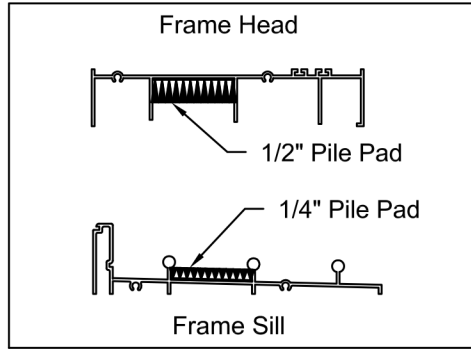


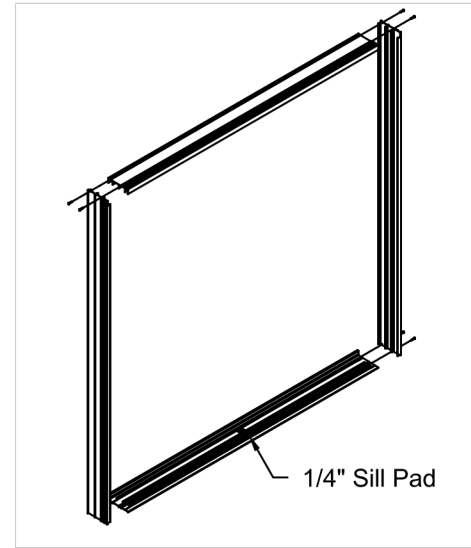
**SERIES 83  
2 PANEL  
PATIO DOOR  
INSTALLATION**

REV 3/2026

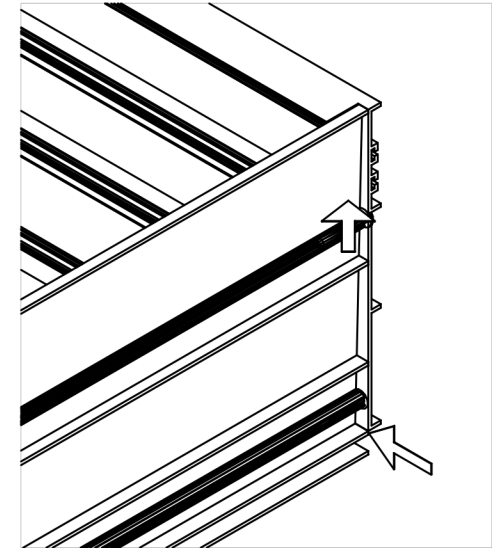


1. Install the 1/2" tall adhesive weather-strip pad in the center of the frame head between the vertical guides legs as shown above.
2. Install the 1/4" tall adhesive weather-strip pad in the center of the frame sill between the two roller tracks as shown above.

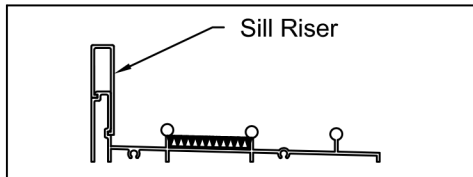
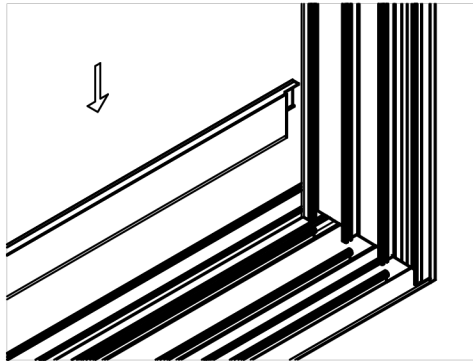
Note: The weatherstrip pads should be in line with the interlocks when the door is completely assembled.



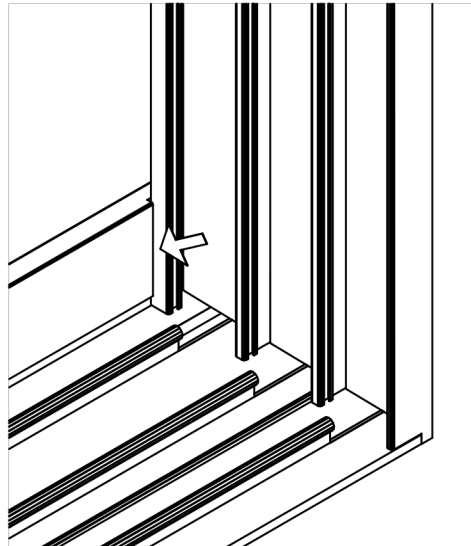
3. Assemble the door frame using the #8 X 1" zinc pan head screws (8).



