

# All-Aluminum Z-Articulating Cap Sill Field Replacement Instructions

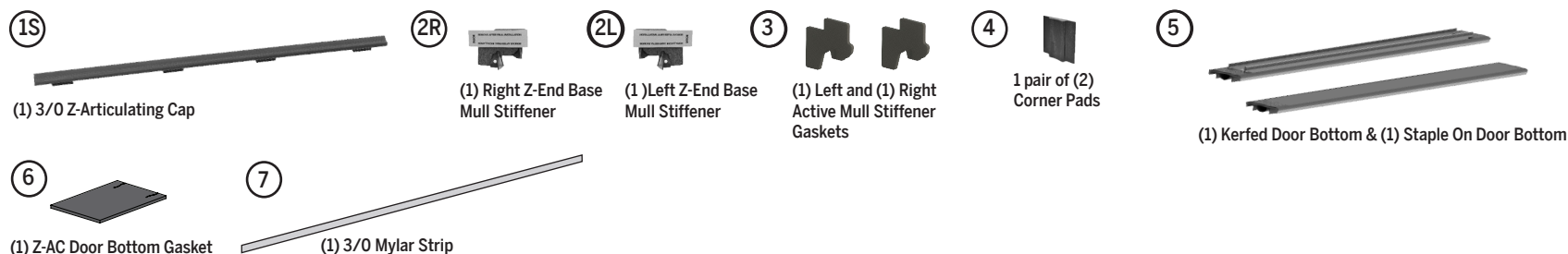
## Required Tools and Materials

1. **Flathead Screw Driver or Stiff Scraper:** To remove old Z-Series sill cap.
2. **Small Wood Block:** To protect aluminum sill deck when prying off adjustable sill cap.
3. **Measuring Tape:** For sizing new sill cap and door bottom before cutting to proper length.
4. **Pencil:** To mark cap and door bottom.
5. **Cutting Tool:** Chop /Miter Saw recommended to trim cap and door bottom to proper length.
6. **1/2" crown Staples:** To secure Door bottom to panel.

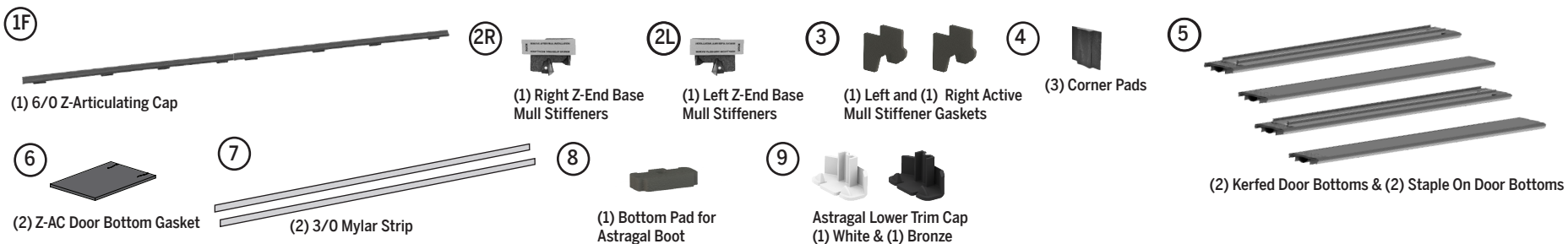
## ADDITIONAL TOOLS FOR FRENCH DOORS

1. **7/8" Diameter Drill Bit**

## Standard Door (Single) Replacement Kit Contents



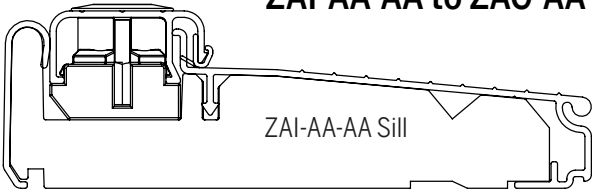
## French (Double Door) Replacement Kit Contents



## Identifying Your Sill System

Use the boxes below to identify your current sill system. Once your sill system has been properly identified, proceed to the appropriate section.


### Z-Series Adjustable Sill (ZAI-AA-AA )




ZAI-AA-AA Sill

**ZAI-AA-AA to ZAC-AA**

SEE PAGE 4



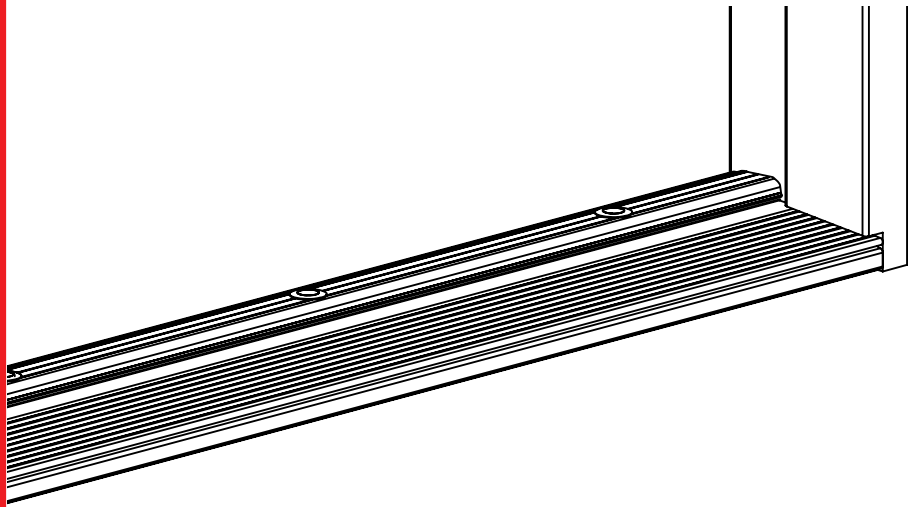
Screw Hole Cover



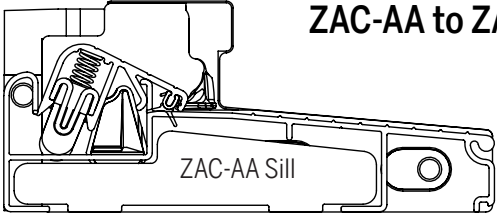
Bolt Receiver Cup  
(French Doors Only)

**ZAI-AA-AA Features**

- Flat Cap
- Receiver Cup Under Cap
- Screw Covers



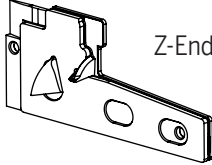
### Z-Series Articulating Sill AA (ZAC-AA )



ZAC-AA Sill

**ZAC-AA to ZAC-AA**

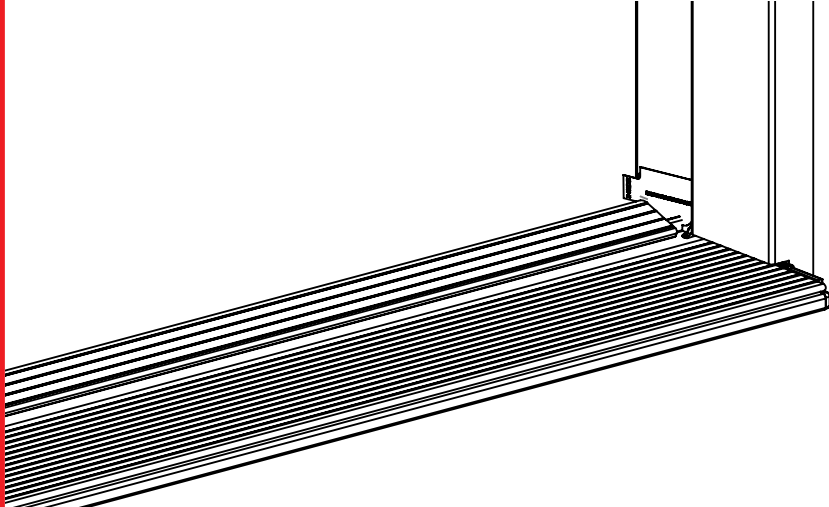
SEE PAGE 17



Z-End Base

**ZAC-AA Features**

- Slanted Cap
- Z-End Bases with Weatherstrip Locator
- Pin Capture Under Cap



# Z-Articulating Cap Sill Field Replacement Instructions

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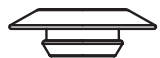
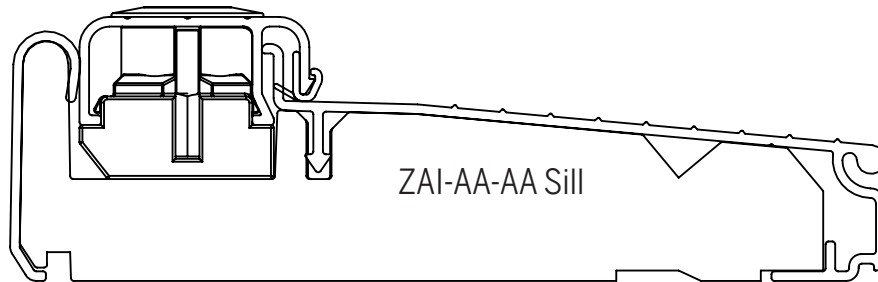
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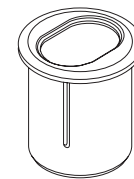
### **ZAC-AA to ZAC-AA** PAGE 14

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## Z-Series Adjustable All-Aluminum Sill (ZAI-AA )



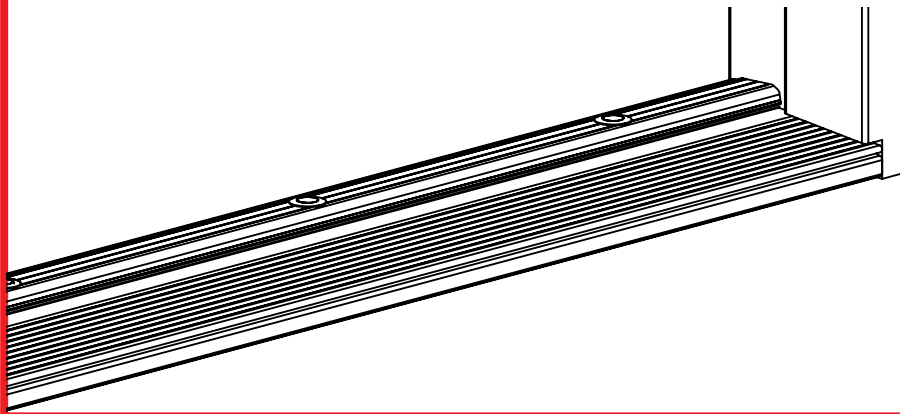
Screw Hole Cover



ZAI-AA-AA Receiver Cup  
(French Doors)

