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PO Box 128 | 504 Highway 63 South | Freeburg, MO 65035 | 800-347-0438 | 573-469-4151 (fax)

Installation Guidelines  
For **ALUMINUM M-SERIES TERRACE IN-SWING DOOR**  
Anchored through jamb with no position fin and flush to the interior

Installer:

- Read these instructions completely before starting any installation. Failure to install and maintain our product according to these instructions may void any warranty, written or implied.
- These instructions are consistent with AAMA IPC-08 “Standard Practice for Installation of Windows and Doors in Commercial Buildings” into common wall constructions. Contact your architect or construction professional for installation into other building designs or constructions methods.
- The installer is responsible for consulting the contractor, structural engineer, architect, or consumer, for proper installation according to local codes and/or ordinances.

Warning:

- Proper eye and hearing protection must always be worn when installing, or performing adjustments to Quaker window and door products.
- Use power tools properly! To avoid personal injury, always follow manufacturers’ instructions for safe operation.
- If broken, glass can fragment causing injury. All Quaker products are available with safety glass. In many areas, local building codes require safety glass in certain locations and/or applications. Unless Quaker’s stipulations dictate safety, glass or safety glass is specifically ordered, Quaker windows are not provided with safety glass. Before ordering, Quaker recommends consulting local building codes for more definitive information.

Caution:

- Lead-based paint may be present in older homes, and the removal of windows may cause this paint to be disturbed. To minimize exposure to lead-based paint dust, please consult [www.epa.gov/lead](http://www.epa.gov/lead).
- Care must be taken to properly recycle or dispose of old materials. Any recyclable materials should be separated from non-recyclable or hazardous materials. Please consult with local or state authorities regarding proper disposal of non-recyclable or hazardous materials.
- Some codes require the use of pressure treated lumber to line rough openings. Corrosion resistant materials, such as stainless steel or hot-dip galvanized steel, must be used for fasteners and anchors having direct contact with pressure treated lumber.

Important:

- Quaker reserves the right to change the information contained in these guidelines without notice.
- Maintain a minimum of ¼” between the exterior window frame and any trim, siding or masonry to allow for expansion.
- Nailing flanges and drip caps (integral or applied) do not take the place of window flashing. All windows and doors must be properly flashed and sealed around the perimeter.
- Do not drill through window sill to install alarm wires.
- If using muriatic acid or brick wash cleaning solutions, please follow the manufacturer’s instructions found on the product label or on the manufacturer’s website.

Handling and Storage:

- Do not store units outside, or in a hot environment. When carrying window, always keep it in a vertical position. Do not carry flat, doing so could result in damage to the unit.
- Stack units as straight as possible to avoid bowing. Do not lay flat!



These instructions are for installing Quaker’s aluminum products into a wood, steel studs, or concrete/masonry wall. Contact your Quaker window and door supplier for more information on installing units in other wall conditions. Please visit our website at [www.quakerwindows.com](http://www.quakerwindows.com) or call at 1-800-347-0438 for additional literature and information.

**Tools required by installer:**

- Safety glasses
- Utility knife
- Drill / screwdriver
- Caulk gun
- Level
- Tape measure



**Materials required by installer:**

Insulation

- Fiberglass or similar strips
- Minimally expanding low pressure polyurethane window and door spray foam. (Must be compliant with AAMA 812-04)

Shims

- Made of cedar or synthetic material

Screws

- Screw size may vary per wall/framing needs.
- Fasteners must be corrosion resistant and compatible with materials contacted and/or penetrated.

Silicone Sealant

- 100% silicone (**ASTM C920 compliant**)
- Neutral cure (modified oxime) only
- Some substrates may need to be primed before sealing. Consult the sealant supplier.
- **Always clean all area where sealant will be applied.**

Cleaning solvent for end dams

- Denatured rubbing alcohol

**Step A: Inspect the window or door unit before installation**

1. Remove all packaging material (blocks, pads, protectors, stretch wrap) and dispose/recycle properly.
2. Inspect unit for any damage or defects, and make sure the unit operates properly.
3. Verify that the window or door unit is the correct size and configuration.
4. Contact the nearest Quaker distributor if there is a problem. Provide the sales order number on the warranty sticker (see <http://quakerwindows.com/wp-content/uploads/2013/04/Warranty-sticker-locations01-30-2015.pdf> for sticker locations).

