



INSTALLATION GUIDE FOR PROFESSIONALS

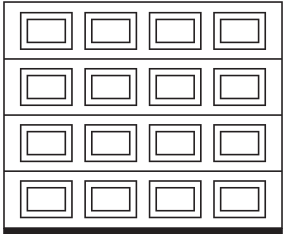
RESIDENTIAL SECTIONAL GARAGE DOORS

WARNING

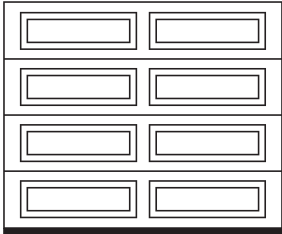
Read this entire safety manual prior to installing an Invicta garage door. Installation of our doors should only be done by professional garage door installers. Be sure to understand all instructions and guidelines before you begin. Failure to follow instructions listed in the manual may result in serious personal injury or property damage.

RESIDENTIAL MODELS

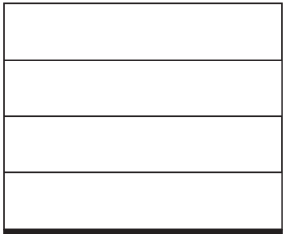
Installation guide is for the following residential models and is for professional door installers.



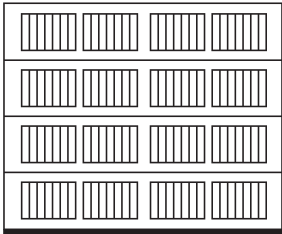
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Short Raised



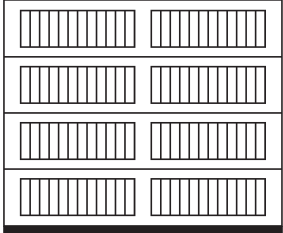
200
Long Raised



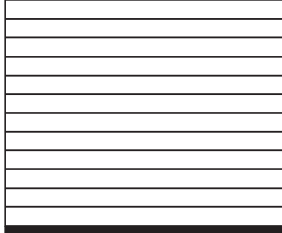
300
Flush



400
Short Carriage



500
Long Carriage



600
Small Slat

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BEFORE YOU BEGIN

1. Confirm you have all the correct parts, tools and materials you need for installation. If you are missing parts please call Invicta Door™ at 833.SSC.DOOR or customer service.
2. Read instructions completely and prepare the proper safety equipment. (See page 3)
3. Check Work Area For:
 - Adequate lighting.
 - Grounded electrical outlet.
 - Clear obstructions to the electrical outlet. Avoid any sharp or hot objects that may cause damage to cord.
4. Ensure you have the correct amount of space on either side of the door and determine if you have standard headroom or low headroom to do the required job. If you have a low headroom, please pay attention to the special instruction on page ?? and you may require additional hardware.
5. Installation of a garage door can take between 5-10 hours. Be sure you have allowed enough time to complete the installation as the garage will be unsecure and exposed to weather until installation is complete.
6. Warranties will only apply if the installation is done per this factory installation guide and done by a professional garage door installer. This includes the use of Invicta Door™ sections, parts and hardware.

WARNING

Never use old track or hardware when installing a new garage door. Old part may cause damage to the new door or failures that could result in serious injury.

7. To install a garage door operator: installing a reinforced mount is required to avoid damage. Item sold separately.
8. When drilling holes, be sure to avoid puncturing the outside steel skin of the garage door.

9. If the door is being installed in extreme wind areas, the door may require additional supports to increase the wind load capacity.

10. If the garage has an existing door that is being replaced, be sure to uninstall the door with caution. Follow the proper instructions depending on the type of springs used (torsion or extension). Each is installed using different methods and the areas of tension are unique to each door type. (See page ?? for uninstall instructions)

11. Springs, brackets, fasteners, counterbalance lift cables and supports are under high tension. Do not attempt to loosen any fasteners of these components without proper instruction or sequence. It could result in the spring releasing causing property damage and risk severe injury.

12. Do not attempt to install the door during windy weather conditions. The door sections may be blown down causing serious injury or property damage.

13. Invicta Door™ does not claim liability for any installation that is not in compliance with this installation guide. If the door is installed in a state that is not applicable or against county building codes.

SAFETY INFORMATION

Review all safety instructions before the start of the installation. Failure to do so may result in property damage or serious injury.

DURING INSTALLATION

RED fasteners must be used where required and should not be loosened or removed. These fasteners secure parts that are under extreme tension.

DO NOT stand or walk under a moving garage door. Keep door fully in view and free of obstructions when operating.

DO NOT place fingers or hands into open section, joints or track when garage door is moving.

REMOVE pull down ropes and disable locks on electrically operated garage doors.

DO NOT hang tools or materials on any part of the garage door that may fall and cause injury.

DO NOT install a garage door on windy weather days. The garage door could fall during the installation causing injury.

DO NOT allow untrained persons to assist in the installation. Ensure there are no children or pets in the work area.

ALWAYS WEAR appropriate attire, including but not limited to safety glasses, closed toe shoes/boots, and gloves.



KEEP HANDS AND FINGERS CLEAR of section joints, when installing each section. If a section should fall or come loose from a temporary brace, it could result in injury.

WHEN YOU ARE READY TO TEST the door, be sure all areas are clear and review the proper cycling from a safe distance until a full cycle is complete.

ENSURE THE GARAGE DOOR OPERATOR being installed is in compliance with current residential building codes and requirements.