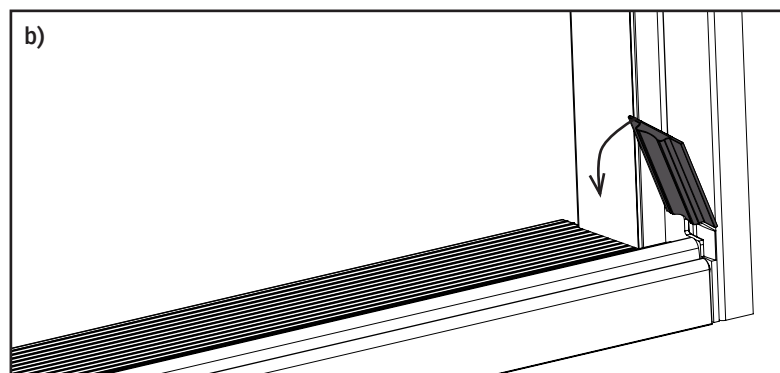
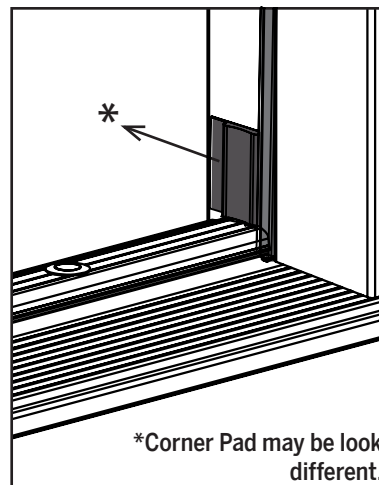
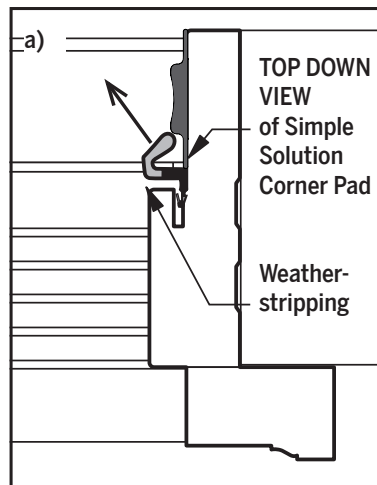
### ZAI-AA-AA Features

- Flat Cap
- Screw Covers
- Receiver Cup Under Cap



## 1. Remove Corner Pads (ZAI-AA to ZAC-AA)

- a) Remove the weatherstrip by pulling it out of the kerf slot
- b) (If Present) Remove Simple Solution Corner Pad from each jamb by peeling it off.
- c) Clean any residual debris and dirt from the jamb.
- d) Proceed to Step 2.

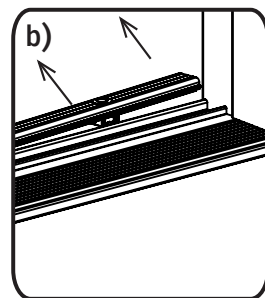
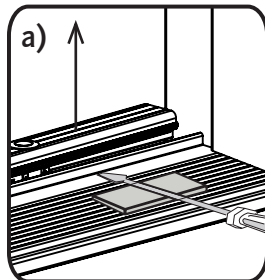


## 2. Remove OLD Adjustable Cap (ZAI-AA to ZAC-AA)



**Protect aluminum sill deck with a small wood block to prevent damage when prying off sill cap.**

- Place a flathead screwdriver under front leg of sill cap at one end. Then pry sill cap up with screwdriver, working from one end to the other.
- Pull sill cap out of channel.
- Clean any debris out of sill channel and on the jambs.
- Proceed to step 3.



## 3. Install Mylar Strip(s) (ZAI-AA to ZAC-AA)

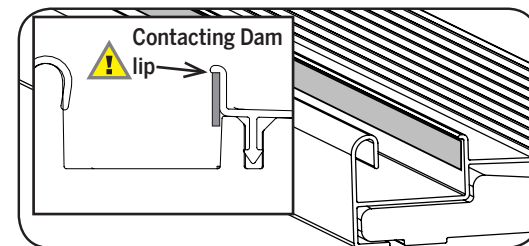
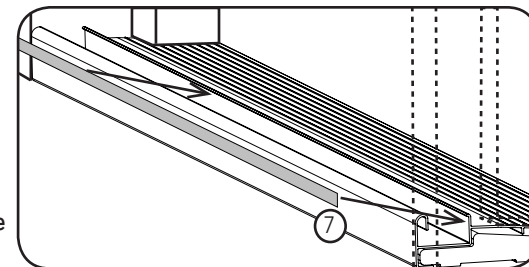
- Align the Mylar Strip ⑦ with the inside edge of the Dam of the Sill, and apply by firmly pressing into place.



**Mylar Strip should contact the lip of the Dam.**



**For French Applications two Mylar strips should be used along the full length of the sill channel.**



## 4. Install Z-End Base Mull Stiffeners (ZAI-AA to ZAC-AA)

- Insert Z-End Base Mull Stiffeners ②L & ②R into each side of the channel against the jambs



**NOTE:** The Z-End Base Mull Stiffeners are handed and can only be inserted one way. The back of the Z-End Base Mull Stiffener should be flush with the face of the jamb.

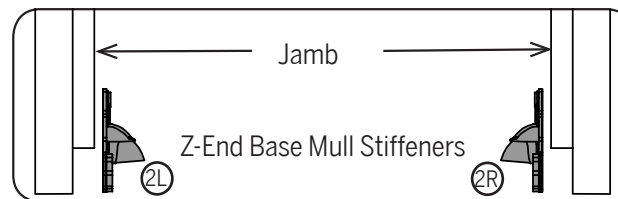
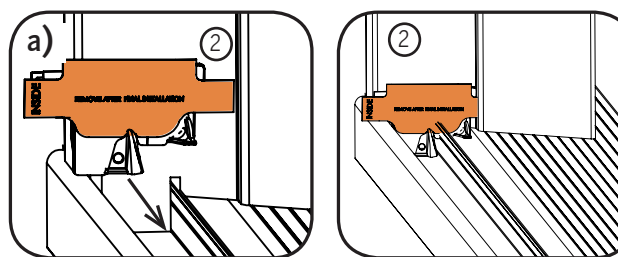


**NOTE:** Do not caulk or staple the Z-End Base Mull Stiffeners in place.



**NOTE:** Do not remove the orange protective gasket label until cap is fully installed into the door unit.

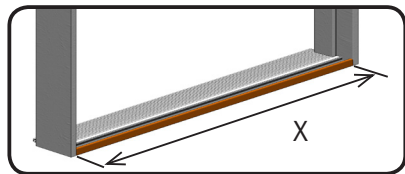
- Proceed to step 4.



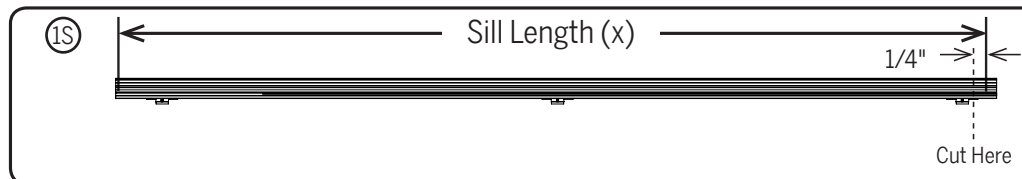
## 5. Cut NEW Z-Articulating Cap to Length (ZAI-AA to ZAC-AA)

### FOR SINGLE, SIDELITE AND HINGED PATIO DOOR APPLICATIONS

- a) Measure the length of the sill (X).



- b) Measure and cut new cap (1S) to match length of the sill minus 1/4".

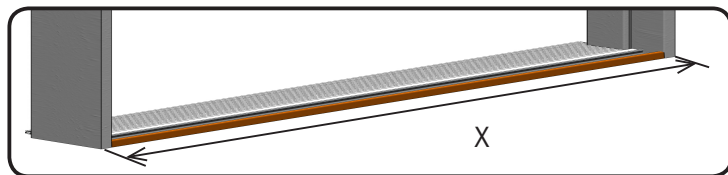


**CAUTION:** Measure carefully and cut precisely within 1/32" to ensure proper operation. A cap cut too short will not seal correctly.

- c) Proceed to step 5

### FOR FRENCH (DOUBLE) DOOR APPLICATIONS

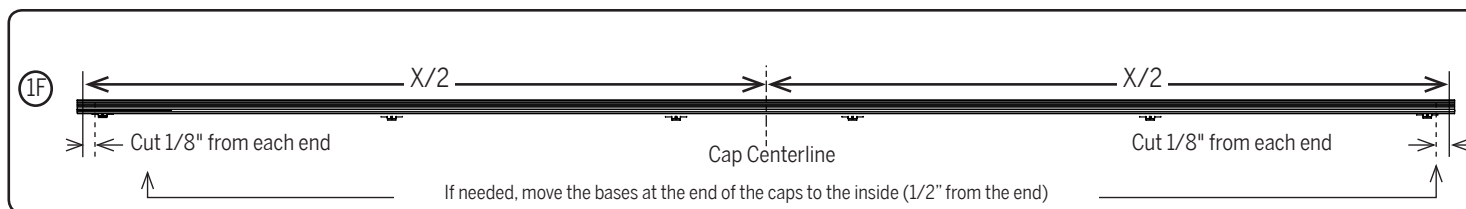
- a) Measure the length of the sill (X).



- b) Measure and mark the centerline of the Cap

- c) Measure and cut new cap (1F) to match length of the sill minus 1/8" on each side. Cut from both ends of the cap to ensure caps Centerline remains centered.

**CAUTION:** Measure carefully and cut precisely within 1/32" to ensure proper operation. A cap cut too short will not seal correctly.



- d) Proceed to step 5

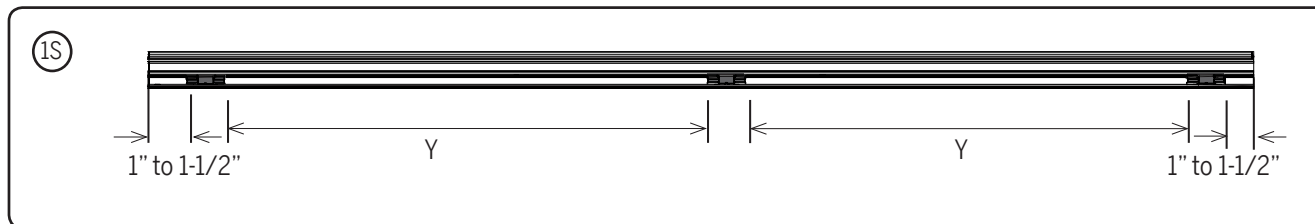
## 6. Apply Spring-Loaded Cap Bases (ZAI-AA to ZAC-AA)

### SINGLE, SIDELITE AND HINGED PATIO DOORS ONLY

- a) Ensure that all 3 spring-loaded bases are used and properly positioned.

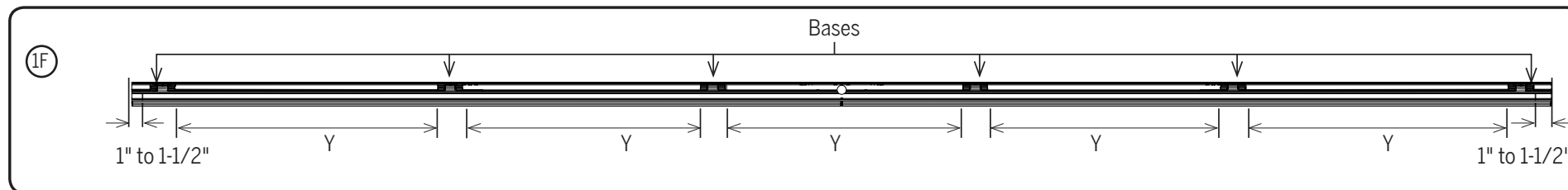
The spring-loaded bases at the ends of the cap should be 1" to 1-1/2" from the cap's edge. The spring-loaded center base should be evenly spaced between the 2 spring-loaded bases at the ends of the cap, approximately 12"-15" inches apart (Y).

