Pre-Assembly:

Prior to installation of this sliding patio door system, it is recommended to read the instructions pertaining to the specific configuration of the unit being installed.

Recommended Tool Requirements (Not Supplied by Manufacturer):

1) Rubber Mallet
2) Level (3' or larger)
3) Florida Approved Installation Fasteners
   (See FL Approval for Size & Spacing)
4) Load Bearing Shims
5) Perimeter Sealant

Note: Sealant shall conform to Fed. Spec. TTs-S-00230C Type II Class, ASTM C920 Type S, Grade NS class 25, AAMA 808.3-92 exterior perimeter sealing compoound.

Step 1. (Inspection) Carefully remove all packaging, frame components, and hardware from the patio door frame pack. Verify that all components shown in the parts list on the final pages of these instructions have been accounted for and are in good working condition.
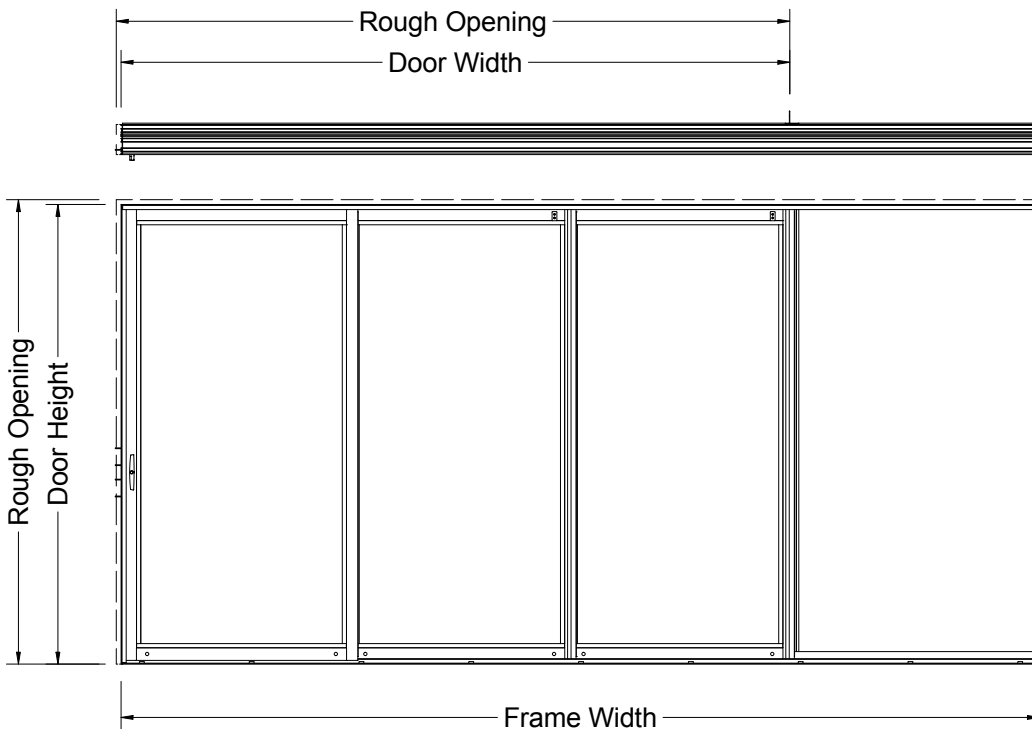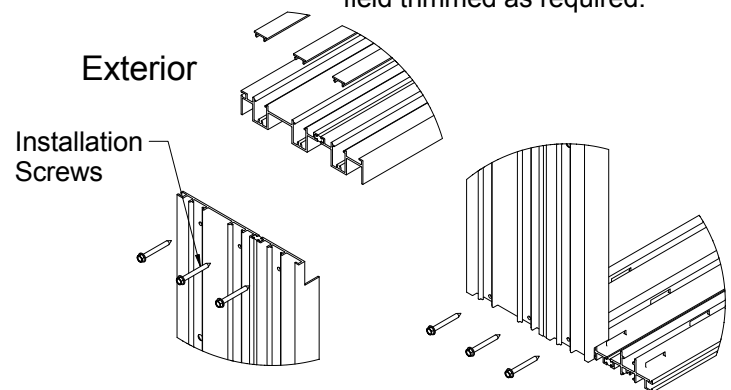

Figure 1.

Step 2. (Preparation) Verify that the rough opening is level, plumb, square, and clear of any obstructions. Also, verify that the unit assembled door size and rough opening coincide with one another. This task can be accomplished by measuring the individual frame components and the rough opening separately. The rough opening width should not exceed the door width by more than 1/4". Similarly, the rough opening height should not exceed the door height by more than 1/4" *(See Figure 1)*.

Note: Measuring the individual components (head / jamb / sill) might be more suitable for larger units. The frame jamb should be equal to the unit height, while the frame head and sill will be 5/16" less than the overall frame width. The frame head and sill can be field trimmed as required.

