FLEETWOOD WINDOWS & DOORS
www.FLEETWOODUSA.com

EDGE | s | MULTI-SLIDE
INSTALLATION INSTRUCTIONS

Table of Contents

I. Care and Maintenance

Operational Warning: Fleetwood products operate smoothly and special care should be taken by the owner to make sure users are not injured.

This product is factory finished, 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, Level, Shims, Screws, Screw Gun, #2 Phillips Bit, T25 Torx Bit, Power Drill, Sealant, Structural Sealant, Caulk Gun, Backer Rod, Utility Knife, Rubber/Plastic Mallet, Pliers, Wax.

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, with the framing, finish and surrounding materials.

Load / 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.
- Fleetwood requires maximum vertical deflection of the header not to exceed Span/720 or 3/8"
- Structural engineer to determine anchor quantity, size, and spacing for design load requirements.
- Proper material must be used between all dissimilar surfaces (i.e. block/concrete & aluminum).

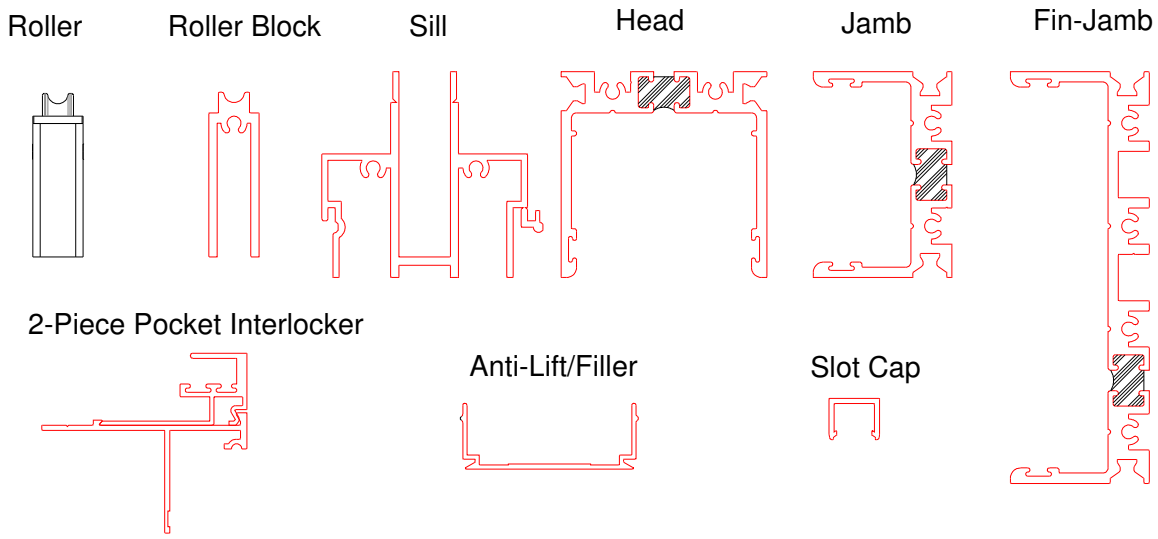
III. Assembly and Installation

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.

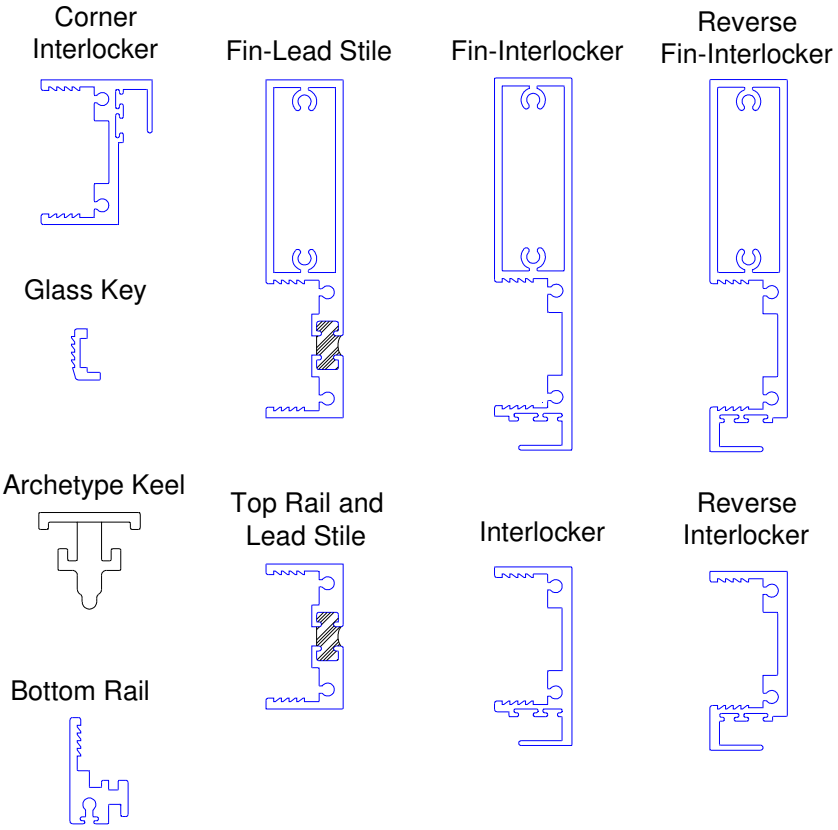
It is essential that each Fleetwood product be assembled and glazed in accordance with AAMA standards and factory instructions. It is the installer's responsibility to ensure that each Fleetwood product is assembled, glazed and installed and completely sealed to ensure that the product is leak-free and 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.

IV. Terminology for EDGE | s | parts

Frame Components



Panel Components



V. Arche-Duct Block Out

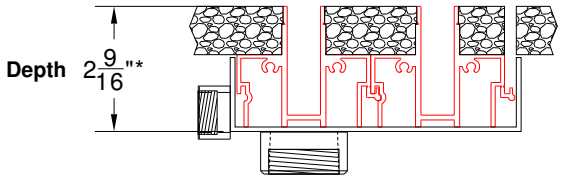
The EDGE | s | Arche-Duct has 1-1/2” tabs towards the exterior and interior for fastening the drainage system to the substrate.

Option #1: Close Fit block out

- Refer to dealer drawing.
  - Add a 1/2” space around jambs / ends
  - Add a 2” space to the exterior / interior faces.
  - For the depth of the block out see Figure 1.

Option #2: Generic block out

- A: N.F.W.+1”
- B: (# of tracks × 2-1/2”) + 4.25”.
- For the depth of the block out see Figure 1.



* Minimum depth required for Arche-Duct. Additional depth may be required for drainage setup. Side drains sit 3/16" below bottom of Arche-Duct.