- b) Proceed to step 6



### FRENCH (DOUBLE) OPENING DOORS ONLY

- a) Ensure that all 6 spring-loaded bases are used and properly positioned.  
The spring-loaded bases at the ends of the cap should be 1" to 1-1/2" from the cap's edge. The 4 center spring-loaded bases should be evenly spaced between the 2 spring-loaded bases at the ends of the cap, approximately 12"-13" inches apart (Y).



- b) Proceed to step 6



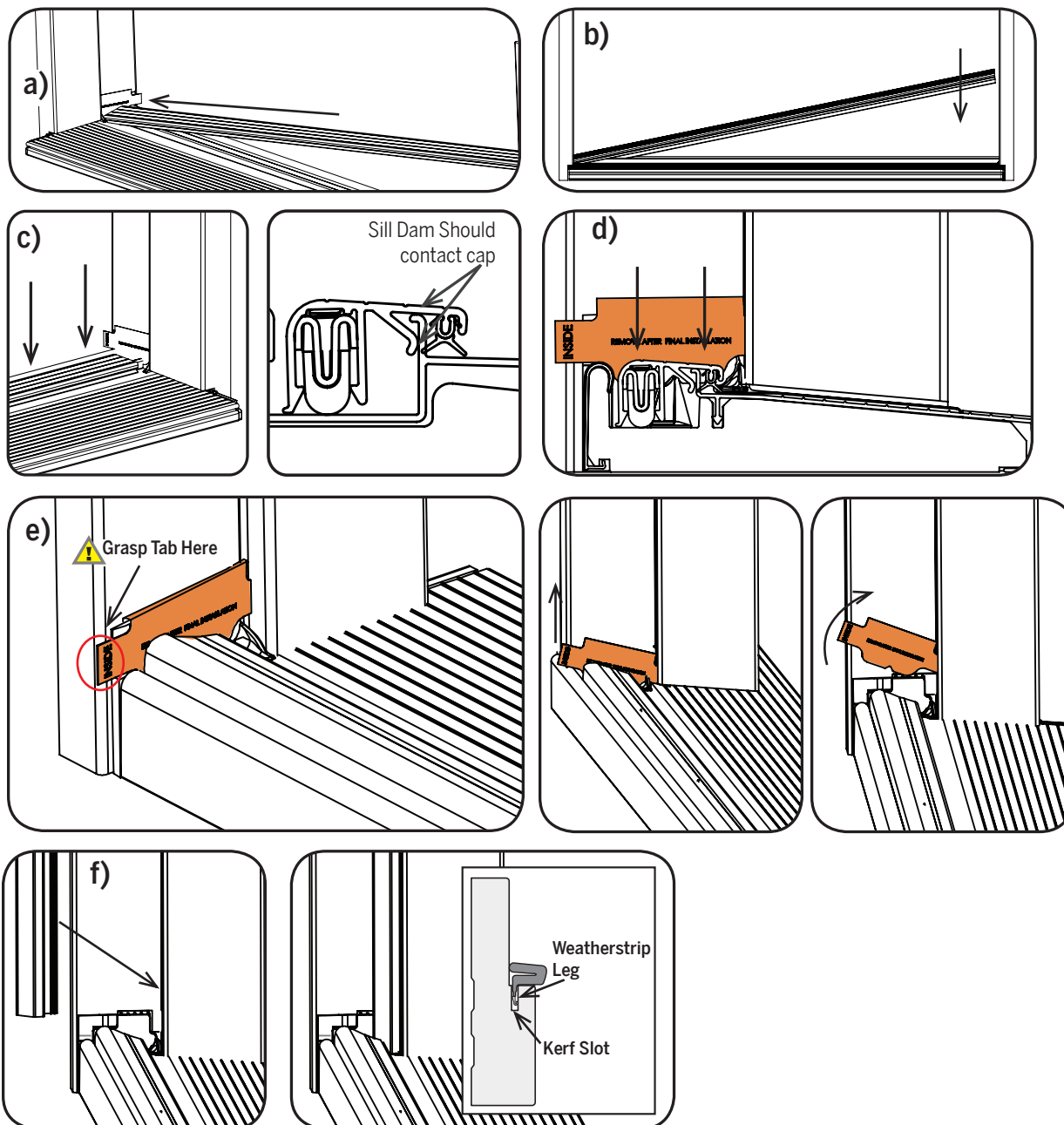
## 7. Insert NEW Sill Cap (ZAI-AA to ZAC-AA)

## FOR SINGLE, SIDELITE, HINGED PATIO AND FRENCH DOOR UNITS

- a) Press one end of cap ① into channel and against Z-End Base/ Mull Stiffeners ②.
- b) Install the opposite end of the cap ① into the sill by bringing it straight down into the sill channel and against Z-End Base/ Z-End Base Mull Stiffener ②.
- c) Apply Pressure to the cap ① to fully seat cap into place along entire length of sill.

**!** Sill Dam should contact the bottom side of the top of the cap, and the angled leg of the cap should contact the back side of the Sill Dam

- d) Depress the cap ①, to gain access to the orange protective labels on each Z-End base/ Mull Stiffener (If present) and remove.



- e) Proceed to step 8

## 9. Replace Astragal Bottom Sealing Pad and Corner Pad *French Door Units Only* (ZAI-AA to ZAC-AA)

### ! FOR FRENCH DOOR UNITS

- a) Position astragal to gain access to the Bottom Bolt Sleeve, Corner Pad and Bottom Sealing Gasket.

! Remove Weatherstrip to gain easy access to the Corner Pad

- b) Remove old corner pad and Bottom Sealing Gasket by peeling down and away from the astragal. Use a stiff scraper to remove any remaining residue.

- c) Install new Astragal Bottom Sealing Gasket ⑧ by aligning the flush bolt with the hole in the pad c1, then install new Simple Solution Corner Pad ④ by Pressing into place c2.

! The lip of the Bottom Sealing Gasket should extend out in front of the astragal, and the Simple Solution Corner Pad should sit flush on top of the gasket.

- d) Remove original Lower Trim Cap by prying it off of the bottom of the astragal with a Flat Head Screw Driver.

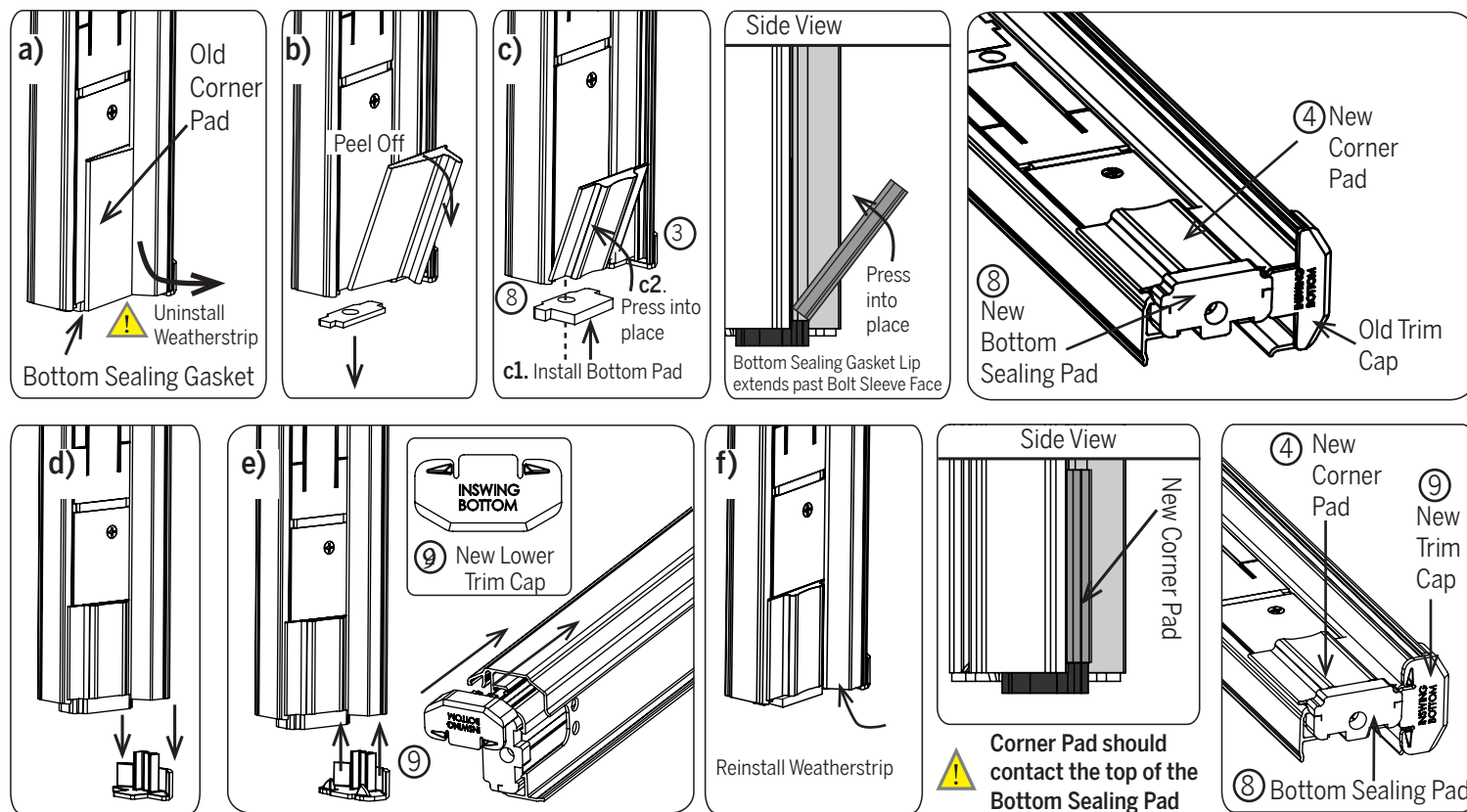
- e) Align the new Lower Trim Cap ⑨ with the astragal's body, and Insert the Trim cap into the bottom of the astragal.

! Use the Trim Cap that matches the color of the astragals body, and discard the other.

- f) Reinstall weatherstripping

! Ensure the edge of the Corner pad is located behind the weatherstrip after installing corner pad in place.

- e) Proceed to step 10



## 10. Replace Door Bottom Sweep (ZAI-AA to ZAC-AA)

### FOR SINGLE, SIDELITE, HINGED PATIO AND FRENCH DOOR UNITS

#### REMOVE DOOR FROM HINGES

- a) Remove old door bottom from panel by prying it off with a flathead screwdriver.
- \*Remove any caulk from the panel and kerf slots using a scraping tool .
- b) Align the Door Bottom ⑤ with the panel and mark cut line within 1/32". Cut line should match length of panel (X).
- c) Cut down the Door Bottom ⑤ to match the length of the panel (X).
- d) Using a stiff scraping tool, remove the existing Door Bottom Gasket from the end of the door bottom. If no Gasket is present or has been cut off completely, skip to step 2.



