

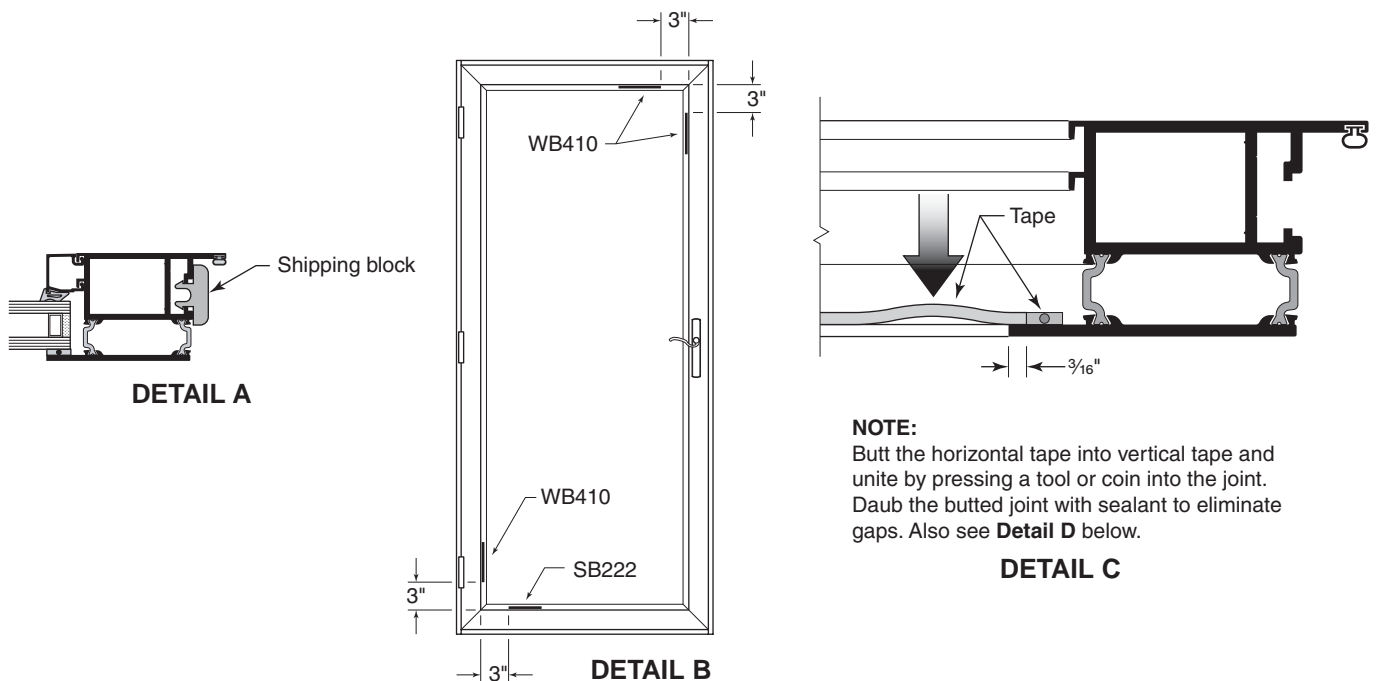
# SERIES 900 TERRACE DOOR INSTALLATION AND GLAZING INSTRUCTIONS

## GLAZING

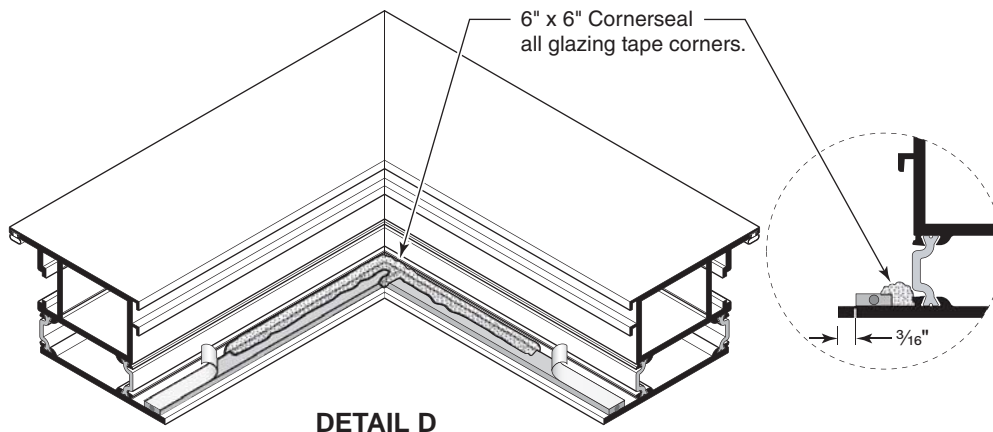
**GLASS SIZE = Daylight Opening (D.L.O.) + 1" (25.4)**

**NOTE: This formula does not take into account glass tolerances.  
Consult glass manufacturer before ordering glass.**

1. Remove temporary shipping blocks located at top and bottom rails and hinge and lock stiles. See Detail A.
2. Clean glazing fins with solvent prior to applying pre-shimmed glazing tape.
3. Apply glazing tape to stiles (D.L.O. + 1 1/8"), inset 3/16" to allow for cap bead. Apply tape to the top and bottom rails, butting tight to the vertical tape, leaving an extra amount at each end to insure a tight joint. See Detail C.
4. Place WB410 walk blocks in door as shown in Detail B.
5. Cut wedge gasket to size. Gaskets should be cut 1/8" longer per foot of D.L.O. to allow for shrinkage.
6. Place SB222 setting block as shown in Detail B.