Figure 1:
Arche-Duct Depth (Side View)

Arche-Duct Block Out

Option #1 (OX Shown, will vary per configuration)

Option #2

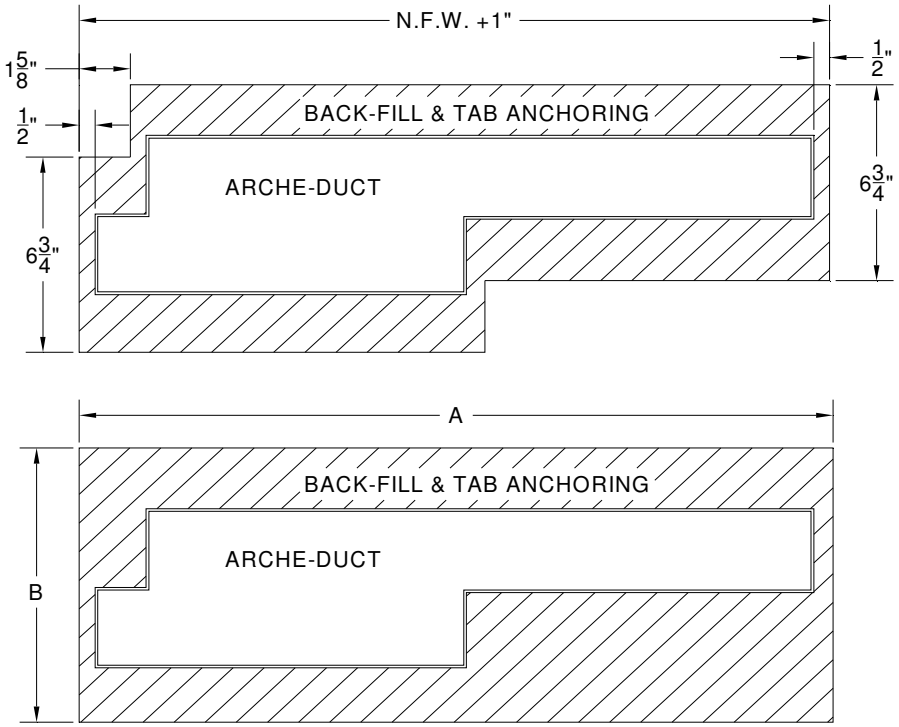


Figure 2:
Arche-Duct Block Out (Top View)

CAUTION: If combining EDGE | f | fixed system- see Appendix A

VI. 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 (Figure 3).
- 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 (Figure 3).

2. Pre-Fit and Leveling

- 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.

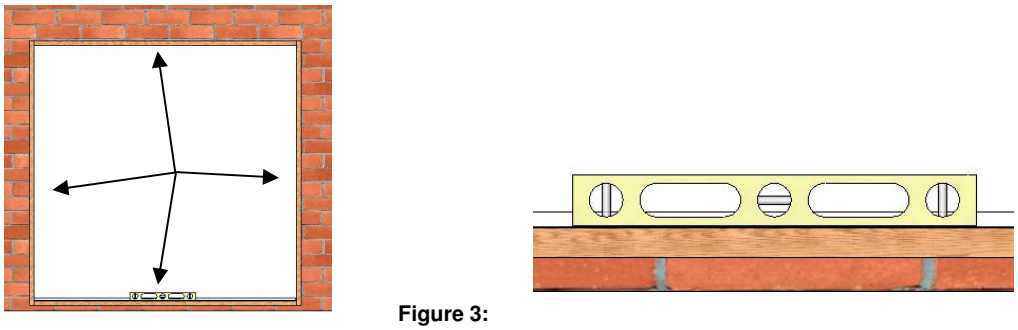


Figure 3:
Use level to determine if the opening is plumb and level

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.

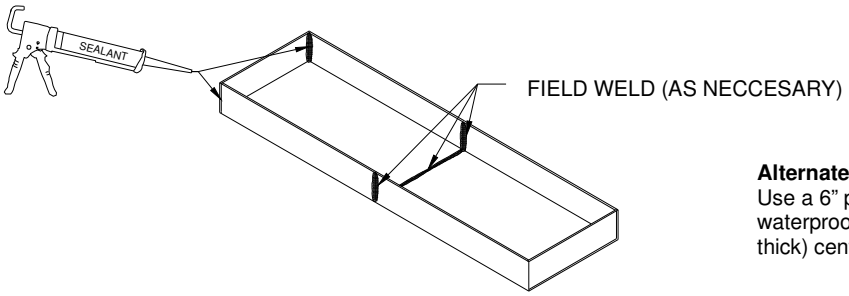
Liquid Flashing

- Follow the liquid flashing manufacturer instructions.

4. Arche-Duct Sealing

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

- It is necessary to use an insulating material between the outer edge of the Arche-Duct and the rough opening. Direct contact with grout, concrete, or dissimilar metal can lead to corrosion of the Arche-Duct pan.
- Apply sealant in all corners and seams of the pan (Figure 4).



Alternate Joining Method:
Use a 6" piece of adhesive waterproof material (max 1/16" thick) 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 the 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. An insulating material should be placed between the Arche-Duct and the supporting structure (concrete, steel, etc.) to prevent corrosion of the aluminum Arche-Duct.
- Connect tubing or pipe to Arche-Duct drain connections.

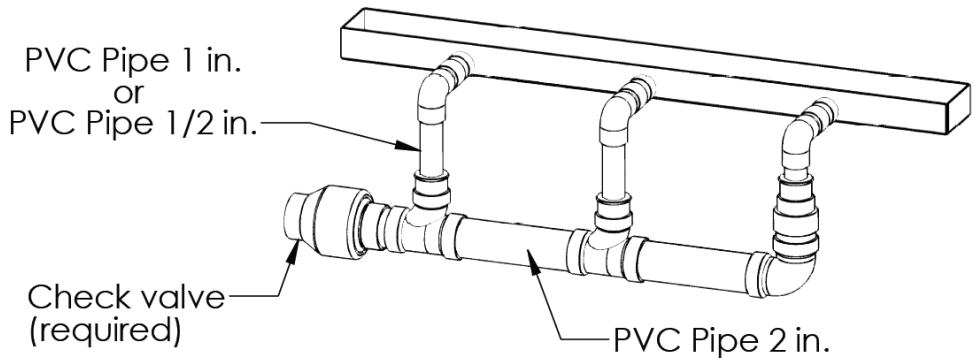


Figure 5:
Drainpipes Connected (side drains shown)

7. **Confirm Weeping Slots**
   - Weep slot locations should be 8” from the ends and less than 60” (equally spaced) for proper drainage.
8. **Backfill**
   - Do not back-fill until door operation is fully tested, including locking into jamb(s) and locking into pocket interlockers (when applicable).
   - Verify that there is access to drainage connections and clean out as necessary.

VII. Frame Assembly

Note: Due to the potential disruption during handling and installation, the installer is responsible for the integrity of all areas requiring sealant whether or not these frames were factory assembled.

