

# Assembly



## Door System Assembly Instructions

**These instructions apply to the following door 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.

## Table of Contents

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

**Step 2: Assembling the Frame and Mull at the Header**

**Step 3: Assembling the Frame at the Sill**

**Step 4: Assembling the Mull at the Sill**

**Step 5: Inserting Weatherstrip**

**Step 6: Fixed Panel Assembly**

**Step 7: Cutting Door Bottom to Length** (If Needed)

**Step 8: Attaching the Door Bottom Gasket**

**Step 9: Attaching the Door Bottom**

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

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

**Step 12: Hinged Panel Assembly**

**Step 13: Attach Alignment Bracket**



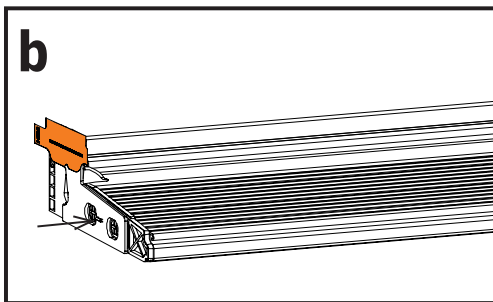
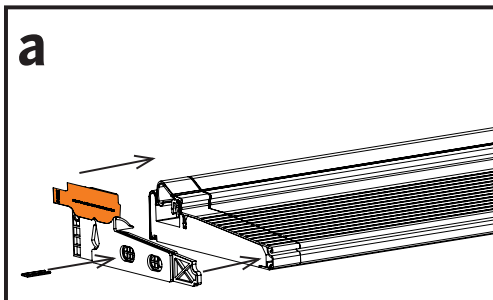
8817 W. Market St., Colfax, NC 27235  
**1.800.334.2006** [www.enduraproducts.com](http://www.enduraproducts.com)

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

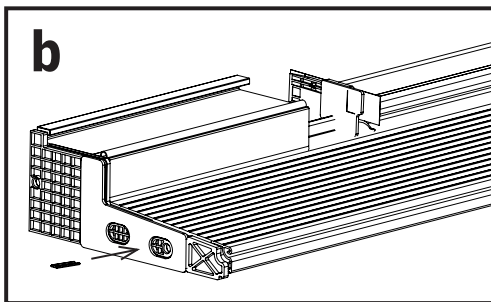
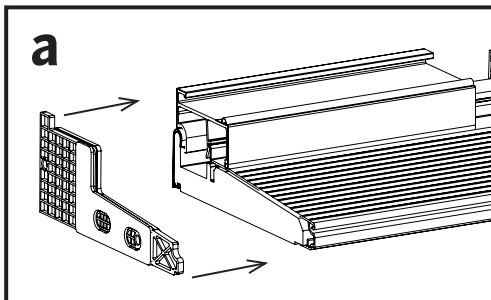
If assembling a door unit with a Z-Articulating Cap Sill, be sure to check the installation prior to beginning the installation process.

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

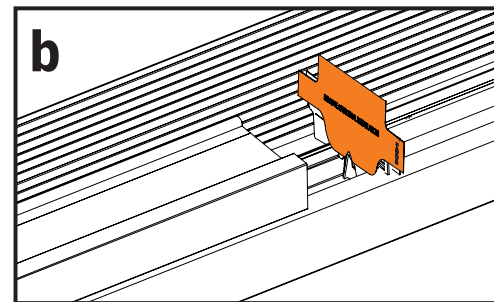
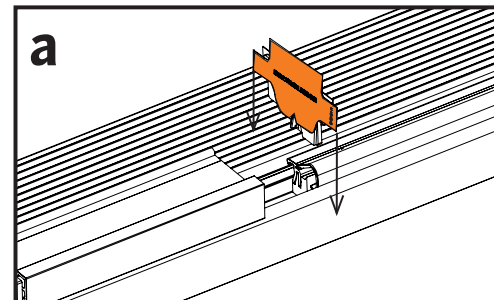
- a. Align the Z-End Base with the of end of the sill and Z-Articulating Cap then attach.
- b. Secure Z-End Base to the sill with staples. Repeat at other end of sill if no Sidelite Cap is present.

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

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

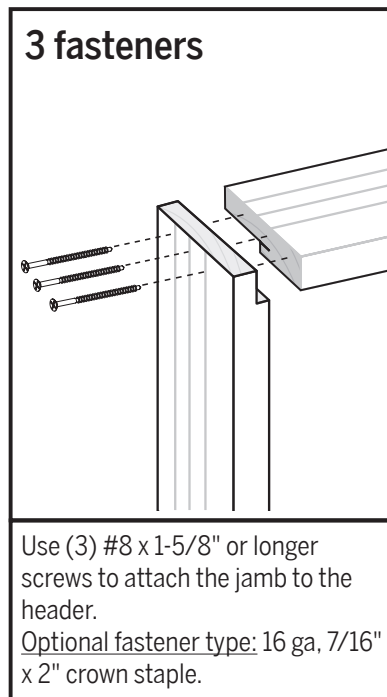
**Installing the Z-End Base Mull Stiffener**

- a. Insert the Z-End Base Mull Stiffener into the sill channel between the Z-Articulating Cap and Sidelite Seat.
- b. 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.

