

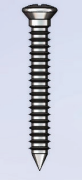
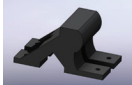
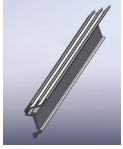
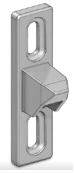
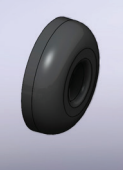
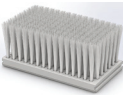


SGD670/
SGD770
SGD770NS
**Assembly
Instructions**

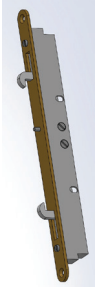
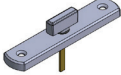
ALUMINUM SLIDING GLASS DOORS



670/770/770NS Parts List

PARTS			
DESCRIPTION		PARTS BAG QTY.	
	FRAME ASS'Y SCREW #8 x 1" LONG	16 per bag	
	Screw used to assemble the main frame.		
	JAMB BUMPER SCREW #6 x 3/8" LONG	1 per bumper	
	Screw used to attach the jamb bumper to the operable panel.		
	COME - A - LONG SCREW #8 x 1 1/4" LONG	2 per come - a - long	
	Screw used to attach the come -a- long block to each operable panels.		
	4 HOLE BUMPER STOP SCREW #8 x 3/8" LONG	4 per bumper	
	Screw used to attach the 4 hole bumper stop to sill and head.		
	COME - A - LONG AND COVER	1 per operable panel	
	Used on the top of operable panels at interlock. Used on multi panel configurations only.		
	SCREEN KEEPER SPACER	1 per screen keeper	
	Shim used to raise screen keeper off of frame for additional adjustment.		
	HEAVY DUTY 4 HOLE BUMPER STOP	2 per operable panel	
	Reinforced vinyl stop attaches to header & sill of the main frame. Used to prevent the "X" panel from impacting components adjacent to it. Also prevents pocket panels from rolling off the track.		
DESCRIPTION			
	FIXED PANEL CLIP (6" LONG)	1 per "O" panel	
	An aluminum clip that attaches to the panel stile & main frame jamb. Used to fix the "O" panel in place.		
	FIXED PANEL RETAINERS	2 per "O" panel	
	There are 2 different retaining clips., one for fixed panels that are on the inner most track of the home (Track 1) and one for fixed panels that are on all other tracks.		
	SCREEN LATCH KEEPER	1 per operable screen	
	Screen latch keeper is used with the standard panel pull on the box screen. Attaches to the main frame jamb to allow the screen to lock in to the jamb.		
	ROLLER ADJUST HOLE PLUG	2 per panel	
	Round plug used to fill the hole for the adjustment screw on the rollers.		
	JAMB BUMPER	1 per main frame jamb	
	Attached to the stile. It keeps the panel from making contact with the main frame.		
	DUST PLUG (HIGH)	2 at each interlock connection	
	Used on the main frame at the top / bottom of every operable panel interlock connection.		
	"O" PANEL BRACKET Narrow Stile Doors Only	2 per fixed panel	
	For some SGD770NS configurations, the "O" panel bracket is required at the head and sill.		

670/770/770NS Parts List

PARTS			
DESCRIPTION		PARTS BAG QTY.	
	MORTISE LOCK RAISED HANDLE SET (ACTIVE)	1 per lockstile panel	
	Standard handle set provided to lock the door. Handle set comes complete with two metal handles, one on the interior & one on the exterior with color match screws.		
	MORTISE LOCK RAISED HANDLE SET (INACTIVE)	1 per astragal	
	Used with Standard raised handle set when door has Astragal panels. Comes complete with two metal handles, one on the interior & one on the exterior with color match screws. Not used on OXO configurations.		
	1" MORTISE LOCK KEEPER	1 per Mortise latch	
	The lock keeper is placed on the main frame jamb or the astragal. This allows the panel to lock into the main frame or lock into the astragal panel.		
	MORTISE LATCH	1 per Mortise latch	
	Factory installed dual point Mortise Latch used to lock the doors.		
		BAG MAY BE SENT WITH EXTRA PARTS TO ACCOUNT FOR LOSS OR MISPLACEMENT OF SMALL PIECES.	
		PLEASE MAKE SURE PRIOR TO ASSEMBLY THAT YOU HAVE THE CORRECT AMOUNT OF PARTS CALLED OUT FOR BY THE "PARTS BAG QTY" SECTION.	
	RECESSED LOCK (ACTIVE)		
	Optional handle set provided to lock the door. Comes complete with two metal handles, one on the interior & one on the exterior with color match screws. * Also used as secondary locks when recessed locks are ordered as Primary Locks.		
	RECESSED LOCK (INACTIVE)		
	Used with recessed handle set when door has Astragal panels. Comes complete with two metal handles, one on the interior & one on the exterior with color match screws.		
	SECONDARY LOCK THUMBTURN		
	Optional secondary lock used with Mortise Raised handle set.		
	EXTERIOR FLATPLATE		
	Used with Interior Raised handle set when a low profile is needed on the Exterior. * Will not be anything to grab to hold the doors.		

NOTICE

CAREFULLY FOLLOWING THE INSTRUCTIONS IN THE PROPER SEQUENCE WILL REDUCE MISTAKES AND SAVE TIME.

- Protect mainframe only with light coating of oil, grease or soap. Action of lime in plaster can destroy finish.
- Sill must be smooth ... buff edges and fill any valleys left by mason. A ridge or lump could cause latching problems.
- If installed in wood surround, measure assembled door frame, add shim space and make surround to these dimensions.
- 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: FRAME ASSEMBLY BY-PASS

(if pocket door skip to pocket section)

1. **Gather** the main frame header, sill and jambs.
Trace the frame ends with sealant. (See Figure 1)
- **Note:** It is good practice to seal the outside of all four corners heavily after the frame is assembled. (See Figure 1 and 2)
2. **Assemble** mainframe head, jambs, and sill using the supplied # 8 x 1 Philips pan head screws at each assembly hole. (See Figure 1 and 2)
3. **Apply** the sill riser adapter to the main frame sill.
First, place sealant along entire length of riser adaptor in area shown. (See Figure 3).
4. **Set** the track on an even, flat, fully supported surface and then connect the sill riser to the sill. (See Figure 3a).
- **Note:** Risers can be applied at the end of the installation as well should panels need to be set from the inside or to protect from job site damage. When using the Box (standard) riser allow for the additional depth the riser will add to the sill towards the inside. If this additional depth is not accounted for there may not be enough room to install the riser. It is recommended that the sill riser be attached (without sealant) until the main frame is secured.
5. **Make** sure the opening which the door is to be installed to is clean and clear of debris. Dry fit the frame into the opening.
- **Note:** Do not force the frame into the opening. If the frame is tight then clear away obstructions.
6. **Once** the frame fits into opening freely, seal under entire length of sill and all frame seams. Make sure to include where the frame sill and head meet the main frame jambs. (See Figure 4)



Figure 1

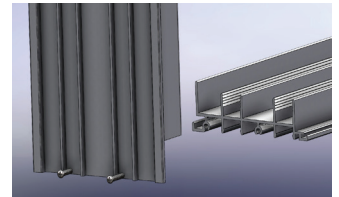


Figure 2

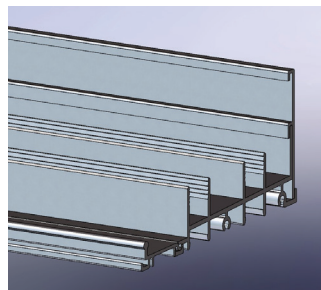
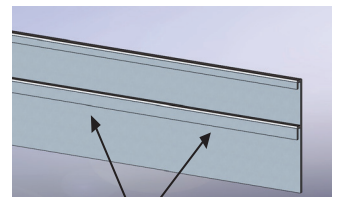


Figure 3A



Apply sealant inside groove before installing

Figure 3

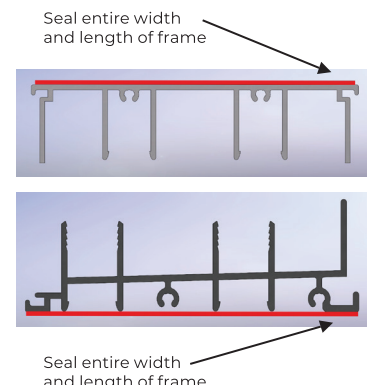


Figure 4

7. Set frame in opening and shim as necessary to make frame plumb, level and square. Shim behind all frame jamb and header installation screws and near mortise keeper to prevent frame distortion when installation screws are tightened.