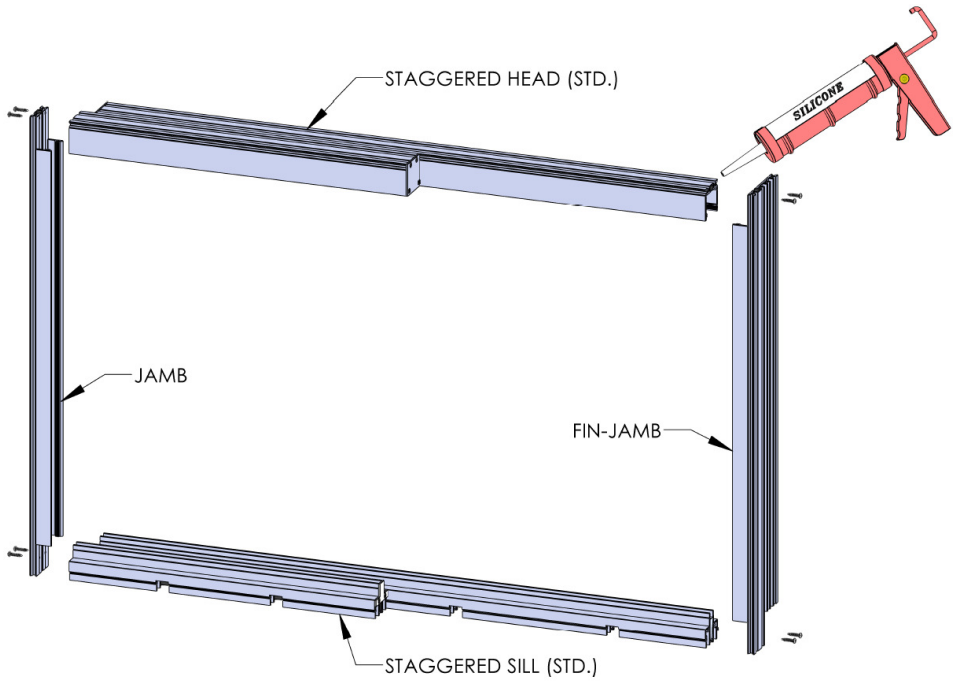


Figure 6:
Frame Joint Sealing (2 tracks shown w/ Fin-jamb Option Chosen)

1. Check with customer order and/or dealer drawings to ensure left and right jamb orientation. Note that the sill slot drain is to the interior (Figure 7).
2. Remove all pre-installed screws from head and sill.
3. Add sealant to the upper corners of the jamb(s) and to the end of the head that is compatible to the entire assembly as shown in Figure 6.
4. Attach the jamb(s) to the head using #10 x 1.5” long pan head screws. Check that the screws pass through jamb(s) and into the screw raceways in the head. It is recommended to add wax to the threads of all fasteners to reduce the drive torque.
5. Attach the jamb(s) to the sill using #10 x 1.5” long pan head screws. Check that the screws pass through jamb(s) and into the screw raceways in the sill. It is recommended to add wax to the threads of all fasteners to reduce the drive torque.

VIII. Frame Installation

The drainage duct must be flushed prior to installation to remove any blockages that may have occurred during the construction process.

1. Pre-fit the frame into the opening *(ensuring orientation is correct*), start by placing the sill into the Arche-Duct as shown in Figure 7.
2. Cut to length (as necessary) and insert aluminum spacer into slot drain along the full width of the slot and along the edges of a staggered system. This will help protect from debris buildup that may occur during the construction phase.

   Note: The aluminum spacer is to be removed after the flooring is finished to ensure proper drain spacing is preserved.

3. Confirm that the frame is centered and square, sill is level (left, right, exterior and interior, Figure 7) and jambs are plumb, all adjustments must be made at this stage as there is no leveling capabilities of the panels. Once the fit has been confirmed, attach frame to structure as shown below (Figures 8).

   Note: Blocking, stainless steel screws (recommended), and wall finish not furnished by Fleetwood. Frame installation anchors furnished by installer. Fleetwood recommends countersink of all anchor screws.

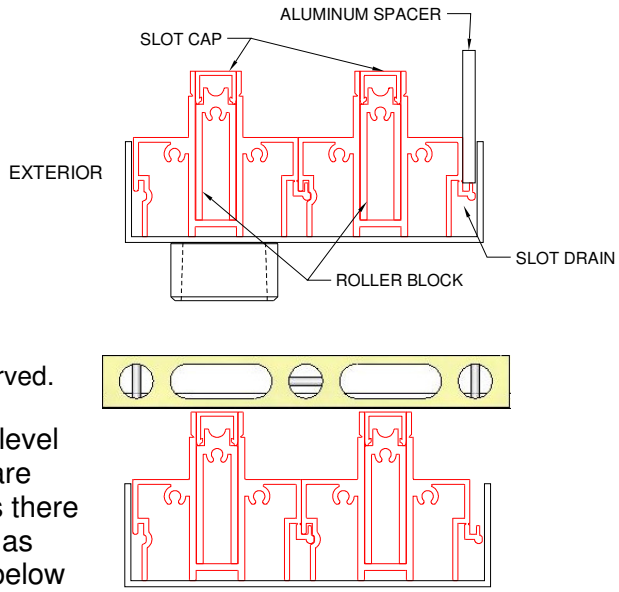


Figure 7:
Sill Placement (2 tracks shown)

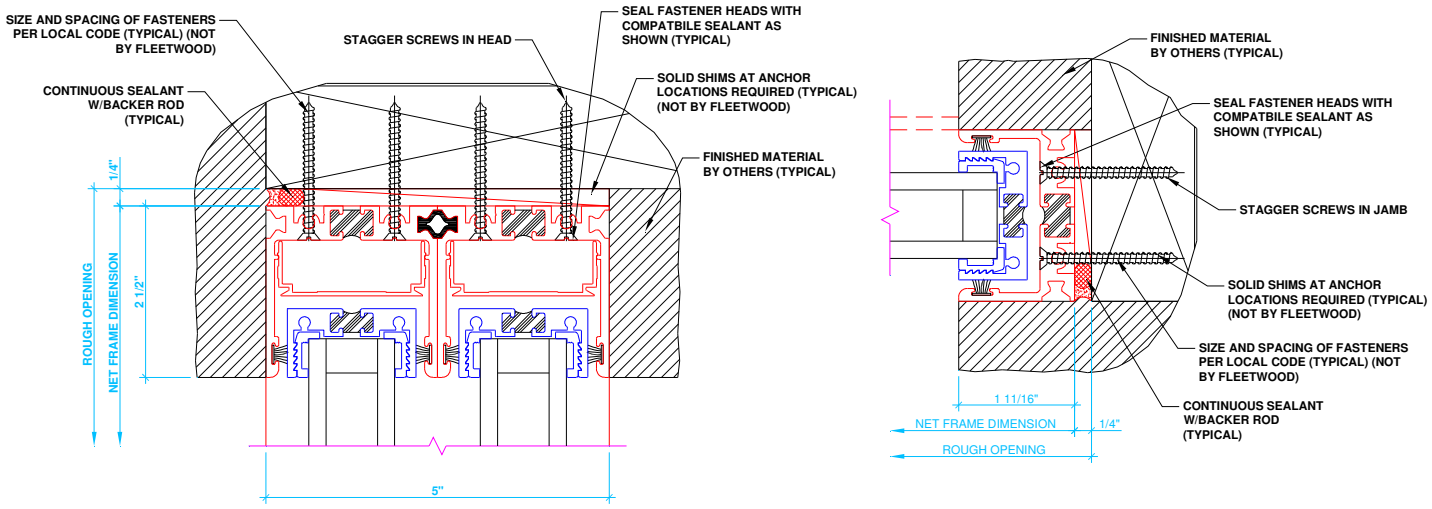


Figure 8:
Typical Frame Installation
(Head shown on the left, Jamb shown on the right)

IX. Glass Key Assembly (For Replacement Glass)

Note: Replacement glass, request glass keys from customer service, installer to size and cut.

