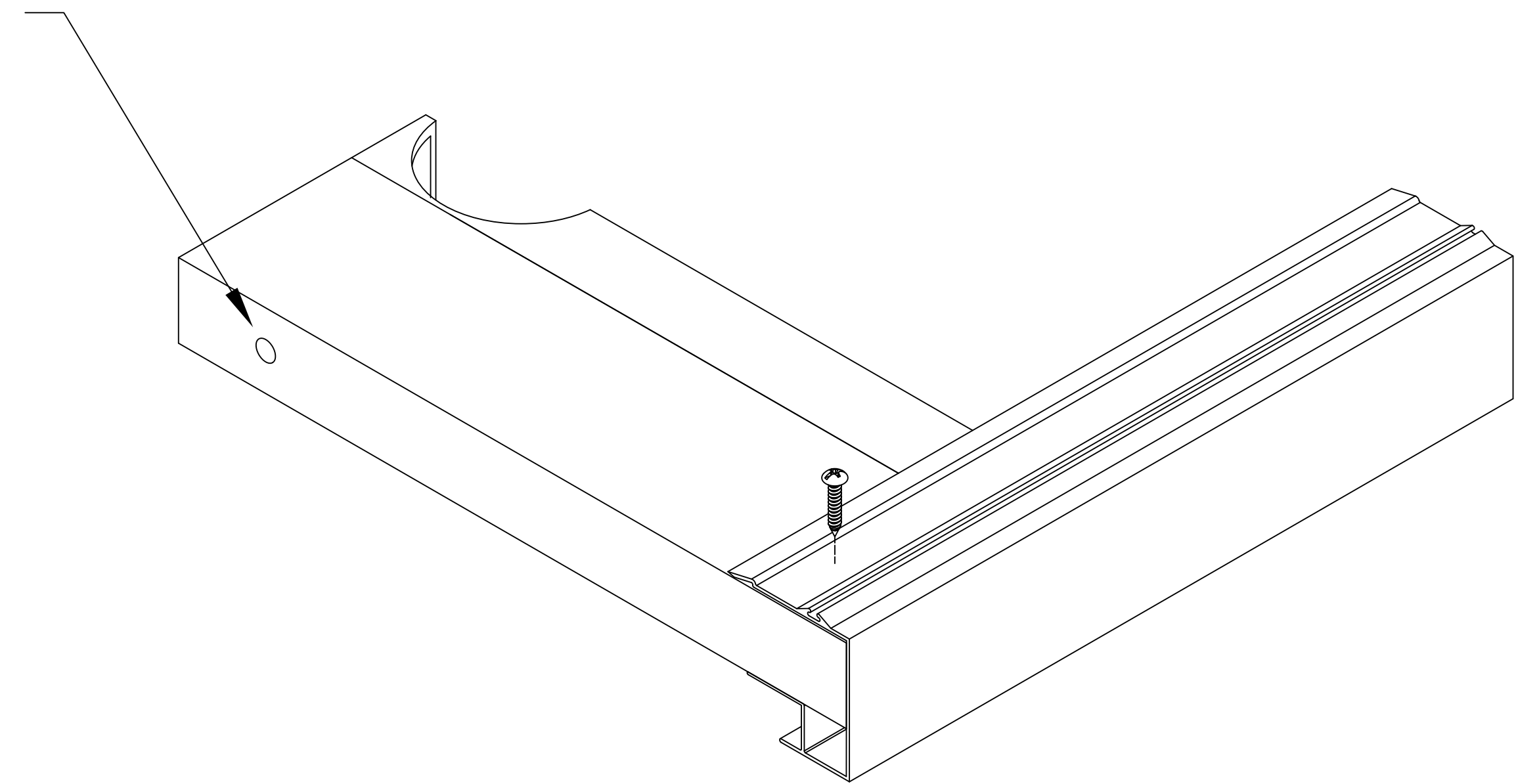




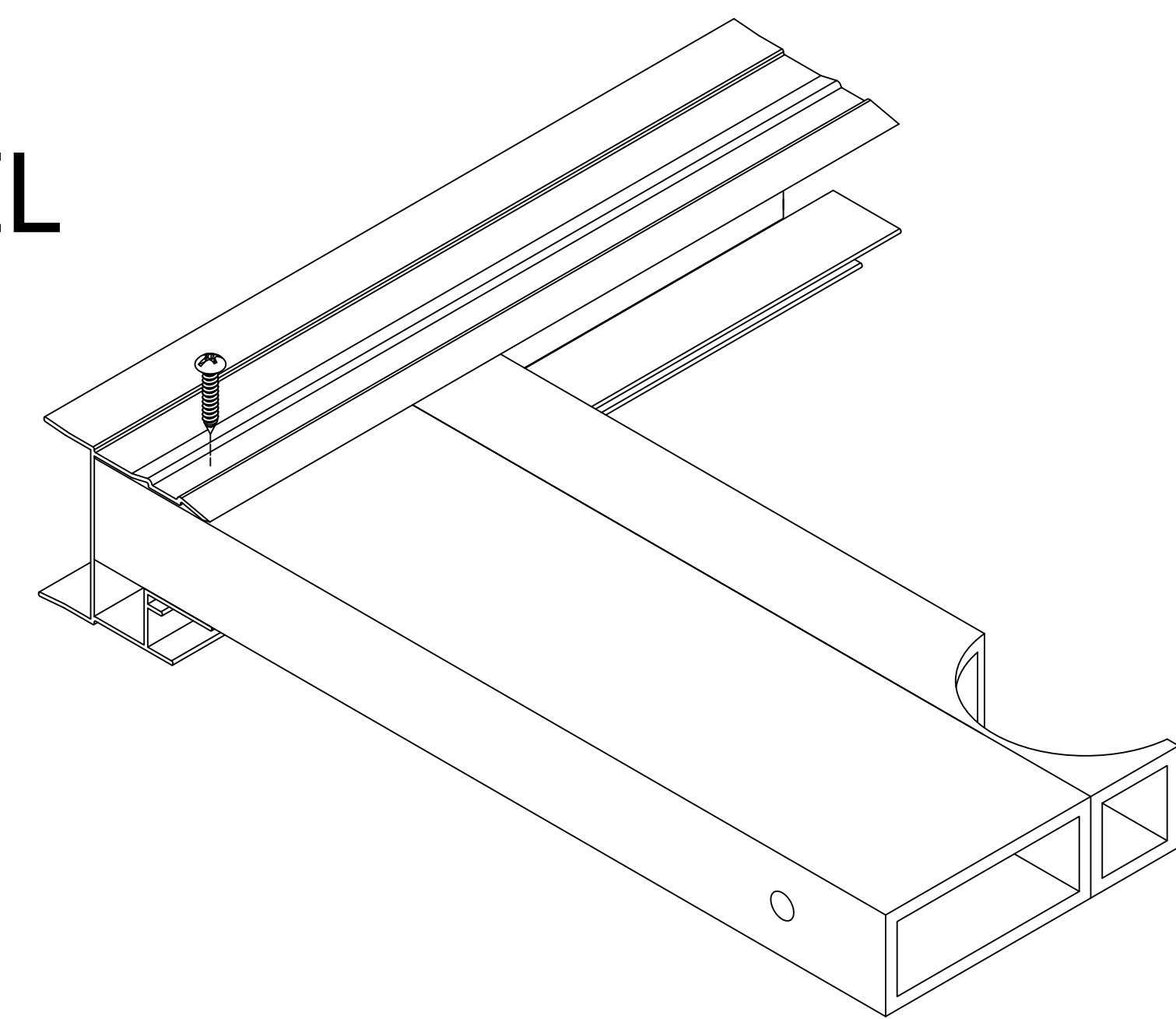
ARCADIAN SLIDER XX DOOR ASSEMBLY INSTRUCTIONS

