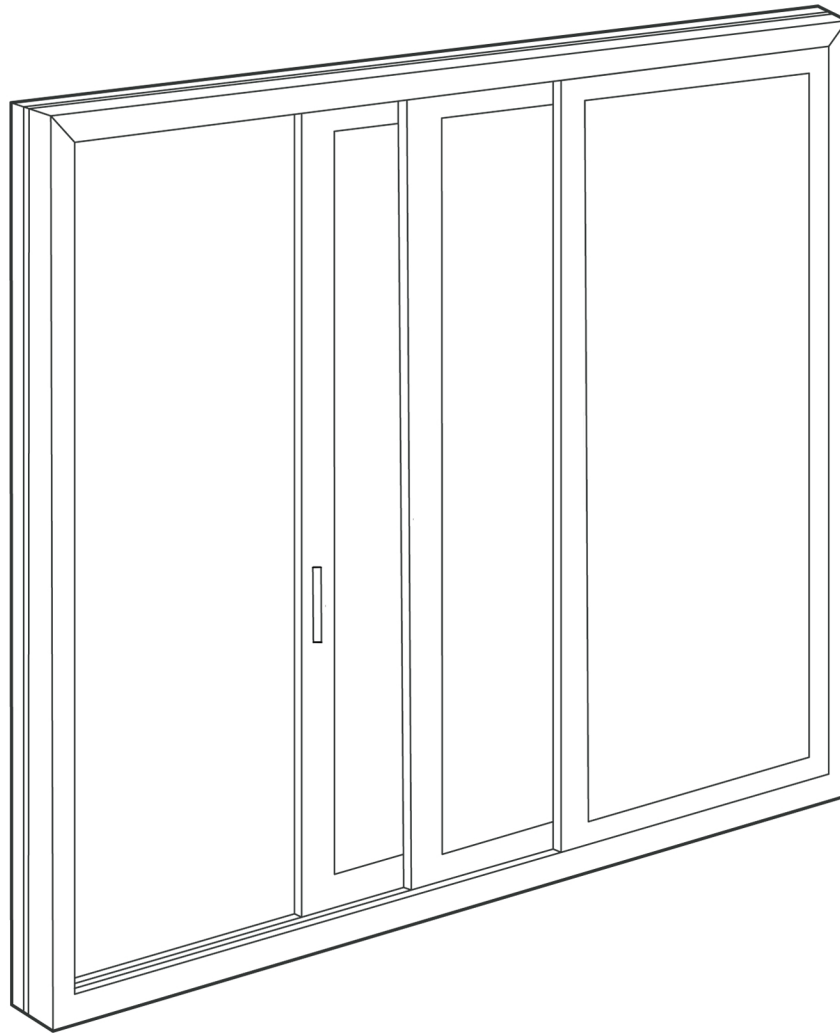


S3000 & S4000 Sliding Doors

Installation Instructions



IMPORTANT NOTICE

Read these instructions thoroughly before beginning to install your RAM window or door product. Follow all guidelines regarding material use, preparation, personal safety and disposal. Failure to follow RAM's installation instructions and any other specific warnings, procedures for use, safety recommendations and standard construction practices can result in personal injury, poor product performance, and premature failure. Contact your RAM supplier if you have any questions regarding product and materials used in manufacturing. It is the responsibility of the builder, installer and subcontractors to protect the interior and exterior of RAM windows and doors from excessive contact with harsh chemical washes, construction material contamination and moisture.

Care and Maintenance

Every RAM window and door product has been designed and tested to meet or exceed industry performance and engineering standards. The key to preserving this performance is the proper installation, care, and maintenance of these products. Failure to perform regular maintenance will cause degradation of your window or door product and will void the manufacturer's warranty. Detailed care and maintenance instructions can be found on our website at ramwindows.com.

Cleaning Instructions

In addition to proper care and maintenance, all RAM window and door products should be cleaned using approved chemicals and solvents that prevent product degradation. A more detailed listing of cleaning methods and warnings can be found on our website at ramwindows.com. General cleaning instructions are as follows:

FRAMES: As with any building product, aluminum requires reasonable care during the installation process as well as periodic cleaning and maintenance after installation. Although both painted and anodized aluminum has excellent corrosion resistance properties, its natural beauty can be marred by harsh chemicals, abrasive materials or neglect. Such conditions usually affect only the surface appearance and do not reduce the service life of the product, however, the marks resulting from such mistreatment may be permanent.

During and immediately after installation:

- Protect all surfaces. It is especially important to not allow stucco or other concrete materials to set on the anodized or painted finish. These building materials are caustic and will permanently damage the finish.
- Clean metal surfaces with mild soapy water, using a sponge or soft cloth.
- Rinse thoroughly by lightly spraying with clean water and repeat as needed.
- Wipe dry with a soft cloth.
- Make sure all weep holes, drain holes and tracks are unclogged.

GLASS: To preserve the visual and energy performance of your window or door, the glass units require reasonable care and attention. The glass surface, especially tempered glass, can be easily scratched or permanently damaged by improper cleaning.

NOTE: Please reference Cardinal Glass Industries for proper handling of glass. More information can be found at cardinalcorp.com.

During and immediately after installation:

- Protect all surfaces. It is especially important to not allow stucco or other concrete materials to set on the glass surface. These building materials are caustic and will permanently damage the glass surface.
- Clean glass surfaces with mild soapy water, using a sponge or soft cloth.
- Rinse thoroughly by lightly spraying with clean water and repeat as needed.
- Wipe dry with a soft cloth.
- Make sure all weep holes, drain holes and tracks are unclogged.

• **HELPFUL TIP:** WINDOW AND DOOR STICKERS CAN BE MORE EASILY REMOVED IF SOAKED BY WATER FOR FIVE MINUTES PRIOR ATTEMPTED REMOVAL.

COMPONENTS: The internal and external components of your product are essential to the proper function and overall performance of your window or door. While these components have been designed for rugged durability, they still require regular inspection and maintenance to ensure proper operation.

During and immediately after installation:

- Vacuum out and clean any dirt or debris from the sill, roller assembly and track areas.
- Lubricate the hardware components, roller assembly and track with a wet silicone spray using a straw applicator.
- Inspect the weather-stripping to make sure it is clean and not torn or brittle.
- Inspect the window or door locks to make sure they function properly. Contact the manufacturer to adjust the locks if needed.