- **Important:** Frame head and track must be level, square and plumb at frame jambs. Measure at head, sill and midpoint horizontally to be certain that frame is not bowed, also measure from top to bottom across the entire frame from left to right to make sure there are no rises in the sill or dips in the header. Rises in the sill or dips in the header could prevent the panels from being installed. Do not over tighten frame installation screws as this could warp the frame. (See Figure 5)
- **Helpful Tip:** Use a short torpedo level across the sill (without setting it on the riser) and at the head to verify the sill and head are level from inside to outside. If the track at sill or head are not level from inside to outside it could cause stiff panel operation. Take notice that the head and sill are not the same depth, it is important to make sure that the tracks align at the head and sill in order for the panels to roll correctly. Use a plumb bob to make sure the head and sill are in alignment, this is especially important in pocket conditions.

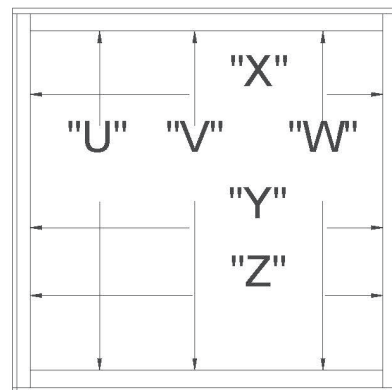


Figure 5

8. Attach frame to opening per PGT specifications and in compliance with all local code requirements, Miami-Dade NOA or test reports.

9. Once the frame is secured and is plumb, level, and square, seal installation screws.

10. After installation screws are sealed, install the sill inserts. There is one insert for each track. (See Figure 6)

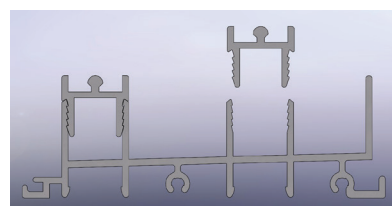


Figure 6

11. Next install the main frame head screw covers. Snap the screw cover in on one side then slide the cover over until it is past the jamb fins, do the same with the other side. The material may need to be arched to get it in tight. (See Figure 7)

- **Note:** Main frame jamb screw covers in tracks where keepers or fixed panel clips will be installed should be installed at the end of installation. This allows for proper placement and adjustment of keepers and clips. The main frame jamb screw covers will need to be trimmed to size once keepers have been adjusted.

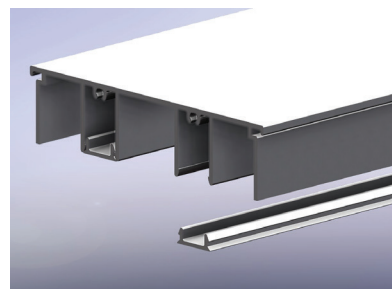


Figure 7

SECTION 2: FRAME ASSEMBLY POCKET

(if pocket door skip to pocket section)

1. Gather the main frame header, sill and jamb (if single pocket). Trace the frame head and sill ends with sealant on jamb side of single pocket doors. It is not necessary to trace the frame ends if the unit is a double pocket door. (See Figure 8 and 9)

- **Note:** It is good practice to seal heavily the outside of all corners where the frame head and sill meet a jamb after the frame is assembled. Not available on double pockets.

2. Assemble mainframe head, sill, and jamb, on a single pocket door using the supplied # 8 x 1 Phillips pan head screws at each assembly hole. (See Figure 8 and 9) This step is not required on double pocket units.

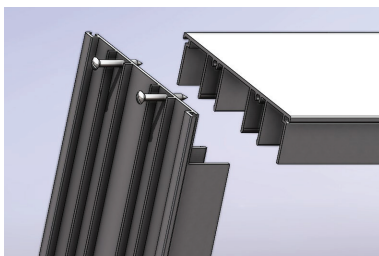


Figure 8

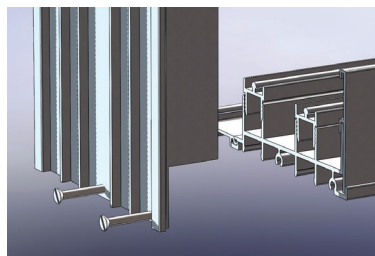


Figure 9

3. **Apply** the sill riser adapter to the main frame sill. First, place sealant along entire length of riser adaptor in area shown (See Figure 10).
4. **Set** the track on an even, flat, fully supported surface and then connect the sill riser to the sill. (See Figure 11).

- **Important:** Sill riser must be installed prior to the p-hook being installed.
- **Note:** Sill riser can be attached near the end of the installation but must be attached prior to installation of the p-hook should panels need to be set from the inside or to protect from job site damage. When using the box (standard) riser allow for the additional depth the riser will add to the sill towards the inside. If this additional depth is not accounted for there may not be enough room to install the riser. It is recommended that the sill riser be attached (without sealant) until the main frame is secured.

5. **Make** sure the opening which the door is to be installed is clean and clear of debris. Dry fit the frame into the opening.

- **Note:** Do not force the frame into the opening. If the frame is tight then clear away obstructions.

6. **Once** the frame fits into opening freely, seal under entire length of sill and all frame seams. Make sure to include where the frame sill and head meet the main frame jamb if the unit is a single pocket.

7. **Set frame** in opening and shim as necessary to make frame plumb, level and square. Shim behind all frame jamb and header installation screws and near mortise keeper to prevent frame distortion when installation screws are tightened.

- **Important:** Frame head and track must be level, square and frame jamb (if used) must be plumb at jamb. Measure at head, sill and mid point horizontally to be certain that frame is not bowed, also measure from top to bottom across the entire frame from left to right to make sure there are no rises in the sill or dips in the header. Rises in the sill or dips in the header could prevent the panels from getting installed. Do not over tighten frame installation screws this could warp the frame. (See Figure 13)

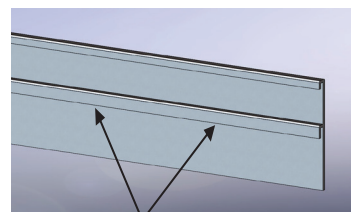
- **Helpful Tip:** Use a short torpedo level across the sill (without setting it on the riser) and at the head to verify the sill and head are level from inside to outside. If the track at sill or head are not level from inside to outside it could cause stiff panel operation. Take notice that the head and sill are not the same depth, it is important to make sure that the tracks align at the head and sill in order for the panels to roll correctly. Use a plumb bob to make sure the head and sill are in alignment, this is especially important in pocket conditions.

8. **Attach** frame to opening as per PGT specifications and in compliance with all local code requirements, Miami-Dade NOA, FPA or test reports.

9. **Next** attach the P-hook.

- **Note:** Pocket doors will only assemble at head, jamb and sill if single pocket. Double pocket main frame is not assembled as there are no jambs supplied with the unit.

10. **Hook** strip P-hook will attach interior panel to substrate. Attach frame and hook strip to opening as per PGT specifications and in compliance with all local code requirements, Miami-Dade NOA or test reports.



Apply sealant inside groove before installing

Figure 10

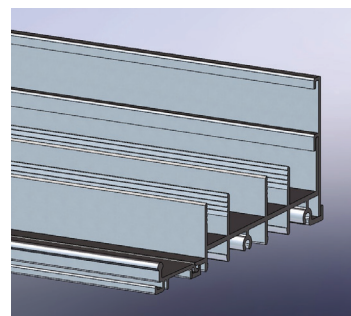


Figure 11

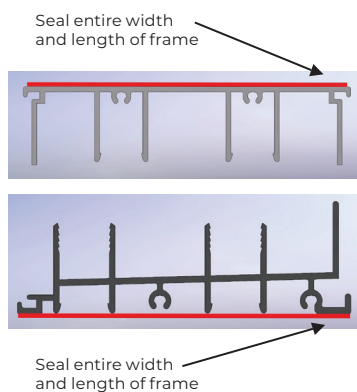


Figure 12

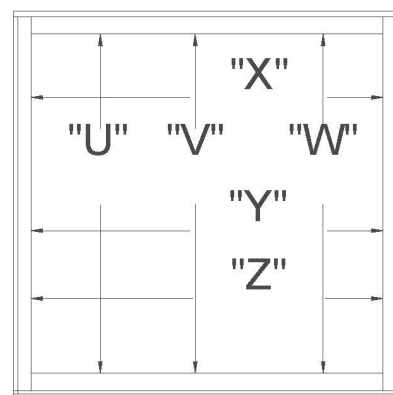


Figure 13

- 11. The P-hook** is not notched and sits on top of the sill and just under the header.
There are two types of P-hooks, one for the narrow sill riser and one for the box (standard) riser. (See Figure 14)

