain promptly.
- Seal all holes in the building paper including those caused by staples or nails.
- Interfaces between our products, flashing and the building's weather resistive barrier must be sealed with a sealant recommended for this application. We cannot recommend a particular type or manufacturer of sealant.
- Muled windows require special treatment. Please consult instructions for your muled conditions.
- Holes drilled for alarms may not be placed on sills or heads and must be sealed.
- Extreme weather conditions may cause water intrusion into your home and subsequent water damage. Consult a licensed engineer for an appropriate rating for expected local weather conditions.
- Do not apply film or tints to the surface of the glass. These products can cause insulated unit failure.
- To avoid the effects of electrolysis and chemical reaction to an aluminum sill, apply bituminous paint to raw masonry or concrete. You may also use a PVC liner to separate the metal frame from the substrate.

**SEMI-ANNUAL MAINTENANCE**

- Improperly maintained products will reduced the performance of any window or door. The sills and weeps must be cleaned regularly to allow for drainage. Water in the sill during a rainstorm is normal.
- Weather-strip should be cleaned and fluffed on a regular basis. Wearing of the wool pile is normal. Wool pile should be replaced if gaps between the weather-strip and frame appear.
- Harsh abrasive cleaners should never be used on frames or glass surface.
- If products are within 10 miles of the coast, metal surfaces should be cleaned with a fresh water rinse every one to three months. Car wax on the surface will provide some protection. Anodized or painted surfaces will help prolong the life and enhance appearance. Clean and lubricate hardware components with corrosion resistant spray or lubricant monthly to ensure proper performance. Silicone lubricant spray can be used on all operable components.

**REMOVAL OF OLD WINDOWS OR DOORS**

Some things to keep in mind when removing old products.

- Follow the EPA's Lead Renovation, Repair and Painting Rule (RRP Rule) which requires that firms performing renovation, repair, and painting projects that disturb lead-based paint in homes, child care facilities and pre-schools built before 1978 have their firm certified by EPA (or an EPA authorized state), use certified renovators who are trained by EPA-approved train providers and follow lead-safe work practices. For more information visit [www.epa.gov/lead](http://www.epa.gov/lead).
- When removing products from a building IWC recommends that you follow local rules and regulations for disposal. Whenever possible, take window and door products or components to reuse or recycling centers and avoid disposing them in the landfill. Consult with your local recycling center for more information on programs in your area.

Installation Instructions: IWC provides installation instructions for common new construction and replacement applications found at [www.intlwindow.com](http://www.intlwindow.com). Some IWC products have specific installation instructions which are also available on the website. For variations of these installation instructions or questions regarding alternative installation practices, call 1.800.477.4032 for more information.

Disclaimer: EPA makes no warranties, expressed or implied, nor assumes any legal liability or responsibility for the accuracy, completeness, or usefulness of the contents of installation instructions, or any portion thereof. Further, EPA cannot be held liable for defects or deficiencies resulting from the proper or improper application of installation instructions.

**PLEASE KEEP THESE INSTRUCTIONS IN YOUR HOME OWNER'S PACKET.**

I have read the above instructions and understand the manufacturer's recommendations.

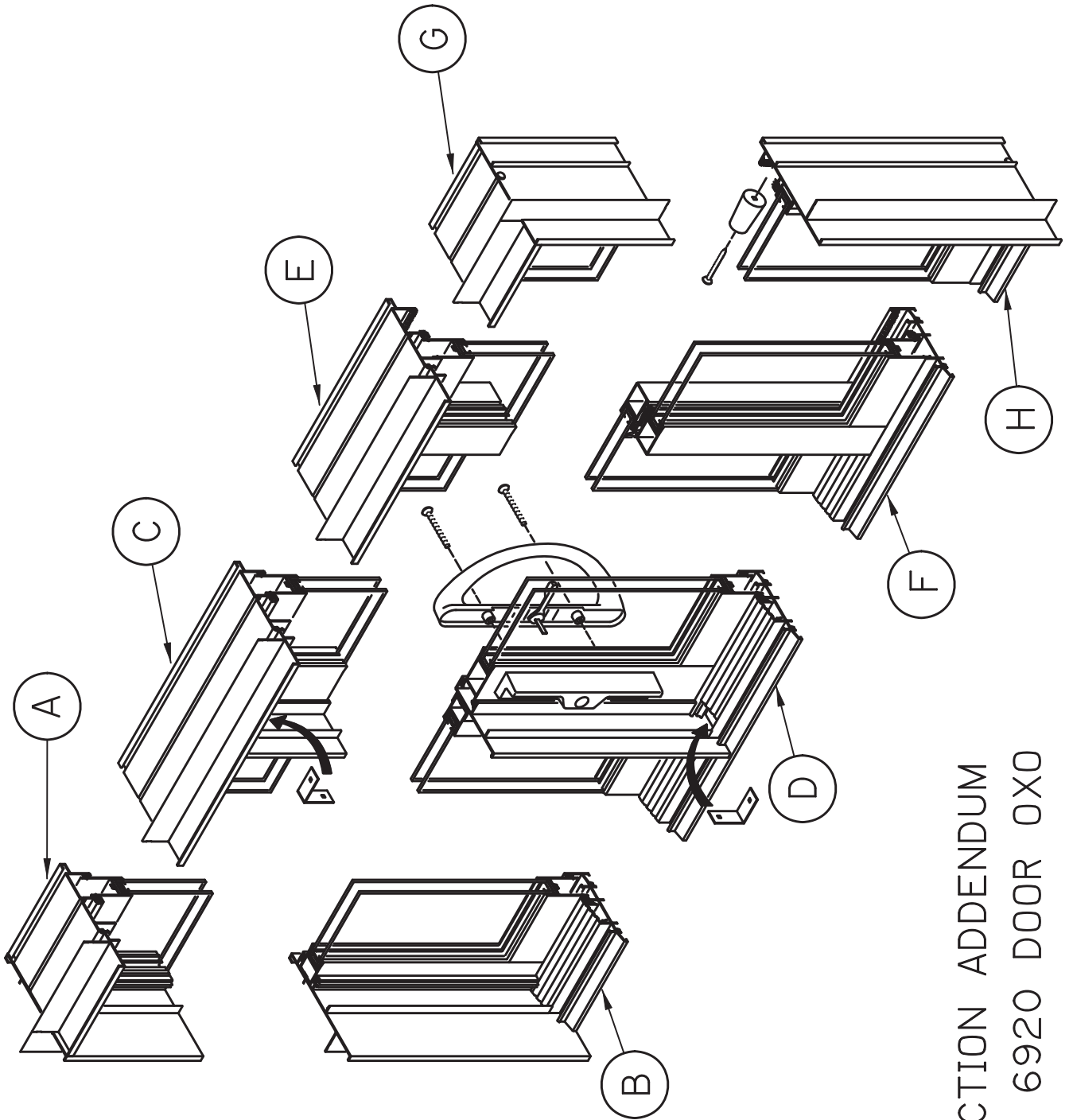
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**Southern California**  
**1.800.477.4032**