**Step B: Prepare rough opening**

1. The surrounding building condition and anchor fasteners must be structurally adequate to accept and carry the implied fastener and window or door loads. Structural adequacy of the condition that the windows or doors are being anchored and fasteners being used are ***not the responsibility of Quaker Window Products.***
2. Measure and verify the size of the rough opening. See shop drawings for the proper opening sizes.
3. Verify the rough opening is flat, plumb, level, and square. (Fig. 1)
4. **The sill beneath the unit must be level for proper unit operation.**
5. Check the fit of the sill pan system making sure the conditions are level, the installer can pre-apply the shims to the sill condition prior to installation of the sub-sill.

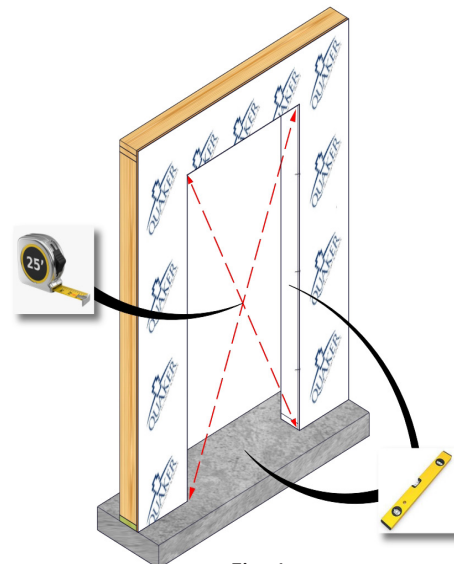


Fig. 1

### Step C: Sill preparation

1. Apply three 1/4" continuous beads of silicone across the entire width of the rough opening sill, and a 1/4" continuous bead of silicone 1/2" from each side of the rough opening. The bead will run the entire depth of the sub-sill anchor plate starting at the face of the wall. (Fig. 2)
2. Install a sill pan flashing (by others)
  - If installing the door flush with the interior to allow for a 180 degree door swing make sure to set the sill pan flush with interior wall finish. (Fig. 3).

