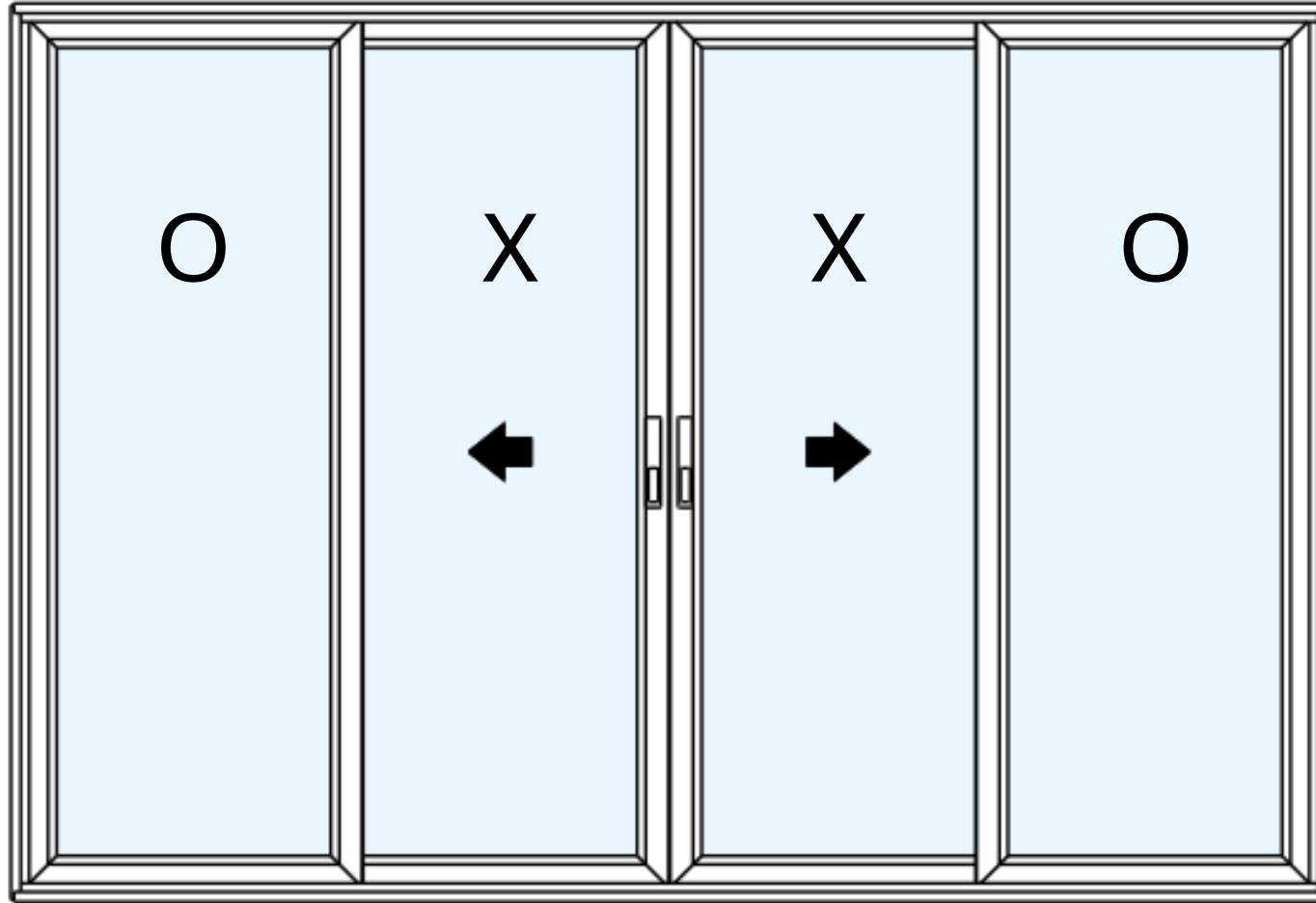


# C700 4 Panel Sliding Glass Door Field Panel Installation 2



# C700 4 Panel SGD Disclaimers

**ADVISORIES AND DISCLAIMERS:** Fully read and follow instructions to ensure proper panel installation on C700 Sliding Glass Door product. Panel Assembly is not a “do-it-yourself” project and should be installed only by experienced, qualified, and where required, licensed installation professionals.

Read this entire document before proceeding with the assembly of Milgard’s products. These instructions address only the installation process for panels into Milgard sliding door products. Read and fully understand ALL manufacturer’s instructions prior to beginning the assembly. Fully follow the applicable Milgard Installation Recommendation for the door. Failure to follow the applicable installation instructions may affect the ability to assemble and operate the door, as well as coverage under the applicable Milgard express limited warranty.

These instructions are to be used only with products specifically ordered with the panel orientation addressed in these instructions. Products must be identified as such on the order documents so the manufacturing plant can properly prepare the products for field assembly. If the doors do not arrive prepared for use with this set of instructions, do not move forward with installation and contact your Milgard representative.

This is a finished product that must be protected before, during and after installation to prevent damage to the glass, frame, finish and hardware. All component parts, including door panels, should be stored in a dry location that is protected from the elements.

Doors requiring field assembly will be delivered with a kit containing the items that should be used when assembling the panels and hardware. Milgard’s products are rated for performance based on the specific items and fasteners included with this kit. Any deviation from these guidelines or substitutions/use of parts not provided with the kit could affect the performance of the product.

Proper panel installation and operation requires appropriate support and securing of fasteners into rough opening framing members. This has the potential to impact the flashing and water management systems at a product opening. Consult the responsible system supplier or responsible owner, architect and/or builder to ensure that support and fastening of the door is effective and in compliance with applicable laws, site requirements and building codes.

Inspect the panel and door frame thoroughly before beginning the assembly process. Ensure all product and hardware options are included with the product. Inspect and report any product or panel damage or other concerns to your Milgard representative prior to moving forward with installation.

# C700 4 Panel SGD Disclaimers

**ADVISORIES AND DISCLAIMERS (continued):** Jobsite and worker protections are recommended and may be required. Follow all manufacturers' instructions for appropriate and safe use of protective equipment, tools, materials, hardware and site protections necessary for assembly of the products. Use caution when handling glass. Broken or cracked glass can cause serious injury.

It is the responsibility of the installation contractor to consult and establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to commencing installation. Do not work alone and use safe lifting techniques. Two or more people may be required to lift. Use a reasonable amount of people with enough strength to lift, carry and install to avoid injury and/or damage to the Product.

It is the sole responsibility of the owner, architect, and/or builder to select the correct products and ensure that installation is in compliance with applicable laws, site requirements, and building codes. Failure to follow these recommendations, local requirements, or good building practices may affect the availability of remedies under Milgard's warranty.

Entry doors of any kind include elements specifically intended to address security and safety concerns. Ensure appropriate glass selection, hardware systems, and presence of security elements (e.g., antilift blocks) are presents on the product before moving forward with installation. Proper assembly and adjustment of security and safety devices must be observed prior to finalizing panel installation.

# C700 4 Panel SGD Field Panel Installation

## **Step 1: Pre-Assembly Preparation – General Information**

- Remove all packaging components from all panels.
- Identify fixed and active panels prior to installation. Identify necessary hardware, and accessories.
- Do not install any panels until proper assembly and installation of the frame is confirmed. Reference the latest version of AAMA 2400 for new construction installation and AAMA 2410 for replacement installation. More information can be found in Milgard's Technical Resources website.
- For image clarity, all diagrams in this document show parts without weatherstripping. Weatherstripping should be present in all parts as noted in the parts list, page 5.
- Depending on actual configuration ordered, actual door may have opposite handing to all diagrams shown.

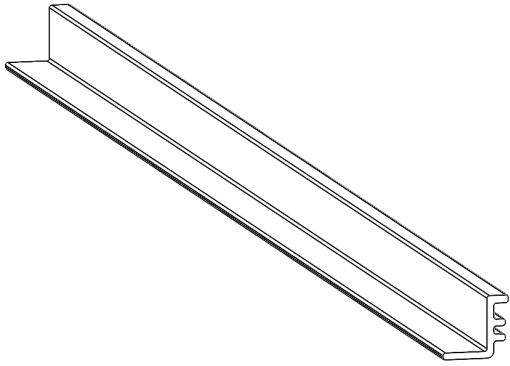
# C700 4 Panel SGD Field Panel Installation

## Step 1: Pre-Assembly Preparation

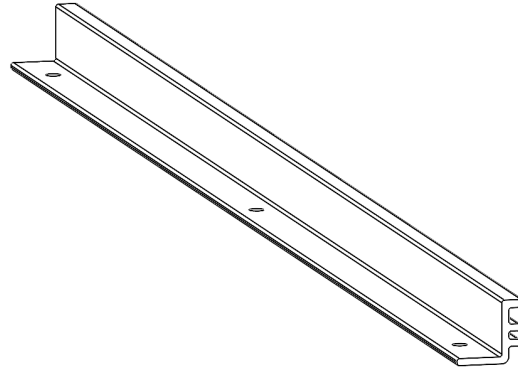
4 PANEL OXXO KD BOM					
ITEM NO.	MILGARD P/N	DESCRIPTION	QTY.	HARDWARE BOX	NOTES
1	PX5016XX	SGD SILL W/ WEATHERSTRIP & WEEP GATES & SILL PANEL JOIN BAR INSERTED	1		-
2	PX5016XX	SGD JAMB W/ WEATHERSTRIP INSERTED	2		-
3	PX5017XX	SGD HEAD W/ WEATHERSTRIP INSERTED	1		-
4	IM3113NC	SILL TO JAMB CORNER KEY	2	X	-
5	IM3114NC	HEAD TO JAMB CORNER KEY RIGHT	1	X	-
6	IM3115NC	HEAD TO JAMB CORNER KEY LEFT	1	X	-
7	FA0315XX	#8x1/2 PH FH SMS	28	X	-
8	VA4610NC	JAMB FIXED PANEL JOIN BAR	2		-
9	VA4611XX	PANEL ANTI LIFT	4	X	-
10	VA6122ABPXX	DOOR STOP	4	X	-
11	PX5022XX	HEAD COVER	1		-
12	EX7304XX	ROLLER TRACK	1		-
13	EX7305XX	FIXED SILL COVER	2		-
14	EX7307XX	VENT SILL COVER	1		-
15	EX7305XX	FIXED JAMB COVER	2		-
16	FA8210SSXX	8Ax1/2" PH FLAT SMS 410 SS SELF DRILL	40	X	-
17	SE8626	RETICULATED FOAM	2	X	-
18	VARIES	SILL PANS	AS RQ'D		-
19	PX5019XX	FIXED PANEL INTERLOCK W/ WEATHERSTRIP INSERTED	2		-
20	PX5019XX	ACTIVE PANEL INTERLOCK W/ WEATHERSTRIP INSERTED	2		-
21	SE0034CL	PECORA SEALANT	4	X	-
22	EX7302XX	STUCCO KEY ACCESSORY 192" SL	AS RQ'D		-
23	EX7303XX	ACCESSORY GROOVE FILLER 192" SL	AS RQ'D		-
24	VA05084001WH	NAIL FIN	AS RQ'D		-
25A	HL7210XX	CREST INTERIOR PLATE & PULL HANDLE ASSEMBLY	1	X	IF CUSTOMER CHOOSES CREST HANDLE
25B	HL7209NA	CREST INTERIOR PLATE MOUNT	1	X	
25C	HL7207XX	CREST EXTERIOR PULL HANDLE	1	X	
25D	HL7206XX	CREST LOCK SNIB	1	X	
25E	FA7211ZP	8-32x3/4" PH FH "F" TYPE	2	X	
25F	FA8211SS	8Ax1 3/4" PH FLAT TYPE F	2	X	
26A	HL4318	INVISIO HANDLE INTERIOR & EXTERIOR MORTISE PLATE KEYED	1	X	IF CUSTOMER CHOOSES INVISIO HANDLE
26B	HL4319	INVISIO HANDLE INTERIOR & EXTERIOR MORTISE PLATE NO KEY	1	X	
26C	HL4320	INVISIO HANDLE INTERIOR & EXTERIOR HANDLE PLATE	1	X	

# C700 4 Panel SGD Field Panel Installation

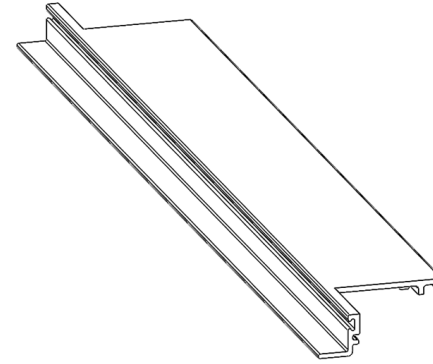
## Step 1: Fixed Panel Installation – Parts Required



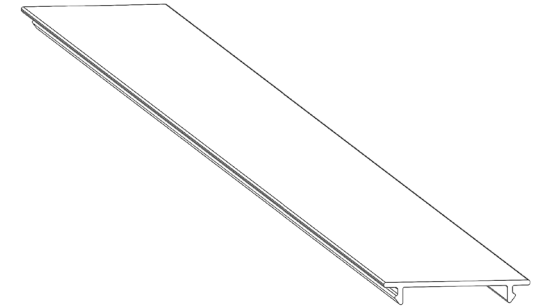
#13: EX7305XX Fixed  
Sill Cover  
2x



#15: EX7305XX Fixed  
Jamb Cover  
2x



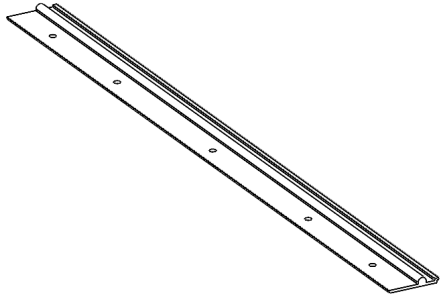
#14: EX7307XX Vent  
Sill Cover  
1x



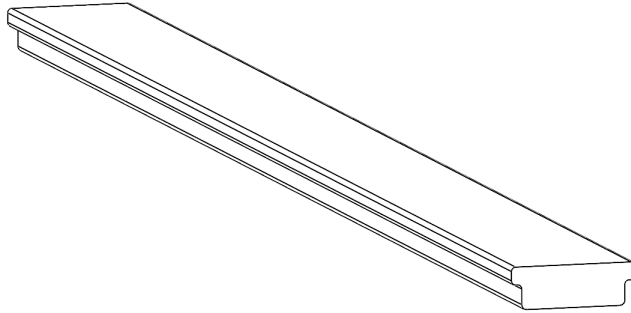
#11: PX5022XX Head Cover  
1x

# C700 4 Panel SGD Field Panel Installation

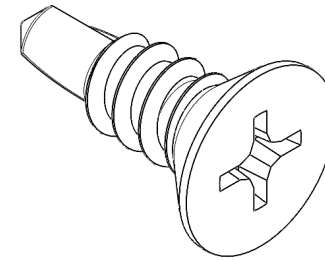
## Step 1: Fixed Panel Installation – Parts Required



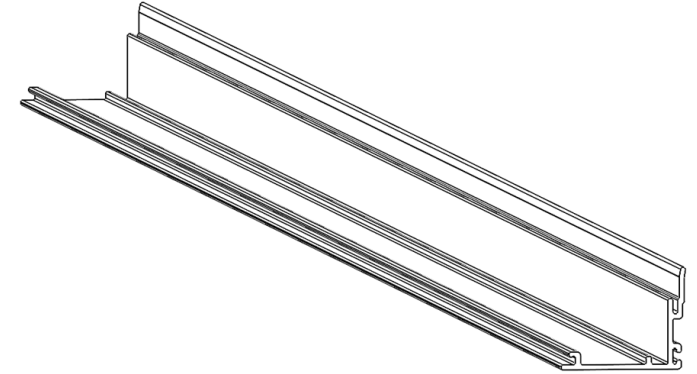
#12: EX7304XX Roller  
Track  
1x



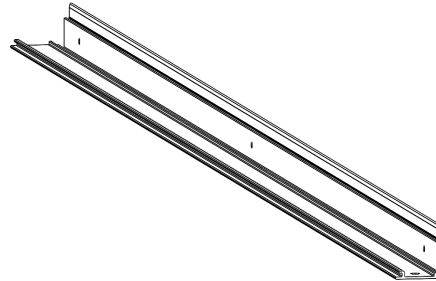
#8: VA4610NC Jamb Fixed  
Panel Join Bar  
2x



#16: FA8210SSXXSSXX #8 x  
½ PH FH Self Drilling  
40x



#19: PX5019XX Fixed Panel  
Interlock 2x

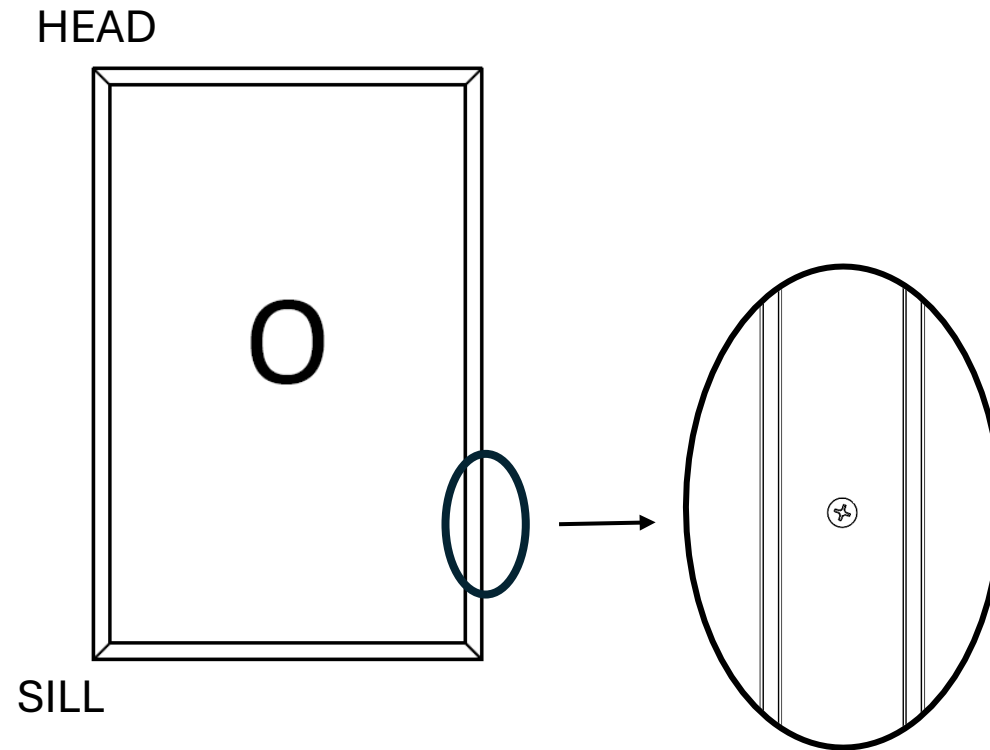


#20: PX5019XX Active Panel  
Interlock 2x

# C700 4 Panel SGD Field Panel Installation

## Step 2: Fixed Panel Installation

- Locate Fixed Panel to be installed. To begin Fixed Panel installation, locate Fixed Panel rail side that will go into the frame. This side has a screw pre-attached near the sill end.

