

ASSEMBLY INSTRUCTIONS



**for Certified Powered By
Endura® Door Systems**

**These instructions apply to the following
Certified Powered By Endura Systems:**



Single Doors



*Single & Double
Continuous Sidelite Units*



*French &
Patio Units*

Notes:

1. This instruction applies to both inswing and outswing doors, except where noted inswing is shown.
2. For caulking requirements Endura recommends (a) polymer based sealant, such as Bostik Pro-MS 50, (b) polyurethane sealant, or (c) 100% silicone sealant.

Required Components

Required components for Endura Certified Powered By Endura Door Units include the following:

For single doors:

- Composite Z-Series Sill
- Hinge Jamb
- Strike Jamb
- Header
- PE650 Weatherstrip
- Hinges
- Door Frame Alignment Bracket
- Dual Bulb Door Bottom (Inswing Units Only)
- Outswing Door Top (Outswing Units Only)

For sidelite and patio doors, in addition to components needed for single doors:

- One-piece Mullion(s)
- Continuous Header
- Continuous Sill
- Fixed or Sidelite Panel(s)
- Certified Powered By Endura Tested Composite Sidelite Seat(s)

For French doors, in addition to components needed for single doors:

- Ultimate Astragal
- Passive Panel
- Header Plate- Standard or Hurricane
- Sill Cup- Inswing or Outswing
- Sill Plate (Outswing Hurricane Only)



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Endura Certified Powered By Endura® Door Unit Assembly Instructions

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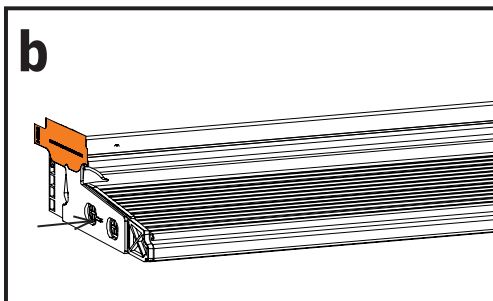
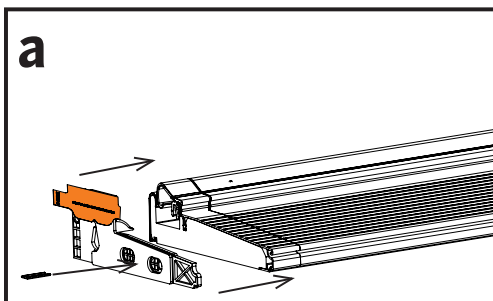
Step 13: Attach Alignment Bracket

Step 1: Checking Installation of Z-End Bases™ (Articulating Cap Sills Only)

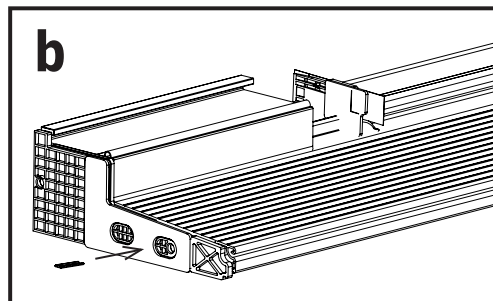
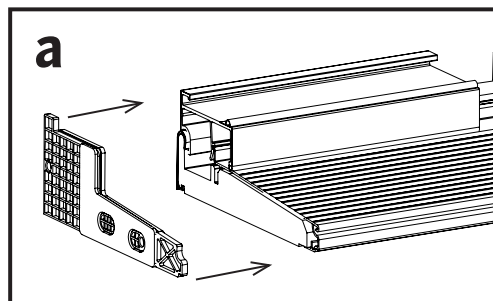
If assembling a door unit with a Z-Articulating Cap Sill®, be sure to check the installation prior to beginning the installation process.

Single, French Sills, Sidelite & Hinged Patio Sills**Installing the Z-End Base**

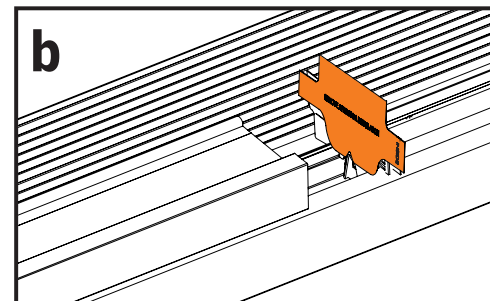
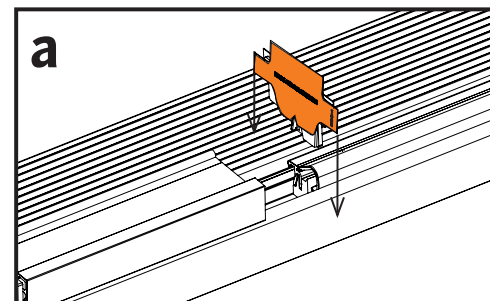
- Align the Z-End Base with the of end of the sill and Z-Articulating Cap then attach.
- Secure Z-End Base to the sill with staples. Repeat at other end of sill if no Sidelite Cap is present.

**Sidelite & Hinged Patio Sills****Installing the Z-End Base Sidelite Gasket**

- Align the Z-End Base Sidelite Gasket with the of end of the sill and Sidelite Cap then attach.
- Secure Z-End Base Sidelite Gasket to sill with staples. Repeat at other end of sill if a Sidelite Cap is present.

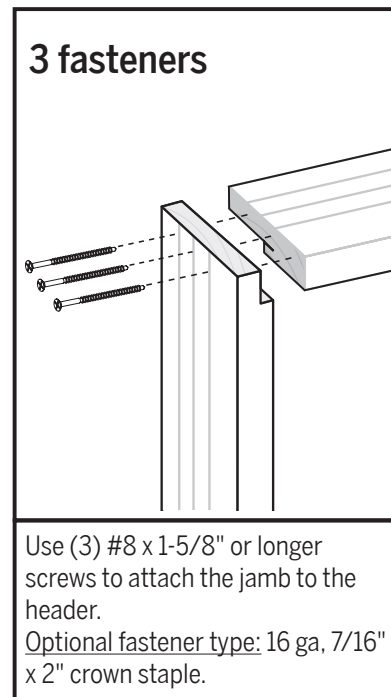
**Installing the Z-End Base Mull Stiffener**

- Insert the Z-End Base Mull Stiffener into the sill channel between the Z-Articulating Cap and Sidelite Seat.
- Ensure that the Z-End Base Mull Stiffener contacts the end of the Z-Articulating Cap. Repeat at the other end of the cap if necessary.

