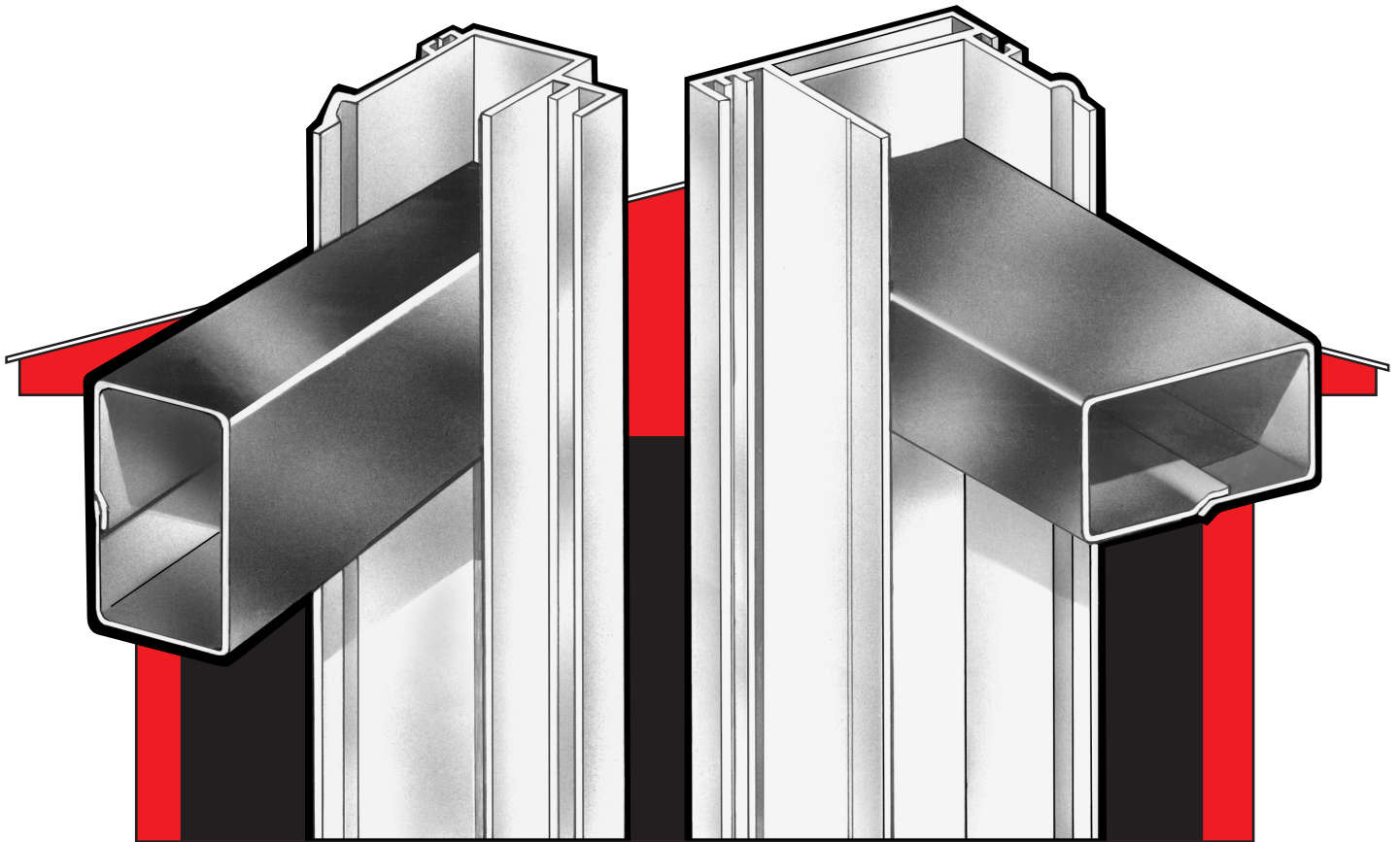


How to assemble and install PLYCO Slide Door Rails

for 1½" and 3½" wood/metal and
all metal framed sliding doors



PLYCO Slide Door Rails bring you . . .

- **Extra Door Strength**

Strong, extruded-aluminum verticals combine with 20-gauge, galvanized-steel box girts to increase overall door strength.

- **Attractive Appearance**

Durable, pre-finish white aluminum verticals and bottom rails provide long, maintenance-free life.

