



# A4-LITE 650 PATIO DOOR INSTRUCTIONS FOR ASSEMBLING



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## REQUIRED TOOLS









- 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

## KIT CONTENTS

1. Kit consisting of the four pieces of the frame, meeting rails, fixed panel support (if not installed) and set of hardware.
2. Kit consisting of the operating panel and the screen.
3. Kit for the fixed panel.

## HARDWARE SET

### KIT A2 KD-650 (162618)









Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	166122	1		HEAD FOAM GASKET
②	166129-droi	1		SILL FOAM GASKET
③	161049	2		#8-10 x 1" PAN HEAD QUADREX ZINC FOR HEAD FIXATION (FIXED SASH)
④	161133	1		#8-10 x 2-1/4" PAN WASHER QUADREX ZINC FOR HEAD BLOCK FIXATION
⑤	161144	2		#6 x 1" FLAT GREY HEAD FIXED SASH
⑥	161096	5		#8 x 1 1/2" PAN QUADREX SELF DRILLING FOR "H" CONNECTOR
⑦	161047	2		#8 x 2 1/2" PAN WASHER QUADREX ZINC FOR BUMPER
⑧	166031	2		DUST PLUG INTERLOCK UP

**BAG 6 X 10 (oxxo)**

DESSIN/DWG:

**A2**

### KIT B3 KD-650 (162622)




Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	166205	2		HEAD DUSTPLUG
②	161041	2		#8 x 3/4" TRUSS QUADREX WHITE HEAD FOR HEAD DUST PLUG
③	130280-CW	2		BUMPER
④	162456-CW	4		3/8" BEARING HOLE PLUG
⑤	162264-CW	1		INT. PRESTIGE HANDLE (XO)
⑥	162265-CW	1		INT. PRESTIGE HANDLE (OX)
⑦	161128-CW	4		#10-24 x 2" OVAL HEAD QUADREX BW HEAD PRESTIGE HANDLE ASSEMBLY
⑧	166130-CW	2		SILL CAPPING

**BAG 6 X 10 (oxxo)**

DESSIN/DWG:

**B3**

### KIT C1 KD-650 (162623)




Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	162442-CW	1		BOTTOM CAP (XO)
②	162262-CW	1		EXT. PRESTIGE HANDLE (XO)
③	162444-CW	1		HEAD FIXATION BLOCK

**BAG 6 X 10 (xo)**

DESSIN/DWG:

**C1**

### KIT C2 KD-650 (162624)

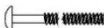

Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	162441-CW	1		BOTTOM CAP (OX)
②	162262-CW	1		EXT. PRESTIGE HANDLE (OX)
③	162444-CW	1		HEAD FIXATION BLOCK

**BAG 6 X 10 (ox)**

DESSIN/DWG:

**C2**

### KIT D1 KD-650 (162625)


Ref.	# PROFILE	QTY	DRAWING	DESCRIPTION
①	161047	24		#8-10 x 2-1/2" PAN WASHER QUADREX ZINC FOR FRAME ASS.
②	166277	4		FOAM FOR JAMB

**BAG 6 X 10**

DESSIN/DWG:

**D1**

### KIT F1 KD-650 (162626)

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

**BAG 3 X 4**

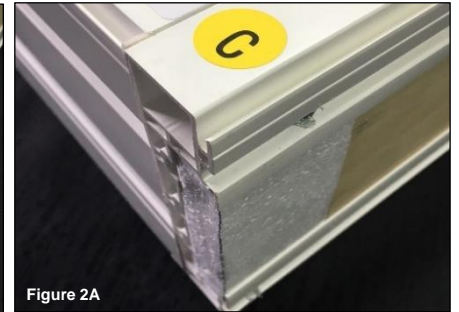
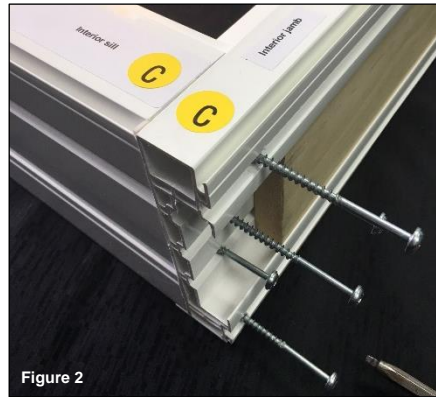
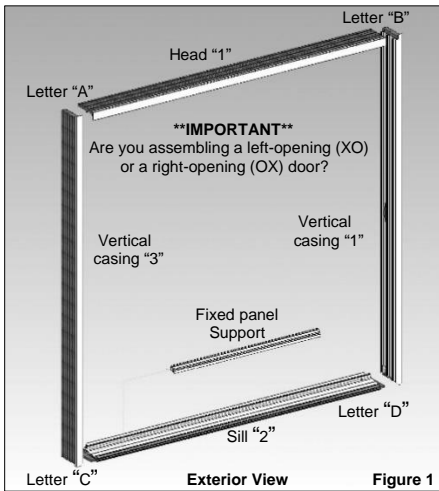
DESSIN/DWG:

**F1**

## STEP 1 FRAME ASSEMBLY

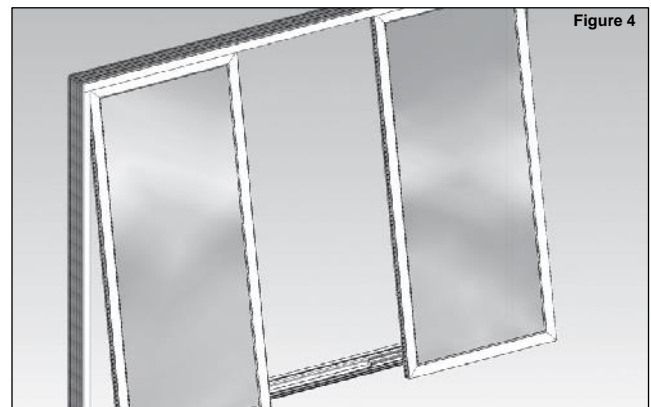
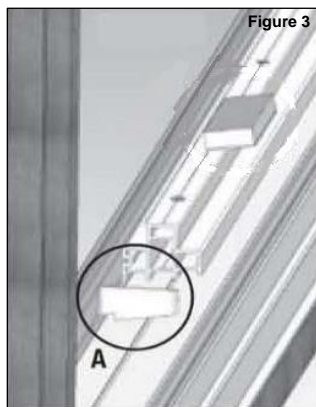
**NOTE:** The frame must be assembled on a flat, clean surface close to the opening made in the wall.

1. Find the PRE-DRILLED frame pieces:
  - 1) Head casing
  - 2) Sill
  - 3) Vertical jamb with wood inserted
  - 4) Vertical jamb with wood insertedSill and head are PRE-SEALED with a foam pad (**Figure 1**).
2. Use the #8-10 x 2 1/2" screws to attach the jambs to the head and sill (6 screws at each corner). Always screw horizontally (**Figure 2**).  
  
When finished, insert the jamb foams as shown (**Figure 2A**).

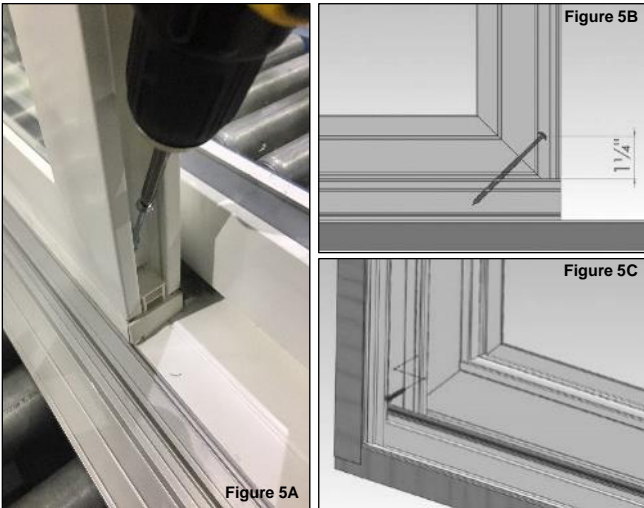


## STEP 2 INSTALLING THE 2 FIXED PANELS (OXXO)

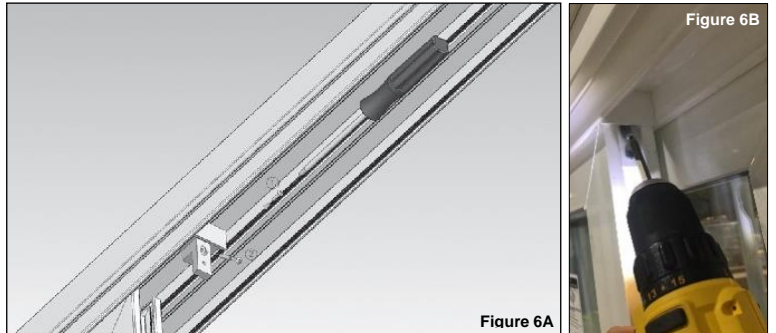
3. Install the fixed support cavity cap (**Figure 3A**).
4. Insert the fixed panels in the frame, making sure that the inside surfaces face the interior. Next, insert the tops and then the bottoms. The identification labels for the fixed panels must be on the inside of the frame (**Figure 4**).