SUPPLIES REQUIRED:

- Anchors (included)
- Moisture Resistant Shims (wedge or horseshoe shims, unless specified by building codes. Long enough to reach full framed depth.)
- Closed Cell Foam Backer Rod
- Window & Door Butyl Flashing Tape
- Installation Sealant
- Sill Pan (recommended, but not required unless specified by code)

TOOLS REQUIRED:

- Laser Level
- Tape Measure
- Drill
- 1/8" drill bit - 6" long
- 9/64" drill bit
- 5/16" drill bit
- 1/8" drill bit
- #2 Phillips Screwdriver (min 8" shank)
- #2 Phillips Impact Bit
- Flat Head Screwdriver
- Square
- Plumb Bob
- Utility Knife
- Impact Driver

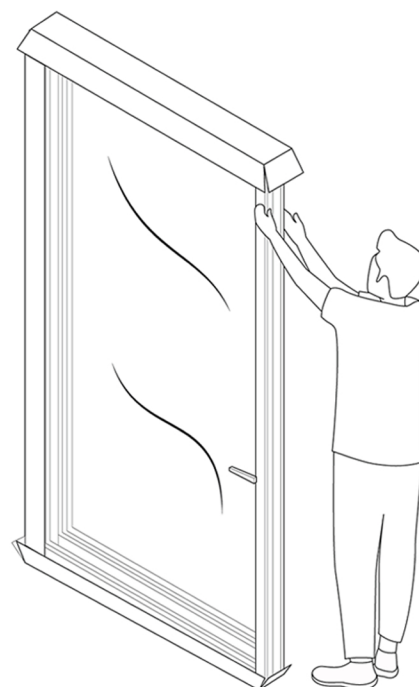
Other construction materials may be required. Read the instructions and inspect the wall conditions before you begin.

Store doors in upright position, out of direct sunlight.

TWO OR MORE PEOPLE WILL BE REQUIRED FOR THE DOOR INSTALLATION.

1 PREPARE FOR INSTALLATION

- Remove plastic wrap and cardboard packaging from the door.**
- Inspect the product for any damage** such as cracks, dents or scratches. DO NOT install damaged doors.
- Remove dirt and debris** from all surfaces.
- Read the entire installation instructions before proceeding.**

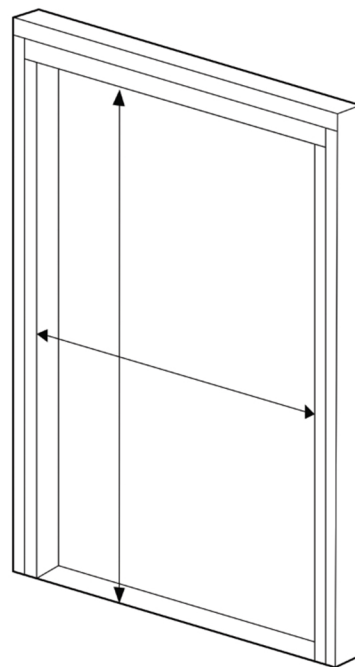


2 PREPARE THE ROUGH OPENING

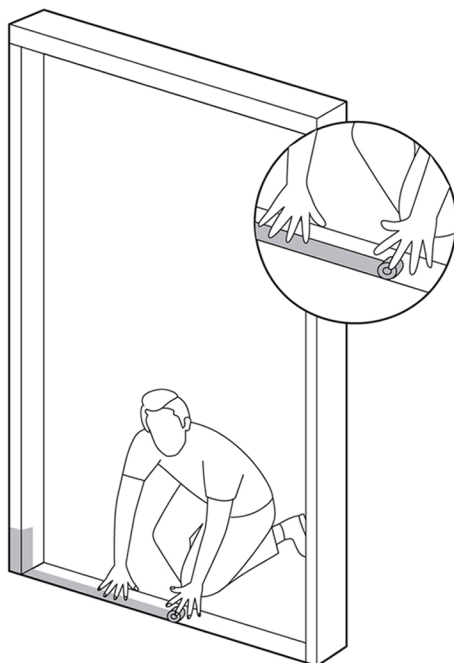
- A. **Plumb, square, and level the rough opening.**
The opening should not be more than $\frac{1}{4}$ " out of square, level, and plumb.
- B. **Seal the rough opening with butyl flashing tape**
in accordance with local building codes.

Note: If sill pan is required by code, install the sill pan onto the door at this step.

2A

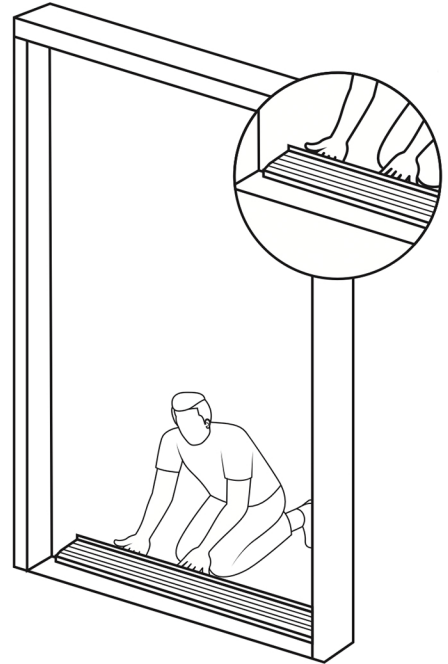
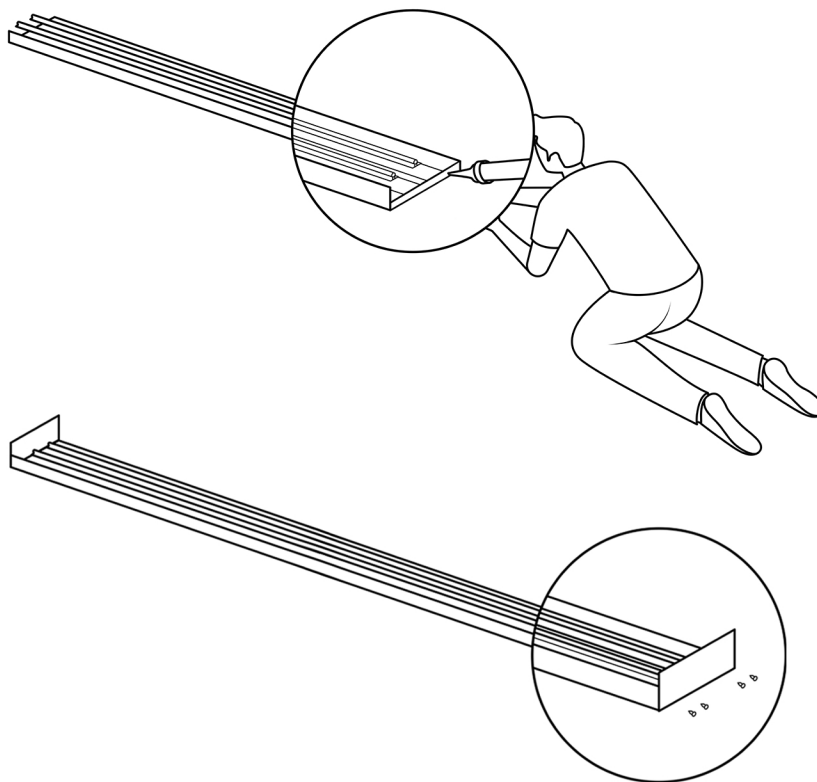


