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I. Care and Maintenance

This product is factory finished. Please handle with extreme care. Protect all exposed surfaces from contact with caustics, corrosives, solvents, abrasions, impacts, wet packing material etc. **FAILURE TO DO SO WILL NULLIFY THE WARRANTY**. Before **ANY CLEANING**, review the Care & Maintenance Instructions (go to www.fleetwoodusa.com for more information). **Contact the local dealer with any questions or concerns.** Fleetwood strongly recommends that all products be cleaned after installation and totally protected from construction debris and equipment.

II. Tools / Materials, Sealant Requirements, & Load / Anchor Instructions

Tools Required: Tape measure, Soft mallet, Level, Shims, Screws, Sealant, caulk gun, Backer Rod, Scissors or utility knife, metal cutting saw, drill bits (#25, 1/4" and anchoring), drive bit and powered drill.

Sealant Requirements

- The sealant referred to within this document for seals associated with the assembly of the product should conform to **AAMA 800**. It may be a sealant recommended and approved by the sealant manufacturer that is compatible with the framing, finish and surrounding materials.
- All sealant bead sizes must conform to the sealant manufacturers' size requirements.
- The Owner / General Contractor is responsible for identifying the need for any additional sealant to be applied by others. Such sealant shall be elastomeric material, compatible with the framing, finish and surrounding materials.
- Proper material shall be used between all dissimilar surfaces (i.e. block/concrete & aluminum).

Anchor Instructions

- Live or Dead Loads can affect product functionality, loads shall be designed to withstand the most critical effects of load factors and load combinations as required by building code.
- Structural engineer to determine anchor quantity, size, and spacing for design load requirements.

III. Assembly and Installation

General: The key to any window or door installation is preparation. This extends from storage of the product to the final installation and to all points in between. Careful planning and attention to detail can help ensure proper installation.

It is essential that each Fleetwood product be assembled and glazed in accordance with AAMA standards and factory instructions. It is the installer's responsibility to ensure that each Fleetwood product is assembled, glazed and installed, and completely sealed to ensure that the product is leak-free and operates correctly**. Installation of Fleetwood products must be in accordance with the standards set forth in ASTM E 2112**. If there are any questions regarding the installation of a Fleetwood product contact the factory customer service department.

Fleetwood has provided this product with recommended field glazed weather-stripping. If the provided weather-stripping does not ensure an optimum fit of glass to frame, the Fleetwood Authorized Dealer should contact Customer Service for an expedited **NO CHARGE** shipment of replacement weather-stripping.