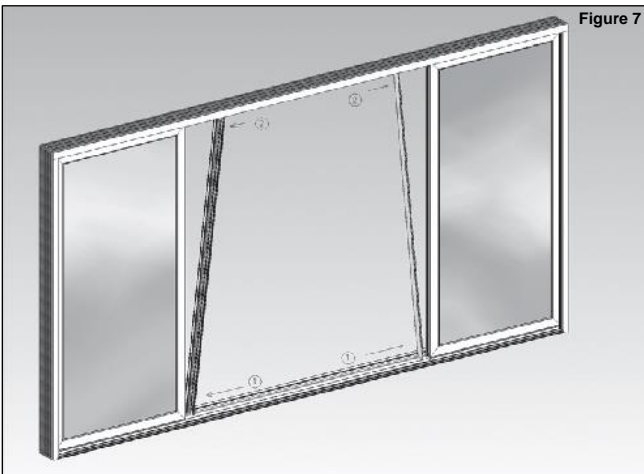
5. Fix the bottoms of the panels using #8-3" screws (Figure 5A – 5B).  
 Fix the panel in place using a #6 - 1" screw.  
 Line the screw up with the height of the glazing stop at the bottom of the panel and in the frame's weatherstrip groove (Figure 5C).



6. Insert the head fixing block 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 - 3" screw. Make sure that the panels are well seated in the bottom of the frame before proceeding (Figure 6A – 6B).



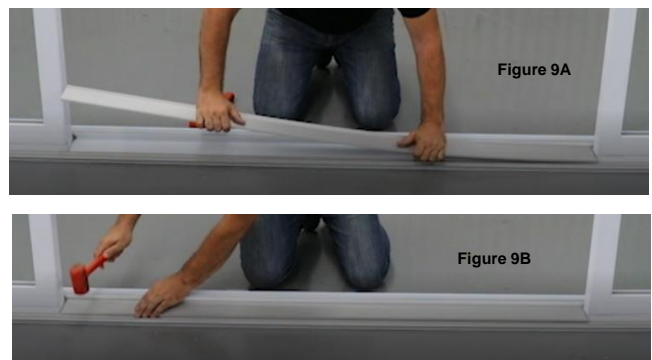
7. Install the fixed meeting rails, starting at the bottom and working upwards (Figure 7- 7A - 7B).



8. Install the dust plug interlock up 3/4 under the meeting rail (Figure 8).



9. Install the threshold (Figure 9A-B).



10. Install the exterior cavity filler Head (Figure 10A-B).



Figure 10A



Figure 10B

### STEP 3 INSTALLING THE OPERATING PANEL (OXXO)

11. Install the HDPE block on the top of the operating panel on the mortise side using #8 - 1 1/4" Truss head screws (Figure 11).
12. 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 (Figure 12).
13. Adjust as necessary and install the finishing "plugs" on the bottom rail (Figure 13).

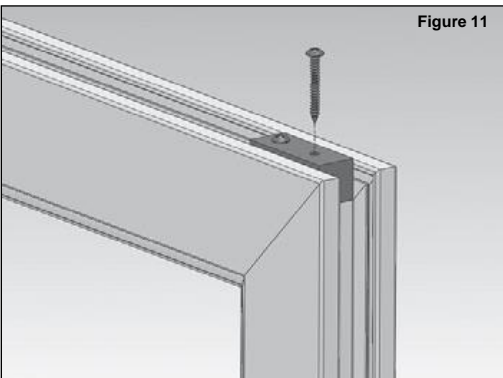


Figure 11

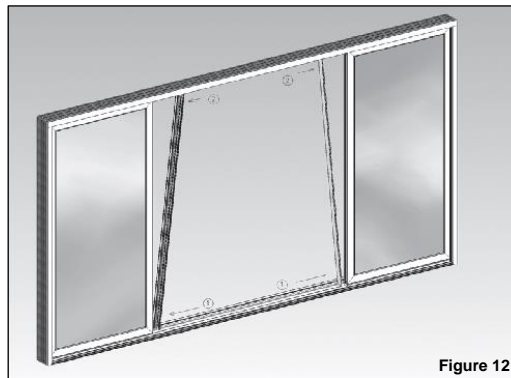


Figure 12

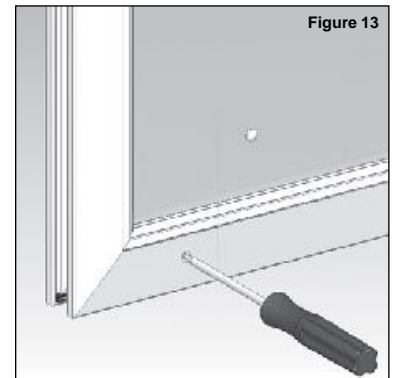


Figure 13

14. 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 (Figure 14A-B).
15. Install the bumper on the fixed panel using a #8 - 2" screw (Figure 15 A).  
Install the interior cavity filer (Figure 15 B).
16. 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 (Figure 16).