1. Measure the glass thickness along all 4 sides of the glass.
2. Add the measurements together and divide by the number of measurements taken. This is the average glass thickness.
3. Use Table 1 to select the appropriate glass keys. Figure 9 can be used to properly identify the glass keys.

Table 1: Glass Key Selection

Average Glass Thickness	Extrusion
1.1875”-1.212”	Es0017
1.213”-1.237”	Es0017 & Es0002
1.238”-1.262”	Es0002
1.263”-1.313”	Es0002 & Es0018

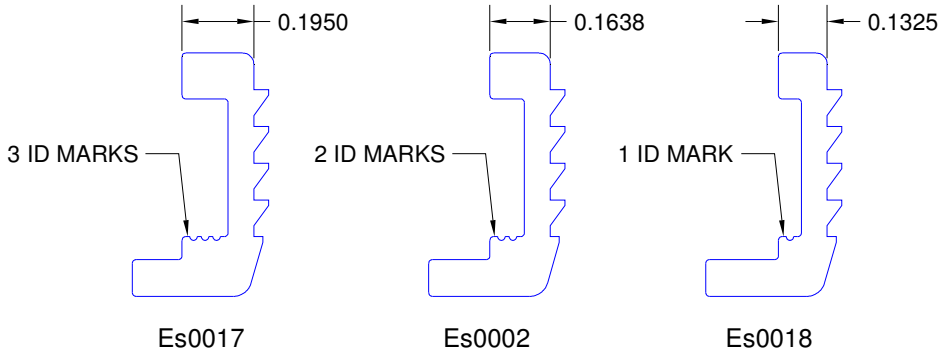


Figure 9:
Glass Key Identification

4. Place 1/4” × 1/4” bead of structural sealant along middle of glass keys.
5. Press the glass key to the face of the glass. The key needs to be placed firmly against the edge of the glass (Figure 10). This is most easily achieved by pressing at a 45° angle onto the glass. Leave a 9/16” gap from the perpendicular sides of the panel to allow for extrusions to be removed / installed easily.
6. Repeat the procedure for all sides top and bottom of the glass.
7. Apply a bead of sealant that is compatible with the insulated glass seal to all four ***exterior*** corners as shown in Detail “A”.

Notes:

a. The glass thickness, net width and height must be to size within +/- 1/32”.
b. Failure to install according to these instructions nullifies all warranties related to this product.

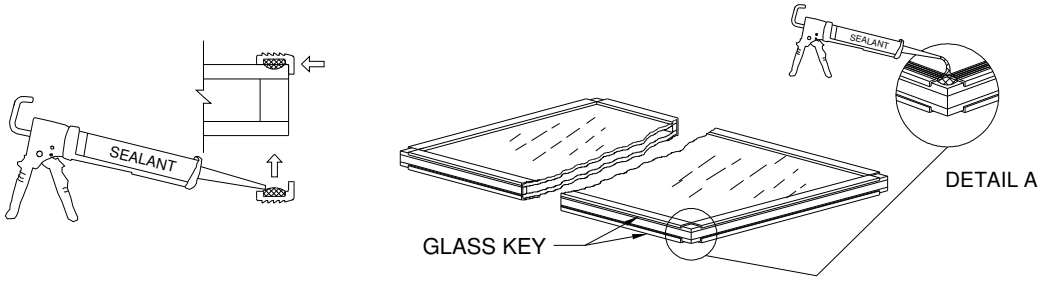


Figure 10:
Glass Key Application

X. Roller Installation

Prior to the panel installation, the roller blocks/slot caps in all active panel locations must be removed and replaced with rollers. If the panels are not to be installed after roller installation it is recommended that the slot caps be reinserted to preserve the functionality of the rollers.

1. Remove the Roller Block and Slot Cap from all active panel sill locations.
2. Using a rubber mallet lightly tap the A4-E Rollers into the sill (Figure 11). Properly align rollers on Rollers by cutting Roller spacer to size and fitting at ends of sill track.
3. If the A4-E Roller does not fit, use the A1-E Roller(s). For spaces that are too small to fit a Roller, use the factory provided Roller spacer (cut to size).

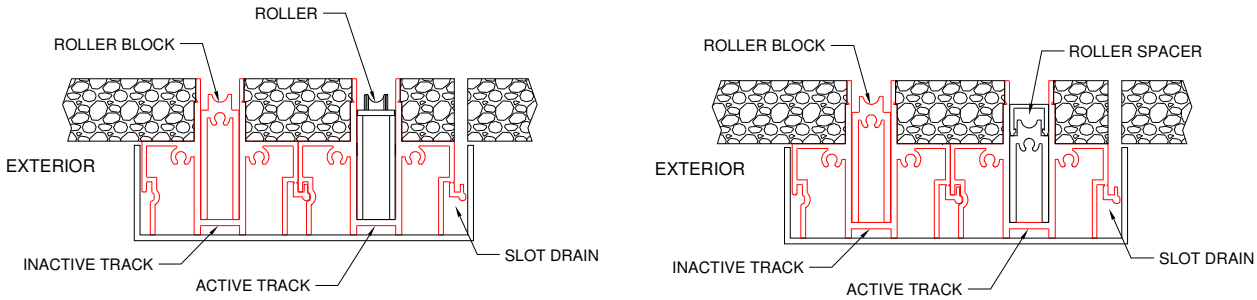


Figure 11:
Roller installation and End of Track Filler

XI. Roller Removal

1. Remove the roller spacer insert from the sill, relieving pressure on the rollers.
2. To avoid damaging the top plate of the roller, lift the roller up evenly on both sides of the Roller to remove.

XII. Panel Assembly (If Not Factory Assembled)

NOTE: Match door configuration and panel orientation with customer order. Configuration and orientation of panels shown in assembly instructions is for illustration purposes only.

1. Starting from the edge of the glass, slide the top rail over the glass keys into the center position.
2. Repeat this procedure with the bottom rail (Figure 12).