IV. Arche-Duct Block Out

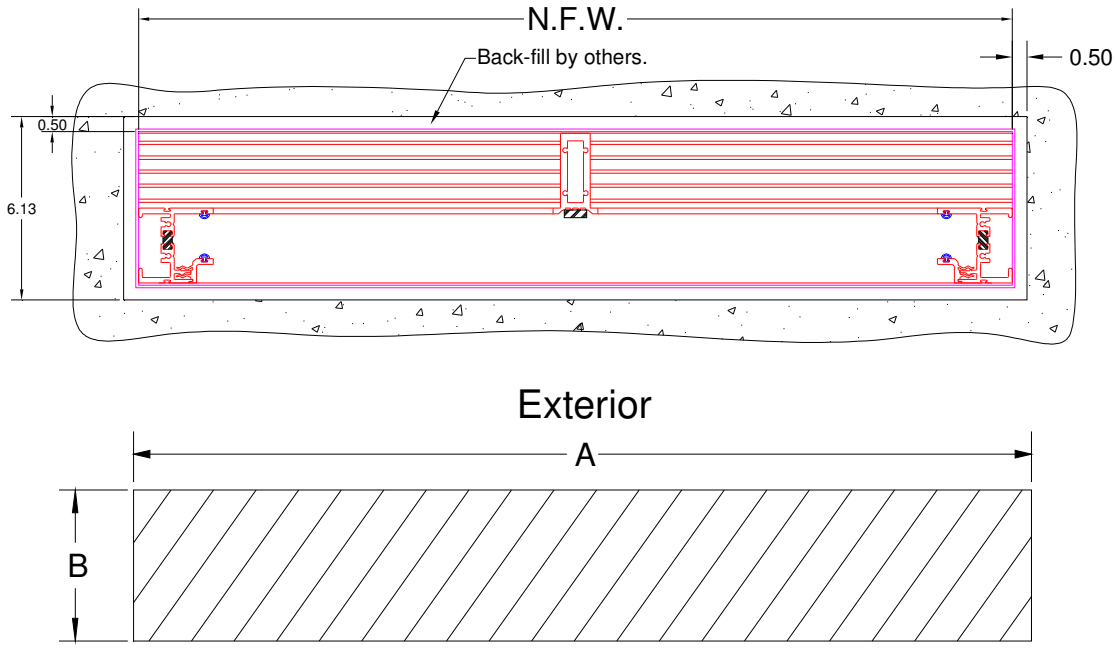


Figure 1:
Arche-Duct Block Out (Top View)

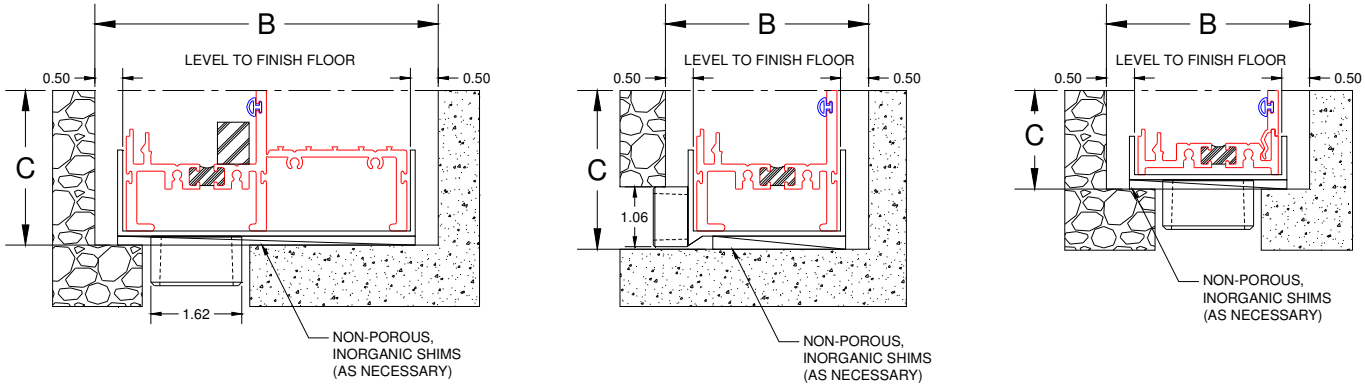


Figure 2:
Arche-Duct Block Out (Side View)

Table 1: Arche-Duct Block Out Dimensions

PROFILE	DIMENSION		
	A	B	C
STANDARD	N.F.W. + 1.00”	6.13”	*2.75”
NARROW		3.63”	*2.75”
LOW			1.75”

*= add 3/16” depth for side drain option.

V. Structure Verification & Arche-Duct Installation

Note: Do not leave the Arche-Duct system exposed for more than 3 months. Prolonged exposure will damage the powder coated finish.

1. Opening Verification

- Check the measurements of the opening and verify that the door will fit into the opening. Measure all four sides of the opening to make sure there is a clearance of 1/2" in width and 1/4" in height.
- Remove the door(s) from the packaging and lay it in front of the opening. Check width and height dimensions.
- Verify the opening is plumb and level.

2. Pre-Fit and Leveling

Note: Do not leave the Arche-Duct system exposed for more than 3 months. Prolonged exposure will damage the powder coated finish.