FACTORY DRILLED
1/2" TROLLEY HOLE

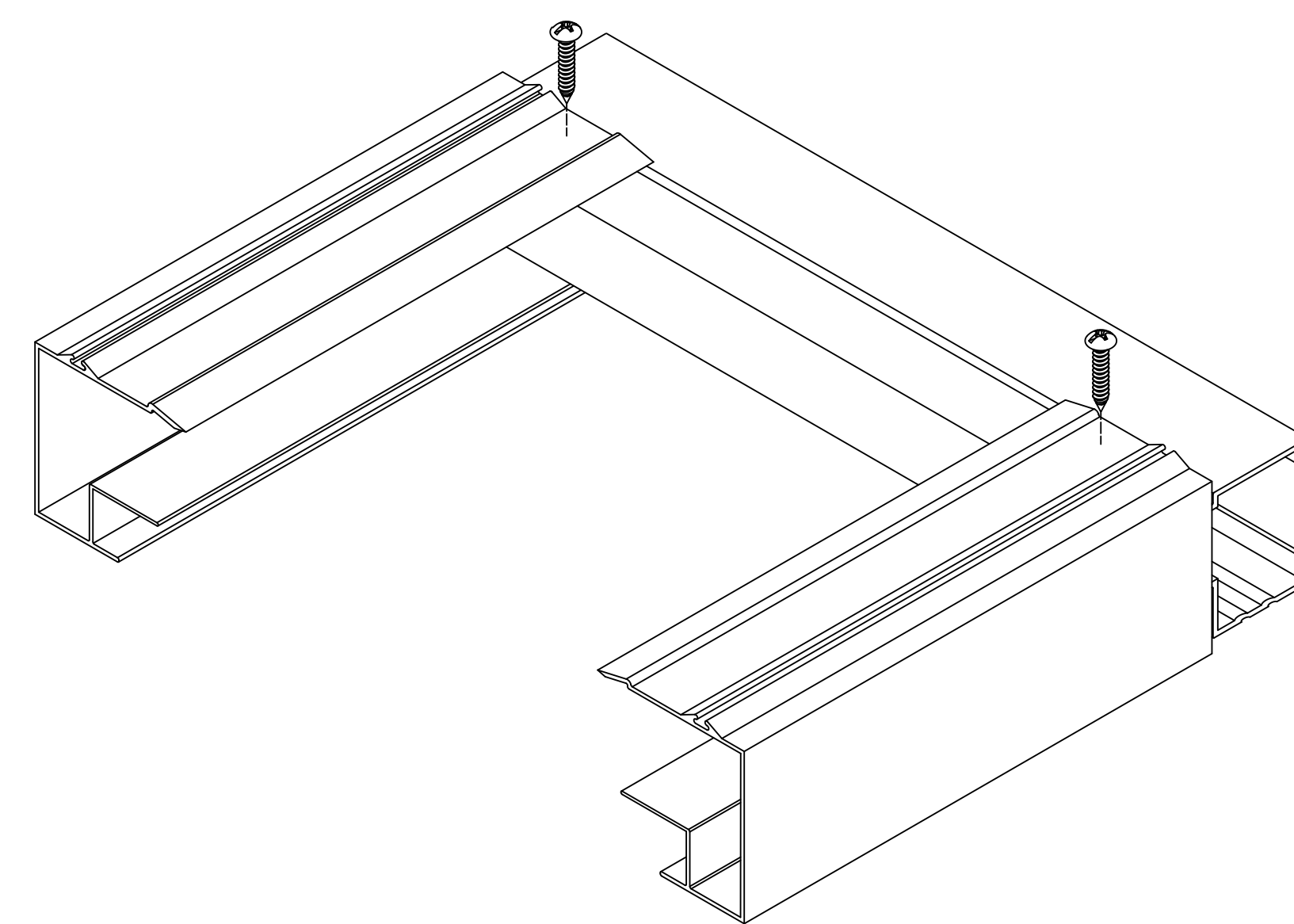


- ① DOOR ASSY PROCESS IS STARTED WITH DOOR FACE DOWN. INSERT THE HEADER ASSEMBLY INTO THE ALUMINUM SIDE RAIL AND FASTEN AT TOP WITH (1) #10 X 1" SELF DRILLER. (OTHER SCREWS ARE ADDED AFTER DOOR IS SQUARE)