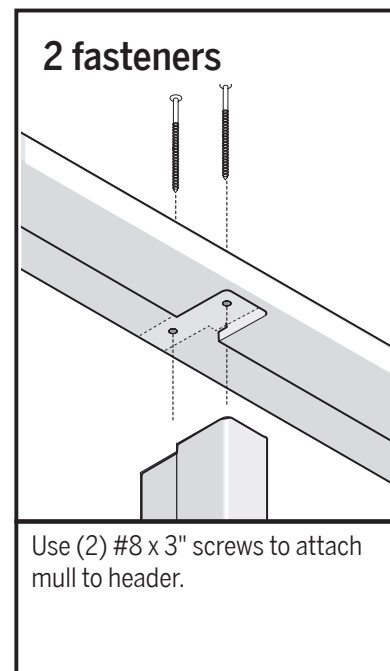


Step 2: Assembling the Frame and Mull at the Header

For All Door Units
Jamb to header



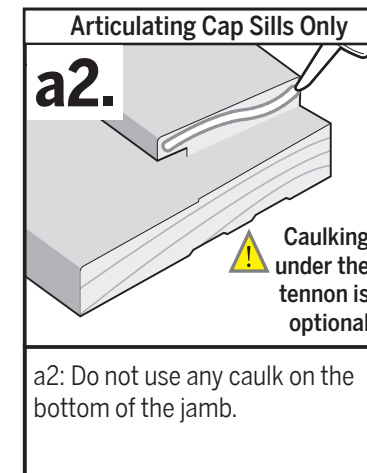
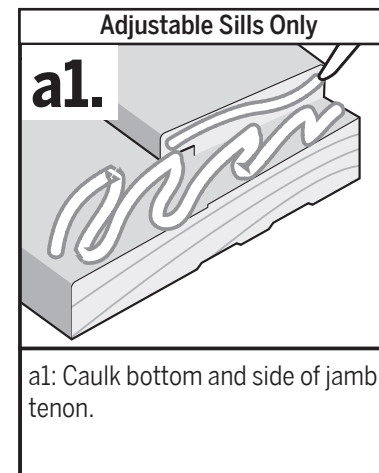
For Sidelite/ Patio Door Units Only
Mull to Header



Note: 3 fasteners are required in mull for high wind zone applications.

Step 3: Assembling the Frame at the Sill

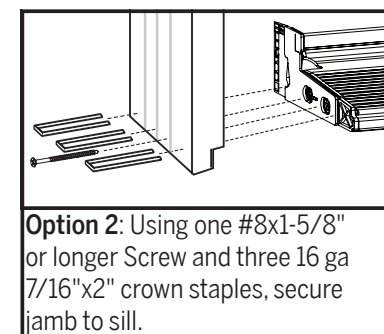
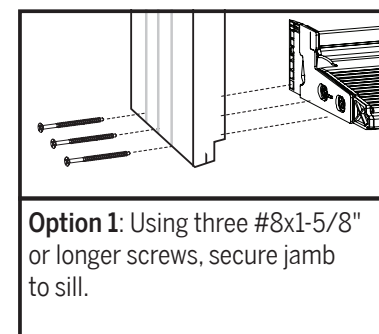
For All Door Units



Note: Assembly applies to both Adjustable and Z- Articulating Caps.