Be sure to completely remove all residue from the old gasket to assure the new pad adheres properly.

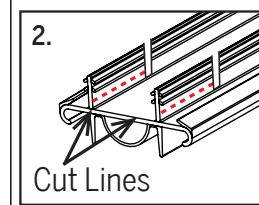
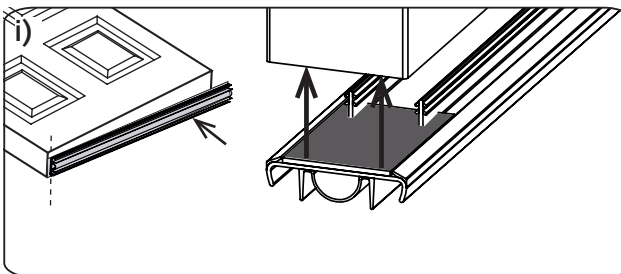
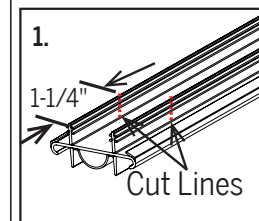
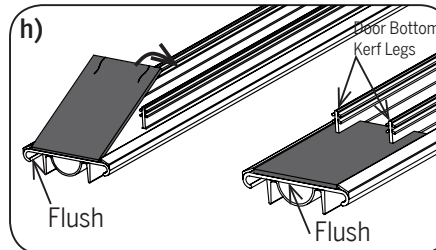
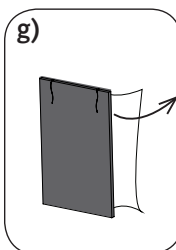
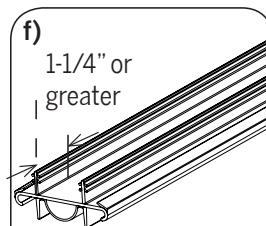
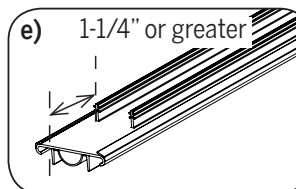
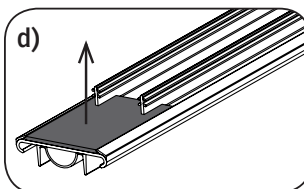
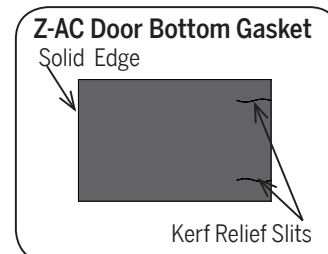
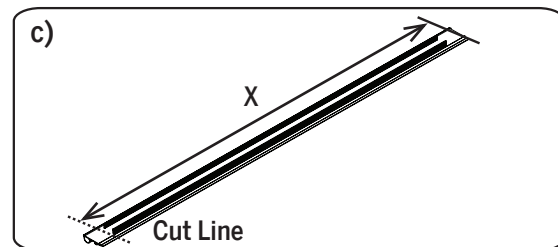
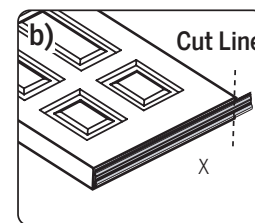
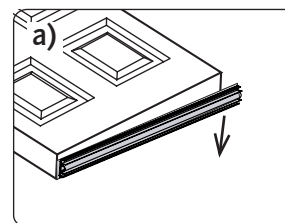
- e) Measure the location of the Kerf Legs. Kerf legs should be trimmed back 1-1/4" or more from the edge of the door bottom. If 1-1/4" or greater notch is present, proceed to step 4, If not proceed to step 3.
- f) If less than a 1-1/4" notch is present, re-notch the Kerf Legs to at least 1-1/4" by clipping the Kerf Legs.
1. Measure and mark the Kerf Legs at 1-1/4" from the edge of the Door Bottom. Cut the Kerf Legs down with a cutting tool to the base of the Door Bottom.



#### **BE CAREFUL NOT TO CUT INTO THE DOOR BOTTOM.**

2. From the edge of the Door Bottom, trim the Kerf Legs at the base back to the cut made in the previous step and remove.

- g) Remove paper backing from the Door Bottom Gasket.
  - Peel the protective paper layer covering the adhesive on the back of the Door Bottom Gasket off and discard.
- h) Align and Apply New Door Bottom Gasket to Z-AC Door Bottom
  - Align the Solid Edge of the Door Bottom Gasket with the outer edge of the Z-AC Door Bottom as shown. Once aligned, tip and press Gasket firmly into place, ensuring that the Door Bottom Kerf Legs protrude through the Gasket Relief Slits, while the Gasket Solid Edge remains aligned flush with the Door Bottom Edge.
- i) Align Door Bottom flush with the **lock side** of the panel and insert kerfs into slots on door.
- j) Proceed to step 11.



## 11. Stapling Door Bottom to Panel (ZAI-AA to ZAC-AA)

### FOR SINGLE, SIDELITE, HINGED PATIO AND FRENCH DOOR UNITS

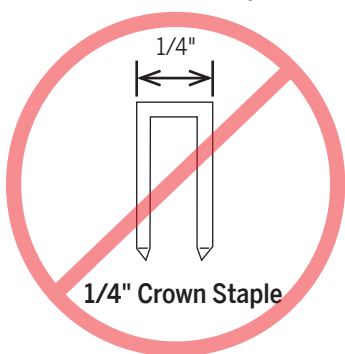
- a) Attach Door Bottom with **two 1/2" crown staples** and **80 PSI of air pressure** at ends between the rigid ramp and flex fins.

⚠ When stapling the Z-AC Door bottom to the panel, staples should be inserted between the **Rigid Ramp** and **Flex Fins**. 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.

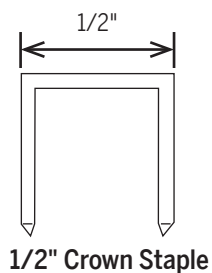
⚠ The insertion of staples at an angle or in the wrong location will result in damage to the door bottom

- b) **STAPLE ON SWEEP**- If using a staple-on door sweep, staple on both sides approximately every 6" along the length of the door.  
c) Proceed to step 12

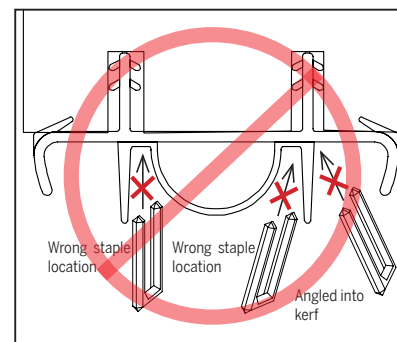
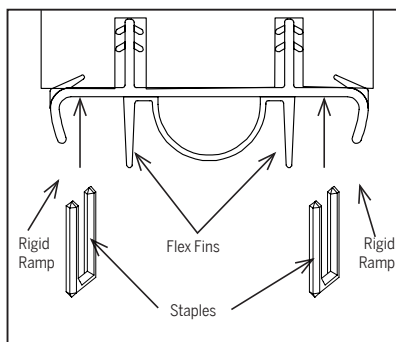
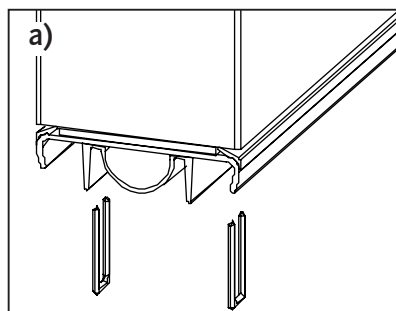
#### Incorrect Size Staple



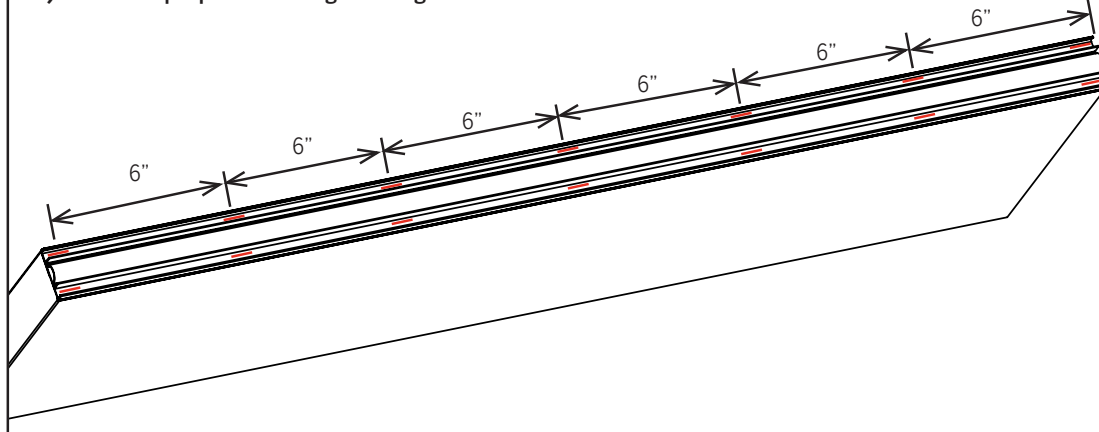
#### Correct Size Staple



Only 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.



#### b) Staple position Along the Length of Panel



#### Required Air Pressure



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

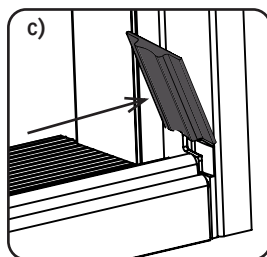
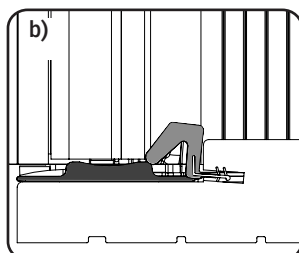
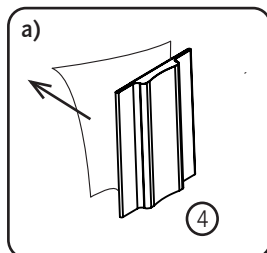
## 12. Replace Corner Pads (ZAI-AA to ZAC-AA)

### FOR SINGLE, SIDELITE, HINGED PATIO AND FRENCH DOOR UNITS

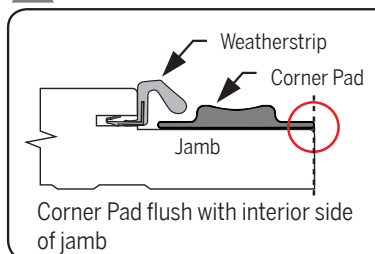
Ensure that the old corner pad has been removed from each jamb.

**NOTE:** For best performance, Do not reapply old/used corner pad. Replace with a new Simple Solution Corner Pad for this step.