- Place the Arche-Duct drain system into the opening and determine any leveling that must be done prior to installation (Figure 1). Prepare relief areas for the PVC drain flange(s).
- Shim as necessary to stabilize the entire depth and length of the Arche-Duct. No unsupported width of more than 8” is allowed. Shim to be load bearing, non-porous, non-absorbent and inorganic.
- If more than 1/8” shim height is required, it is recommended that pouring self-leveling “Rock Hard” (or equal) to achieve level and stable surface.

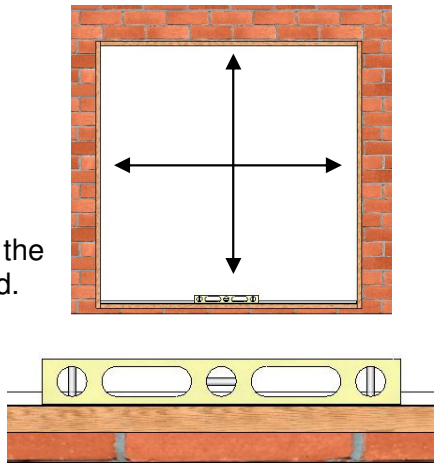


Figure 1:
Plumb and Level Opening

3. Flash the Opening

- Once the opening has been confirmed, flashing of the opening is required prior to Frame installation. Paper and/or liquid flashing methods are acceptable (see AAMA 711/714 for material requirements).
- Check local Building codes for any additional flashing requirements.

Paper Flashing

- At each Jamb the flashing paper should be cut at least 3” past the weep-screed or diado flashing and at least 6” above the head of the door. The flashing must wrap around the jamb and at least 3” back into the opening.
- At the Head run the flashing paper long enough to extend at least 3” past the jamb flashing and wrap around the Header at least 3” into the opening.

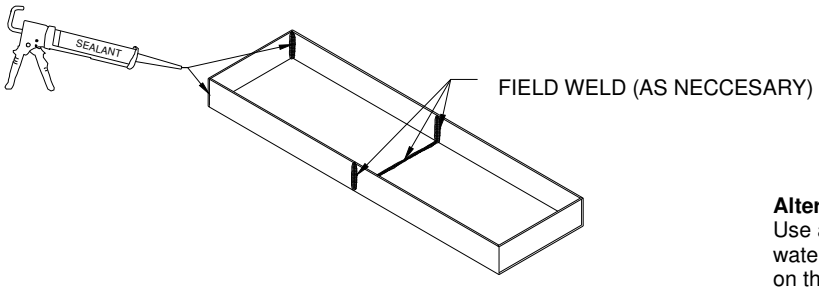
Liquid Flashing

- Follow the liquid flashing manufacturer instructions.

4. Arche-Duct Sealing

Note: Multiple piece Arche-Duct sections require field splicing.

- Apply sealant in all corners and seams of the pan (Figure 4).



Alternate Joining Method:
Use a 6" piece of adhesive waterproof material centered on the joint.

Figure 4:
Seal corners and seams

5. Arche-Duct Water Test

Note: Installer responsible for verifying the integrity of the Arche-Duct for water leakage and performance.

- Block all drain outlets and fill the Arche-Duct with water to verify the integrity of all seams and drain connections. Look for leak points, the water level of the Arche-Duct should remain constant. If Arche-Duct passes water test, drain Arche-Duct and continue with installation of frame.

6. Arche-Duct Install

- Confirm proper orientation of Arche-Duct for tracks and drain location with customer order and/or dealer drawings.
- Install Arche-Duct into already leveled opening.
- Connect tubing or pipe to Arche-Duct drain connections (Figure 5).

CAUTION: An insulating material shall be placed between the Arche-Duct and dissimilar materials to prevent corrosion of the aluminum Arche-Duct.