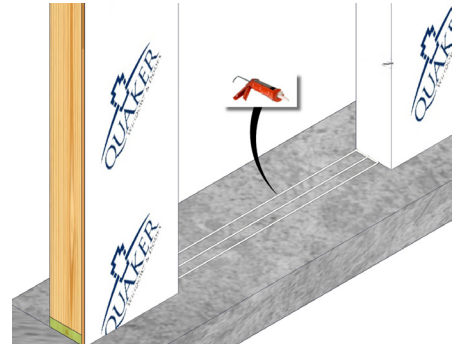


Fig. 2

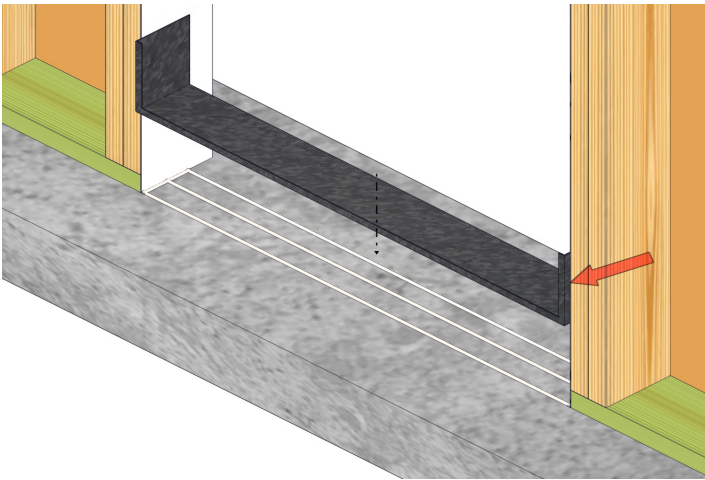


Fig. 3a

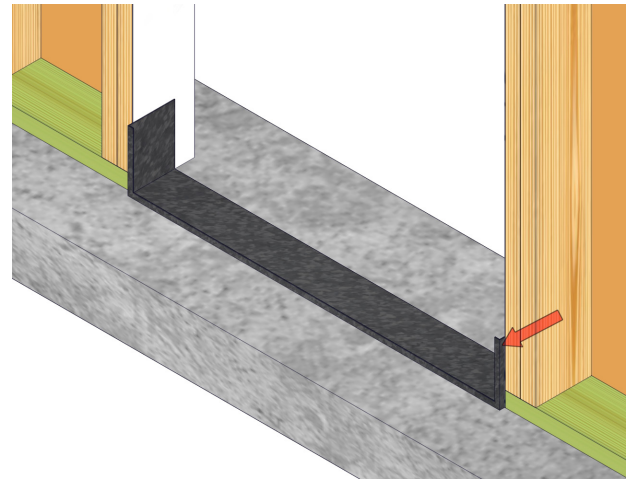


Fig. 3b

### Step D: Door Installation

1. Center and set the door frame into the rough opening. (Fig. 4)
2. Make sure to keep the door flush with the interior wall finish.
3. Level at the sill and plumb the frame. Shim under the frame to bring to level in necessary.
4. From the interior, square the frame in the opening by installing shims between the jambs and framing. (Fig. 5)

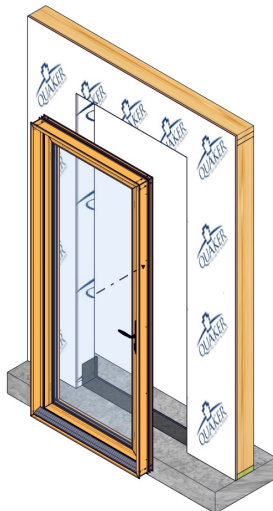


Fig. 4

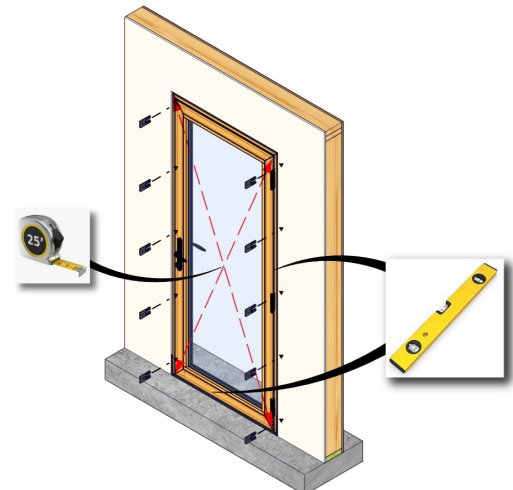


Fig. 5

**Step E: Door installation anchoring**

1. Drill a countersink hole through the jambs in the exterior track per anchorage calculations. **Quaker Window Products does not supply or claim liability for anchorage/fastener calculations. It is the installer/client's responsibility for structural adequacy of the anchorage and fasteners.** Typically, 3" from the corners and 16" on center, and at every hinge and lock location. (Fig. 6)
2. Install and fasten the door unit in place using fasteners by others per anchorage calculations. **Quaker Window Products does not supply or claim liability for anchorage/fastener calculations. It is the installer/client's responsibility for structural adequacy of the anchorage and fasteners.** Typically, 3" from the corners and 16" on center, and at every hinge and lock location. (Fig. 7)
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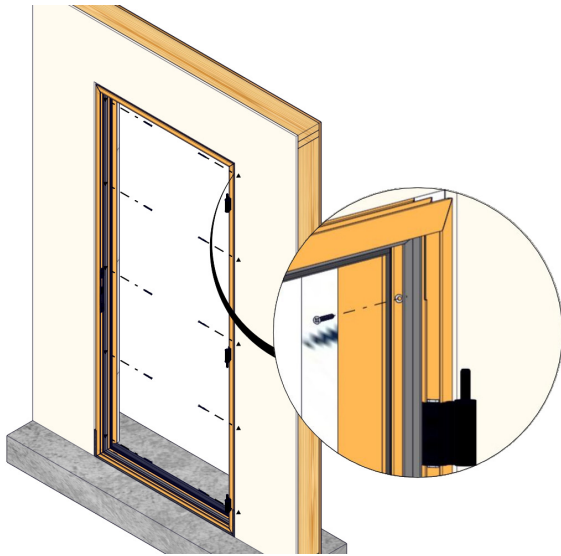