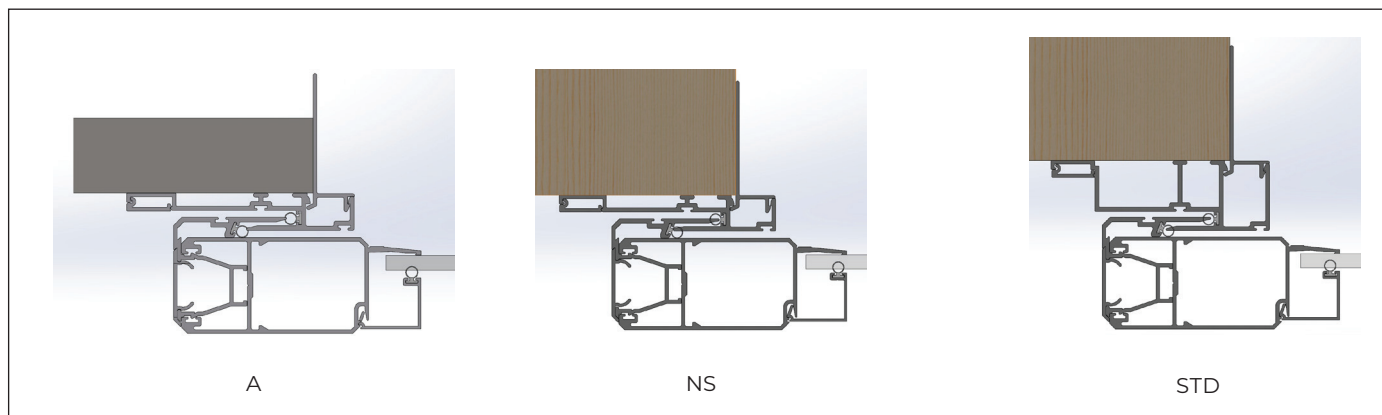


Figure 14

- 12. If a panel** is not available to set the location of the p-hook from inside to outside then align the p-hook with the riser and header as shown. (See Figure 15)

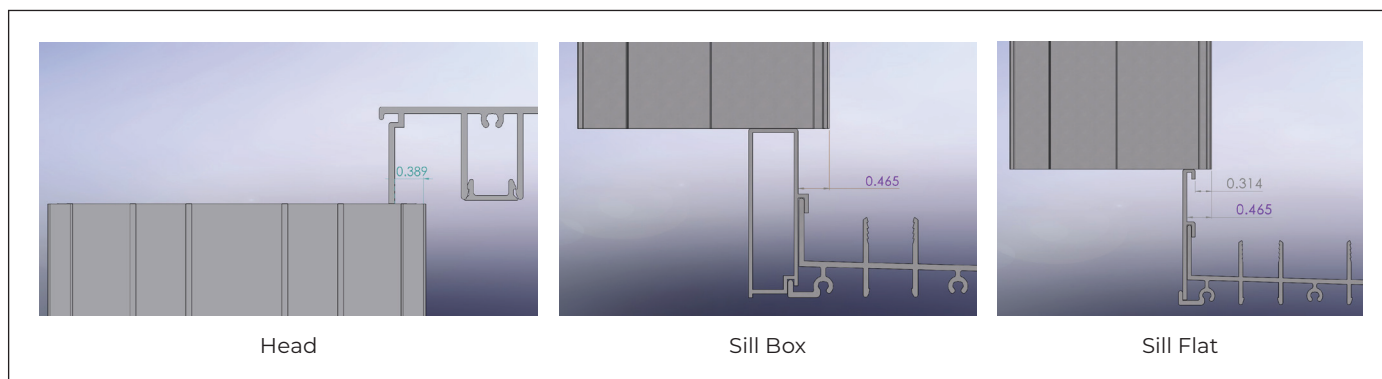


Figure 15

- Note:** riser heights will determine how many dust plugs will be needed at the sill. Install as many as needed to fill the void from the bottom of the panel to the underside of the P-hook

Once the frame is secured and is plumb, level, and square; seal installation screws.

- 13. After** installation screws are sealed, install the sill inserts. There is one insert for each track. (See Figure 16)

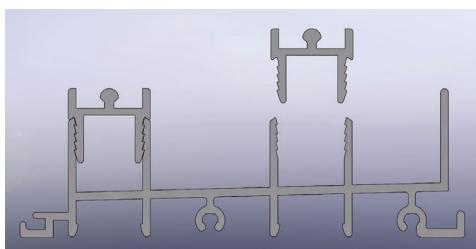


Figure 16

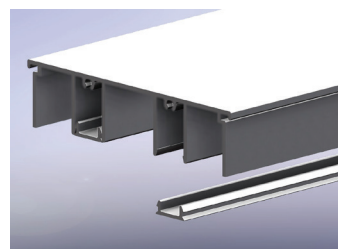


Figure 17

- 14. Next** install the main frame head screw covers and P-hook screw covers. (See Figure 17)

- Note:** For pocket doors with main frame jambs - the main frame jamb screw covers conceal where the keepers will be mounted and should be installed at the end of installation. This will allow for proper placement and adjustment of keepers. The main frame jamb screw covers will need to be trimmed to size once keepers have been adjusted.

SECTION 3: CORNER DOOR SECTION

1. **Corner** door main frames will meet at a 90° corner (either inside or outside) (See Figure 18)

- **Note:** Each side will either be a by-pass or a pocket and will follow the same main frame instruction as listed in the appropriate by-pass or pocket frame assembly sections.

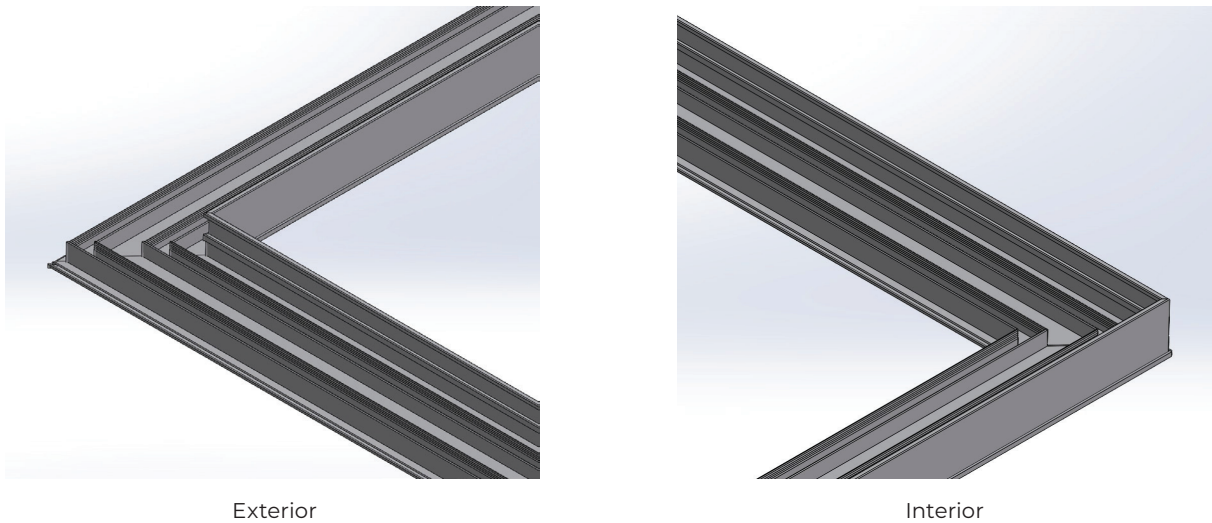


Figure 18

SECTION 4: FRAME ASSEMBLY

If unit being installed has only pocket doors, skip to the pocket door section.

1. **Gather** the main frame header, sill and jamb. Trace the frames ends with sealant. (See Figure 19)

- **Note:** It is good practice to seal the outside of all joints heavily after the frame is assembled.

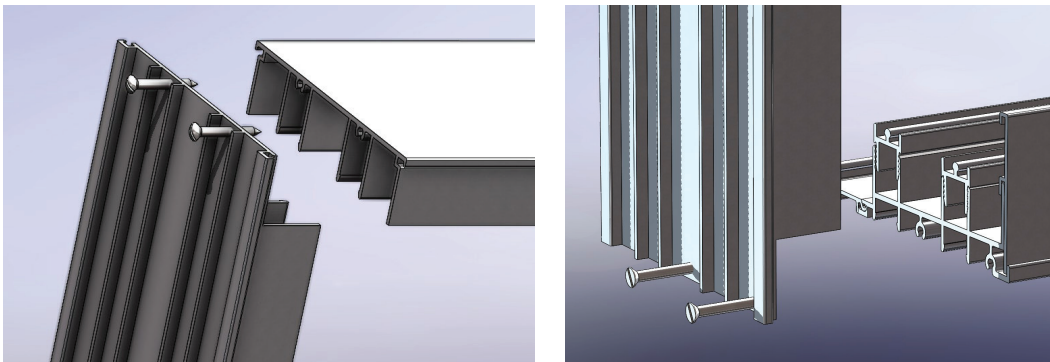
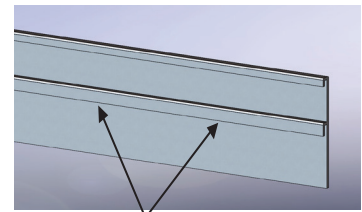


Figure 19

SECTION 4.1: FRAME ASSEMBLY POCKET

If unit being installed has only bypass doors, skip to the next section.