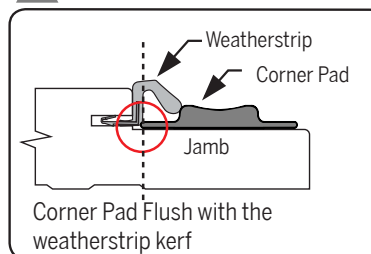
- Remove backing paper from Simple Solution Corner Pad ④ to expose adhesive.
- Align Simple Solution Corner Pad with the top of Z-End Base. For margins **less or equal to**  $5/32"$ , apply the corner pad with the locator edge flush against the weatherstrip kerf, and for margins **greater than**  $5/32"$ , apply the corner pad with the locator edge flush against the interior jamb.
- Ensure the Simple Solution Corner Pad contacts the top surface of the Z-End Base and press firmly into place on to jamb.
- Repeat Steps a - c for the second jamb
- Proceed to step 13



**For Strike Margins greater than  $5/32"$**



**For Strike Margins less than  $5/32"$**



## 13. Check the Operation of the Door

Close and open the door several times

- Ensure that the door opens and closes smoothly.
- Ensure the cap operates properly up and down as the door is opened and closed.
- Ensure that Door Bottom makes contact with the Z-AC as the door is closed.
- Ensure the Panel makes contact with the Corner Pad and Z-End Bases.

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

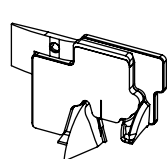
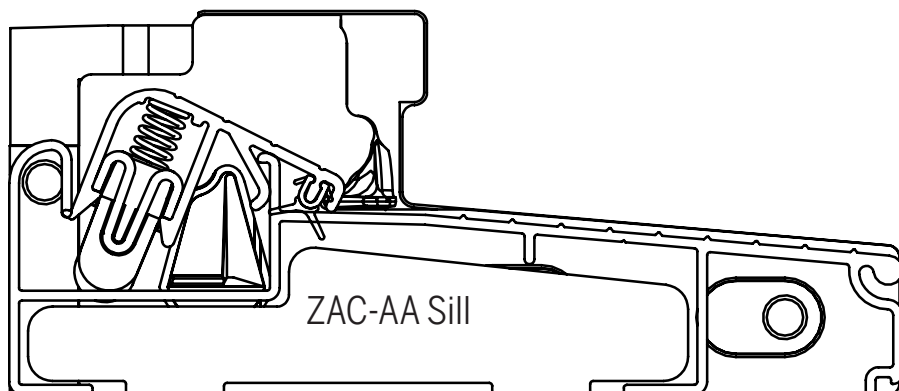
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US Patents: 6,789,358; 7,350,336; 8,522,483; 8,991,100; 8,991,101; D722,388; D638,958; D722,387; D722,388; D713,976 and Patents Pending.  
Canadian Patents: 2,771,705; D139,250 and Canadian Patents Pending.

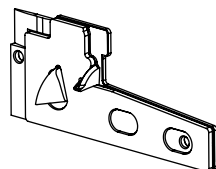


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## Z-Series Articulating Cap All-Aluminum Sill (ZAC-AA )

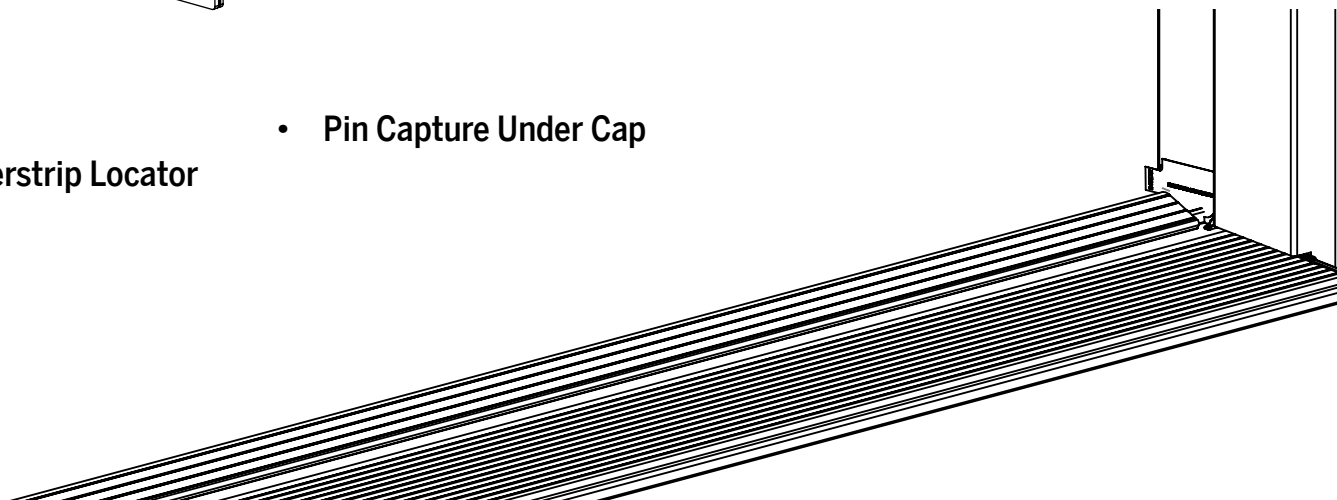


Z-End Base



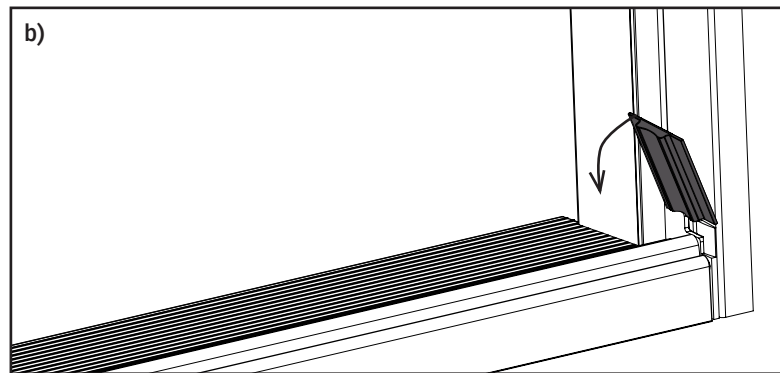
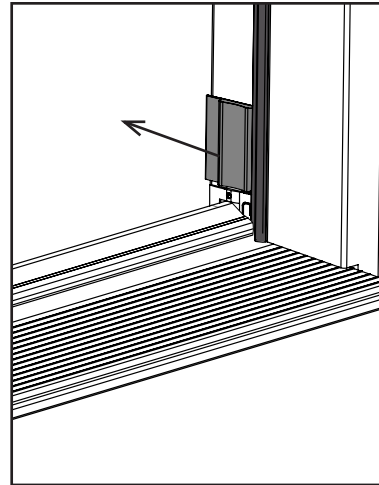
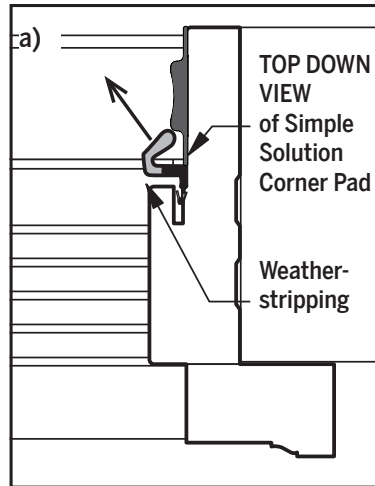
### ZAC-AA Features

- Slanted Cap
- Z-End Bases with Weatherstrip Locator
- Pin Capture Under Cap



## 1. Remove Corner Pads (ZAC-AA to ZAC-AA)

- a) Remove the weatherstrip by pulling it out of the kerf slot
- b) (If Present) Remove Simple Solution Corner Pad from each jamb by peeling it off.
- c) Clean any residual debris and dirt from the jamb.
- d) Proceed to Step 2.

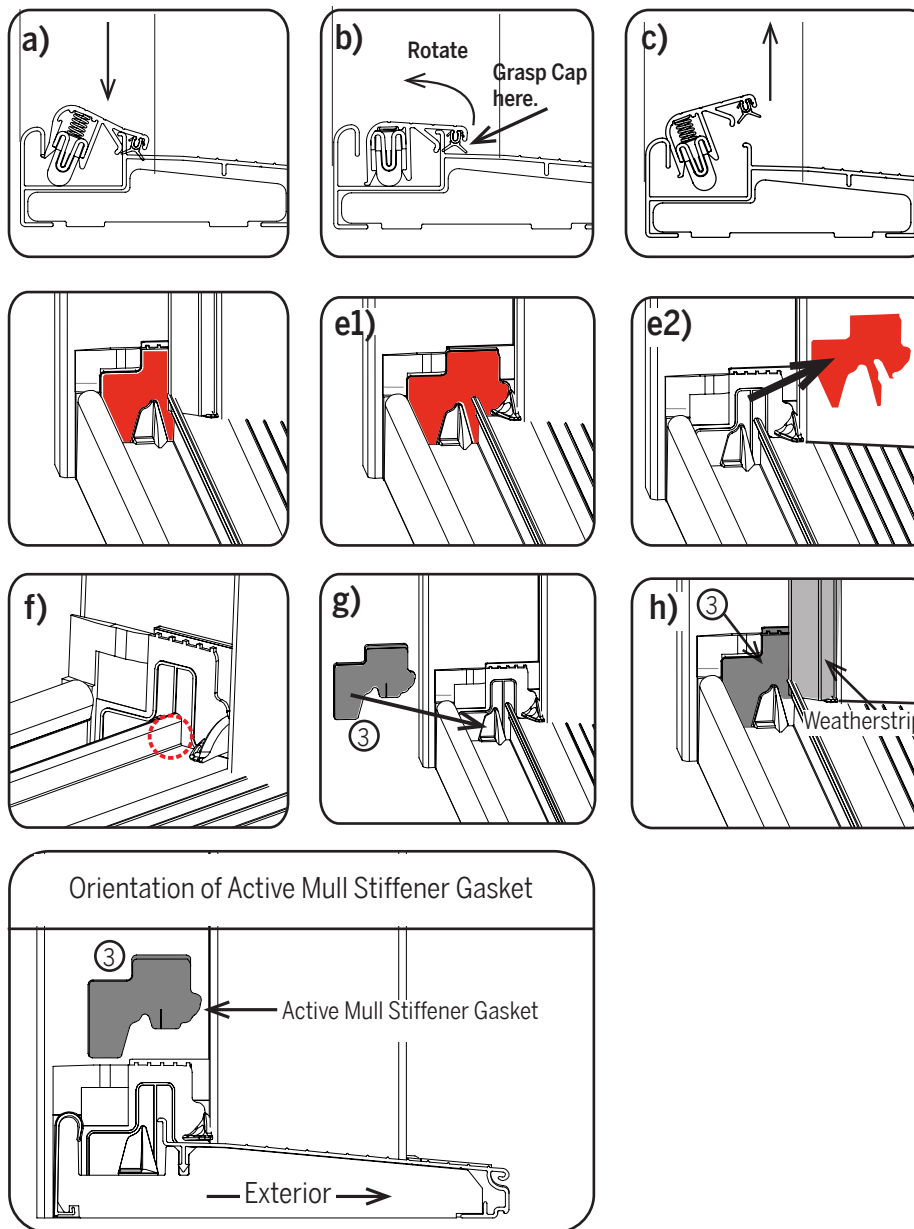




## 2. Remove ZAC-AA (ZAC-AA to ZAC-AA)

### SINGLE AND FRENCH DOOR UNITS

- a) Starting **at the end of the sill**, depress the cap to its downward position.
- b) Grasp the front of the cap near the sill's dam and rotate it backwards towards the interior side of the sill.
- c) Once the end of the cap is no longer attached to the sill, simply pull the cap up and out of the sill.
- d) Clean any debris out of sill channel
- e) Remove the weatherstrip (e1) and using a scraping tool, remove visible portion of the foam sealing pad (gasket) from the Z-End Base (e2). **Do not remove the plastic Z-End Base, just the foam pad.**
- f) Carefully apply Silicon on the dam of the sill to fill in any gaps that will be created when installing Active Mull Stiffener Gasket 3 in place of the damaged Z-End Base's Gasket
- g) Apply new Active Mull Stiffener Gasket ③ to the Z-End Base in place of the old gasket pad.
- h) Reinstall weatherstrip.
- j) Proceed to step 3



