













Custom Windows and Doors

# Aluminum French Door Assembly Instructions

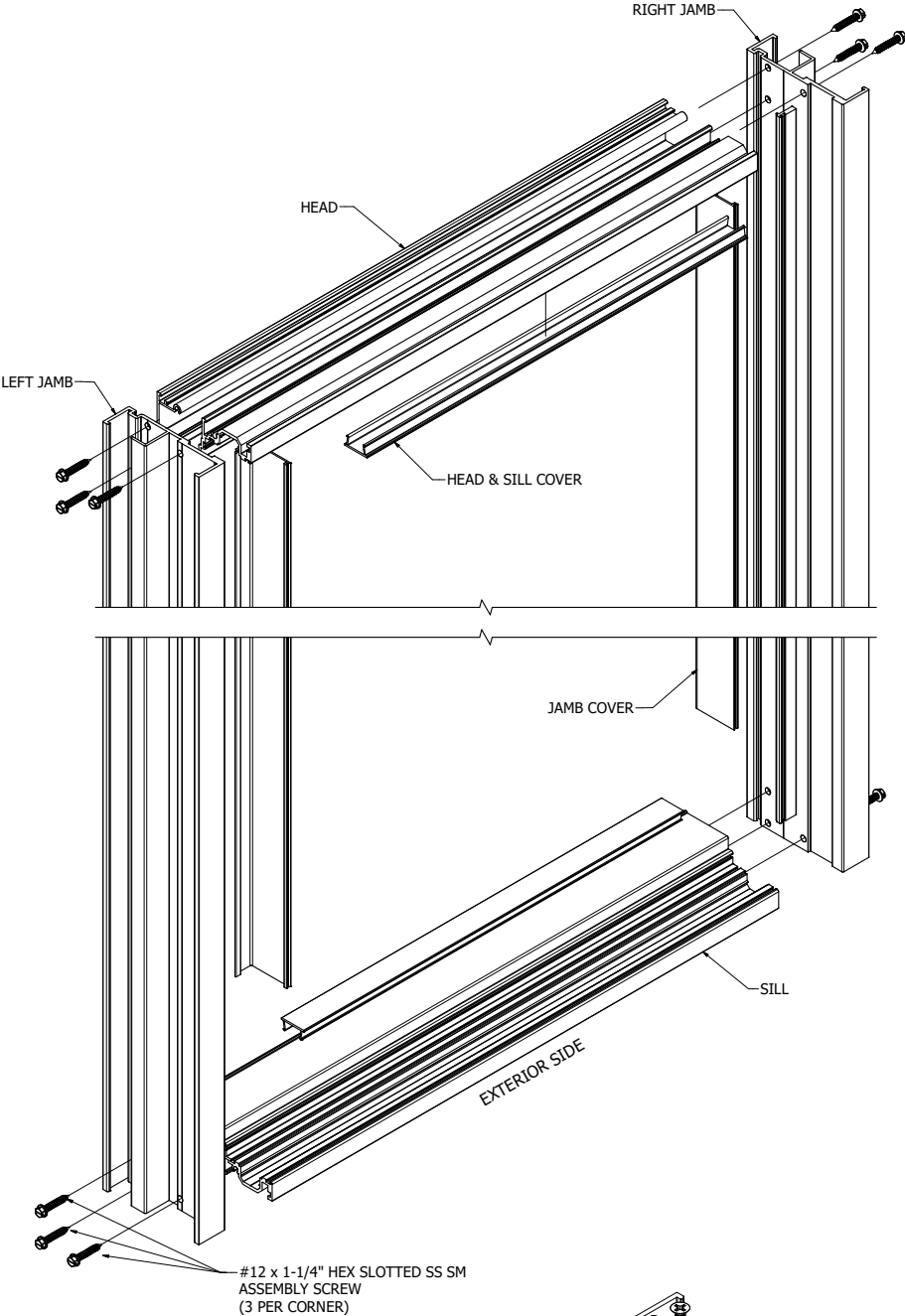
**SERIES FD 450**



# FD 450 Parts List

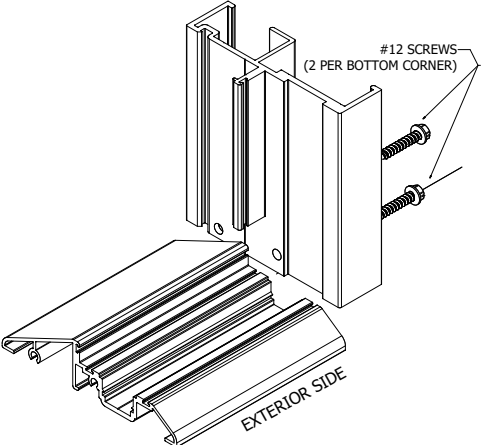
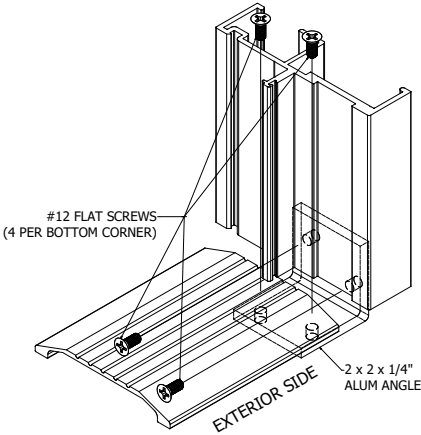
ITEM	FD 450 PARTS LIST		
1		BALDWIN ACTIVE PASSAGE LEVER SET	1
		Door Active Panel Lever (if Residential Standard Handleset selected)	
2		BALDWIN DUMMY LEVER SET	1
		Door Inactive Panel Dummy Lever (if Residential Standard Handleset selected)	
3		45° OFFSET LADDER PULL HANDLE, BACK-TO-BACK	1
		One set per Panel (if Residential Ladder Pull selected) Available as 36", 48", and 72" long	
4		HINGE SCREW 12-24x 1/2, FLAT, PH, 18-8, MS	8 PER HINGE
		Used to install hinges. 4 preinstalled out of factory.	
5		ASTRAGAL SEAL	2 PER PAIR OF DOORS
		Seal installed on the bottom sill of the center meet between the panels	
6		FRAME HEAD & SILL SCREW COVER	2
		Cover to be installed on frame head and sill (If Integral Transom selected, to be installed as Transom Head Cover)	
7		FRAME JAMB SCREW COVER	2
		Cover to be installed on frame jambs (If Integral Transom selected, to be installed as Transom Sill & Jambs Cover)	
8		ASSEMBLY SCREW #12 X 1-1/4" HEX SLOTTED SCREW 18-8 SS SM	12
		Corner Assembly screws for the Frame	
9		SIDELITE FASTENING #10 X 1, PAN, PH, 18-8 SMS TYPE A	16 to 24
		Sidelite Panel Fastening to Sidelite Frame	
10		SELF-MATING SIDELITE #14 X 3/4 HEX TEK 410 SS SM	6 to 10
		Self-Mating Sidelite (mating jamb to door frame jamb)	