Fig. 6

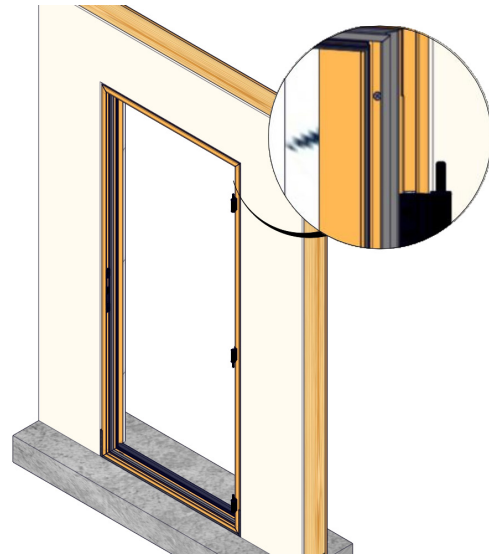


Fig. 7

**Step F: Door installation check, adjustments, and sealant**

1. Verify the door is square, level, and plumb. Check the spacing around the door at the top, middle, and bottom to make sure the door is not over shimmed. (Fig. 8)
2. See hinge and lock adjustment guides if adjustments are needed.
3. Apply backer rod as needed and a continuous bead of sealant around the entire perimeter of the door unit. (Fig. 9)

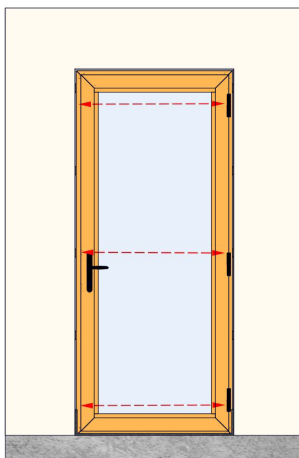


Fig. 8

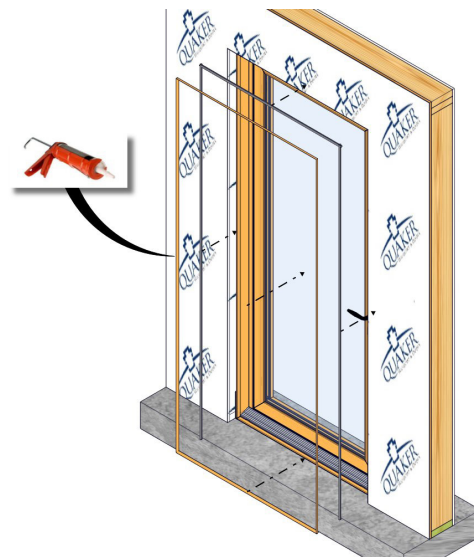


Fig. 9



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3. Verify the rough opening is flat, plumb, level, and square. (Fig. 1)
4. **The sill beneath the unit must be level for proper unit operation.**
5. Check the fit of the sill pan system making sure the conditions are level, the installer can pre-apply the shims to the sill condition prior to installation of the sub-sill.