1. **Gather** the main frame header and sill. Trace the frame head and sill ends with sealant on the mitered end. Corner pocket doors do not have a frame jamb. P-hook(s) will attach interior panels to substrate; therefore there is not any assembly of the mainframe.
2. **Apply** the sill riser adapter to the main frame sill. First, place sealant along entire length of riser adaptor as shown. (See Figure 20)
 - **Important:** Sill riser must be installed prior to the p-hook being installed.
3. **Set** the track on an even flat, fully supported surface, and then connect the sill riser to the sill. (See Figure 21)
 - **Note:** Do not force the frame into the opening. If the frame is tight then clear away obstructions.
 - **Note:** Sill riser can be attached near the end of the installation but must be attached prior to installation of the p-hook should panels need to be set from the inside or to protect from job site damage. When using the box (standard) riser allow for the additional depth the riser will add to the sill towards the inside. If this additional depth is not accounted for there may not be enough room to install the riser. It is recommended that the sill riser be attached (without sealant) until the main frame is secured.
4. **Make** sure the opening which the door is to be installed to is clean and clear of debris.
5. **Seal** under entire length of sill, where mitered corners meet, and all frame seams. Make sure to include where the frame sill and head meet the p-hook. (See Figure 22)
6. **Set** frame in opening and shim as necessary. Make sure frame is plumb, level and square. If space exists between substrate and frame, shim behind all frame installation screws to prevent frame distortion when installation screws are tightened.
7. **When** checking for plumb it is important to remember that the head and sill are different widths. Make sure you align the fins of the header with the fins of the sill.
 - **Important:** Frame head and track must be level, square and plumb. Measure at head, sill and midpoint horizontally to be certain that frame is not bowed, also measure from top to bottom across the entire frame from left to right to make sure there are no rises in the sill or dips in the header. Rises in the sill or dips in the header could prevent the panels from getting installed. Do not over tighten frame installation screws this could warp the frame. (See Figure 23)
 - **Helpful Tip:** Use a short torpedo level across the sill (without setting it on the riser) and at the head to verify the sill and head are level from inside to outside. If the track at sill or head are not level from inside to outside it could cause stiff panel operation. Take notice that the head and sill are not the same depth, it is important to make sure that the tracks align at the head and sill in order for the panels to roll correctly. Use a plumb bob to make sure the head and sill are in alignment, this is especially important in pocket conditions.



Apply sealant inside groove before installing

Figure 20

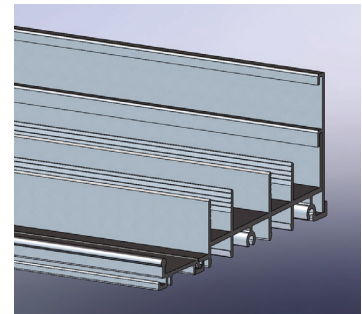
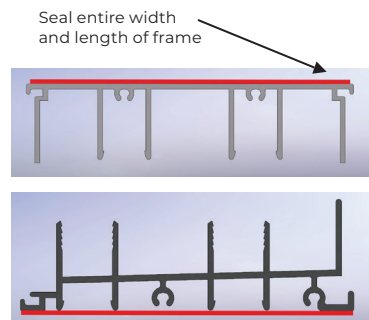


Figure 21



Seal entire width and length of frame

Seal entire width and length of frame

Figure 22

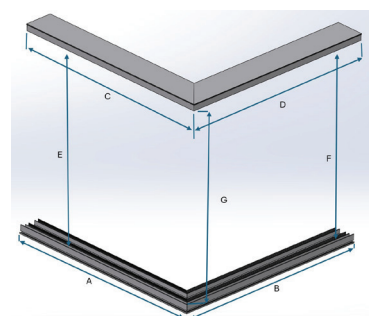


Figure 23

8. **Attach** frame to opening as per PGT specifications and in compliance with all local code requirements, Miami-Dade NOA or test reports.
9. **Next** attach the P-hook.
10. **The P-hook** is not notched and sits on top of the sill riser and just under the header.
There are two types of P-hooks, one for the narrow sill riser and one for the box (standard) riser.
(See Figure 24)

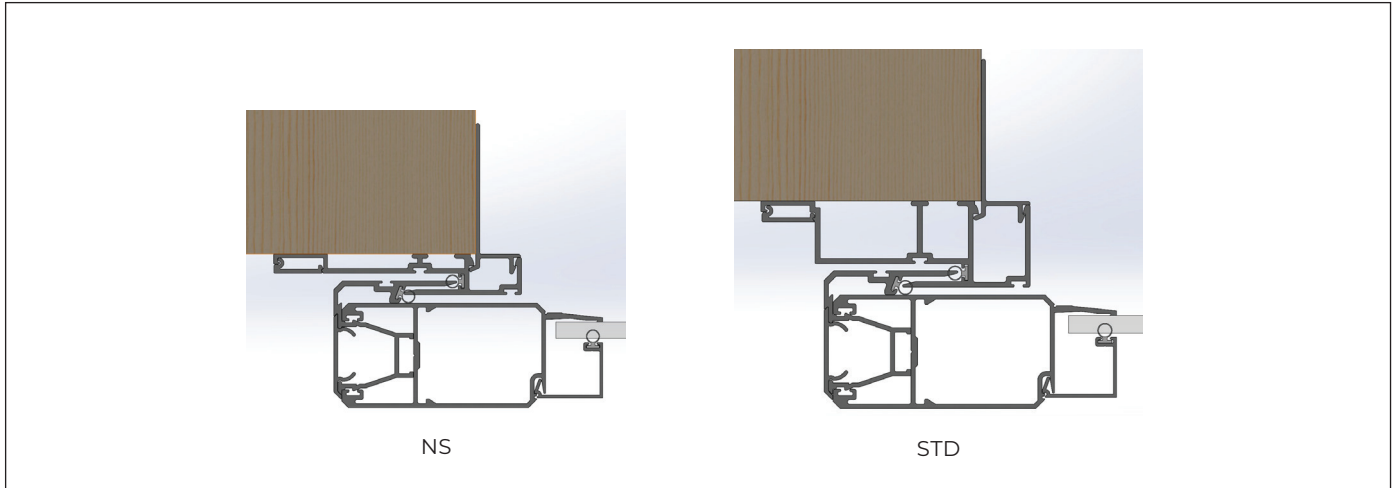


Figure 24

11. **Hook** strip P-hook will attach interior panels to substrate. Attach frame and hook strip to opening as per PGT's specifications and in compliance with all local code requirements, Miami-Dade NOA, FPA or test reports.
12. **If a panel** is not available to set the location of the p-hook from inside to outside then align the p-hook with the riser and header as shown. (See Figure 25)

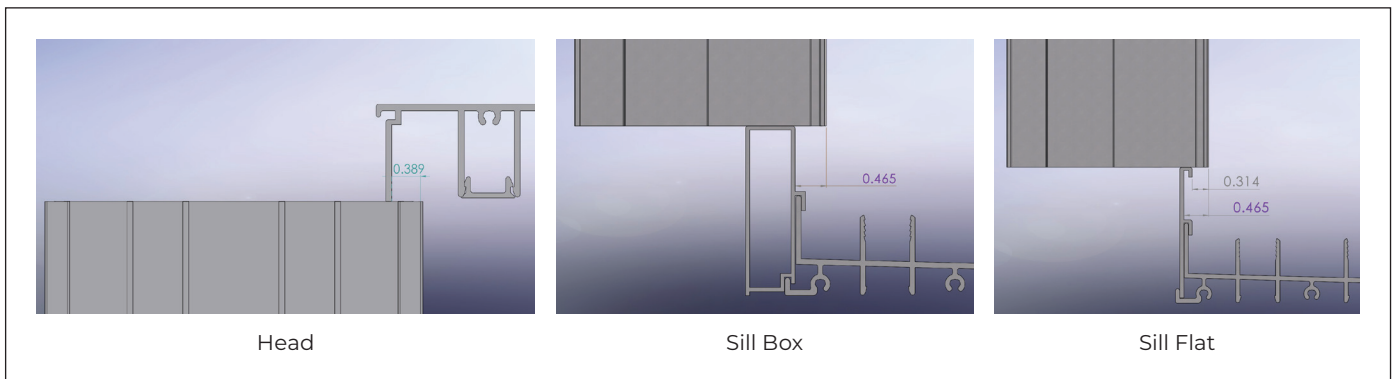


Figure 25

13. The **hook** strip may need to be field notched or ordered longer if jumping tracks with a build out. (See Figure 26)
14. **Once** the frame is secured and is plumb, level, and square; seal installation screws.
15. **After** installation screws are sealed, install the sill inserts. There is one insert for each track. (See Figure 27)
16. **Next** install the main frame head screw covers and P-hook screw covers. (See Figure 28) (See Figure 28a)

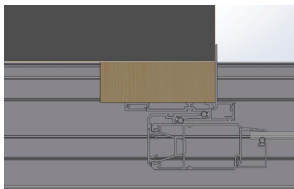


Figure 26

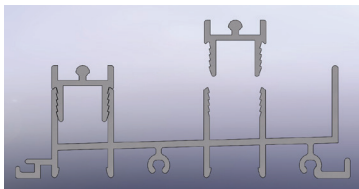


Figure 27



Figure 28

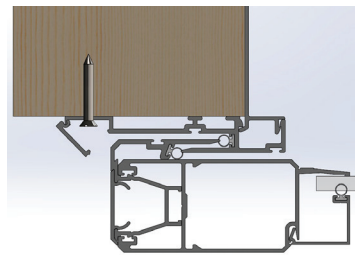


Figure 28a

SECTION 5: PANEL INSTALLATION

BEFORE YOU START please note the following: PGT offers many configurations; please see the panel orientation sheet to make sure you have the correct panels on the correct tracks.