- **Design Compatibility**

Extra leg in "J" trim hides cut metal. Extra deep and extra wide nail/screw groove hides almost any fastener.

- **Energy Efficient**

Optional, vinyl weather strip on the verticals wipe against the jambs to seal the opening from outside weather.

How to assemble PLYCO No. SDR1600AV 1½" Aluminum Vertical Rails with 2" x 4" or 2" x 6" wood girts and No. SDR1600AB Bottom Rail over 2" x 6" wood girt.

1. Cut two vertical rails to required heights, allowing ¾" to 1" for overlap of the door opening at the top. Vertical rails should be 3" shorter than the overall door height to allow for the aluminum bottom rail.

2. Cut the required number of girts to correct widths. Suggest doors overlap jambs 1½" on each side; 2½" if Combo No. 190500 Keeper-Stoppers are used. Use a 2" x 6" for the bottom girt. Recommended girt spacing is 24" on centers for 2" x 4"s; 30" on centers for 2" x 6"s. Drill top girt for mounting trolley hangers.

3. Lay vertical rails with J-trim facing down on a flat, even surface and insert all girts into the verticals, as shown in Figure 1. Allow the 2" x 6" bottom girt to drop 3" below the verticals for mounting the aluminum bottom rail.

4. Attach the vertical rails to the girts by using one 1½" nail at each joint.

5. Diagonally square the door frame, as shown in Figure 2. Adjust as needed and secure with a second 1½" nail at each joint.

6. Turn frame over, re-square, and secure with one 1½" nail at each joint. Completed assembly will have two 1½" nails in the back and one 1½" nail in the front at each joint.

7. Using a skill saw or snips, notch the aluminum bottom rail for mating with the vertical rails, as shown in Figure 3. Attach the aluminum bottom rail to the 2" x 6" bottom girt with nails driven up through the bottom and above the stiffener.

8. Apply skin, install trolley hangers, door hardware and optional weather stripping (See Figure 4). Hang door(s) on building, as explained on the back page.

9. For double or split slide doors, substitute one No. SDR1600HV "H" Vertical Rail in place of No. SDR1600AV. No. SDR1600HC "H" Closure Rail may be used, if preferred. Allow for "H" rails when cutting door girts.

How to assemble PLYCO No. SDR1600AV 1½" Aluminum Vertical Rails with No. SDR1635BG 1½" x 3½" Steel Box Girts, No. SDR1600WB Bottom Rail and No. SDR1000GZ Guide Rail.

1. Cut two vertical rails to required heights, allowing ¾" to 1" for overlap of the door opening at the top. Vertical rails should be 1½" shorter than the overall door height to allow for the bottom rail.

2. Cut the required number of girts to correct widths. Suggest doors overlap jambs 1½" on each side; 2½" if Combo No. 190500 Keeper-Stoppers are used. Recommended girt spacing is 24" to 30" on centers. Cut the bottom rail to the same width as the girts. Drill the top girt for mounting trolley hangers.

3. Lay vertical rails with J-trim facing down on a flat, even surface and insert all girts and bottom rail into the verticals, as shown in Figure 1. Face the bottom rail stiffener downward to fit against the J-trim on the verticals, as shown in Figure 5.

4. Attach the vertical rails to the girts and bottom rail using on 1" TEK screw at each joint.

5. Diagonally square the door frame, as shown in Figure 2. Adjust as needed and insert a second 1" TEK screw at each joint.

6. Turn frame over, re-square and secure the front of the verticals to the girts with one 1" TEK screw at each joint. Completed assembly will have two 1" TEK screws in back and one 1" TEK screw in front at each joint. **Note:** If the flat of the steel skin is to be inserted into the small J-trim (Figure 4), attachment of the front screws should be delayed until after the skin is installed.

7. Apply skin, install trolley hangers, door hardware and optional weather stripping (Figure 4). Hang door(s) on building, as explained on the back page.

8. Install the bottom guide rail, as explained on the back page.

9. For double or split slide doors, substitute one No. SDR1600HV "H" Vertical Rail in place of No. SDR1600AV. No. SDR1600HC "H" Closure Rail may be used, if preferred. Allow for "H" rails when cutting door girts.