2B



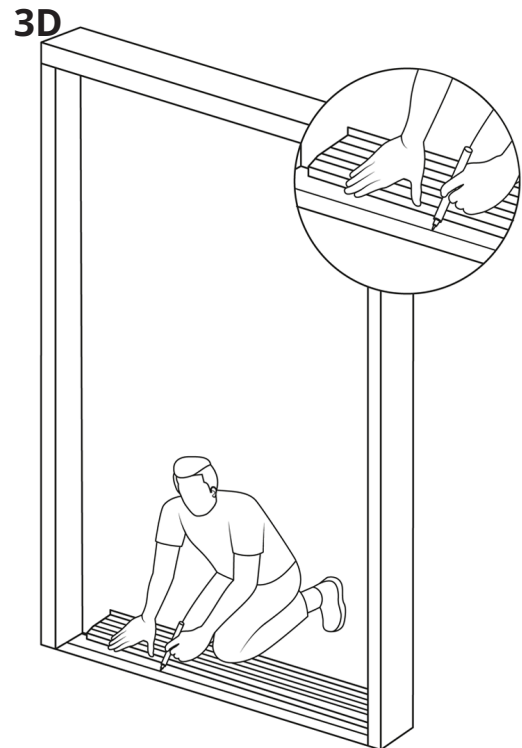
3-A BLOCK FRAME INSTALL

- A. **Ensure the floor is flat and level**, and does not vary more than .0625" (1/16") per foot or a total of .25" (1/4") over the entire width of the opening.
Note: Repairs must be made if the floor does not meet specifications. Shimming under the sill is not recommended.
- B. **Install end plates on head and sill.** Apply a liberal amount of sealant to ensure a seal between end plate and head and sill.
- C. **With weep holes facing the exterior, position the threshold assembly on the floor** in the approximate location and ensure alignment on the interior and exterior of the structure.

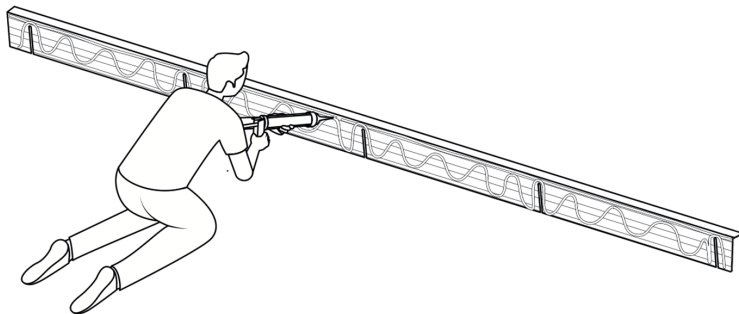
3A**3B**

3A BLOCK FRAME INSTALL CONTINUED

- D. **Inspect the mating surface of the sill and floor** and mark any gaps that are present. Any voids or bumps will need to be filled/shimmed or smoothed before installation. Sill must be fully supported.
- E. **Ensure the head can be installed directly above the sill** on both ends. Mark the sill around the entire perimeter to guide final installation.
- F. **Apply a liberal amount of approved sealant** around the weeping slots as to not block water from evacuating the system. Add an additional generous bead in a straight line across the entire length of the sill behind the weeps, and straight lines along the length in between each weep.



3F



3A

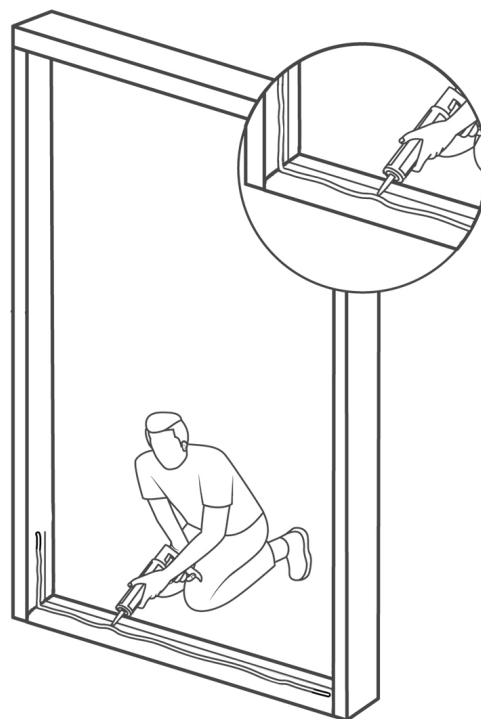
BLOCK FRAME INSTALL CONTINUED

- G. **Apply a 1/2" wide by 1/2" high bed of sealant** on the floor along the exterior side of your mark along entire length of opening, applying 6" up the jamb and from the inside corners across the end to the outside edge of where the Threshold Track assembly will be.

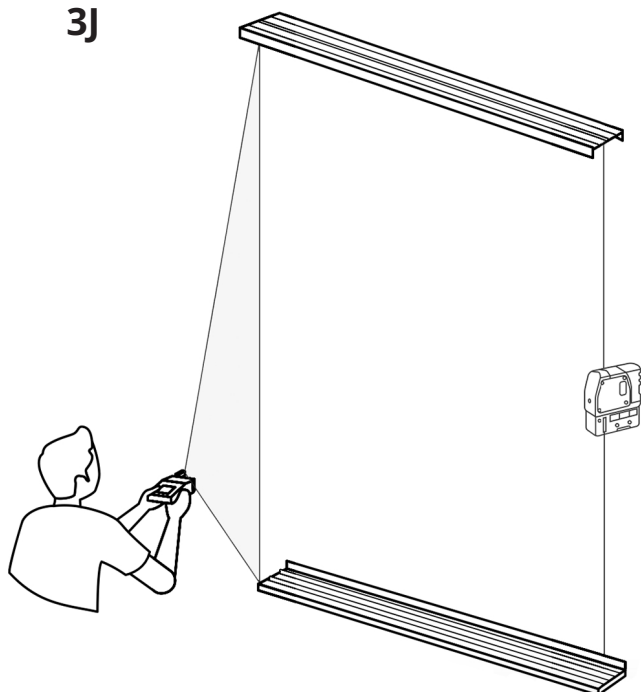
Note: Ensure water barrier has no voids across the full width of the opening.

- H. **Using marks from Step 3E, set sill in place** and level as required. Once in place, walk across the entire sill to help sealant settle.
- I. **Inspect header to ensure sufficient backing** for anchors.