# FD 450 Frame Exploded View



#12 x 1-1/4" HEX SLOTTED SS SM ASSEMBLY SCREW (3 PER CORNER)

**OTHER THRESHOLD TYPES:**



# NOTICE

READING THESE INSTRUCTIONS FIRST AND FOLLOWING THE PROCEDURES IN PROPER SEQUENCE WILL SAVE FRUSTRATION AND REDUCE COSTLY MISTAKES AND WASTED TIME.

- A Parts List is provided at the front of this document for quick reference. Inspect the product and take inventory of all parts and pieces prior to installation. (ex. screws, frame, panel, etc.)
- Exploded View Reference(s) at the front of this document act as a reference for general location of parts and depict figures that are referenced when following steps outlined in these instructions.
- Carefully review these assembly instructions along with installation details contained in the AAMA Specifications, Miami-Dade Notice of Approval, or test reports, including anchorage information, if applicable.

## SECTION 1: GENERAL INFORMATION

These instructions provide a general guide for assembly. Always refer to the product's approval documents for installation details.

### Opening Requirements & Preparation

- Ensure all fasteners and rough opening dimensions comply with the product's Florida Product Approval (FPA).
- Wood bucks, if used, must be pressure treated.
- The **sub sill** (concrete base) must be clean, dry, and level.
- **A 1-1/2" interior floor recess** is recommended to prevent water infiltration.
- Verify the opening is **square, level, and plumb** before installation.
- Do **not** install it if these conditions are not met.