Visit our website at [www.intlwindow.com](http://www.intlwindow.com)

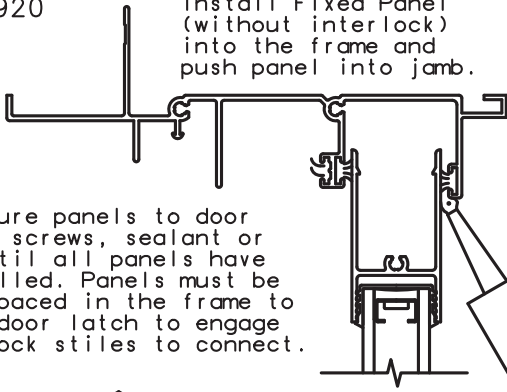




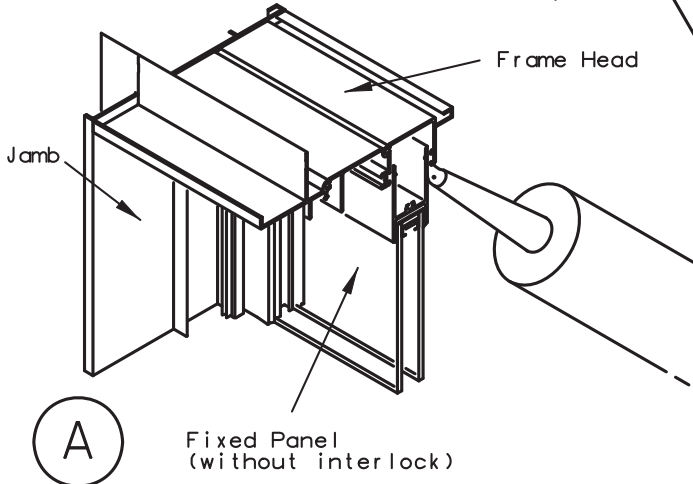
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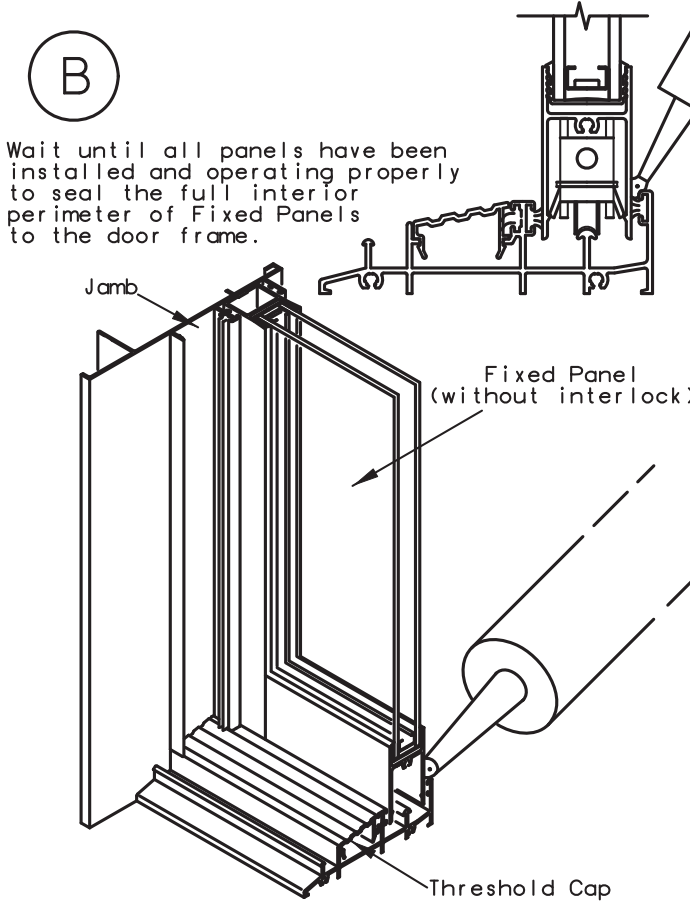
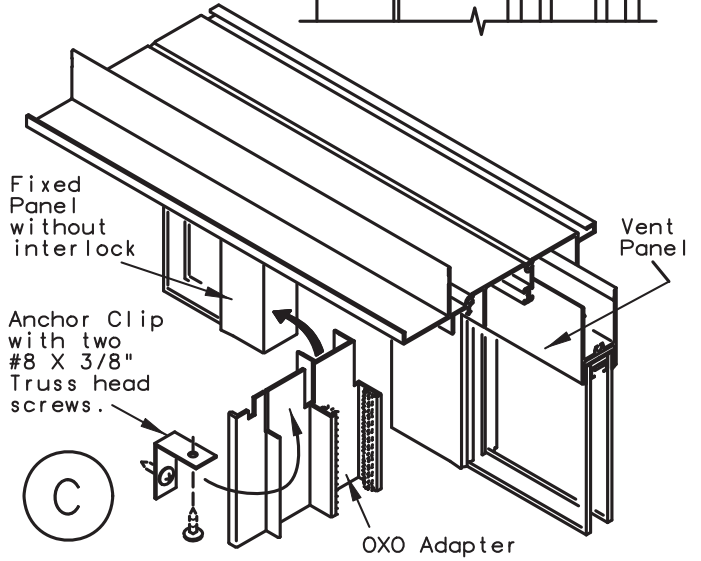
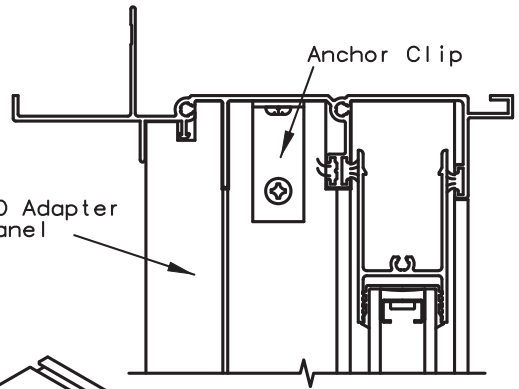
Install Fixed Panel  
(without interlock)  
into the frame and  
push panel into jamb.