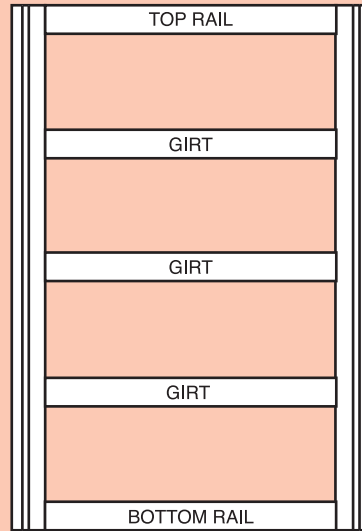


Figure 1. Always lay vertical rails and girts out on a flat, even surface for assembly. A bow or warp built into the door during construction will not disappear when it's hung.

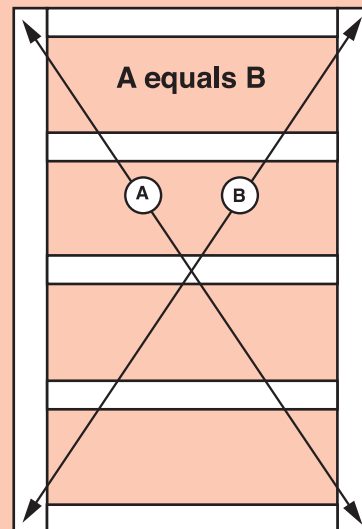


Figure 2. Square each door leaf by stretching a measuring tape diagonally, as shown, so that the lengths are the same both ways.

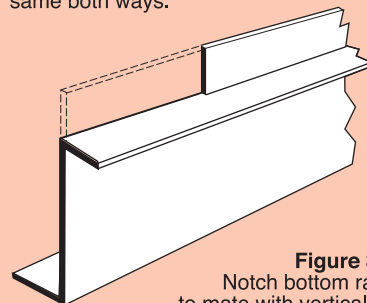


Figure 3.
Notch bottom rail
to mate with verticals.

How to assemble PLYCO No. SDR1635BV 3 1/2" Aluminum Vertical Rails with 2" x 4" wood girts and Combo Bottom Door Guide System.

1. Cut two vertical rails to required heights, allowing 3/4" to 1" overlap of the door opening at the top. Verticals should be 1 1/2" shorter than the overall door height to allow for the bottom rail.

2. Cut the required number of girts to correct widths. Suggest doors overlap jambs 1 1/2" on each side; 2 1/2" if Combo No. 190500 Keeper-Stoppers are used. Recommended girt spacing is 24" on centers. **Note:** Overall door width will be 1 1/2" wider than girts, due to box extrusions in the vertical rails (Figure 6).

3. Construct top rail by sandwiching together one 2" x 6" and one 2" x 4" with a 1/2" plywood spacer, as shown in Figure 7. Cut to same width as girts. Drill the 2" x 6" for mounting trolley hangers.

4. Lay the vertical rails with J-trim facing down on a flat, even surface and insert all girts into the verticals, as shown in Figure 1. Insert the top rail so that the 2" x 6", which is drilled for mounting the trolley hangers, will be on the inside of the door. Attach the vertical rails to the girts with one 3" nail at each joint.

5. Diagonally square the door frame, as shown in Figure 2. Adjust as needed and secure with a second 3" nail at each joint.

6. Turn frame over, re-square, and secure the front side of the verticals to the girts with one 3" nail at each joint. Completed assembly will have two 3" nails in the back and one 3" nail in the front at each joint.

7. Attach Combo No. 153500 Bottom Rail to bottom girt, using nails or screws in all four fastener holes provided in each bottom rail mounting bracket (Figure 9). **Note:** Bottom Rail may be spliced.

8. Apply skin, trolley hangers, door hardware and optional weather stripping (Figure 4). Hang door(s) on building, as explained on the back page.

9. Install bottom guide rail as explained on the back page.

10. For double or split slide doors, attach optional SDR1635BC Box Vertical Closure.

How to assemble PLYCO No. SDR1635BV 3 1/2" Aluminum Vertical Rails with No. SDR1635BG 3 1/2" x 1 1/2" Steel Box Girts, No. SDR1635BB Bottom Rail and No. SDR1000GZ Guide Rail.

1. Cut two vertical rails to required heights, allowing 3/4" to 1" overlap of the door opening at the top. Verticals should be 2" shorter than the overall door height to allow for the bottom rail.