WARNING LABELS

DO NOT remove any of the following four (4) warning labels during or after installation of the garage door:

Spring Warning Label attached to the spring assembly.

General Warning Label on the back of a garage door panel, around eye level.

Operator Warning Label for the garage door operator (provided with operator) and to the top of the door for visibility.

Bottom Bracket Tension Warning Label above the garage door's bottom brackets.

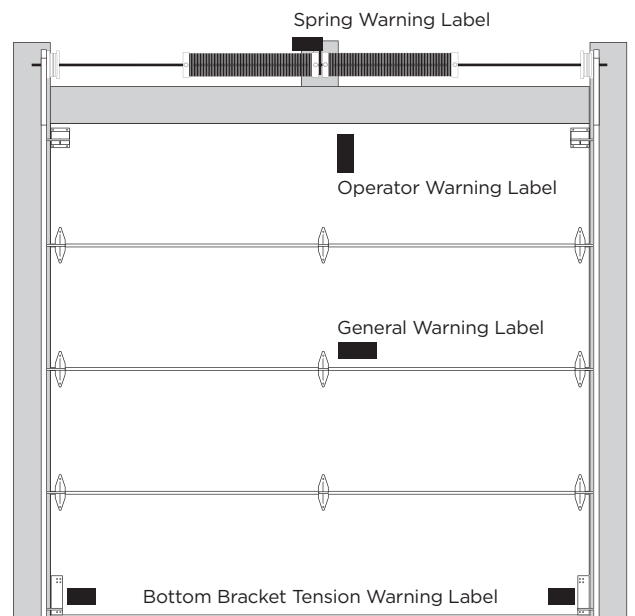

























IMAGE	DESCRIPTION	SINGLE DOORS	DOUBLE DOORS
	#1 Hinge	5	11
	#2 Hinge	2	2
	#3 Hinge	2	2
	#4 Hinge (included in 5 section doors only)	2	2
	Bottom Bracket, (1) LH + (1) RH	2	2
	Flag Bracket (1) LH + (1) RH	2	2
	Top Bracket	2	2
	Jamb Bracket, Long Track	2	2
	Jamb Bracket, Short Track	2	2
	Cable Assembly	2	2
	Lift Handle	2	2

IMAGE	DESCRIPTION	SINGLE DOORS	DOUBLE DOORS
	Rollers	10 (4 sections) 12 (5 sections)	
	Struts	0	1 or 3
	Horizontal Track, Curved	2	2
	Vertical Track	2	2
	1/4" 3/4" Hex Head Self-Tapping Screw (7/16" Head)	70	100
	* 1/4" 5/8" Track Bolt	12	12
	3/8" -18 x 3/4" Large Carriage Bolt	6	6
	* 5/16" x 1-5/8" Lag Bolt	12 (5 sections)	
	3/8" Washer	2	2
	1/4" Flange Nut	16	22
	* 3/8" Hex Nut	6	6

* Indicates red painted hardware intended for load bearing sections of the garage door assembly

DIFFERENT HARDWARE SUPPLIED FOR EXTENSION SPRINGS

IMAGE	DESCRIPTION	QTY REQUIRED
	Extension Spring Kit	1

ADDITIONAL HARDWARE REQUIRED FOR LOW HEADROOM

EXTENSION SPRINGS

LOW HEADROOM OPTION	HEADROOM REQUIRED	QTY REQUIRED
Low Headroom Track	4 ½"	1 set
Low Headroom Conversion Kit	4 ½"	1
Low Headroom Top Bracket	4 ½"	2

TORSION SPRINGS

LOW HEADROOM OPTION	HEADROOM REQUIRED	QTY REQUIRED
Low Headroom Conversion Kit	8"	1 set
Low Headroom Bracket	7"	1 set
Low Headroom Top Bracket	6"	2
Operator Extension Bracket	-	1

ADDITIONAL MATERIALS YOU WILL NEED:

- Spray Lube
- 3" Nails
- Stop Molding
- Operator Bracket
- Perferated Angle
- Wood Shims
- Wood Block
- Rope
- H Track
- Angle

TOOLS NEEDED:

- Work Gloves
- C-Clamp
- Hammer
- Angle Square
- Measuring Tape
- 24" or 48" Level
- Stepladder
- Drill, drill bit set, drive bit set, & box wrenches
- Additional tools may be required
- Padded Sawhorses
- Hacksaw
- Winding Bars
- Flathead Screwdriver
- Angle Cutter
- Knife
- Socket Wrench Set

REMOVING THE EXISTING DOOR

The door is going to be dismantled in the closed position, so be sure you have everything you need inside the garage. Determine if the door to be dismantled has a torsion or extension spring counterbalance assembly and follow the instructions corresponding to that type.

WARNING

If done improperly, serious injury can be a result of not controlling the release of garage door springs. Be sure to properly release the tension in the spring(s) before starting other work on the door. This work must be done by a garage door professional.

WARNING

Keep hands clear of the garage door while in operation to avoid pinching or crushing fingers.

REMOVING THE EXISTING DOOR

EXTENSION SPRINGS

To release the tension in the extension spring, place the door in the open position. Secure the door in place using vice grips below the bottom roller. When you are confident that the door is secured, release the spring by unhooking the S Hook from the track, or by releasing the cable from mechanism that holds it in place. Take apart the extension spring counterbalance assembly from both sides.

When the counterbalance assembly and the cables are fully dismantled, slowly lower the garage door to the closed position.