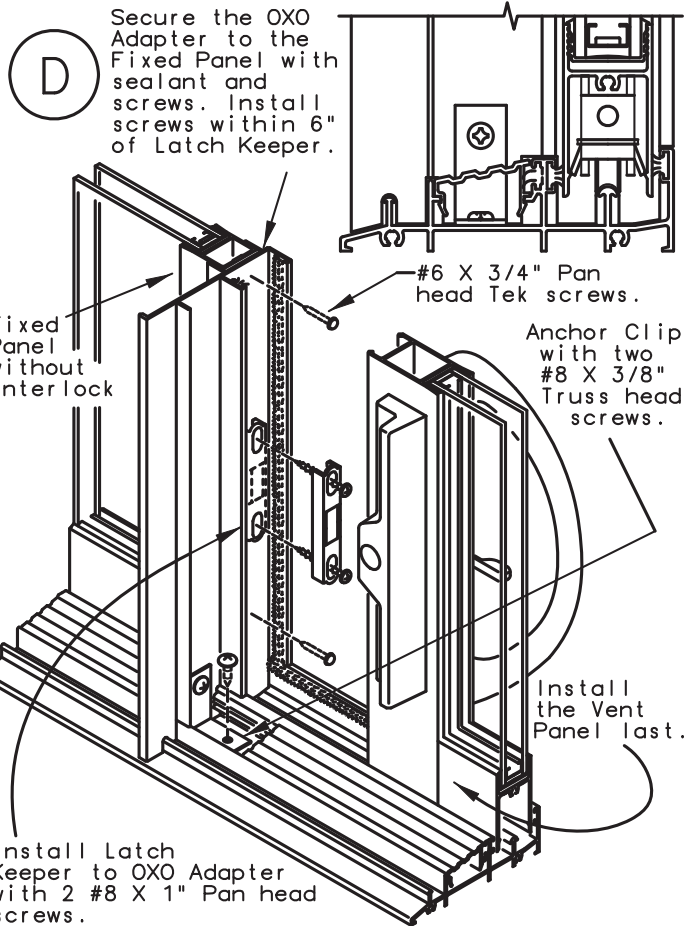
Do not secure panels to door frame with screws, sealant or anchors until all panels have been installed. Panels must be properly spaced in the frame to allow the door latch to engage and interlock stiles to connect.



Install OXO Adapter to Fixed Panel and Frame.

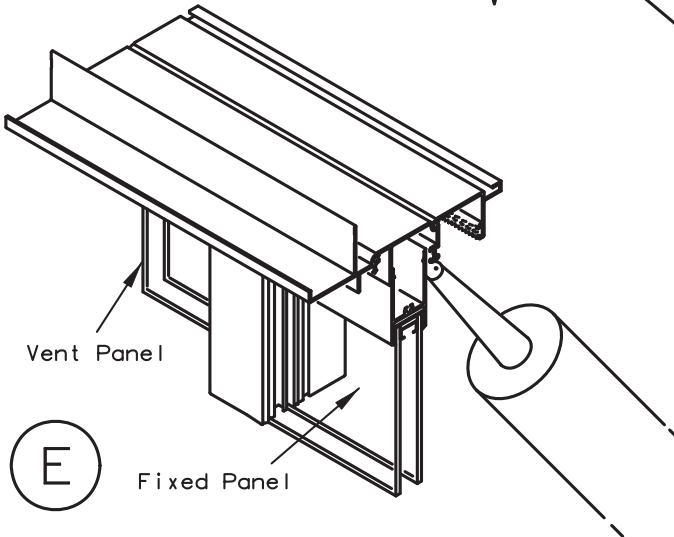


Wait until all panels have been installed and operating properly to seal the full interior perimeter of Fixed Panels to the door frame.