- Shipping labels on panels will have the panel # and letter name on them; they will be installed in order from left to right. Please see the configuration page for the proper track the panel goes into. (See Figure 29)
1. **Position** panel so that the top of panel slips over track frame header. Swing bottom of panel in until bottom of panel is aligned over sill and set panel on roller spline. (See Figure 30)
 2. **Repeat** procedure, with next outer panel until all panels are installed.
 3. **Panels** are always installed with roller adjustment holes to the exterior.
 4. **It is important** that the panels at the corner are adjusted first. The corner receiving panel fins must align with the frame head and sill tracks. (See Figure 31)
 5. **To adjust** rollers on panels use a Phillips head screwdriver to turn adjustment screws located on the bottom outside of panel. (See Figure 32)

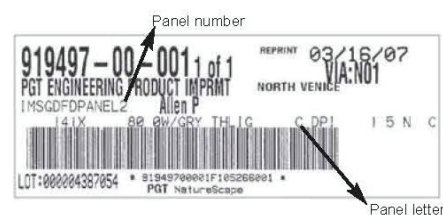


Figure 29

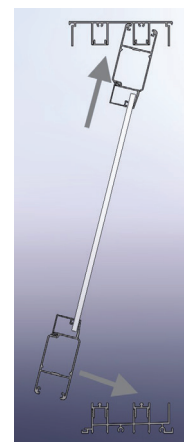


Figure 30

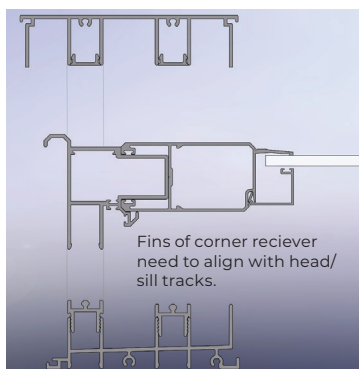


Figure 31



Figure 32

6. **Screw** guns can strip the adjustment and therefore are not recommended. To raise panels, pick up the panel at the edge to relieve the weight pressure on the wheels, and then adjust by turning adjustment screw clockwise. To lower panels turn adjustment screws counter clockwise then use weight pressure on the panel to set the wheels to the new adjustment level.

- **WARNING:** When raising and lowering the wheels, if you feel pressure do not continue as this could cause the adjustment screw to strip. Adjust each panel until all panels roll freely and all panels' stiles and frame jambs are parallel when in the closed position.

7. **Once** all panels are set into place and have been adjusted properly, check the reveals and operations to verify that everything is in proper working order. You are now ready to start to install the hardware. (See Figure 33)

- **It is recommended to install the locking hardware BEFORE attaching any of the fixed panel hardware.**



CORRECT
PANELS STILES AND FRAME
JAMBS ARE PARALLEL

INCORRECT
PANELS STILES AND FRAME
JAMBS ARE SKEWED

Figure 33

SECTION 6: LOCKING HARDWARE

Door to Jamb Connection (See Figure 34)

1. **Align** the thumb turn tail piece of the interior handle into the slot of the mortise assembly.
2. **Attach** handles using the three (2) #8-32 pan head screws provided.

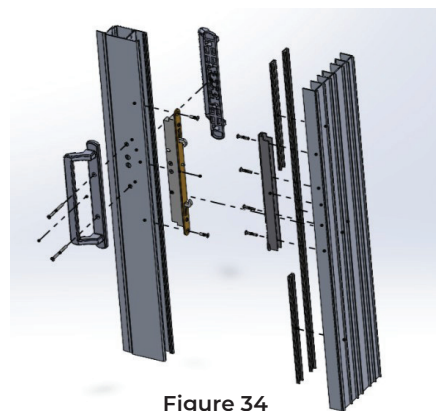


Figure 34

SECTION 7: JAMB KEEPER INSTALLATION

1. **Attach** keeper to frame jamb using four (4) #10 X 1 1/2" pan head screws. Track will be dimpled in the location the keeper is installed into the frame jamb.
2. **With** the mortise lock latch extended, adjust the keeper to maximize bite with the latch. Check operation of the lock and adjust the keeper up or down if required.
 - **HELPFUL TIP:** There is adjustment on the latch to move the cams in or out. Adjust the cams independently to remove play or add play to the latch engagement in the panel. If your unit has fixed panels it is recommended to adjust the cams in tight until the fixed panel is secured. Once the fixed panel(s), fixed panel clip(s), and retainer clip(s), have been completely installed readjust cams to allow for a little bit of play in the operating door(s). (See Figure 35)

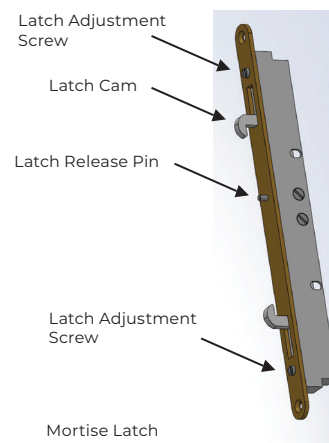


Figure 35

SECTION 8: LOCKING HARDWARE

Door to Door Connection at corner (See Figure 36)

1. **Align** the lever tail piece of the interior handle into the slot of the mortise assembly.
2. **Attach** handles using the two (2) #8-32 pan head screws provided.
 - **Note:** latch may not be operated unless the safety pin (located between the two mortise cams) is depressed.

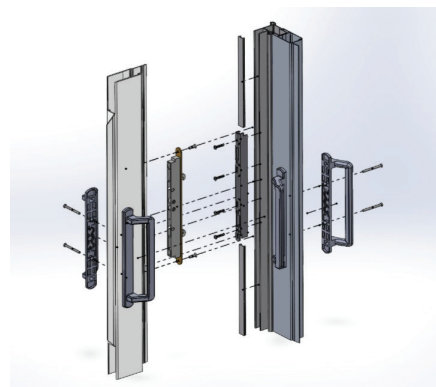


Figure 36

SECTION 9: ASTRAGAL KEEPER INSTALLATION

1. **Attach** keeper to corner receiver panel astragal using four (4) #10 X 1 1/2" pan head screws. Corner receiving astragal will be dimpled in the location the keeper is installed into the frame jamb.
2. **With the mortise lock** latch extended, adjust the keeper to maximize bite with the latch. Check operation of the lock and adjust the keeper up or down if required.
 - **HELPFUL TIP:** There is adjustment on the latch to move the cams in or out. Adjust the cams independently to remove play or add play to the latch engagement in the panel. If your unit has fixed panels it is recommended to adjust the cams in tight until the fixed panel is secured. Once the fixed panel(s), fixed panel clip(s), and retainer clip(s), have been completely installed, readjust cams to allow for a little bit of play in the operating door(s). (See Figure 37)
3. **If the door** has the recessed hardware or any secondary lock hardware, follow the same procedures listed above.

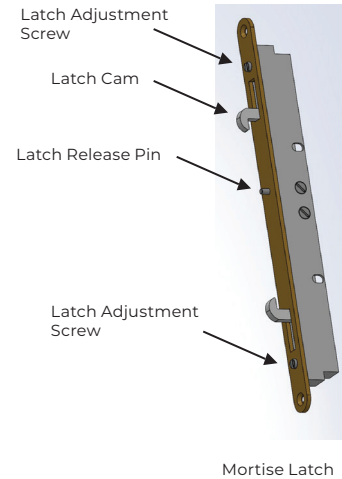


Figure 37

SECTION 10: FIXED PANEL HARDWARE

If there are any non-moving panels in your configuration then proceed to fixed panel hardware section. If not, skip to the Parts and Pieces Section.