Frame Assembly (Pocket Door):

Step 3. (Frame Assembly) Gather the frame head sill and jambs required for pocket door installation. Align frame assembly holes of each jamb with the screw bosses on the head and sill profiles. Assemble the door frame using the provided #8 x 1 1/2" Hex Washer Head screws. Complete this process at the head and sill before continuing (*See Figures 2 and 2A*).

Exterior

Installation Screws

Figures 2 and 2A.

Interior

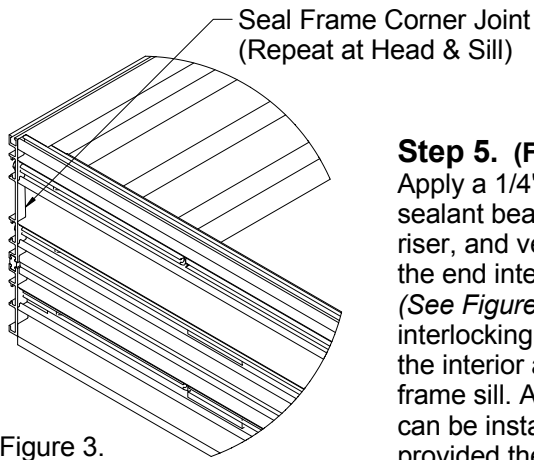(Continued)

Seal Frame Corner Joint (Repeat at Head & Sill)

Figure 3.

Step 4. (Frame Assembly Cont.) Apply a generous bead of sealant along the frame sill to frame jamb joints on the bottom side of the frame assembly. Repeat this procedure at all four corner joints of the pocket door assembly before proceeding to the next step *(See Figure 3)*.

Step 5. (Frame Assembly Cont.) Apply a 1/4" diameter horizontal sealant bead full length of the sill riser, and vertical sealant bead at the end intersecting the frame jamb *(See Figures 4 and 4A)*. Insert the interlocking end of the sill riser into the interior accessory grove on the frame sill. Alternatively, the sill riser can be installed after the door frame provided there is a minimum of 1/2" clearance between the door frame and foundation.

Sealant Bead

Sill Riser Interlock

Accessory Grove

A

Figures 4 and 4A.
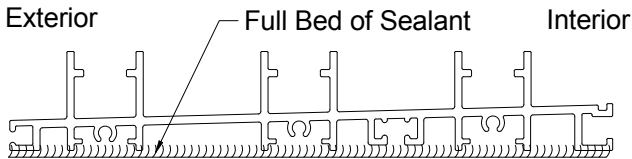
Exterior   Full Bed of Sealant   Interior
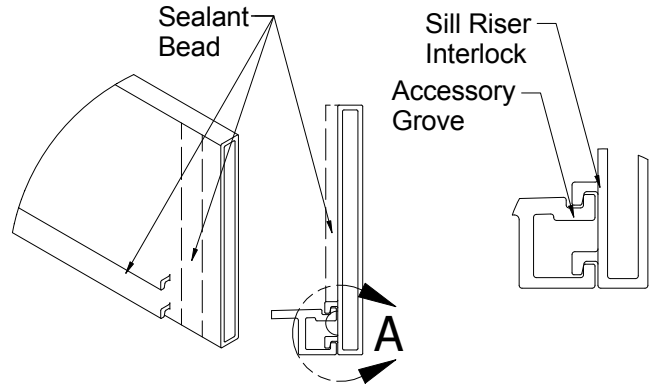
Figure 5.

Installation (Pocket Door):

Step 6. (Installation) Place assembled frame unit in bed of sealant full length of the frame sill *(See Figure 5)*. If the installer chooses to install the sill riser after the frame has been placed in the rough opening, ensure that sufficient room is available.

Step 7. (Shimming) Once the frame has been placed in the rough opening, verify that the frame is plumb and square. Shim underneath all installation fasteners at the frame head and frame jamb. During the shimming process, continually check that the frame is plumb and square.

Step 8. (Fastening) Attach the door frame to the opening through the pre-punched installation holes at the head, jamb, and sill. Fill each installation hole with sealant prior to fastener insertion. Once all fasteners have been installed, seal all screw heads applied through the frame sill.
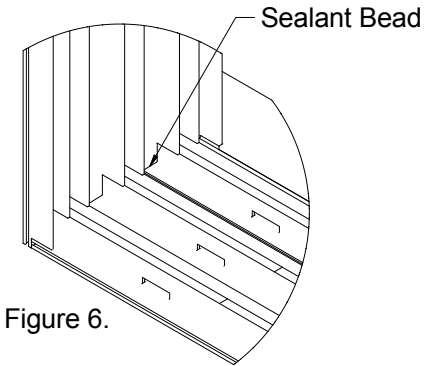
Note: See Florida Approval for the correct fastener type, quantity and minimum embedment of the applicable construction.

Sealant Bead

Figure 6.