3G



3J



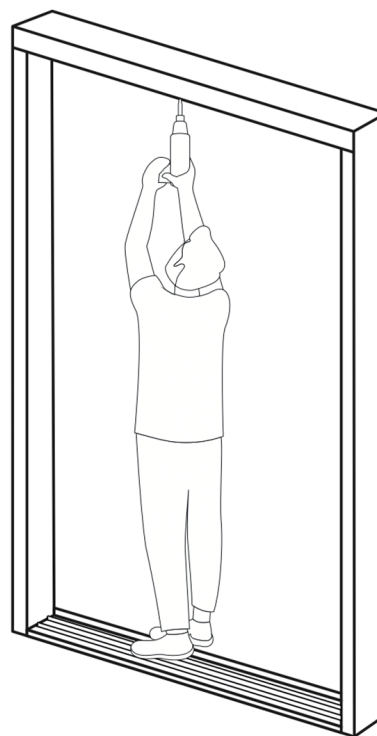
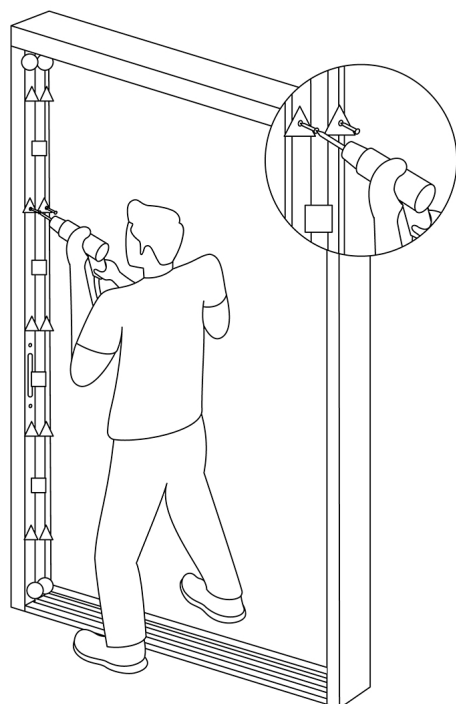
- J. **Using a laser level, mark the position for the head track** directly above the sill, and ensure square and plumb with a plumb bob, laser or similar tool. Loosely fasten head into place through predrilled holes using supplied #10 fasteners, drill pilot holes into wood as necessary.
- K. **Properly seal the holes and endplate** on head and threshold and place jamb into position. Adjust head height to properly align with the endplate holes.

3A BLOCK FRAME INSTALL CONTINUED

L. **Anchor head through predrilled holes** using supplied #10 fasteners, being sure to apply sealant between fasteners and anchoring holes. Ensure that the head is plumb, level, square and parallel with the sill.

M. **Anchor the jambs, being sure to apply sealant between fasteners and anchoring locations.**

Start by loosely installing end plate fasteners (circles). Then anchor the middle fasteners (squares) to ensure plumb, level, square. Then anchor the outer fasteners (triangles) while using a straight edge to ensure flatness. Finally, finish in stalling end plate fasteners. In each cavity, using a 9/64" drill bit, drill a clearance hole through the thermal break every 18" starting at the middle and working toward the top and bottom. Use supplied #10, 3" long fasteners to anchor jamb to rough opening, use shims to ensure frame stays plumb, level and square. Finally, finish installing endplate fasteners.

3L**3M**

N. **1. Fill any voids between the frame perimeter and the opening** with closed cell foam backer rod.

NOTE: DO NOT use expansion foam.

NOTE: Make sure the backer rod is double the size of the opening it's meant to fill.

2. Use a compatible sealant to seal on top of the backer rod around the perimeter of the door.

3. Ensure the sealant creates a watertight and weatherproof seal around the door.

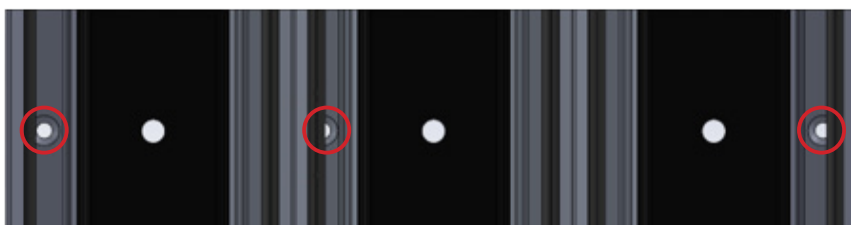
3B NAIL FIN INSTALL METHOD

- A. **Ensure the floor is flat and level**, and does not vary more than .0625" (1/16") per foot or a total of .25" (1/4") over the entire width of the opening.

NOTE: Repairs must be made if the floor does not meet specifications. Shimming under the sill is **NOT** recommended.

- B. **Install endplates onto head and sill frame members**, using silicone around frame section to ensure watertight seal.
- C. **Drill #6 clearance holes (#25 drill bit)** in line with predrilled endplate holes on jamb, on head and sill side.

3C



- D. **Assemble frame on the floor** utilizing #6 self-drilling fasteners through clearance holes in previous step. Use precautions to avoid damaging frame finish. Seal the corners using the silicone where the jamb meets the head and endplate.

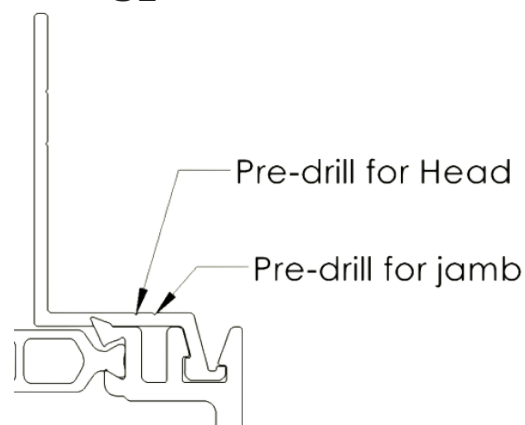
- E. **Install the nail fins by predrilling the nail fin** utilizing the integrated scribe line for the provided fasteners in 3 locations each (near top, middle and bottom). Install and seal provided corner brackets. Jamb utilize a 4-40 fastener, (1/8" drill bit). Heads use a 5/16" fastener, (5/16" drill bit).

- F. **Dry fit the frame to ensure proper fitment** and pencil mark the interior length of the sill and weep locations. Repair any foundation flaws, if necessary, before proceeding to the next step.

- G. **Predrill nail fins for install fasteners every 12"**.

- H. **Clean the rough opening surfaces and apply silicone** to either the sill or foundation. Use the marks from the previous step to ensure sealant is placed in proper locations. Be sure to apply silicone so as not to block weeping. Continuous 1/2" bead across the interior side of the sill and 6" up each jamb.

3E

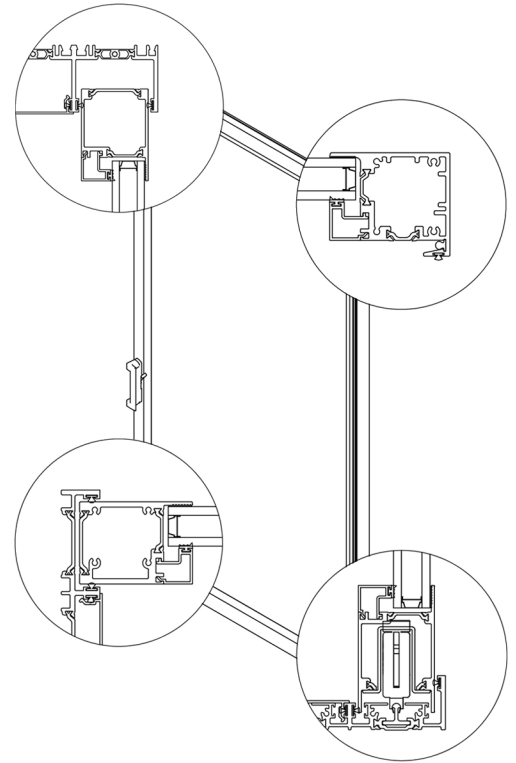


- I. **Place frame in the center of the rough opening and temporarily shim.**
- J. **Install fasteners into sill using substrate** approved #10 (or equivalent) flat head screws. Apply silicone to screw holes before driving fasteners through substrate.
- K. **Plumb, level and square the unit** and fasten nail fins to opening using #10 flat head screws.
- L. **Shim and fasten head and jambs to RO**, ensuring unit stays plumb level and square. Be sure to apply silicone to each screw hole before driving fastener through.