4. **Each fixed panel has one 6" fixed panel clip and one retaining clip.**
5. **The fixed panel clip** will snap into the main frame jamb at the center of the height of the jamb. Attach the clip to the Main frame jamb by tapping it into place with a hard plastic mallet.
 - **Note:** Be sure the "Fins" on the clip are facing the interior of the house. (See Figure 38)
6. **Once the clip** is snapped firmly into place on the frame jamb and the fins are positioned to the inside of the house, lock the operating panels with the cams adjusted all the way in, close the fixed panels over the clips.
7. **The fins** from the clip will make interference with the stile and lock the panel into place.
8. **Once the fixed panels** are locked into place, install the retaining clip. The clip is installed on the interior of the home as well and will fit between the stile of the door and the main frame jamb leg.

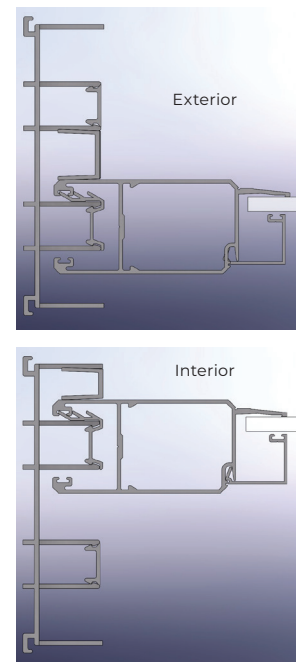


Figure 38

- **Note:** the retaining clip must be installed so that the panel cannot be pushed on from the exterior and disengaged from the fixed panel clip. There are 2 different retaining clips, one for fixed panels that are on the inner most track of the home (Track 1) and one for fixed panel that are on all other tracks. Be sure to reference the test report or Miami-Dade NOA for proper quantity and placement of the fixed panel.
9. **When** the SGD770ND requires an angle bracket, remove the header block if installed, as it is not required. (see Figure 39)
 10. **Install** Bracket on Fixed Panel on top and bottom Interlock. (See Figure 40)

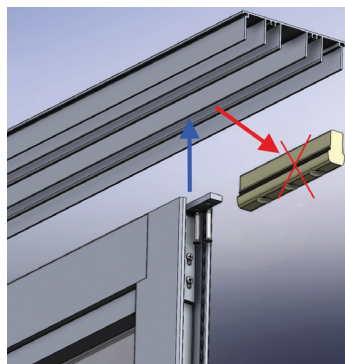


Figure 39



Figure 40

SECTION 11: SCREEN FRAME INSTALLATION (STANDARD SCREEN)

If the unit does not have screens, please skip to the next section. The standard screen rides on the same mainframe as the glass panels with the addition of one sill screen/finishing rail.

11. **Attach** the standard screen rail to the main frame by inserting the tail piece into the main frame sill accessory grove and rotate downward. (See Figure 41)

- **Note:** There are not any anchorage requirements for the screen frame, so attach as needed to hold the screen frame into place.

12. **Seal** under entire length of sill and all frame seams and also apply a small amount of sealant where screen mainframe and glass door main frame meet.

13. **Shim** as necessary to make screen sill plumb, level and square.

- **Note:** If unit is an OXO then the screen astragal adapter and screen astragal will need to be installed. It will be installed at the end of the installation and is in the parts and pieces section of this assembly instruction manual.

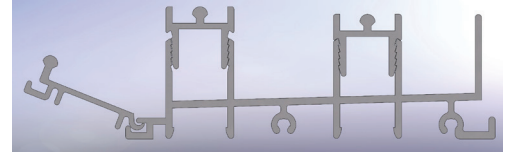


Figure 41

SECTION 12: SCREEN PANEL INSTALLATION (BOX SCREEN)

1. **Position** panel so that top of panel slips into frame header channel. Swing bottom of panel in until bottom of panel is aligned over sill spline and set panel on roller spline. (See Figure 42)
2. **Repeat** procedure, with next in line or outer screen until all screens are installed. Please see the configuration page for the track the screens go on to.
3. **Adjust** screen rollers located at ends of screen panel.
 - **WARNING:** When raising and lowering the wheels, if you feel pressure do not continue as this could cause the adjustment screw to strip. Adjust each screen until all screens roll freely and all screen stiles and frame jambs are parallel.
4. **When screens** are properly adjusted, latch keepers may be installed and raised or lowered to make proper contact with latch P-cam.

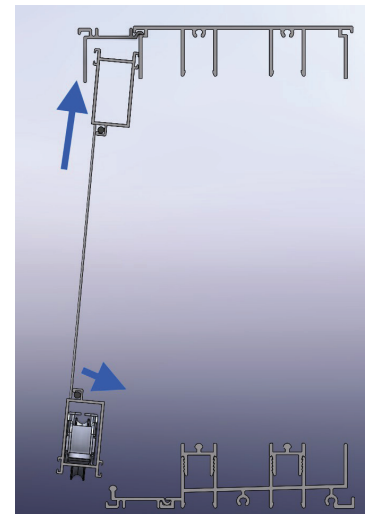


Figure 42

SECTION 13: SCREEN PANEL INSTALLATION (STANDARD SCREEN)

1. **Position** panel so that top of panel slips onto frame header fin. Swing bottom of panel in until bottom of panel is aligned over sill add on fin and set panel roller on fin. (See Figure 43)
2. **Repeat** procedure, with next in line screen until all screens are installed.
3. **Please see** the configuration page for the track the screens go on to.
4. **Adjust** screen rollers located at top and bottom of screen at each end.

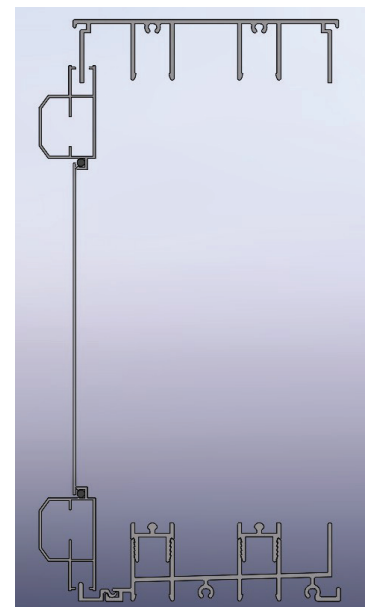


Figure 43

SECTION 14: PARTS AND PIECES

After the above steps have been completed, the unit is operating properly, and is set in place you are ready for the final parts and pieces.

High Pile Dust Plugs

Dust plugs are used to fill any voids where interlocking panels are set in the closed position and require a weather seal. Position two high pile pads above and below the interlocking section of the doors in the closed position.

To do this, mark the area where the doors interlock together in the closed position. Then open the panels and place the high pile pads on the extrusion making sure that the adhesive backing makes good contact to the extrusion. (See Figure 44)

- **Note:** Pocket doors will also require a dust plug added to the head and sill facing the interlocking panel. (See Figure 45)

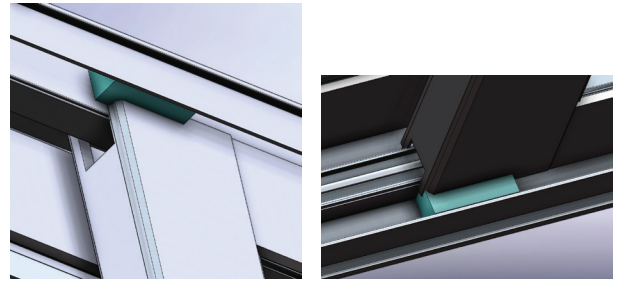


Figure 44

Panel Bumpers

The four hole bumper stop can be used to stop the travel of a panel on a bypass or to keep a panel from rolling off the track when installing a pocket door. For a bypass it should be placed in the header and/or on the sill in such a way to keep the locking handle from making contact with the next door's interlock. On a pocket door unit it should be installed to keep a panel from rolling off of the end of a track. (See Figure 46)

- **Note:** For multiple panel units it may be necessary to also use the panel come-a-long in conjunction with the four hole bumper stops.

Panel Come-A-Long

If the unit is a multi-panel, multi-track or pocket door unit it may be necessary to install panel come-a-longs. This allows the door to open without having to move each panel individually and also keeps the panels from hitting the interlocks or making contact with the handle hardware. They may be installed at the top of the door panel. (See Figure 47)

The come-a-long should be located in front of the vertical stile at the top rail. As the panel moves down the track it will make contact with the panel come-a-long and start driving the next panel down the track. It installs with two number 8" x 1 1/4" sheet metal screws.

When located in the correct position it should leave a gap between the handle and the interlock of the panel.