H RAIL



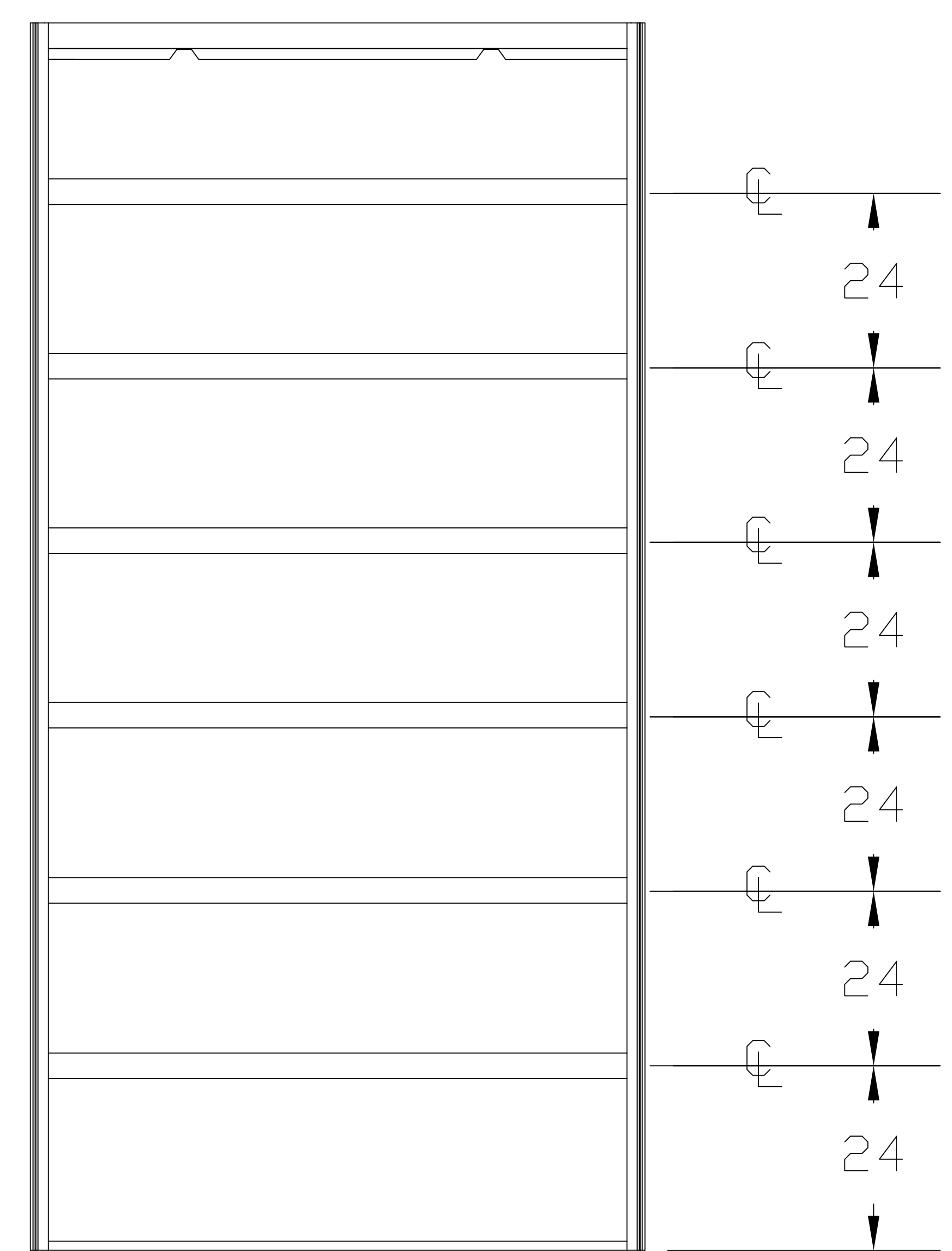
- ② INSERT SIDE RAIL OR H RAIL ON TO OTHER SIDE OF THE HEADER ASSEMBLY AND FASTEN WITH (1) #10 X 1" SELF DRILLER. ONE H RAIL IS PROVIDED ON SPLIT DOOR APPLICATIONS AS SHOWN.



- ③ INSERT THE BOTTOM RAIL WITH GUIDE INTO THE SIDE RAILS AND FASTEN WITH (2) #10 X 1" SELF DRILLERS. (OTHER SCREWS ARE ADDED AFTER DOOR IS SQUARE)

- ④ POSITION BOX GIRTS 24" ON CENTER APART, STARTING FROM THE BOTTOM OF THE DOOR AND CHECK DOOR FOR SQUARENESS. FASTEN EACH GIRT WITH (1) SELF DRILLER AT THIS TIME.

IF DOOR HEIGHT =	# OF BOX GIRTS
8'	3
10'	4
12'	5
14'	6





ARCADIAN SLIDER XX DOOR ASSEMBLY INSTRUCTIONS

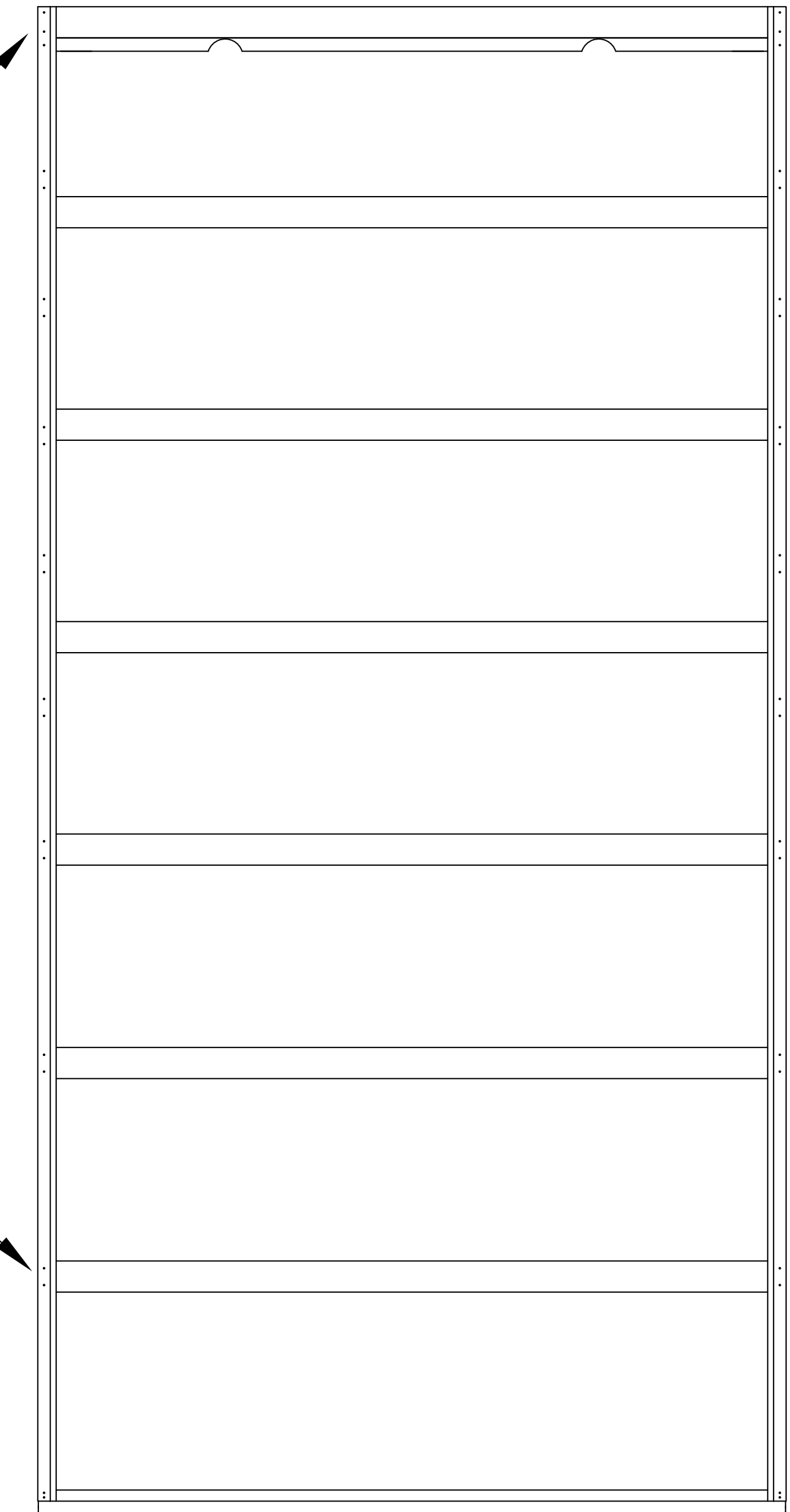
⑤ RECHECK DIAGONAL DIMENSIONS FOR SQUARENESS AND FASTEN ALL GIRTS AND HEADER ASSEMBLY WITH A SECOND SELF DRILLING FASTENER