Step 9. (Frame Corner Sealant) Once all installation screws have been properly installed, apply a bead of sealant and tool at the frame sill to frame jamb joint *(See Figure 6)*.
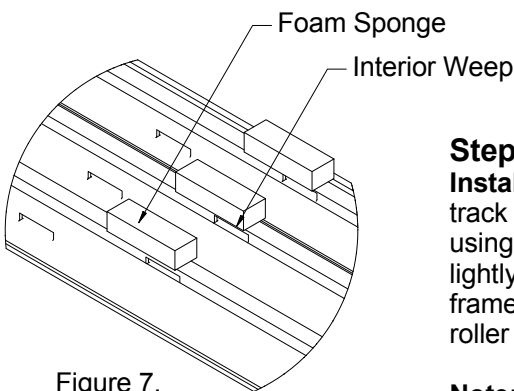
Foam Sponge

Interior Weep

Figure 7.

Step 10. (Foam Sponge Installation) Compress and insert the reticulated foam sponge provided in the frame hardware pack. Placement of the sponge should fully cover the interior weep of the frame sill. Complete this process at each weep location for all roller track cavities *(See Figure 7)*.

Step 11. (Roller Track Installation) Install the roller track as shown in Figure 8, using a rubber mallet and lightly hammering. The door frame pack will come with one roller track per panel.

Note: The roller track may need to be field trimmed to flush up with the end of the frame sill
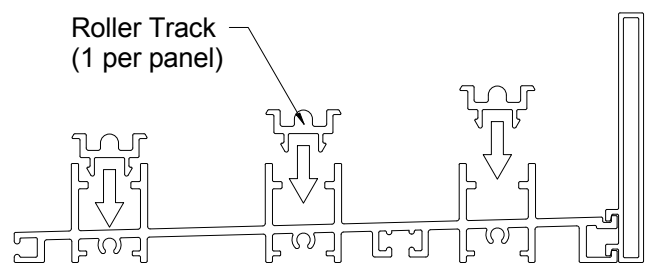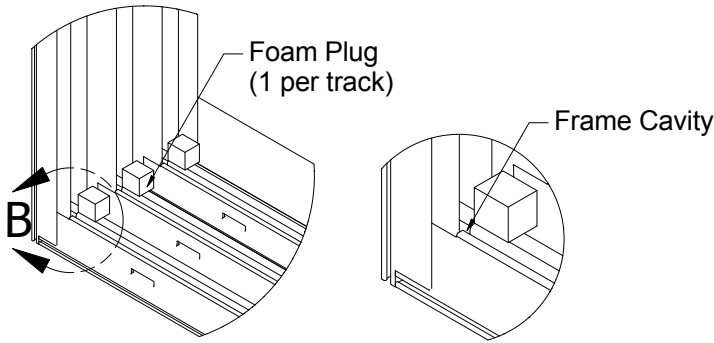
Roller Track (1 per panel)

Figure 8.

(Continued)

Foam Plug
(1 per track)

Frame Cavity

B

Figures 9 and 9A.

Step 13. (Weather Stripping Installation) Place the 0.180" x 0.500" x 3" long adhesive back weather stripping at the lower most edge of the panel and apply to the interlock of the interior panel ONLY *(See Figure 10)*. Once the sill riser is in place, the weather stripping can be trimmed to the appropriate length.
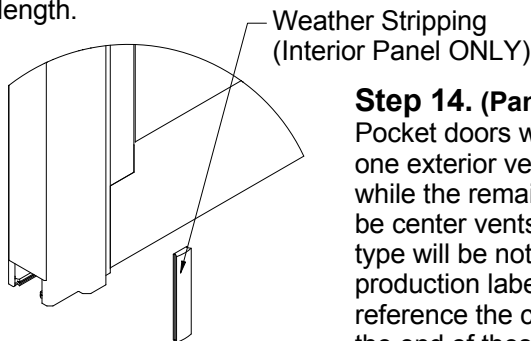
Weather Stripping
(Interior Panel ONLY)

Figure 10.

Step 14. (Panel Installation) Pocket doors will be supplied with one exterior vent (XRE / XLE), while the remaining vents will all be center vents (XC). The vent type will be noted on the production label, or you can reference the configurations at the end of these instructions. Insert the innermost center vent by slipping the panel head rail over the accompanying frame head track and rotating the bottom of the panel inward. Once the panel is vertical, lower the panel and ensure that the rollers are properly seated on the roller track. Each panel should be installed with the roller adjustment holes facing the exterior.

Step 16. (Panel Adjustment) Adjust the panels by using a phillips head screw driver and turning clockwise (raise panel) or counter clockwise (lower panel). Adjust all door panels until all sight lines are even and the panels operate freely. **DO NOT** use a drill or impact driver to adjust the rollers, as this may cause damage to the roller.