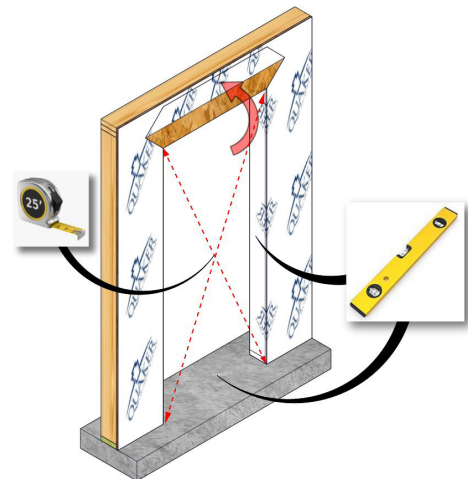


Fig. 1

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2. Install a sill pan flashing with minimum 1/2" interior leg (by others)
  - If installing the door with the position fin set the sill pan 3 3/16" in from the exterior. (Fig. 3)

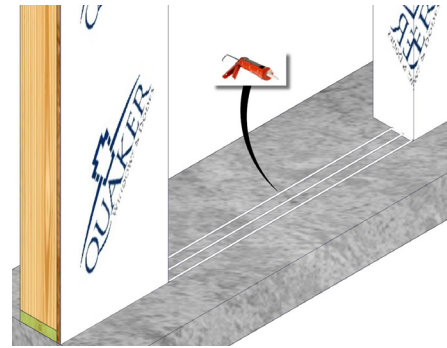


Fig. 2

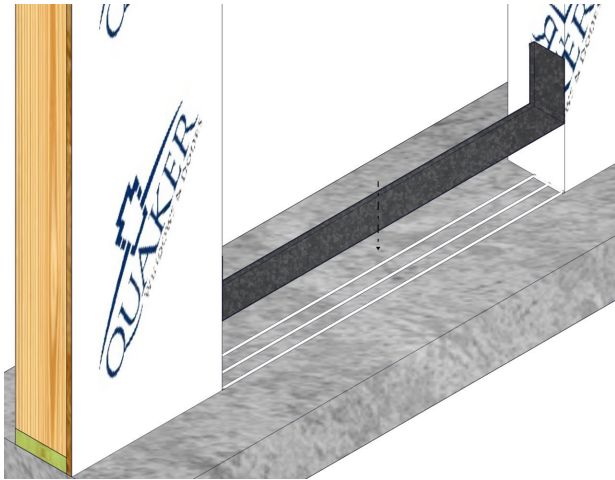


Fig. 3a

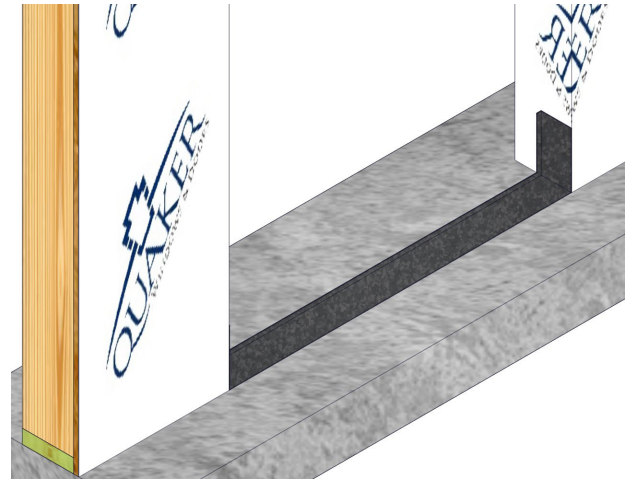


Fig. 3b

**Step D: Door position fin installation (Note: This is not a installation flashing fin and not made to anchored through)**

1. Install the position fin onto the frame if not installed at the factory on the head and both side jambs. (Fig. 4)
2. Snap the fin into place with short side of the flange facing the exterior. (Fig. 5)
  - Seal the corners of the position fin.