⑥ TURN DOOR OVER AND CHECK SQUARENESS.

⑦ POSITION PLYWOOD (WE RECOMMEND 3/8" PLYWOOD) AS SHOWN AND FASTEN WITH #10 X 1" SELF DRILLERS 12" O.C. HORIZONTALLY AND VERTICALLY. PLYWOOD PROVIDED BY CONTRACTOR IF PURCHASED AS A KIT.

(3) SELF DRILLERS IN EACH END OF HEADER ASSEMBLY

(2) SELF DRILLERS IN EACH END OF ALL GIRTS



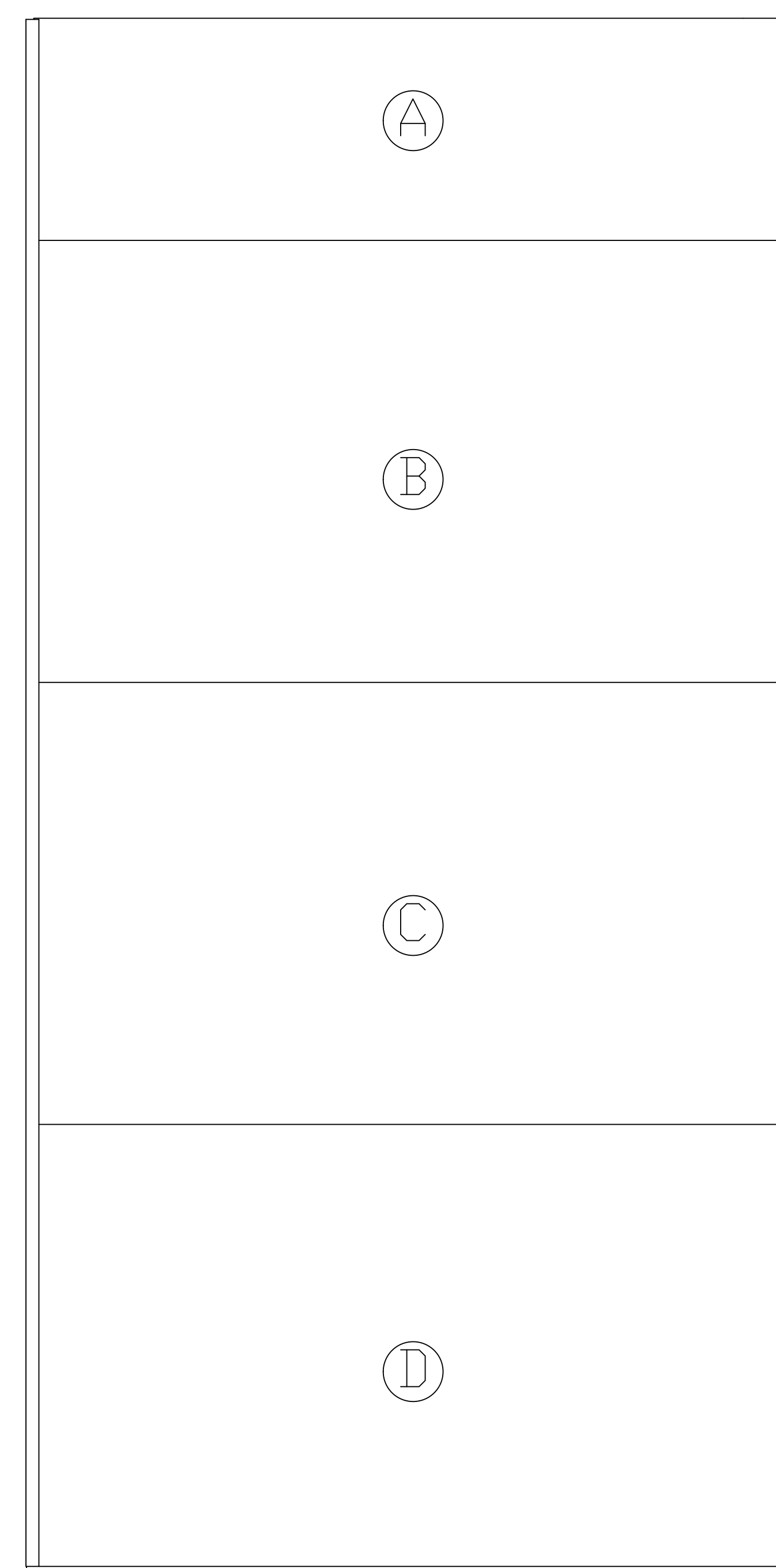
PLYWOOD CUT WIDTH

IF DOOR WIDTH =	A	B	C	D
4'	45.688	45.688	45.688	45.688
5'	57.688	57.688	57.688	57.688
6'	69.688	69.688	69.688	69.688
7'	81.688	81.688	81.688	81.688