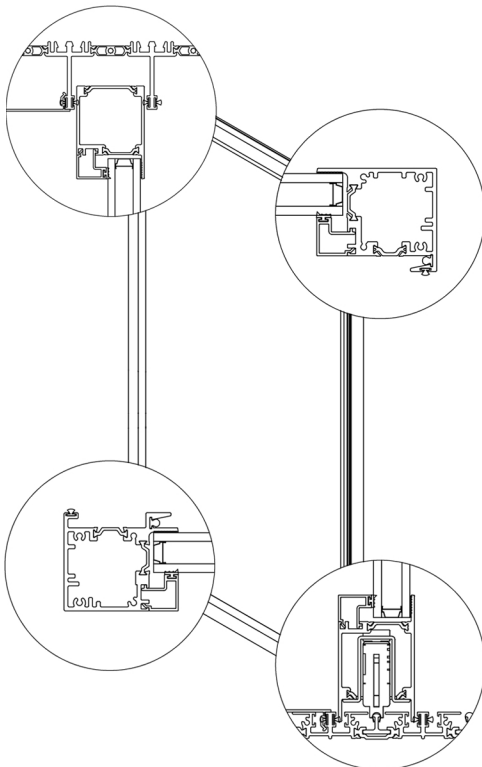
4 PANEL INSTALL

- A. **Identify Lead Panel** - This panel will have a handle and a lock mechanism. Position the panel so the glazing stops are facing exterior. If biparting, there will be two lead panels. From the exterior of the building, with glazing stops facing outwards, lean and insert into the interior most head track, lifting while pivoting the door to the interior most threshold track. Adjust rollers to lift panel off threshold while maintaining contact with weather seals. Roll panel towards locking jamb and make final adjustments so the gap between the jamb and lock stile is consistent from head to threshold.

4A



4B



- B. **Identify Intermediate Panel (skip if 2 panel door)** - This panel will have two interlock stiles. Position the panel so the glazing stops facing the exterior. With half the panel overlapping the lead panel, insert the panel into the next track, lifting while pivoting the door to the next threshold track. Adjust rollers to match sightlines and with previous panel. Repeat for each intermediate panel.

4 PANEL INSTALL CONTINUED

STOP: DO NOT ANCHOR FIXED PANEL WITHOUT COMPLETING THE FOLLOWING STEPS.

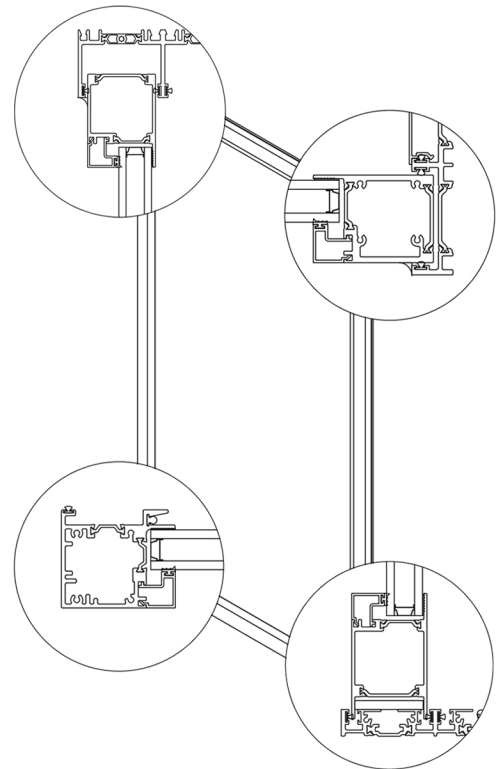
- C. **Identify Fixed Panel** - This panel will have one interlocking stile and one smooth stile without handle and locking hardware. Position previous panel so the fixed panel can be installed while overlapping 50% of the previous panel. Position with glazing stops facing exterior, lean and insert into the exterior most head track, lifting while pivoting the door to the exterior most threshold track. While lifting the panel, slide provided plastic spacer bar underneath panel. Use water approved shims to match sightlines to previous panel.
- D. **Make any necessary adjustments to rollers and shims** to ensure the best possible alignment.
- E. **Close door and lock lead panel.** If adjustments are necessary, complete now. Vertical adjustments are done by loosening strike mounting screws and sliding entire strike assembly up or down. There are also two spring loaded screws to adjust strike horizontally towards the lead panel. This should be utilized to remove or provide any necessary slack for effortless locking. Ensure proper locking is achieved before moving to the next step.
- F. **With lead panel fully closed AND locked**, gently close and engage the remainder of the panels until fixed panel is properly seated into the fixed jamb. Install exterior most head and sill track cover to prevent the panel from moving during security screw install. On the interior side, install provided fixed panel screws (#8 1-1/2") on the top middle and bottom of the panel. Be sure to drill appropriate pilot holes before installing screws.
- G. **Install the remainder of the head, sill and jamb covers.** Use a clean rubber mallet or plastic/wood block, free of burs to prevent damaging during installation.

- H. **Seal sill from jamb to jamb** on interior side only. Seal the jambs and head on the exterior only.

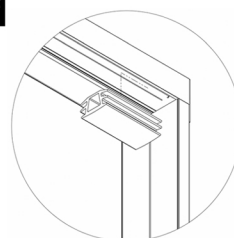
STOP: BE SURE TO NOT SEAL EXTERIOR SIDE OF SILL SO DOOR IS FREE TO WEEP PROPERLY.

- I. **Install supplied bumper stops** - only applies to units with contemporary handles.
 1. Push-in bumper stops [2-track systems]. Install into head cavity at fixed jamb(s). Once inserted, slide the bumper so that the face is contacting the end plate.
 2. Surface mount bumper stop [3 & 4 track systems]. Install using predrilled holes and supplied fasteners on bottom rail of intermediate panel(s).

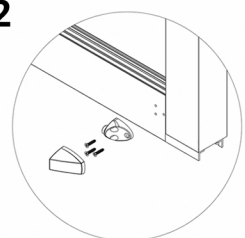
4C



11



12



5 FOAM INSTALLATION

1. Head Track - Adhesive Backed Closed Cell Foam & Dust Plug

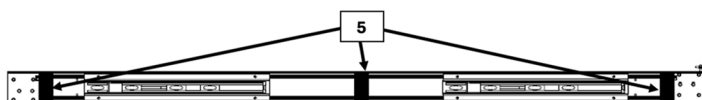
Install foam into the frame head track above interlock stiles. Determine install location after panels have been placed into the frame. Dust plug fins shall be oriented perpendicular to the head track.