WARNING

Garage doors are extremely heavy, weighing up to 400lbs. Lowering the garage door should be done by two people, one on each end of the door. Lower slowly and completely to the floor, do not allow to fall freely.

TORSION SPRINGS

To release the tension in the torsion spring, place the door in the down position. Carefully unwind the torsion spring or springs using the winding bars to release all of the counterbalance tension. Next, you will want to take the cables off the drums and bottom bracket.

DISMANTLING THE DOOR

With the door in the closed position there should be no tension and you can begin the dismantling process. Start at the top section and disassemble the hinges from the door. As the hinges come off, the sections become free and loose from the track and other sections. Take the removed sections and stack them in a safe area. Continue this process until all sections have been removed.

Once all the panels are removed, move to the torsion or extension spring counterbalance assembly and dismantle this completely. Once all of the tracks and mounting brackets have been dismantled and removed, the opening should be free and clear from any past door components.

PREPARING THE DOOR OPENING

- Inspect the rough opening (without stop molding) for damaged wood or rot and replace as needed.
- The garage door opening should be approximately the same size as the door and framed with 2" x 6" lumber with vertical jambs extending beyond the opening per required headroom.
- The jambs must be plumb and the header level for a square opening with all fasteners flush with surface.

NOTE: Jamb and Spring Pad installation is typically performed by the builder of the home at the time of home construction. If replacing a door, be sure to inspect thoroughly.

STOP MOLDING INSTALLATION

Stop molding is sold separately to match the style and colors of the garage trim.

- Measure door opening and cut the trim to length, place the trim flush with the inside edge of the door jamb. The soft, flexible flap should be installed at an angle to the garage door.

NOTE: Temporarily secure the molding, you will be able to make adjustments after the door is fully installed before you finalize the placement.

- Repeat this process with the side pieces, cut to length and attach to the jamb temporarily.

PREPARING THE DOOR SECTIONS

SAFETY BOTTOM BRACKET INSTALLATION

- The bottom section has a rubber weather seal on the bottom. Place the section face side down on sawhorses that are covered in cloth or carpet to protect their surface.
- If bottom brackets are joined with tabs, bend at the tabs to separate and remove sharp edges.
- Slide the brackets onto the stile

WARNING

Failure to fully engage safety tabs can result in sections falling or springs breaking free when tension is applied.

- Use (2-4) 1/4" x 5/8" Self Drill Screws (Red Head) to attach each Bottom Bracket to the door section.
- Insert the Roller into the Bottom Bracket. Repeat procedure for the other end stile.

LIFT CABLE INSTALLATION

- Hook looped ends of LONG lift cables over buttons on bottom brackets.

WARNING

For Standard Extension Springs — use the cables that are longer, for lifting. The shorter cables are for safety containment, using these as lift cables can cause improper door function.

ATTACHING HINGES

- Hinges are stamped with numbers 1 - 4 on the side of the hinge that attaches to the section. Hinge 2 and above, always attach with roller stem tube below hinge. (Number 4 is only used on 5 section doors)

- Attach a #1 hinge to each stile using prepunched holes along top edge of section using (2) 1/4"x3/4" sheet metal screws per hinge.

NOTE: Use the tables below to determine if your bottom or intermediate section needs a strut attached.

- To attach strut to the section, attach on top of hinges using 1/4" x 3/4" self-drill & tap screws.

STANDARD STEEL DOORS

DOOR THICKNESS	DOOR WIDTH	STILE WIDTH	SECTIONS		
			BTM	3 RD	TOP
2"	< 15'	All	-	-	-
2"	2"	All	-	-	1

PREPARING THE DOOR SECTIONS (CONTINUED)

SECOND SECTION

- Place the second section face down on the padded sawhorses.
- Attach a #2 hinge to each end at top edge using (2) 1/4"x3/4" sheet metal screws. Attach a #1 hinge to all center hinge locations (prepunched) holes using (2) 1/4"x3/4" sheet metal screws.
- Each new section of door you prepare, refer to the strut charts on page 7 to indicated if you need to add a strut to that section or not.
- The second panel should also have a lift handle installed on the end stile on both ends of the door. You may need to drill holes. Be sure to leave room for the top flap of the bottom section hinge to be attached.

THIRD SECTION

- Place the third section face down on the padded sawhorses. This section will have a General Warning Label on the back of the section
- Attach a #3 hinge to each end at top edge using (2) 1/4"x3/4" sheet metal screws. Attach a #1 hinge to all other prepunched holes using (2) #14 x 5/8" sheet metal screws.
- Each new section of door you prepare, refer to the strut charts on page 7 to indicated if you need to add a strut to that section or not.

TOP SECTION

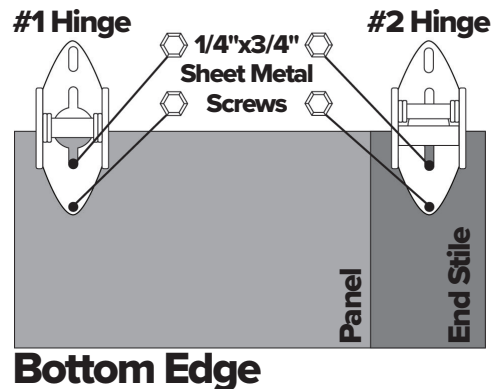
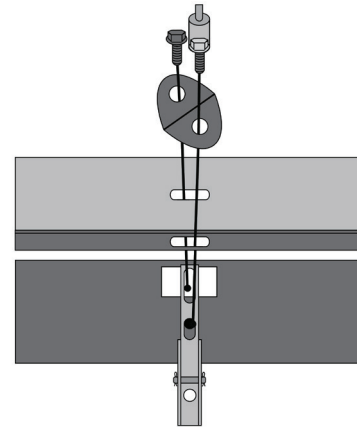
- Place the top section face down on the padded sawhorses.