PLYWOOD CUT HEIGHT

IF DOOR HEIGHT =	A	B	C	D
8'	48	48	X	X
10'	24	48	48	X
12'	48	48	48	X
14'	24	48	48	48

EX. FOR A 7X14 XX- PLYWOOD =
 A 81.688 X 22.5
 B 81.688 X 48
 C 81.688 X 48
 D 81.688 X 48





ARCADIAN SLIDER XX DOOR ASSEMBLY INSTRUCTIONS

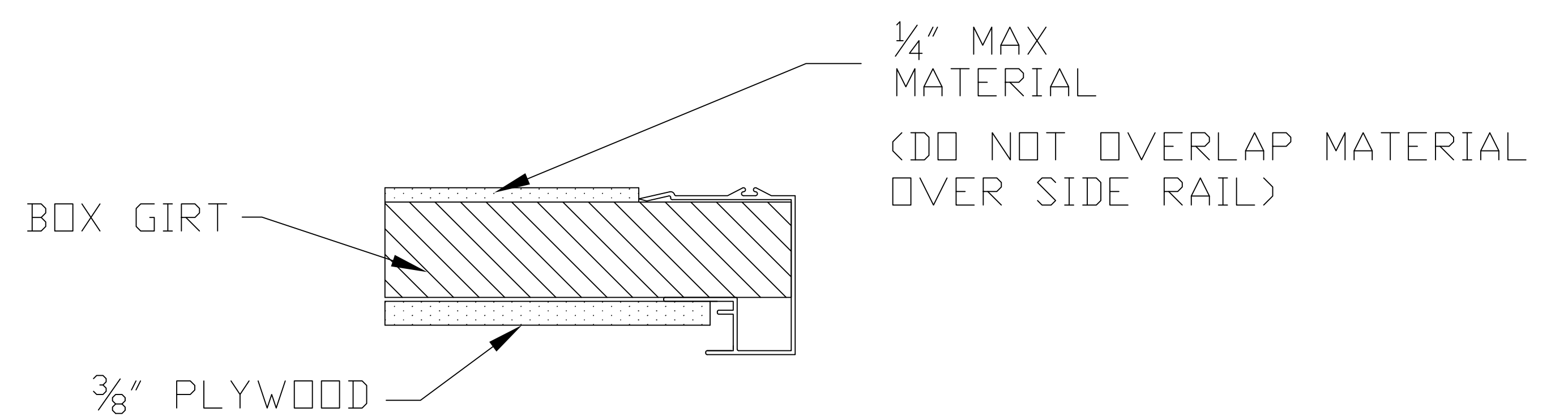
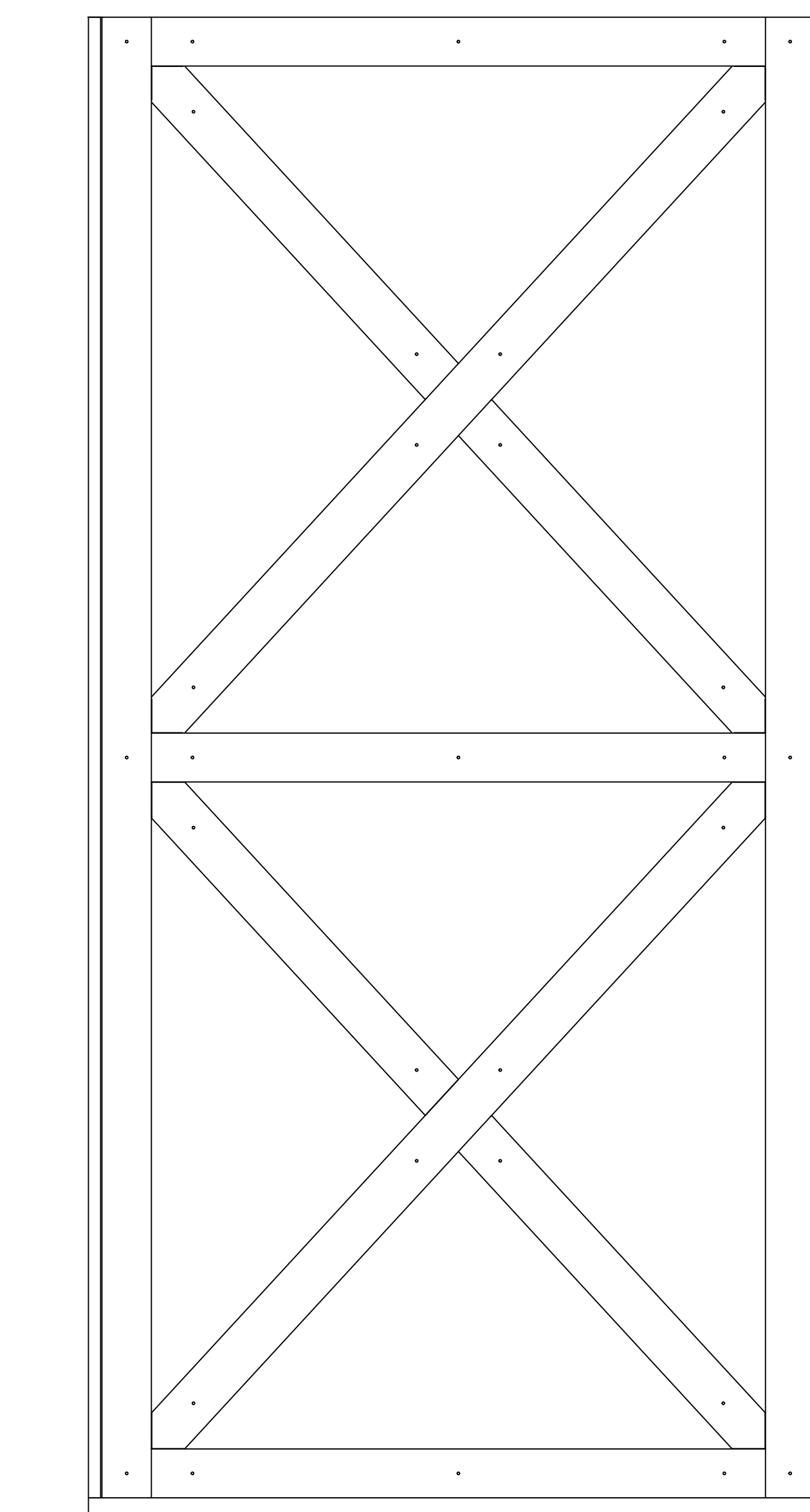