Adjustable and Articulating Cap Sills/ All Sills

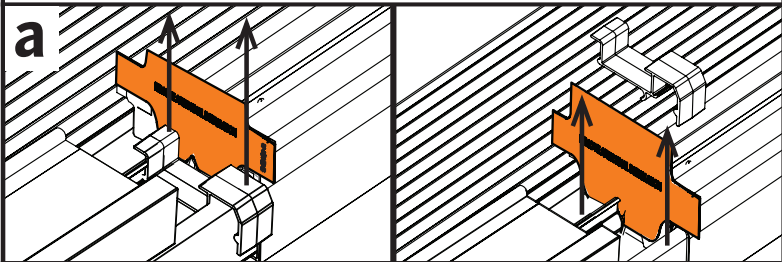
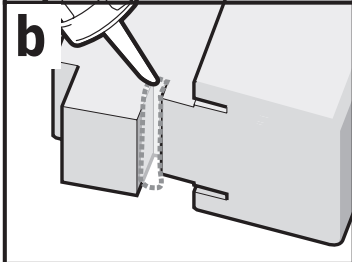
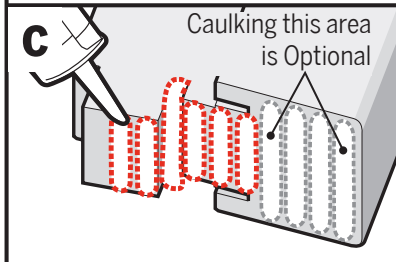
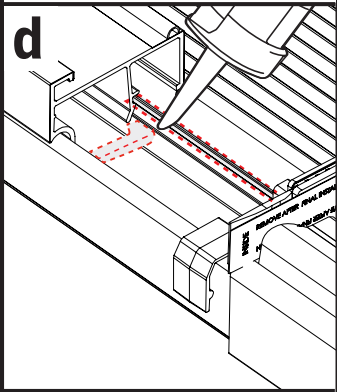
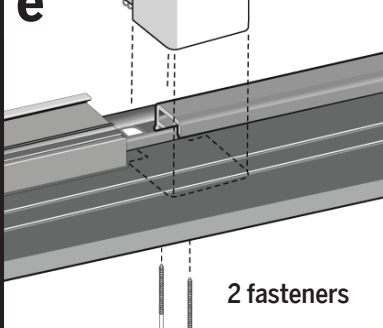
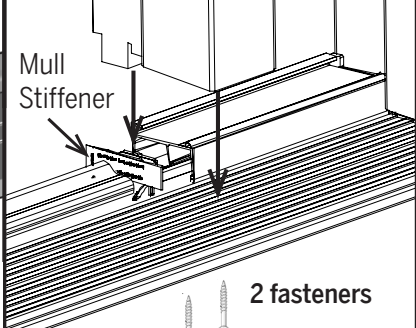
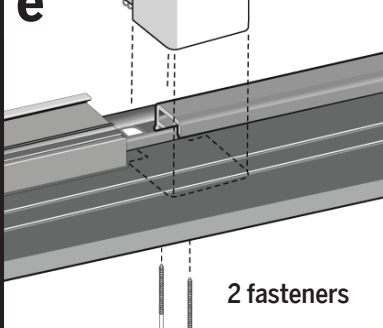
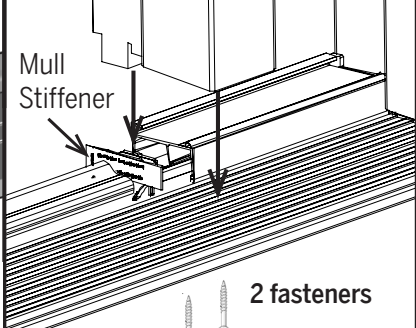
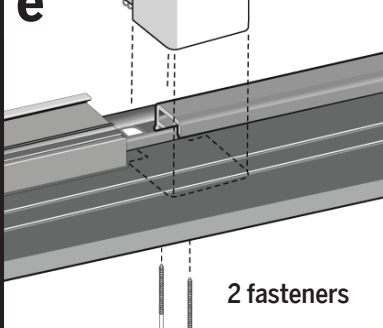
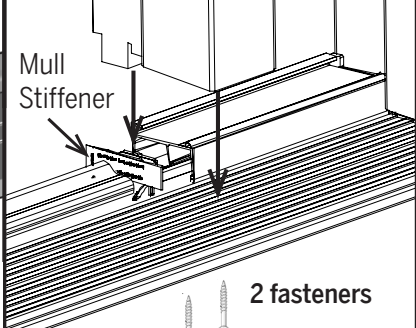
b: Secure jamb to sill.





Step 4: Assembling the Mull at the Sill


For Sidelite/ Patio Door Units Only


Note: Assembly applies to both Adjustable and Z-Articulating Caps, unless otherwise noted.

<p>Articulating Cap Sills Only</p>  <p>a</p> <p>Remove the protective shipping clip securing the mull stiffener in place.</p>	<p>All Sills</p>  <p>b</p> <p>Caulk thoroughly in dam haunch as shown by dotted lines above.</p>	<p>All Sills</p>  <p>c</p> <p>Caulk mull bottom surfaces bottom as shown by dotted lines above.</p>				
<p>All Sills</p>  <p>d</p> <p>Caulk inside edge of sill dam. Caulk substrate joint if present.</p>	<table border="1"> <tr> <td data-bbox="468 846 848 1235"> <p>Adjustable Sill Shown</p>  <p>e</p> <p>2 fasteners</p> </td> <td data-bbox="848 846 1260 1235"> <p>Articulating Cap Sill Shown</p>  <p>Mull Stiffener</p> <p>2 fasteners</p> </td> </tr> <tr> <td colspan="2"> <p>Apply caulked mull to sill as shown. Use #8 x 3" screws to mount mull to sill.</p> </td> </tr> </table>		<p>Adjustable Sill Shown</p>  <p>e</p> <p>2 fasteners</p>	<p>Articulating Cap Sill Shown</p>  <p>Mull Stiffener</p> <p>2 fasteners</p>	<p>Apply caulked mull to sill as shown. Use #8 x 3" screws to mount mull to sill.</p>	
<p>Adjustable Sill Shown</p>  <p>e</p> <p>2 fasteners</p>	<p>Articulating Cap Sill Shown</p>  <p>Mull Stiffener</p> <p>2 fasteners</p>					
<p>Apply caulked mull to sill as shown. Use #8 x 3" screws to mount mull to sill.</p>						

 **Note:** FrameSaver® mullions can be pre-drilled for easier screw attachment.

 **Note:** 3 fasteners are required in mullion for high wind zone applications.

 **Note For Articulating Cap Sill Applications:** Carefully insert mullion in place to avoid damaging Mull Stiffener.

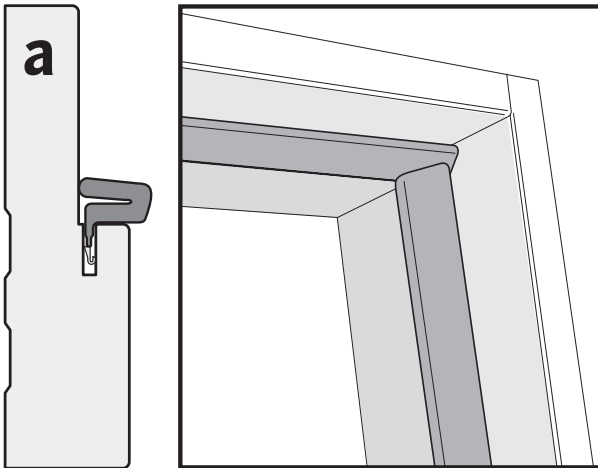
 **Note:** Avoid caulk squeeze out on the Z-End Base™ Gasket

If a Mull Boot is used, follow separately issued Mull Boot Instructions

Step 5: Inserting the Weatherstrip

For All Door Units

- a. Insert weatherstrip by fully installing/placing leg fully into frame kerf slot.
- Ends should lightly touch frame face or mating weatherstrip.