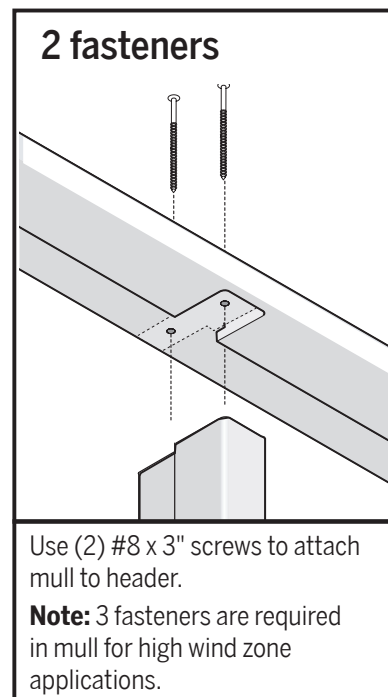


## Step 2: Assembling the Frame and Mull at the Header

For All Door Units  
Jamb to Header



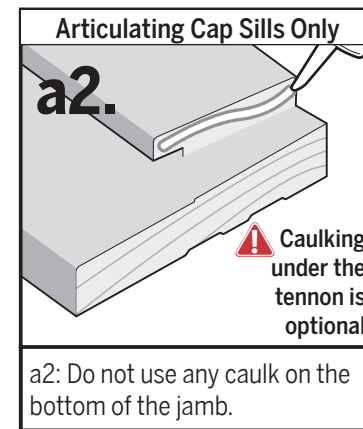
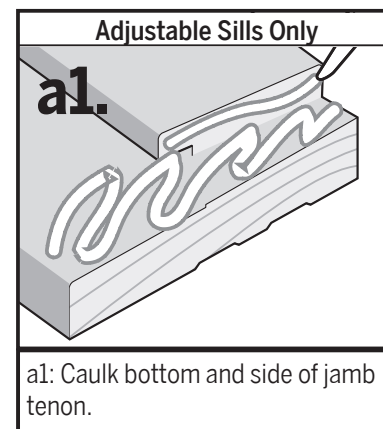
For Sidelite/ Patio Door Units Only  
Mull to Header



## Step 3: Assembling the Frame at the Sill

For All Door Units

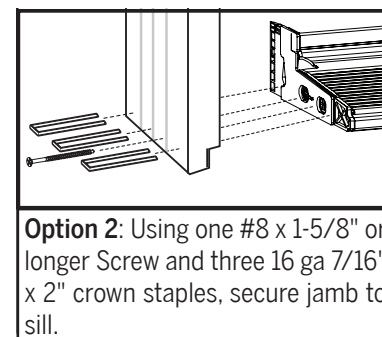
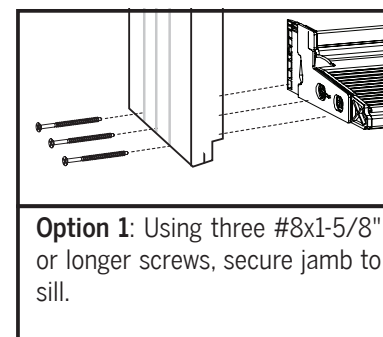
a. Caulk components.



