

KOLBE®

WINDOWS & DOORS

Ultra Series, Heritage Series

SLIDING PATIO DOOR

*FRAME ASSEMBLY
INSTRUCTIONS*

**READ AND COMPLETELY UNDERSTAND
THESE INSTRUCTIONS
BEFORE STARTING ANY INSTALLATION**

⚠ CAUTION

Lead-based paint may be present in older homes, and the removal of windows & doors may cause this paint to be disturbed. In order to minimize exposure to lead-based paint dust, please consult www.epa.gov/lead for more information.

www.kolbewindows.com

INTRODUCTION

These instructions are for frame assembly of standard and K-Force (impact) rated sliding patio door units. For simplicity, only extruded aluminum units are shown in pictures throughout the instructions.

NOTICE

Proper installation and regular maintenance of Kolbe windows and doors are crucial for preserving the quality of our products. Failure to follow these instructions for installation and maintenance will void any warranty, whether written or implied. The installer is responsible for consulting with the contractor, structural engineer, architect, or consumer to ensure installation complies with local codes and ordinances.

NOTICE

Certain building codes require pressure-treated lumber to line rough openings. Fasteners and anchors in direct contact with pressure-treated lumber must be made from corrosion-resistant materials, such as stainless steel or hot-dip galvanized steel.

NOTICE

Before applying sealant, make sure the surface is clean, dry, and free of frost. Choose a color-matching or transparent sealant. The photos use contrasting sealant for clarity and demonstration purposes only.

⚠️ WARNING

Improper use of hand or power tools may lead to personal injury or product damage. Always follow the manufacturer's instructions for safe equipment operation.

⚠️ WARNING

Proper Eye and Hearing Protection must always be worn when installing, removing or performing adjustments to Kolbe window and door products.

NOTICE

Please read and fully understand these instructions before beginning the assembly or installation of Kolbe window and door products.

ITEMS REQUIRED BY INSTALLER

- Hearing protection device
- Safety glasses/goggles
- Sealant
- Caulk gun
- Tape measure
- Square
- Phillips head screwdriver or bit
- Tape measure
- Standard screwdriver or bit
- Putty knife
- Power drill
- 3/32" (2mm), 7/64" (3mm), 9/64" (4mm) and 3/16" (5mm) drill bits

ITEMS SUPPLIED BY KOLBE

IMPORTANT: Screws are packaged to meet the requirements for 3-panel doors. For 2-panel doors, there will be extra screws left over after installation.

- Head Jamb - 45° angle on each end w/ corner keys installed
- Side Jambs - 45° angle at top end
- Sill
- #8 x 2-1/4" Phillips Oval Head WS ZYel screws (Qty-6) for attaching head jamb to side jambs
- #8 x 1-3/4" Phillips Flat Head SMS 18-8SS screw (Qty-8)
6- for attaching side jamb to sill assembly
2- for securing head & side brickmold(wood units only)
- #7 x 5/8" Phillips Flat Head SMS Self Sealing screws (Qty-2) for attaching head nosing to side nosing (**Extruded units only**)
- #8 x 3/4" Phillips Pan Head SMS 18-8SS screws (Qty-2) for attaching sill nosing to side jamb nosing
- Nailing Fin foam corner (Qty-2) (**Clad & Extruded units only**)



