

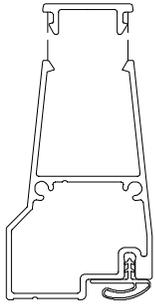
Integrity Swinging Door Field Service Guide

Stationary Panel Replacement



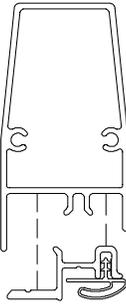
ATTENTION: The following steps on removing the stationary panel will differ depending on when the unit was manufactured. Units manufactured before August 2002 will have the old mull post and mull cap (A230 and A775). Units manufactured after this date will utilize a mull post and base (A1210 and A1209). See illustrations below to determine unit type.

OLD



A230 Mull post with
A775 Mull post cover

NEW

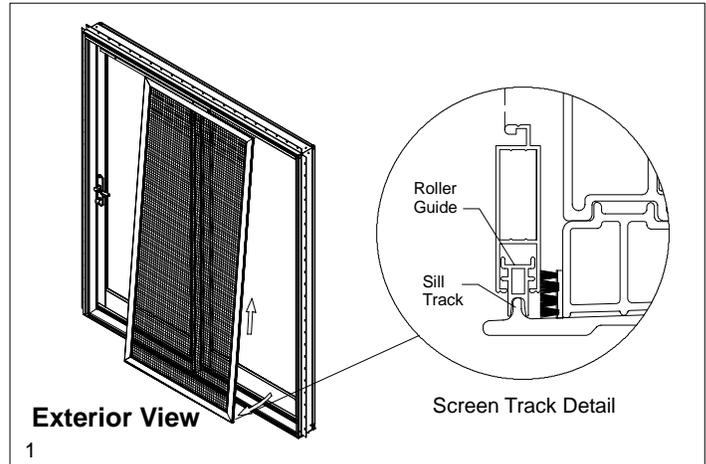


A1210 Mull post with
A1209 Mull post base

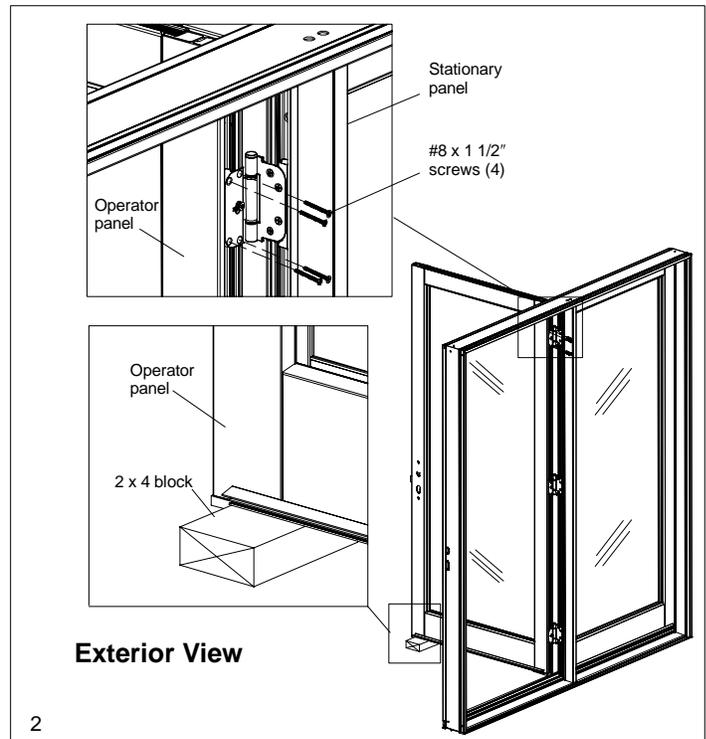
SCREEN AND OPERATOR PANEL REMOVAL

NOTE: This step is not necessary on units that utilize the new A1210 mull post.

1. Remove the screen panel by sliding the screen toward the center of the unit. Remove the two mounting screws from the screen roller bar. Grasp the screen near the bottom, depress screen roller guide, lift panel and pull out toward the exterior. Remove the screen from the screen roller bar. See illustration 1.