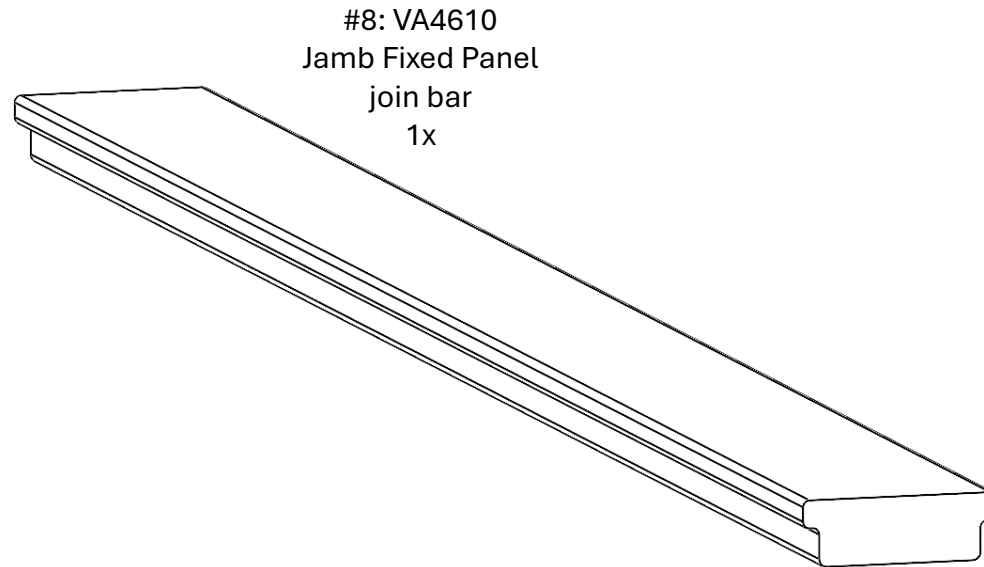




# C700 4 Panel SGD Field Panel Installation

## Step 2: Fixed Panel Installation

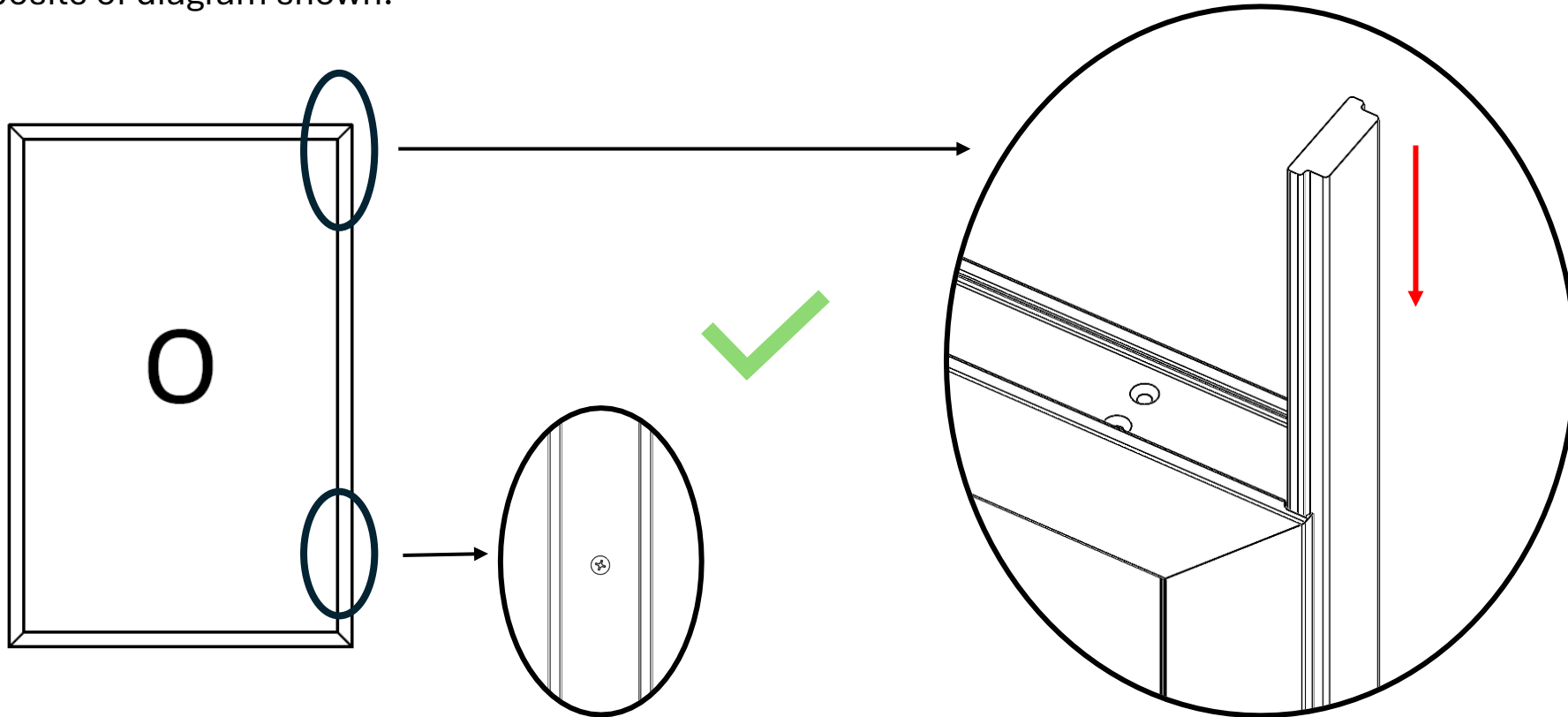
- Locate the Jamb Fixed Panel join bar.



# C700 4 Panel SGD Field Panel Installation

## Step 2: Fixed Panel Installation.

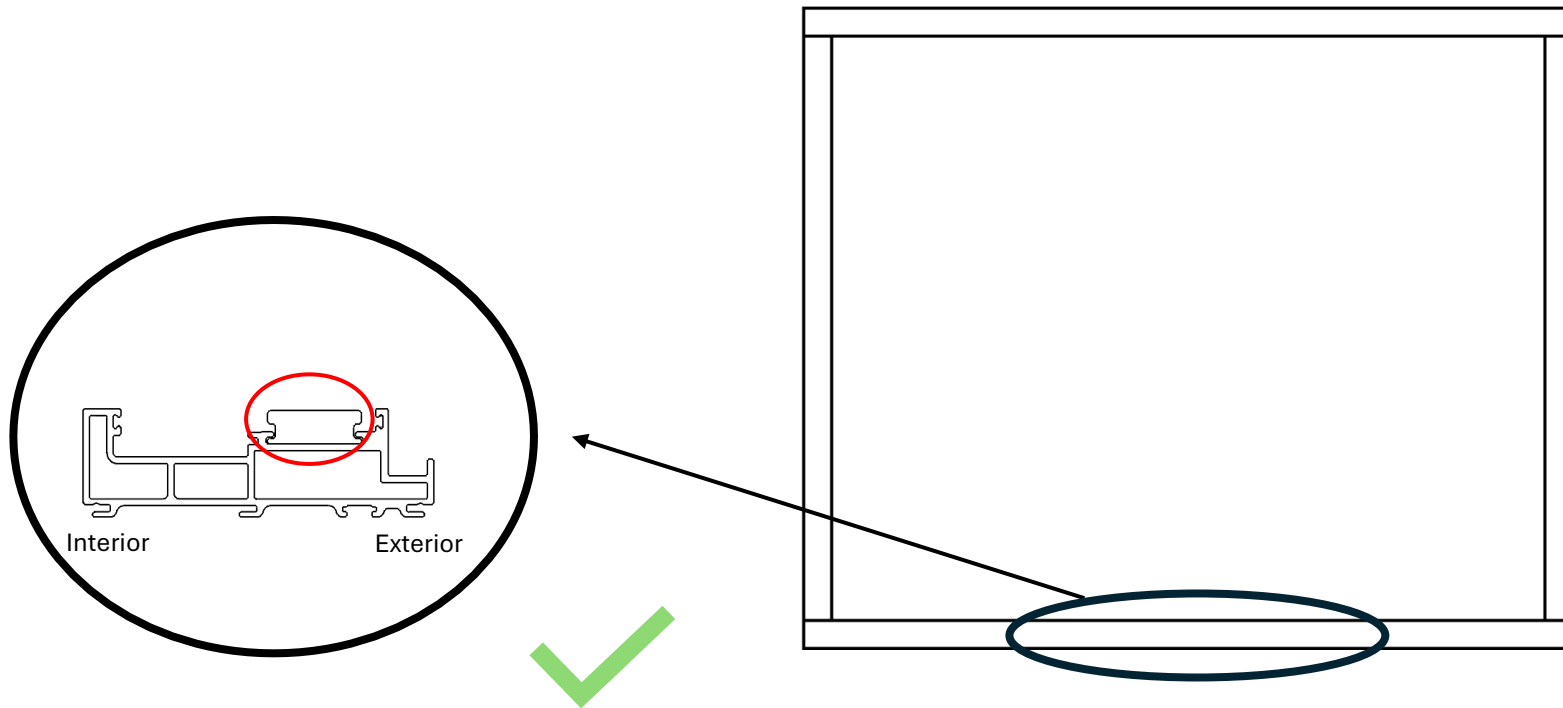
- Slide the Fixed Panel Jamb Join Bar into the rail until it stops on the pre-attached screw shown . Location of Fixed Panel Jamb Join Bar may be opposite of diagram shown.



# C700 4 Panel SGD Field Panel Installation

## Step 2: Fixed Panel Installation

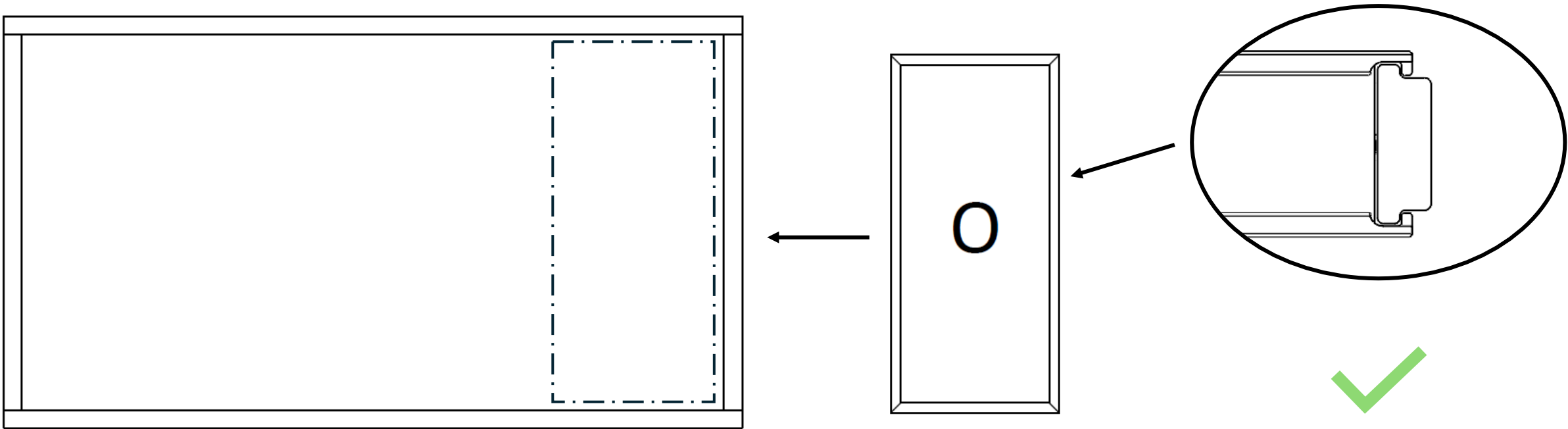
- Slide both pre-attached Fixed Panelsill join bars (circled in red) towards the middle of the frame. The Fixed Panel will install on the exterior track.



# C700 4 Panel SGD Field Panel Installation

## Step 2: Fixed Panel Installation

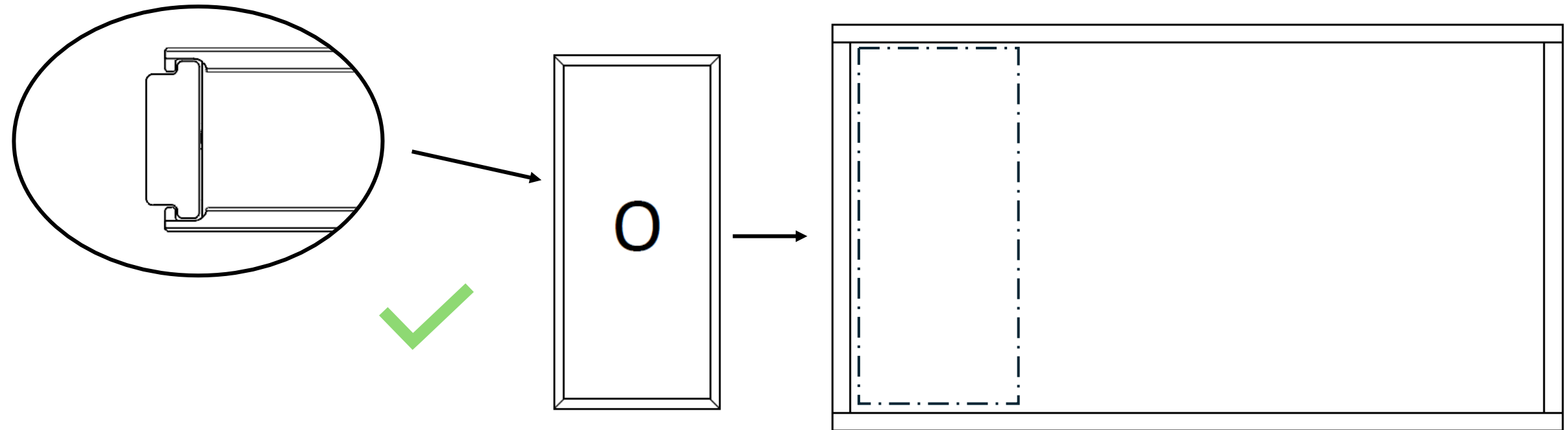
- The Fixed Panel is to be installed opposite of the vent panel strike. Fixed Panel jamb Join Bar should be oriented to face the frame jamb.



# C700 4 Panel SGD Field Panel Installation

## Step 2: Fixed Panel Installation

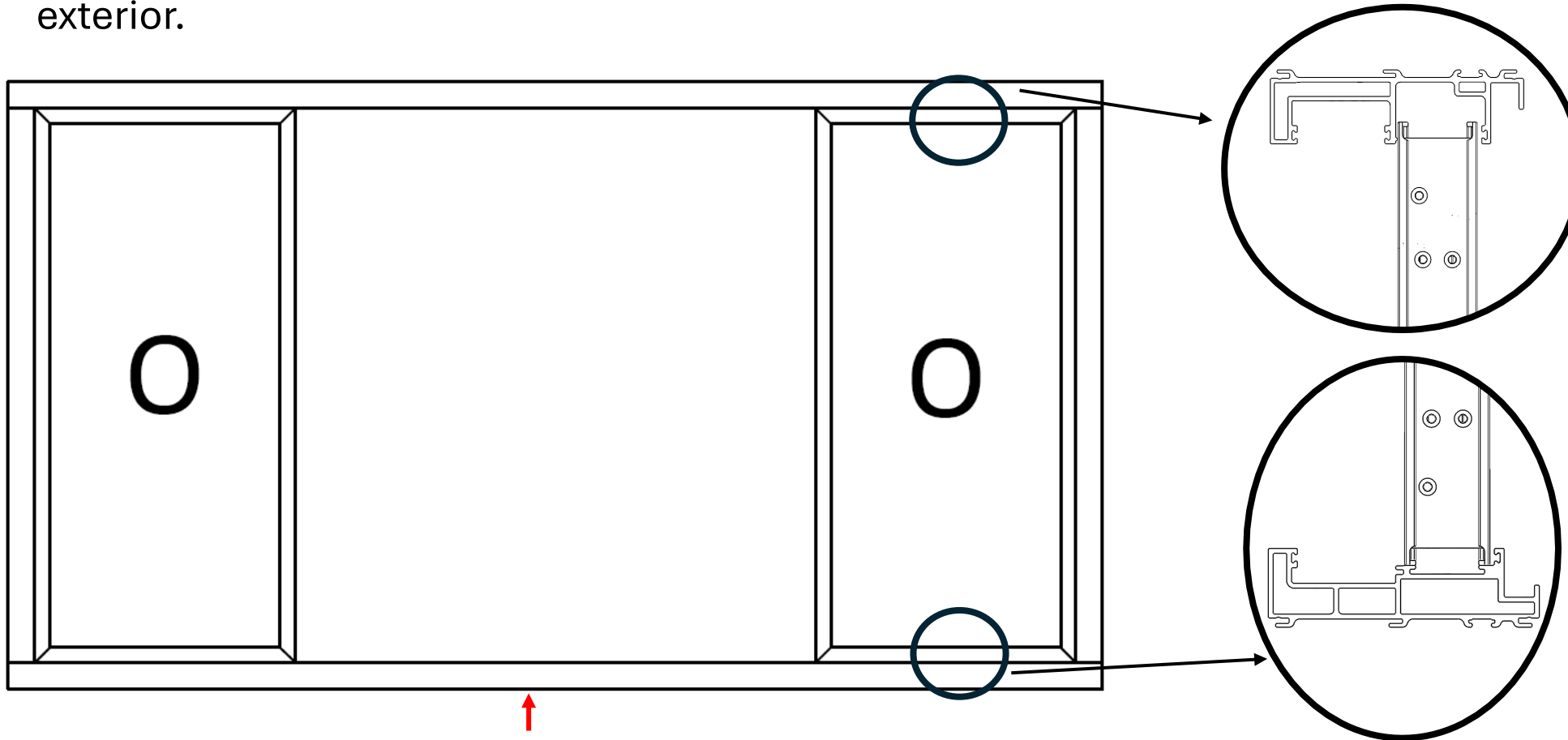
- The Fixed Panel is to be installed opposite of the vent panel strike. Fixed Panel jamb Join Bar should be oriented to face the frame jamb.



# C700 4 Panel SGD Field Panel Installation

## Step 2: Fixed Panel Installation

- Install Fixed Panel by pushing it diagonally into the head cavity first then lowering it onto the sill from the exterior.