Screws are shown to scale

PRELIMINARY PREPARATION

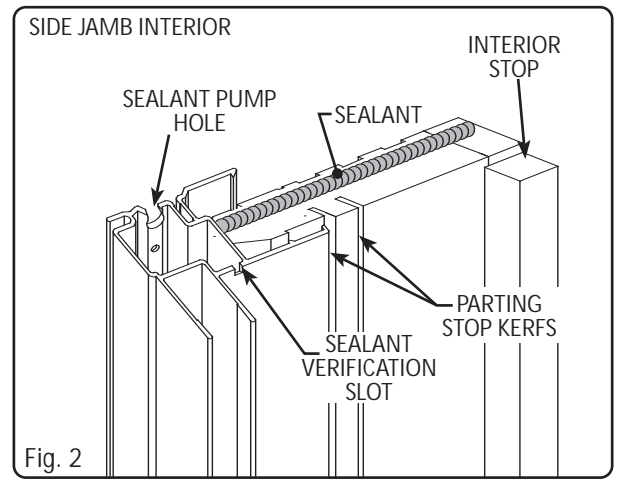
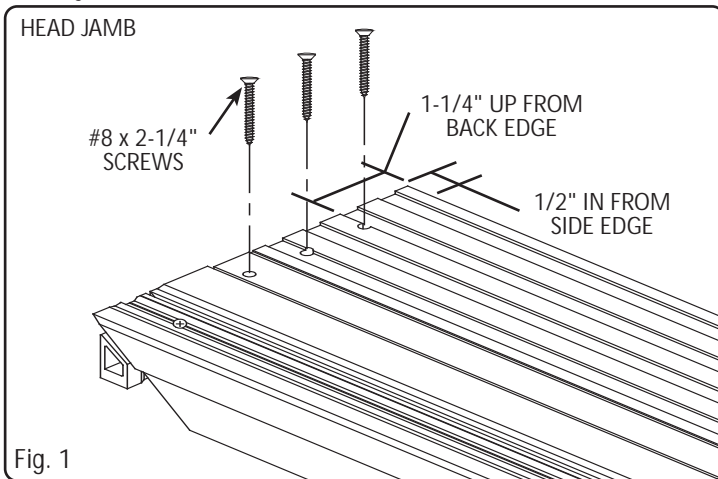
1. **Unpacking:**
Remove and properly dispose of all shipping and packaging materials. These materials may include the protective shipping film and covers on the exterior of the frame, cardboard wrapping, skid plates, factory bracing, or factory applied ridged or strap handles attached to the frame.
2. **Positioning:**
Place the door on a clean, flat work surface with the exterior side facing up.
3. **Assessment:**
Ensure the unit is undamaged. Take note of its size dimensions for reference. Contact your Kolbe door supplier if you find damage or size discrepancies.
4. **Hardware Check:**
Verify that all necessary hardware, such as screws, brackets, handles, is present and accounted for.

FRAME ASSEMBLY

Attach Head Jamb to Side Jamb:

(Fig. 1) Take the head jamb and on each end mark clearance hole locations, 1/2" in from the side edge, towards the center of the unit, and space the holes evenly starting 1-1/4" (19mm) up from the back edge on the wood portion. Using a 3/16" (5mm) drill bit pre-drill holes at each marked screw location on each end. *For wood units only: Also pre-drill one 3/16" hole on each end of the head jamb brickmould. Place the hole 1" (26mm) in from each end and centered on the brickmould.*

Dry fit the head jamb and side jambs. Drill 3/32" (2mm) pilot holes through the clearance holes in the head jamb and down into each side jamb.



(Fig. 2) Apply a 3/16" (5mm) bead of sealant to the top of each side jamb assembly. Attach the head jamb to the side jambs by fastening through the clearance holes in the head jamb and into the side jamb, using three #8 x 2-1/4" (57mm) screws (provided) on each end.

For extruded units: Use one #7 x 5/8" (16mm) flat head screw (provided) through the side nosing into the corner key on each side of the unit.

For wood units: Secure the head brickmould to the side brickmould using one #8 x 2-1/4" (57mm) screw (provided) on each side.

For clad units: Tuck side jamb clad under head jamb clad, fold head cladding tabs down 90° and staple to side jamb using 3/4" (19mm) brad nail (provided by other).