Note: Do not use weatherstrip that is too short or too long.

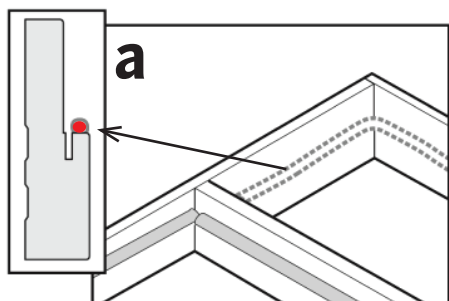


Note: Do not fold or wrinkle weatherstrip.

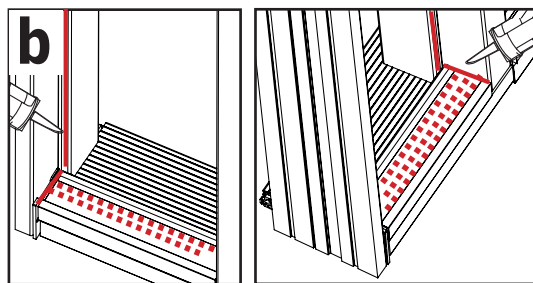
Step 6: Fixed Panel Assembly

For Sidelite/ Patio Door Units Only

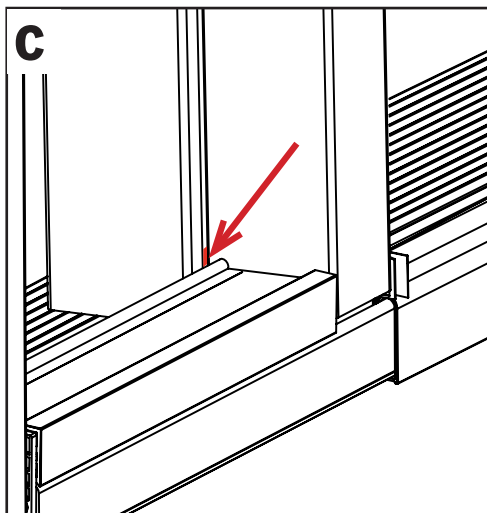
Caulking for the Fixed Panel



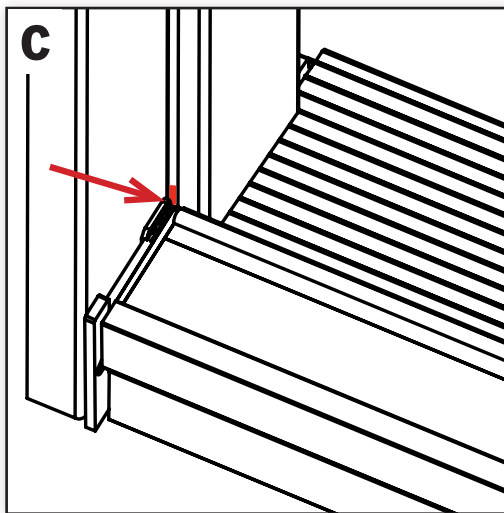
a. Apply a continuous bead of caulk to the stop of the jamb, mull and head where the sidelite will rest.



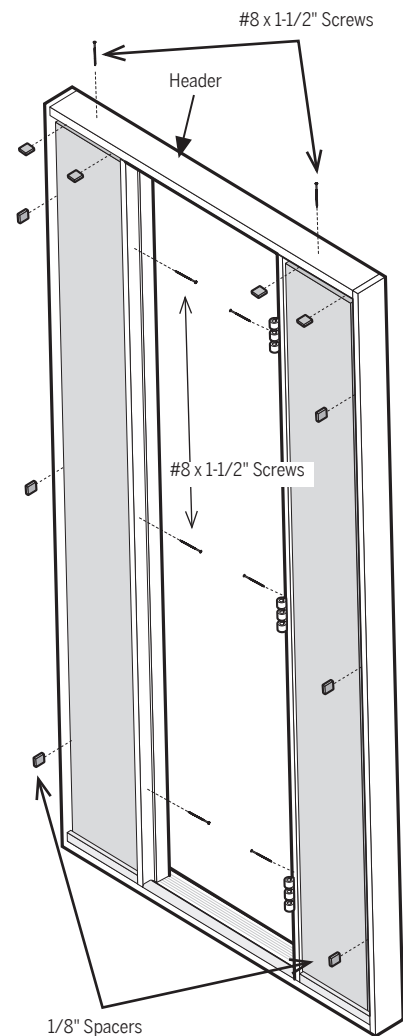
b. Apply caulk to the inactive cap as shown. Caulk through in both corners



c. Squeeze extra caulk into the kerf slot in front of sidelite cap to ensure that a proper seal is created.



Installing Fixed Panels



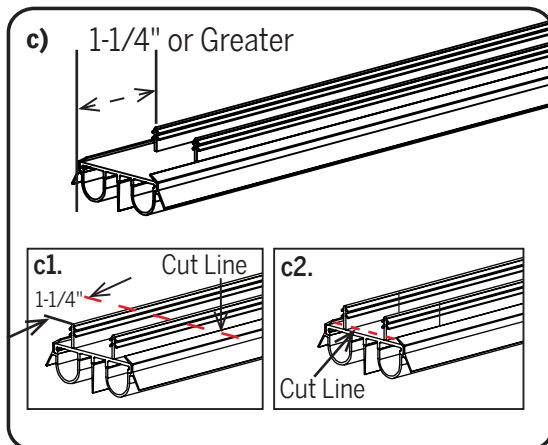
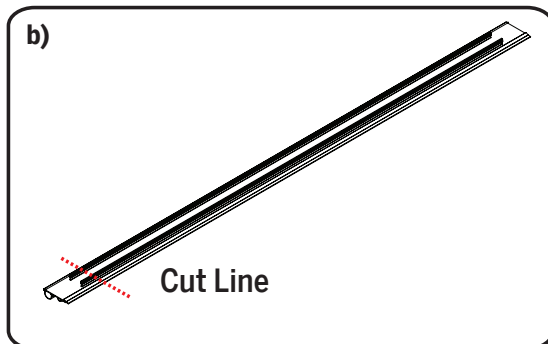
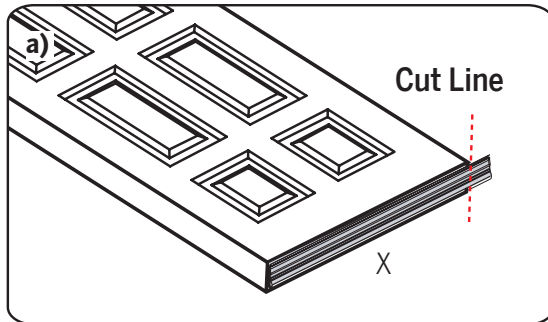
- Place panel into frame opening.
- Set tight sidelite seat & mullion
- Apply 1/8" spacers
 - Two at the header
 - One at the jamb at each hinge position
- Secure to frame with #8 x 1-1/2" screws.
 - First through the mullion at each hinge position.
 - Next through the jamb at each hinge position
 - Finally through the header at the center.