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

### Adjustable and Articulating Cap Sills/ All Sills

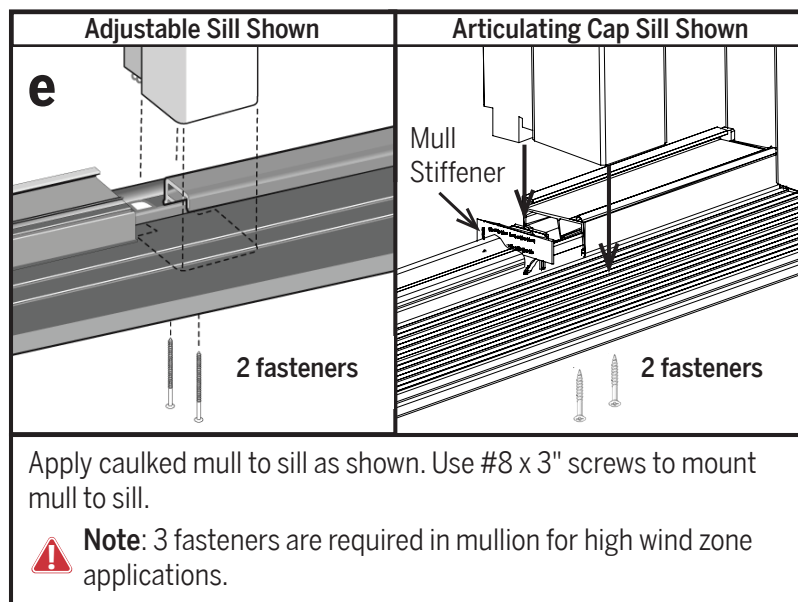
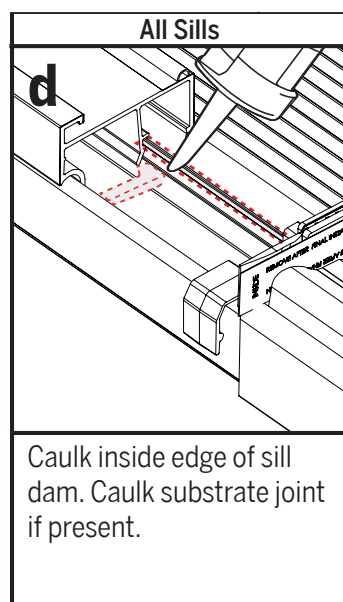
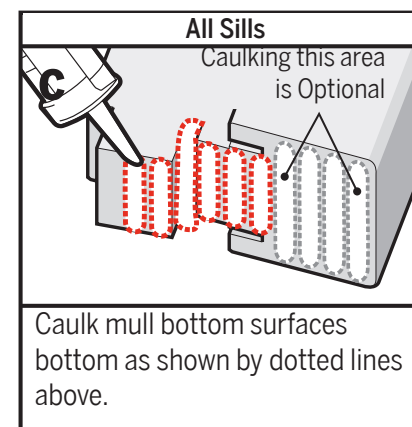
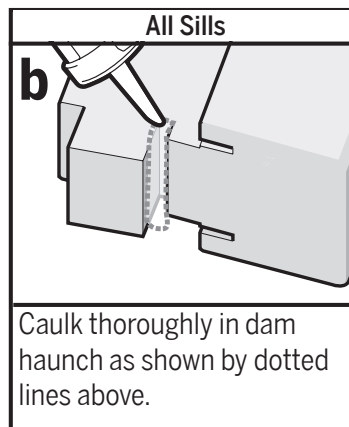
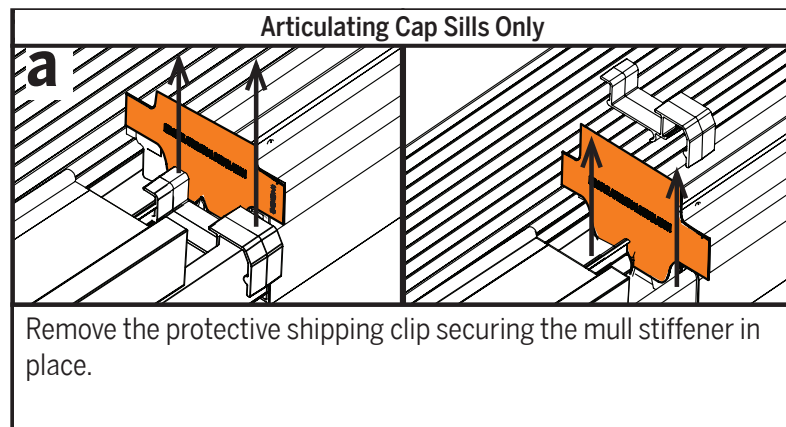
b. Secure jamb to sill.



## 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.



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

**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

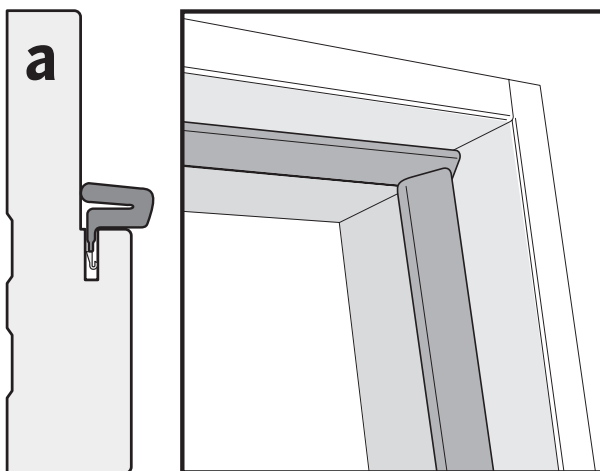
If a Mull Boot is used, follow separately issued Mull Boot Instructions


## 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.



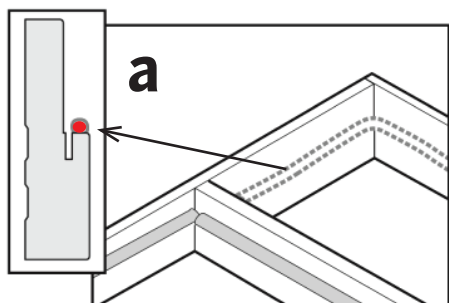
 **Note:** Do not use weatherstrip that is too short or too long.