Figure 14 A



Figure 14 B



Figure 15 A



Figure 15 B

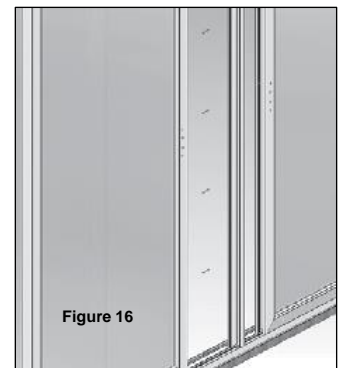
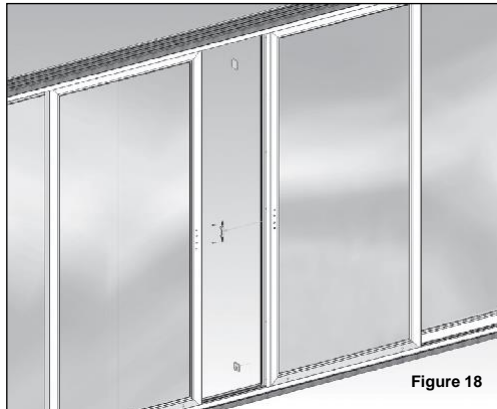


Figure 16

17. 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 - 1" screws (Figure 17).

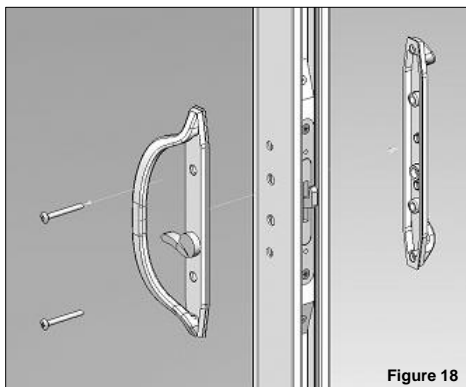


18. Attach the latch to the "H" connector, using a #8 - 1 1/2" screw. Attach the foam seals to the "H" connector, placing the square piece at the head and the piece with the slope at the bottom (Figure 18).



#### STEP 4 HANDLE AND SCREEN ASSEMBLY (OXXO)

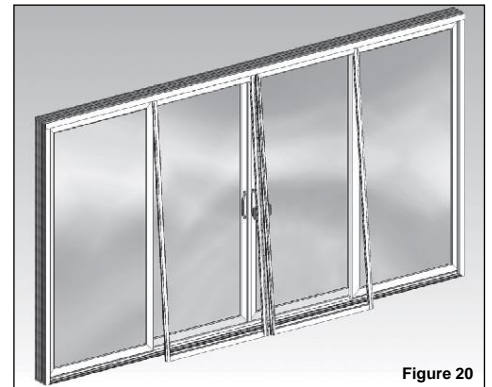
19. **Panel handle**  
Insert the exterior handle into the holes in the panel and insert the interior handle. Make sure that the latch operates properly before tightening the screws (Figure 18).



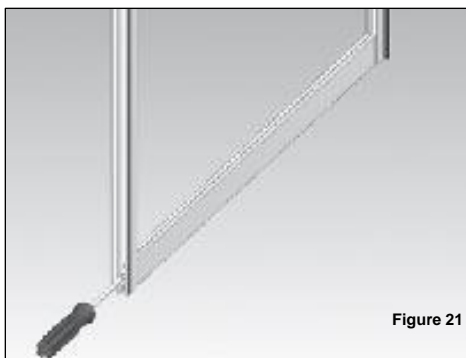
20. **Attaching the latches**  
Repeat the step for the second panel by adding the exterior piece to hold the handle bolt for the semi-opening panel (Figure 19).



21. **Attaching the latches**  
Close the operating panel and check that it operates smoothly. Adjust as needed. Insert the 2 screens in the frame and close to the center of the frame (Figure 20).



22. Adjust height sure that the screens are seated firmly on the stop latch (Figure 21).



22. To install the screen stop, close the semi-opening screen, place the stop in the proper location, mark the spot where the stop will be installed, open the screen and fix the stop in place with 2 x # 6 - 1" flat square zinc screws. Close the 2 screens to see if everything is OK and adjust as needed (Figure 22A-B).



## 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 (**Figure 23**).
2. Insert the foam seals in the frame cavity and slide them towards the stop if everything is OK and adjust as needed (**Figure 24**).
3. Using 2 x #8 - 3/4" white truss head Quadrex screws, fix the 2 foam seals in place  
  
Repeat the operation for the screen stop, using #6 - 1" screws (**Figure 25**).