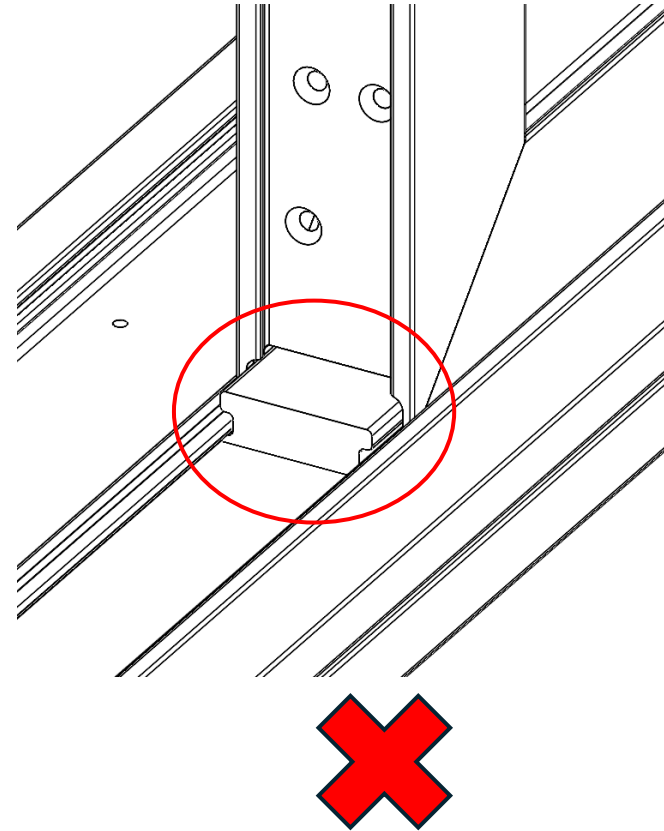
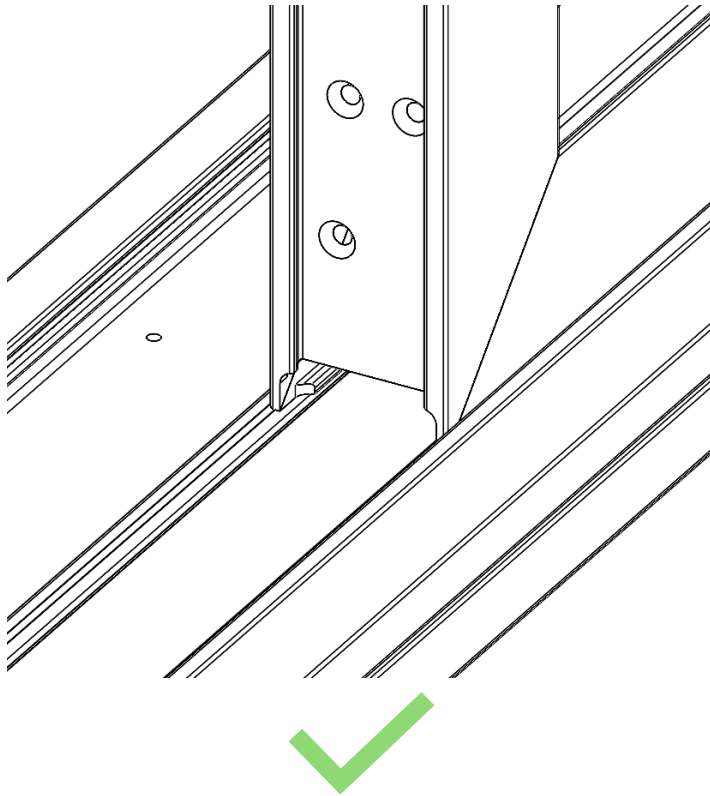


**Note:** Glazing bead on the panel should be facing the exterior of the door.

# C700 4 Panel SGD Field Panel Installation

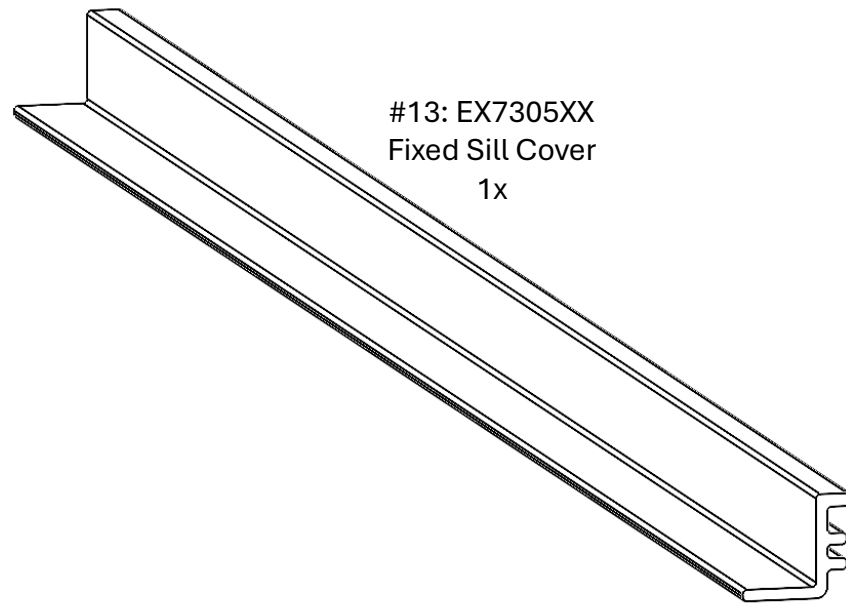
## Step 2: Fixed Panel Installation

- Slide the Fixed Panel sill Join Bar under the Fixed Panel until it is fully inserted. The sill panel Join Bar should be completely underneath the Fixed Panel and should not be visible once inserted. 1 Join Bar per panel.

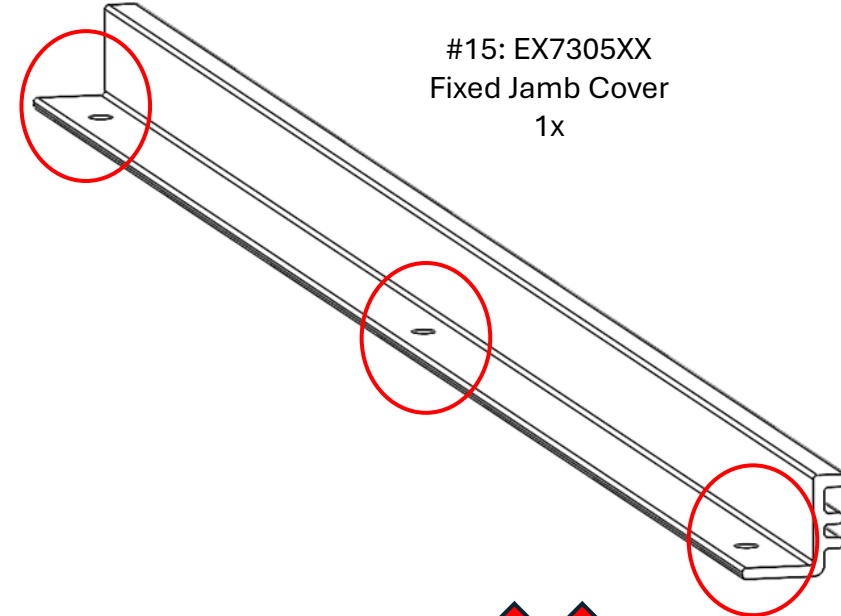


# C700 4 Panel SGD Field Panel Installation

## Step 3: Fixed Sill Cover Installation – Part Identification



#13: EX7305XX  
Fixed Sill Cover  
1x



#15: EX7305XX  
Fixed Jamb Cover  
1x





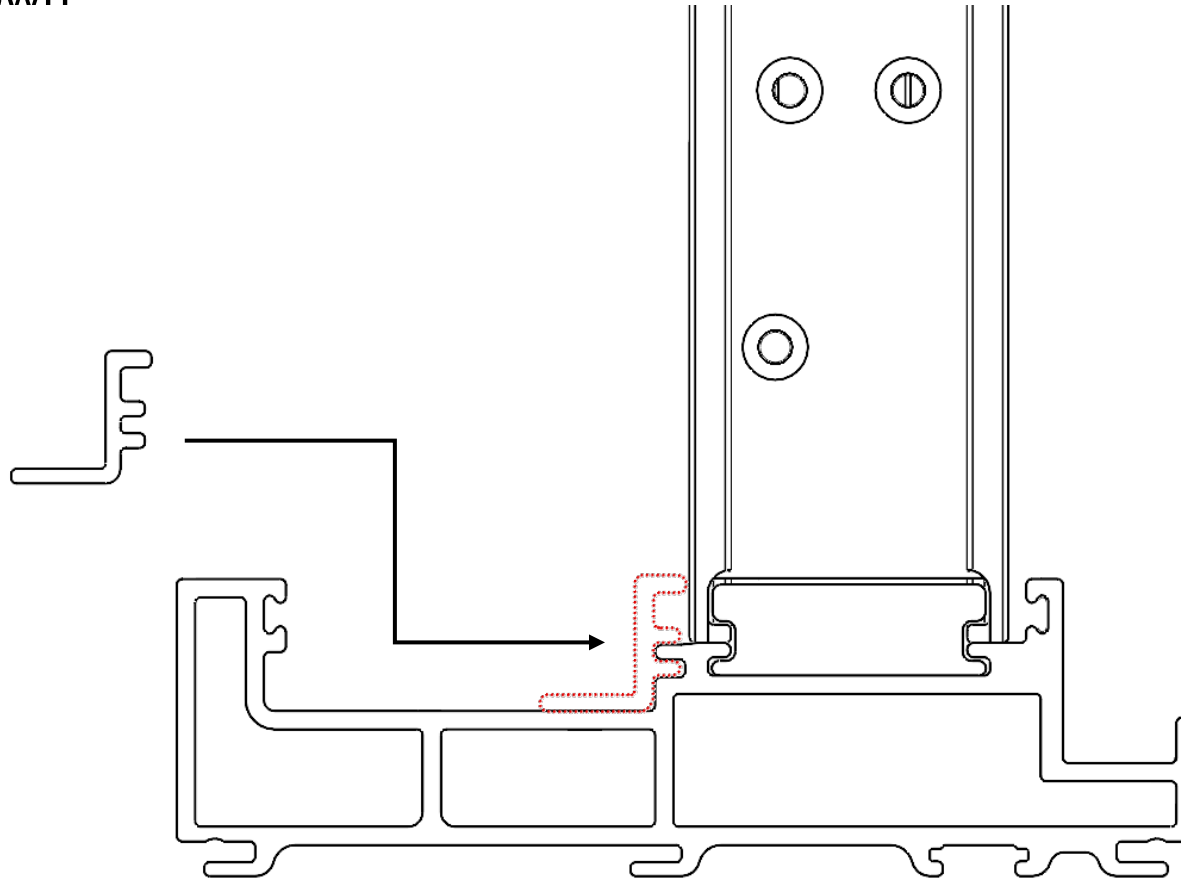
# C700 4 Panel SGD Field Panel Installation

## Step 3: Fixed Sill Cover Installation

- Attach trim piece as shown

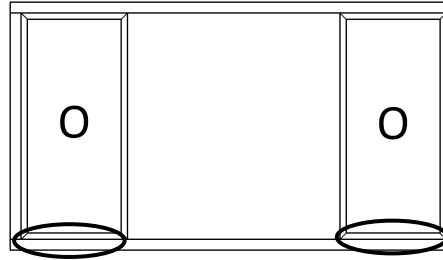


**Note:** Diagram for 1 side shown.  
Part must be installed as shown on  
both fixed panels.

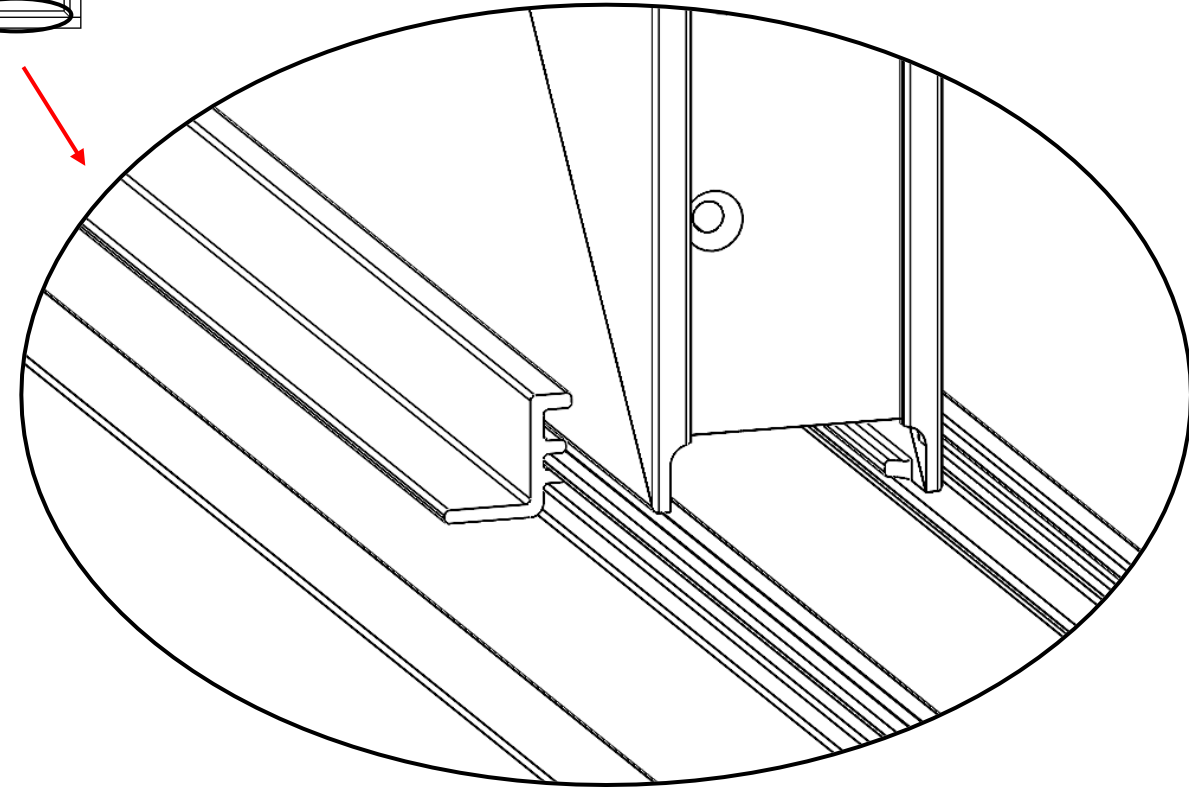
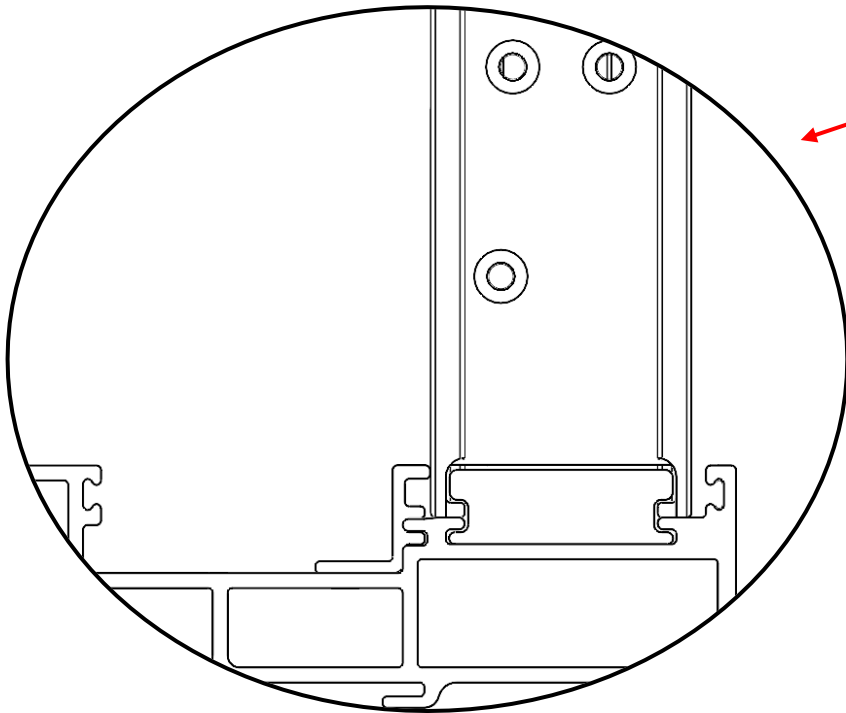


# C700 4 Panel SGD Field Panel Installation

## Step 3: Fixed Sill Cover Installation



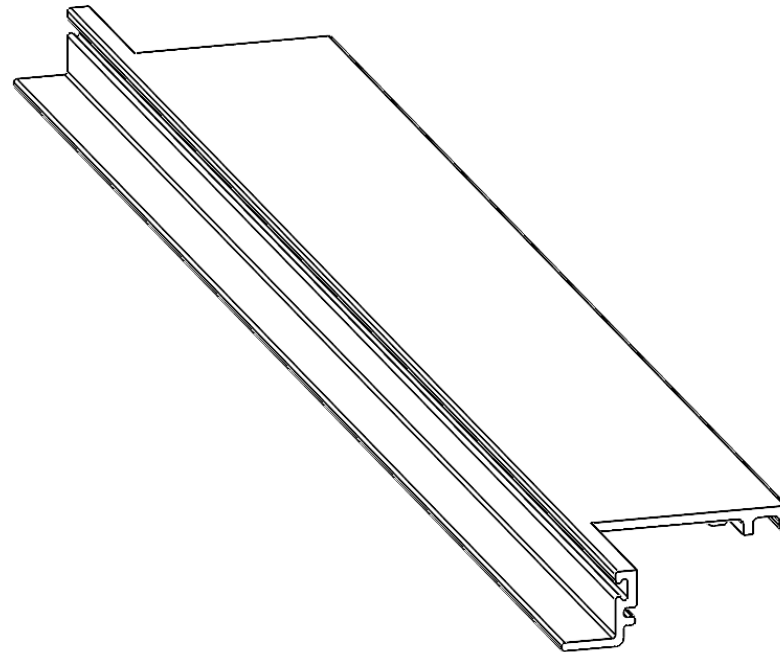
**Note:** Diagram for 1 side shown.  
Part must be installed as shown on  
both fixed panels.