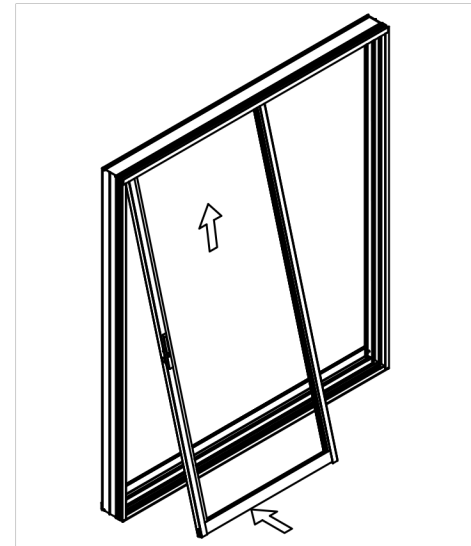
4. Caulk the bottom of the frame sill to jamb joint making sure all joints between sill and jamb are filled with sealant.
5. Install the frame in the opening per Alenco instruction detail 1-4780-1 (finless frame) or 1-4780-2 (nail fin version)



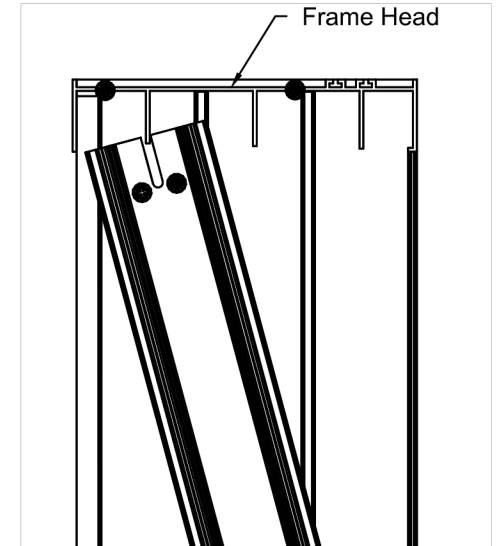
6. If the sill riser is required use a rubber mallet to drive it over the dam of the frame sill.



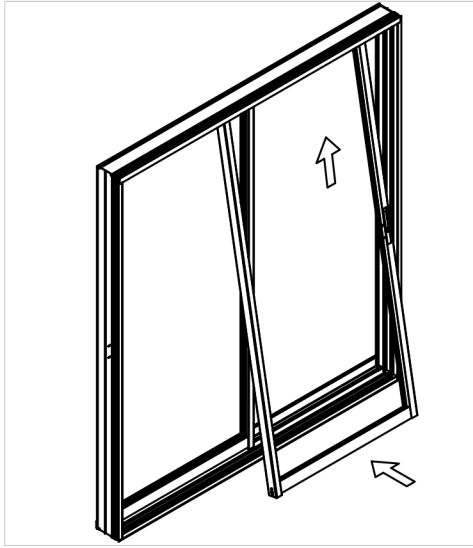
7. If the sill riser is added sealant must be applied from the top of the riser to jamb joint down to the frame sill.



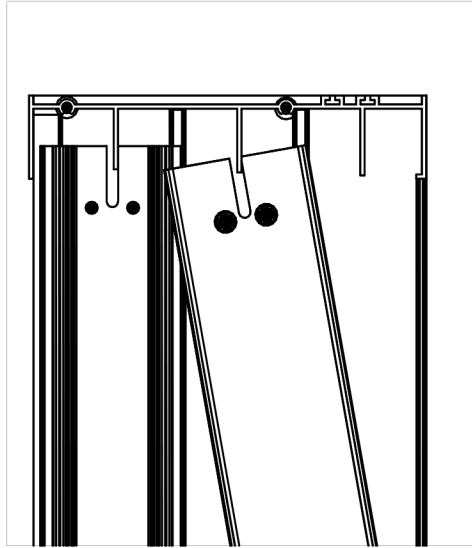
8. Install the inside vent first. The vent installs from the outside. Push the top of the vent up into the head and swing the bottom onto the sill.



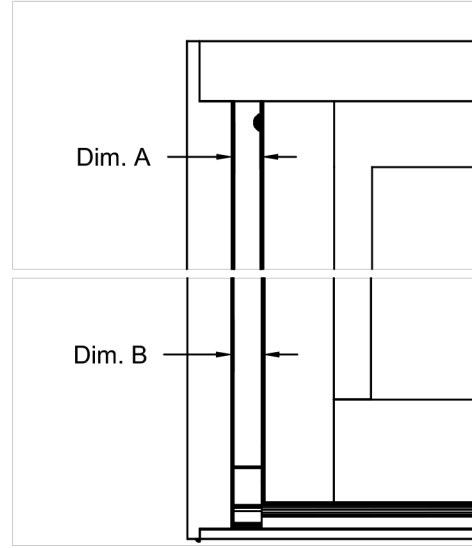
Note: The figure above shows the inside vent being inserted into the interior track.