**!** Gasket refers to the foam sealing pad attached to the Z-End Base.  
**DO NOT ATTEMPT TO REMOVE THE Z-END BASE**



### 3. Remove ZAC-AA (ZAC-AA to ZAC-AA)

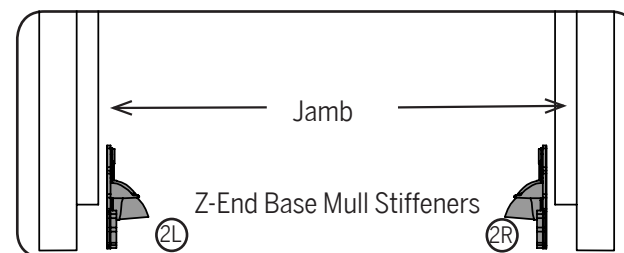
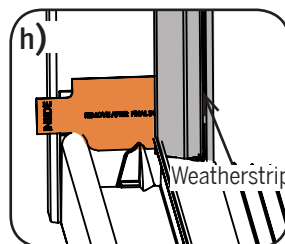
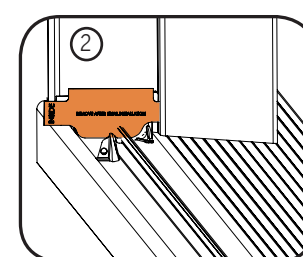
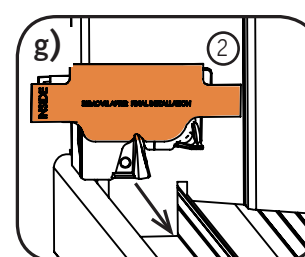
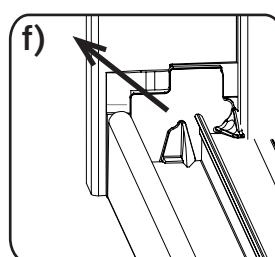
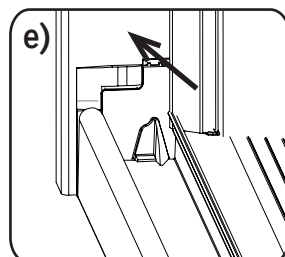
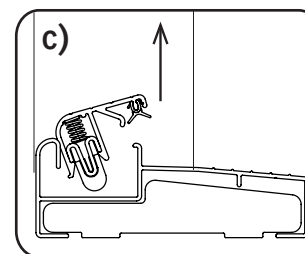
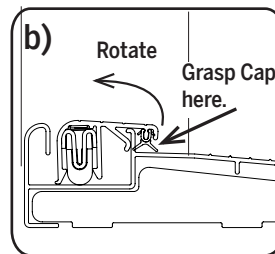
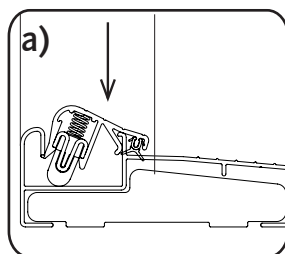
#### FOR SIDELITE, HINGED PATIO AND PREVIOUSLY RETROFITTED UNITS

- a) Starting **at the end of the sill**, depress the cap to its downward position.
- b) Grasp the front of the cap near the sills dam and rotate it backwards towards the interior side of the sill.
- c) Once the end of the cap is no longer attached to the sill, simply pull the cap up and out of the sill.
- d) Clean any debris out of sill channel
- e) Remove the weatherstrip
- f) Remove the installed Z-End Base Mull Stiffener and discard it.
- g) Insert new Z-End Base Mull Stiffeners (2L & 2R) into each side of the channel against the jambs

**⚠ NOTE:** The Z-End based are handed and can only be inserted one way. The back of the Z-End Base Mull Stiffener should be flush with the face of the jamb.

**⚠ NOTE:** Do not remove the orange protective gasket label until cap is fully installed into the door unit.

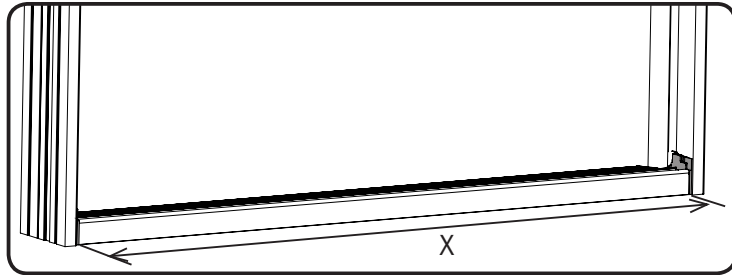
- h) Reinstall weatherstrip.
- i) Proceed to step 4



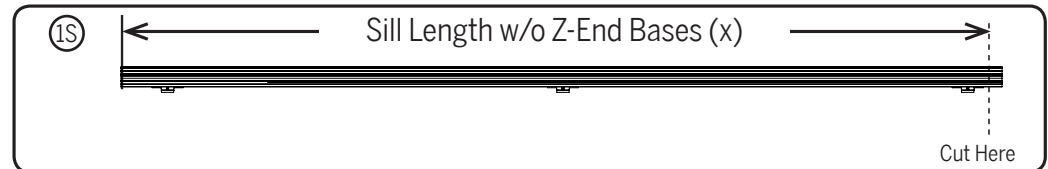
#### 4. Cut NEW Z-Articulating Cap to Length (ZAC-AA to ZAC-AA)

##### FOR SINGLE, SIDELITE & HINGED PATIO DOOR APPLICATIONS

- a) Measure the length of the sill without black Z-End Base Assemblies (X).



- b) Measure and cut new cap ①S to match length of the sill minus 1/4".



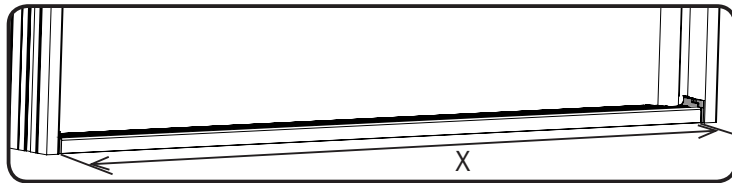
**CAUTION:** Measure carefully and cut precisely within 1/32" to ensure proper operation. A cap cut too short will not seal correctly.

**Note:** With Field Replacement of Existing ZAC-AA Sill, sill length has been cut down to accommodate Z-End Bases. New ZAC-AA Cap Should be the same length as the old ZAC-AA cap.

- c) Proceed to step 5

##### FOR FRENCH (DOUBLE) DOOR APPLICATIONS

- a) Measure the length of the sill without black Z-End Base Assemblies (X).



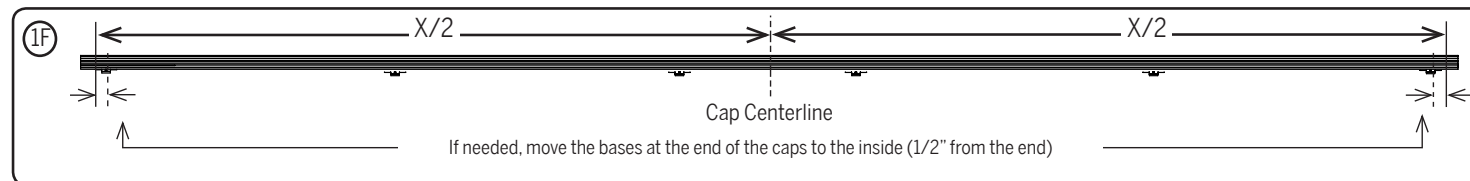
- b) Measure and mark the centerline of the Cap

- c) Measure and cut new cap ①F to match length of the sill minus 1/8" on each side.

*Cut from both ends of the cap to ensure centerline remains in the center of the cap.*

**CAUTION:** Measure carefully and cut precisely within 1/32" to ensure proper operation. A cap cut too short will not seal correctly.

**Note:** With Field Replacement of Existing ZAC-AA Sill, sill length has been cut down to accommodate Z-End Bases. New ZAC-AA Cap Should be the same length as the old ZAC-AA cap.



- d) Proceed to step 5

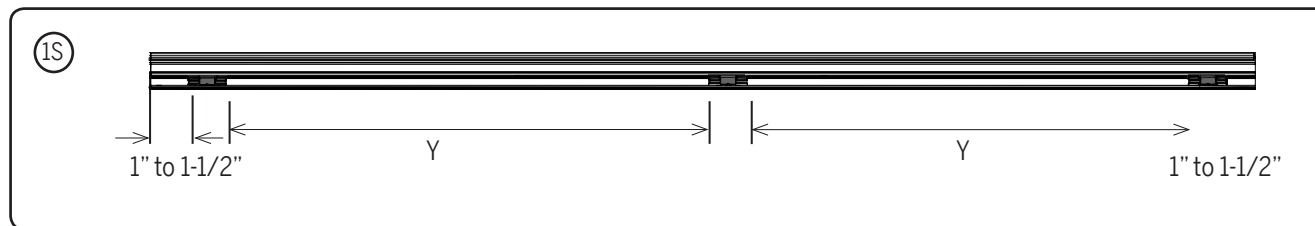
## 5. Apply Spring Loaded Cap Bases (ZAC-AA to ZAC-AA)

### SINGLE, SIDELITE AND HINGED PATIO DOORS ONLY

- a) Ensure that all 3 spring-loaded bases are used and properly positioned.