 **Note:** Do not fold or wrinkle weatherstrip.

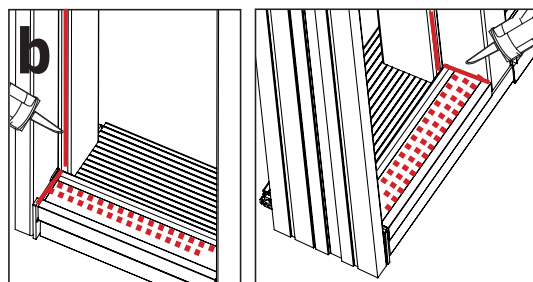
## Step 6: Fixed Panel Assembly

### For Sidelite/ Patio Door Units Only

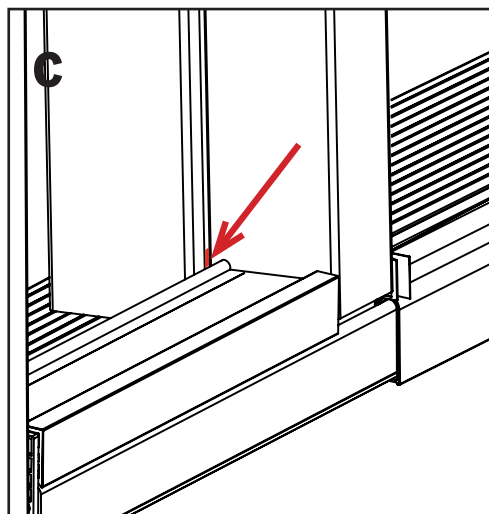
#### Caulking for the Fixed Panel



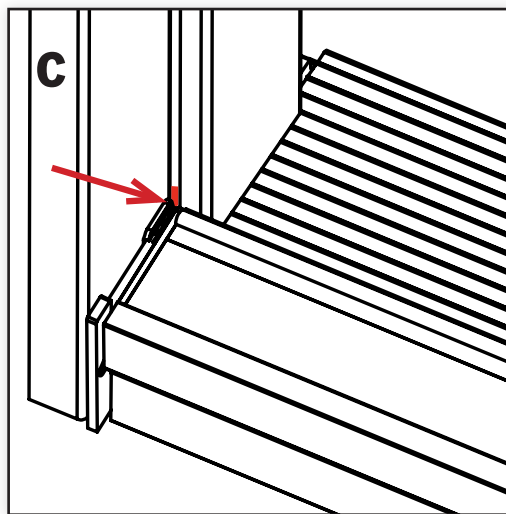
**a.** Apply a continuous bead of caulk to the stop of the jamb, mull and head where the sidelite will rest.



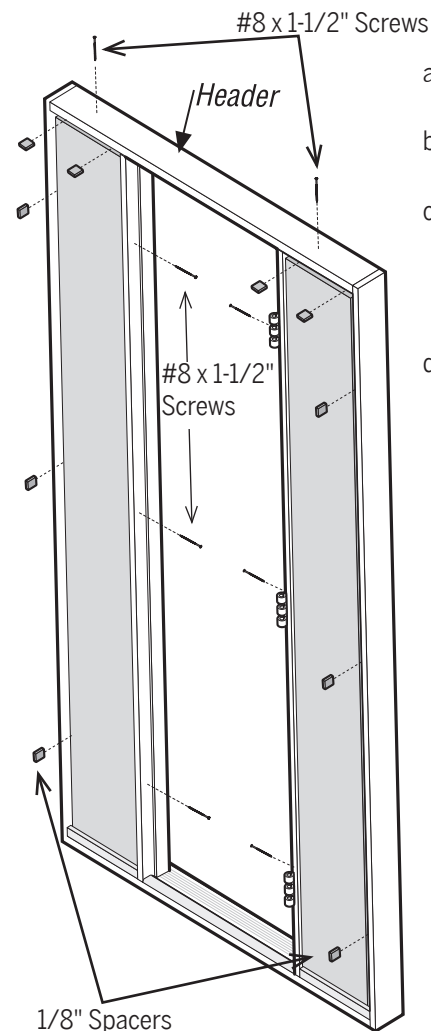
**b.** Apply caulk to the inactive cap as shown. Caulk through in both corners



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



#### Installing Fixed Panels



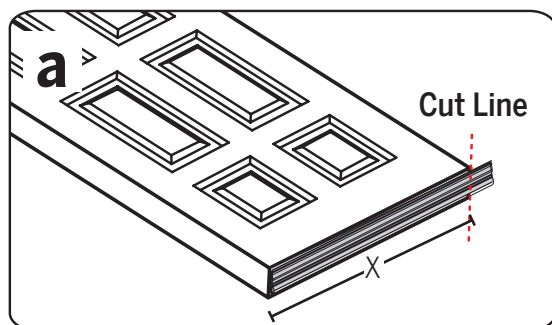
- Place panel into frame opening.
- Set tight sidelite seat & mullion
- Apply 1/8" spacers
  - Two at the header
  - One at the jamb at each hinge position
- Secure to frame with #8 x 2-1/2" screws.
  - First through the mullion at each hinge position.
  - Next through the jamb at each hinge position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

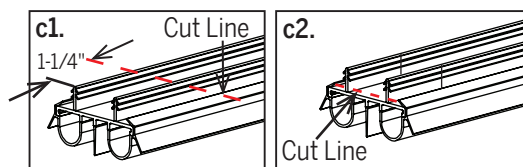
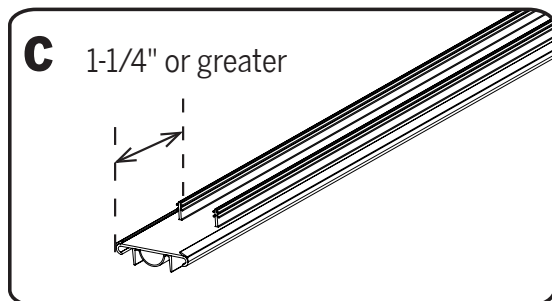
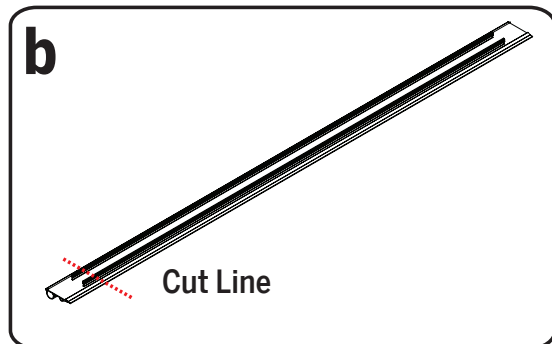
b) Cut down the Door Bottom to match the length of the panel within 1/32".