2. Interlock Stile Head Notch - Adhesive Backed Closed Cell Foam

Install foam onto the interlock stile so that the gap between the head and interlock notch is filled. Foam should be installed once the panel has been set into the frame. The leading edge of the foam ramp shall be oriented towards the fixed panel jamb. If necessary, trim the width of the foam for proper fitment between the frame and interlock stile.

3. Interlock Stile & Sill Gap - Adhesive Backed Closed Cell Foam

Install foam onto the interlock stile so that the gap between the interlock and sill is filled. If necessary, trim the width of the foam for proper fitment between the frame and interlock stile.



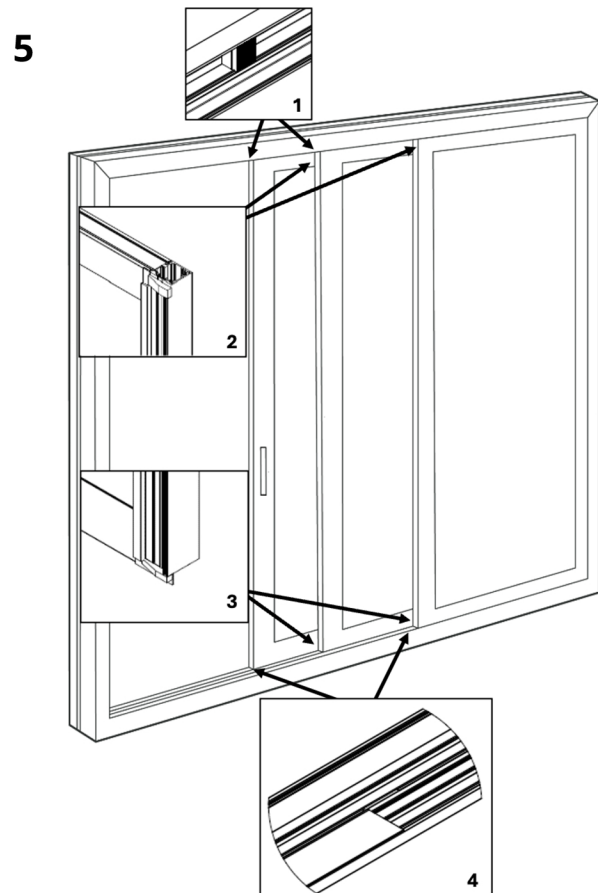
4. Sill Track Rail Extension Cavity - Open Cell Foam

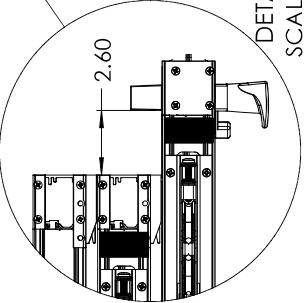
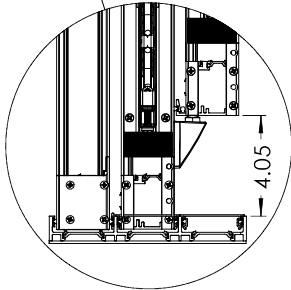
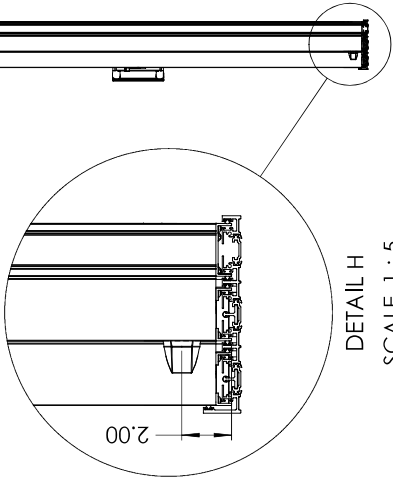
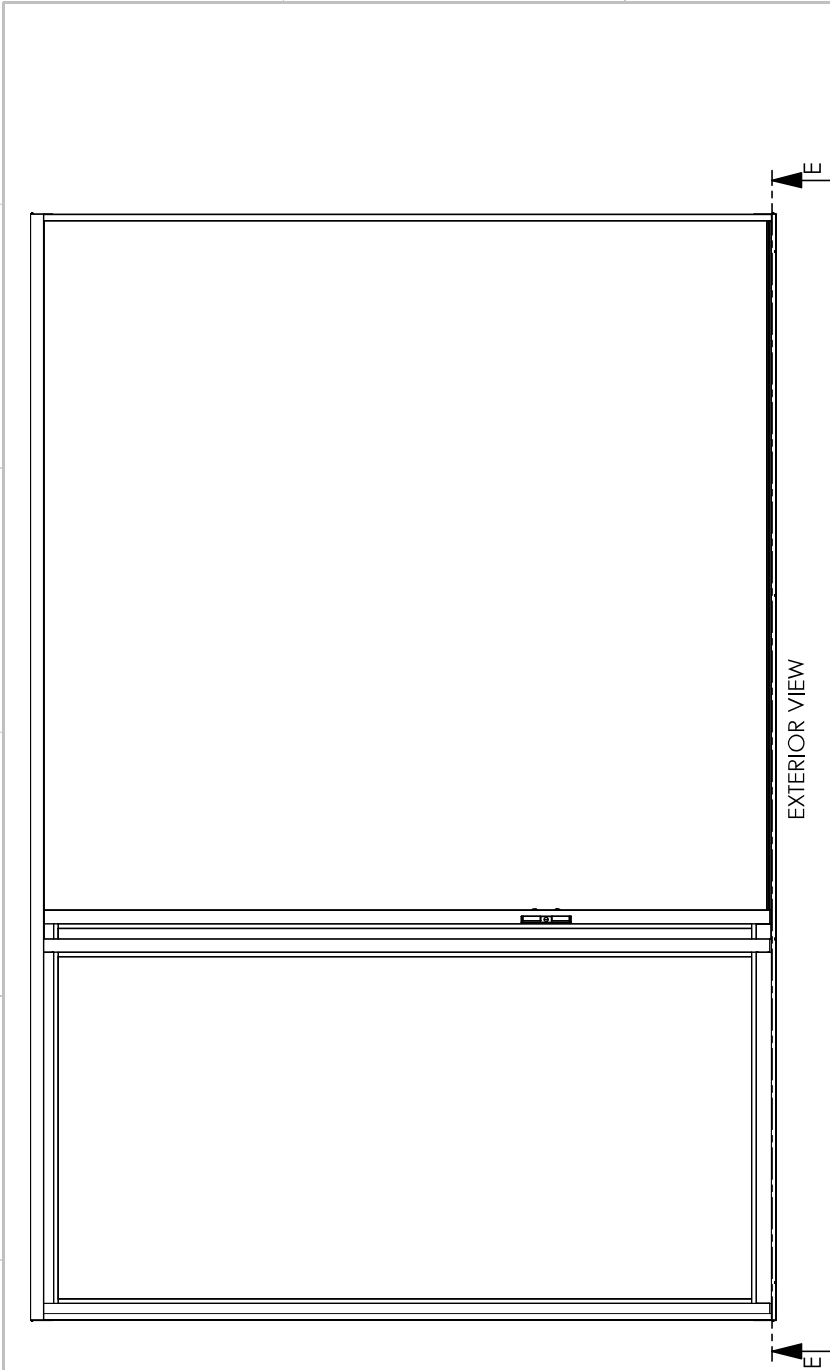
Install foam into the sill rail extension cavities. Determine install location with the door closed. Foam shall be placed under the rail extensions below the interlock.