- **Note:** Installing come-a-longs in the bottom rail of the panel could prohibit the roller from operating correctly as the screw could bind into the roller housing.
- **Note:** Do not locate the part in any other area than shown in the drawing; doing so could cause damage to the frame or glass.

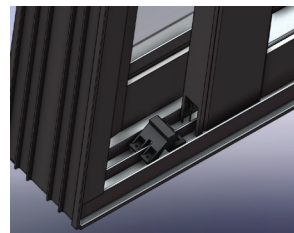


Figure 46

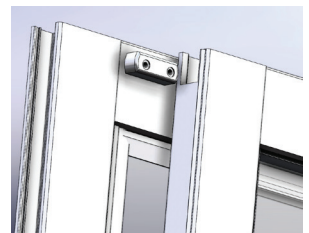


Figure 47

Do not use longer screws; doing so could cause interference or operational problems.

Adjustment Hole Plug

Once the doors are installed and working properly, install the roller adjustment hole plugs. There are two per operable panel and should be located on the outside face of the door. (See Figure 48)



Figure 48

Screen Astragal and Screen Astragal Adapter

If the unit has screens and is an OXO configuration, then the screen astragal and screen astragal adapter will need to be installed. Slide the screen astragal into the screen astragal adapter. Take the assembled part and install it onto the astragal base. This is applied to the exterior of the stationary panel's astragal base as shown in the drawing.

Use four #10 x 3/4" self drilling screws to attach the astragal adapter and astragal to the glass panels astragal base. Once installed latch keepers may be installed and raised or lowered to make proper contact with latch P-cam. Caulk any seams where the astragal adapter and astragal meets head or sill. (See Figure 49)

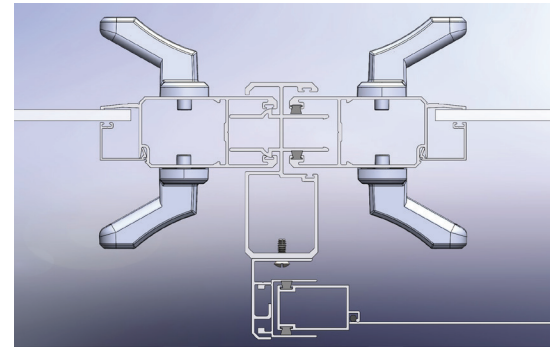


Figure 49

Final Screw Covers

Once the installation is complete, install any remaining screw covers. This includes screw covers that need to be cut to size that fit above and below the frame jamb keepers or astragal keepers. If the unit is a pocket door, there will also be a screw cover for the screws on the P-hook.

SECTION 15: SPECIAL FEATURE NOTE:

This door has unique features that allow for versatility in the field.

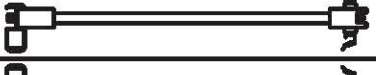
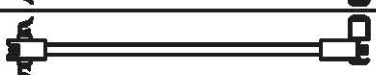
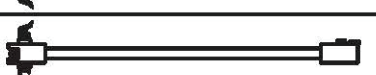
Changing the Stack:

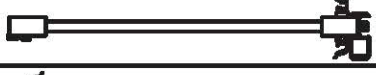
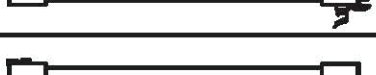
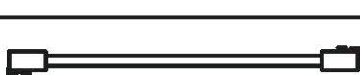
The interlock design used on this product allows the panels to move from interior tracks to outer tracks thus reversing the stack of the unit without requiring the glass to be deglazed from the product. Not all units are capable of stack reversal. See Configuration Drawings to verify.

Steps to reversing the stack:

1. Remove the panel from the opening
 2. Lay the panel down on a saw horse or supported surface
 3. Remove the interlock screw cover
 4. Remove the screws attaching the interlock to the stile
 5. Slide the interlock off the top or bottom, notice the two barbs that fit inside the weather-strip groove
 6. Flip the interlock so that it is now facing the other direction
 7. Slide the interlock back into place making sure the barbs are in the weather-strip groove.
 8. Reinstall the interlock screws
 9. Reattach the interlock screw cover
 10. Reinstall the panel
- **Note:** There is a flat edge and a slanted edge of the interlock screw cover, be sure that the slanted edge is on the opposite side of the interlock hook. When attaching the interlock screw cover make sure not to cover the top panel notch. Covering the top panel notch will not allow the reinstallation of the panel. Last, changing the stack will not change a fixed panel to an operable panel (an XO will be still be an XO).

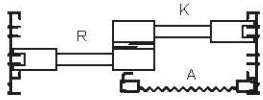
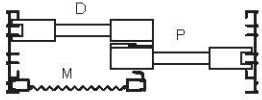
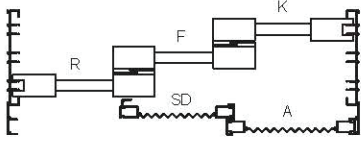
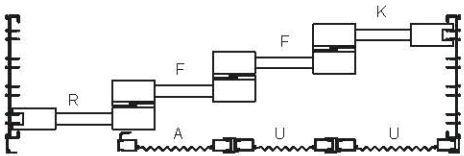
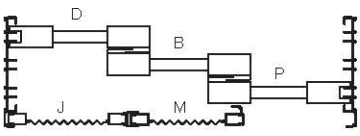
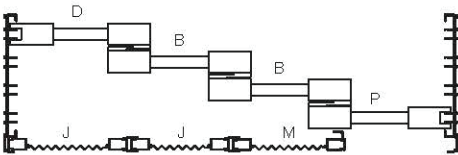
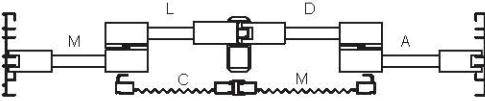
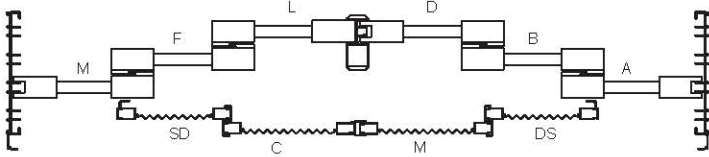
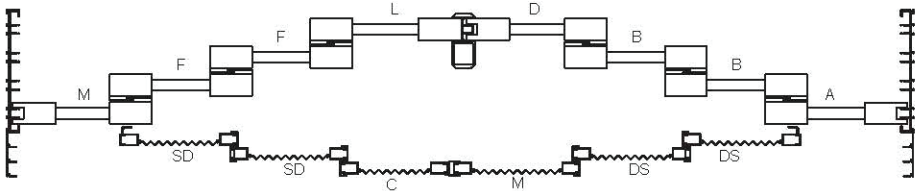
If you require additional help in reversing the stack or changing the configuration, please contact a PGT Sales or Customer Service Representative.

OPERABLE - PANEL TYPES			
PANEL LETTER			
K	SINGLE INTERLOCK		LOCKSTILE
U (BOX OUT)	ASTRAGAL OUT		LOCKSTILE
U (BOX IN)	ASTRAGAL IN		LOCKSTILE
A	SINGLE INTERLOCK		LOCKSTILE
D	LOCKSTILE		SINGLE INTERLOCK
J (BOX OUT)	LOCKSTILE		ASTRAGAL OUT
J (BOX IN)	LOCKSTILE		ASTRAGAL IN
M	LOCKSTILE		SINGLE INTERLOCK

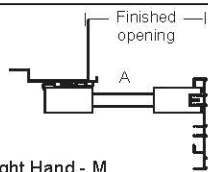
INTERMEDIATE - PANEL TYPES			
PANEL LETTER			
L (BOX OUT)	SINGLE INTERLOCK		ASTRAGAL OUT
LR (BOX OUT)	ASTRAGAL OUT		SINGLE INTERLOCK
N (BOX OUT)	ASTRAGAL IN		SINGLE INTERLOCK
C (BOX IN)	SINGLE INTERLOCK		ASTRAGAL IN
B	SINGLE INTERLOCK		SINGLE INTERLOCK
F	SINGLE INTERLOCK		SINGLE INTERLOCK
E	SINGLE INTERLOCK		SINGLE INTERLOCK

FIXED - PANEL TYPES			
PANEL LETTER			
P	SINGLE INTERLOCK		FIXED LOCKSTILE
R	FIXED LOCKSTILE		SINGLE INTERLOCK
T (BOX OUT)	ASTRAGAL OUT		FIXED LOCKSTILE
T (BOX IN)	ASTRAGAL IN		FIXED LOCKSTILE
S (BOX OUT)	FIXED LOCKSTILE		ASTRAGAL OUT
S (BOX IN)	FIXED LOCKSTILE		ASTRAGAL IN