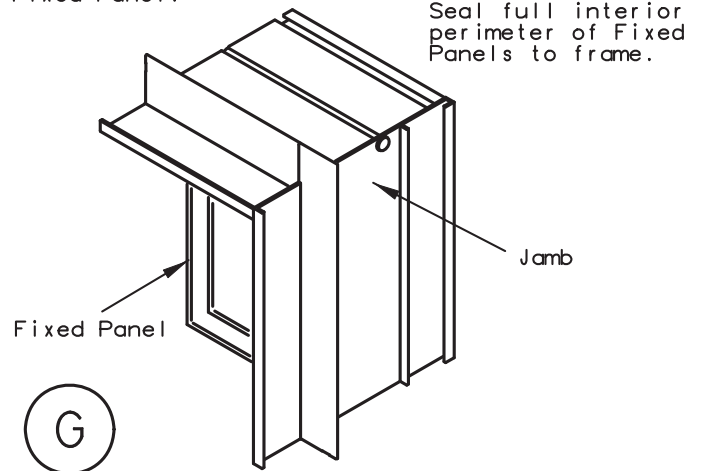


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DOOR OXO

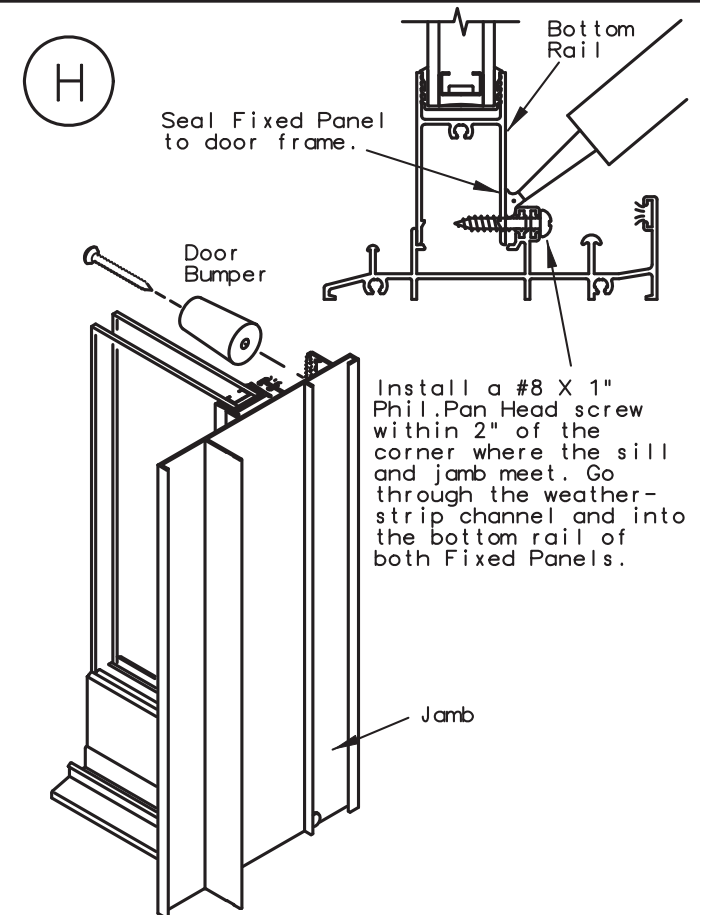
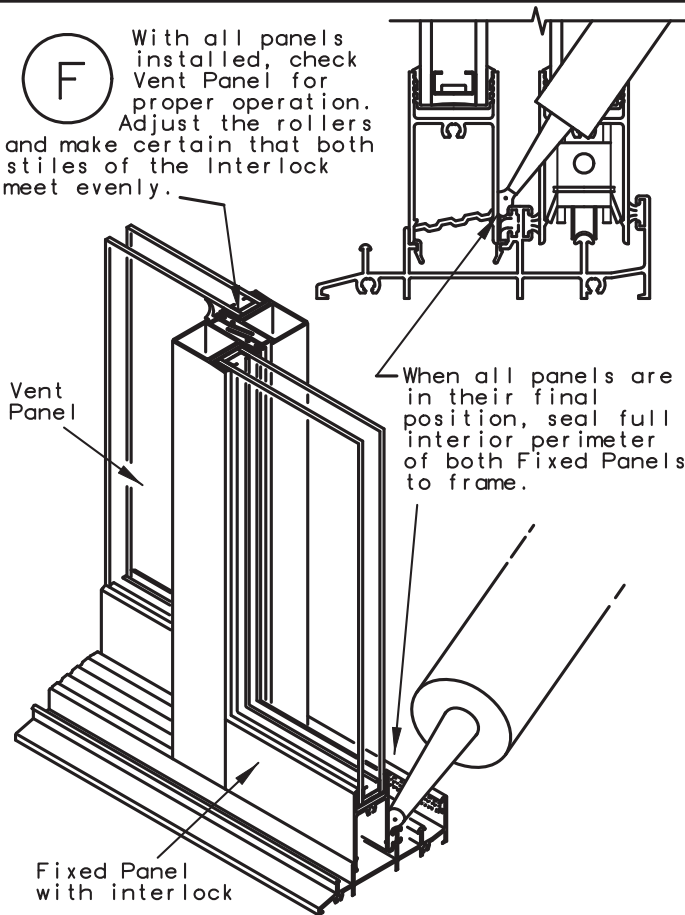
Install 2nd. Fixed Panel (with the interlock) into frame, followed by the Vent Panel.

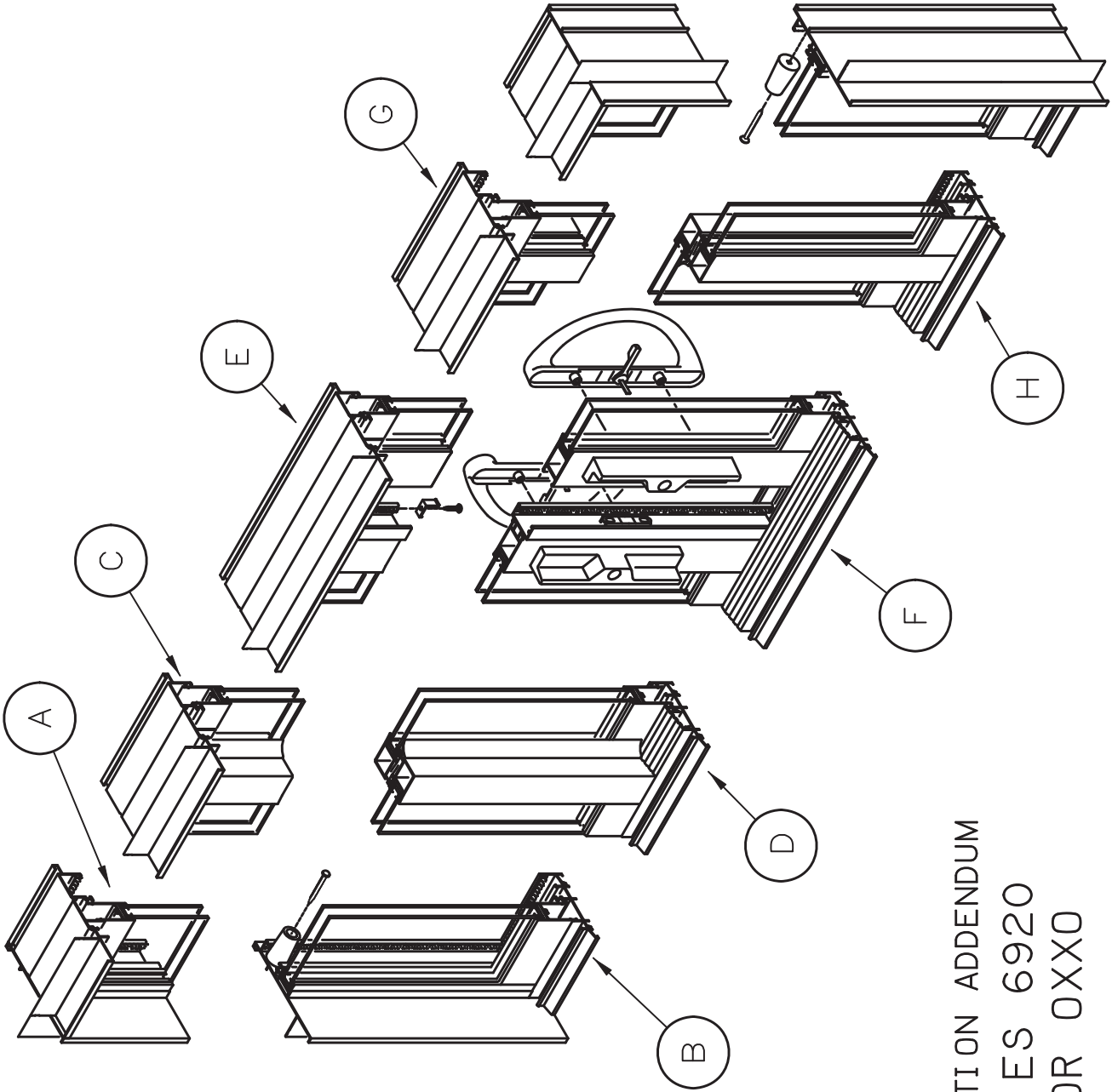


Secure both Fixed Panels to the frame with a #8 X 1" Phil.Pan Head screw. Install screw within 2" of the upper corner, where the head and jamb meet. Go through the weatherstrip channel in the frame and into the top rail of the Fixed Panel.