5. Operable Panel Bottom Rail - Adhesive Backed Dust Plug

Apply one dust plug between each roller carriage and stile. Dust plug fin shall be oriented perpendicular to bottom rail.

Apply one dust plug at centerline of bottom rail. Dust plug fin shall be oriented perpendicular to bottom rail.





UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE
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FRACTIONAL $\pm 1/8$		TITLE:		
ANGLES ± 1 DEG		S3000 SGD, OXX, COMPLETE UNIT,		
ONE PLACE DECIMAL ± 0.2		CONTEMPORARY HANDLE,		
TWO PLACE DECIMAL ± 0.06		SURFACE MOUNT BUMPER STOP		
THREE PLACE DECIMAL ± 0.010		OPEN		
MATERIAL		SIZE	DWG. NO.	REV
PROPRIETARY AND CONFIDENTIAL		B	50000085	0
THE INFORMATION CONTAINED IN THIS		SCALE: 1:20		
DRAWING IS THE SOLE PROPERTY OF		SHEET 16 OF 16		
RAM WINDOWS & DOORS. ANY				
REPRODUCTION IN PART OR AS A WHOLE				
WITHOUT THE WRITTEN PERMISSION OF				
RAM WINDOWS & DOORS IS PROHIBITED.				

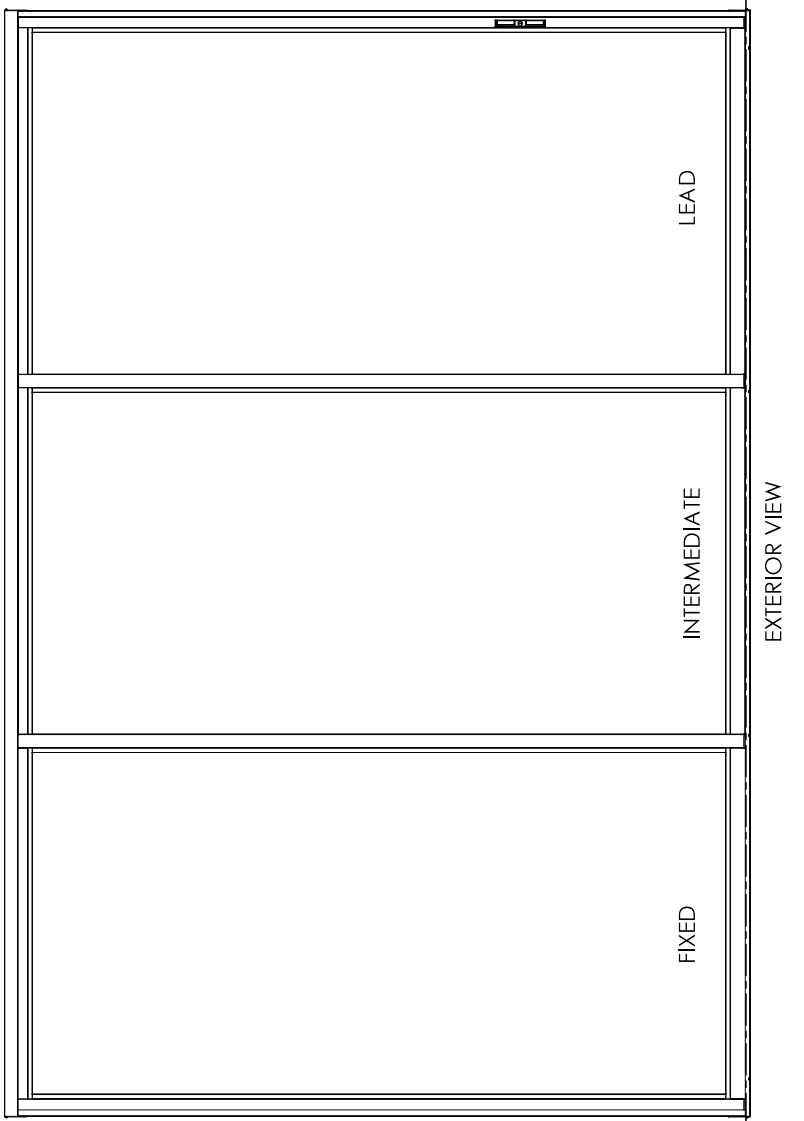
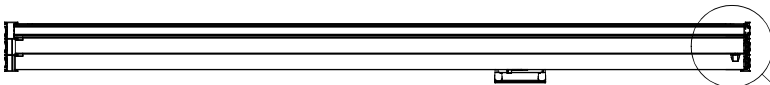
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D

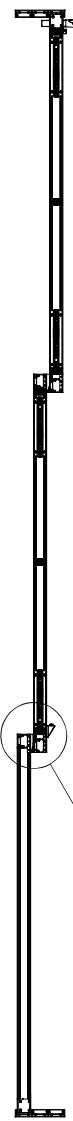
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B

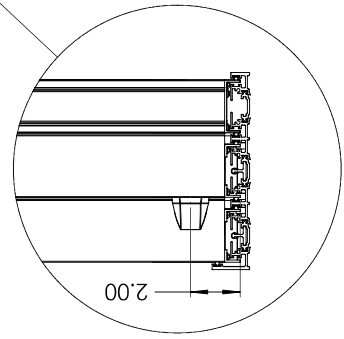
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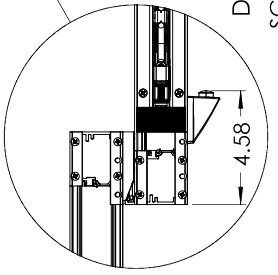
EXTERIOR VIEW