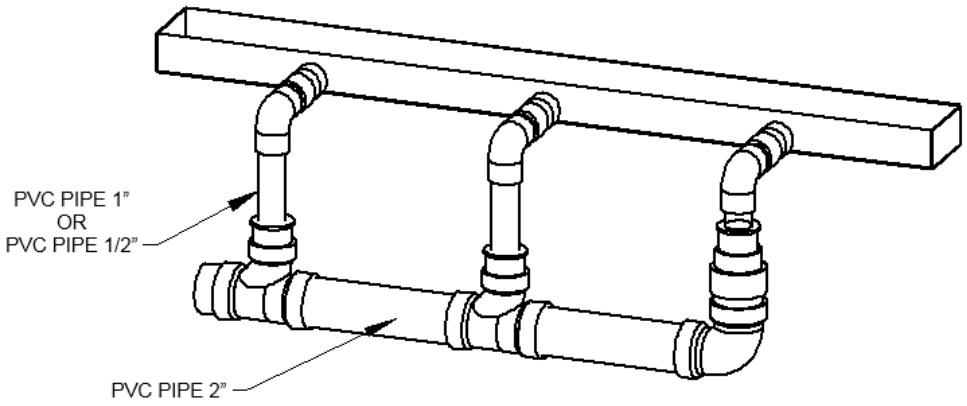


Figure 5:
Drain Pipes Connected (side drains shown)

VI. Frame Assembly

Important Note: Glass Wedges must be field cut to size after the frame is assembled. Failure to assemble the frame according to the installation instructions, nullifies warranties related to this product.

1. Apply a compatible sealant to the corners of the frame. Assemble the frame with screws provided (Figure 6).
2. Install Head and Sill to jambs using #10 X 1" PHP (provided).
3. For Head / Sill configurations that are over 180"

EDGE |f| Fin Installation (with shelf)

Note: fin installation on frames without a shelf (see glazing instructions).

1. Install each full-length Fin, using #10 X 1" PHP Screw into pre-drilled holes at the head and sill (Figure 6)**.**

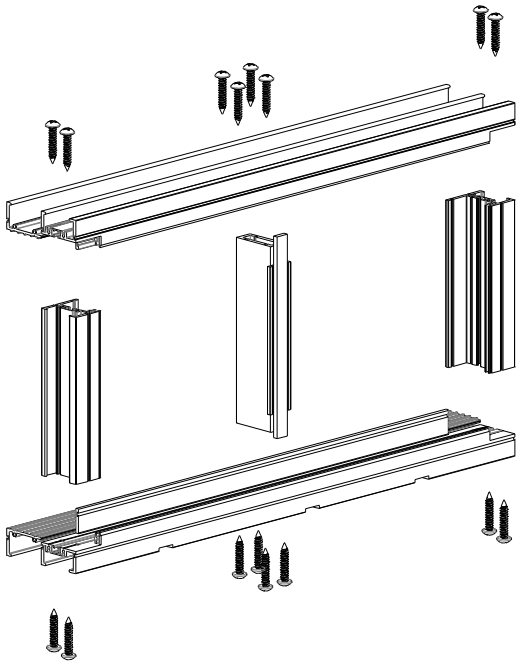


Figure 6:
Frame Assembly

VII. Frame Installation

Important Note: Proper material must be used between all dissimilar surfaces (i.e. block/concrete & aluminum).

1. Prepare the opening to accept the frame ensuring that the weep-screed or diado flashing at the sill is adjusted to maintain a weatherboard style flashing.
2. Insert the frame into the Arche-Duct. Cross-measure and adjust as necessary to achieve a plumb square and level condition, as well as an even reveal around the framed opening. Shim with non-porous, non-absorbent, inorganic shims where needed. Seal all fastener heads with compatible sealant. Only drill holes through Sill and Arche-Duct as required for design load.
3. Anchor Location and Sealant (Figure 7)

   Note: Frame installation anchors furnished by installer, not by Fleetwood. Stainless steel screws are recommended. Fleetwood recommends countersinking for all frame anchors.