F With all panels installed, check Vent Panel for proper operation. Adjust the rollers and make certain that both stiles of the Interlock meet evenly.





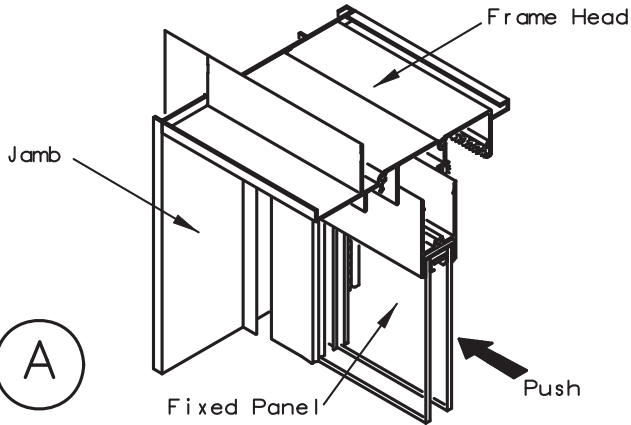
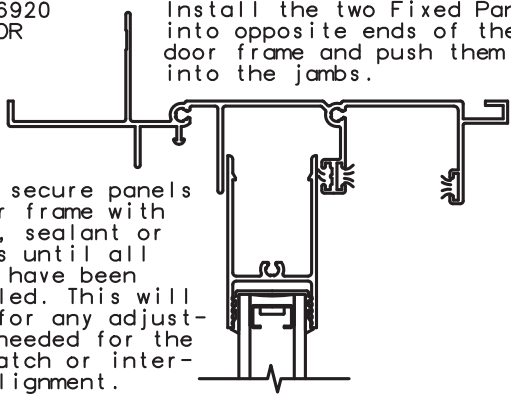
INSTRUCTION ADDENDUM  
SERIES 6920  
DOOR OXX0



SERIES 6920  
OXXO DOOR

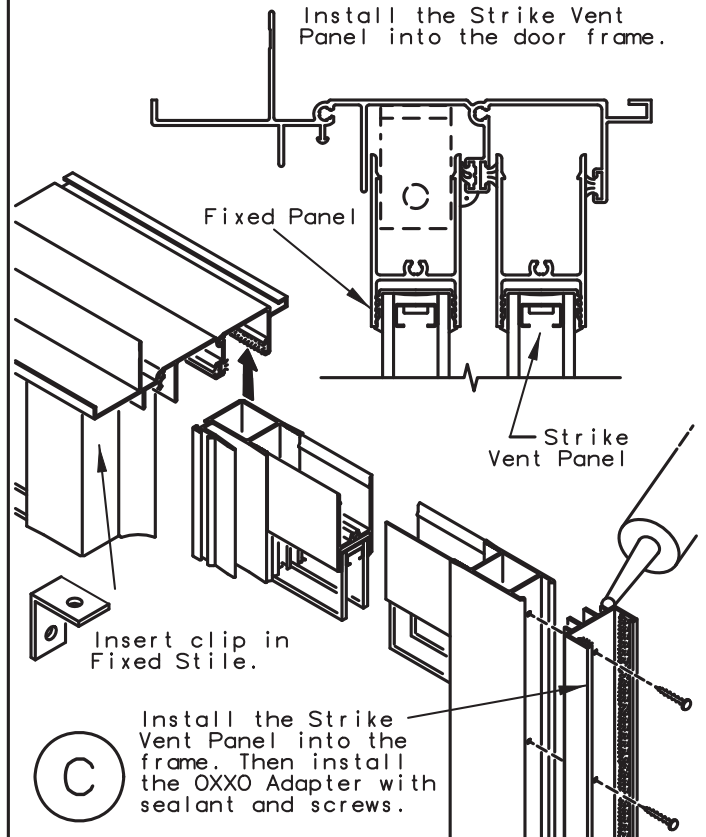
Install the two Fixed Panels into opposite ends of the door frame and push them into the jambs.

Do not secure panels to door frame with screws, sealant or anchors until all panels have been installed. This will allow for any adjustments needed for the door latch or interlock alignment.



(A)

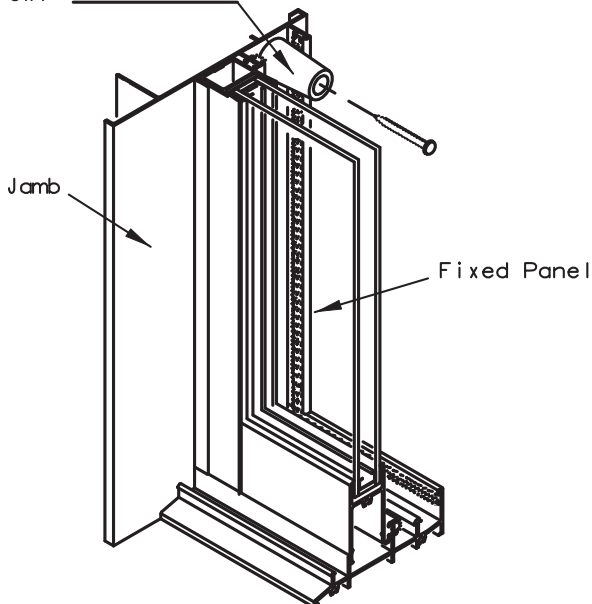
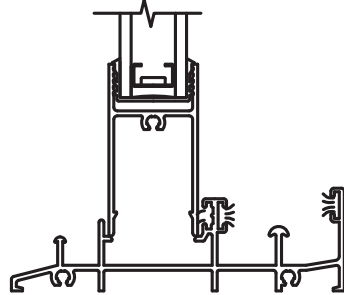
Install the Strike Vent Panel into the door frame.