NOTE: Leave at least 1" from the top of the section when installing the strut.

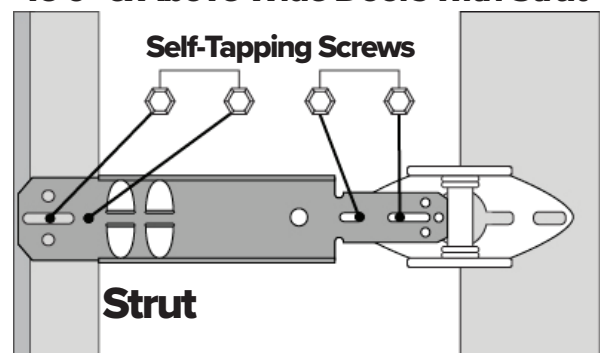
- Secure top fixtures 3 1/4" from the top of

the section, aligning the middle hole in top of bracket with the bottom hinge hole. Loosen the top bracket adjustment nut.

- Install an operator bracket (not included) to the center stile of the top section. This is required for extra support for doors using and electric operator.
- Refer to the strut charts on page 7. Align the strut a 1" down from the top of the door section and fasten with (6) 1/4"x5/8" screws. You may need to install a strut clip (not included).

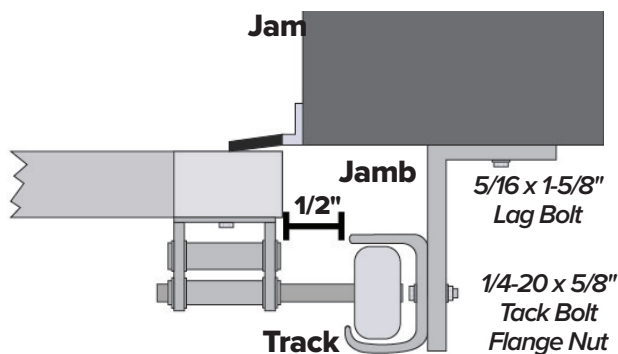
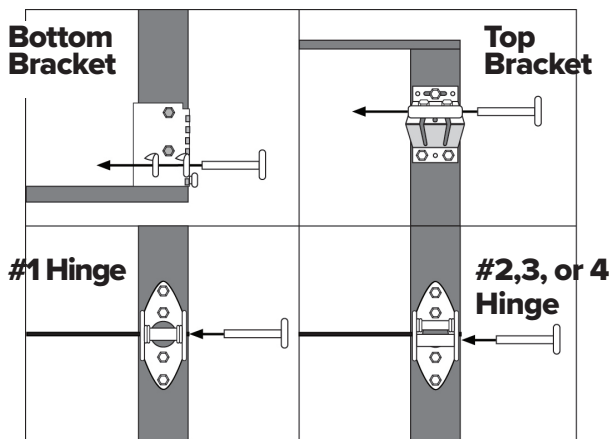


16'0" & Above Wide Doors with Strut



INSTALLING THE DOOR SECTIONS

- Position the bottom section centered in the door opening, against stop molding.
- Use a level and shims to ensure the bottom section is level.
- Temporarily secure door section to the wall with 3" nails into the side jams at both ends. Bend nail over the edge to hold section in place.
- Place each sequential section carefully on top of the last one placed. Secure each one with a 3" nail bent over the edge to prevent movement.
- Secure each section the previous by flipping the hinge below onto the new panel, fastening the hinge with (2) 1/4" x 3/4" sheet metal screws.
- Place a roller in each top and bottom bracket and proper tubes in the side hinges on each section.



INSTALLING VERTICAL TRACK

WARNING

The track and spring anchor are under high spring tension and **MUST** be secured appropriately. Failure to do so could result serious injury or death.

Start hand tightening fasteners when assembling the track, it will allow for adjustments when fully installing.

- There are different sizes of Jamb brackets (see table). Each bracket should be installed with the longside facing flat side of track and short side toward wall (Fig. 11-A).

NOTE: Raise the vertical track 1/2" from the ground to avoid roller binding.

- Start at the bottom of the track with the smaller of the pairs of jamb brackets. Using a hand screw driver, loosely fasten longer edge of jamb brackets 10" from bottom of track using (1) 1/4" x 5/8" track bolt and (1) 1/4" flange nut.

NOTE: Make sure nuts are always on the outside of the track.

- In the center of the track, loosely fasten the larger of the jamb brackets.
- For doors over 8', install the remaining jamb brackets 10" from the top.
- Attach flag bracket to top of track using (2) 1/4" x 5/8" track bolts and 1/4" flange nuts.

NOTE: Flag brackets can accommodate thickness of the door. Use additional slots for adjustments.

- Position the track over the rollers on door.
- Move track close to door so rollers are all the way into hinges & brackets leaving about 1/2" between edge of door and edge of track.
- When you're satisfied with the installation, use a power drill to secure tightly.

INSTALLING VERTICAL TRACK (CONTINUED)

- Use shims (if needed) to raise the track to match the level of the door (or the door will not work properly).