2. Open operator panel perpendicular to frame. Place a 2x4 or other blocking under the panel for support while removing the operating panel from the hinges. Remove the four (4) #8 x 1 1/2" screws from each of the three adjustment leaves attaching the hinges to the operating panel as shown in illustration 2. Remove the top and bottom guide hinges before removing the middle set hinge.



STANDARD PARTS NEEDED

ILLUSTRATION (not to scale)	DESCRIPTION AND COLOR	PART/PROFILE NUMBER
	Screen door meeting stile dust block	10500161
	Mull post cover A775	SW 17035868 PB 17015869 AR 17015868
	<i>Note: (If original is damaged upon removal from older units.)</i>	

YOU WILL NEED TO SUPPLY

Safety glasses	Hearing protection
Power drill w/ 3/16" drill bit	#2 Phillips head bit
Stiff putty knife or small pry bar	Pliers
Wood block	Rubber mallet
1/8" drill bit	7/64" drill bit
#8 x 1/2" Phillips panhead screw	Ratchet type clamps (2)
Double sided adhesive tape	
Grade NS Class 25 sealant per ASTM C920	
2x4 or other wood blocking to support operator panel	

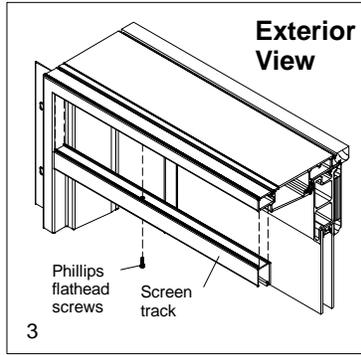
NOTE: Numbers listed in parentheses () are metric equivalents in millimeters rounded to the nearest whole number.

CAUTION: Integrity Swinging Door panels are heavy. If necessary, use the assistance of another individual to remove/install panel.

3. Carefully lift the operating panel out from the frame.

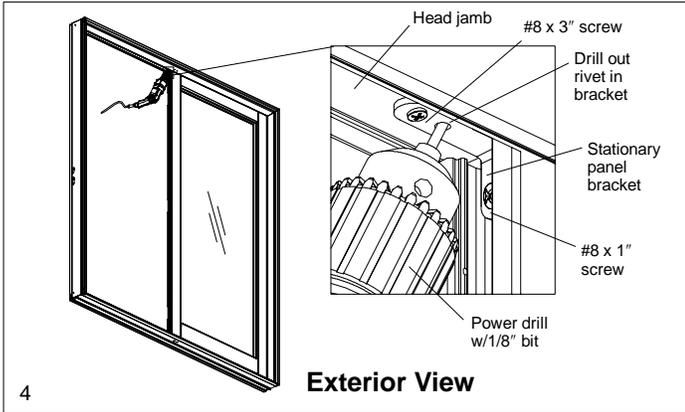
NOTE: this step is not necessary on units that utilize the new A1210 mull post.

4. Slide the screen roller bar to one side and remove the #7x 5/8" screws located in the screen track. Move roller bar to the opposite side and remove the remaining screws. See illustration 3. Remove the screen track and set aside.