Note: For high wind zone applications, apply #8 x 3" screw through the bottom of the sill into the panel.

- 1 at the center of the sidelite panels
- 2 evenly spaced for full sized panels.

Step 7: Cut Door Bottom to Length (If needed)

For All Door Units



a) Align the Door Bottom with the panel and mark cut line.

b) Cut down the Door Bottom to match the length of the panel within 1/32".

c) If less than a 1-1/4" notch is left after cutting down the Door Bottom, re-notch the Kerfs to 1-1/4" by clipping the kerf legs.

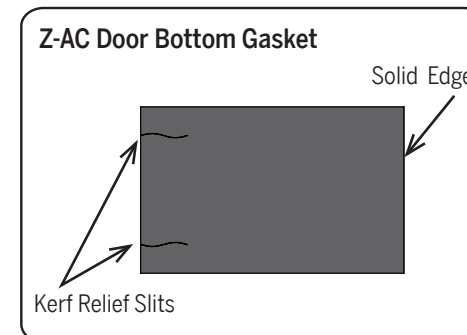
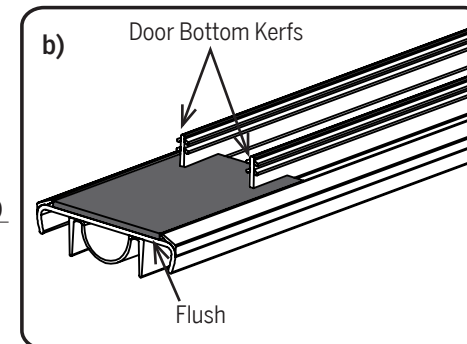
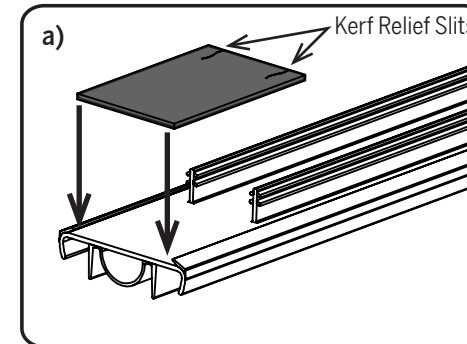
c1. Measure and mark the Kerf legs at 1-1/4" from the edge of the Door Bottom. Cut the Kerf leg down to the base of the door bottom.

BE CAREFUL NOT CUT INTO THE DOOR BOTTOM.

c2. From the edge of the Door Bottom, trim the kerf legs at the base back to the cut made in the previous step.

Step 8: Apply New Door Bottom Gasket**Z- Articulating Cap Sill® Kerfed Door Bottoms**

If the Door Bottom Gasket was trimmed off in step 7, apply a NEW Door Bottom Gasket to the trimmed end of the Z-AC™ Door Bottom.



a) Align the Door Bottom Gasket with the Z-AC Door Bottom.

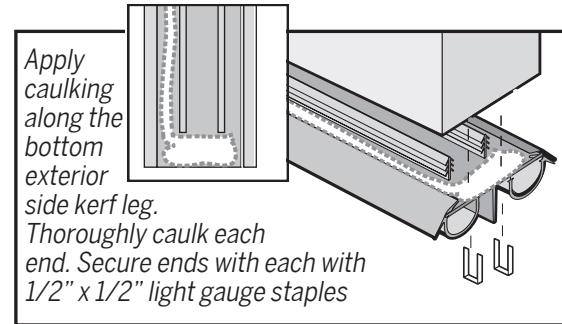
- The edge with the Kerf Relief Slots should be facing the Door Bottom's Kerfs, while the solid edge should be aligned with the outer edge of the door bottom.

b) Apply Door Bottom Gasket to Door Bottom.

- Ensure that the Gasket's Solid Edge is aligned flush with the edge of the Z-AC Door Bottom, and that the Door Bottom's Kerfs are protruding through the Relief Slits of the Gasket.