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

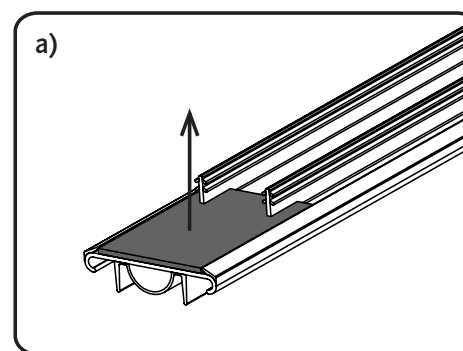
c1. Measure and mark the Kerf legs at 1-1/4" from the edge of the Door Bottom. Cut the Kerf leg down to the base of the door bottom.

**BE CAREFUL NOT TO 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.

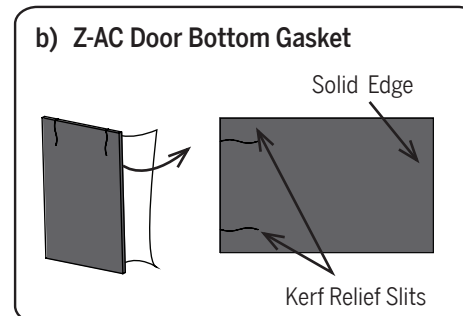
**Step 8: Apply New Door Bottom Gasket****Z- Articulating Cap Sill™ Kerfed Door Bottoms**

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.



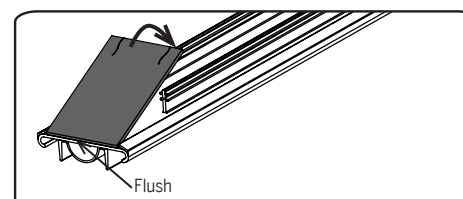
a) Using a stiff scraping tool, remove the existing Door Bottom Gasket from the end of the door bottom.

- 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.



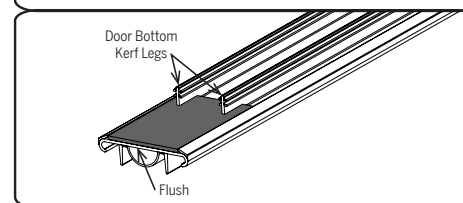
b) Remove paper backing from the Door Bottom Gasket.

- Peel the protective paper layer covering the adhesive on the back of the Door Bottom Gasket off and discard.



c) Align and apply new Door Bottom Gasket to Z-AC Door Bottom.

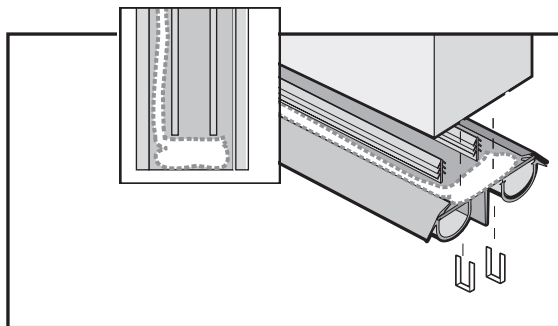
- Align the Solid Edge of the Door Bottom Gasket with the outer edge of the Z-AC Door Bottom as shown.
- Once aligned, tip and press gasket firmly into place, ensuring that the Door Bottom Kerf Legs protrude through the Gasket Relief Slits, while the Gasket Solid Edge remains aligned flush with the Door Bottom Edge.





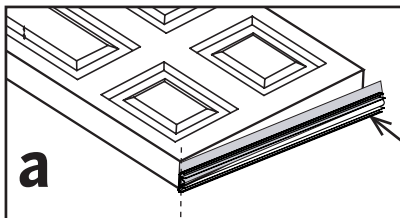
## Step 9: Attaching the Door Bottom

### Adjustable or Fixed Sill Door Bottoms

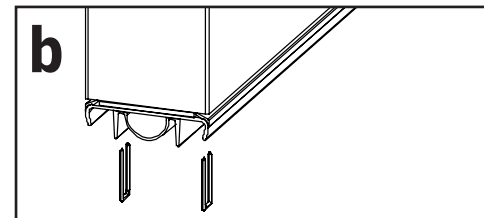
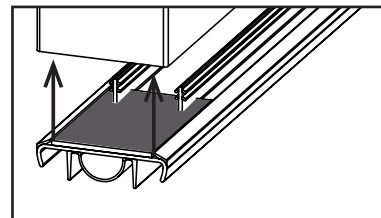


### Z- Articulating Cap Sill Kerfed Door Bottoms

DO NOT USE ANY CAULK



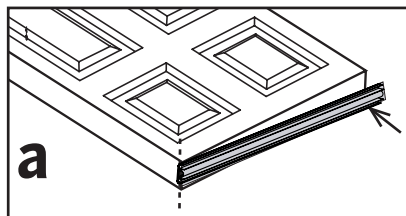
a. Align door bottom flush with the **lock side** of the panel and insert kerfs into slots on door. DO NOT USE ANY CAULK



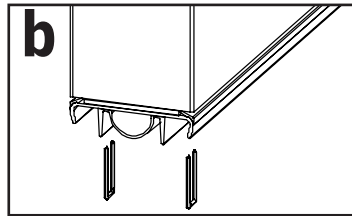
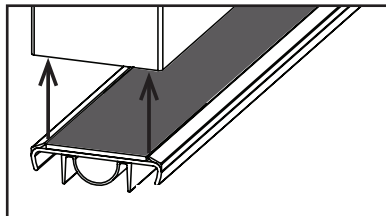
b. Attach Door Bottom with **two 1/2" crown staples and 80 PSI of air pressure** at ends between the rigid ramp and flex fins.