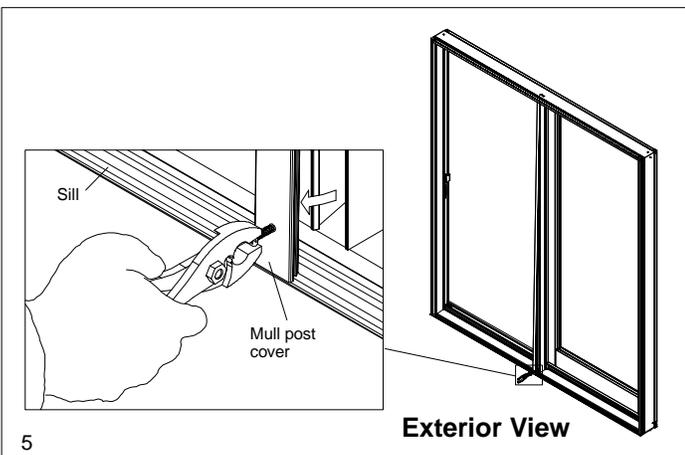
REMOVING THE STATIONARY PANEL

5. Use a power drill and 1/8" bit to drill out the rivet attaching the bracket to the head jamb. Remove the #8 x 3" Phillips panhead screw at the head jamb. Remove the #8x1" panhead screw attaching the stationary panel head jamb bracket to the stationary panel hinged stile. See illustration 4. Remove the bracket and set aside for re-installation of stationary panel. **For newer units skip to step 9.**

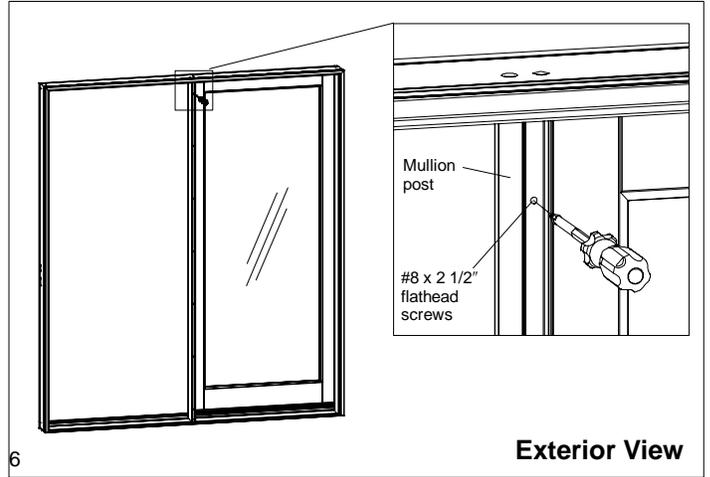


6. REMOVING STATIONARY PANELS ON OLDER UNITS: Remove the meeting stile dust block located at the bottom of the mull post cover. Drill a small hole near the bottom of the cover and insert a #7x5/8" wood screw. With a set of pliers, grasp the screw and pull to remove the bottom of the mull post cover as shown in illustration 5. Remove the rest of the way by hand, being careful not to kink or bend the cover, if it will be used later.

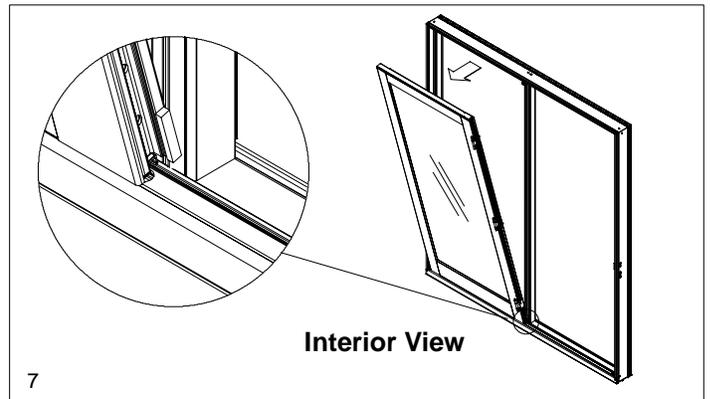
NOTE: Mull post cover may be removed by prying at the bottom with a stiff putty knife or small pry bar. However, use caution as damage can occur making it necessary to order a new cover.