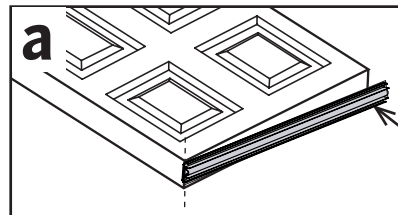
Step 9: Attaching the Door Bottom

Adjustable or Fixed Sill Door Bottoms

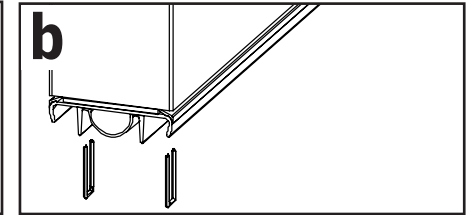
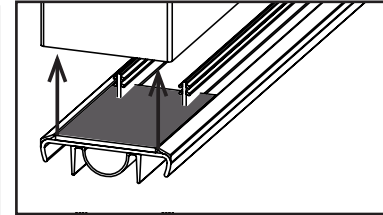


Z- Articulating Cap Sill® Kerfed Door Bottoms

DO NOT USE ANY CAULK



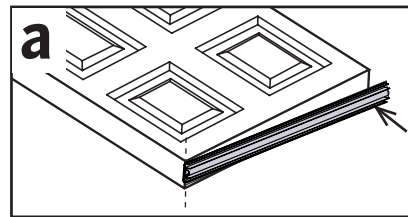
a. Align door bottom flush with the **lock side** of the panel and insert kerfs into slots on door. DO NOT USE ANY CAULK



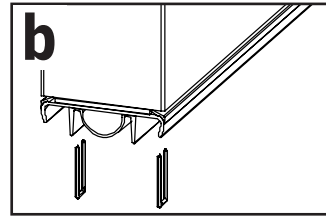
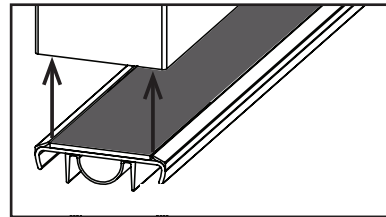
b. Attach Door Bottom with **two 1/2" crown staples and 80 PSI of air pressure** at ends between the rigid ramp and flex fins.

Z- Articulating Cap Sill Staple-On Door Bottoms

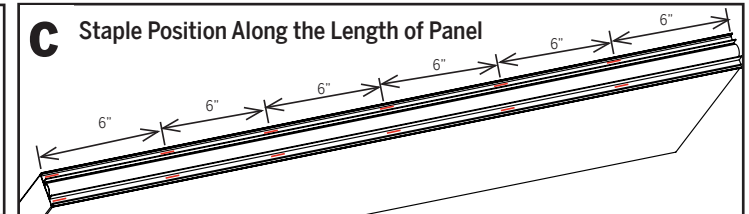
DO NOT USE ANY CAULK



a. Align door bottom flush with the **lock side** of the panel and hold in place. DO NOT USE ANY CAULK



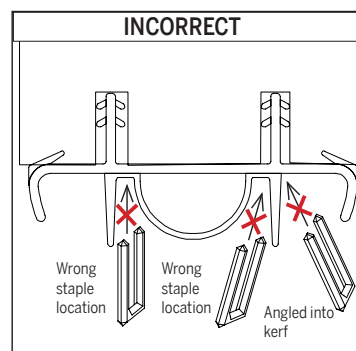
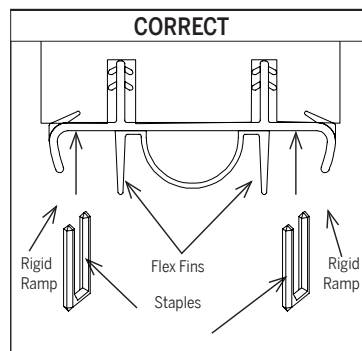
b. Attach Door Bottom with **two 1/2" crown staples and 80 PSI of air pressure** at ends between the rigid ramp and flex fins.



c. Staple on both sides approximately every 6" along the length of the door.

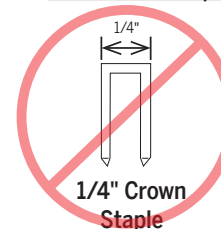
Note: When stapling the Z-AC™ Door bottom to the panel, staples should be inserted between the **Rigid Ramp** and **Flex Fins**. On all Door bottom applications, staples should be aimed away from the kerf slots in the bottom of the panel to prevent cracking of the door bottom, or damage to the kerfs.

The insertion of staples at an angle or in the wrong location will result in damage to the door bottom

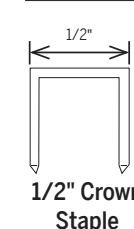


1/2" crown staples should be used to secure the door bottom to the panel. The use of staples with a shorter crown such as crown 1/4" staples will result in cracking and damage to the door bottom.