2. Cut required number of girts and bottom rail to correct widths. Suggest doors overlap jambs 1 1/2" on each side; 2 1/2" if Combo No. 190500 Keeper-Stoppers are used. Recommended girt spacing is 24" to 30" on centers. **Note:** Overall door width will be 1 1/2" wider than girts, due to box extrusions in vertical rails (Figure 6).

3. Construct top rail by using two girts, one on top of the other (Figure 8), and drill for mounting trolley hangers. **Note:** Locate trolley mounting holes 3/4" in from rear of top rail, and attach Combo No. 199000 Trolley Support Plates under lower top rail.

4. Lay the vertical rails with J-trim facing down on a flat, even surface and insert top rail, girts and bottom rail into the verticals, as shown in Figure 1. Face the bottom rail stiffener downward to fit against the J-trim on the verticals (Figure 5).

5. Attach the vertical rails to the top rail, girts and bottom rail using one 1" TEK screw at each joint.

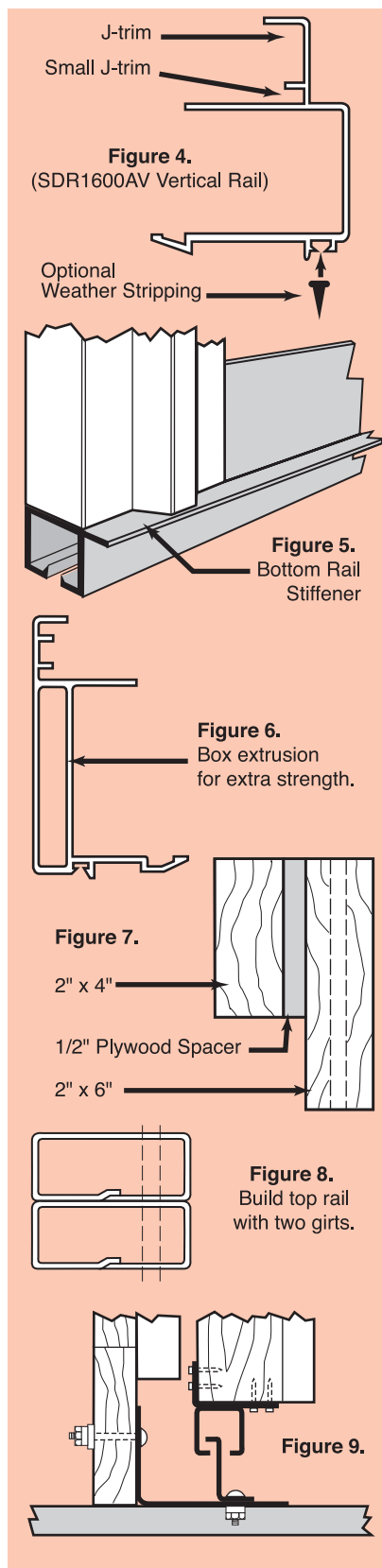
6. Diagonally square the door frame, as shown in Figure 2. Adjust as needed and insert a second 1" TEK screw at each joint.

7. Turn frame over, re-square and secure the front of the verticals to the girts with one 1" TEK screw at each joint. Completed assembly will have two 1" TEK screws in back and one 1" TEK screw in front at each joint. **Note:** If the flat of the steel skin is to be inserted into the small J-trim (Figure 4), attachment of the front screws should be delayed until after the skin is installed.

8. Apply skin, trolley hangers, door hardware and optional weather stripping (Figure 4). Hang door(s) on building, as explained on the back page.

9. Install the bottom guide rail, as explained on the back page.

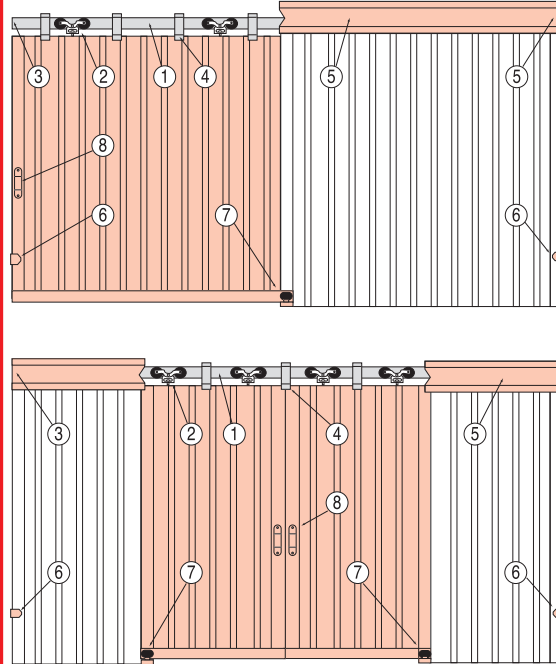
10. For double or split slide doors, attach optional No. SDR1635BC Box Vertical Closure Rail.