## SECTION 2: SINGLE OR DOUBLE DOOR ASSEMBLY

**Tip:** Perform all work from the exterior side of the building.

- 1. Unpack Components** – Remove frame and door panel; set panel aside.
- 2. Weatherproof Sub Sill** – Apply two 3/8" caulk beads, one 1/4" from front and one 1" from rear, with a wave pattern between.
  - Also caulk under sill corners where jambs meet threshold.
  - Top and side wood bucks, if used, must be fully set in sealant. If using 2x bucks, bucks must be independently secured to concrete with concrete anchors.
- 3. Build Door Frame** – apply silicone sealant to ends of head and sill members and attach them to pre-drilled assembly holes onto the jambs. Make sure all connections are square and tighten all screws.
- 4. Set Frame** – Tilt frame into opening, seating sill first.
- 5. As per approval** – Shim, level & square, per drill and install fasteners.

**6. Attach Door Panel** – Align hinges to jamb holes and fasten using #12-24 x 1/2” screws.

- Do **not** overtighten; use torque setting 5–6 on drill.
- If **double door**, attach inactive first then active panel.

**7. Check Alignment** – Ensure a uniform 3/16” gap around the panel. Adjust frame position if needed by adding or removing shims. Tighten all anchors from the inside.

**8. Seal Door Sill** – seal all anchors at sill of door and gap at both ends between the sill channel (where installation screws sit) and frame jambs (see item 1 on figure 3)

**9. Install Lockset** – Follow lock manufacturer instructions. Adjust top/bottom bolts if needed.

**10. Seal Exterior Perimeter** – Apply continuous exterior-grade caulk around the door frame for a watertight seal.

**11. Integral Transom** – if the unit has an Integral Transom, you can install the transom panel at this stage. The transom panel will hide the installation screws at the head, you can decide:

- Hold off on the transom panel installation until inspection is completed; or,
- Install transom panel now and remove it when inspection is being made.

Refer to Figure 5 to install the panel. Panel should be installed from the exterior by inserting the top of panel into head channel (pre-installed at factory) and swing the panel towards the frame. Secure the panel using #10 x 1” stainless steel screws (included in kit).