NOTE: Be sure the bottom of the track still fully encases the bottom roller.

- Drill the pilot holes for your lag screws to secure the flag brackets to the jamb using (3) 5/16" × 1-5/8" lag screws.

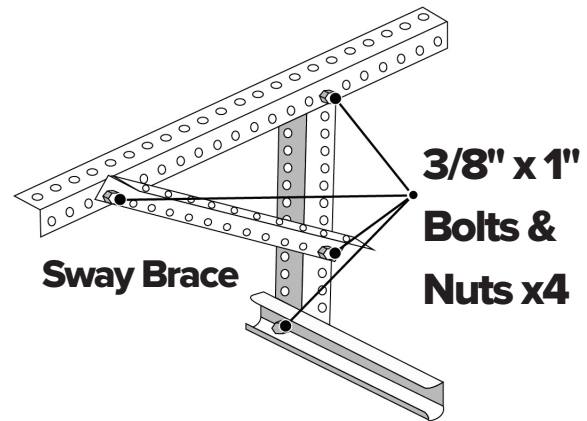
NOTE: Check that the tops of the flag brackets are level with each other or the door will not work properly. You may need to cut materials off the bottom of the track to accomplish this.

- Once flag brackets are securely fastened to jamb, tighten track bolts and flange nuts connecting flag brackets to tracks.

INSTALLING HORIZONTAL TRACK

- Temporarily support the backends of the horizontal track with the top of a ladder or suspended in a rope secured to supports above.
- Place curved end of horizontal track over roller in top bracket.
- Add support to the top end of the track you just secured with horizontal angle by attaching one end to the curved track and the other to the flag bracket using 3/8" × 3/4" carriage bolt and 3/8" hex nut. Be sure the nuts are on the outside of the track.

NOTE: Curved and vertical track should align smoothly to form one continuous track.



ASSEMBLE REAR TRACK HANGERS

Use perforated angle (not included) to create sway free supports for the rear end of the horizontal track. Attach these to ceiling joists and ensure they are strong enough to support the full weight of the door.

WARNING

Braces must be strong enough to support the weight of the door and prevent the tracks from spreading, allowing the door to fall. The bolts attaching the angle to the back of the track must be at least 1" long to act as a stop, preventing the door from exiting the track.

- Use 1-1/4" × 1-1/4" punched angle, at least 13 gauge or 3/32" steel to make two rear track hangers with sway braces.
- Placement should be with 6" of the end of the track to properly hold horizontal track level and square to door.
- Determine squareness by measuring diagonal corners of the track, from top left-hand corner of door to rear of right-hand horizontal track and top right-hand corner of door to rear of left-hand horizontal track.
- Diagonals should be within 1/2" of each other and horizontal track can slope out of level less than 1" from front jamb to rear track hanger.

- Once track is square, permanently fasten supports to ceiling with (3) 5/16" × 1-5/8" lag screws.
- Make sure the distance between the two sides of track is the same between the base of the vertical track by the floor, the two of the vertical track by the curve and the end of the horizontal track by the rear track hangers. All three measurements should be within 3/8" of each other.
- Once secured, you can carefully remove the rope or ladder support.

WARNING

Be sure rear track supports are secured to ceiling joists to support the weight of the track and garage door. Failure to do so may cause serious injury.

ADJUST TOP SECTION

- The top section of the door can now be adjusted with the track in place.
- With the door in the closed position, push the top section tight against the opening and lightly pull the top slide toward the inside of the garage. Tighten the slide on the top fixture.
- Adjust the roller so it is tight against the inside groove in track and tighten slide bolts.
- Remove all temporary nails holding the sections in place.
- Pull Rope Installation can now be installed only if an electric opener is not used. To do so, attach one end of the pull rope to the Safety Bottom Bracket and the other end to the second Jamb Bracket. **DO NOT INSTALL PULL ROPE IF ELECTRIC OPENER IS USED.**

INSTALL LOCK (IF INCLUDED)

EXTERIOR KEYED LOCK

- If the door has an exterior lock, follow the instructions provided with lock hardware to complete the installation.

INTERIOR SLIDE LOCK

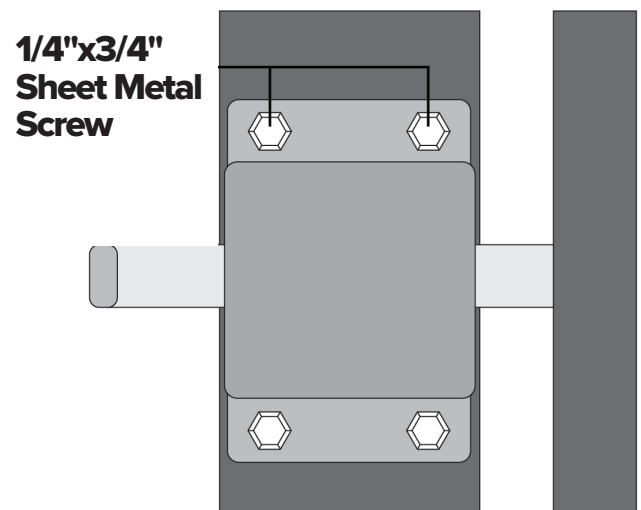
- Use the track as a guide to align the lock properly.
- Place the slide bolt against the top of a rectangular engaging slot in the vertical track.