Note: Due to the weight of the panels, it is recommended to lift the panel corner being adjusted to prevent damage to the roller adjustment screw.
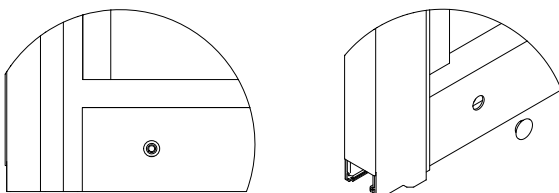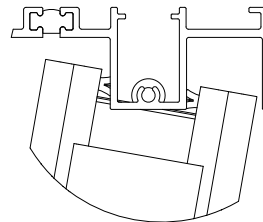
Figures 11 and 11A.

Step 12. (Foam Plug Installation) Remove the liner of the adhesive back dust plug provided in the hardware frame pack. Insert the plug into the cavity between the roller track and frame jambs *(See Figures 9 and 9A)*.

Note: There will be one dust plug provided for each roller track / frame jamb cavity.
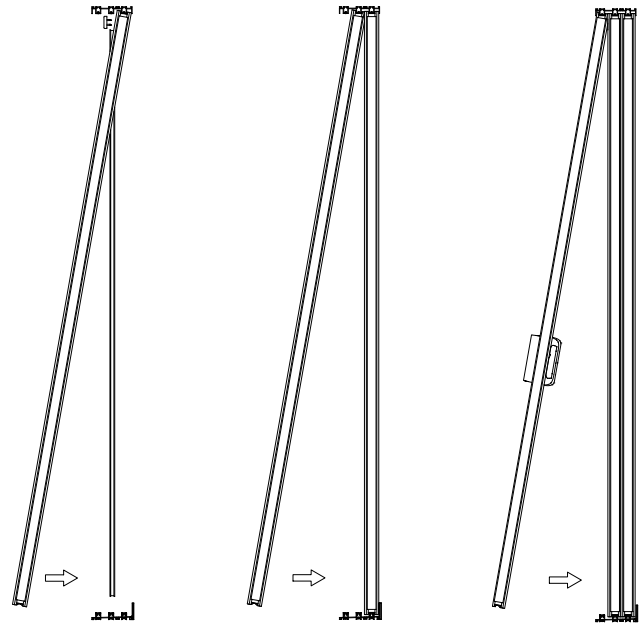
Panel Installation (2 and 4 Panel Doors Similar)

Step 15. (Panel Installation Cont.) Repeat Step 14 for each of the remaining door panels.

Note: The exterior panel will have a single interlock and should be the last panel installed.

Step 17. (Hole Plug Installation) Cover the roller adjustment holes with the supplied 1/2" hole plug *(See Figure 11 and 11A)*.
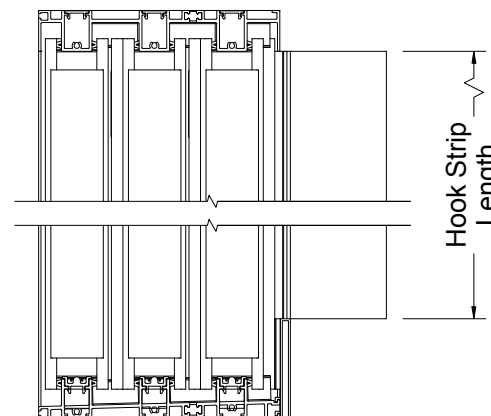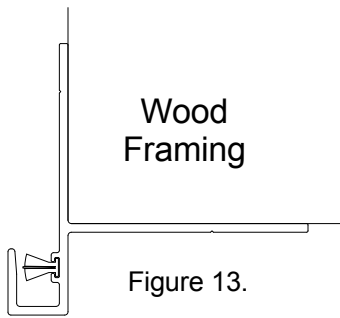
Step 18. (Hook Strip Installation) Measure the distance from the top of the sill riser to the bottom edge of the frame head. This measurement will be the required length of the pocket hook strip *(See Figure 12)*.

Hook Strip Length

Figure 12.

(Continued)

Wood Framing

Figure 13.

Step 19. (Hook Strip Installation Cont.) Apply sealant under each leg of the hook strip and install using approved installation fasteners. Placement should be less no greater than 6" from each end and a maximum of 20" O.C. *(See Figure 13)* Screws on opposite sides of the hook strip should be staggered, so that there will be no interference with opposing screws.