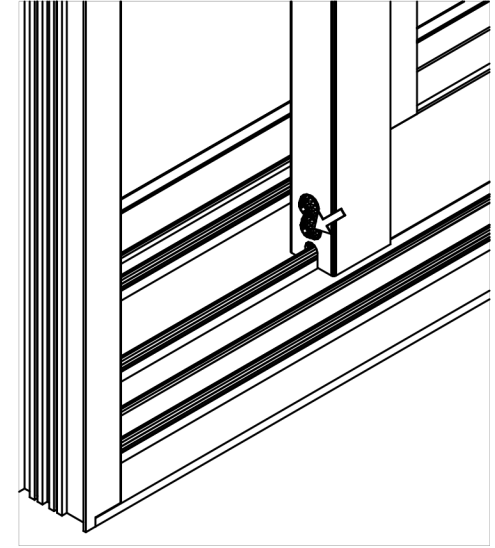
9. Install the outside vent next. This vent also installs from the outside. Push the top of the vent up into the head and swing the bottom onto the sill.



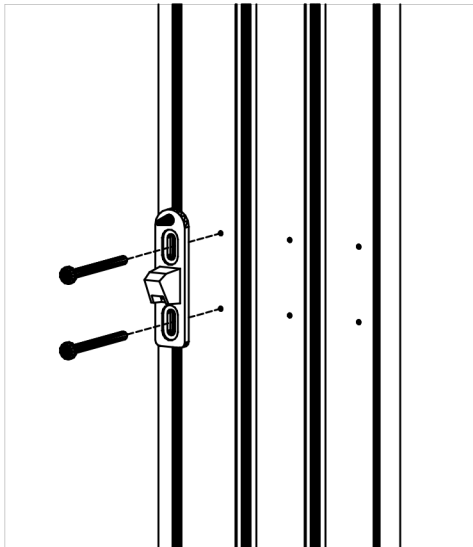
Note: The figure above shows the outside vent being inserted into the center track.



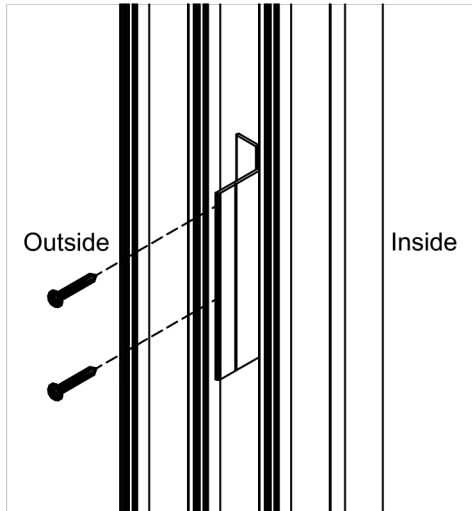
10. Move a vent up to the frame and measure the gap at the head and at the sill. (Dim. A and Dim. B)



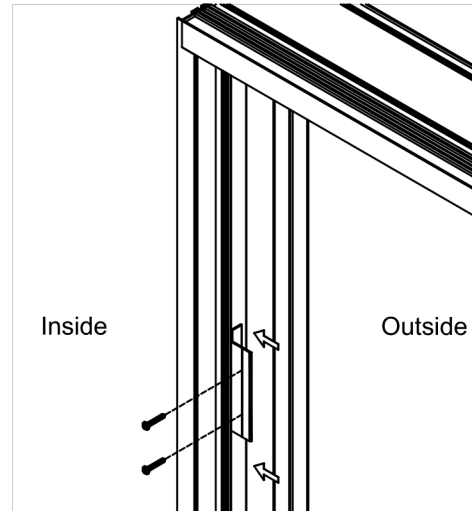
11. Use the roller height adjustment screws to raise and lower either end of the vent until Dim. A and Dim. B are equal. Repeat steps 10 and 11 for the other vent.



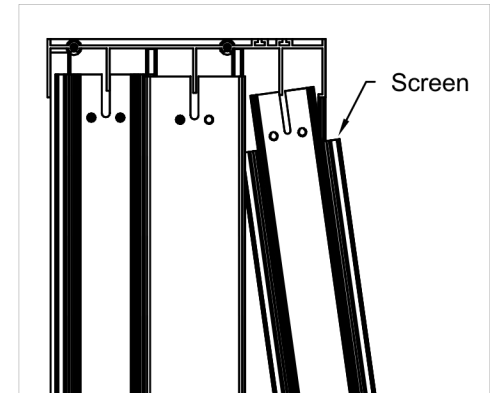
12. Install the keepers in the frame jambs using the predrilled holes as shown above. Attach using the 1" long phil pan head screws and be sure to place a shim behind the jamb at each keeper location. Adjust the keeper vertically until the throw of the lock fully engages the keeper.