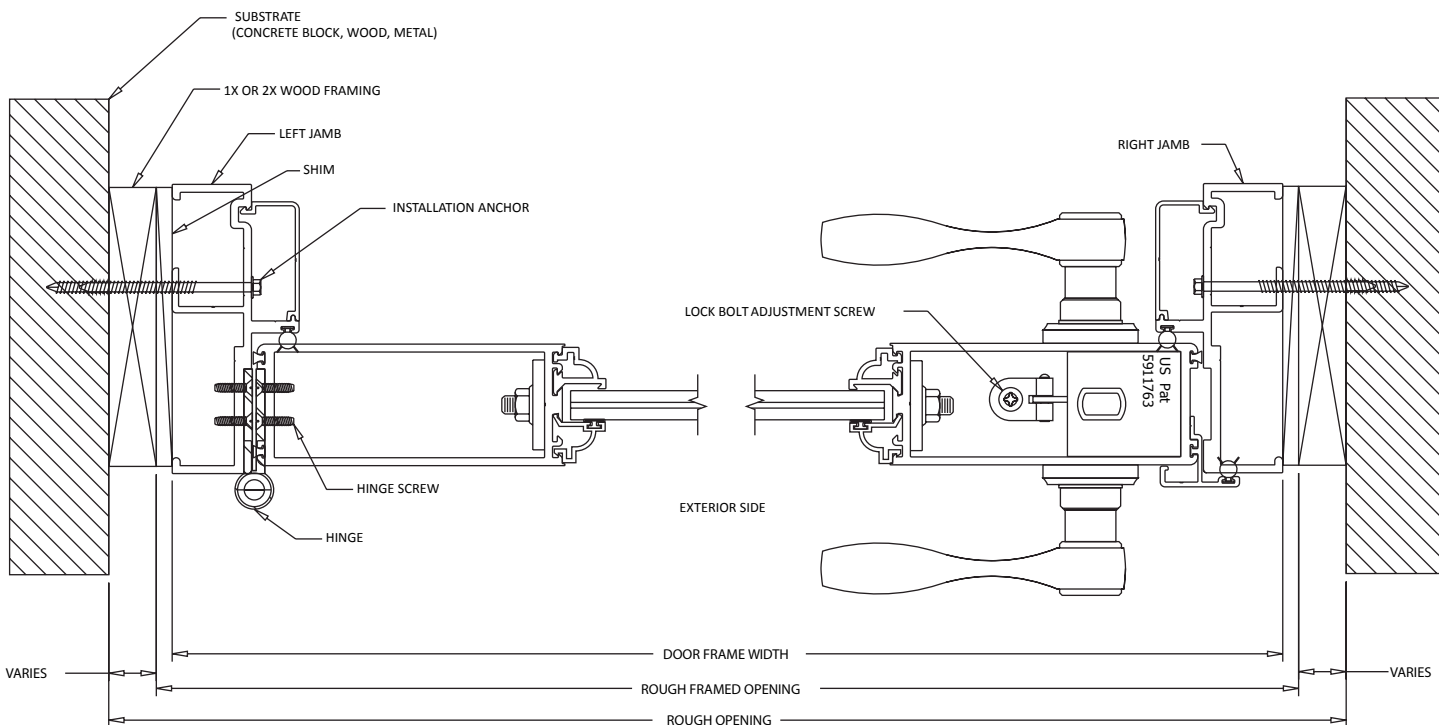


FIGURE 1

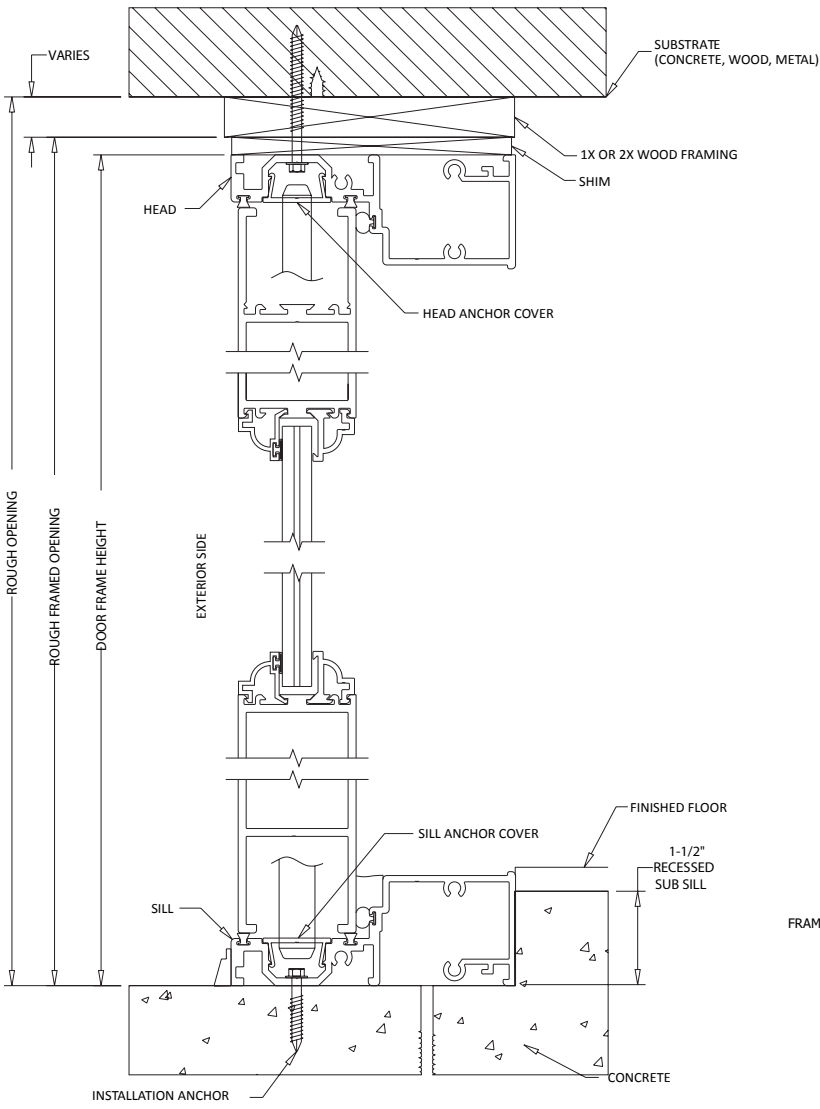


FIGURE 2

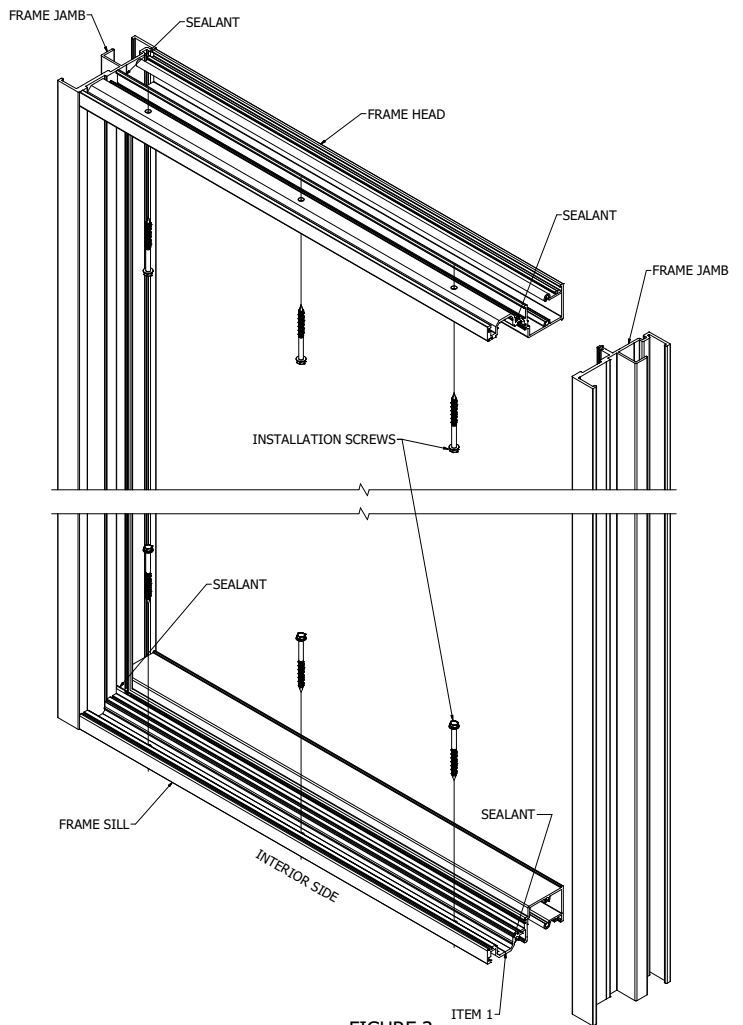