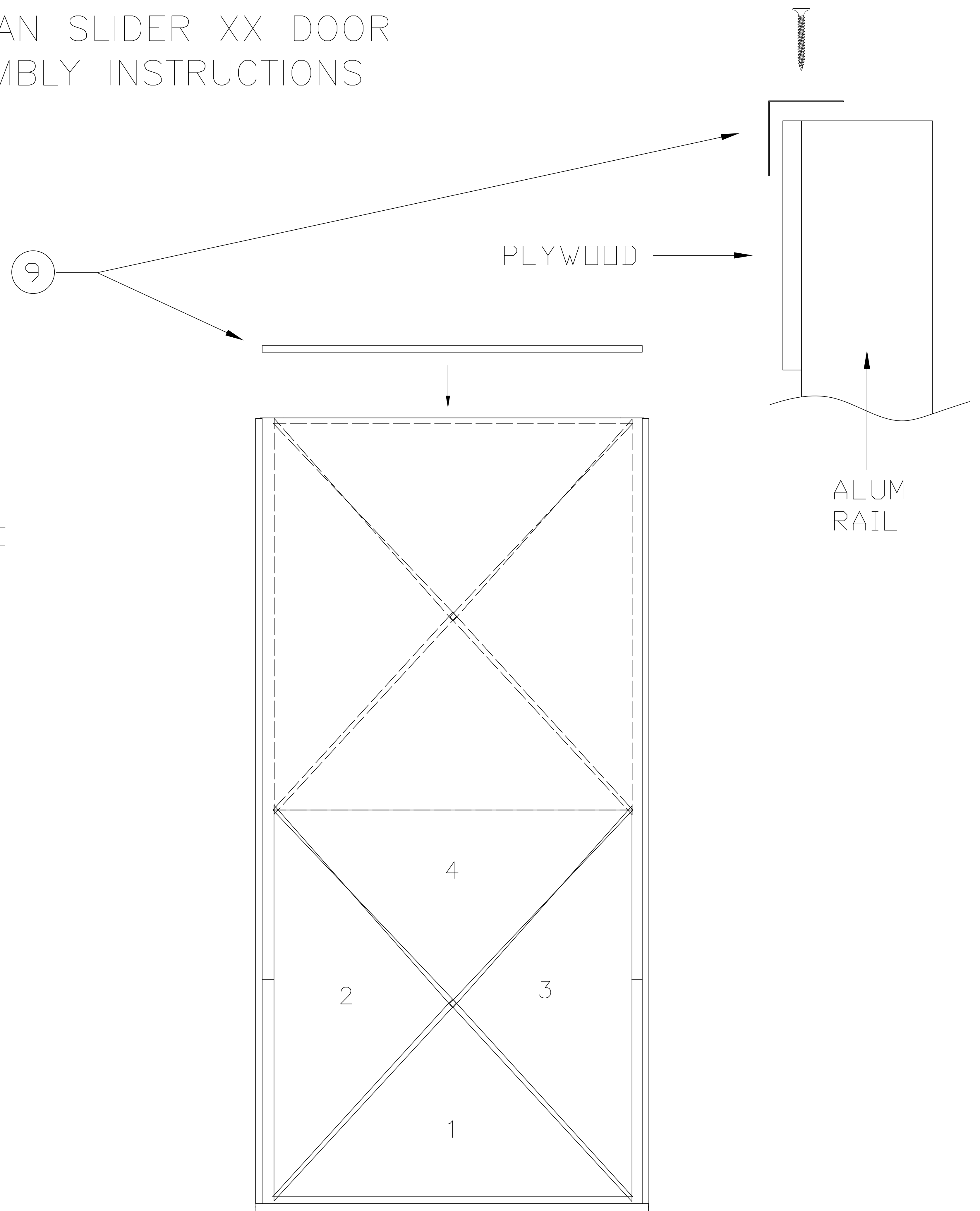
⑧ ATTACH 29GA INSERT PANELS IN THE ORDER SHOWN TO CREATE SHINGLE EFFECT. EACH NUMBER SIGNIFIES WHEN THAT PART GETS LAID DOWN ONTO PLYWOOD. THERE IS APPROXIMATELY A 2" OVERLAP ALLOWED. LAMINATE STEEL TO PLYWOOD USING A HIGH PERFORMANCE LAMINATE ADHESIVE. (ADHESIVE NOT SUPPLIED WITH KIT)