NOTE: A slug may need to be knocked out to make an opening for the lock engagement. To remove the slug, use a screw driver and hammer to punch the slug out from the track.

- Install inside slide bolt on the end stile of second section. Use 1/4"×3/4" hex head sheet metal screws for steel doors or 1/4" × 1" lag screws.

NOTE: 3/16" holes may need to be pre-drilled before installing screws.

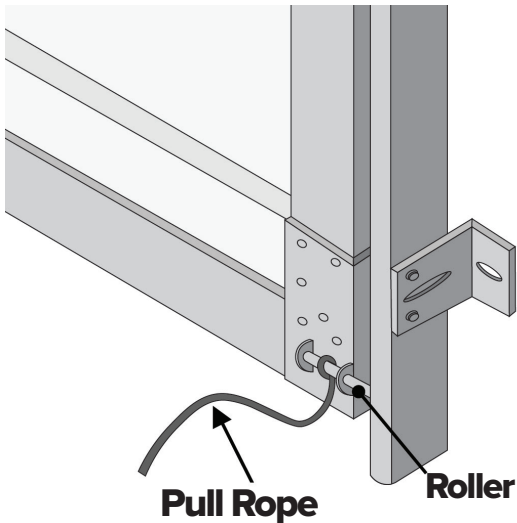
IMPORTANT: If the door has an automatic opener, always make sure the door is unlocked before using the opener. This will keep from damaging your door.



ATTACHING PULL ROPE

- To install the pull rope, attach it to the shaft of the roller in the bottom bracket of the door.

NOTE: Pull ropes are only to be used on manually operated doors. DO NOT INSTALL PULL ROPE IF THE DOOR HAS AN AUTOMATIC OPENER.



WARNING

Remove the pull rope to avoid strangulation or personal injury, when installing an automatic garage door opener.

ATTACHING AUTOMATIC GARAGE DOOR OPENER

NOTE: To avoid damage to the door, it's imperative to reinforce the top section of door. This provides a mounting point to attach the opener. Not reinforcing the door as illustrated will result in a void door warranty.

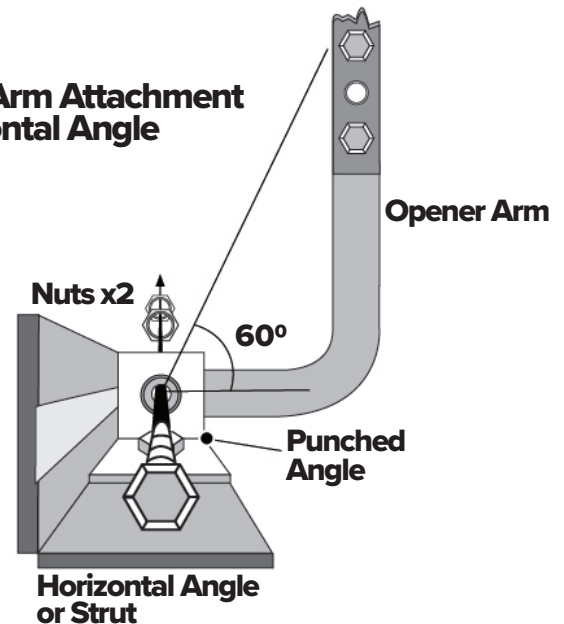
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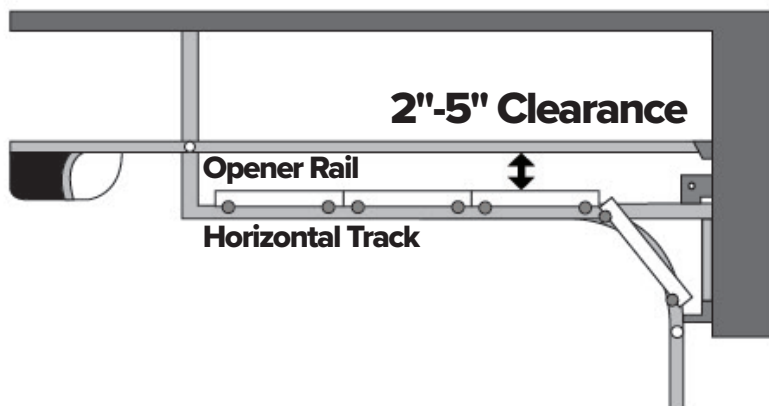
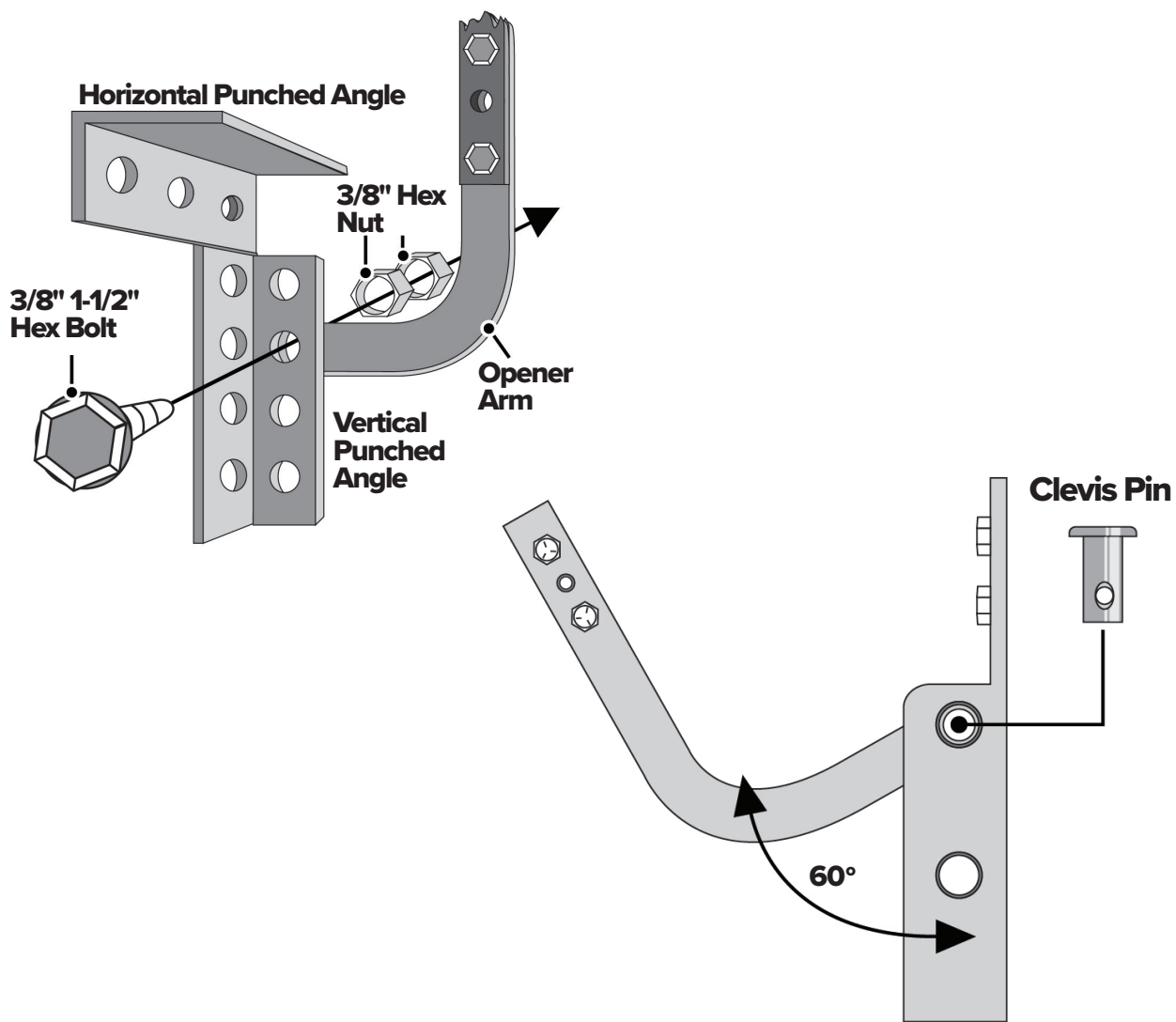
If you previously installed a door lock, remove it at this time. Failure to remove the lock will damage the door and void the warranty.