# C700 4 Panel SGD Field Panel Installation

## Step 4: Vent Sill Cover Installation – Part Identification

#14: EX7307XX Vent  
Sill Cover  
1x



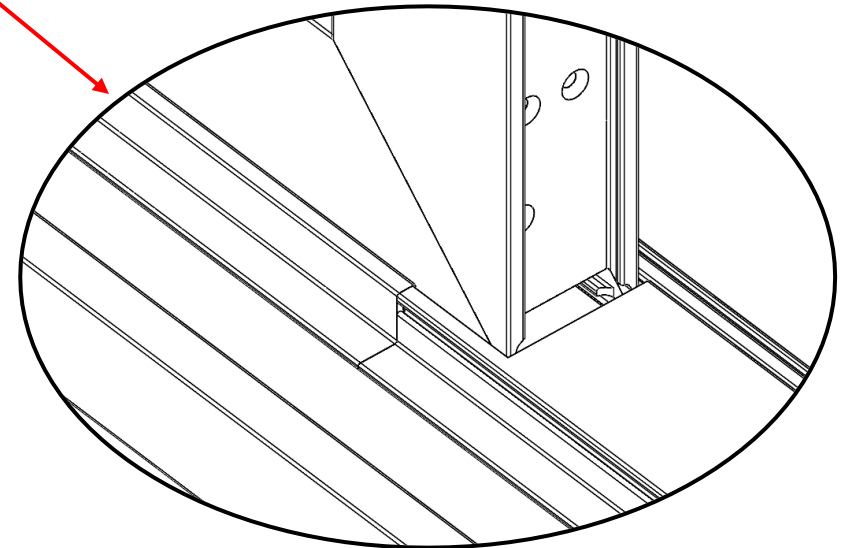
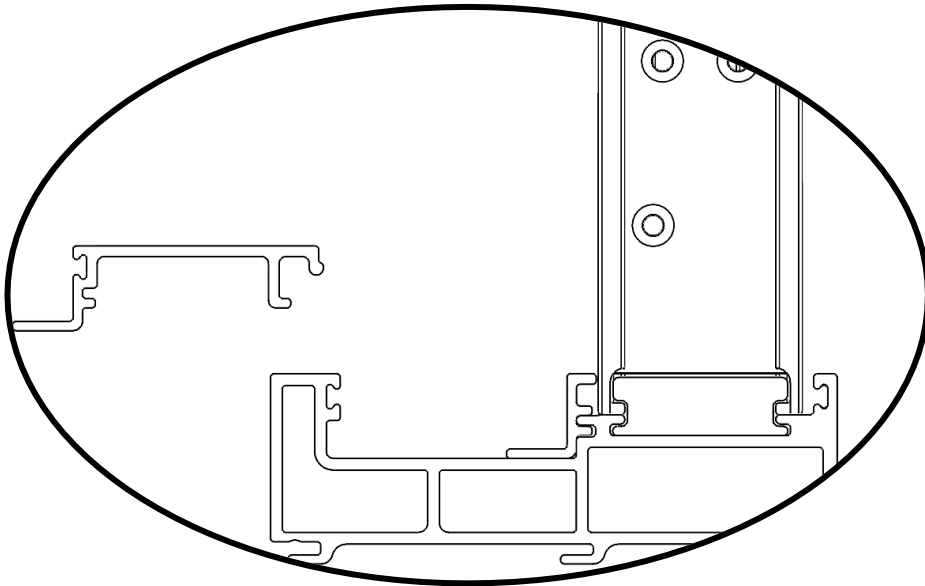
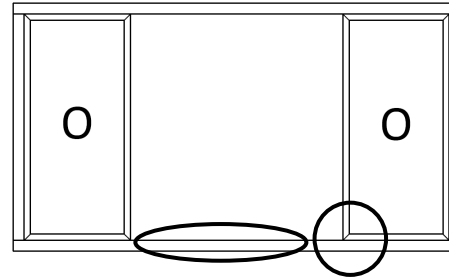
# C700 4 Panel SGD Field Panel Installation

## Step 4: Vent Sill Cover Installation

- Attach trim piece as shown. The side with the notch back should face the fixed panel.

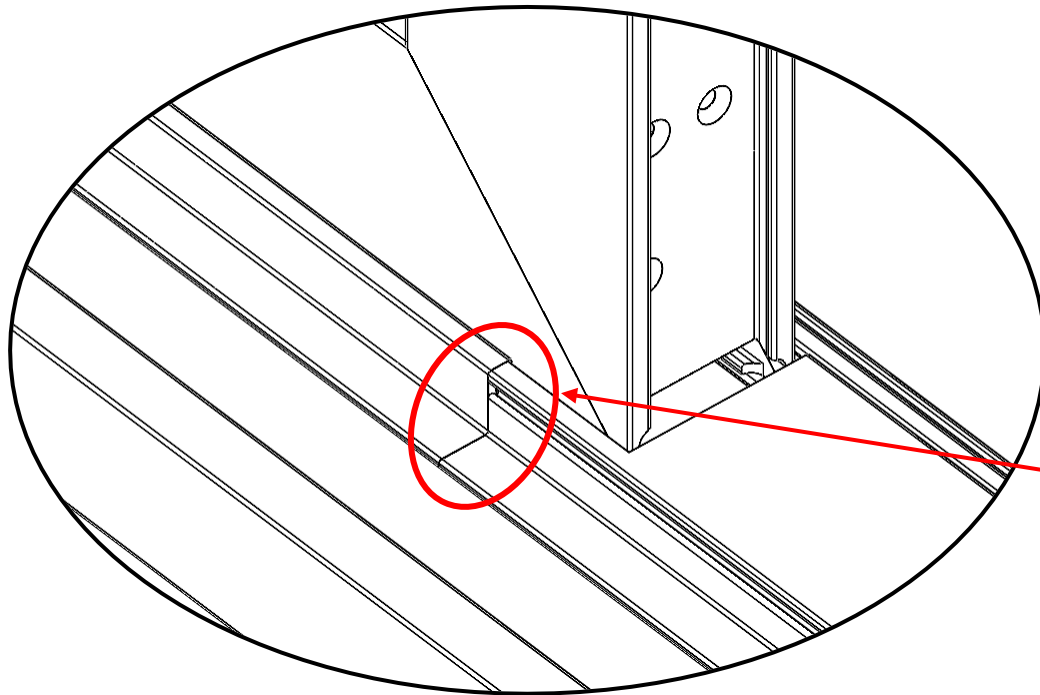
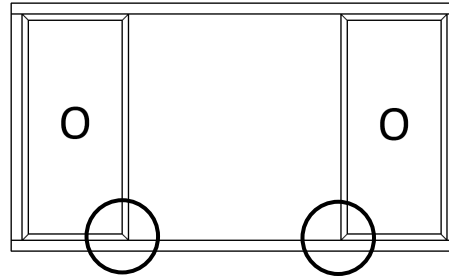


**Note:** Diagram for 1 side shown.  
Part must be installed as shown on  
both fixed panels.

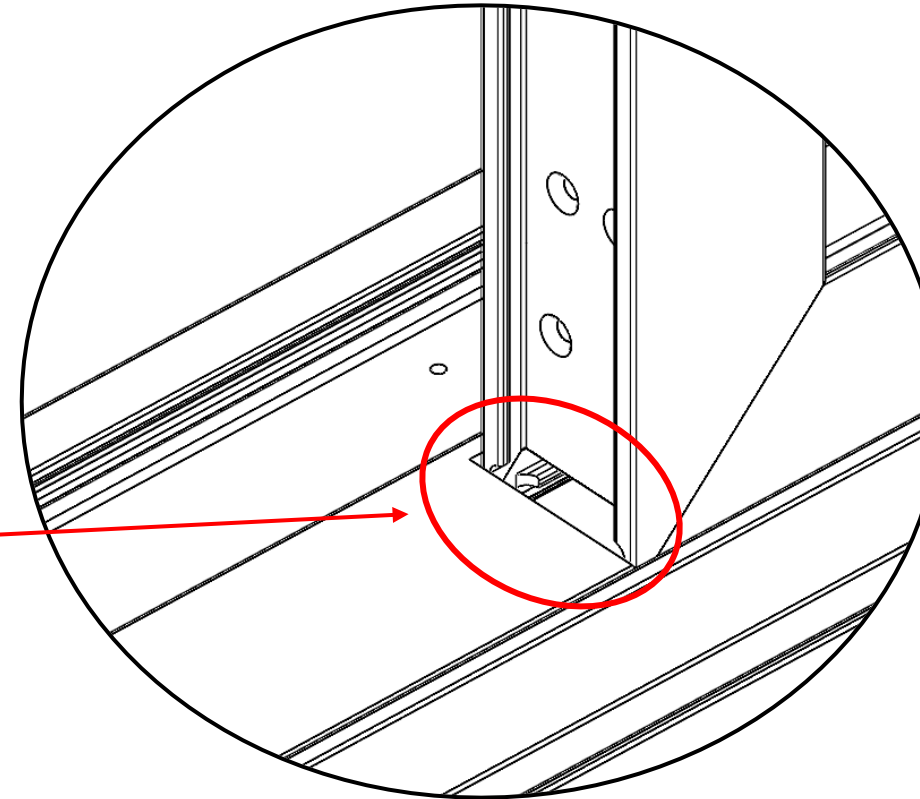


# C700 4 Panel SGD Field Panel Installation

## Step 4: Vent Sill Cover Installation



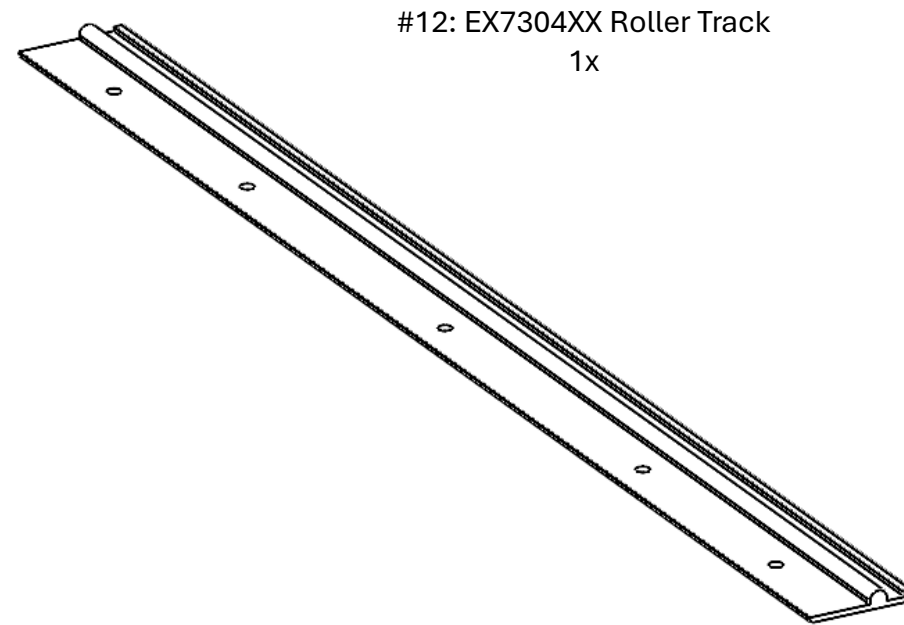
Flush



# C700 4 Panel SGD Field Panel Installation

## Step 5: Roller Track Installation – Part Identification

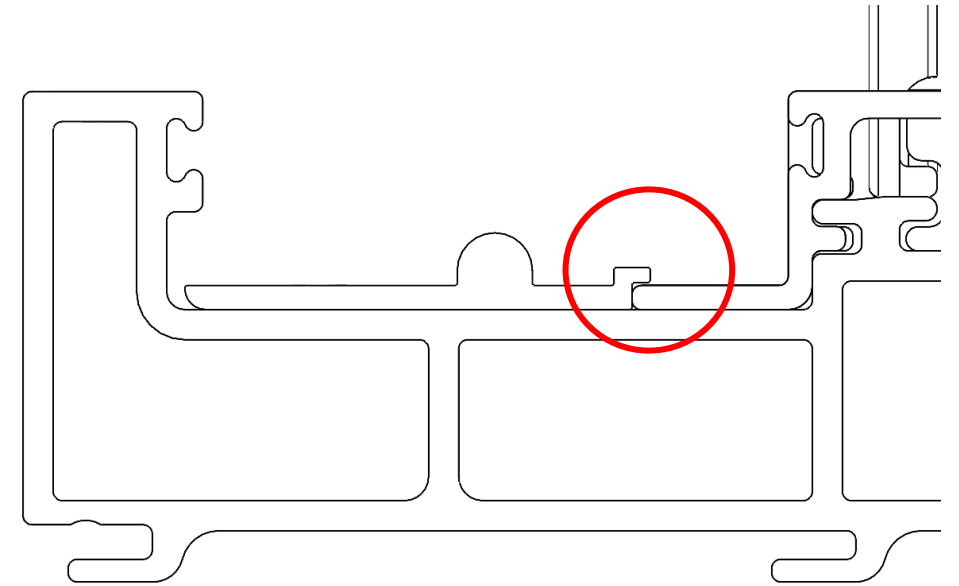
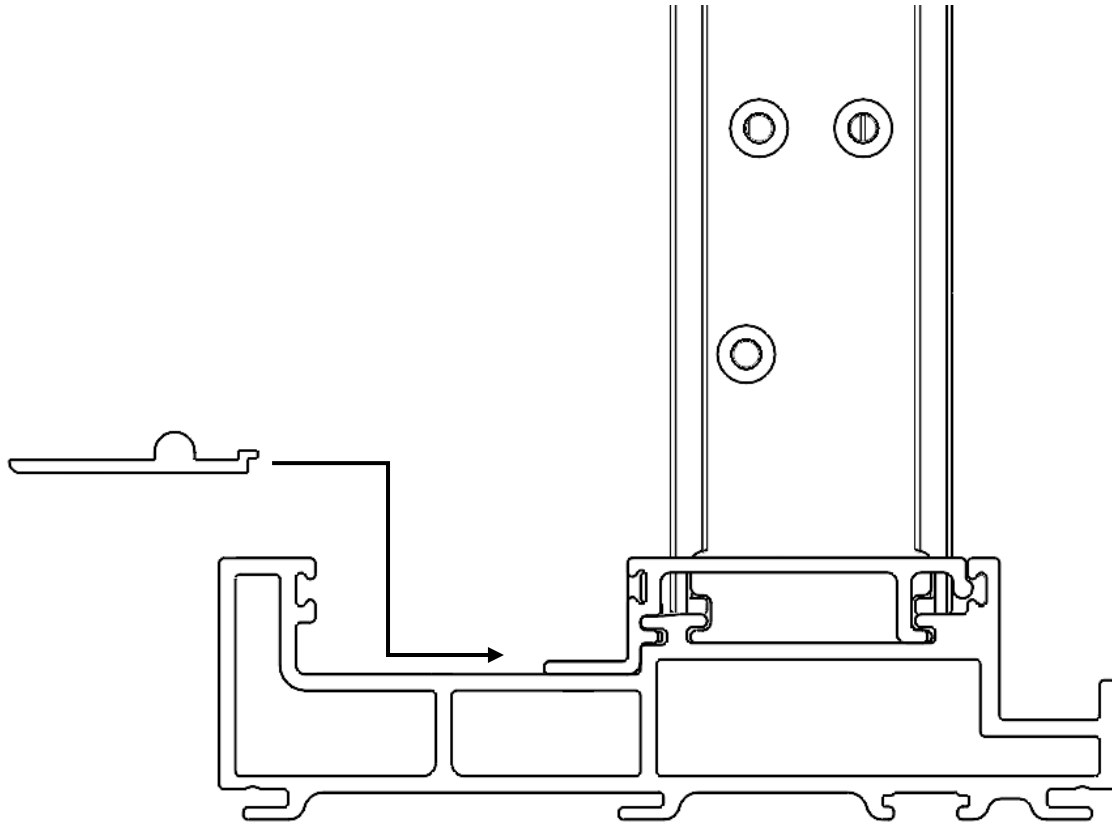
- Locate the Roller track for installation.



#12: EX7304XX Roller Track  
1x

# C700 4 Panel SGD Field Panel Installation

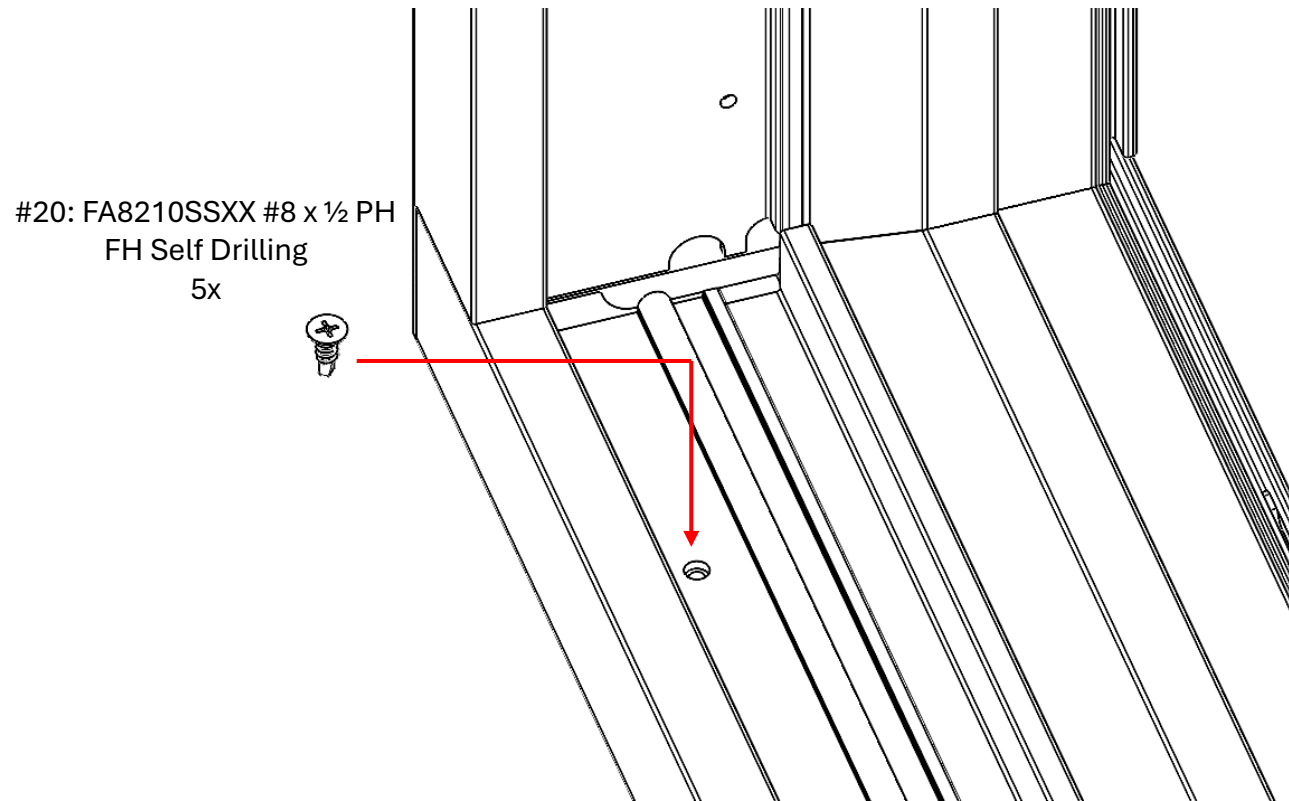
## Step 5: Roller Track Installation



# C700 4 Panel SGD Field Panel Installation

## Step 5: Roller Track Installation

- Align the pre-punched holes on the roller track with the pre-punched holes on the frame sill.