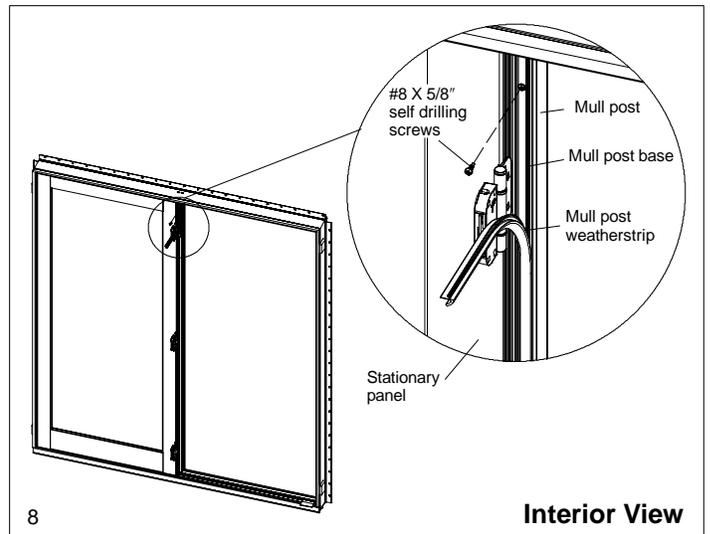
7. Using a #2 Phillips head screwdriver, remove the ten (10) #8 x 2 1/2" flat head screws attaching the mull post to the stationary panel as shown in illustration 6.



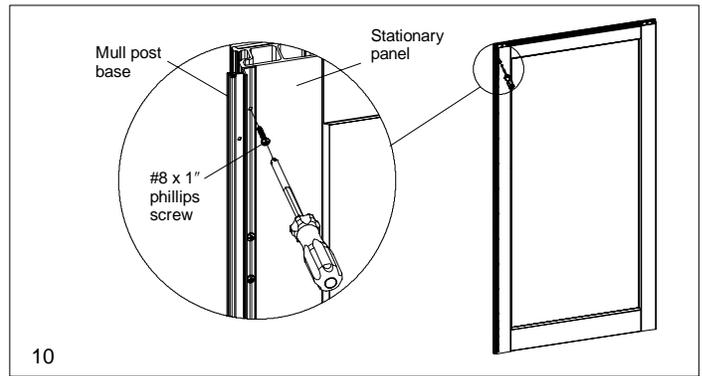
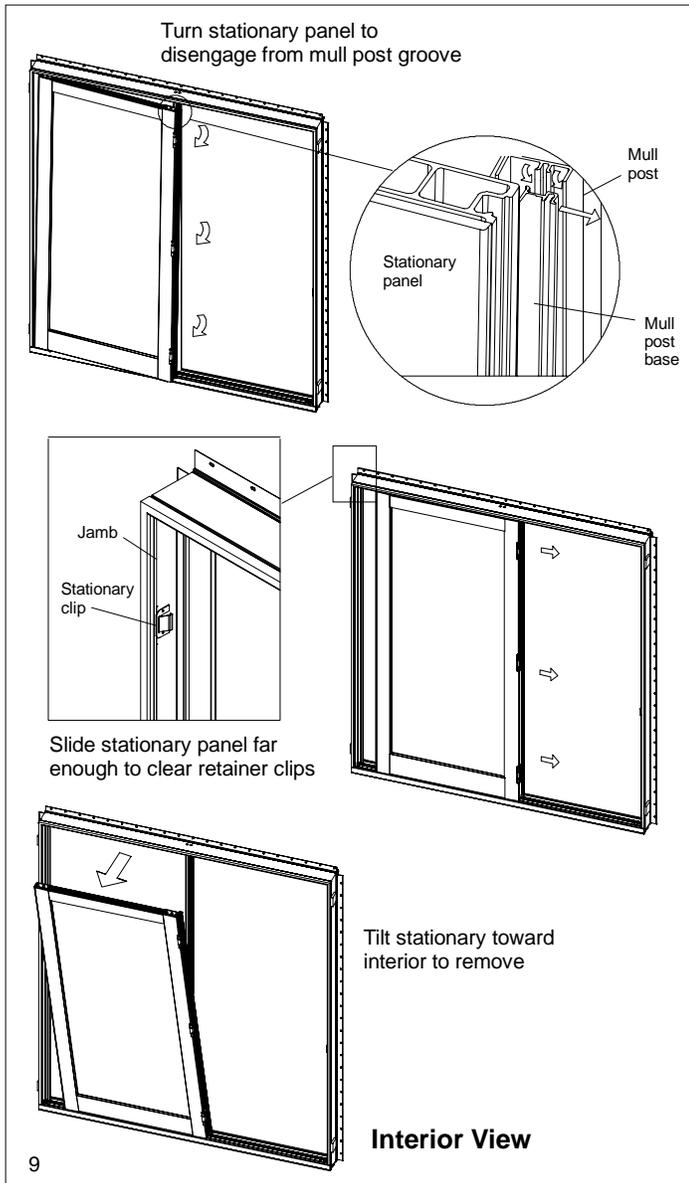
8. From the interior, slide the stationary panel 3/8" (10) toward the center of the unit so that the stationary panel disengages from the stationary panel spacer on the stationary jamb. Tilt the panel to the interior, lift and remove from unit. See illustration 7. Skip to step 11 of Installing the New Stationary Panel.