- The opener rail should be installed greater than 2" and less than 5" from the face of door, in the open position. This will prevent the top of door from bending.
- Follow the automatic operator manual instructions.
- Install opener arm to vertical reinforcement. This should be around the same height as the top roller on door.
- When the door is in down position, it should be angled around 60 degrees.

NOTE: When installing an automatic garage door opener, follow manufacturer's installation and safety instructions carefully.

Opener Arm Attachment to Horizontal Angle or Strut





MAINTENANCE FOR ALL NON-INSULATED GARAGE DOORS

Invicta Doors need regularly scheduled inspection, lubrication and cleaning. This checklist will help keep your door working well and help it in tough elements.

WARNING

Springs, bottom brackets, cables and hardware on the door are under high tension. They can cause death, serious injuries, or damage to the door if not handled properly. Follow these instructions to keep yourself and others safe:

- Do not loosen or remove bottom bracket with the spring tension engaged.
- If the spring is broken, do not operate door
- If handles are not installed or functioning properly, do not operate door manually
- If the door opens too quickly, the rollers fall of the track or the door is too difficult to move up and down, do not operate.
- If glass or window retainer is loose, cracked, or warped, do not operate the door. Do not remove screws on retainer.
- For assistance with these maintenance steps, repair or replacement of any parts, please contact us. (833)-772-3667

LUBRICATE THE DOOR

Twice per year, lubricate all moving parts of the door:

- Lift cables at bottom bracket button.
- Lock hardware where surfaces turn or slide.
- Full length of torsion spring to reduce friction between coils.
- Rollers at the bearing (but not the tire)
- Hinges

VISUAL INSPECTION CHECKLIST

We recommend inspecting your garage door once a month for problems. If something seems wrong on the door, please contact Invicta support team: (123)-456-7890

Inspect the door in the down position for:

- Loose or bent hinges.
- Broken wheels, bent shafts or worn out bearings on rollers.
- Loose or missing bolts, screws, or other fasteners on the door or track.
- Creases or bends in the track.
- Cracking or fatigue of the door panels.
- Damaged or broken springs or spring components. If the spring looks broken it will need replaced.
- Standard extension springs that run alongside the horizontal track must include a safety containment cable.
- Worn or frayed cables.
- Loose, cracked, or warped glass panels or inside glass retainers. Inside the door, the plastic retainer and holding the glass and its fasteners should appear secure.
- Tears or gaps in the bottom weather seal or perimeter seal.
- Any covered, ripped, damaged, or missing warning labels.
- Any missing, broken, loose, or malfunctioning door handles. There should be two lifting points on the outside and two on the inside of the garage door.