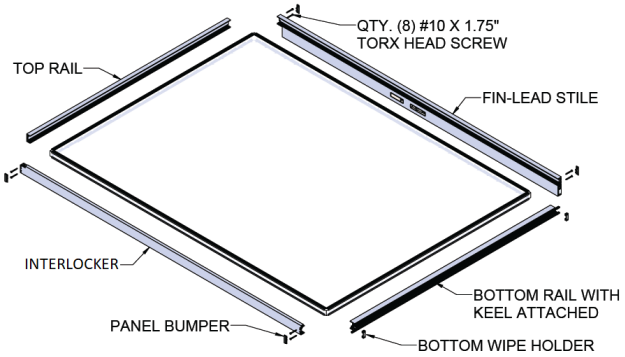


Figure 12:
Panel Assembly (X Panel Shown)

Note: Before installing the Lead Stiles and Interlockers, check required orientation with customer order.

3. Position the Interlocker on the correct side of the glass and slide the stile over the glass keys into position.
4. Repeat this procedure with the opposite side.
5. Place the bottom wipe holder between the bottom rail and stiles.
6. Secure the Stiles to the rails with (8) #10 x 1-3/4" Torx Head Screw (Figure 12) using a T25 bit. Add wax to the ends of all fasteners to reduce the drive torque required for installation.
7. Cover all fastener heads with the provided panel bumpers.

Reverse Interlockers

Locking hardware for typical installation is located on the interior panel, customer has the option to choose which stile will have the locking hardware at the time of order (Figure 13).

Locking Hardware

Prior to installation of the panels, verify the locking hardware is at the correct height (from the locked position) and is installed correctly. The bottom guide of the locking hardware should be offset towards the glass (Figure 14). If not, uninstall the guide and adjust the blade hardware.

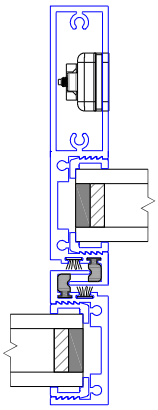


Figure 13:
Reverse Interlockers
(Fin-Reverse Interlocker / Reverse Interlocker Shown)

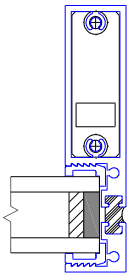


Figure 14:
Blade Guide Position

XIII. Panel Installation

Note:

a. Check customer order for proper panel configuration and orientation.
b. Pocket walls: Installer to flash pocket walls to adequately protect from moisture.
c. On pocket doors, installation of panels should be completed before construction of pocket is complete.
d. Sequence of panel installation is from interior to exterior.
e. After all panels have been inserted; trim the weather stripping at the head and sill so that an air barrier is formed at the head and finished flooring.

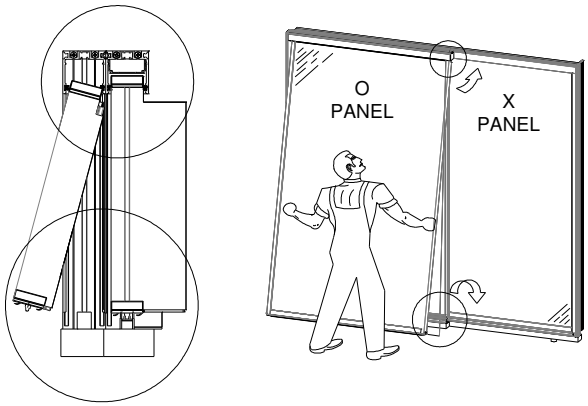


Figure 15:
Panel installation

"X" Panel

1. Insert panel into the upper head channel. Push up and swing the bottom inward until panel is vertical, then lower panel down onto the track (Figure 15).

Note: On PX or XP configurations, if the pocket construction has been completed, demolition may be necessary to insert or remove the panel(s). Other pocket configurations, additional track length in the head has been included to aid in the removal of the pocket panel.

2. Repeat step 1 until all panels have been installed. Panels must overlap during installation to allow proper engagement of interlockers after installation (except for Reverse Interlockers).
3. Verify that all panels with hooks engage properly (See Figure 13). If lead stile panel is not engaging properly with the jamb or Reverse Interlockers reveal is not even check to ensure frame components are square and level.
5. When applicable, use a soft mallet to install Head Fillers into all tracks where they do not interfere with the operation of the system.

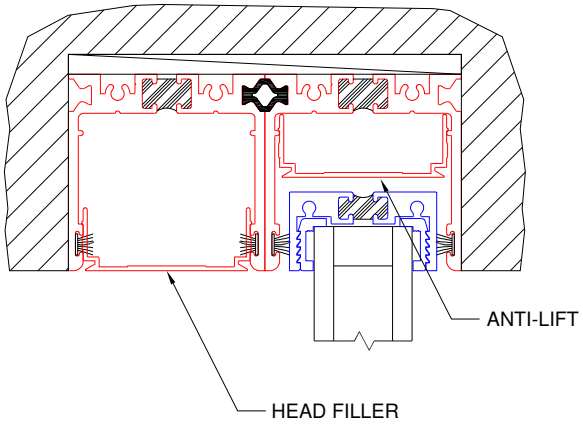


Figure 16:
Head Filler and Anti-Lift Installed

"O" Panel

Lift and move the panel into the fixed jamb until the glass reveal is even to the jamb. Verify that the weather stripping in the frame head is located so that it contacts the width of the "O" panel.

"O" Panel Securing

Once the fixed panel is in position, take the fixed panel bracket and butt it up against the head and fixed panel. Mark the hole locations of the bracket in the head and drill out using ¼" drill bit. Fasten the bracket through the head to the frame using two #10 screws (not provided by Fleetwood). Screw the #3/8-16 bolt into the bracket to prevent the fixed panel from being lifted up. Cover the exposed bracket with the 1.5" section of head filler (Figure 17).

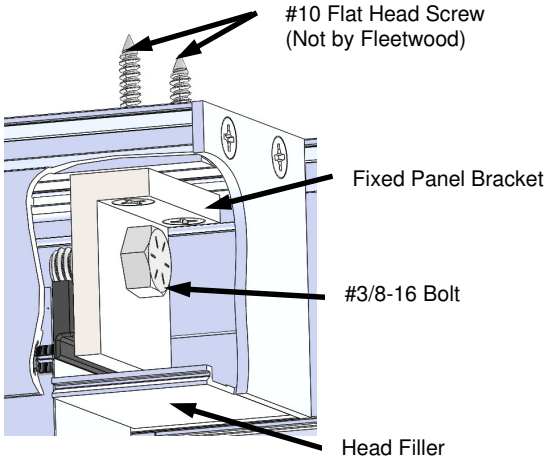


Figure 17:
Fixed Panel Fastening

XIV. Blade Case Installation

Note: Any gaps between blade case and finished flooring/jambs must be sealed to prevent water infiltration. For proper installation of the blade case on 3.5" Sill see Appendix B.