FIGURE 3

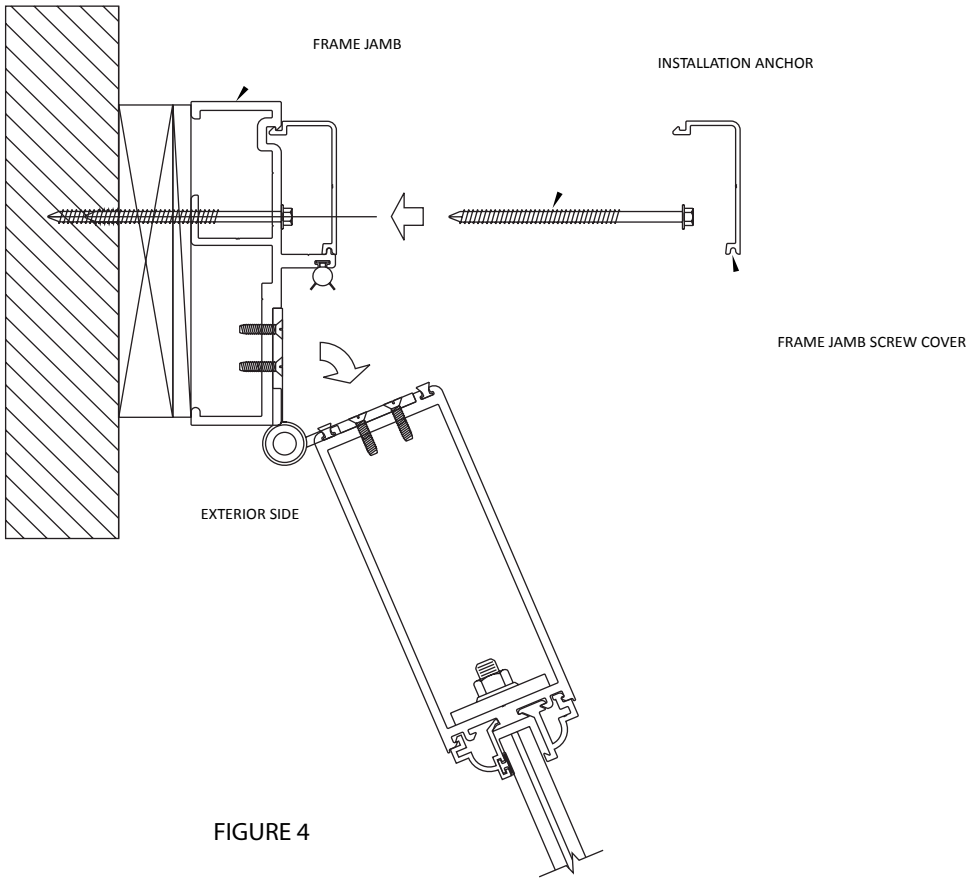


FIGURE 4

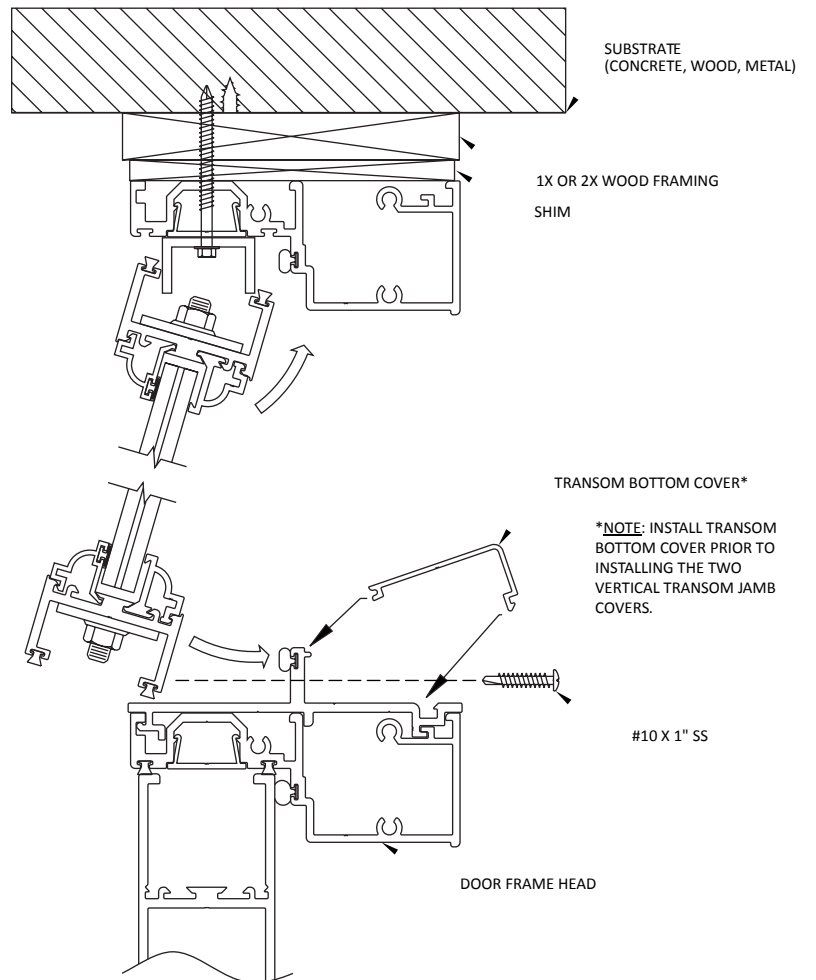