Incorrect Size Staple



Correct Size Staple



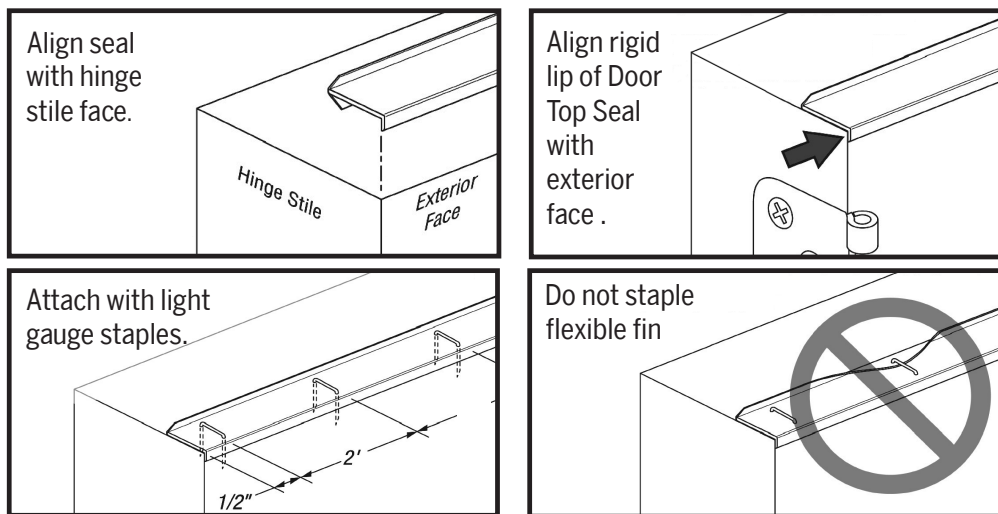
Required Air Pressure



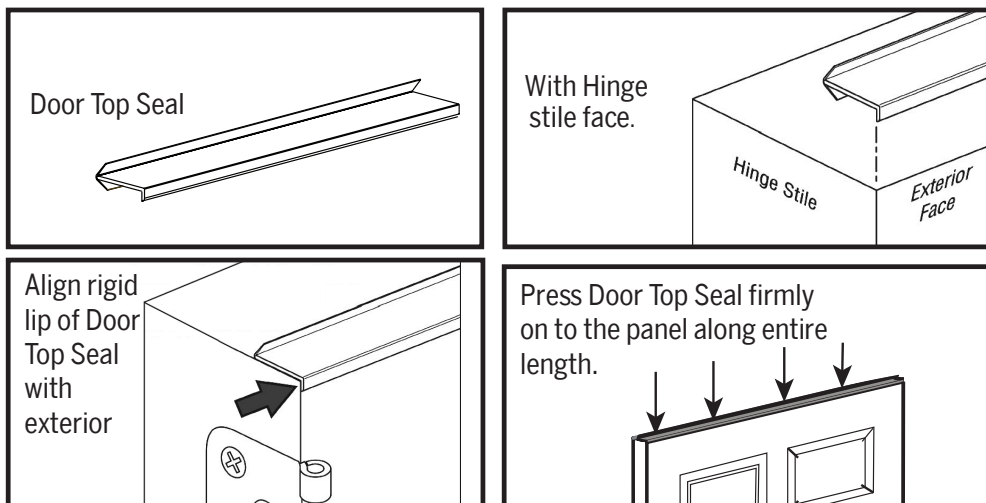
Use 80 PSI of air pressure to insert staples. Endura suggest using an air pressure regulator for best results.

Step 10: Attaching Door Top. (Outswing Units Only)

Note: For Steel Edge Doors skip to 8b.



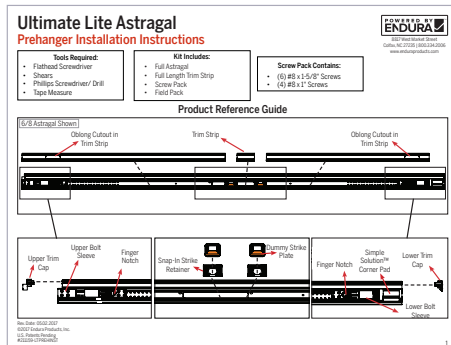
8b. Attach Door Top (For Steel Edge Panels)



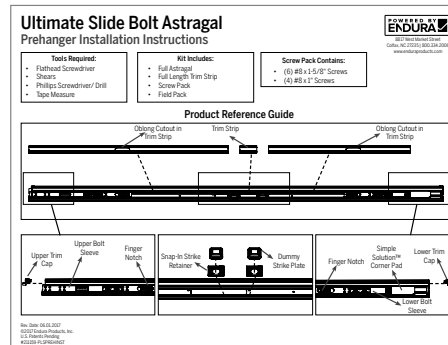
Step 11: Attaching Astragals to the Inactive Panel. (French Units Only)

Attach an Endura Ultimate Astragal according to separately issued “Prehanger Installation Instructions”.