1. Determine the location setting for the blade case (Figure 18). Remove screws (from the underside) and reassemble as necessary. When the High Interior Leg is chosen for the Arche-Duct, notching and sealing of the pan may be required depending on configuration (Figure 19).
2. Mark the blade case locations.
   Method 1:
   If the panels are un-installed the case locations can be determined from dealer drawings.
   Method 2:
   If the panels are installed the blade can be activated and the location marked.
3. Predrill holes for a #10 screw using a #25 drill bit. Fasten blade case with #10 X 1" PHP Screw.

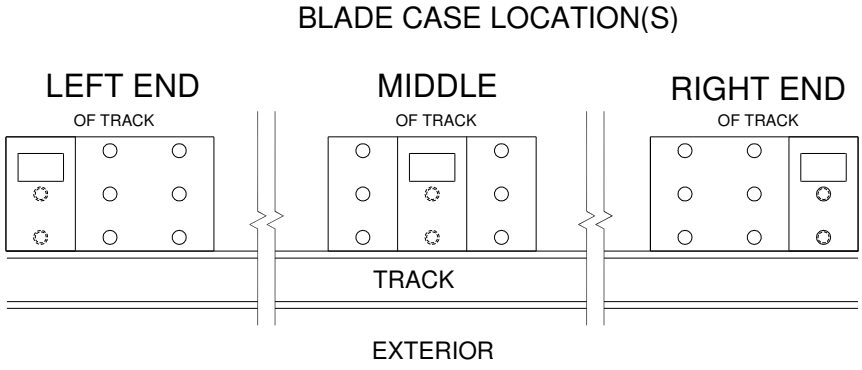


Figure 18:
Blade Case Location Options

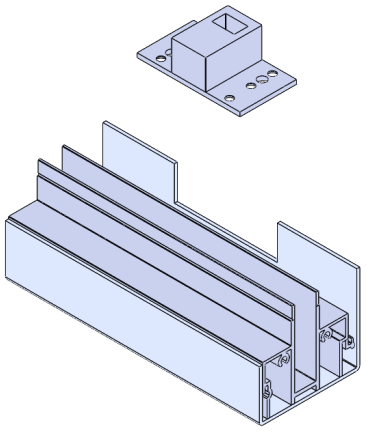


Figure 19:
Blade installation (High Interior Leg Arche-Duct Shown)

XV. Anti-Lift(s)

At the top of all active panel vertical stiles, insert into the head an Anti-Lift block (4" head filler, cut to size by installer). See Figure 16 for illustration.

XVI. Finished Flooring Installation

Note: When installing 2" thick flooring, see Appendix B.

Flooring Material: The sill for this product was designed to incorporate the finished flooring as a key component to the bottom rail sealing and the linear slot drain. The material chosen to surround the extruded sill should be such that water will not damage it.

Linear Slot drain: The sill comes with an aluminum spacer to ensure the linear slot drain spacing is correct (Figure 7). This spacer is to be removed after the finished flooring is installed.

XVII. Pocket Interlocker and Pocket Closer Installation

Note: Installation of Pocket Interlocker and Pocket Closer should be done prior to wall completion. Pocket Interlockers are furnished net frame height and must be field cut.

1. Assuming that all door and screen panels will be installed from the exterior, the interior pocket interlocker is installed before any screen or door panels.
2. Attach pocket interlocker(s) with #8 flat head screws, not by Fleetwood. Install screws 6" from top and bottom with additional screws 18" on center.
3. Drill .136 diameter holes (#29 drill bit) thru pocket closer and one wall of interlocker. Holes to be located 6" from top and bottom of pocket closer, then evenly spaced on 18" centers. Assemble pocket closer to back side of interlocker with #10 x 1/2" long pan head screws (Figure 20).

Note: On PX or XP configurations, if the pocket construction has been completed, demolition may be necessary to insert or remove the panel(s). Other pocket configurations, additional track length in the head has been included to aid in the removal of the pocket panel.

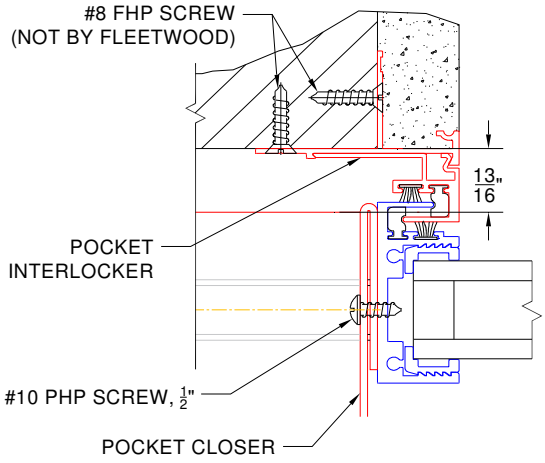


Figure 20:
2-piece Pocket Interlocker

Appendix A: O Panel Type EDGE | f |

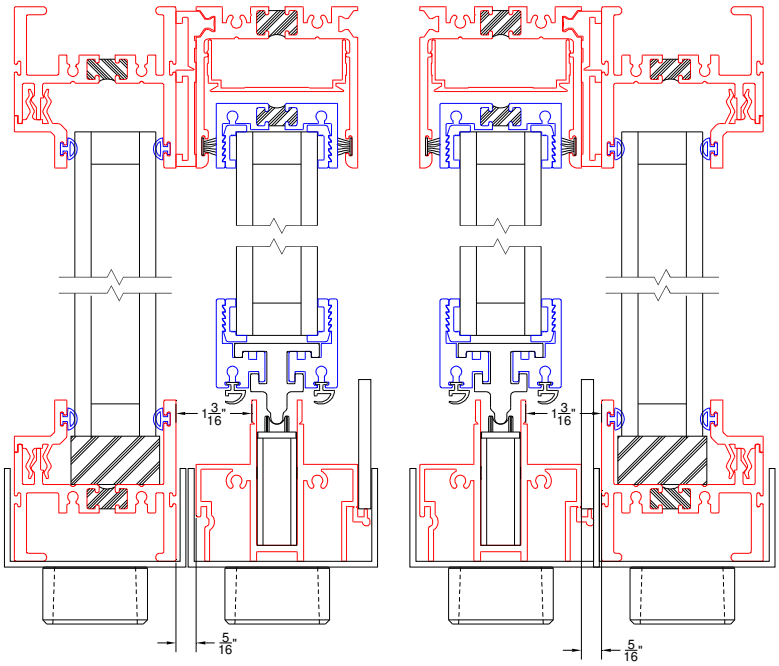
Note: Drainage between multiple systems must be reviewed, and may vary depending on configuration. EDGE | f | frame installation must be installed with the glazing wedges facing away from EDGE | s | track(s).

At the head and sill where the two series meet a 5/16” gap needs to be maintained (Figure A1). The distance between products is crucial, any misalignment may prevent hooks from properly engaging.

Proper block out spacing at the combined products to be a minimum of 7-1/2” to allow for proper backfill, check with dealer drawings to confirm, different combinations may require more spacing.