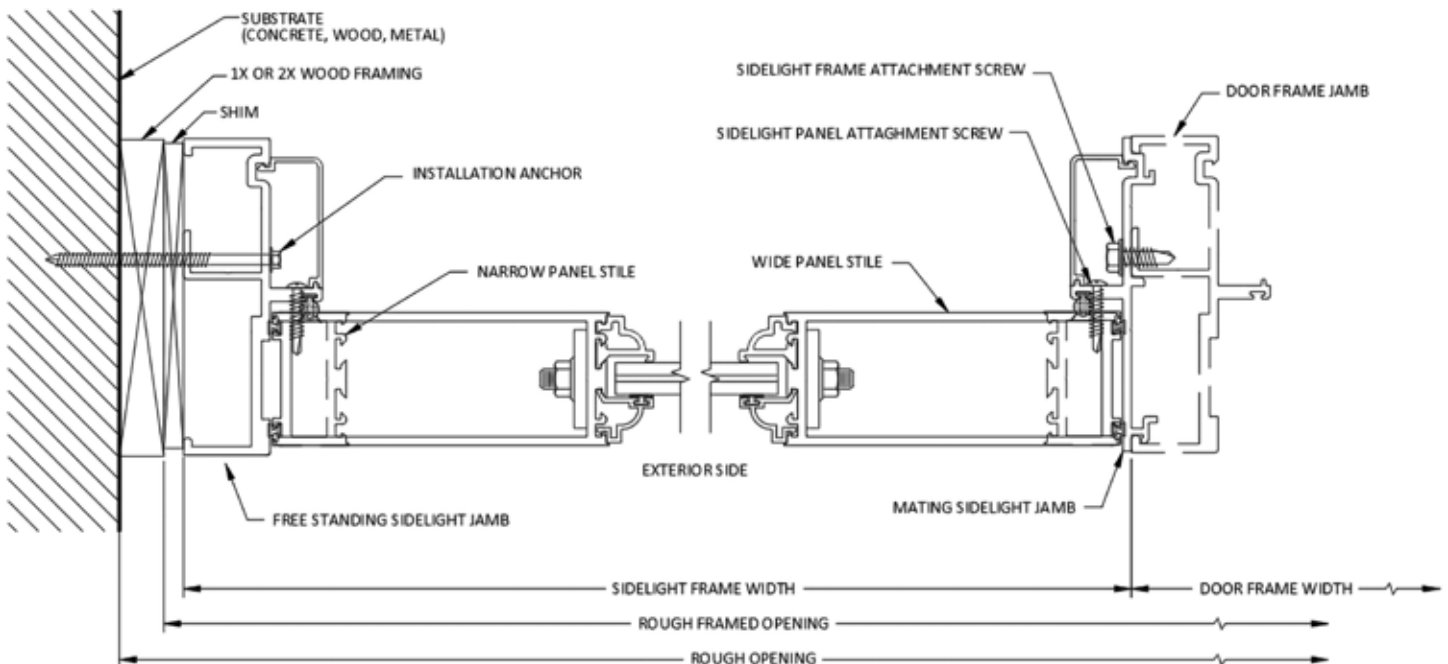
FIGURE 5  
DOOR SHOWN, SIDELITE SIMILAR

## SECTION 3: SIDELIGHT ASSEMBLY

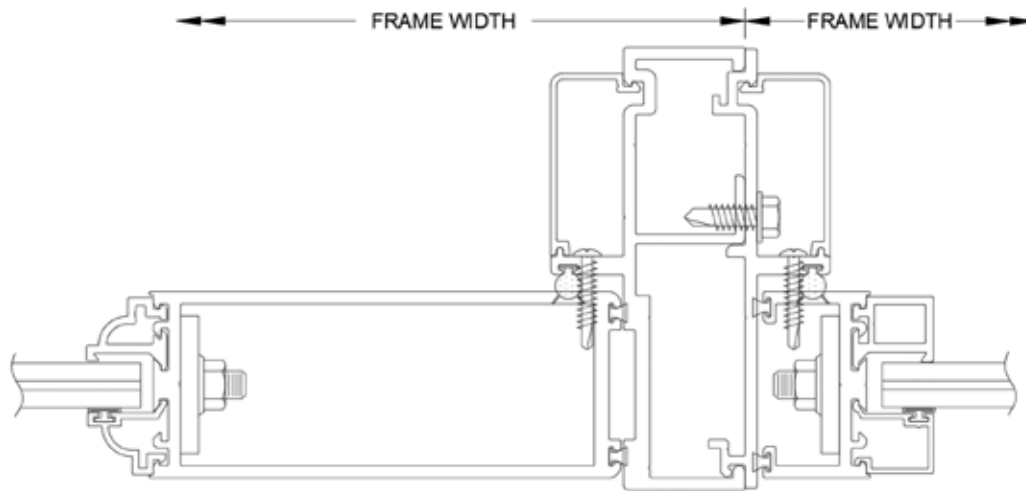
(no sidelight(s) skip to section 4)

For doors with one or more sidelights. Install from the **exterior** side.