4. The installer is responsible for the integrity of all framing joints after installation and must therefore ***water*** test all joints to guarantee a completely sealed product. Apply joint sealer and/or sealant necessary to ensure watertight joints. Retest as necessary.
5. To complete the installation, apply backer rod and bead of sealant between the frame and the building structure, exterior and interior. Tool the sealant to eliminate bubbles, voids and / or breaks and ensure a completely watertight seal. See Anchor Location Drawing, Figure 7.

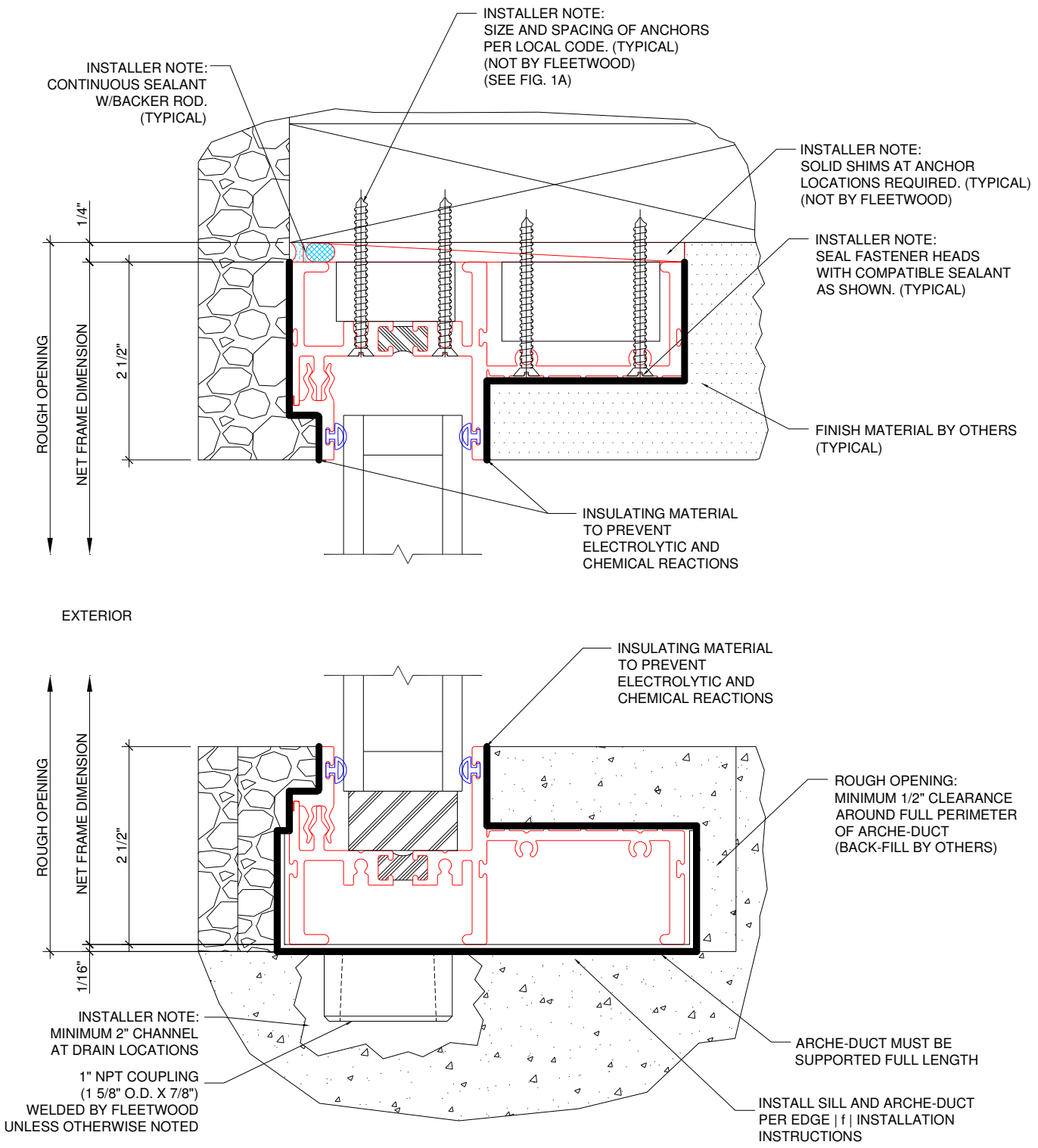


Figure 7:
Standard Sill with Sealant Shown (Exterior Glazed)