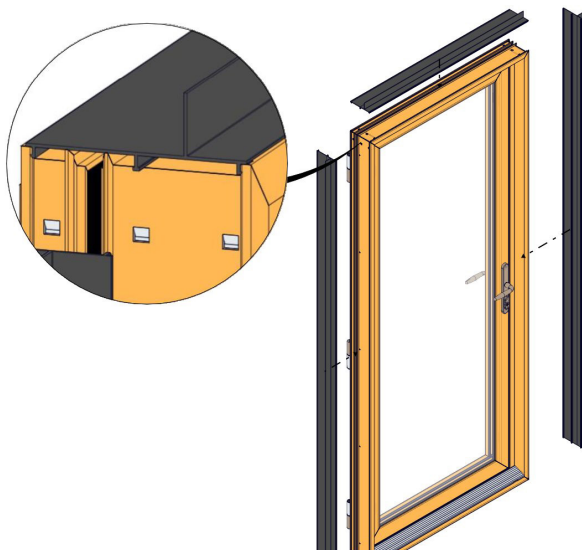


Fig. 4



Fig. 5

### Step E: Door Installation

1. Install the two top foam corner key gaskets over the exterior side of the position fin corner gaps.
  - Seal the exterior corners where the foam gasket meets the position fin. (Fig. 6)
2. Install a continuous bead of sealant around the interior side of the position fin. (Fig. 7)
3. Center and set the door frame into the rough openings pushing the position fin tight against exterior framing.
 

**Note: DO NOT nail or fasten through the position fin.** (Fig. 8)
4. Level at the sill and plumb the frame. Shim under the frame to bring to level in necessary.
5. From the interior, square the frame in the opening by installing shims between the jambs and framing. (Fig. 9)