Step 20. (Dust Plug Installation) Place the fin seal dust plug directly underneath each interlock at the head and sill ends *(See Figure 14)*. Trim two dust plugs so that they fit between the innermost roller track and the sill riser. These dust plugs will be placed directly above and below the center panel / hook strip interlock.
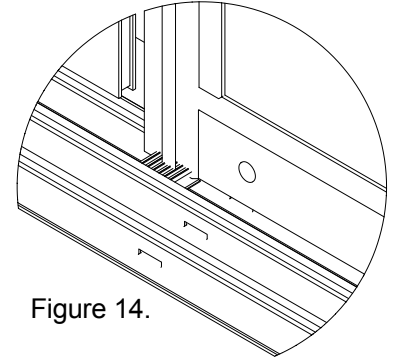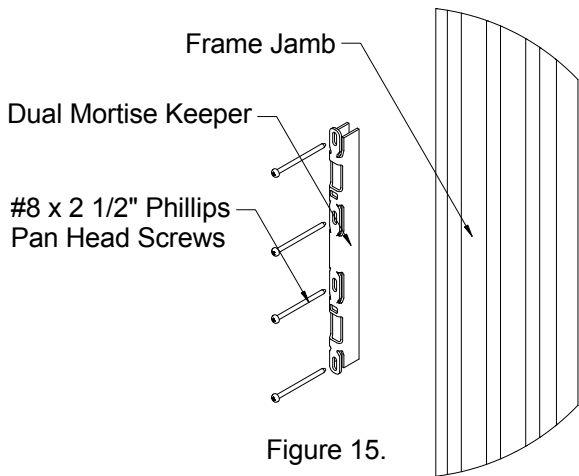
Figure 14.

Frame Jamb

Dual Mortise Keeper

#8 x 2 1/2" Phillips Pan Head Screws

Figure 15.

Hardware Installation

Step 21. (Keeper Installation) To complete the frame installation, use the supplied #8 x 2 1/2" stainless steel phillips pan head screws to install the dual mortise keeper *(See Figure 15)*. There will be dimples in the frame jamb to help locate the keeper.

Note: Each jamb cavity will contain dimples, but the keeper should only be installed with the adjoining locking panel.

Exterior Handle Pull

Thumb Latch
Interior Handle Pull
Installation Screw

Step 22. (Handle Installation) The handle kits will be packaged together, and will be supplied in the frame hardware pack. Insert the tail of the thumb latch into to accompanying slot on the mortise. Secure the interior and exterior frame using the oval head fasteners supplied in the handle set *(See Figure 16)*.

Note: Be sure the handle is securely fastened, but be aware not to overtighten the assembly screws. Also, the mortise will not activate unless the safety pin is engaged.

Engagement Pin

Figure 16.

Panel Block

¾   4
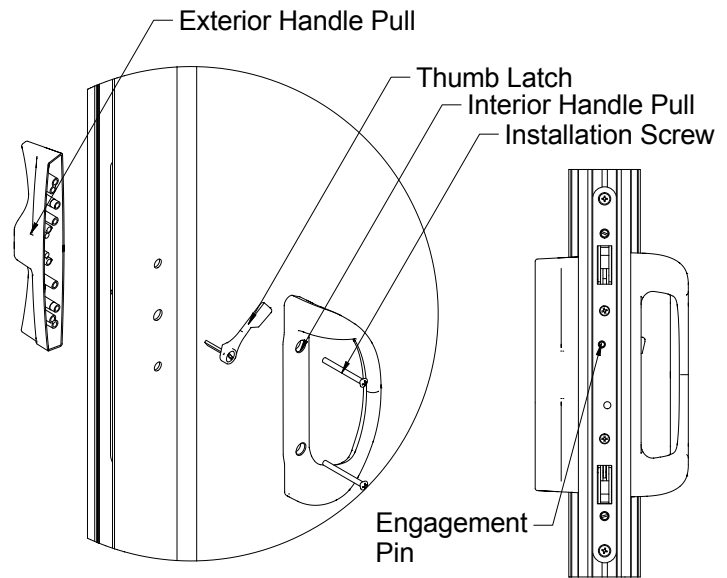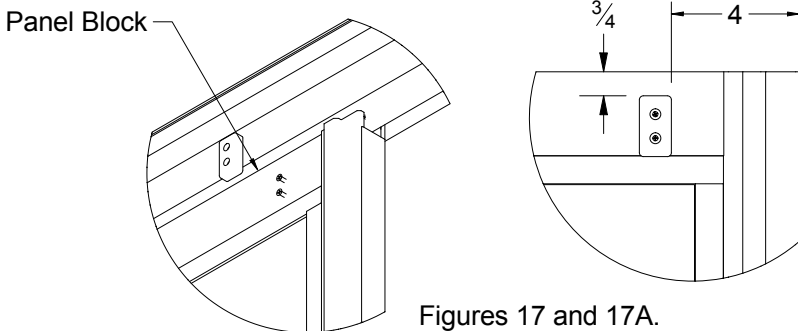
Figures 17 and 17A.

Step 23. (Panel Bumper Block Installation) Apply the supplied panel bumper block in the upper corner of all interior panels. Placement should be 4" from the end of the panel and 3/4" from the top of the panel. The panel blocks will be fastened using the provided #8 x 1" phillips flat head screws *(See Figure 17 and 17A)*.

Note: Panel blocks will be installed on all interior panels and will be used to prevent clashing of the panels. Panel block installation will not be required for exterior panels.