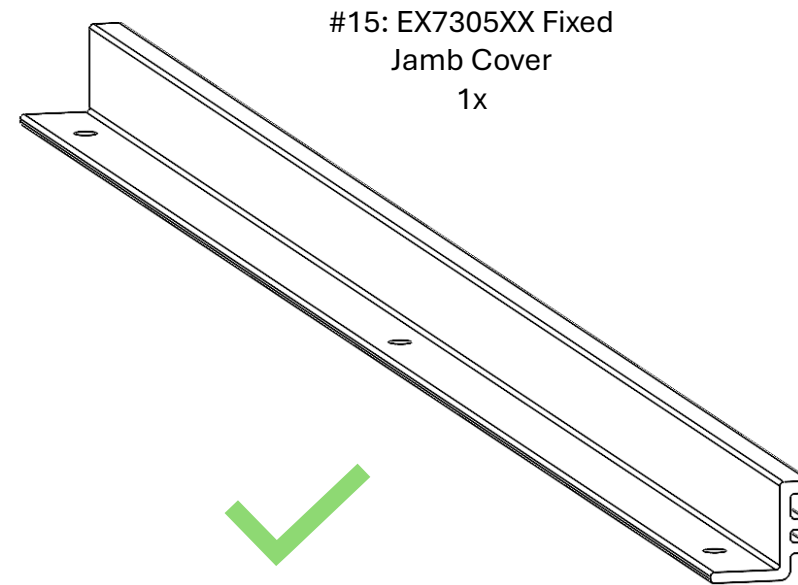


**Note:** Diagram for 1 side shown. All pre-punched holes on this piece must be fastened to the sill. Drill pilot holes as necessary for middle roller track hole(s).



# C700 4 Panel SGD Field Panel Installation

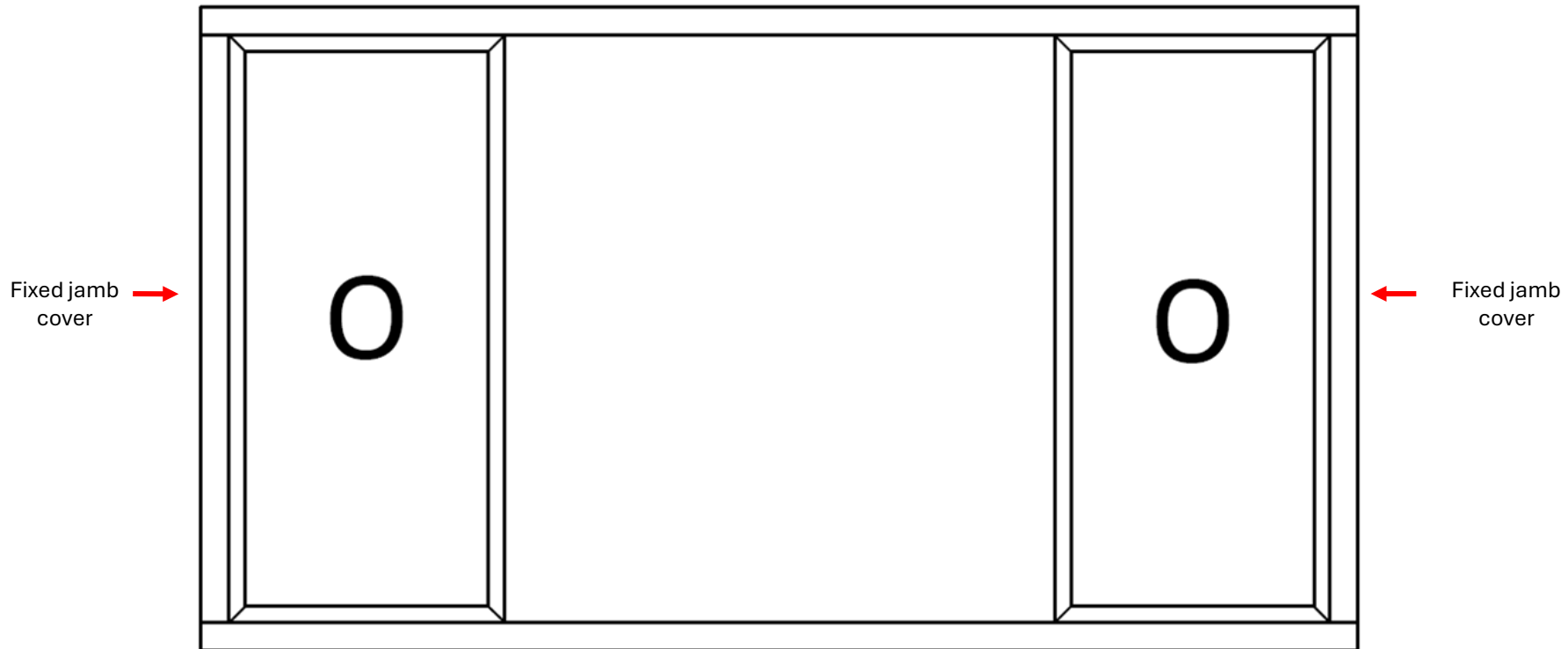
## Step 6: Fixed Jamb Cover Installation – Part Identification



# C700 4 Panel SGD Field Panel Installation

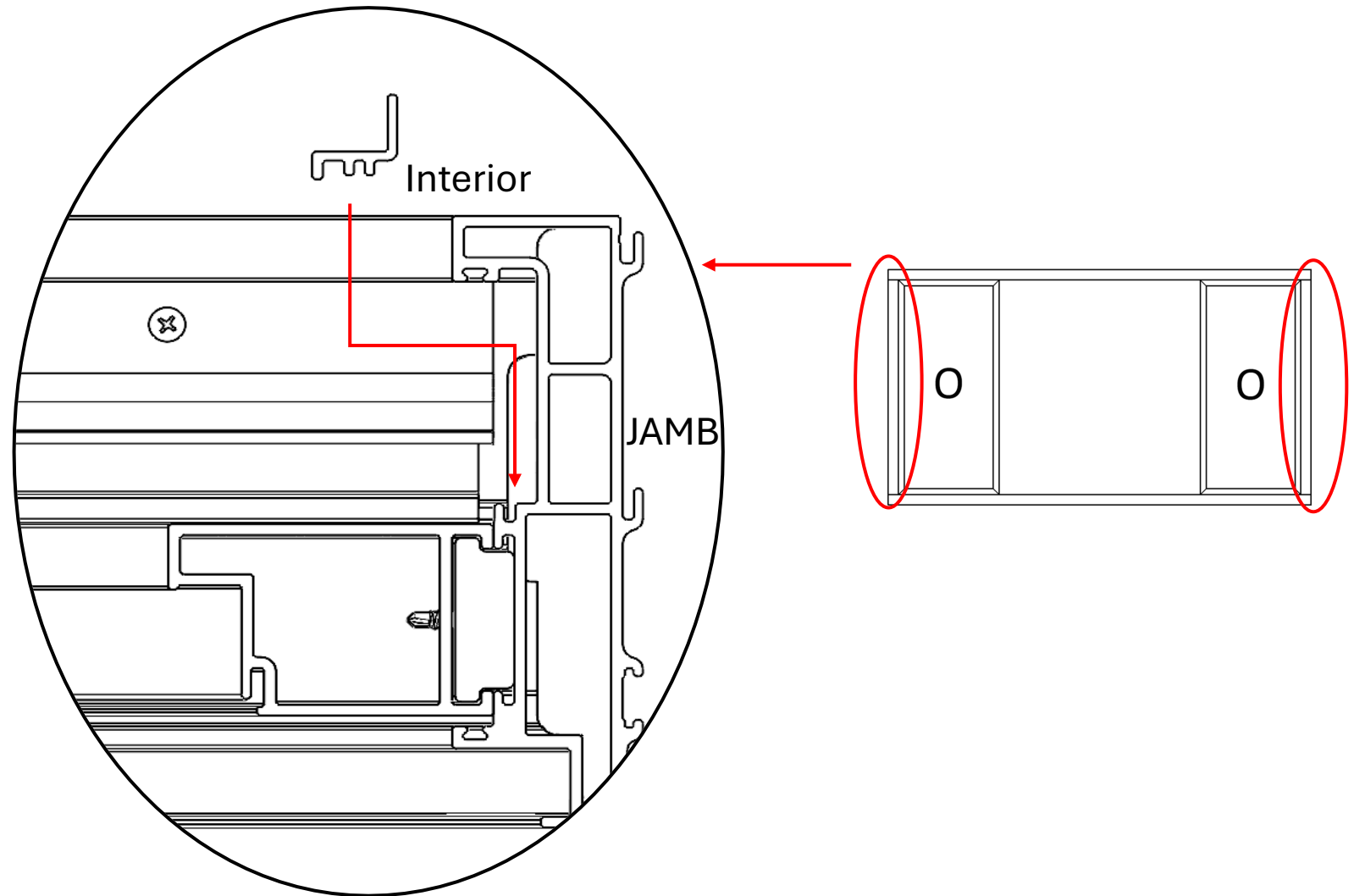
## Step 6: Fixed Jamb Cover Installation

-This piece will attach to the frame jamb opposite of the vent strike.



# C700 4 Panel SGD Field Panel Installation

## Step 6: Fixed Jamb Cover Installation

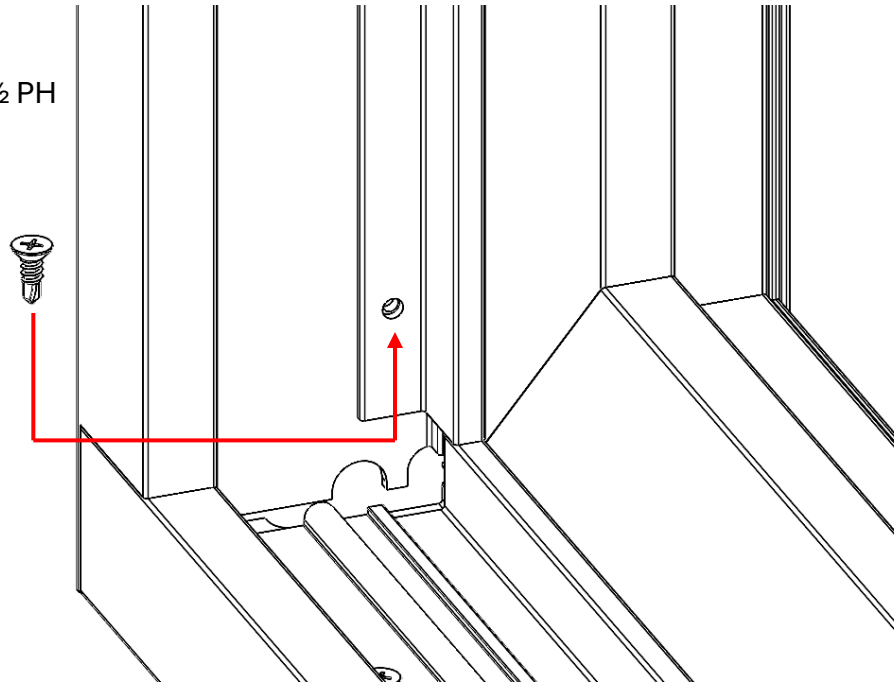


# C700 4 Panel SGD Field Panel Installation

## Step 6: Fixed Jamb Cover Installation

- Align the pre-punched holes on the fixed jamb cover with the pre-punched holes on the frame jamb.

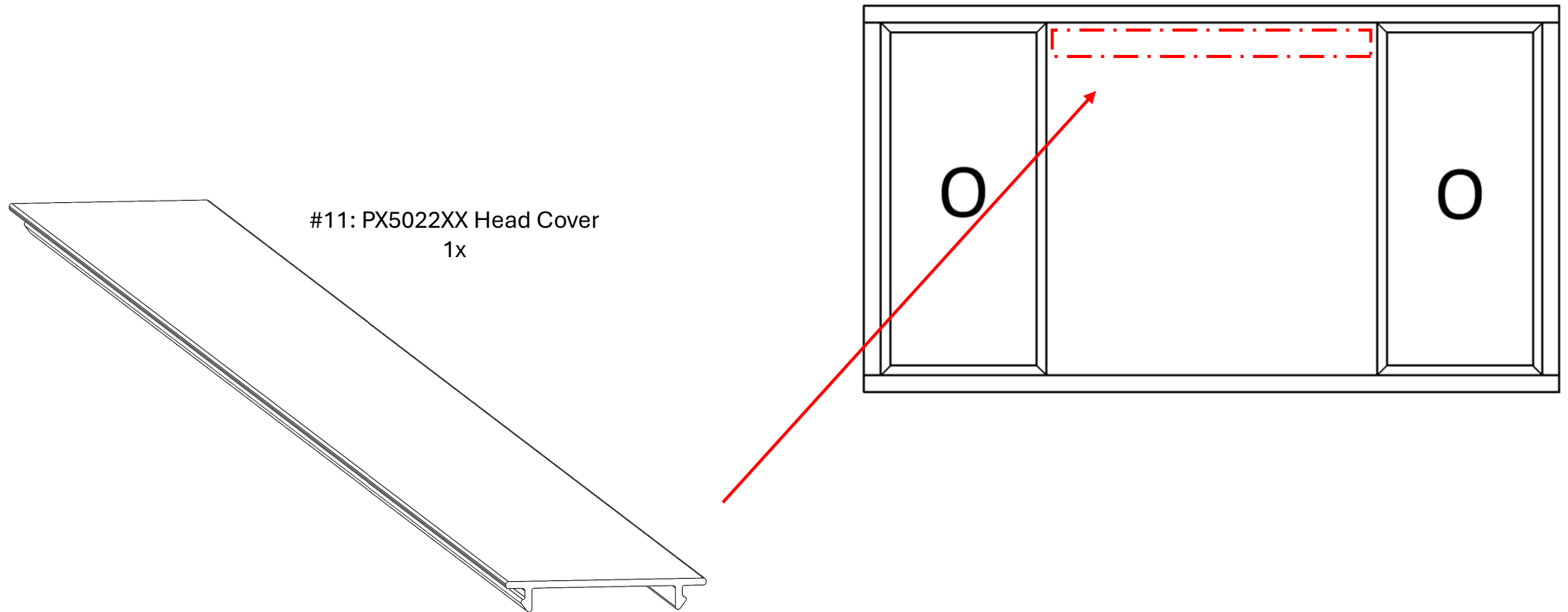
#16: FA8210SSXX #8 x 1/2 PH  
FH Self Drilling  
3x



**Note:** Diagram for 1 side shown. All pre-punched holes on this piece must be fastened to the jamb. Drill pilot holes as necessary for middle fixed jamb cover hole.

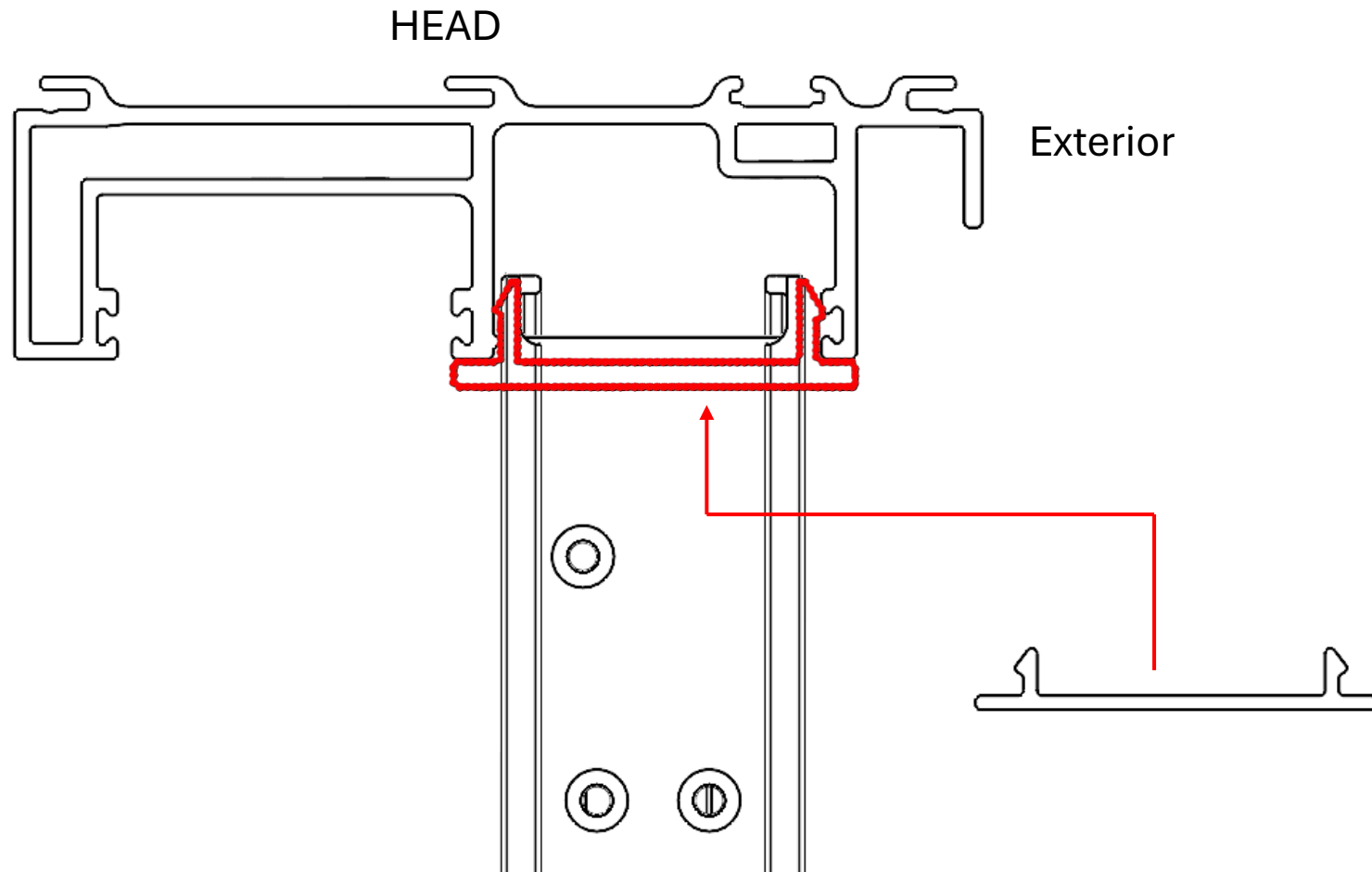
# C700 4 Panel SGD Field Panel Installation