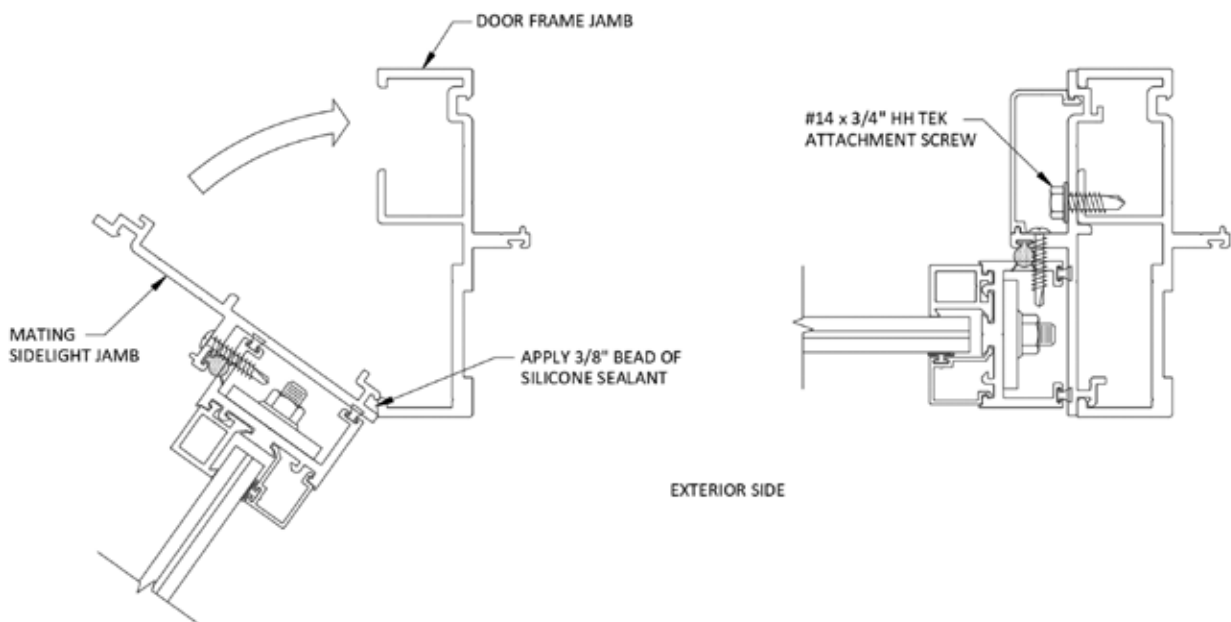
- 1. Identify Mating Jamb** – The narrower jamb mates with the door frame.
- 2. Position Sidelight** – Confirm correct left/right orientation.
- 3. Apply Sealant** – Run a  $\frac{3}{8}$ " silicone bead on the exterior leg of mating jamb.
- 4. Attach Sidelight** – Snap to door frame and fasten using #14 x  $\frac{3}{4}$ " TEK screws through predrilled holes.
- 5. Confirm Fit** – Rough opening should be up to  $\frac{1}{2}$ " wider and  $\frac{1}{4}$ " taller than full door + sidelite unit.
- 6. Weatherproof Sub Sill** – Apply caulk as in Single Door instructions.
- 7. Seal Door Sill** – Seal as in Single Door instructions.
- 8. Set & Shim Unit** – Tilt into opening, seat sill first, and shim at all anchor points.
- 9. Verify Level & Plumb** – Adjust as required for square alignment.
- 10. Drill & Anchor** – Drill  $\frac{1}{4}$ " x  $2\frac{1}{2}$ " holes and install fasteners. Leave slightly loose for adjustment.
- 11. Attach Door Panel(s)** – Follow same procedure as Single or Double Door section.
- 12. Final Seal** – Caulk entire exterior perimeter for a weather-tight finish.







SIDLIGHT TO SIDELIGHT MULLION  
WIDE STILE MULLED TO NARROW STILE



EXTERIOR SIDE

## SECTION 4: FINAL NOTES

- Do **not** install screw covers until final inspection approval.
- **Install Screw Covers** – Snap in covers at head, sill and jambs (after inspection).

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