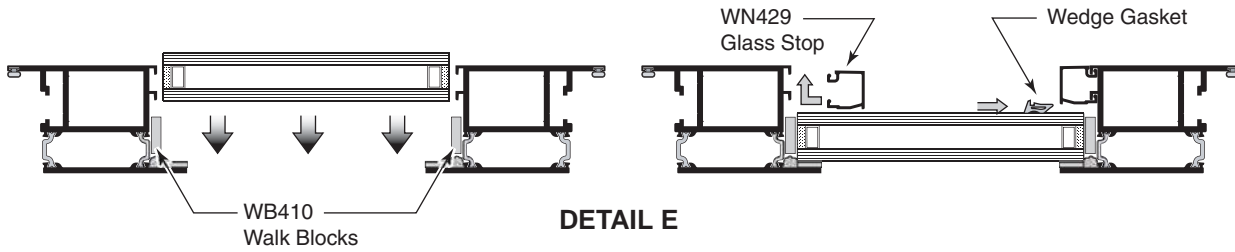


7. Clean glass edges with solvent. Avoid touching edges after cleaning.
  8. Prior to glazing, peel protective paper from the glazing tape. **DO NOT TOUCH** exposed tape surfaces with fingers or any tool. See Detail E.
  9. Apply 6" x 6" bead of silicone sealant at each corner of glazing tape. Sealant should fill reveal and cover approximately half of inside edge of tape as shown in Detail D.
- NOTE: Door should be glazed while sealant is wet.**



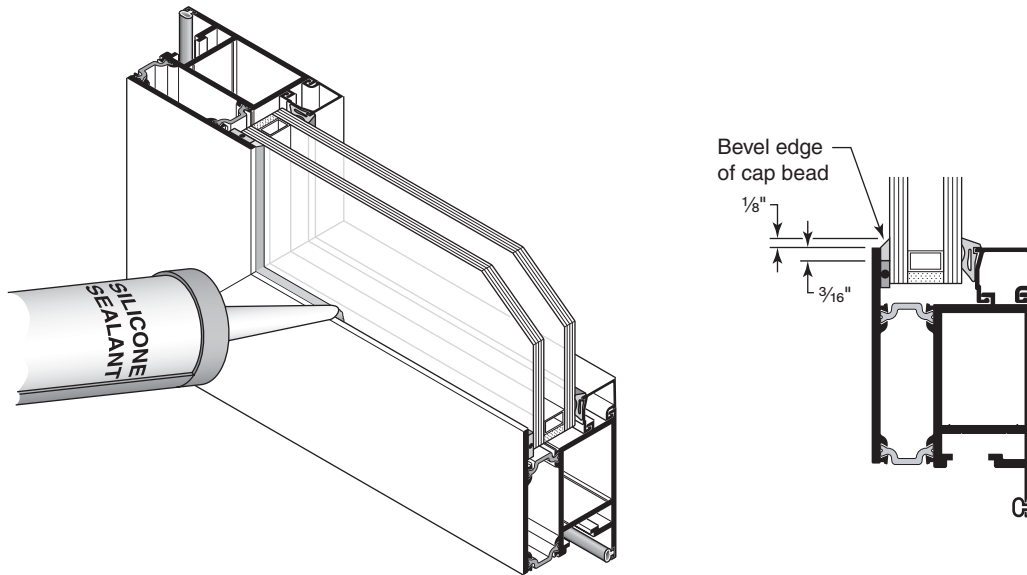
## GLAZING

- Place glass square into opening pressing firmly against glazing tape.
- Install glass stops and wedge gaskets immediately. See Detail E.



DETAIL E

- Apply a cap bead of silicone full perimeter between glazing fin and glass injecting sealant full depth of recess. Sealant edge should be beveled as shown in Detail F.

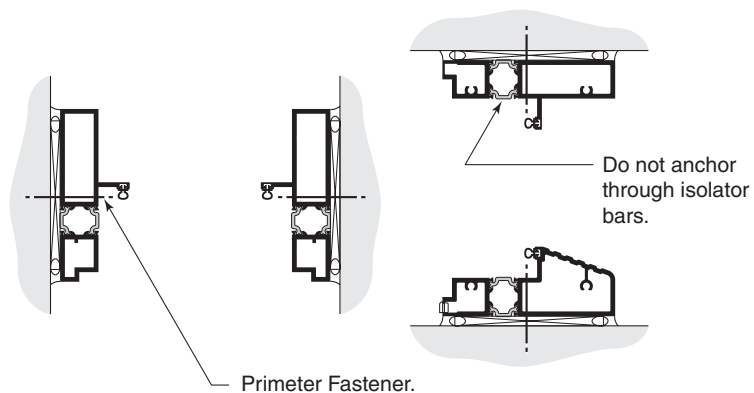


DETAIL F

## INSTALLATION

- Anchor frame plumb and square shim as required. Seal head of each screw at anchor locations and tool sealant. **Consult U.S. Aluminum for perimeter screw type and locations prior to anchoring.**
- Seal interior and exterior perimeter shim space. Tool sealant.

**NOTE:**  
Bulb gasket must be temporarily removed prior to drilling and installing fasteners.  
No screws allowed through isolator bars.



DETAIL G