Pocket Door Bagged Parts Lists

XXP Pocket Door
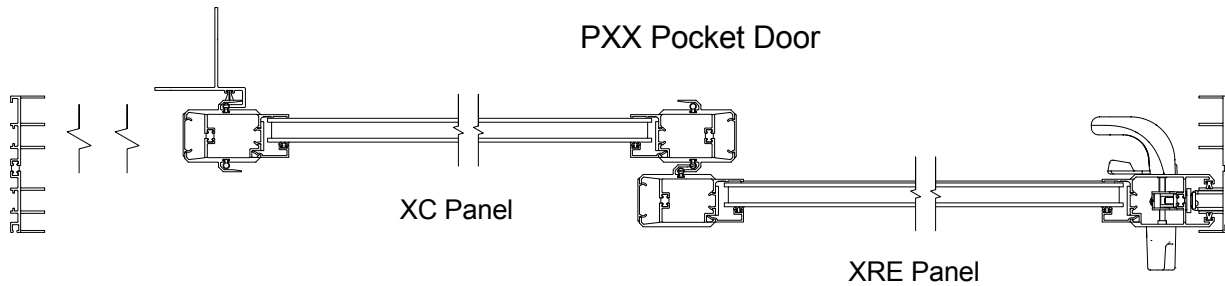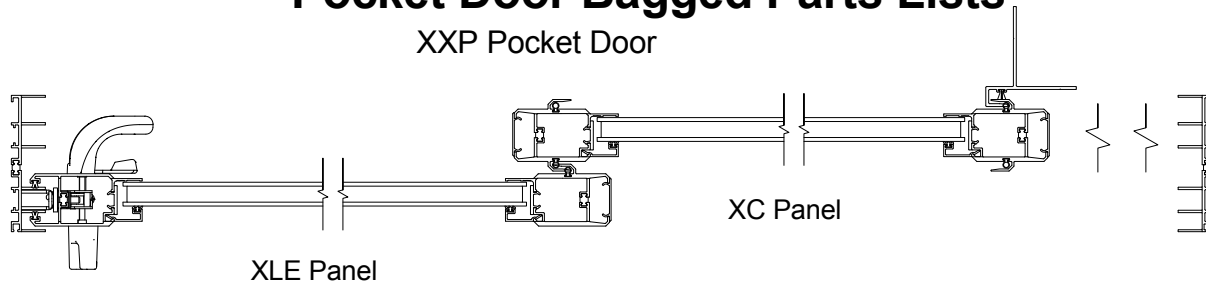
XC Panel

XLE Panel

PXX Pocket Door

XC Panel

XRE Panel

White

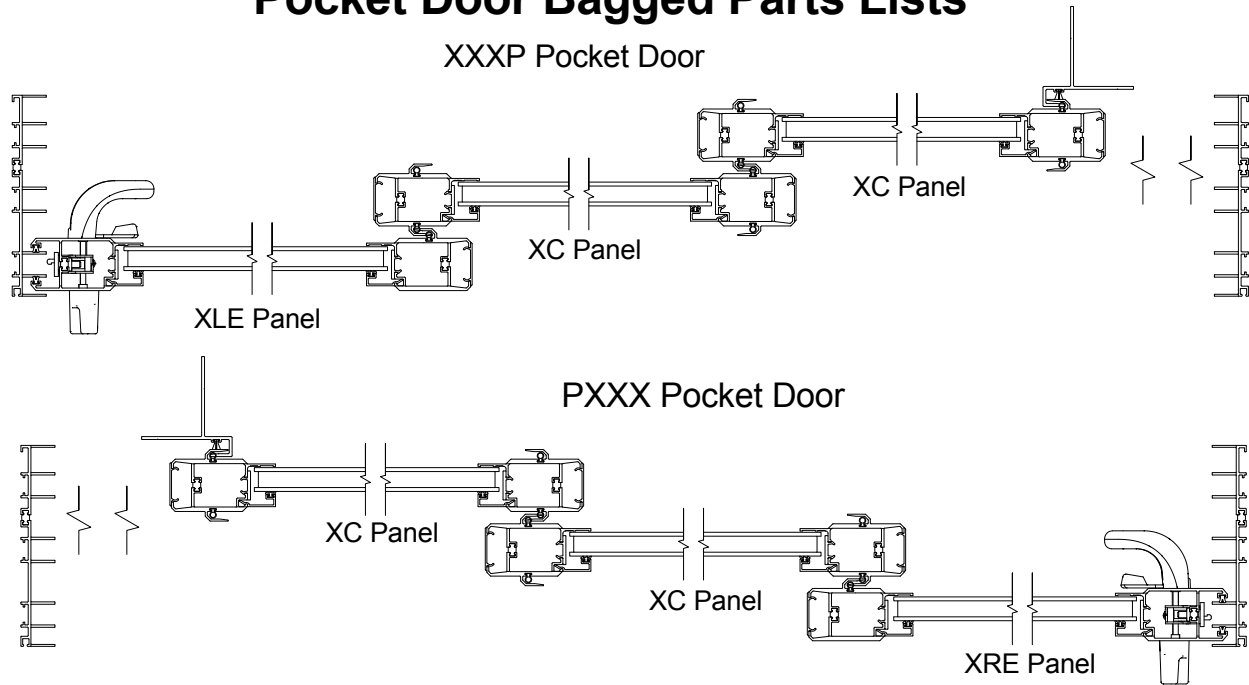| Part No.	Quantity	Color	Description
460031005	1	White	Interior / Exterior Handle Set
420122000	1	Stainless Steel	Dual Mortise Keeper
430031005	1	White	Panel Bumper Block
279751	4	White	Roller Adjustment Hole Plug
440037005	2	White	#8 x 1" Ph Flt Hd Panel Bumper Block Installation Screw
440026000	4	Stainless Steel	#8 x 1 1/2" Hex Hd Frame Assembly Screw
440027000	4	Stainless Steel	#8 x 2 1/2" Ph Pn Hd Keeper Installation Screw
166609	10	Black	1.25" x 0.5" x 2" Reticulated Foam Bug Sponge
600036010	4	Grey	0.625" x 1.5" x 1.188" Head / Sill Interlock Dust Plug
600037010	2	Black	0.680" x 0.635" x 0.75" Frame Jamb / Roller Track Foam Plug
600038010	1	Grey	0.180" x 0.5" x 3" Interior Panel / Sill Riser Weather Stripping