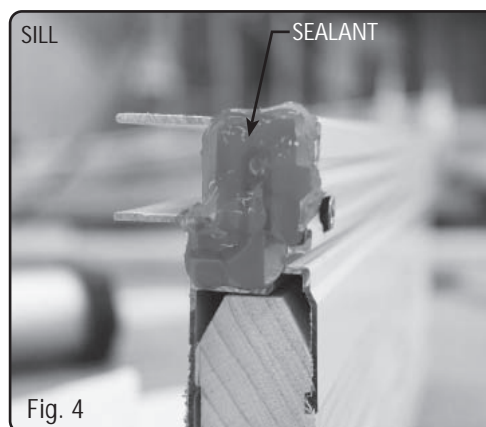
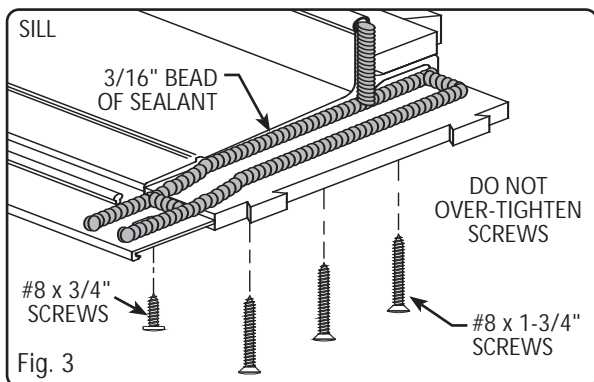
Attach Sill to Side Jamb:

(Fig. 3) Dry fit each side jamb to the sill, aligning the edge of the side jamb with the end of the sill assembly. Drill 3/32" (2mm) pilot holes through the pre-drilled holes in the sill end keys and into the side jamb for each side.

Run a 3/16" (5mm) bead of sealant on each end of the sill as shown in **(Fig. 3)**.

Apply sealant to the end of side jamb around the sill end key as shown in **(Fig. 4)**.

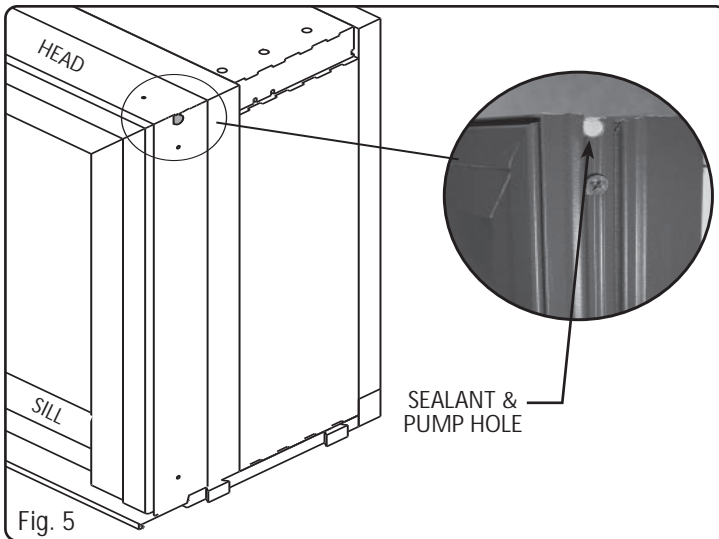
Dab sealant on the screw holes. Butt and align each side jamb assembly, with the end key in place, onto the sill assembly. Fasten through the holes in the sill and into the side jamb, using three #8 x 1-3/4" (44mm) screws on each end. Using #8 x 3/4" (19mm) screws, fasten through the sill assembly and up into the side nosing on each side. Do not over tighten screws.



(Fig. 5) On the exterior of the frame, there is a sealant pump hole at the top of the side jamb on the jamb nosing, and a sealant verification slot on the opposite side of the frame, near the screen track. Pump color matching or clear sealant through the hole, into the corner key, until it squeezes out the verification slot. Wipe off any excess sealant squeeze-out. Apply one nailing fin foam corner to the nail fin on each side where the side jamb and head jamb nail fin meet at the top of the unit.

The frame is now assembled and ready for installation. Please see our Sliding Patio Door Installation Instructions for installing the unit into the rough opening.

Visit www.kolbewindows.com for more information.



Contact your Kolbe window and door supplier or visit us at www.kolbewindows.com for further information.

THANK YOU
FOR PURCHASING KOLBE PRODUCTS

Kolbe & Kolbe Millwork Co., Inc. reserves the right to change specifications without notice.