(C)

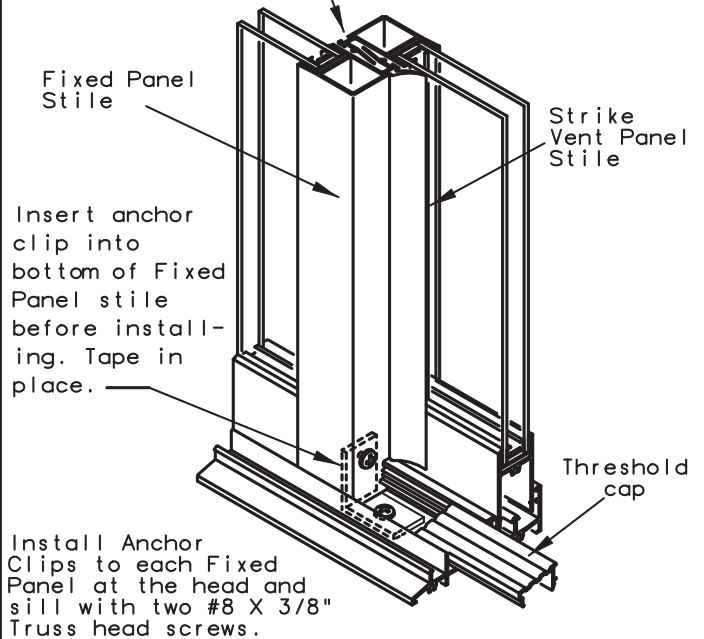
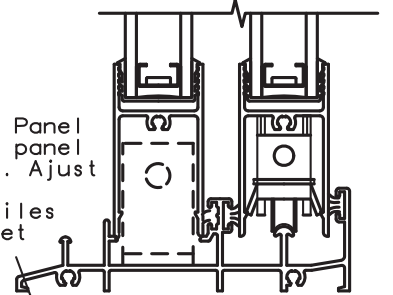
(B)

Attach a Door Bumper to each jamb with a 2" installation screw.



(D)

With the Strike Vent Panel installed, check the panel for proper operation. Adjust the rollers and make certain that both stiles of the Interlocks meet evenly.

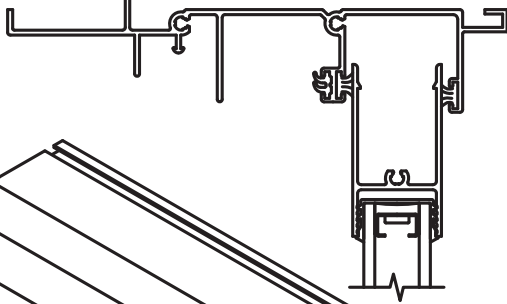


Insert anchor clip into bottom of Fixed Panel stile before installing. Tape in place.

Install Anchor Clips to each Fixed Panel at the head and sill with two #8 X 3/8" Truss head screws.

SERIES 6920  
OXXO DOOR

Install the Locking Vent Panel into the frame.



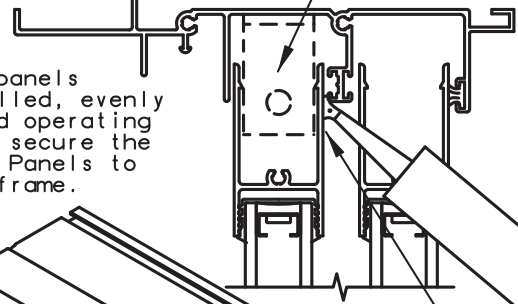
Strike Vent Panel

OXXO Adapter  
reinstalled

(E)

Locking Vent Panel

Install Anchor Clips to Fixed Panels.



With all panels now installed, evenly spaced and operating properly, secure the two Fixed Panels to the door frame.

Seal Fixed panel

Anchor Clip

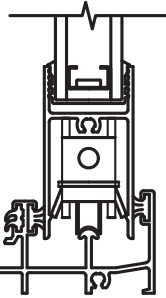
(G)

Fixed Panel Interlock

Anchor clips are attached to the Head and Sill of the Frame and to the Fixed Panel Interlock stiles. Secure Clips with two #8 X 5/8" Pan Hd Tek screws.

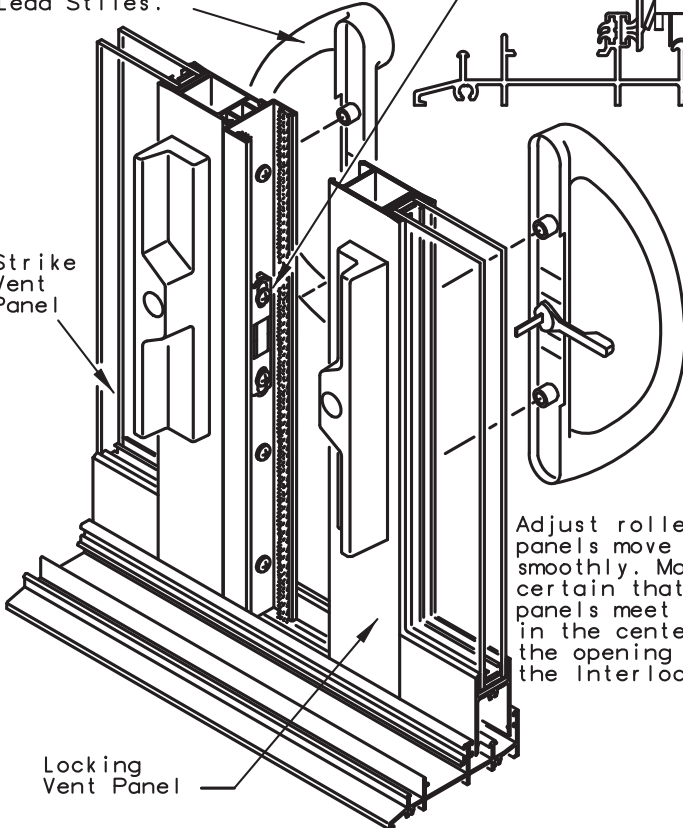
(F)

Install the Latch Keeper onto the OXXO Adapter with two #8 X 1" Pan head screws. Adjust Keeper so that Latch Hook in the door lock fully engages.



Assemble Pulls onto Lead Stiles.