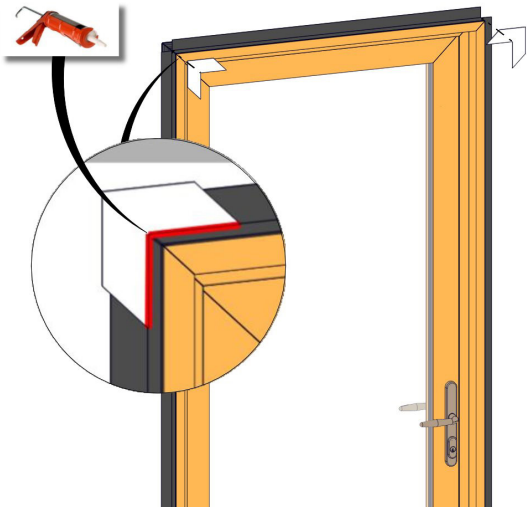


Fig. 6

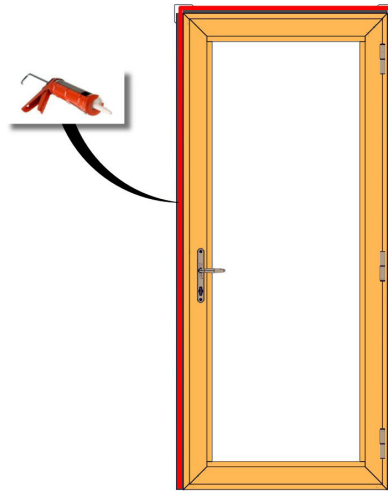


Fig. 7

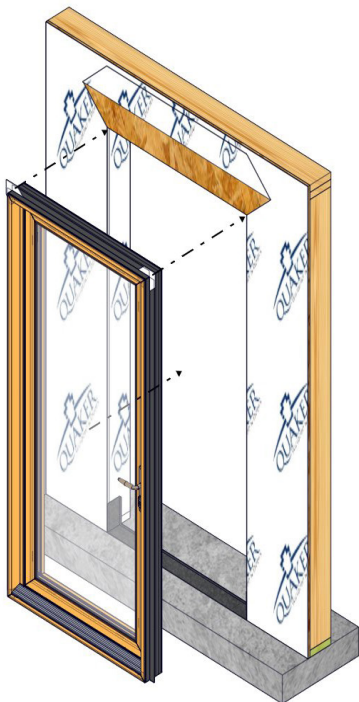


Fig. 8

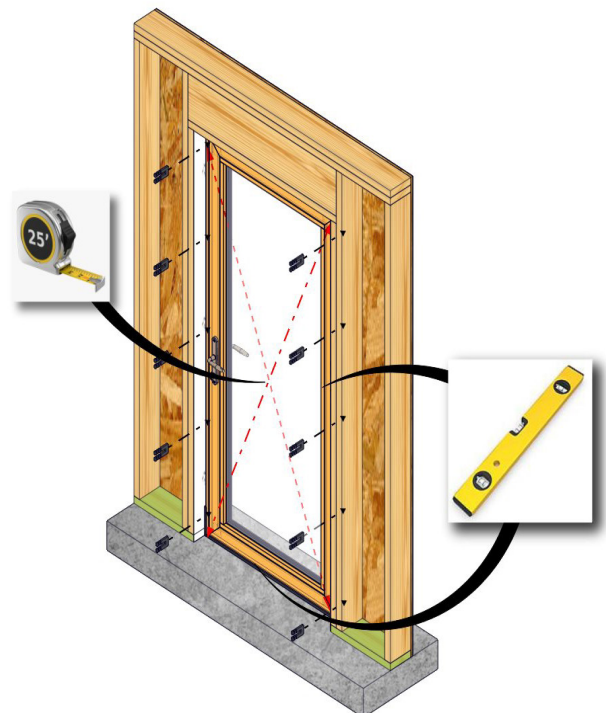


Fig. 9



### Step F: Door installation anchoring

1. Drill a countersink hole through the jambs in the exterior track per anchorage calculations. **Quaker Window Products does not supply or claim liability for anchorage/fastener calculations. It is the installer/client's responsibility for structural adequacy of the anchorage and fasteners.** Typically, a #12 screw 6" from the top and bottom and 15" on center thereafter. (Fig. 10)
2. Install and fasten the door unit in place using fasteners by others per anchorage calculations. **Quaker Window Products does not supply or claim liability for anchorage/fastener calculations. It is the installer/client's responsibility for structural adequacy of the anchorage and fasteners.** Typically, a #12 screw 6" from the top and bottom and 15" on center thereafter. (Fig. 11)
  - Always follow the anchorage calculations and fastener/anchor manufacture's guidelines for proper edge distance, load capacity and installation techniques.

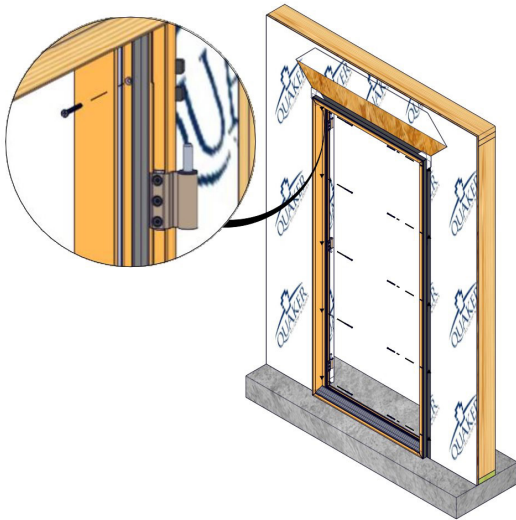


Fig. 10

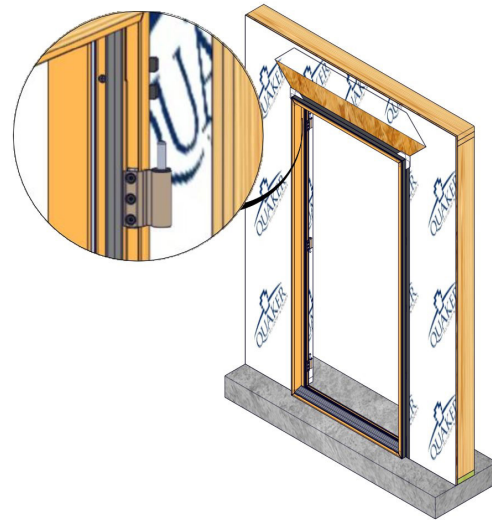


Fig. 11

### Step G: Door installation check, adjustments, and sealant

1. Verify the door is square, level, and plumb. Check the spacing around the door at the top, middle, and bottom to make sure the door is not over shimmed. (Fig. 12)
2. See hinge and lock adjustment guides if adjustments are needed.
3. Apply insulation and a continuous bead of sealant around the entire interior perimeter of the door unit. (Fig. 13)