### Z- Articulating Cap Sill Staple-On Door Bottoms

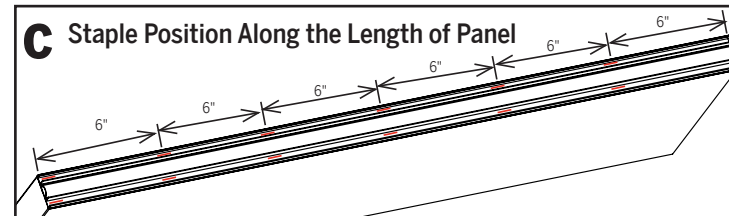
DO NOT USE ANY CAULK



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

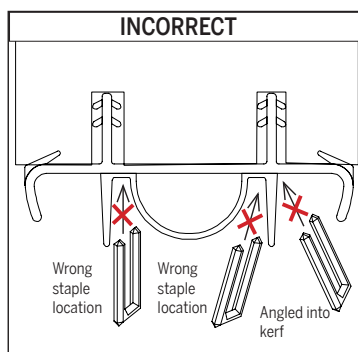
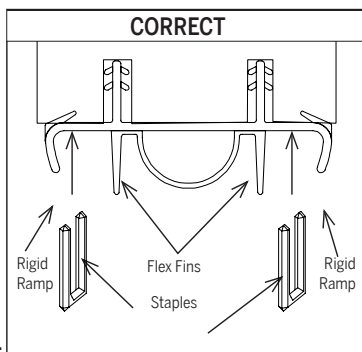


b. Attach Door Bottom with **two 1/2" crown staples and 80 PSI of air pressure** at ends between the rigid ramp and flex fins.



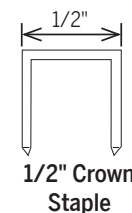
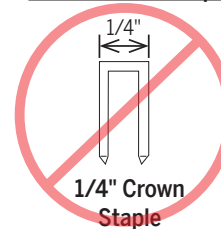
c. Staple on both sides approximately every 6" along the length of the door.

**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.



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 suggests using an air pressure regulator for best results.

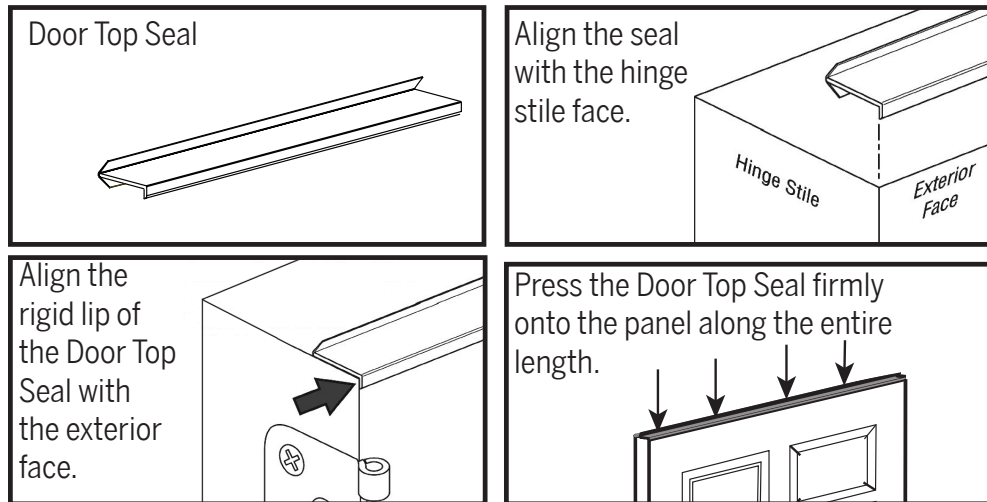


The insertion of staples at an angle or in the wrong location will result in damage to the door bottom