⑨ CUT DOWN TOP TRIM TO APPROPRIATE LENGTH AND ATTACH TO TOP OF DOOR USING #10 X 1" SELF DRILLERS.

⑩ LOOSE ASSEMBLE TRIM PIECES. PLACE VERTICAL TRIMS IN POSITION FIRST. PLACE HORIZONTAL AND X-BUCK TRIM IN POSITION, WORKING FROM THE BOTTOM OF THE DOOR UP. USE THE HORIZONTAL TRIMS TO ESTABLISH THE SPACING BETWEEN THE VERTICALS. USE MID HORIZONTAL TO INSURE THAT CROSS BUCKS FIT TIGHTLY. USE #10 X 2" PAINTED SELF DRILLERS ON VERTICAL AND HORIZONTAL. USE #10 X 1" PAINTED FOR CROSSBUCKS.

⑪ INSTALL DOOR PULL AND TBSG DOOR GUIDE. TRACK AND TROLLEYS ARE PROVIDED BY CONTRACTOR AS WELL AS PLYWOOD IF SHIPPED IN KIT FORM.

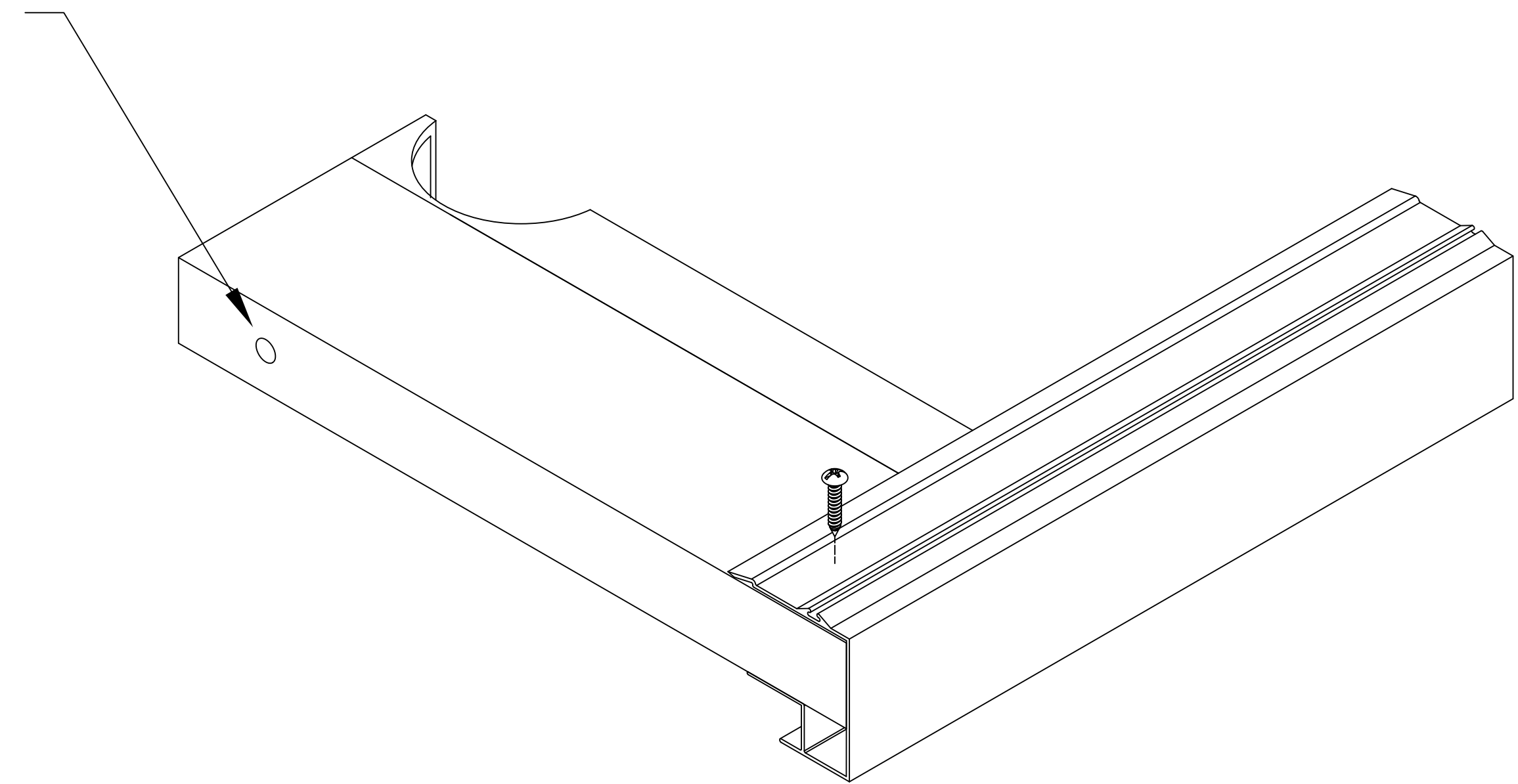
⑫ AT OWNERS DISCRETION, BACK OF DOOR CAN BE COVERED WITH 1/4" MAX THICKNESS MATERIAL. (PLYWOOD, PLASTIC, MASONITE, ETC...) (CUSTOMER SUPPLIED MATERIAL AND FASTENERS)





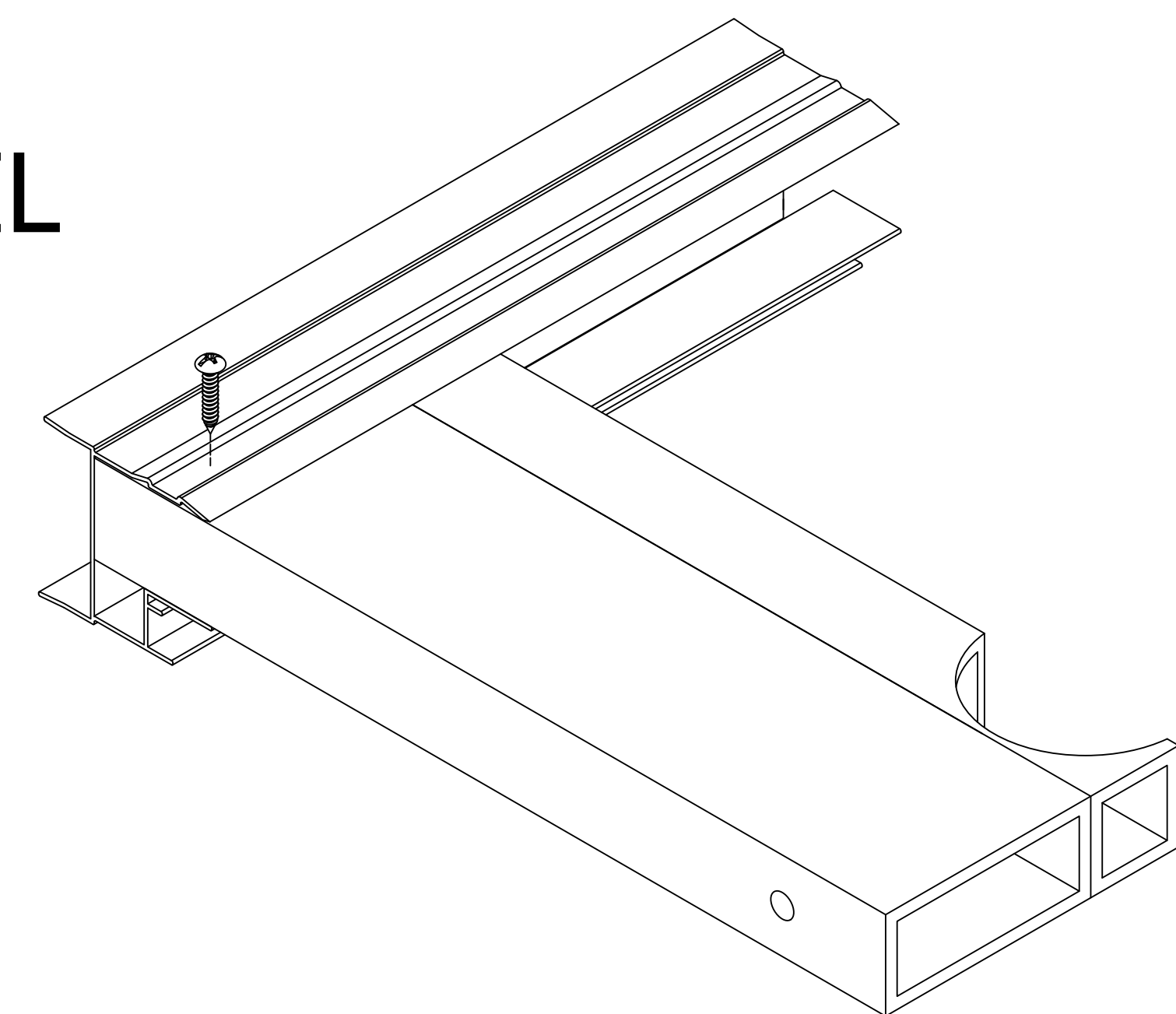
ARCADIAN SLIDER XX DOOR ASSEMBLY INSTRUCTIONS