Follow the EDGE | f | and EDGE | s | product Installation Instructions for how to properly install and assembly the frames of the two series.

The O panel type EDGE | f | when paired with an EDGE | s | will come with 1” long glass keys pre-attached at the top and bottom of the interlocker(s). When installing the interlockers center on the glass and back-fill between glass keys with structural silicone (Figure A2).



EDGE | f | Exterior Location **EDGE | f | Interior Location**

Figure A1:
O Panel Type EDGE | f | Spacing

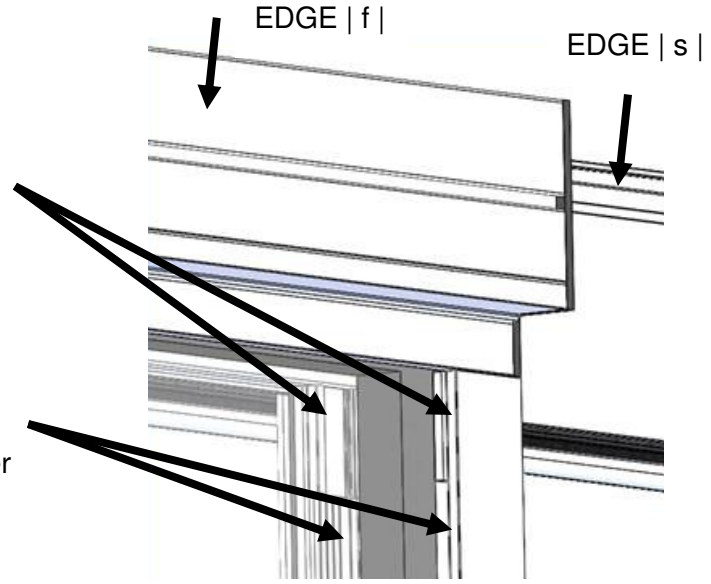


Figure A2:
EDGE | s | with EDGE | f | Silicone Location

Appendix B: 3.5” Sill Option

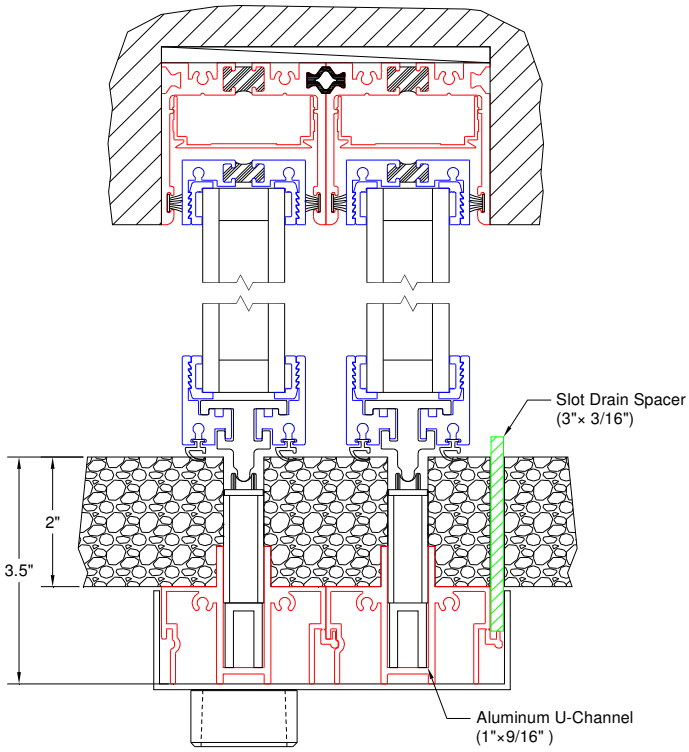


Figure B1:
3.5” Sill Option

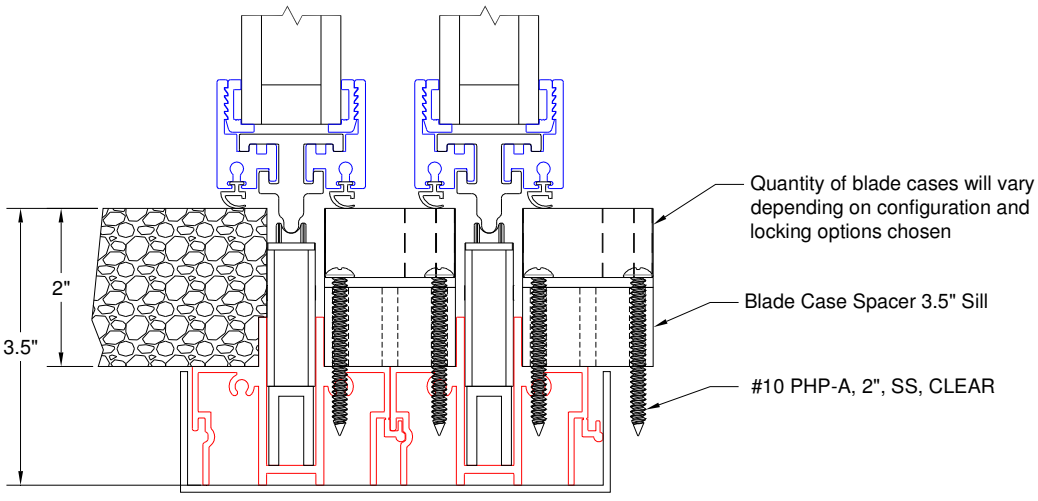
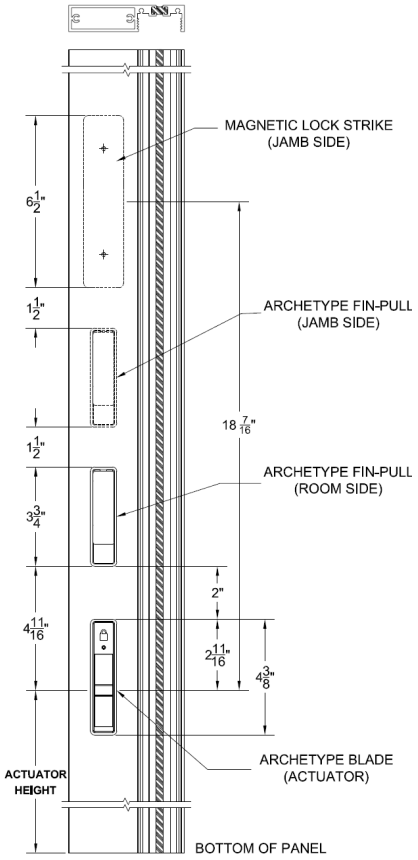


Figure B2:
3.5” Sill Blade Case Installation

Appendix C: Magnetic Latch Instructions



Basic Functions & Features

- Rofu 8406M magnetic lock.
- Automated locking when the door closes
  - The magnet is activated when the power source is connected and on.
- Remote access provided by home automation or user interface (not by Fleetwood)

Provided (located)

- An electromagnetic lock that is activated by a 24VDC or 12VDC power supply
- The magnet strike is located above the Archetype Hardware
- Fleetwood provides the Frame and Panel(s) fabricated to assemble the magnet and the magnetic strike into the door
- Wiring for the magnet is accessible from the backside of the active jamb
- The Archetype Narrow hardware is required for added security (i.e. power outages)
  - The magnetic lock should only be considered as a secondary lock, not the primary lock.