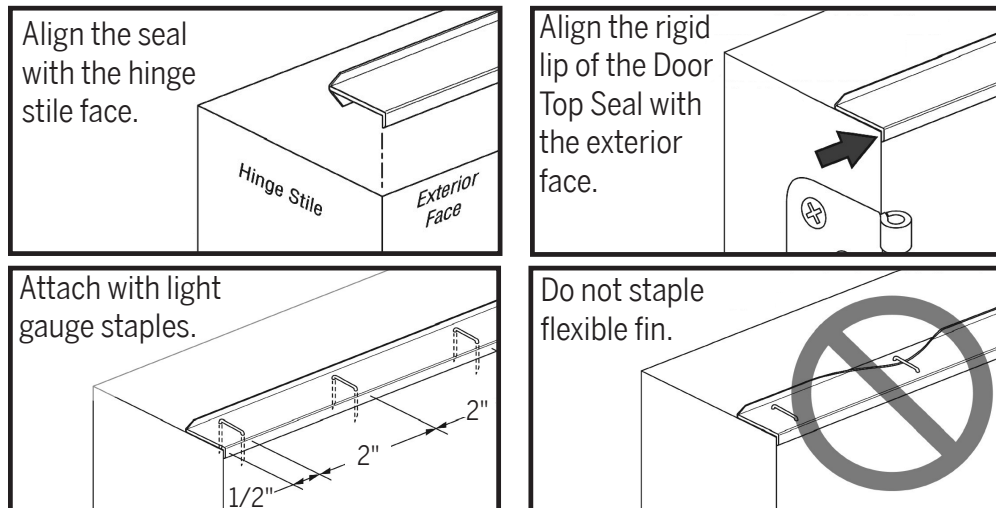


## Step 10: Attaching Door Top. (Outswing Units Only)

### Steel Edge Panels



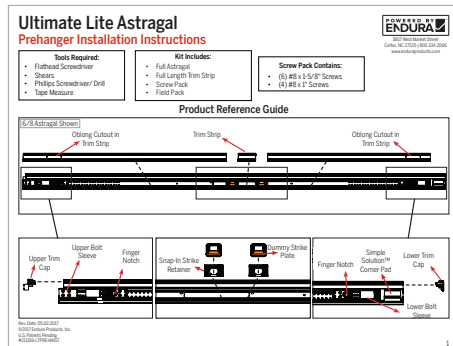
### All Other Panels



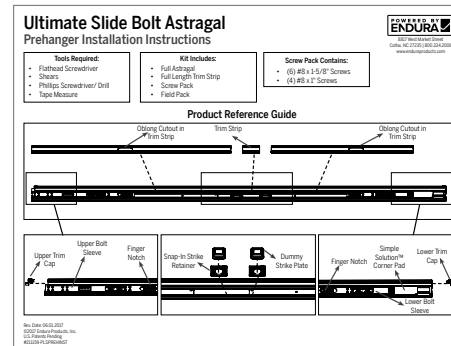
## Step 11: Attaching Astragals to the Inactive Panel. (French Units Only)