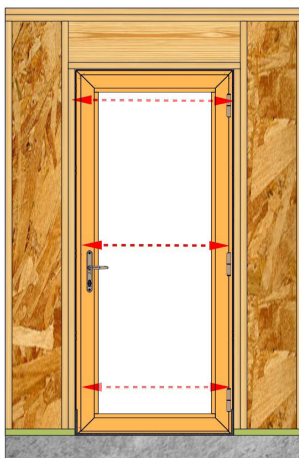


Fig. 12

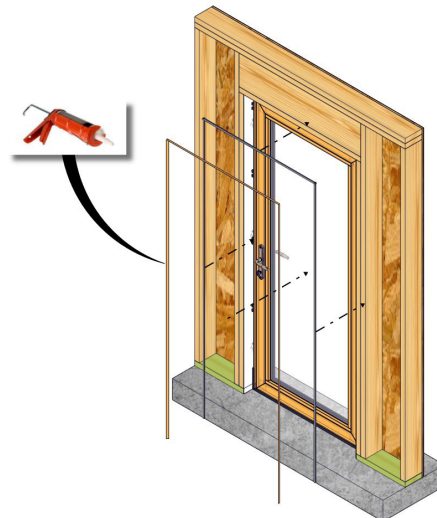


Fig. 13

**Step H: Exterior Door flashing tape**

1. Cut two pieces of flashing tape for jamb flashing extending 1" above head position fin. Remove release paper and press tightly along sides of door frame. (Fig. 14)
2. Cut a piece of flashing tape for the head flashing, which extends beyond outer edges of jamb flashings. Remove release paper and install completely covering position fin and adhering to exposed sheathing or framing members. (Fig. 15)
3. Flip down upper flap of WRB so it lays flat across head flashing, then trim 1" - 2" above the door opening. (Fig. 16)
4. Tape along all cuts in WRB and across head of the door with flashing tape. (Fig. 16)
5. Apply a continuous bead of sealant across the full length of the sill and around exterior perimeter of door unit. (Fig. 17)

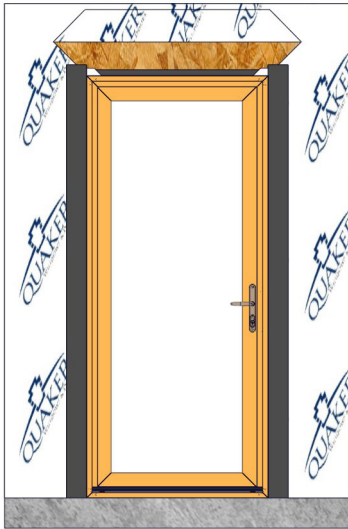


Fig. 14



Fig. 15



Fig. 16

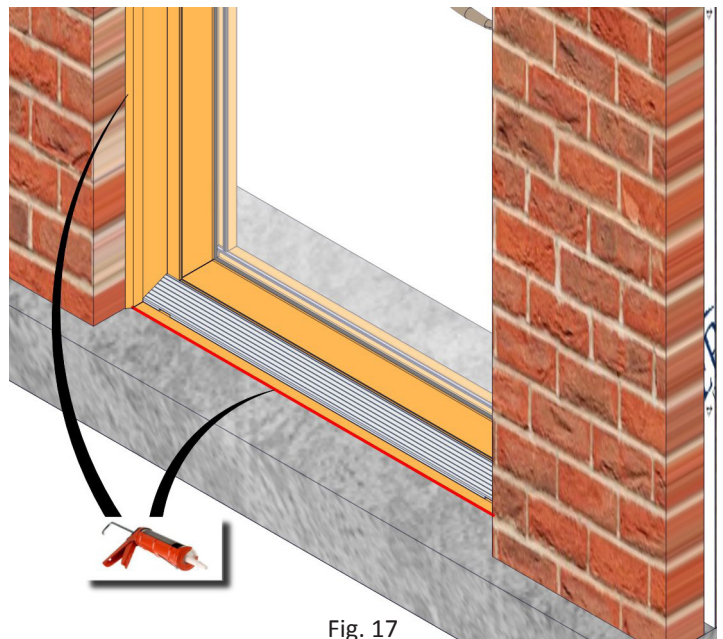


Fig. 17