Note: The magnetic lock can only be located in the Jamb. Doors that lock with meeting stiles are not offered with magnetic locks.

Not Provided

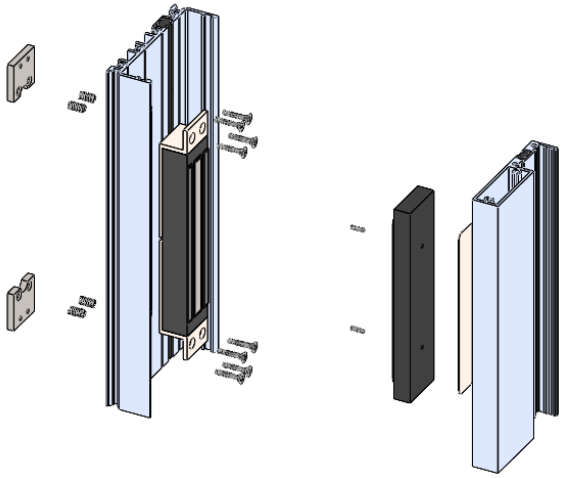
- Power Supply: 24VDC or 12VDC is required.
- User Interface: Entry access system (e.g., keypad, biometric, etc.). The lock can be integrated with home automation systems or an electronic switch interface.

Retrofitting

- Existing doors would require factory CNC fabrication. At a minimum, a new Locking Jamb and Lead Stile would be required.

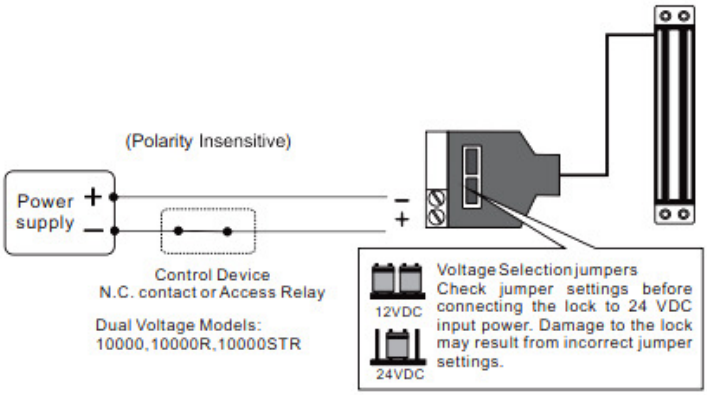
Adjustment

- After adjusting the panels, the magnet in the jamb needs to make full contact with the strike located on the panel. Turning the screws (located on the magnet), will allow the magnet to move in and out from the jamb, adjust until the magnet forms a parallel contact with the strike on the panel.



Appendix C cont: Magnetic Latch Instructions

Connecting Diagram

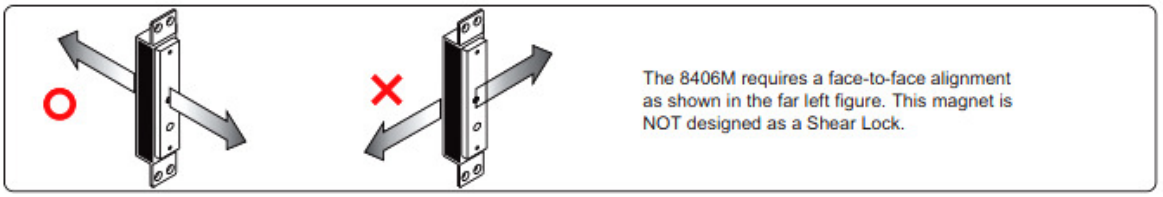


Butt Splice (DC) Connector

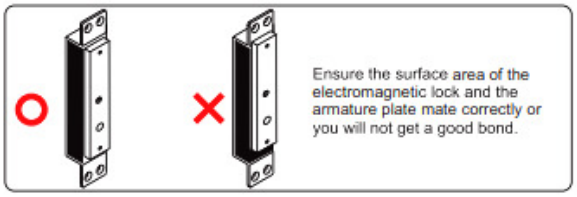
ROFU

Use crimper or pliers and press the header of connector down to even position

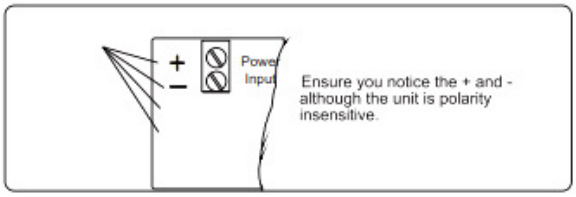
Important Note



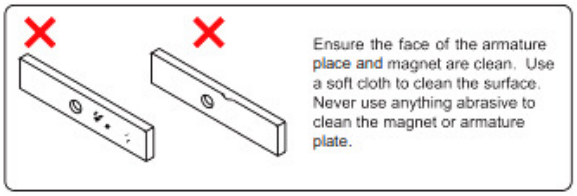
The 8406M requires a face-to-face alignment as shown in the far left figure. This magnet is NOT designed as a Shear Lock.



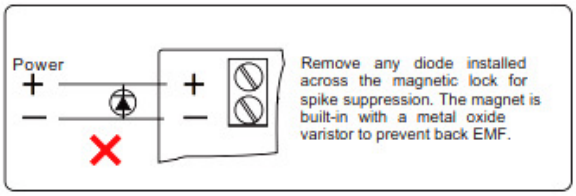
Ensure the surface area of the electromagnetic lock and the armature plate mate correctly or you will not get a good bond.



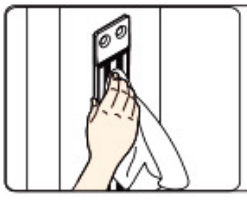
Ensure you notice the + and - although the unit is polarity insensitive.



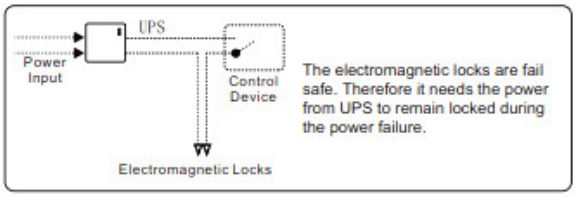
Ensure the face of the armature place and magnet are clean. Use a soft cloth to clean the surface. Never use anything abrasive to clean the magnet or armature plate.



Remove any diode installed across the magnetic lock for spike suppression. The magnet is built-in with a metal oxide varistor to prevent back EMF.



Wipe the surface of magnet lock with anti-rust oil regularly.



The electromagnetic locks are fail safe. Therefore it needs the power from UPS to remain locked during the power failure.