## Step 7: Head Cover Installation



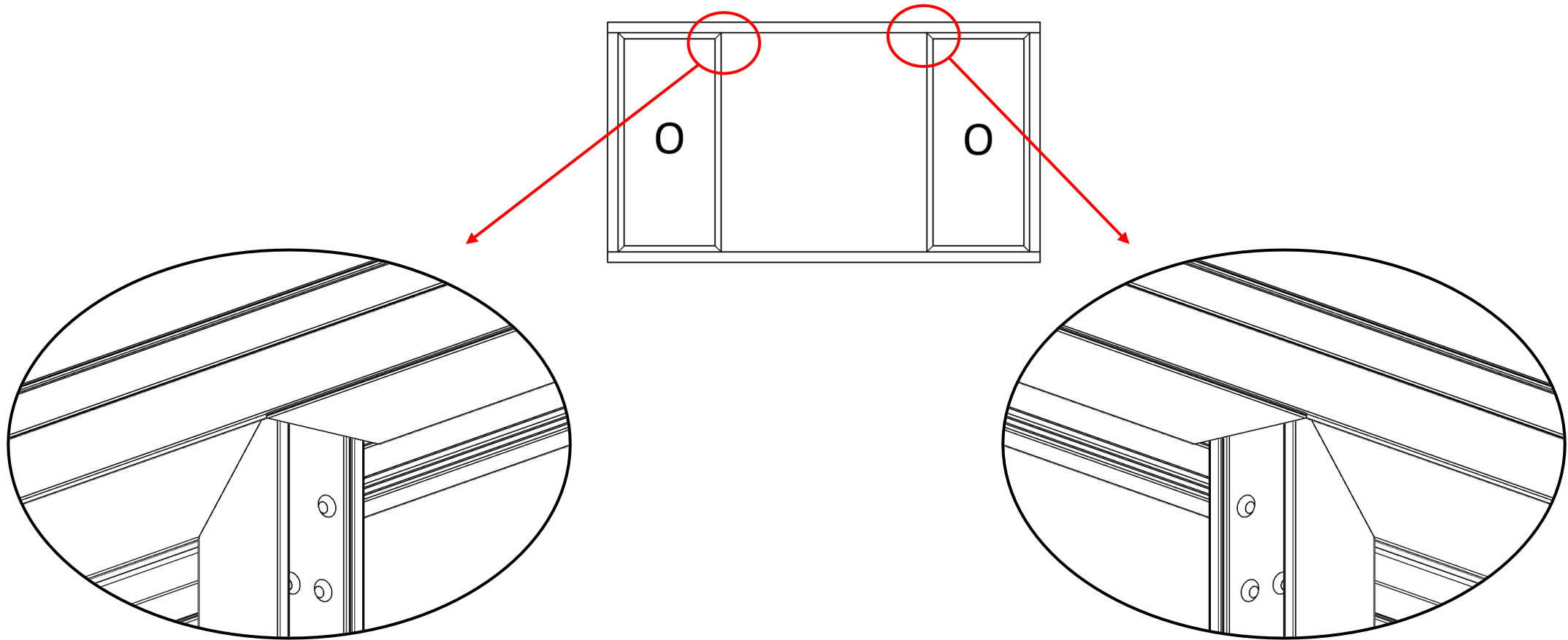
# C700 4 Panel SGD Field Panel Installation

## Step 7: Head Cover Installation



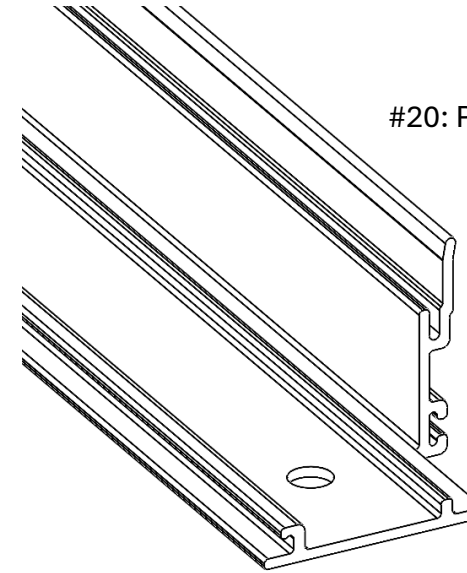
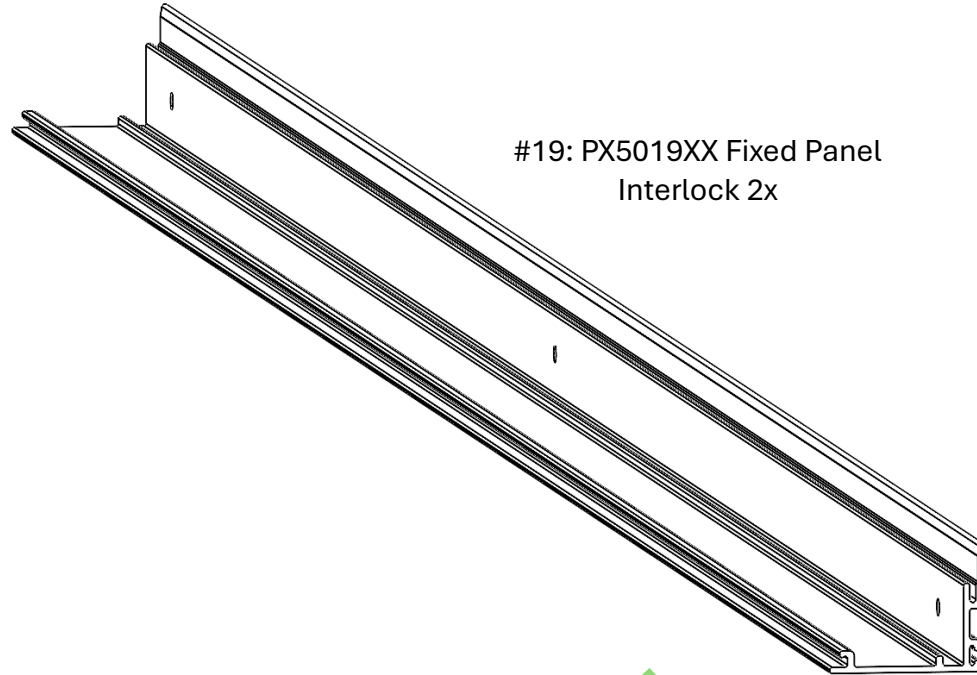
# C700 4 Panel SGD Field Panel Installation

## Step 7: Head Cover Installation



# C700 4 Panel SGD Field Panel Installation

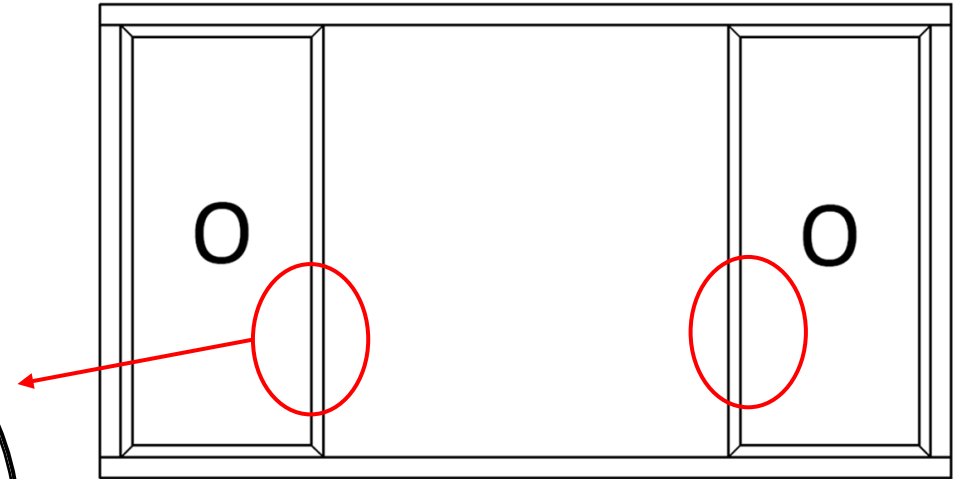
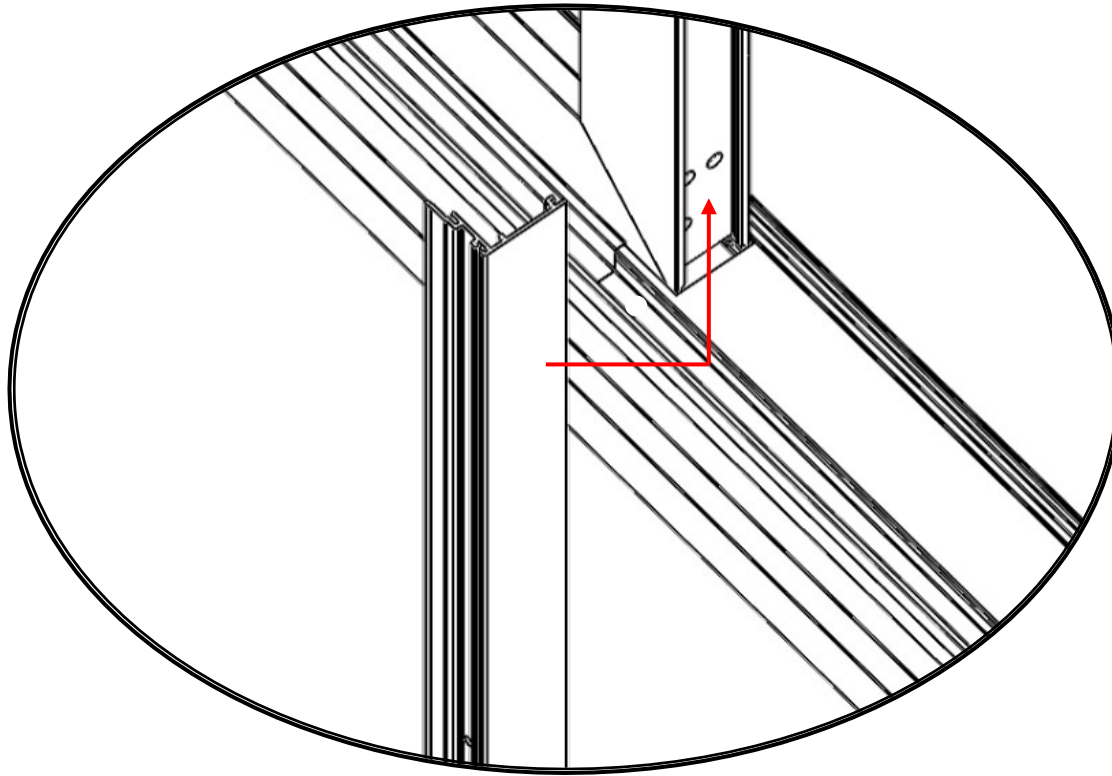
## Step 8: Fixed Panel Interlock Installation – Part Identification





# C700 4 Panel SGD Field Panel Installation

## Step 8: Fixed Panel Interlock Installation



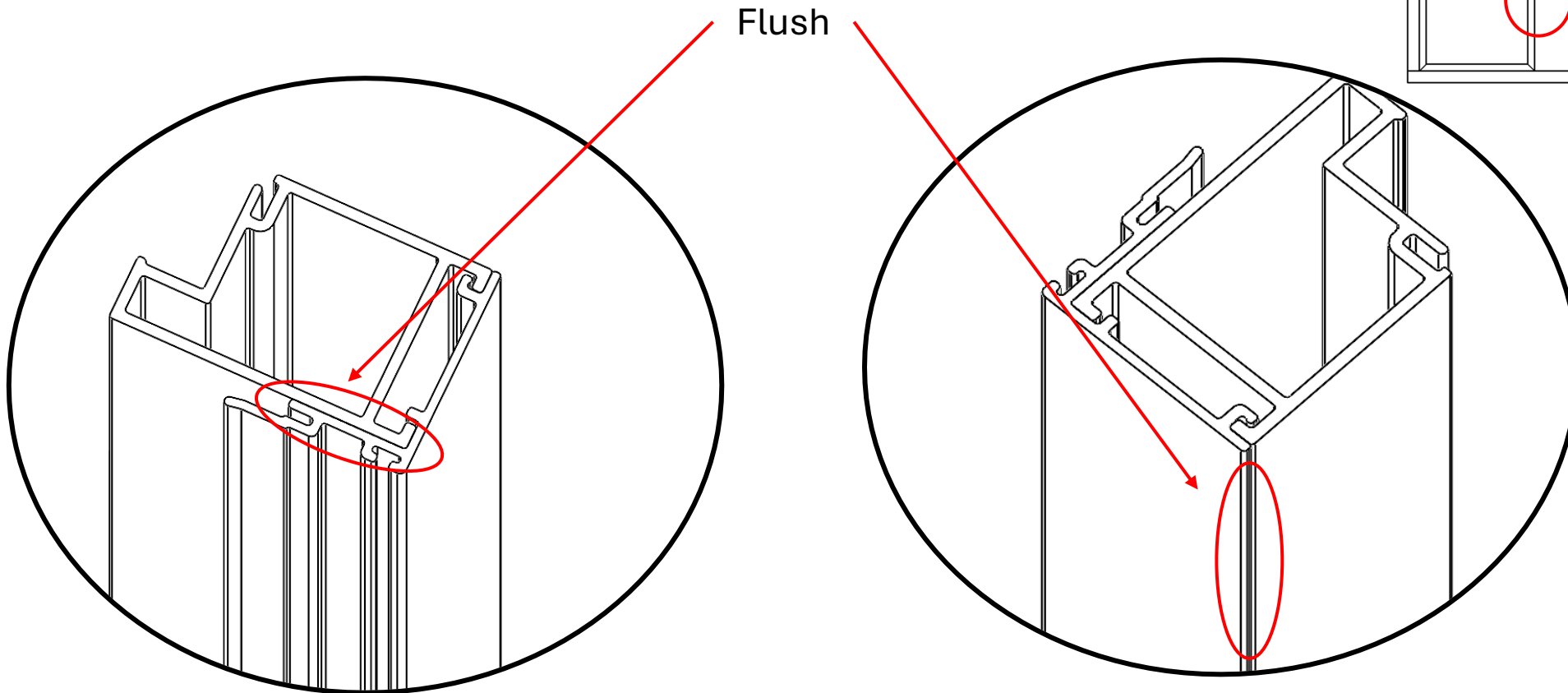
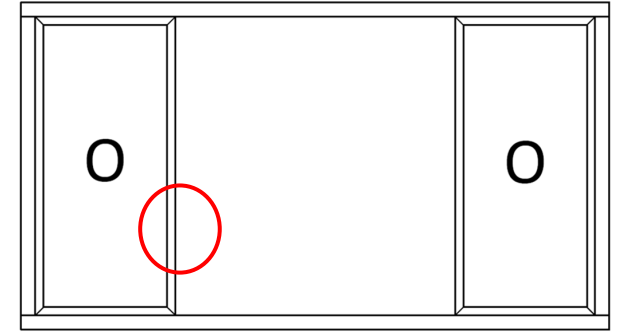
**Note:** Diagram for 1 side shown. Part must be installed as shown on both fixed panels. Diagram shows a shorter cross-section view of the interlock. Actual part is longer.