VIII. Glazing Instructions

Note: For Low Profile Sill option, leave exterior glass wedges installed while glazing.

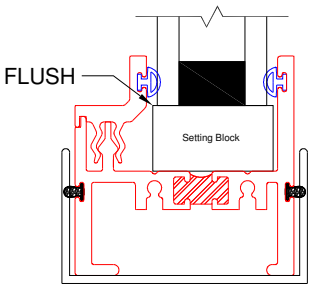


Figure 8:
Setting Block Dimensions

1. Cut each glass wedge to size and test fit. Remove prior to glass installation. For 9/16" glass, pre-drill holes through the glass wedge and frame using a #25 (0.15") drill bit, use a 1/4" drill bit to open the hole in wedge / spacer to prevent breakage.
2. Orientate the setting blocks to be flush with the glass (Figure 8) and place at ¼ points along the sill.

Fin / Multi-lite configurations

   a. Configurations with the fin and no shelf, install glazing and finished surround, the Fin is to be cut to size and sealed with structural sealant
   b. Attached to the Fin is a double-sided adhesive spacer, partially peel back the protective film. Once satisfied with the glass position, fully remove the protective film
   c. maintain a 3/8" gap between glass for sealant (Figure 9).
   d. Apply structural sealant between the glass and fin (Figure 9).

3. Insert glass into the head channel. Push up and swing the bottom inward until vertical, then lower down into the sill (Figure 10). Center the glass horizontally into the daylight opening (Figure 10).
4. Finish assembly by inserting the two horizontal glass wedges, two exterior vertical glass Wedges and two interior glass wedges. Once all four Wedges are installed on one side move to the opposite side and install the last two vertical Wedges. For 9/16" glass, pre-drill and fasten the glass Wedge into the frame with the screws provided (red bag).
5. Apply silicone at the intersection of glass wedges (Figure 11).
6. Once satisfied with glass installation and applying insulating material, backfill around the Arche-Duct. Verify you have access to drainage connections and clean out as necessary.

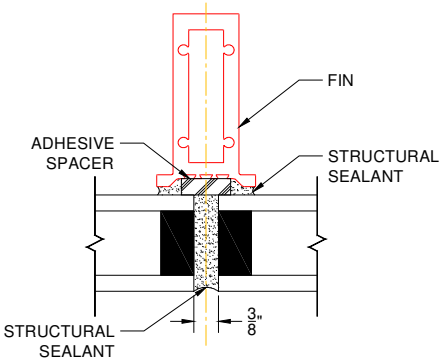


Figure 9:
Fin Glazing Directions

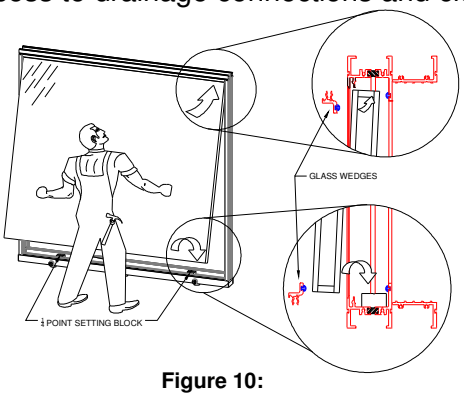


Figure 10:
Glazing Directions

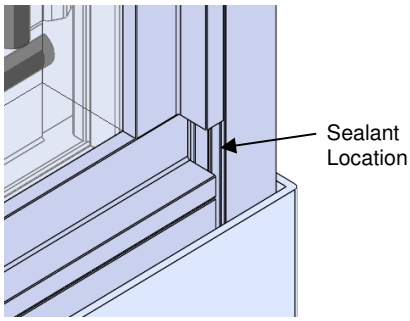


Figure 11:
Glass Wedge Detail

Alternate Glazing Procedure

Note: Where additional water sealant is required.