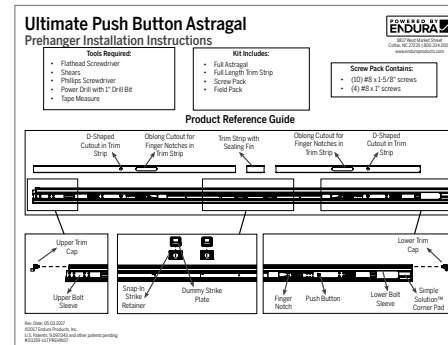
Ultimate Lite Astragal



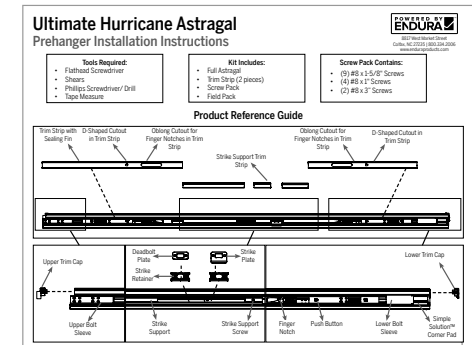
Ultimate Slide Bolt Astragal



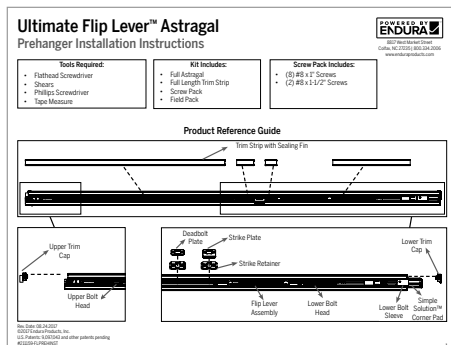
Ultimate Push Button Astragal



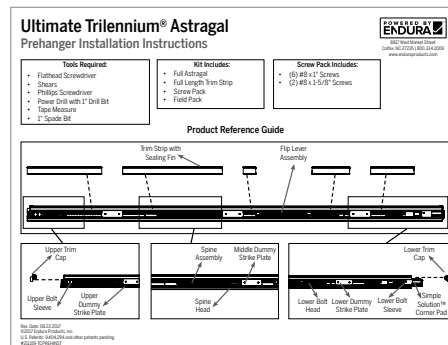
Ultimate Hurricane Astragal



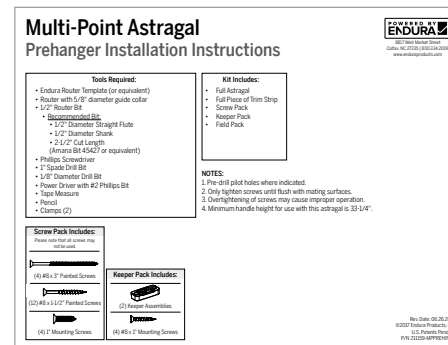
Ultimate Flip Lever™ Astragal



Ultimate Trilennium® Astragal



Ultimate Multi-Point Astragal



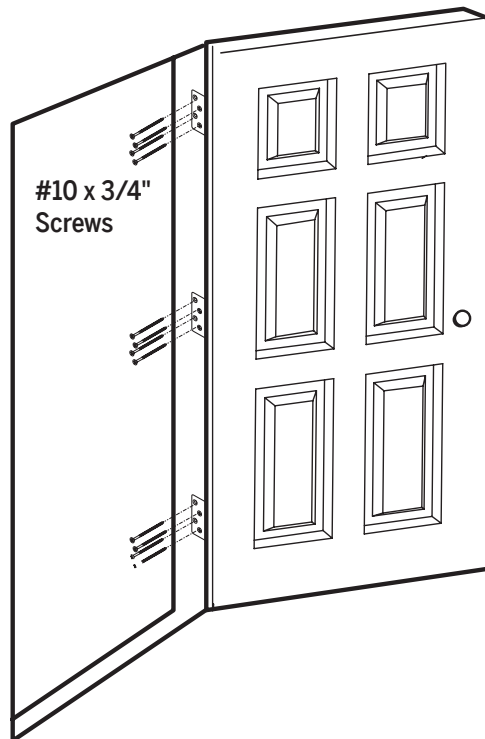
Step 12 Hinged Panel Assembly

For All Door Units

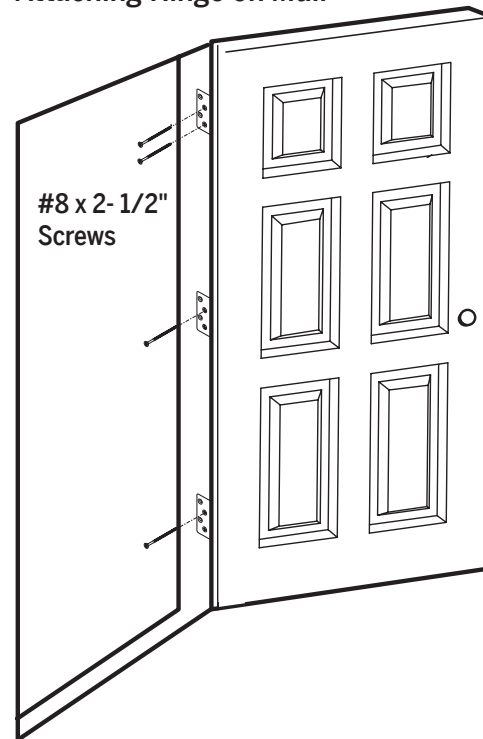
Attach hinges

- a. Secure to panel with #10 x 1" screws
- b. Secure to jamb with #10 x 3/4" screws
- c. For hinge on mull use # 8 x 2- 1/2" screws at:
 - Top two holes closest to the weatherstrip
 - Other hinges on top hole closest to the weatherstrip

Attaching Hinge on Jamb

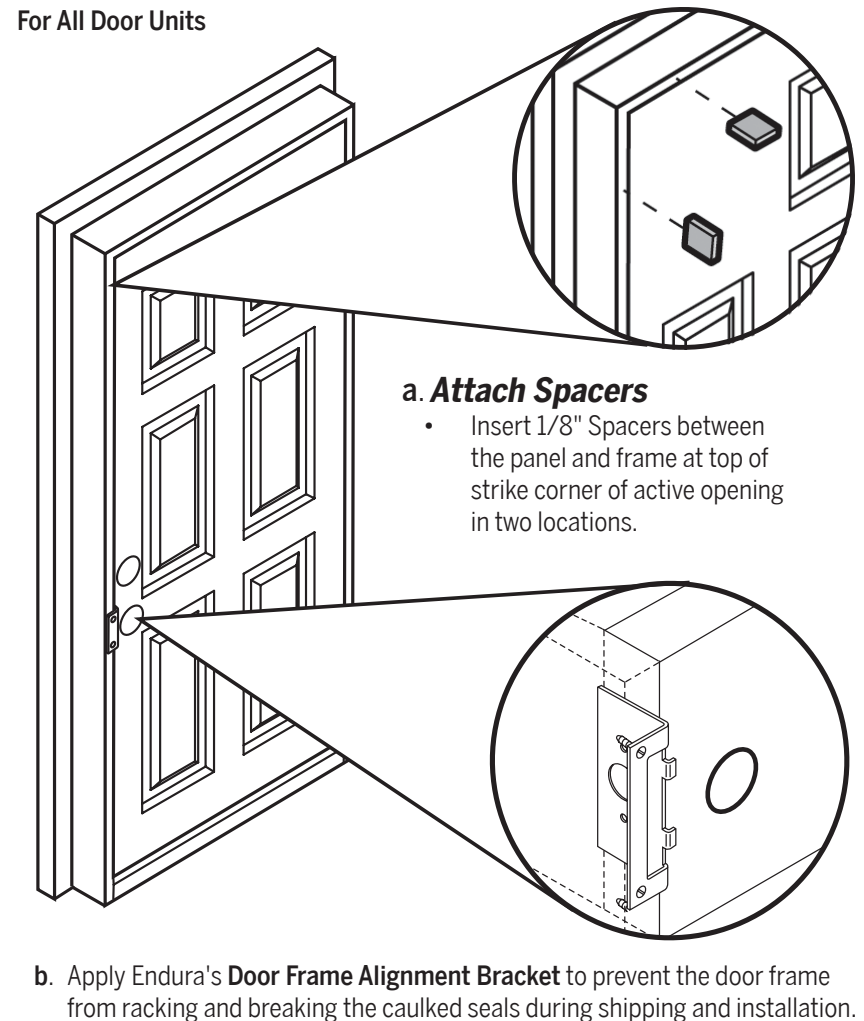


Attaching Hinge on Mull



Step 13: Attach Alignment Bracket

For All Door Units



If you have any questions, please contact your Endura Sales Representative or call Customer Service: 1-800-334-2006

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