9. REMOVING STATIONARY PANELS ON NEWER UNITS: from the interior, remove the mull post weatherstrip. Using a #2 Phillips screwdriver, remove the #8 x 5/8" self drilling panhead screws and set aside for reuse later. See illustration 8.



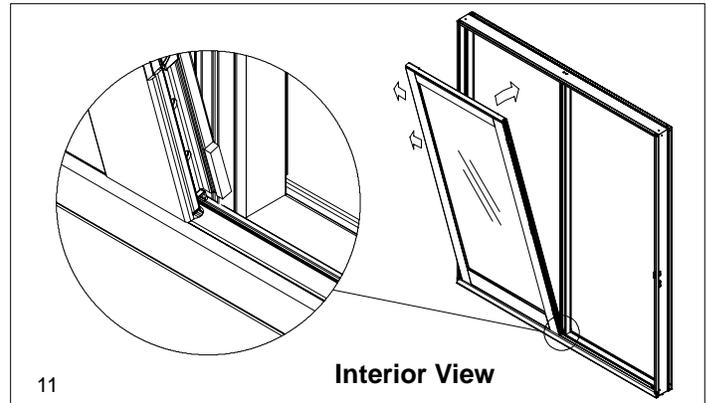
10. Rotate the stationary panel to the interior, slide the panel over slightly and tip in to the interior away from the frame. See illustration 9.



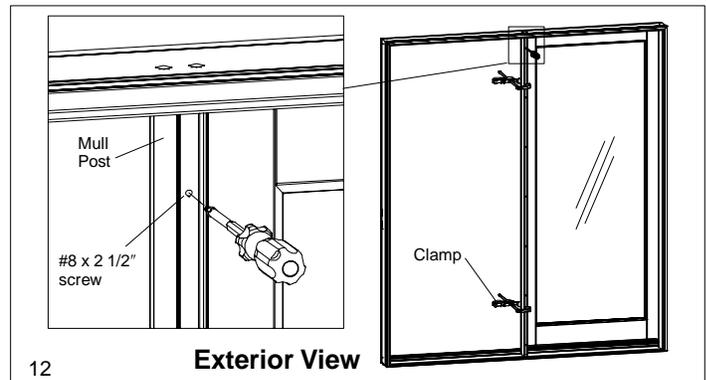
12. Prior to installing, inspect the stationary panel to ensure that all necessary components are in place such as the panel drip and gaskets; stationary panel spacers and stile foam block. Also, be sure that standing blocks are fastened to the sill.

Note: Some older panels may have the standing blocks fastened to the bottom. If this is the case, remove the standing blocks and fasten to the sill with double sided adhesive tape.

13. From the interior, set the new stationary panel (resting on the sill) 3/8" from the stationary jamb. Tip the panel into the frame and slide the panel to the stationary jamb until the panel engages with the stationary panel spacer. See illustration 11.



14. With the panel in proper position and stationary panel stile fully engaged with the stationary panel spacer, clamp the panel to the mull post at the top and bottom. Using the holes in the mull post as a guide, pre-drill into the Ultrex stile on the stationary panel with a 7/64" drill bit. Attach the panel to the mull post with the ten #8 x 2 1/2" screws removed earlier. See illustration 12.