Strike Vent Panel

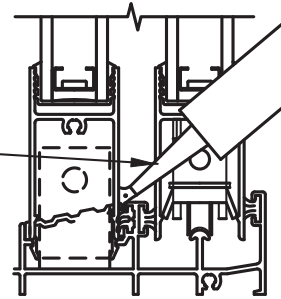


Locking Vent Panel

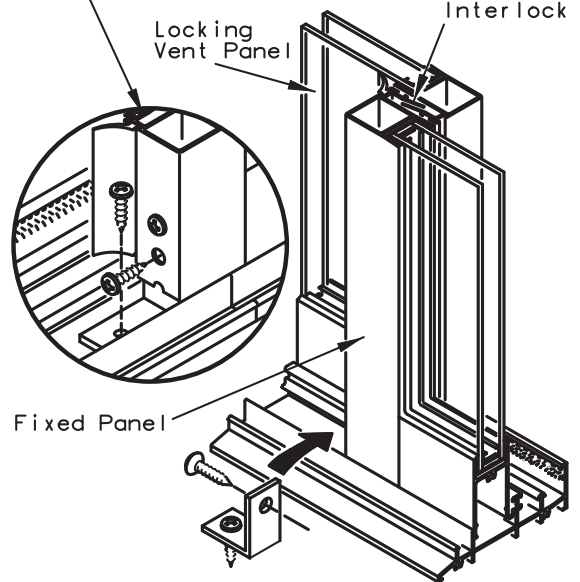
Adjust rollers so panels move smoothly. Make certain that both panels meet evenly in the center of the opening and at the interlocks.

(H)

Seal Fixed panel to frame.



Insert and tape Anchor Clip to bottom of Fixed stile before installing.

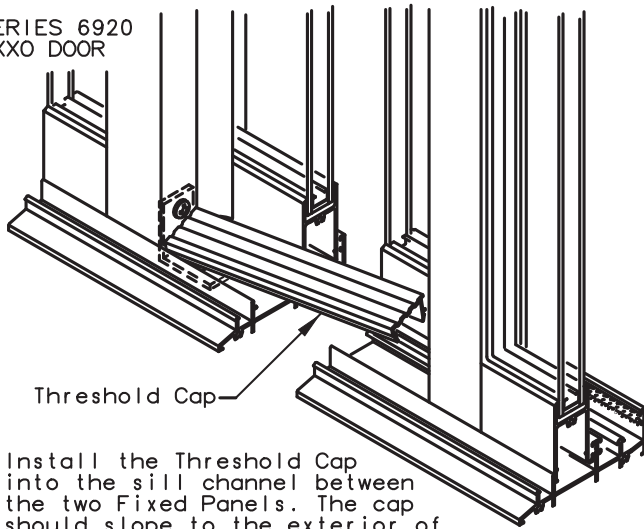


Locking Vent Panel

Interlock

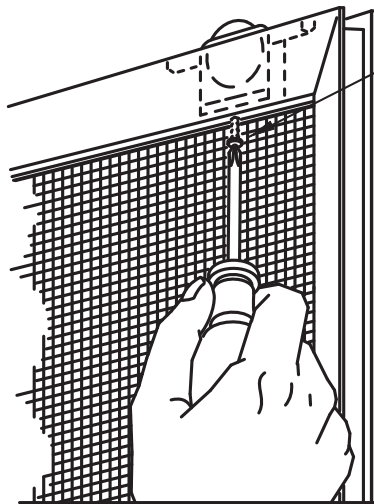
Fixed Panel

SERIES 6920  
OXXO DOOR



Threshold Cap

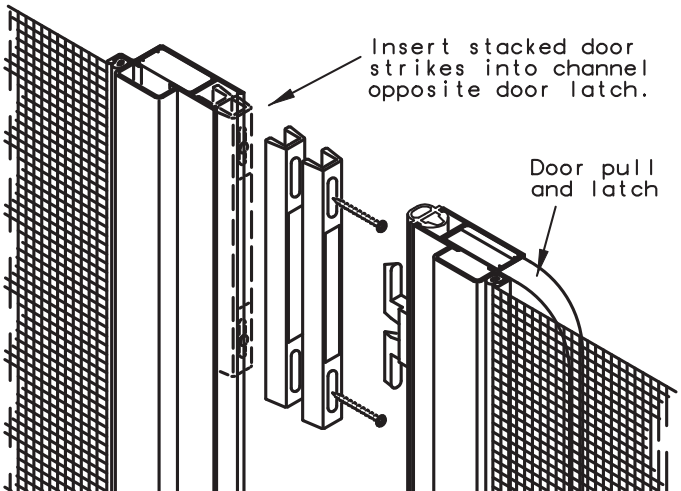
Install the Threshold Cap into the sill channel between the two Fixed Panels. The cap should slope to the exterior of the door. Insert one end of the cap into one corner and work it in across to the other corner. You may want to use a block of wood and a mallet to snap it in place.



Adjustment Screw

Adjust rollers so screen door is vertically parallel with door frame. Don't over tighten rollers, screen door must operate smoothly.

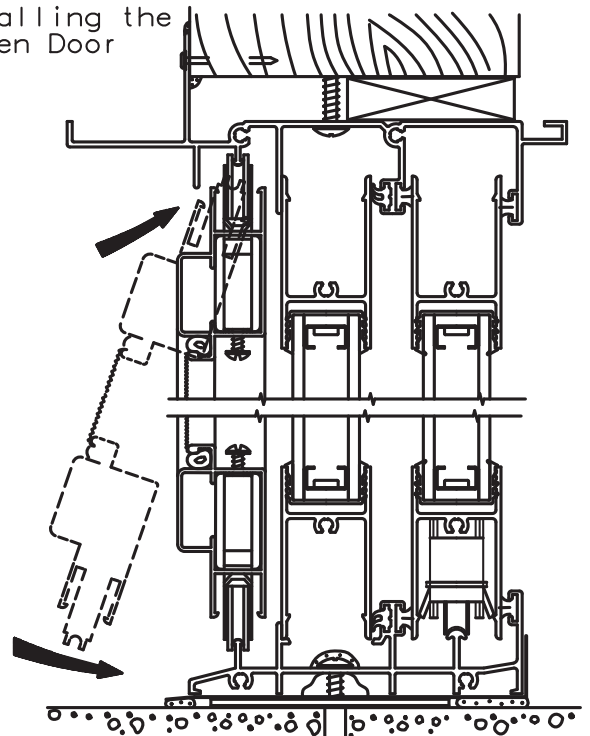
Installing the screen door strike; The screen door frame without the locking handle will be accepting the door strike. Stack the two door strikes on one another as shown and align them with the door latch on the opposite screen frame. Secure the door strikes with two #6 X 1 1/2" Phillips pan head Tek screws.