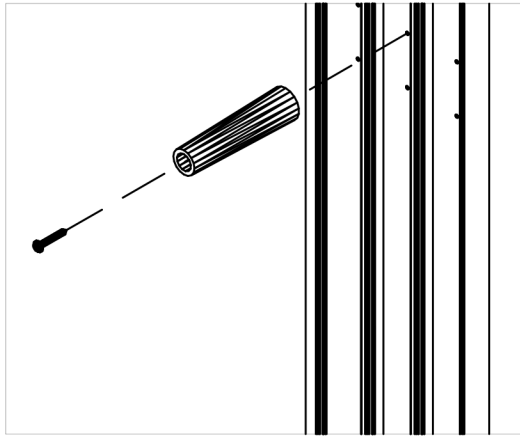
13. Install two O-Panel Clips in the frame jamb as shown. Space the clips approximately 1/4 of the door height down from the head and 1/4 of the door height up from the sill. Use 2 #8 X 1" self drilling screws per clip.



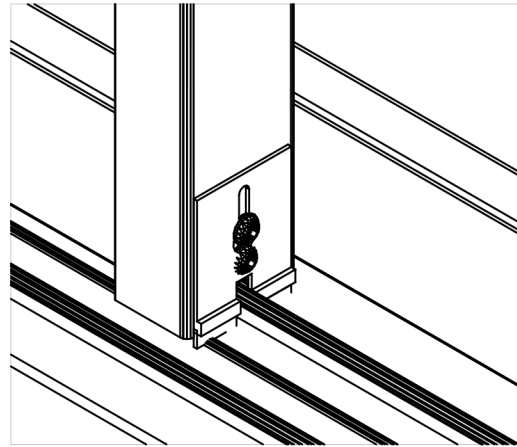
14. Complete the O-Panel installation by inserting the panel into the frame jamb and attaching the clip to the panel using 2 #8 X 1" self drilling screws per clip.



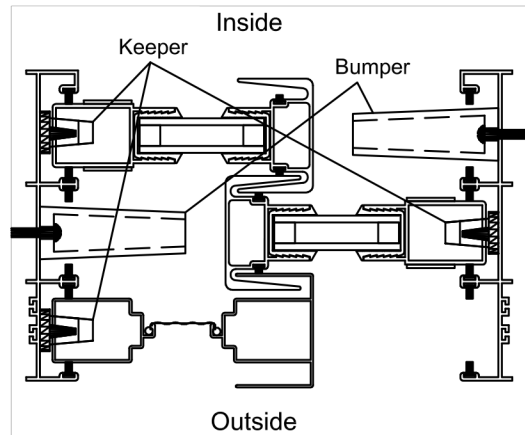
15. Install the screen from the outside so that it operates the same direction as the interior vent of an XX door or the same direction as the operating panel of an XO or OX door. To install the screen push the top of the vent up into the outer most track of the head (as shown above) and swing the bottom onto the sill. Adjust the screen just as you did the vents in steps 10 and 11 and then install the keeper as shown in step 12. Note: screen latch may need to be reversed.



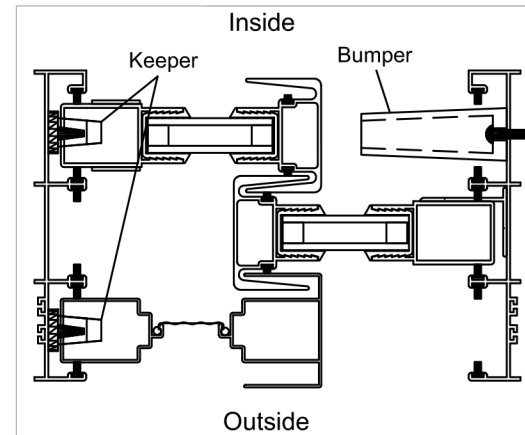
16. Install the frame bumpers in the jamb track opposite operating vents with #8 x 1" self drilling screws.



17. Optional: Add bug sweeps at bottom of interlocks. Back out the bottom panel assembly screw 2-3 turns or enough to slip bug sweep over head of screw and slide behind screw. Adjust and tighten screw.



Note: Above picture shows bumper and keeper locations for XX door.



Note: Above picture shows bumper and keeper locations for XO door (OX opposite).