DOOR OPERATION CHECKLIST

At least twice per year, we recommend you visually inspected the door parts.

- Check the balance of the door.
 1. Put the door in the down position, then detach the opener by pulling down on the red manual release handle.
 2. Next, manually lift the door halfway up and release the door. If the door is balanced, it should stay in place and not raise or lower. If the door does not stay in place contact our support team.
- Check the door operation.
 - Lift the door up and down making sure it moves smoothly. The door should be easy to control lifting and lowering.

NOTE: Make sure to reattach the opener once you have gone through the first two steps of the checklist.

- Check the safety feature for automatic operating doors:
 - If an automatic operator is installed, ensure door locks are disabled or removed.
 - Retest the operator following the manufacturer's instructions.

STEEL GARAGE DOORS

CLEANING & PRESERVING THE DOOR

Clean the door at least twice a year or four times a year for harsher climates. This helps prevent rust. Loss of warranty could result if not followed. Any questions, please contact the Invicta support team. (833)-772-3667

CLEANING THE DOOR

From top to bottom of the door sections, use a soaked rag, sponge or soft bristle brush and one of these solutions:

- One cup of non-toxic biodegradable cleaner into two gallons of warm water.
- Household liquid dishwashing detergent.
- DO NOT USE scouring powders or solvents to clean
- Rinse off door with clean water and allow to dry to finish the door cleaning.

NOTE: Make sure to clean behind stop molding on the top and sides of the door.

WINDOW CARE

REMOVING DECORATIVE INSERTS FOR CLEANING & PAINTING PURPOSES

NOTE: Do not remove the screws from the window frame.

- To remove the inserts, pull the center of the insert firmly out of the window.

- Replacing the insert is the reverse of taking out. There are tabs on each end of each leg of the insert. The four tabs must be under the lip in the window frame.

WINDOW CLEANING

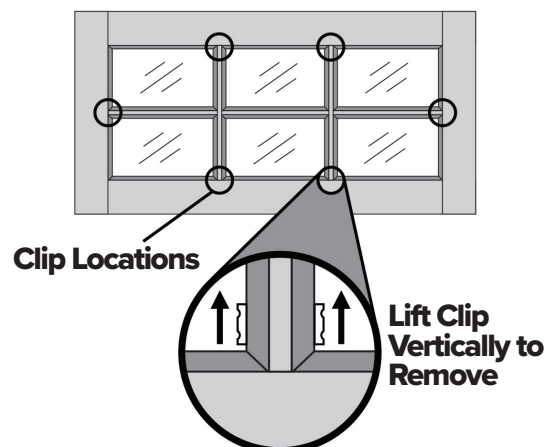
- Use a mild solution of a dishwashing detergent and a soft cloth to clean the window properly.
- For acrylic, impact, or decorative windows: Only use a clean, soft sponge or cloth with mild dish soap and lukewarm water. Drying with soft cloth or chamois will prevent spotting.
- Ammoniated, abrasive or solvent-based cleaners of any kind should not be used.
- Do not brush, scrub or scrape the windows.
- Rinse thoroughly when finished cleaning.

GLASS REPLACEMENT

WARNING

Two people are needed to replace door windows.

- Follow the steps below to replace the window on your door:
 1. One person hold the outside frame, while the other removes the screws from the inside frame retainer.
 2. Remove inside frame from door. Remove broken or old glass carefully. Insert new glass.
 3. One person hold the outside frame, reinsert screws into inside frame, securing glass.



 **WARNING**

Use extreme caution when handling glass window pane to avoid injuries. With frame removed, avoid contact with exposed steel edges as they may be sharp.

PAINTING THE DOOR

 **WARNING**

Failure to follow these instructions may cause damage to your door, which will result in loss of warranty.

REQUIRED PAINT

- High quality 100% acrylic latex exterior grade paint should be used to paint the door.
- Oil-based paint or alkyd modified paint should not be used as they will void the warranty.

NOTE: We recommend all doors are painted with solar reflective paint. These paints help reflect more sunlight keeping the surface of the door cooler.

PREPARING THE SURFACE

- Clean the door, window frames and inserts making sure they are free of dirt, oil, caulk, waxes and mildew.
- Lightly sand the entire exposed door with medium sandpaper (wet 300-600).

CLEANING THE DOOR FOR PAINTING ONLY

- Make a solution of 1/3 cup trisodium phosphate, and add it to 1-1/2 to 2 gallons of water.

 **WARNING**

Do not use unless you are painting the door.

 **WARNING**

Never blend cleaners or ammonia with bleach.

- Rinse with clean water and sponge, making sure to change the water often.

NOTE: Remove all wax applied to the door before cleaning.

PRETESTING PAINT

- Paint on a small area of door.
- Let paint dry and check for any peeling.
- Test the adherence by placing masking tape over the paint and peel back tape. Make sure the paint stays on the door and does not peel off with the tape.

APPLYING PAINT

Follow directions provided by the paint container and apply to door.

NOTE: Refrain from applying paint when door surface temperature is outside the suggested temperature range for application.

PAINT REPAIR

To prevent rust from forming on the door, it is important to repair the damaged area so that no bare metal is exposed.

- Lightly sand the area with medium to fine sandpaper. If there is visible rust, make sure to remove it.
- Wipe this area with dry, clean rag.
- Coat sanded area with rust inhibiting primer.
- Check the primers instructions for drying before painting the door.



INVICTA
DOOR®