FACTORY DRILLED
1/2" TROLLEY HOLE

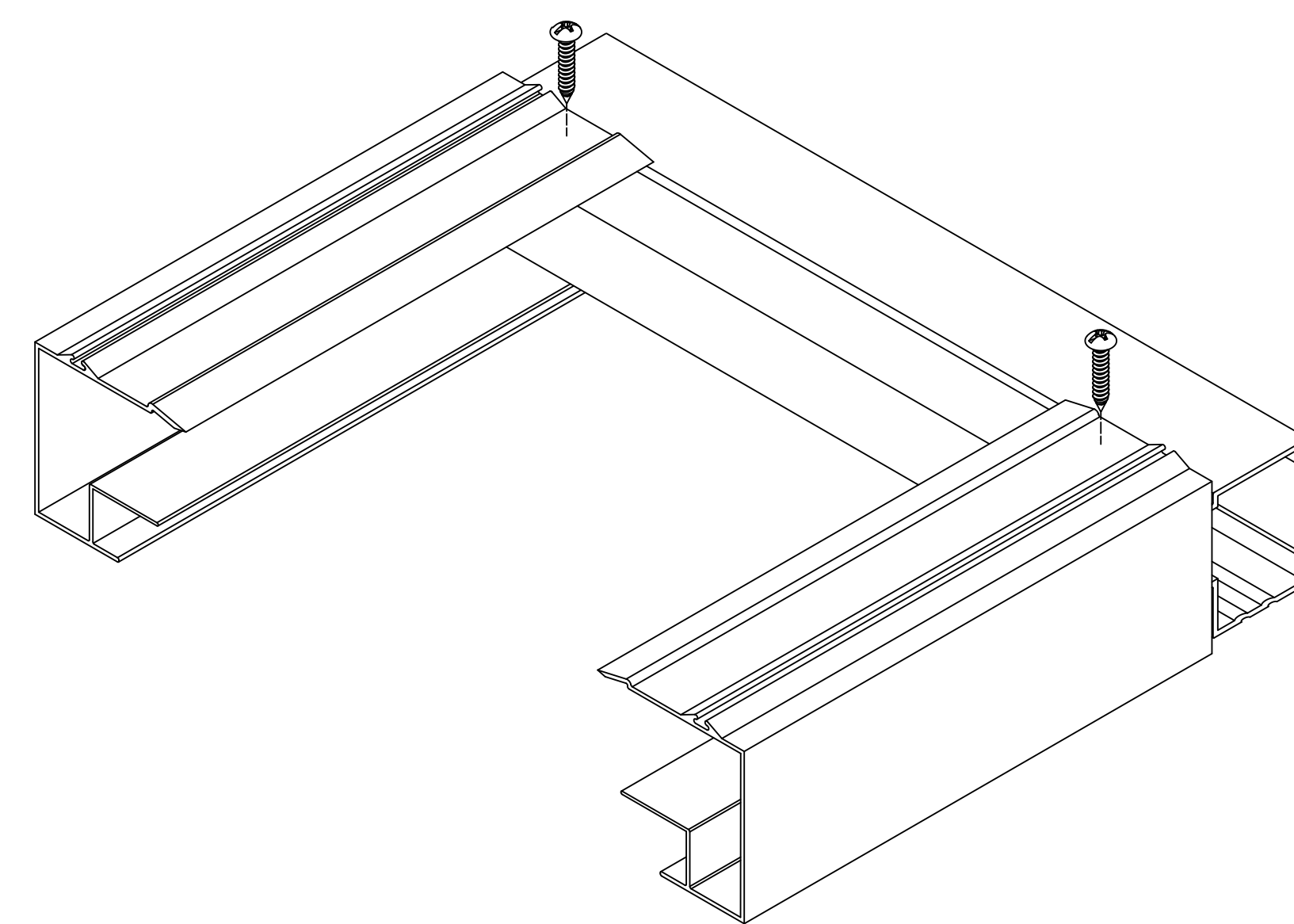


- DOOR ASSY PROCESS IS STARTED WITH DOOR FACE DOWN. INSERT THE HEADER ASSEMBLY INTO THE ALUMINUM SIDE RAIL AND FASTEN AT TOP WITH (1) #10 X 1" SELF DRILLER. (OTHER SCREWS ARE ADDED AFTER DOOR IS SQUARE)

H RAIL



- INSERT SIDE RAIL OR H RAIL ON TO OTHER SIDE OF THE HEADER ASSEMBLY AND FASTEN WITH (1) #10 X 1" SELF DRILLER. ONE H RAIL IS PROVIDED ON SPLIT DOOR APPLICATIONS AS SHOWN.



- INSERT THE BOTTOM RAIL WITH GUIDE INTO THE SIDE RAILS AND FASTEN WITH (2) #10 X 1" SELF DRILLERS. (OTHER SCREWS ARE ADDED AFTER DOOR IS SQUARE)

- DOOR WIDTH DETERMINES HOW MANY BOX GIRTS ARE USED. IF DOOR IS 4' OR 5' WIDE, POSITION BOX GIRTS 24" ON CENTER APART. IF DOOR IS 6' OR 7' WIDE POSITION BOX GIRTS 16" ON CENTER APART. MAKE SURE TO START POSITIONING BOX GIRTS FROM THE BOTTOM OF THE DOOR AND CHECK DOOR FOR SQUARENESS. FASTEN EACH GIRT WITH (1) SELF DRILLER AT THIS TIME.

IF DOOR HEIGHT =	4' & 5' # OF BOX GIRTS	6' & 7' # OF BOX GIRTS
8'	3	5
10'	4	6
12'	5	8
14'	X	9