Bronze / Adobe Grey

Part No.	Quantity	Color	Description
460031018	1	Black	Interior / Exterior Handle Set
420122000	1	Stainless Steel	Dual Mortise Keeper
430031005	1	Black	Panel Bumper Block
643209	4	Black	Roller Adjustment Hole Plug
640631	4	Adobe Grey	Roller Adjustment Hole Plug
440037018	2	Black	#8 x 1" Ph Flt Hd Panel Bumper Block Installation Screw
440026000	4	Stainless Steel	#8 x 1 1/2" Hex Hd Frame Assembly Screw
440027000	4	Stainless Steel	#8 x 2 1/2" Ph Pn Hd Keeper Installation Screw
166609	10	Black	1.25" x 0.5" x 2" Reticulated Foam Bug Sponge
600036010	4	Grey	0.625" x 1.5" x 1.188" Head / Sill Interlock Dust Plug
600037010	2	Black	0.680" x 0.635" x 0.75" Frame Jamb / Roller Track Foam Plug
600038010	1	Grey	0.180" x 0.5" x 3" Interior Panel / Sill Riser Weather Stripping

Ply Gem®
WINDOWS & DOORS

4880 / 4880IR Pocket Sliding Patio Door Assembly and Installation Instructions
4/19/2019 INSTRUCTION P/N: E48SGD4001 REV. C

Pocket Door Bagged Parts Lists

XXXP Pocket Door

XC Panel

XC Panel

XLE Panel

PXXX Pocket Door

XC Panel

XC Panel

XRE Panel

White

Part No.	Quantity	Color	Description
460031005	1	White	Interior / Exterior Handle Set
420122000	1	Stainless Steel	Dual Mortise Keeper
430031005	2	White	Panel Bumper Block
279751	6	White	Roller Adjustment Hole Plug
440037005	4	White	#8 x 1" Ph Flt Hd Panel Bumper Block Installation Screw
440026000	6	Stainless Steel	#8 x 1 1/2" Hex Hd Frame Assembly Screw
440027000	4	Stainless Steel	#8 x 2 1/2" Ph Pn Hd Keeper Installation Screw
166609	20	Black	1.25" x 0.5" x 2" Reticulated Foam Bug Sponge
600036010	6	Grey	0.625" x 1.5" x 1.188" Head / Sill Interlock Dust Plug
600037010	3	Black	0.680" x 0.635" x 0.75" Frame Jamb / Roller Track Foam Plug
600038010	1	Grey	0.180" x 0.5" x 3" Interior Panel / Sill Riser Weather Stripping