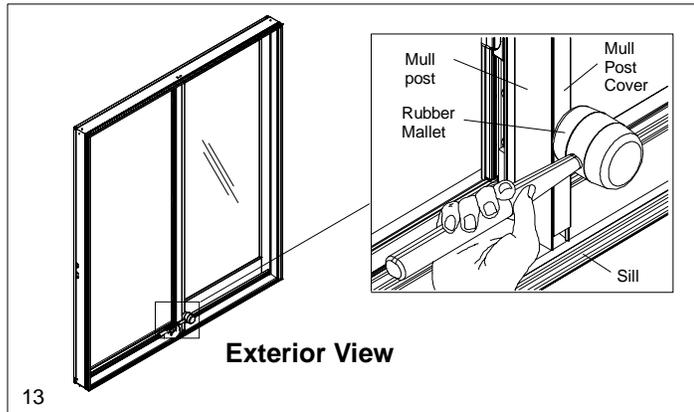
INSTALLING THE NEW STATIONARY PANEL

ATTENTION: When installing a stationary panel in units with the new mull post, DO NOT REMOVE THE MULL POST BASE FROM THE REPLACEMENT PANEL. Skip ahead to step 16.

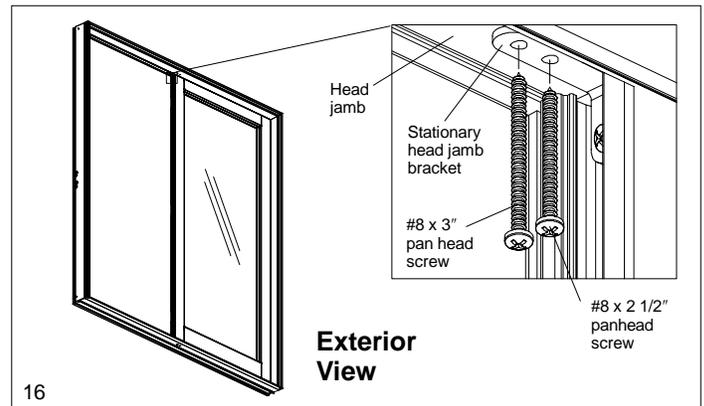
11. INSTALLING STATIONARY PANELS ON OLDER UNITS: Place the new stationary panel on a sturdy surface. The mull post base will need to be removed prior to installation. Remove the #8 x 1" panhead screws fastening the base to the panel with a Phillips screwdriver. See illustration 10. Remove the mull post base and discard. Seal the screw holes with sealant (see recommended sealant in "you will need to supply" section).

- Replace the mull post cover by placing it flush with the top of the mull post. Tap the cover into place near the edges of the cover with a rubber mallet. Be careful not to dent or mar the surface of the cover. See illustration 13. Skip ahead to step 19.

NOTE: If the mull post cover was removed by pulling it out with a screw, install the end of mull cap with the screw hole at the top of the mull post.

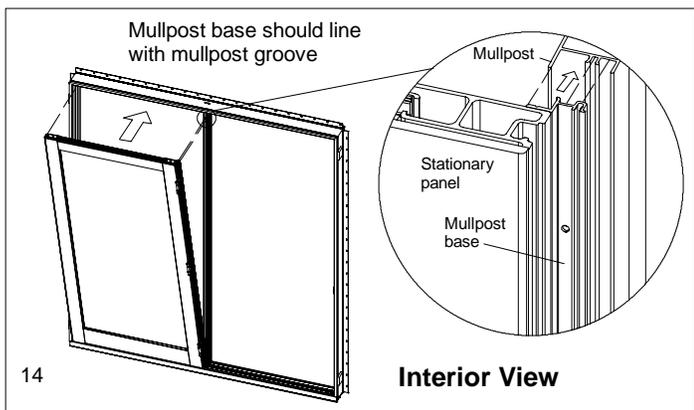


- Replace the stationary panel head jamb bracket and attach to the stationary panel hinged stile with a #8 x 1" Phillips panhead screw removed earlier. Attach the stationary head jamb bracket to the head jamb with a #8 x 2 1/2" pan head wood screw (not included with panel) and the #8 x 3" screw (removed earlier) as shown in illustration 16.