# C700 4 Panel SGD Field Panel Installation

## Step 8: Fixed Panel Interlock Installation

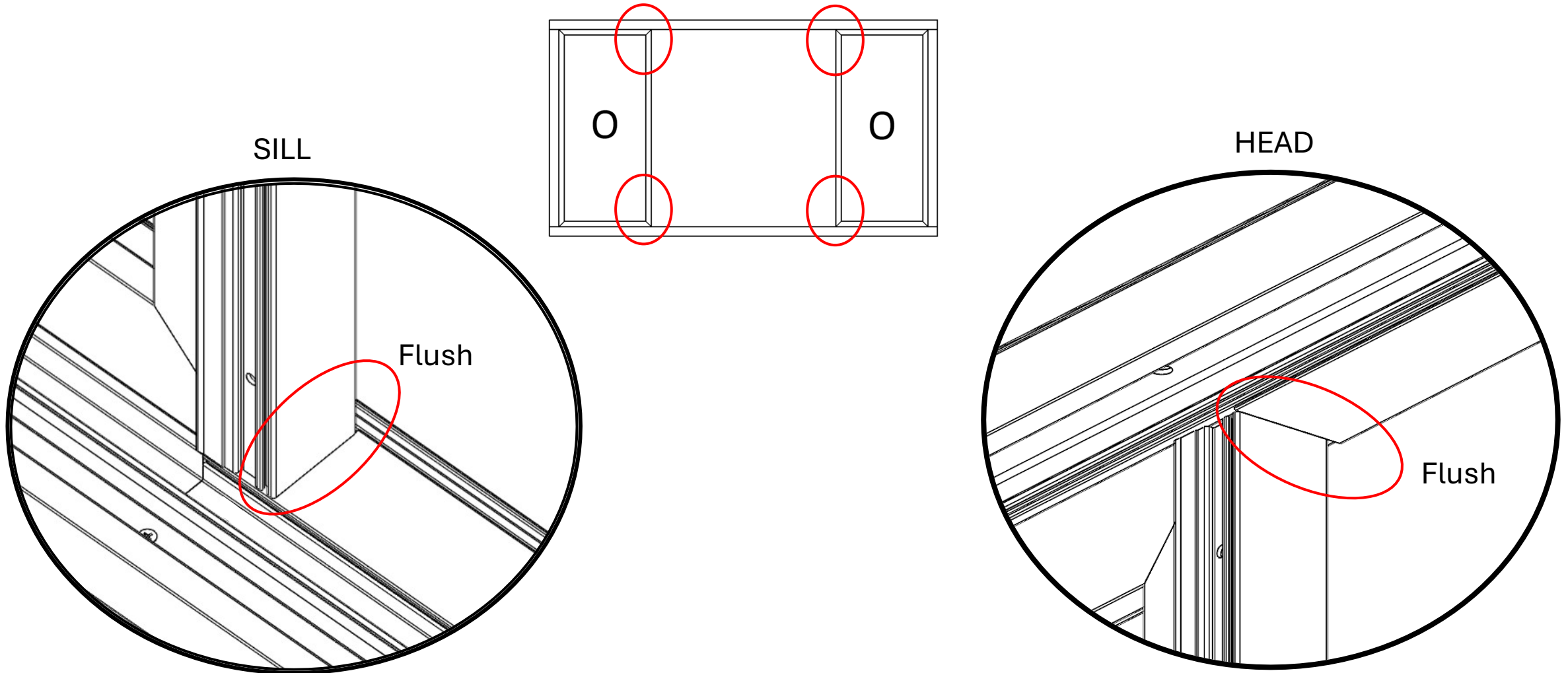


**Note:** Diagram for 1 side shown.  
Part must be installed as shown on  
both fixed panels.



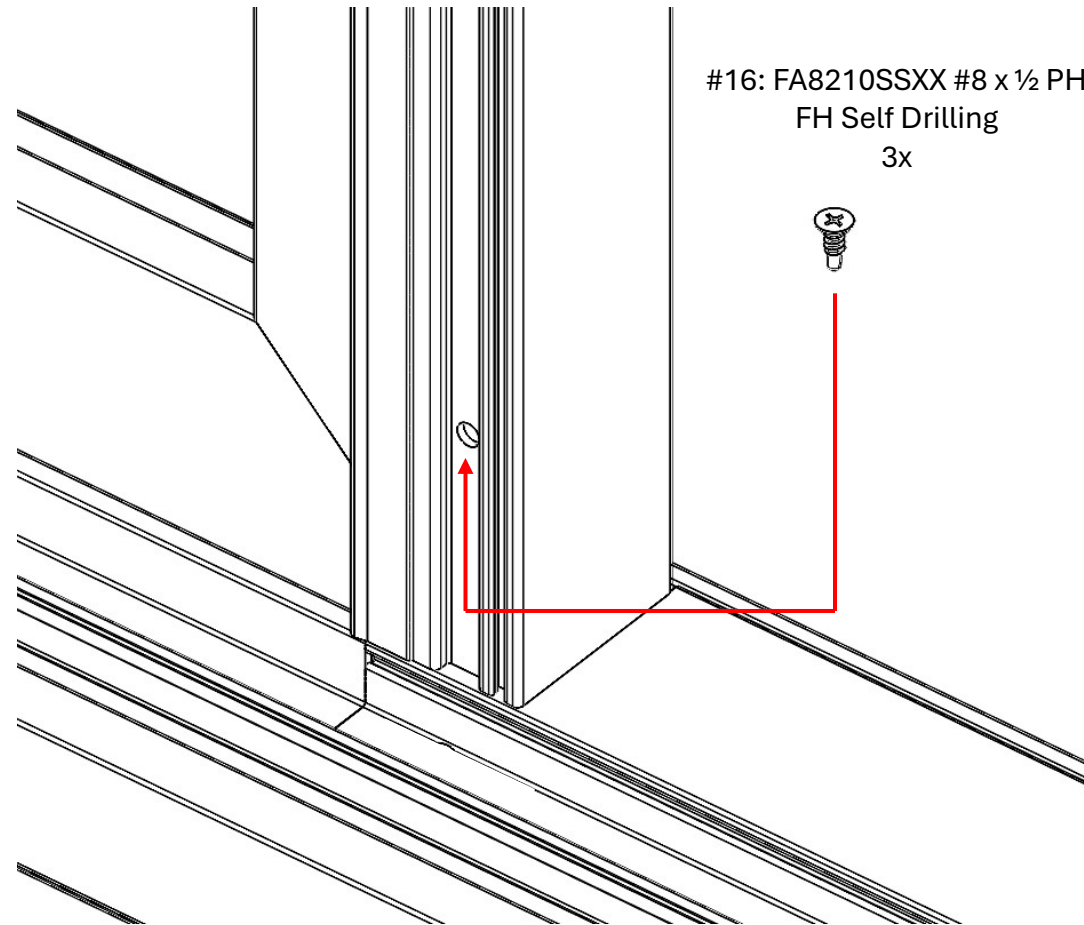
# C700 4 Panel SGD Field Panel Installation

## Step 8: Fixed Panel Interlock Installation



# C700 4 Panel SGD Field Panel Installation

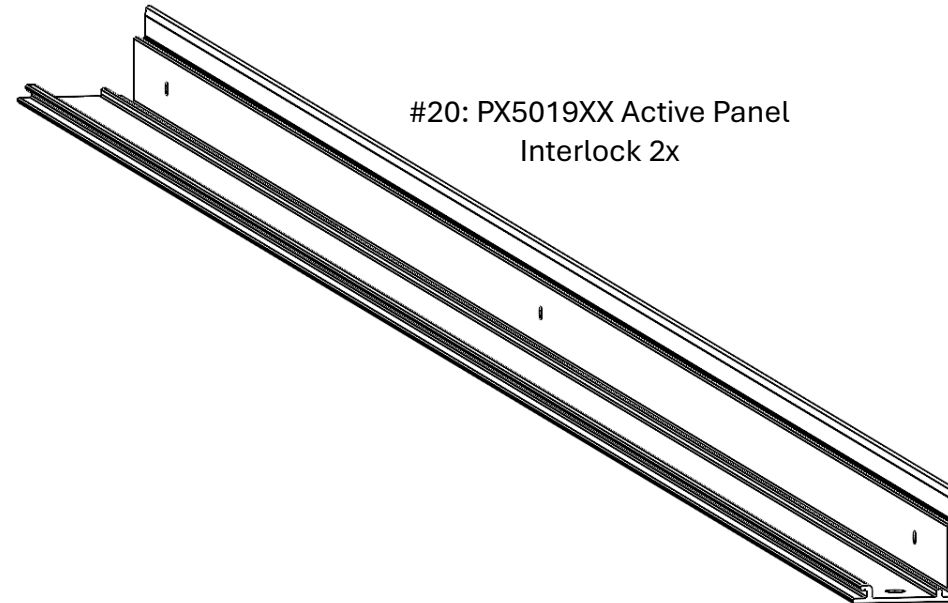
## Step 8: Fixed Panel Interlock Installation



**Note:** Diagram for 1 side shown. All pre-punched holes on this piece must be fastened to both fixed panels using screws.

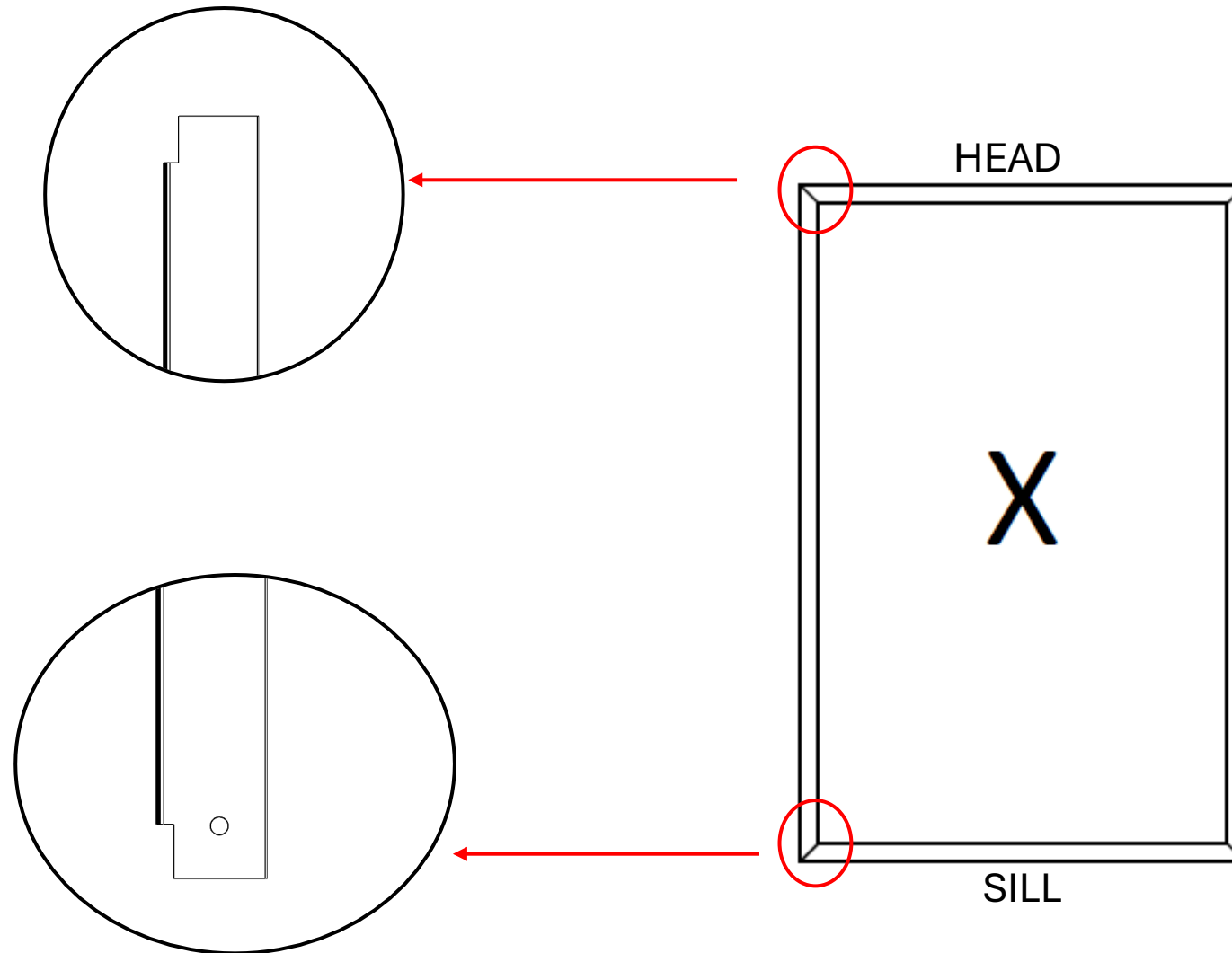
# C700 4 Panel SGD Field Panel Installation

## Step 9: Active Panel Interlock Installation



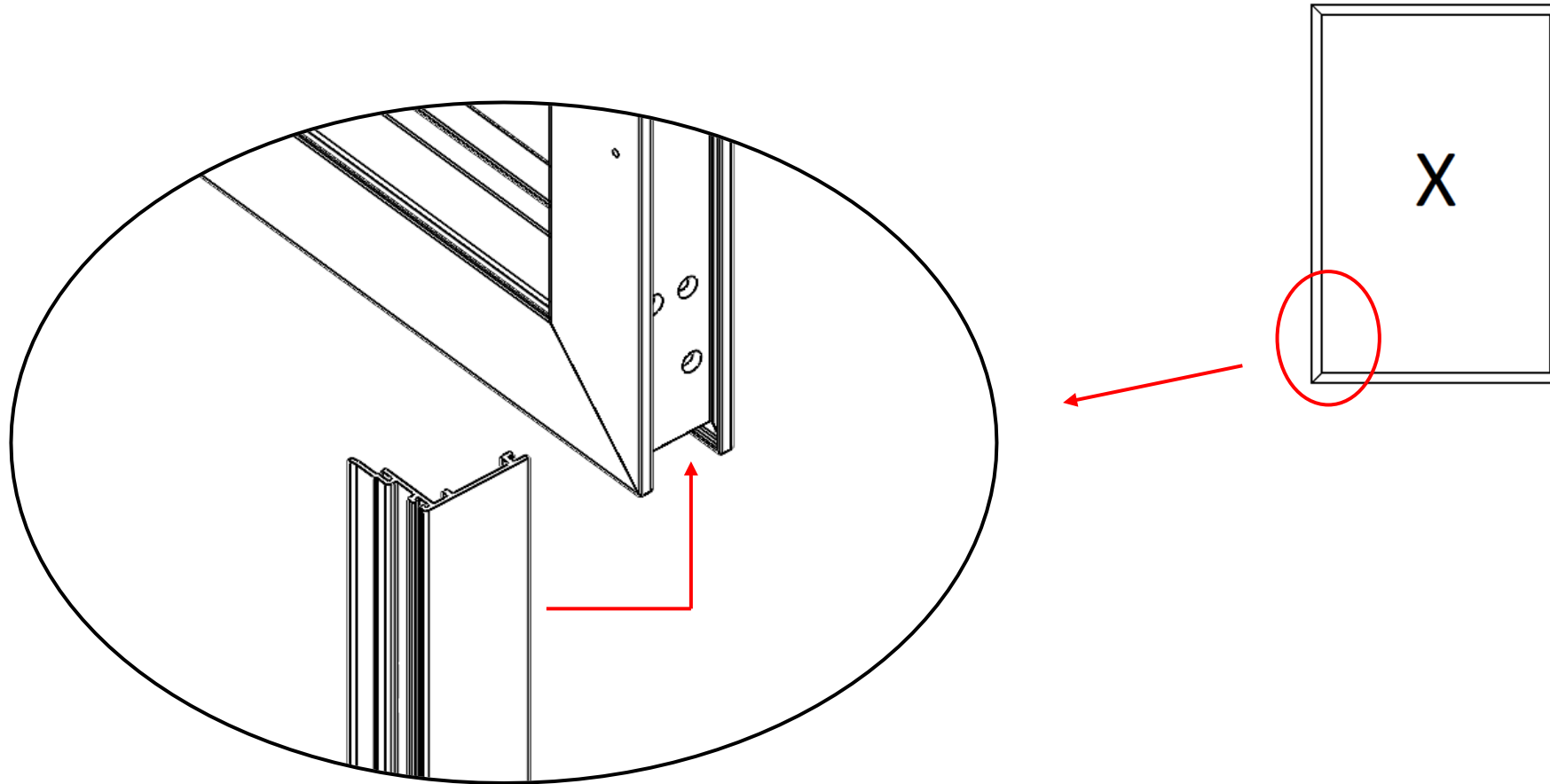
# C700 4 Panel SGD Field Panel Installation

## Step 9: Active Panel Interlock Installation



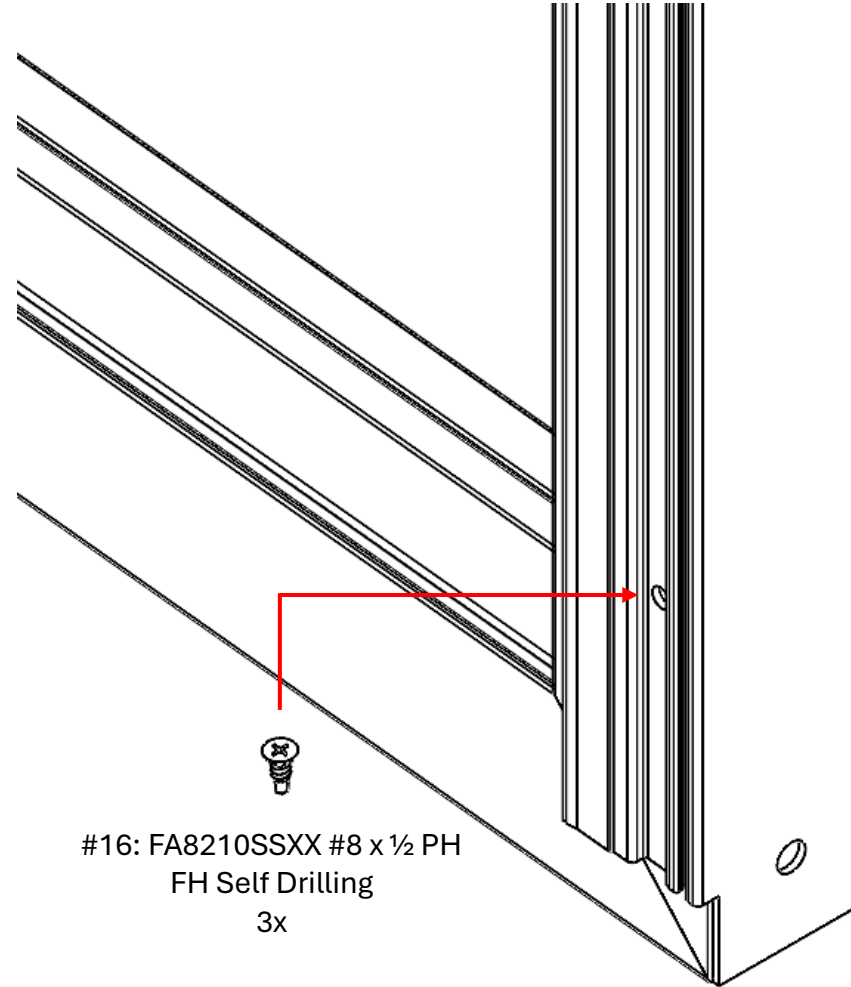
# C700 4 Panel SGD Field Panel Installation

## Step 9: Active Panel Interlock Installation



# C700 4 Panel SGD Field Panel Installation

## Step 9: Active Panel Interlock Installation



**Note:** Diagram for 1 side shown. All pre-punched holes on this piece must be fastened to both active and passive panels using screws.



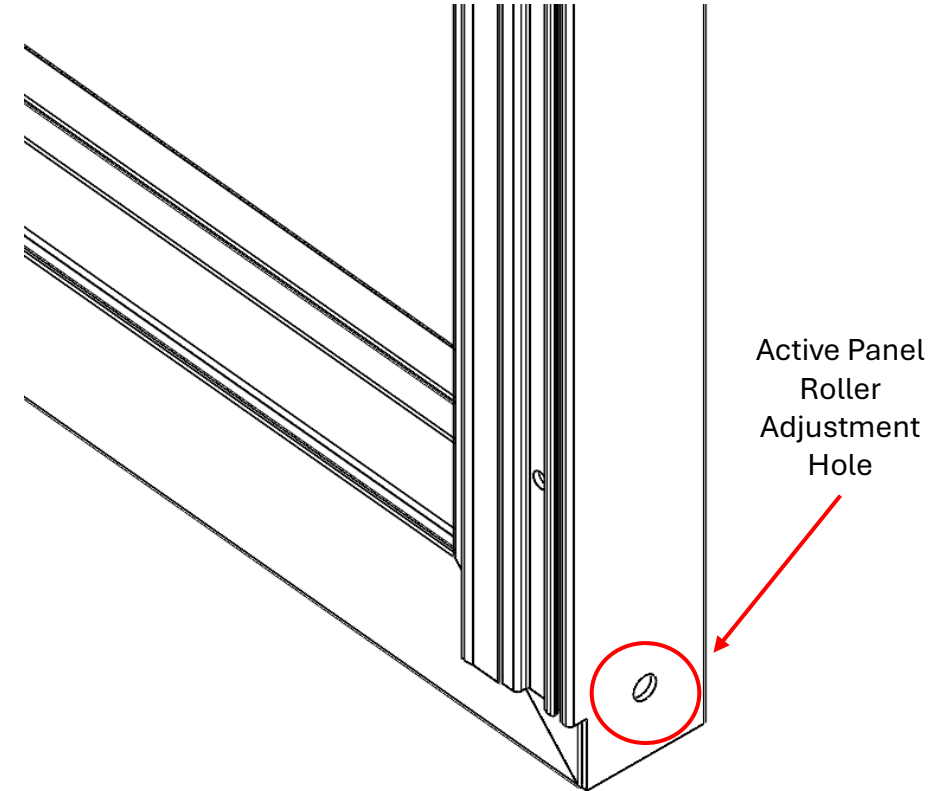
# C700 4 Panel SGD Field Panel Installation

## **Step 10: Active Panel Installation**

- Install the active and passive panel over the roller track by pushing panel diagonally into the head. *Ensure the glazing bead faces the exterior of the door.*
- Adjust rollers as necessary using a Phillips head screwdriver.