How to install single- and double-leaf sliding doors

1. Install a length of Combo door track which is double the door opening width onto the building track plank, making sure the track is mounted straight and level. Use extension brackets for the portion of track which extends beyond the door opening, if desired.

2. Position the door leaf beneath one end of the track and lift vertically to insert the wheels of the first trolley into the track. Hold the top of the door parallel to the track and roll forward until the second set of trolley wheels can be inserted into the track. Using the trolley hanger adjustments, move the door up-or-down and in-or-out from the building until it rolls freely in the track without interference.



3. Add end caps to each end of the track.

4. Snap track cover brackets into all track mounting brackets.

5. Install track cover and cover end trim.

6. Mount one adjustable door stop at each end of the track run.

7. Install one adjustable stay roller or adjustable door guide where the door overlaps the building wall. If a continuous bottom door guide system is being used, refer to guide rail installation instructions, below.

8. Add steel door pull(s) and desired latches.

How to install Bottom Door Guide Rail

1. Install and adjust door(s), as explained above.

2. Roll door panel(s) so that the door opening is completely closed. If in-stalling double-leaf doors, be sure panels meet in the center.

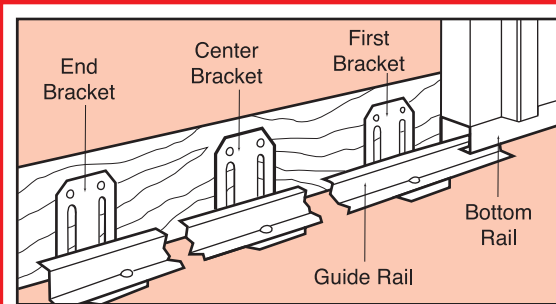
3. Using a length of guide rail which is at least 50% of the door panel width, align the guide rail with the bottom rail on the closed door.

4. With about 1 1/2" of guide rail centered in the bottom rail on the closed door panel, attach the guide rail to a guide rail mounting bracket using a 3/8" x 1" carriage bolt. Do not fully tighten bolt at this time.

5. Attach additional guide rail mounting brackets to the guide rail. Three guide rail mounting brackets are required for each 10' length of guide rail. Guide rail may be cut into two 5' lengths, requiring 2 brackets each.

6. Using two 3/8" x 2 1/2" carriage bolts (or lags) per bracket, bolt the first guide rail mounting bracket at the jamb to the building splash board. Do not fully tighten bolts.

7. With the guide rail engaged in the bottom rail, roll the door open until it comes to the last guide rail mounting bracket.



8. Bolt the last bracket securely to the building splash board, making certain that the guide rail is centered in the bottom rail on the door. Repeat for center mounting bracket, if required.

9. Return to the first bracket and tighten mounting bolts.

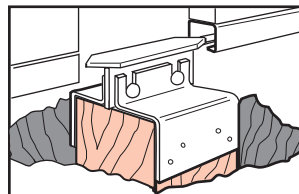
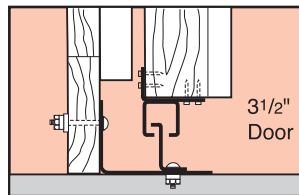
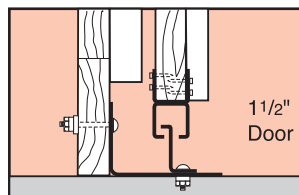
10. Check door for friction-free movement and tighten all bolts

holding the guide rail to the guide rail mounting brackets. Elongated slots in the bottom leg of the guide rail mounting brackets permit in-out guide rail adjustment.

Note: For the most secure door installation, it's best to mount the guide rails so that the top segment of its z-shape is pointing toward the building.

11. Secure all guide rail mounting brackets to the splash board with nails in the holes provided.

12. To secure double-leaf doors in the closed position, mount one No. 156000 Center Door Guide on a 6" x 6" post in the center of the door opening, as shown here.



PLYCO

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