1. Apply a continuous 1/4" bead of sealant before and/or after glazing (Figure 12).

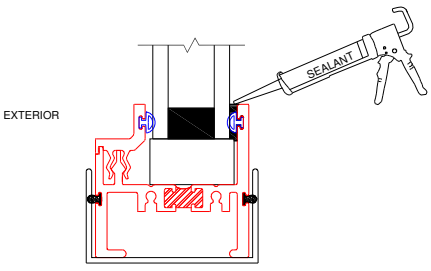


Figure 12:
Inside Glazing Sealant Locations

IX. Flashing after Installation

The flashing paper referred to in this document is Moistop or other code compliant flashing material that conforms to **Federal Specification UU-B-790a, Type 1, Grade A, Style 4**. The strips of flashing paper are to be no less than 9 inches wide (or wider as required by local codes). Flashing paper must be applied with galvanized nails or corrosion resistant staples. Flashing paper shall be applied in a weatherboard fashion around the full perimeter of the framed opening.

1. Once satisfied that the frame is water tight, and immediately prior to application of the flashing paper at the head and jambs, apply a continuous bead of sealant to the exposed mounting flange (nail-fin) at the top (head) and sides (jambs) of the installed frame. Also, apply sealant at corners of the frame, the full length of the seams where the nail fin flashing is mounted.
2. At each jamb, embed the flashing paper into the sealant onto mounting flange and fasten into place. The flashing paper should be cut sufficiently long enough to extend at least 3 inches past the weep-screed or diado flashing and at least 6 inches above the head of the window (Figure 13).
3. Finally, at the head, embed the flashing into the sealant on the mounting flange and fasten into place. The flashing paper should be cut sufficiently long enough to extend past the flashing paper at each jamb by at least 3 inches (Figure 14).
4. Weather resistant building paper should be applied in a weatherboard fashion to complete the installation (Figure 15).

Note: Where weather resistant building paper, insulating board, or other materials by other trades may constitute the primary weather barrier behind the exterior wall finish (i.e., stucco, masonry, siding, etc.), the owner / General Contractor are responsible to ensure that the weather barrier is continuous by effectively sealing the material to the window.

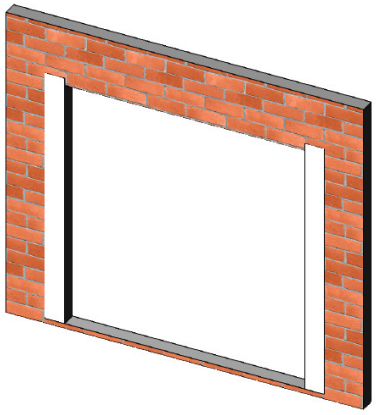


Figure 13:
Jamb flashing

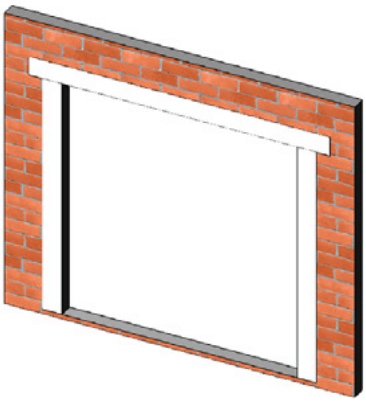


Figure 14:
Head Flashing

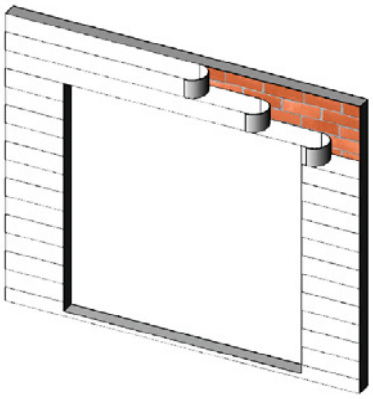


Figure 15:
Building Flashing

Appendix A: Glass Removal

Note: If the low-profile option was chosen for head, demolition of finished surround will be required.