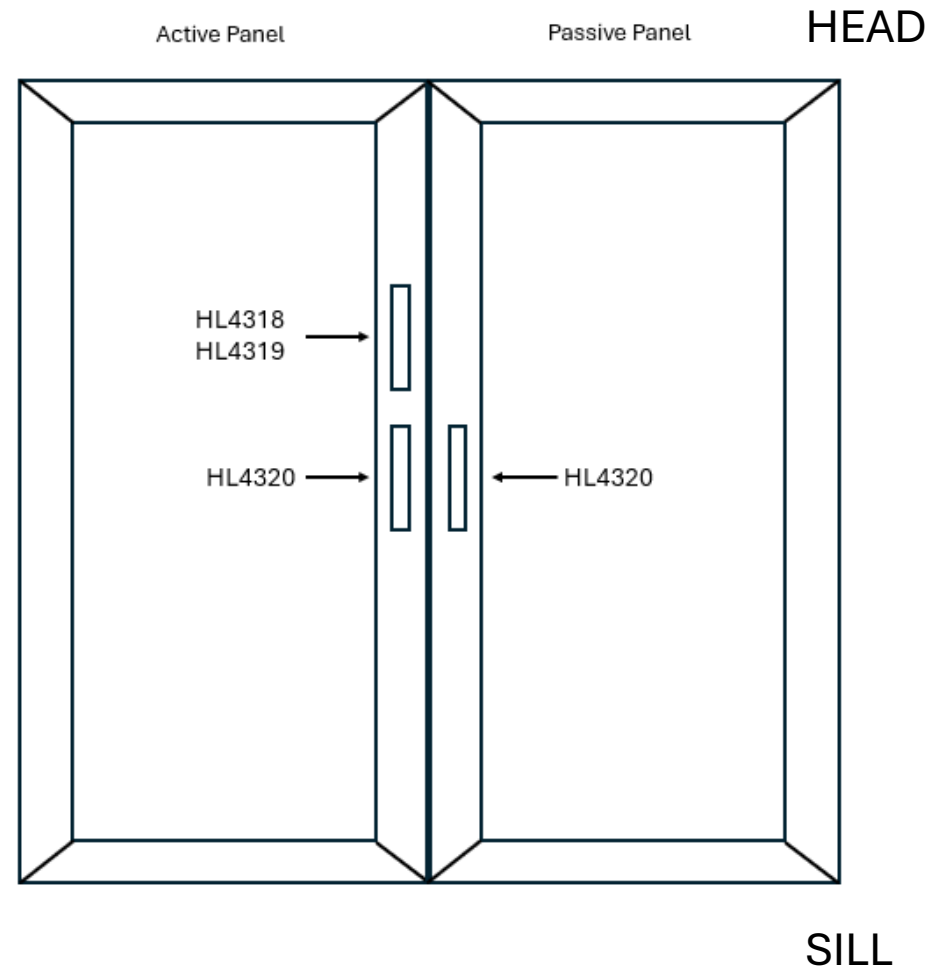
### **Handles:**

- Standard (Crest) Handle: Install handles using included instructions. Skip to Step 12.
- Flush (Invisio) Handle: Follow Step 11 for installation.



# C700 4 Panel SGD Field Panel Installation

## Step 11: Invisio Handle Installation



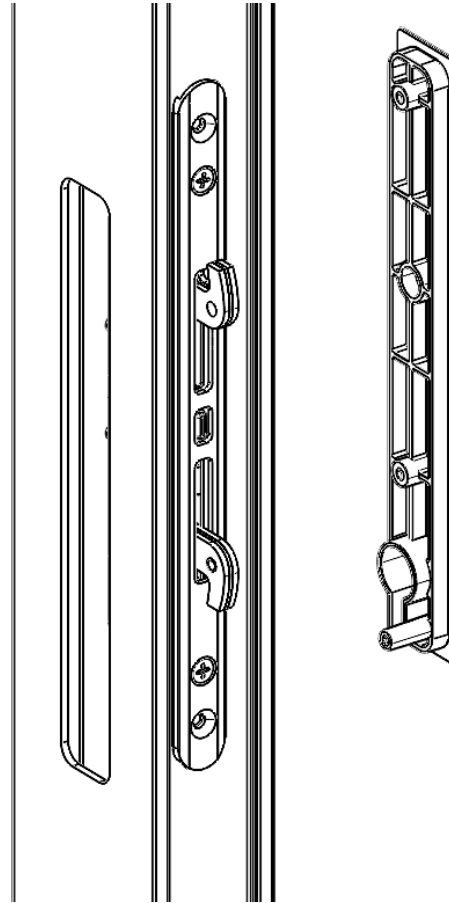
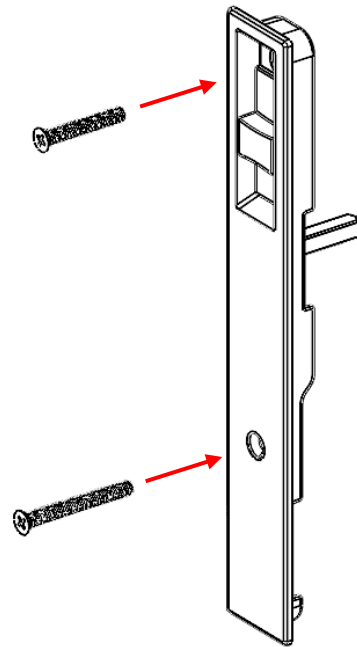
# C700 4 Panel SGD Field Panel Installation

## Step 11: Invisio Handle Installation – Mortise Latch



**Note:** Mortise latch plate fastens to the interior. Screw for mortise latch is shorter.

#26A/26B  
HA4318/HA4319

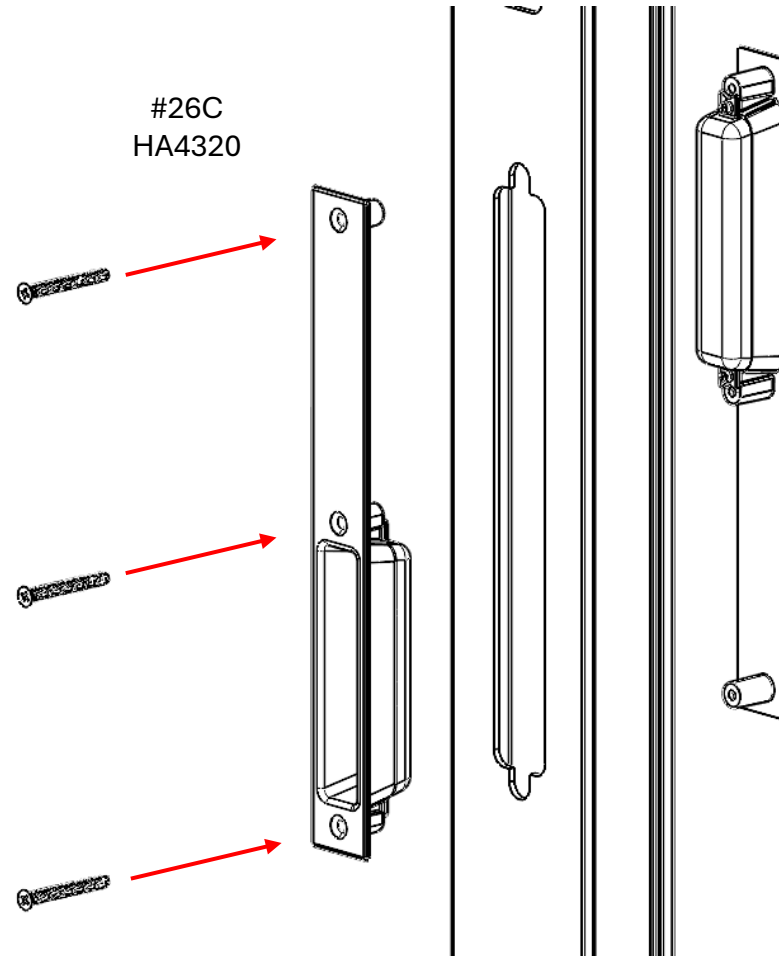


# C700 4 Panel SGD Field Panel Installation

## Step 11: Invisio Handle Installation – Bottom Handle



**Note:** Screws for the bottom handle go on the interior.

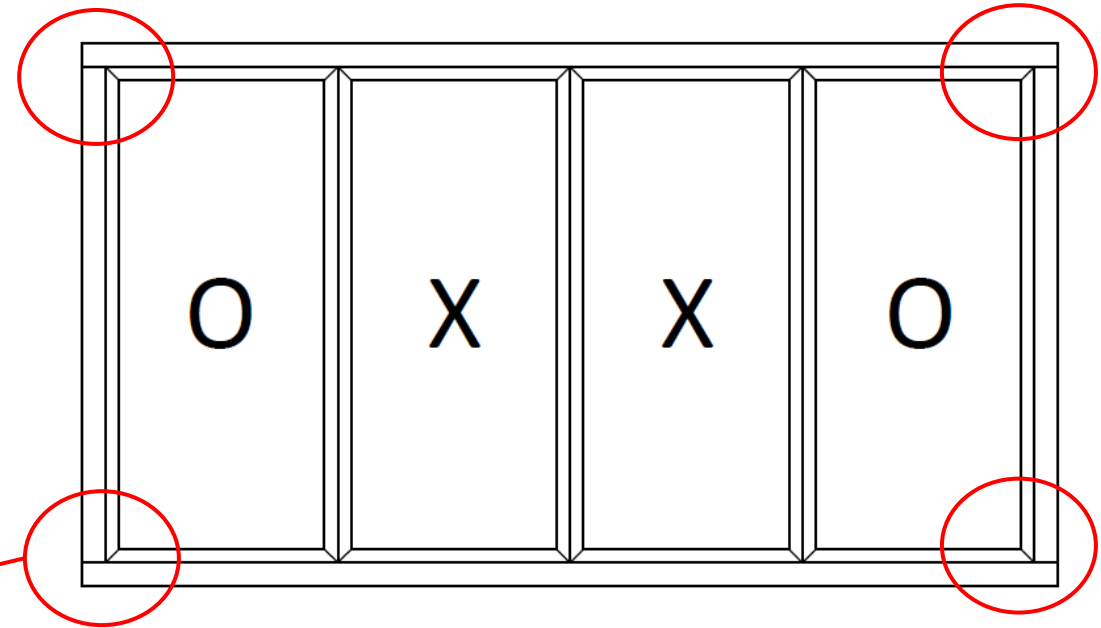
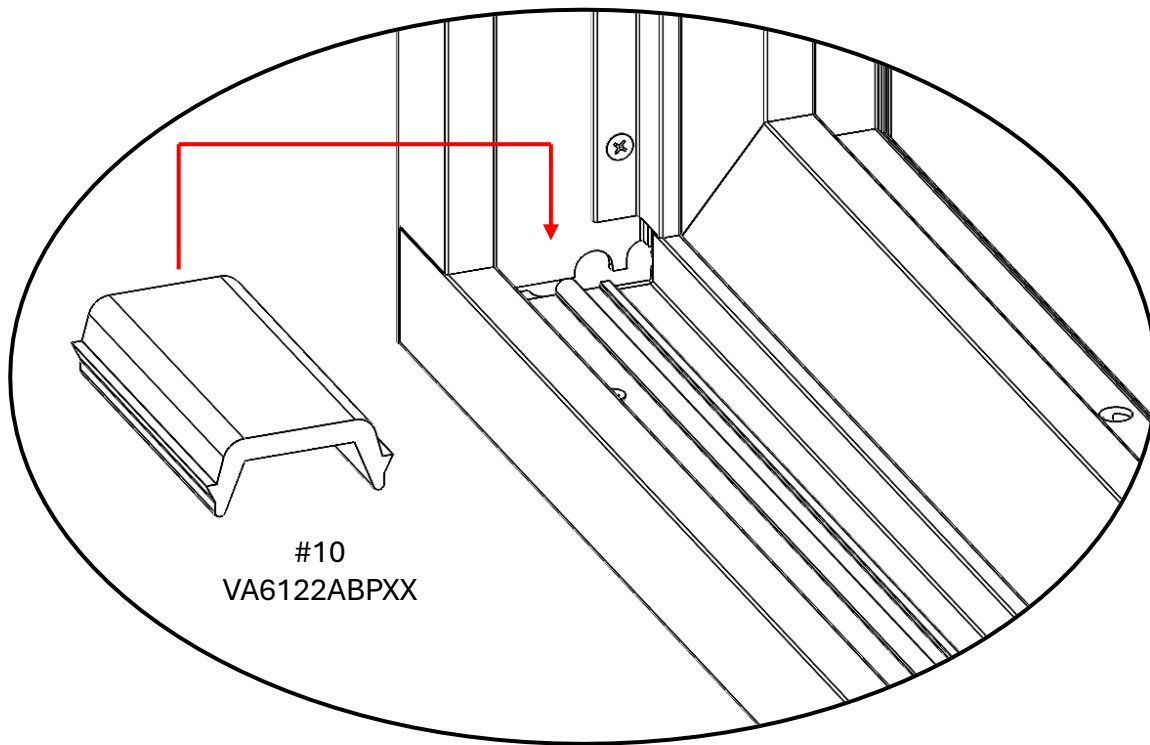


# C700 4 Panel SGD Field Panel Installation

## Step 12: Active Panel Installation - Door Stoppers



**Note:** Diagram for 1 side shown.  
Door stopper required on both head  
and sill.

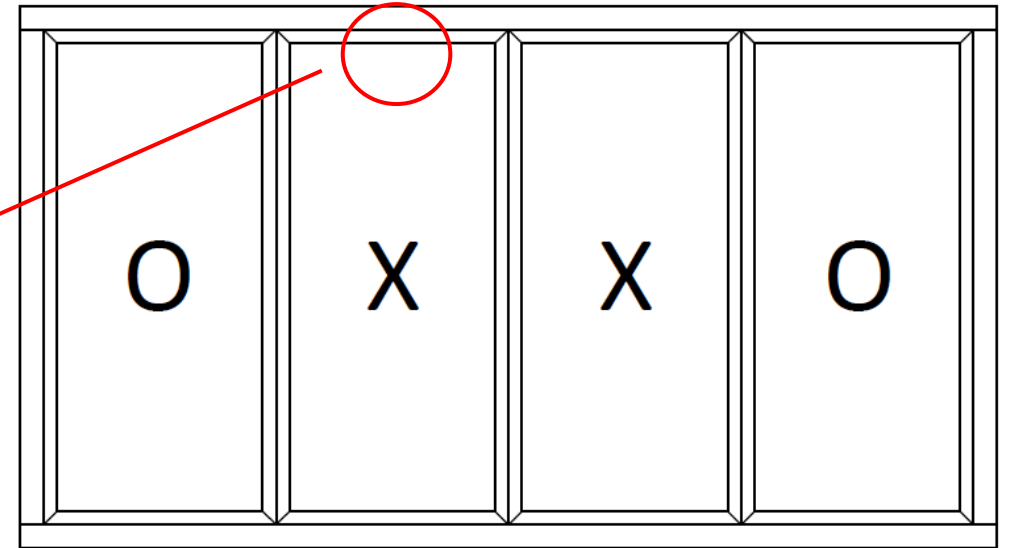
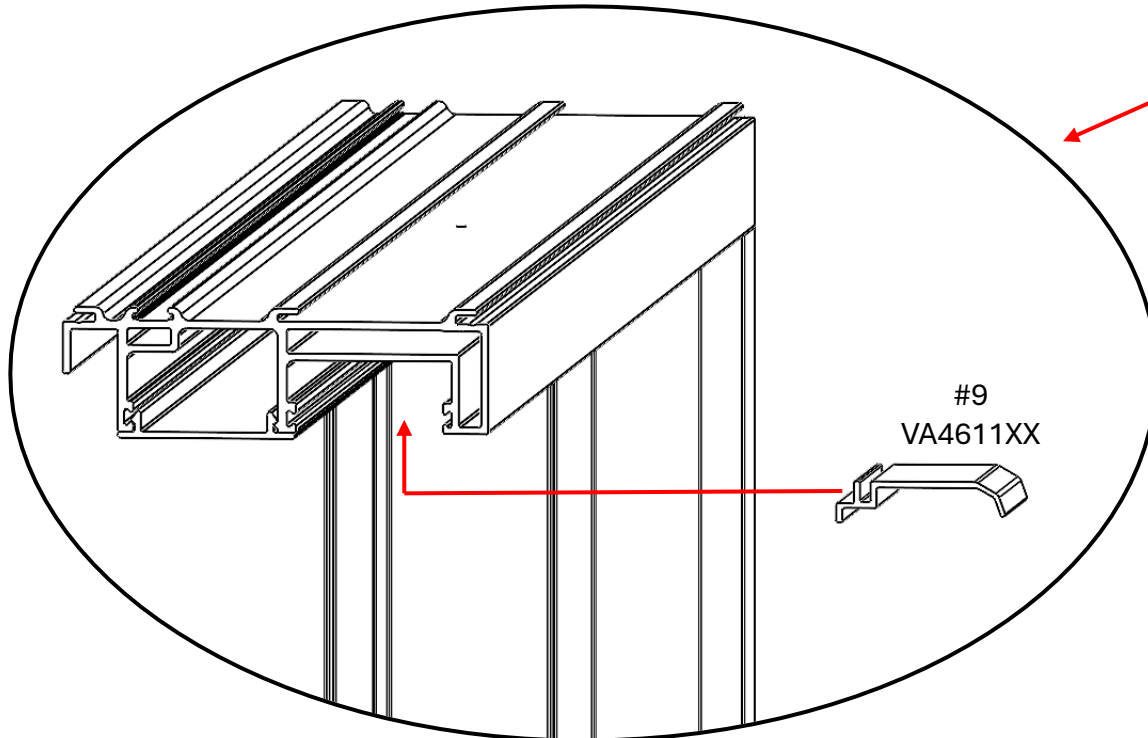


# C700 4 Panel SGD Field Panel Installation

## Step 13: Active Panel Installation – Anti Lift Clips



**Note:** Slide door open to install anti lift clips. Anti lifts required above both active and passive panels.



# C700 4 Panel SGD Field Panel Installation

## Step 13: Active Panel Installation – Anti Lift Clips



**Note:** Slide door open to install anti lift clips. Anti lifts required above both active and passive panels.