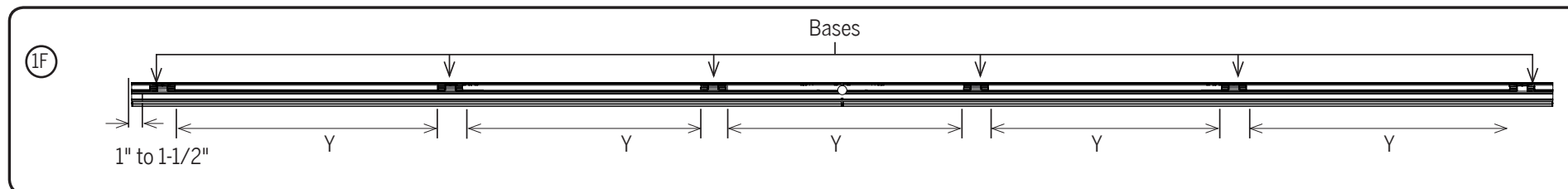
The spring-loaded bases at the ends of the cap should be 1" to 1-1/2" from the cap's edge. The spring-loaded center base should be evenly spaced between the 2 spring-loaded bases at the ends of the cap, approximately 12"-15" inches apart (Y).

- b) Proceed to step 6



### FRENCH (DOUBLE) OPENING DOORS ONLY

- a) Ensure that all 6 spring-loaded bases are used and properly positioned.  
The spring-loaded bases at the ends of the cap should be 1" to 1-1/2" from the cap's edge. The 4 center spring-loaded bases should be evenly spaced between the 2 spring-loaded bases at the ends of the cap, approximately 12"-13" inches apart (Y).



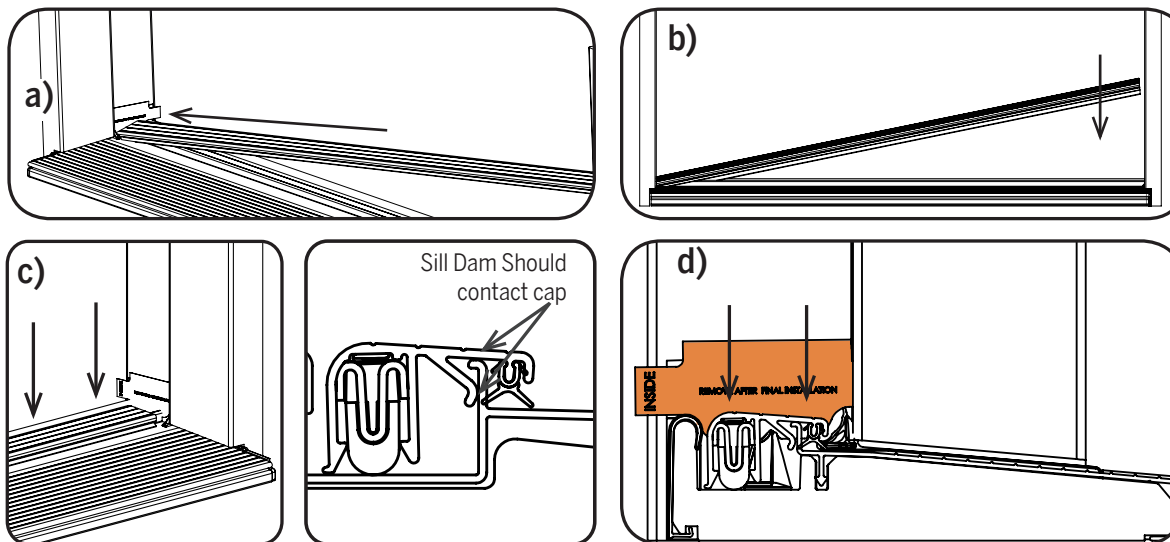
- b) Proceed to step 6

## 6. Insert NEW Sill Cap (ZAC-AA to ZAC-AA)

### FOR SINGLE, SIDELITE, HINGED PATIO AND FRENCH DOOR UNITS

- a) Press one end of cap ① into channel and against Z-End Base/ Mull Stiffeners ②.
  - b) Install the opposite end of the cap ① into the sill by bringing it straight down into the Sill channel and against Z-End Base/ Z-End Base Mull Stiffener ②.
  - c) Apply Pressure to the cap ① to fully seat cap into place along entire length of sill.
- ⚠ Sill Dam should contact the bottom side of the top of the cap, and the angled leg of the cap should contact the back side of the Sill Dam**
- d) Depress the cap ①, to gain access to the orange protective labels on each Z-End base/ Mull Stiffener (If Present) and remove.

Proceed to step 7.




## 8. Replace Astragal Bottom Sealing Pad and Corner Pad *French Door Units Only* (ZAC-AA to ZAC-AA)

**! FOR FRENCH DOOR UNITS**


- a)** Position astragal to gain access to the Bottom Bolt Sleeve, Corner Pad and Bottom Sealing Gasket.

 Remove Weatherstrip to gain easy access to the Corner Pad


- b) Remove old corner pad and Bottom Sealing Gasket by peeling down and away from the astragal. Use a stiff scraper to remove any remaining residue.
- c) Install new Astragal Bottom Sealing Gasket (8) by aligning the flush bolt with the hole in the pad **c1**, then install new Simple Solution Corner Pad (4) by Pressing into place **c2**.

 The lip of the Bottom Sealing Gasket should extend out in front of the astragal, and the Simple Solution Corner Pad should sit flush on top of the gasket.

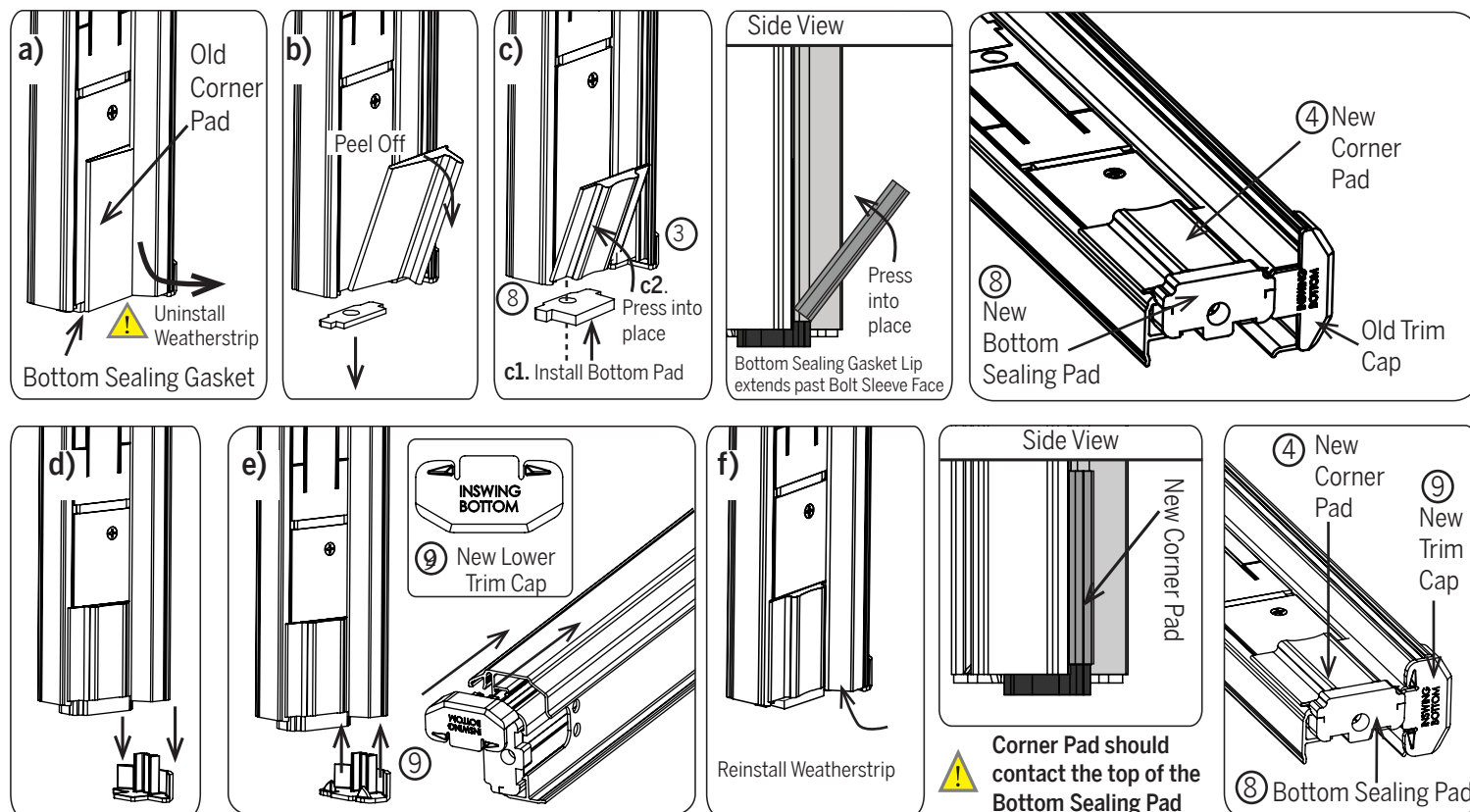
- d) Remove original Lower Trim Cap by prying it off of the bottom of the astragal with a Flat Head Screw Driver.
- e) Align the new Lower Trim Cap ⑨ with the astragal's body, and Insert the Trim cap into the bottom of the astragal.

 Use the Trim Cap that matches the color of the astragals body, and discard the other.

- f)** Reinstall weatherstripping

 Ensure the edge of the Corner pad is located behind the weatherstrip after installing corner pad in place.

- e) Proceed to step 9



## 9. Replace Door Bottom Sweep (ZAC-AA to ZAC-AA)

### FOR SINGLE, SIDELITE, HINGED PATIO AND FRENCH DOOR UNITS

#### REMOVE DOOR FROM HINGES

- a) Remove old door bottom from panel by prying it off with a flathead screwdriver.
- \*Remove any caulk from the panel and kerf slots using a scraping tool .**
- b) Align the Door Bottom ⑤ with the panel and mark cut line within 1/32". Cut line should match length of panel (X).
- c) Cut down the Door Bottom ⑤ to match the length of the panel (X).
- d) Using a stiff scraping tool, remove the existing Door Bottom Gasket from the end of the door bottom. If no Gasket is present or has been cut off completely, skip to step 2.