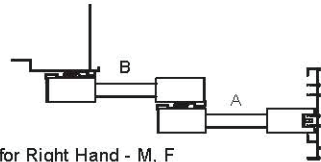
TYPE	STANDARD	REVERSE
2P3T XX BOX SCREEN		
3P3T OXO BOX SCREEN		
3P4T XXX BOX SCREEN		
3P5T XXX BOX SCREEN		
4P3T OXOX BOX SCREEN		SAME AS STANDARD STACK
4P5T XXXX BOX SCREEN		
4P7T XXXX BOX SCREEN		
TYPE	STANDARD STACK	
6P5T OXXXXO BOX SCREEN		
8P7T OXXXXXXO BOX SCREEN		

TYPE	STANDARD	REVERSE
2P3T OX BOX SCREEN	N/A ORDER AS XO	
2P2T XO BOX SCREEN		N/A ORDER AS OX
3P4T OXX BOX SCREEN	N/A ORDER AS XXO	
4P5T OXXX BOX SCREEN	N/A ORDER AS XXXO	
3P4T XXO BOX SCREEN		N/A ORDER AS OXX
4P5T XXXO BOX SCREEN		N/A ORDER AS OXXX
4P3T XXXX BOX SCREEN		SAME AS STANDARD STACK
TYPE	STANDARD STACK	
6P5T XXXXXX BOX SCREEN		
8P7T XXXXXXXX BOX SCREEN		

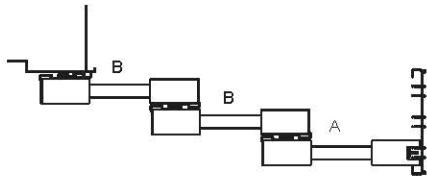
LEFT HAND POCKETS



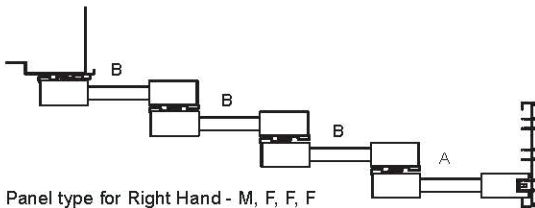
Panel type for Right Hand - M



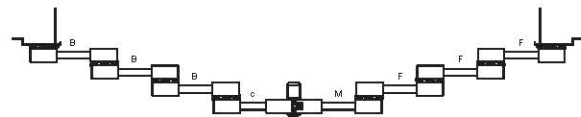
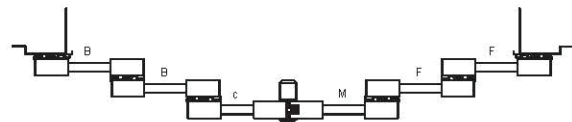
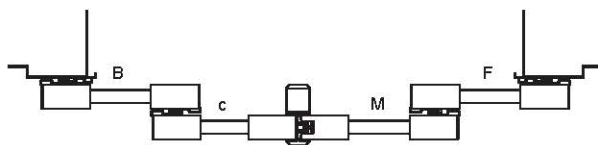
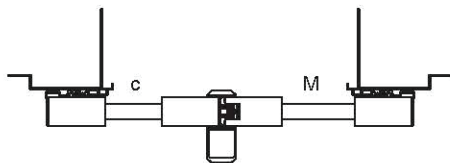
Panel type for Right Hand - M, F



Panel type for Right Hand - M, F, F



Panel type for Right Hand - M, F, F, F



OUTSIDE CORNER LEFT SIDE CONFIGURATIONS

TYPE	PRIMARY	SECONDARY
2P2T XX		
3P3T XXX		
4P4T XXXX		
2P2T OX		
3P3T OXX		
4P4T OXXX		

OUTSIDE CORNER RIGHT SIDE CONFIGURATIONS

TYPE	PRIMARY	SECONDARY
2P2T XX		
3P3T XXX		
4P4T XXXX		
2P2T XO		
3P3T XXO		
4P4T XXXO		

OUTSIDE CORNER POCKET CONFIGURATIONS

TYPE	PRIMARY LEFT HAND POCKETS
1P2T 1 POCKET	
2P2T 1 POCKET	
3P3T 1 POCKET	
4P4T 1 POCKET	

TYPE	SECONDARY LEFT HAND POCKETS
1P2T 1 POCKET	
2P2T 1 POCKET	
3P3T 1 POCKET	
4P4T 1 POCKET	

TYPE	PRIMARY RIGHT HAND POCKETS
1P2T 1 POCKET	
2P2T 1 POCKET	
3P3T 1 POCKET	
4P4T 1 POCKET	

TYPE	SECONDARY RIGHT HAND POCKETS
1P2T 1 POCKET	
2P2T 1 POCKET	
3P3T 1 POCKET	
4P4T 1 POCKET	

INSIDE CORNER LEFT SIDE CONFIGURATIONS

TYPE	PRIMARY	SECONDARY
2P2T XX		
3P3T XXX		
4P4T XXXX		
2P2T OX		
3P3T OXX		
4P4T OXXX		

INSIDE CORNER RIGHT SIDE CONFIGURATIONS

TYPE	PRIMARY	SECONDARY
2P2T XX		
3P3T XXX		
4P4T XXXX		
2P2T XO		
3P3T XXO		
4P4T XXO		

INSIDE CORNER POCKET CONFIGURATIONS

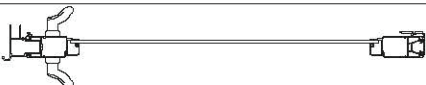
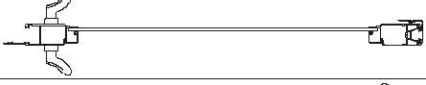
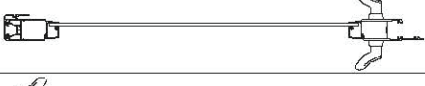
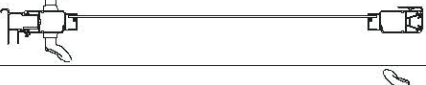
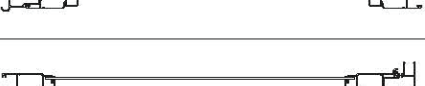
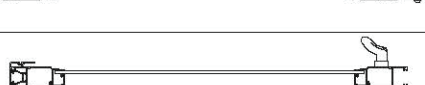
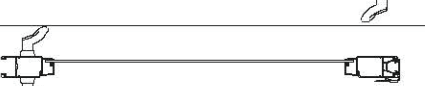
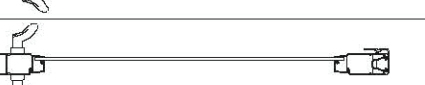
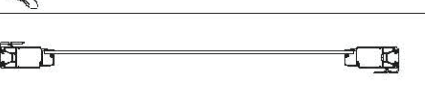
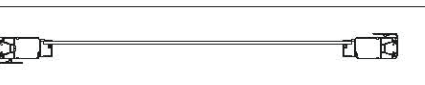
TYPE	PRIMARY LEFT HAND POCKETS
1P2T 1 POCKET	
2P2T 1 POCKET	
3P3T 1 POCKET	
4P4T 1 POCKET	

TYPE	SECONDARY LEFT HAND POCKETS
1P2T 1 POCKET	
2P2T 1 POCKET	
3P3T 1 POCKET	
4P4T 1 POCKET	

TYPE	PRIMARY RIGHT HAND POCKETS
1P2T 1 POCKET	
2P2T 1 POCKET	
3P3T 1 POCKET	
4P4T 1 POCKET	

TYPE	SECONDARY RIGHT HAND POCKETS
1P2T 1 POCKET	
2P2T 1 POCKET	
3P3T 1 POCKET	
4P4T 1 POCKET	

CORNER - PANEL TYPES

PANEL LETTER			
CS	CORNER RECEIVER		SINGLE INTERLOCK
SC	SINGLE INTERLOCK		CORNER RECEIVER
QS	CORNER LOCKSTILE		SINGLE INTERLOCK
SQ	SINGLE INTERLOCK		CORNER LOCKSTILE
AS	CORNER RECEIVER		SINGLE INTERLOCK
SA	SINGLE INTERLOCK		CORNER RECEIVER
CI	CORNER LOCKSTILE		SINGLE INTERLOCK
IC	SINGLE INTERLOCK		CORNER LOCKSTILE
CF	CORNER RECEIVER		FIXED LOCKSTILE
FC	FIXED LOCKSTILE		CORNER RECEIVER
A	SINGLE INTERLOCK		LOCKSTILE
D	LOCKSTILE		SINGLE INTERLOCK
M	LOCKSTILE		SINGLE INTERLOCK
B	SINGLE INTERLOCK		SINGLE INTERLOCK
F	SINGLE INTERLOCK		SINGLE INTERLOCK
K	SINGLE INTERLOCK		LOCKSTILE
RR	FIXED LOCKSTILE		SINGLE INTERLOCK
PP	SINGLE INTERLOCK		FIXED LOCKSTILE

SLIDING GLASS DOOR 670/770/770NS



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