Insert stacked door strikes into channel opposite door latch.

Door pull and latch

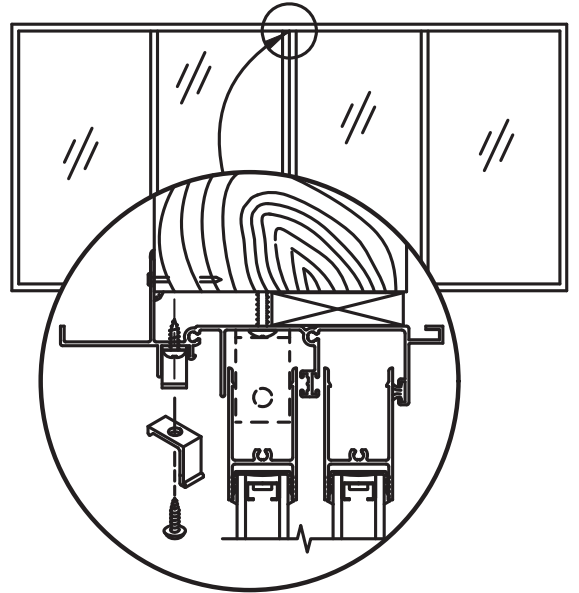
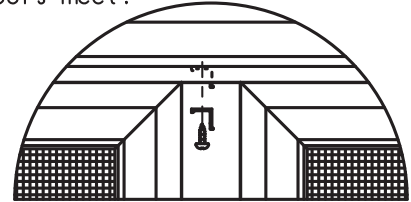
Installing the Screen Door



Lift screen frame up into the head of the door frame. Roller wheels must ride on track in the head to operate properly. Swing bottom of screen frame onto sill track. A flat screw driver or putty knife may be needed to guide wheels over the frame and onto the screen track.

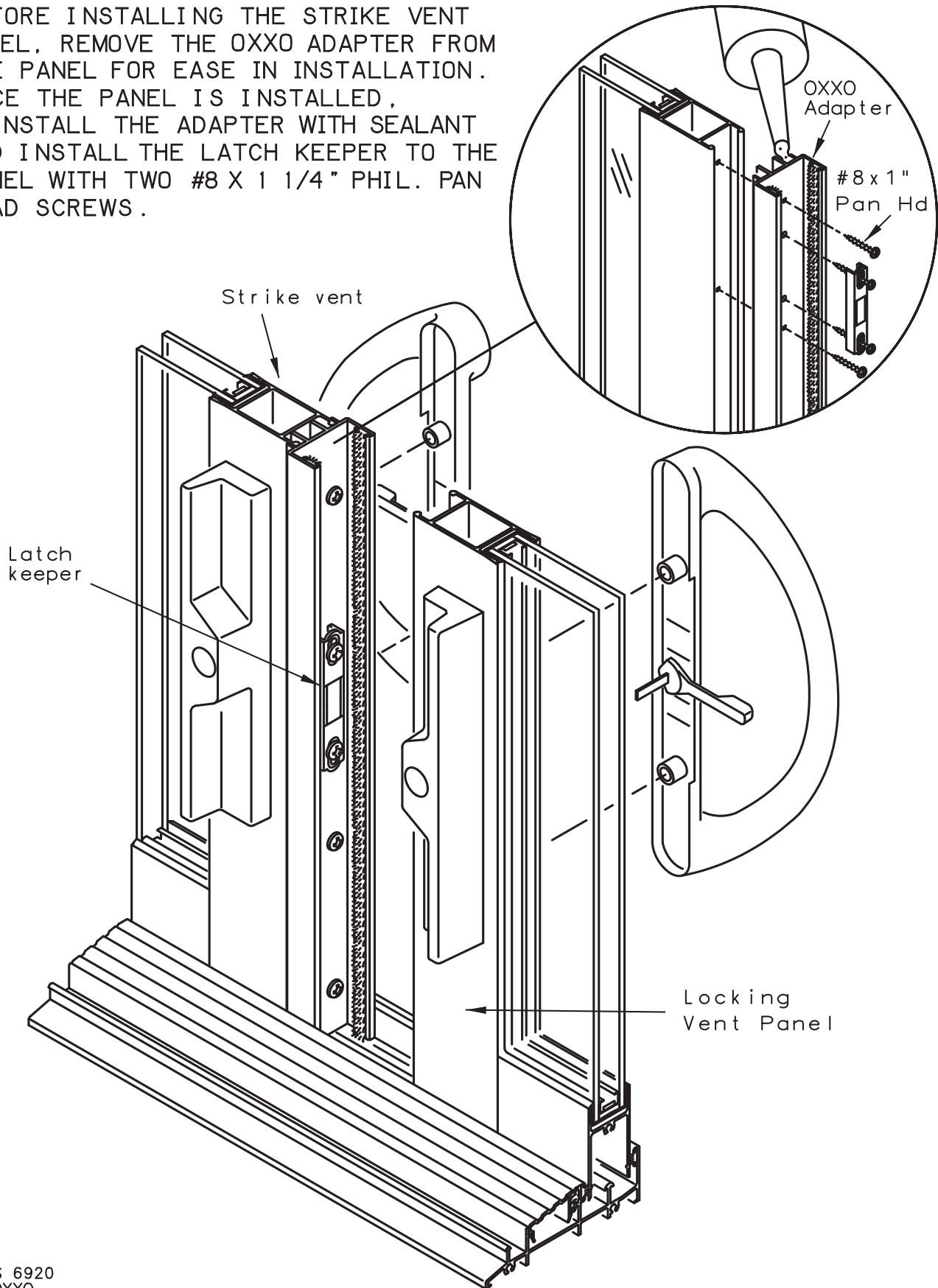
Installing the Double Screen Door Stop.

Install the screen door stop to the frame head in the center of the opening, where the two screen doors meet.



OXXO DOOR CONFIGURATION:

BEFORE INSTALLING THE STRIKE VENT PANEL, REMOVE THE OXXO ADAPTER FROM THE PANEL FOR EASE IN INSTALLATION. ONCE THE PANEL IS INSTALLED, REINSTALL THE ADAPTER WITH SEALANT AND INSTALL THE LATCH KEEPER TO THE PANEL WITH TWO #8 X 1 1/4" PHIL. PAN HEAD SCREWS.



SERIES 6920  
DOOR OXXO