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

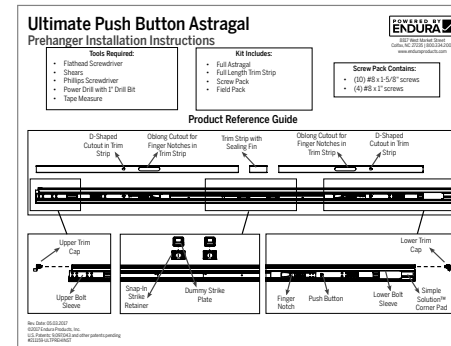
### Ultimate Lite Astragal



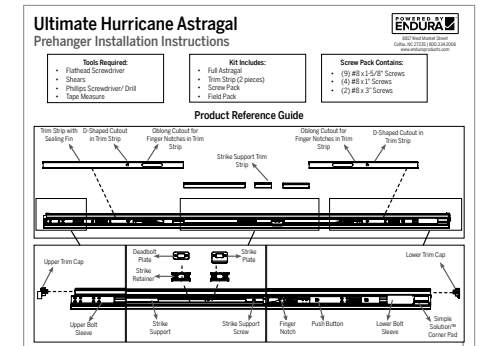
### Ultimate Slide Bolt Astragal



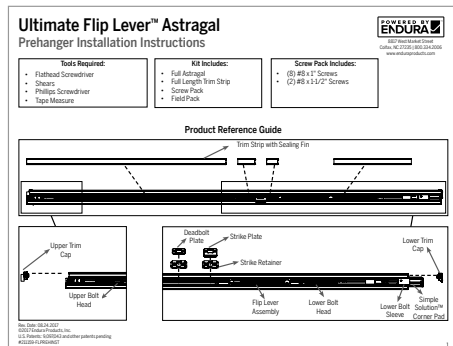
### Ultimate Push Button Astragal



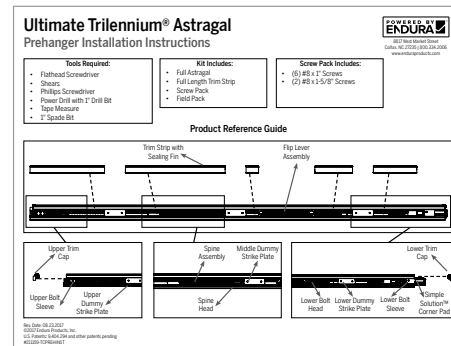
### Ultimate Hurricane Astragal



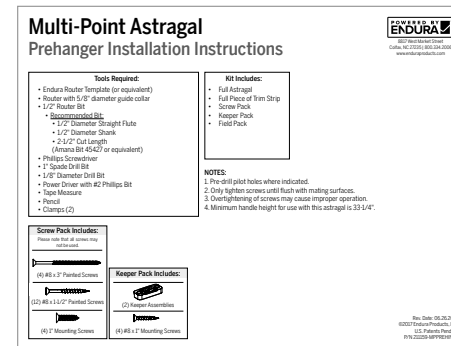
### Ultimate Flip Lever™ Astragal



### Ultimate Trilennium® Astragal



### Ultimate Multi-Point Astragal



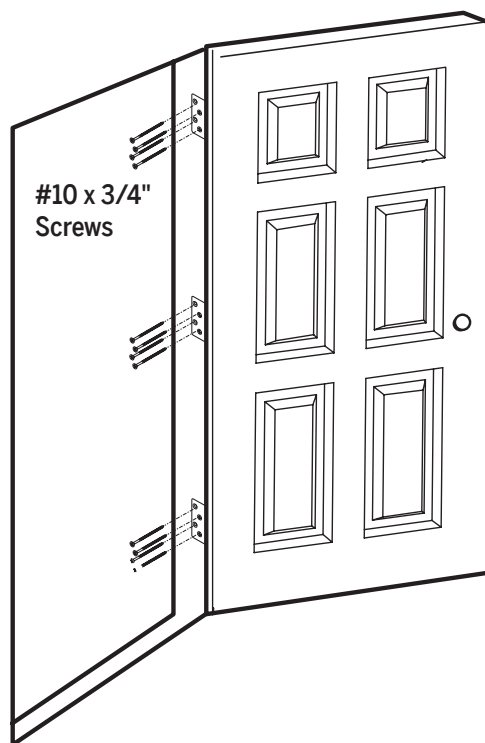
## Step 12: Hinged Panel Assembly

### For All Door Units

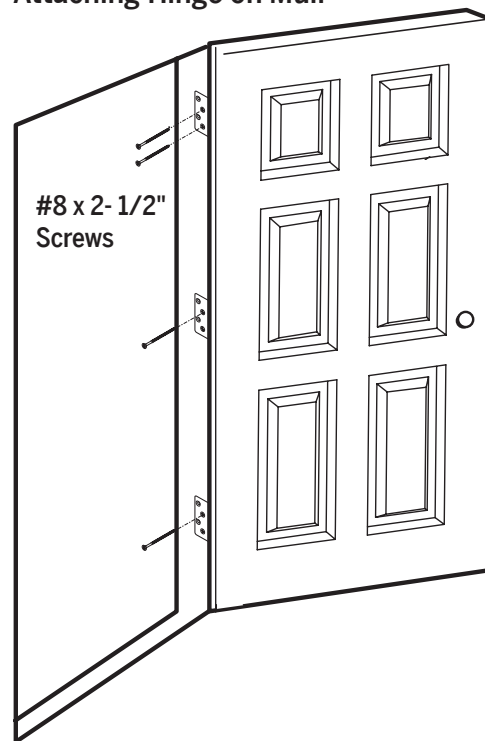
Attach hinges

- 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

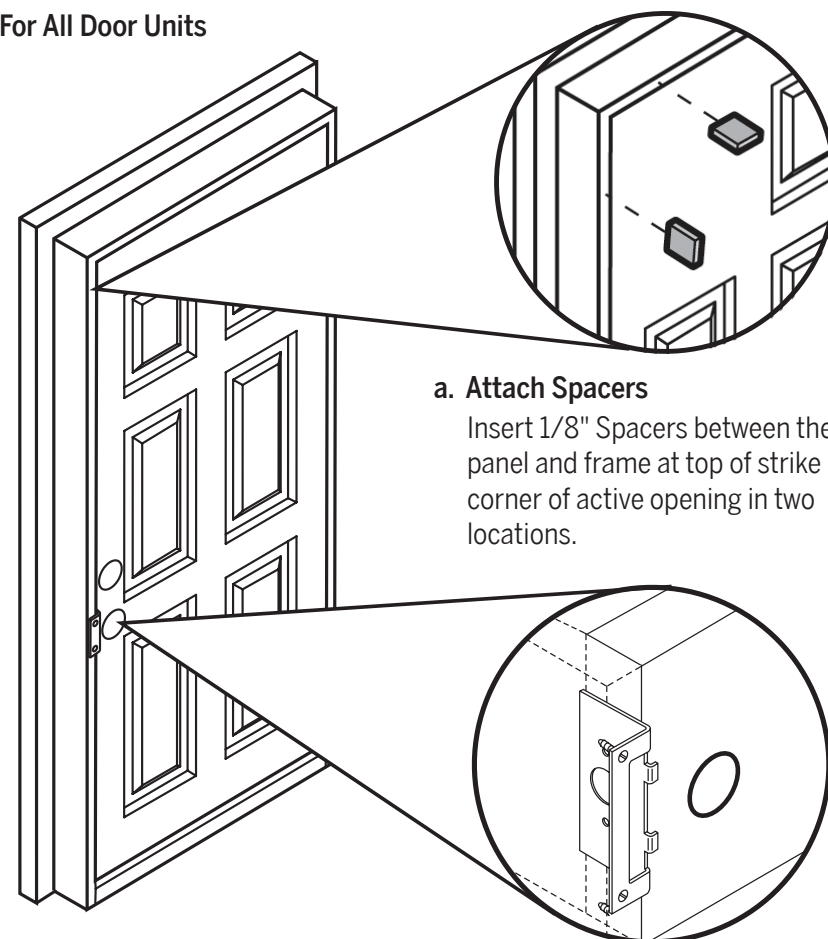


### Attaching Hinge on Mull



## Step 13: Attach Alignment Bracket

### For All Door Units



### a. Attach Spacers

Insert 1/8" Spacers between the panel and frame at top of strike corner of active opening in two locations.

- b. Apply Endura's **Door Frame Alignment Bracket** to prevent the door frame from racking and breaking the caulked seals during shipping and installation.

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

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