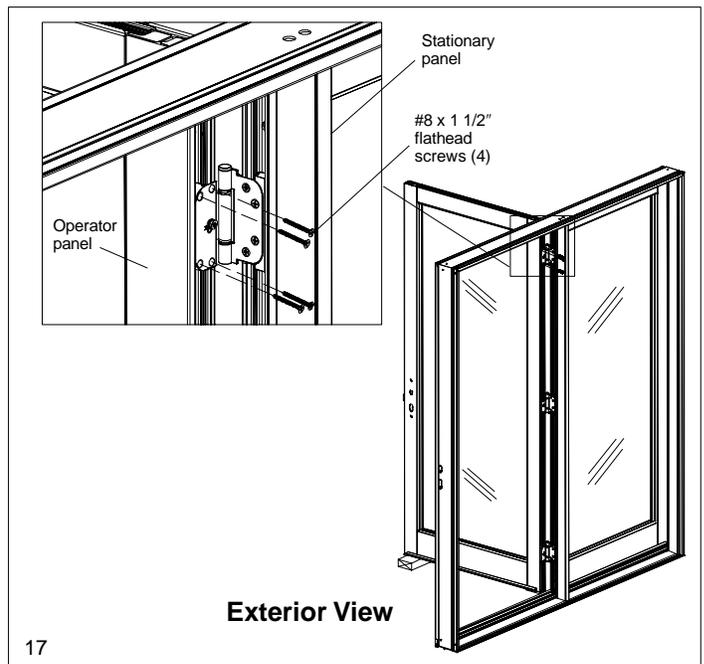
- INSTALLING STATIONARY PANELS ON NEWER UNITS:** Prior to installing, inspect the stationary panel to ensure that all necessary components are in place such as the panel drip and gaskets; stationary panel spacers and stile foam block.

- From the interior, set the new stationary panel (resting on the sill) so that the mull post base will line up with the mull post. Tip the panel into the frame making sure the panel engages with the stationary panel clips on the frame. See illustration 14.

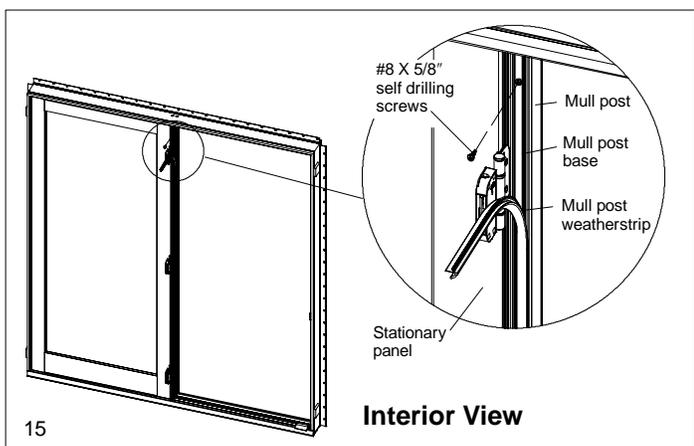


INSTALLING THE OPERATING PANEL

- Position the operating panel in the frame for installation. Use blocking under the panel to ease installation and avoid binding when replacing screws.
- Using the holes in the operating panel as a guide, attach the set hinge to the panel with the four (4) #8 x 1 1/2" flathead wood screws removed earlier. See illustration 17.



- Fasten the stationary panel to the mull post by driving the #8x5/8" self drilling panhead screws (removed earlier) through the mull cap base into the mull post ensuring that they are evenly spaced. Replace the mull post weatherstrip. See illustration 15.



- Attach the top and bottom guide hinges in the same manner as the set hinge in step 18.
- Replace the screen door meeting stile dust block centered on the face and flush with edge of the mullion cover.
- Install the head jamb screen track and screen roller bar.
- Check panel for proper operation and adjust hinges as necessary.