Multi-lite system

1. Remove the butt joint sealant. If a fin is present, separate the glass at the top and bottom from the double-sided tape (Figure A1).
2. Slide either end of the glass (left or right lite) into the jamb. Move the next piece of glass in the same direction as the previous (Figure A2).
3. Before removal, ensure the glass is free of all obstructions to the left and right.
4. Lift glass into the head providing clearance at the sill to swing glass out for removal (Figure A3).
5. Repeat as necessary. To remove last lite, slide out of jamb and repeat steps 2-3.

Single lite system

1. Determine removal direction (exterior or interior), demo the finished surround at the jambs enough to remove the wedges (Figure A1).
2. Remove the jamb wedges.
3. Lift glass into the head providing clearance at the sill to swing glass out for removal (Figure A3).

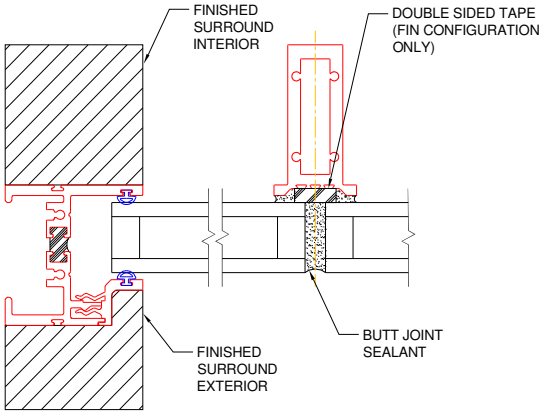


Figure A1:
Callout Locations (Multi-Lite Shown)

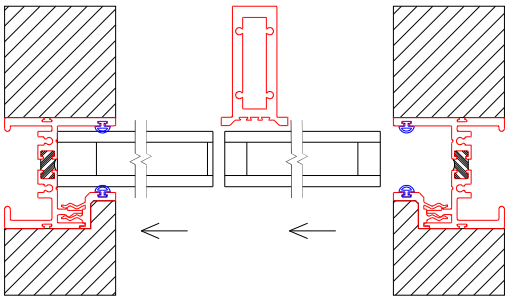


Figure A2:
Horizontal Movements
(Left Movement Shown, removal of Right lite shown)

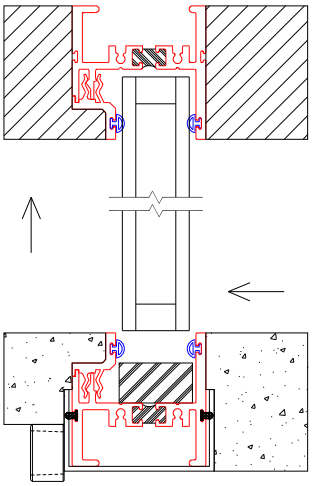


Figure A3:
Glass Removzal
(Swing to the exterior shown)

Appendix B: CLiC Glass Installation

Fleetwood offers CLiC on demand Privacy Glass as a glazing option. This type of glazing option requires power to be run to each lite using cardinals proprietary glass controller. Depending on the type of product ordered, the wire leads locations will vary. Please ask at the time of purchase to confirm where these leads will be located so assist in preparing the opening accordingly.

Below are links to CLiC glass specific installation instructions:

Quick Start Guide

Installation Manual

Technical Data Sheet