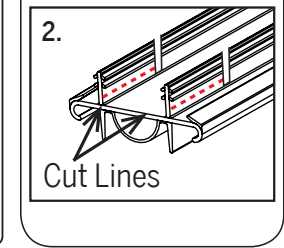
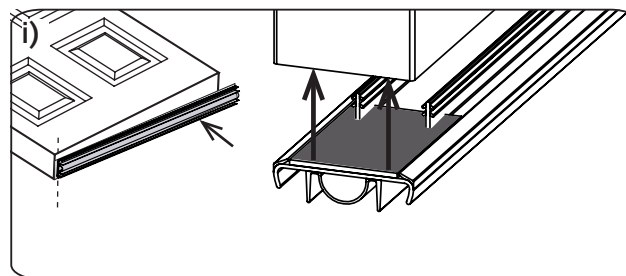
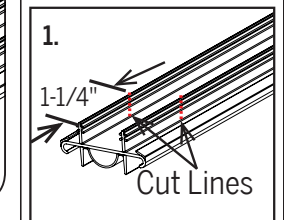
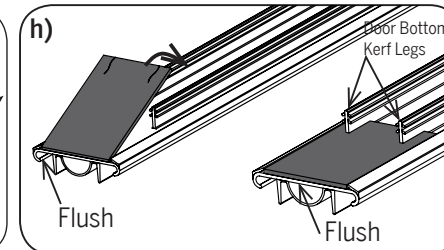
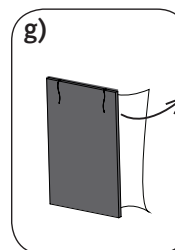
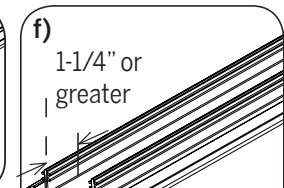
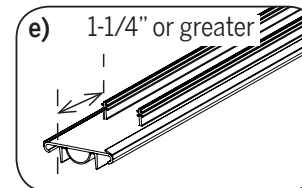
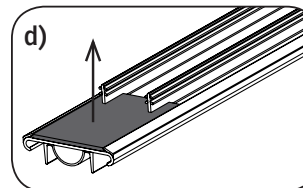
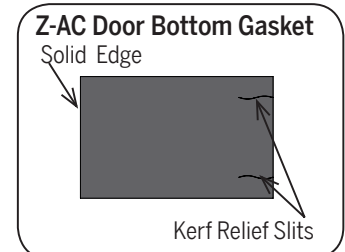
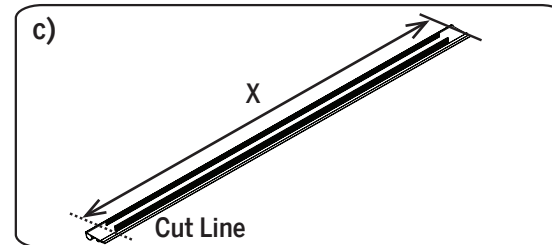
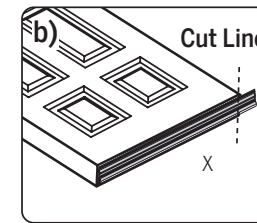
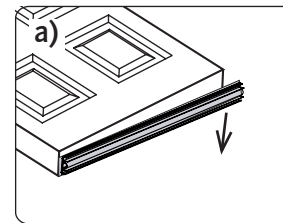
Be sure to completely remove all residue from the old gasket to assure the new pad adheres properly.

- e) Measure the location of the Kerf Legs. Kerf legs should be trimmed back 1-1/4" or more from the edge of the door bottom. If 1-1/4" or greater notch is present, proceed to step 4, If not proceed to step 3.
- f) If less than a 1-1/4" notch is present, re-notch the Kerf Legs to at least 1-1/4" by clipping the Kerf Legs.
1. Measure and mark the Kerf Legs at 1-1/4" from the edge of the Door Bottom. Cut the Kerf Legs down with a cutting tool to the base of the Door Bottom.



#### **BE CAREFUL NOT TO CUT INTO THE DOOR BOTTOM.**

2. From the edge of the Door Bottom, trim the Kerf Legs at the base back to the cut made in the previous step and remove.
- g) Remove paper backing from the Door Bottom Gasket.
  - Peel the protective paper layer covering the adhesive on the back of the Door Bottom Gasket off and discard.
- h) Align and Apply New Door Bottom Gasket to Z-AC Door Bottom
  - Align the Solid Edge of the Door Bottom Gasket with the outer edge of the Z-AC Door Bottom as shown. Once aligned, tip and press Gasket firmly into place, ensuring that the Door Bottom Kerf Legs protrude through the Gasket Relief Slits, while the Gasket Solid Edge remains aligned flush with the Door Bottom Edge.
- i) Align Door Bottom flush with the **lock side** of the panel and insert kerfs into slots on door.
- j) Proceed to step 10.



## 10. Stapling Door Bottom to Panel (ZAC-AA to ZAC-AA)

### FOR SINGLE, SIDELITE, HINGED PATIO AND FRENCH DOOR UNITS

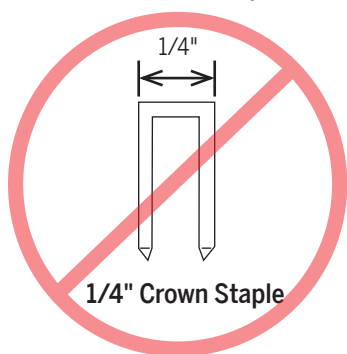
- a) Attach Door Bottom with **two 1/2" crown staples** and **80 PSI of air pressure** at ends between the rigid ramp and flex fins.

⚠ When stapling the Z-AC Door bottom to the panel, staples should be inserted between the **Rigid Ramp** and **Flex Fins**. 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.

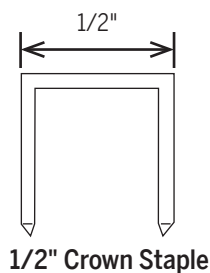
⚠ The insertion of staples at an angle or in the wrong location will result in damage to the door bottom

- b) **STAPLE ON SWEEP**- If using a staple-on door sweep, staple on both sides approximately every 6" along the length of the door.  
c) Proceed to step 12

#### Incorrect Size Staple



#### Correct Size Staple

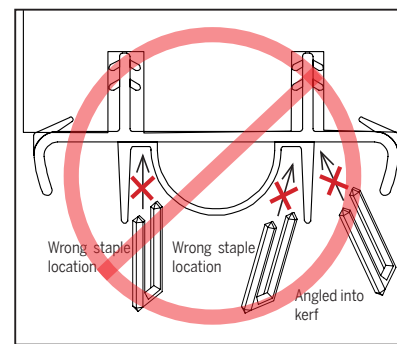
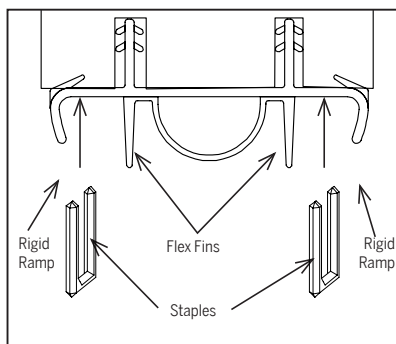
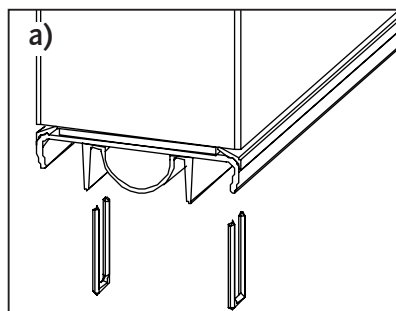


Only 1/2" crown staples should be used to secure the door bottom to the panel. The use of staples with a shorter crown such as crown 1/4" staples will result in cracking and damage to the door bottom.

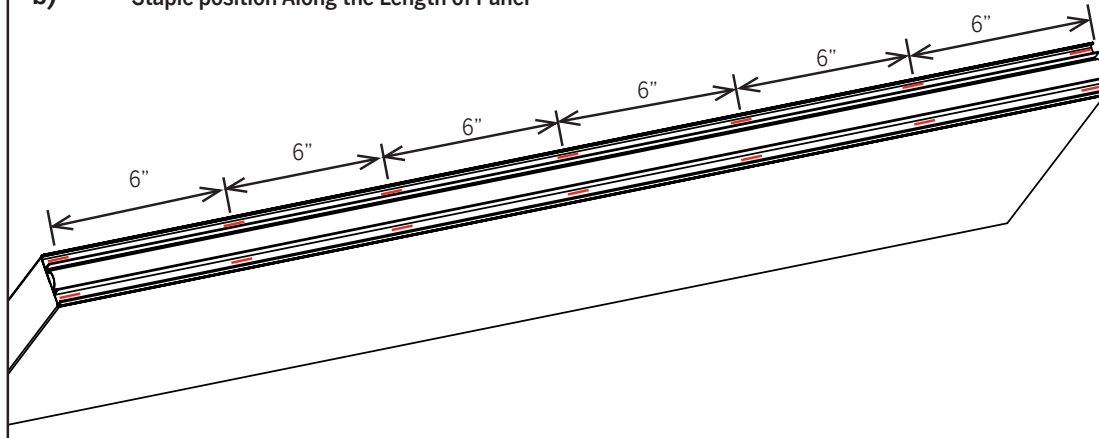
#### Required Air Pressure



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



#### b) Staple position Along the Length of Panel





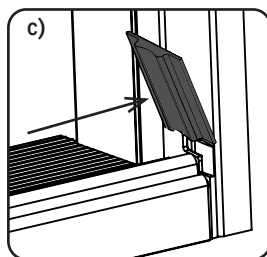
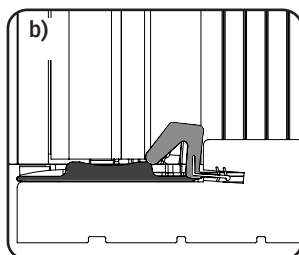
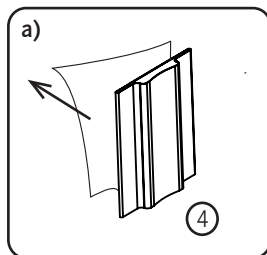
## 11. Replace Corner Pads (ZAC-AA to ZAC-AA)

### FOR SINGLE, SIDELITE, HINGED PATIO AND FRENCH DOOR UNITS

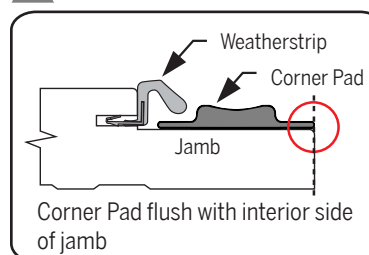
Ensure that the old corner pad has been removed from each jamb.

**NOTE:** For best performance, Do not reapply old/used corner pad. Replace with a new Simple Solution Corner Pad for this step.

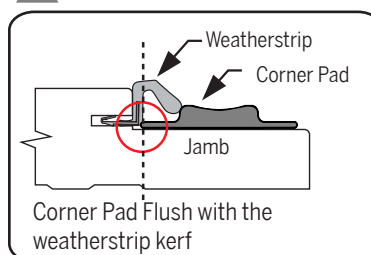
- a) Remove backing paper from Simple Solution Corner Pad ④ to expose adhesive.
- b) Align Simple Solution Corner Pad with the top of Z-End Base. For margins **less or equal to**  $5/32"$ , apply the corner pad with the edge flush against the weatherstrip kerf, and for margins **greater** than  $5/32"$ , apply the corner pad with the edge flush against the interior jamb.
- c) Ensure the Simple Solution Corner Pad contacts the top surface of the Z-End Base and press firmly into place on to jamb.
- d) Repeat Steps a - c for the second jamb
- e) Proceed to step 12



**For Strike Margins greater than  $5/32"$**



**For Strike Margins less than  $5/32"$**



## 12. Check the Operation of the Door

Close and open the door several times

- a) Ensure that the door opens and closes smoothly.
- b) Ensure the cap operates properly up and down as the door is opened and closed.
- c) Ensure that Door Bottom makes contact with the Z-AC as the door is closed.
- d) Ensure the Panel makes contact with the Corner Pad and Z-End Bases.

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

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