Bronze / Adobe Grey

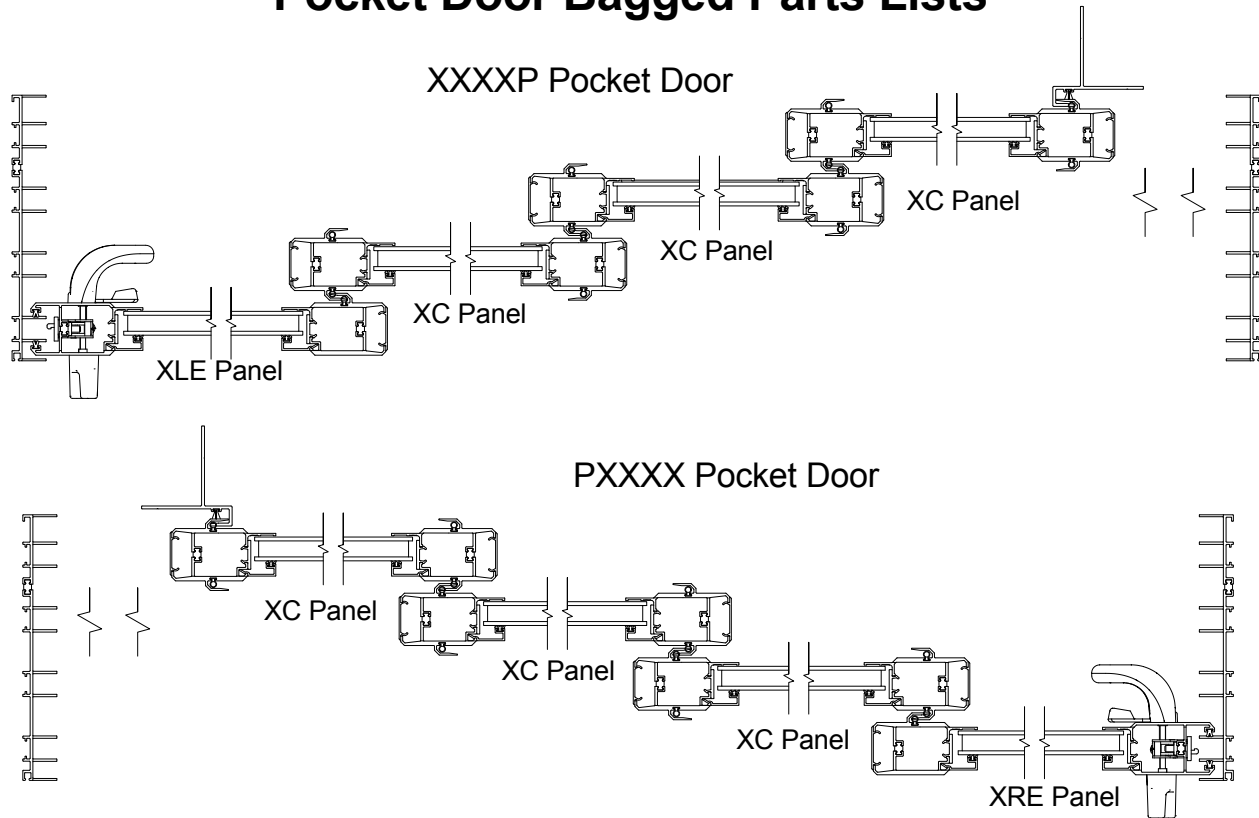| Part No.	Quantity	Color	Description
460031018	1	Black	Interior / Exterior Handle Set
420122000	1	Stainless Steel	Dual Mortise Keeper
430031018	2	Black	Panel Bumper Block
643209	6	Black	Roller Adjustment Hole Plug
640631	6	Adobe Grey	Roller Adjustment Hole Plug
440037018	4	Black	#8 x 1" Ph Flt Hd Panel Bumper Block Installation Screw
440026000	6	Stainless Steel	#8 x 1 1/2" Hex Hd Frame Assembly Screw
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166609	20	Black	1.25" x 0.5" x 2" Reticulated Foam Bug Sponge
600036010	6	Grey	0.625" x 1.5" x 1.188" Head / Sill Interlock Dust Plug
600037010	3	Black	0.680" x 0.635" x 0.75" Frame Jamb / Roller Track Foam Plug
600038010	1	Grey	0.180" x 0.5" x 3" Interior Panel / Sill Riser Weather Stripping

Pocket Door Bagged Parts Lists

XXXXP Pocket Door

XC Panel
XC Panel
XC Panel
XLE Panel

PXXXX Pocket Door

XC Panel
XC Panel
XC Panel
XRE Panel

White

Part No.	Quantity	Color	Description
460031005	1	White	Interior / Exterior Handle Set
420122000	1	Stainless Steel	Dual Mortise Keeper
430031005	3	White	Panel Bumper Block
279751	8	White	Roller Adjustment Hole Plug
440037005	6	White	#8 x 1" Ph Flt Hd Panel Bumper Block Installation Screw
440026000	8	Stainless Steel	#8 x 1 1/2" Hex Hd Frame Assembly Screw
440027000	4	Stainless Steel	#8 x 2 1/2" Ph Pn Hd Keeper Installation Screw
166609	30	Black	1.25" x 0.5" x 2" Reticulated Foam Bug Sponge
600036010	8	Grey	0.625" x 1.5" x 1.188" Head / Sill Interlock Dust Plug
600037010	4	Black	0.680" x 0.635" x 0.75" Frame Jamb / Roller Track Foam Plug
600038010	1	Grey	0.180" x 0.5" x 3" Interior Panel / Sill Riser Weather Stripping

Bronze / Adobe Grey

Part No.	Quantity	Color	Description
460031018	1	Black	Interior / Exterior Handle Set
420122000	1	Stainless Steel	Dual Mortise Keeper
430031018	3	Black	Panel Bumper Block
643209	8	Black	Roller Adjustment Hole Plug
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