SECTION B-B



DETAIL D
SCALE 1 : 5

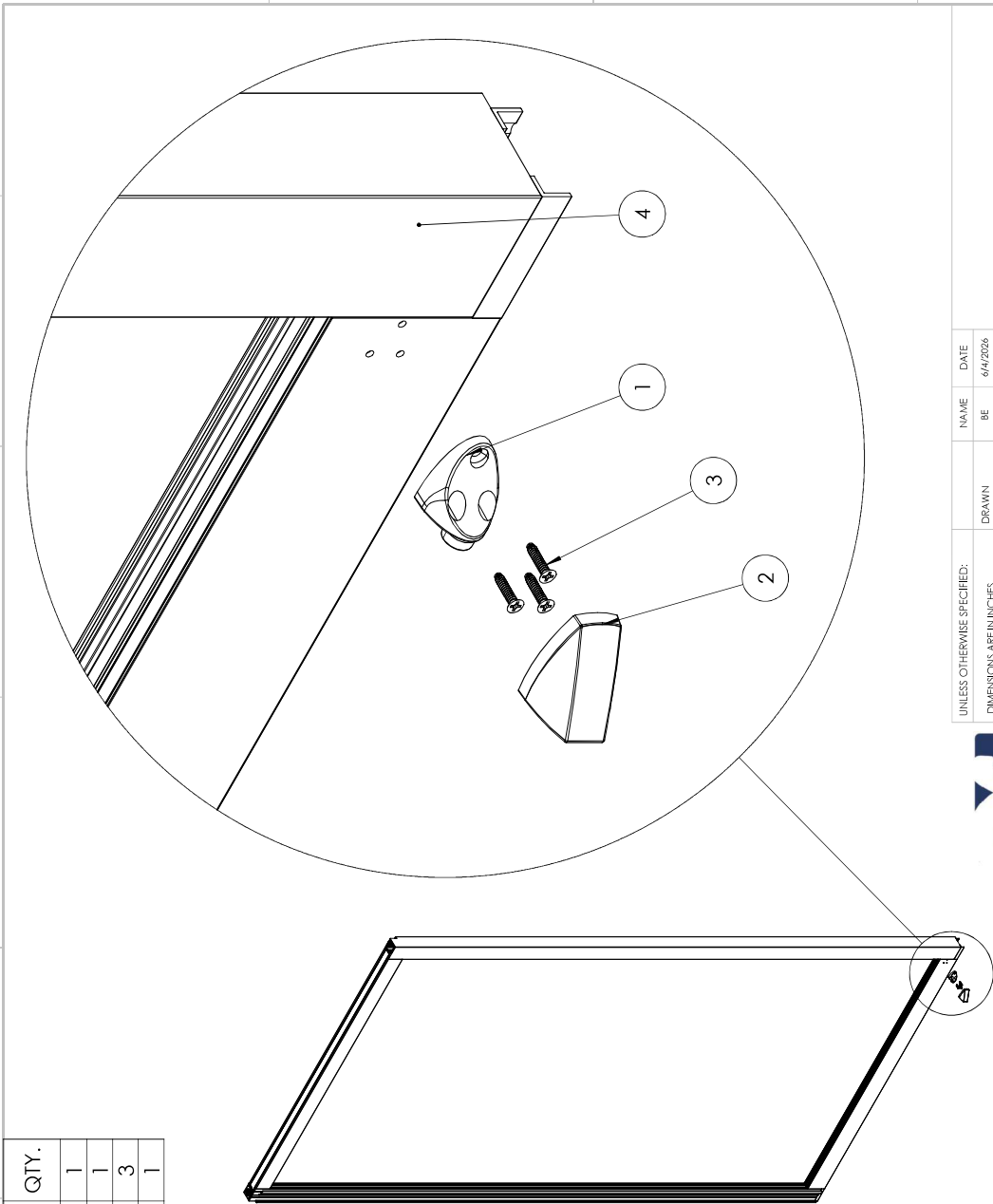


DETAIL C
SCALE 1 : 5



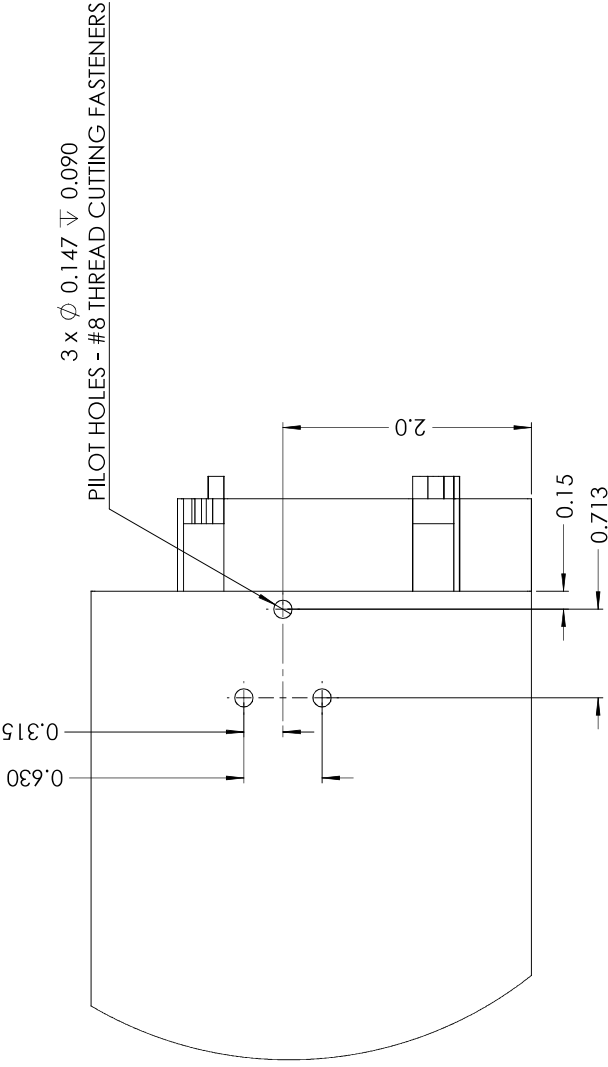
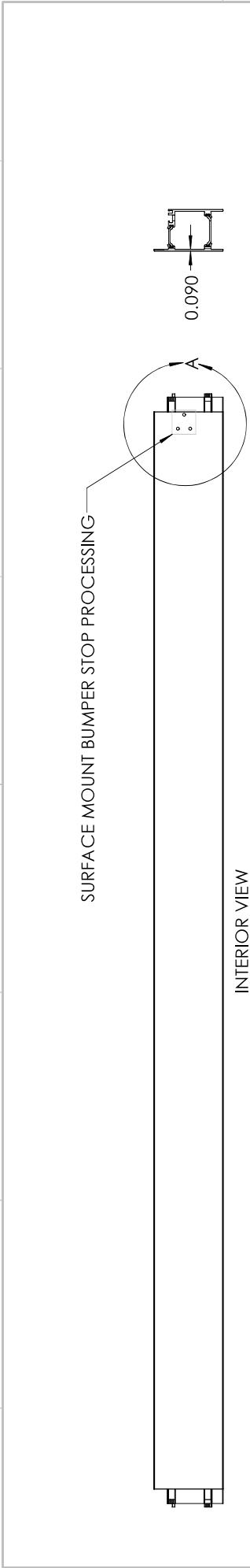
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FRACTIONS: 1/8		TITLE:		
ANGLES: 1 DEG		S3000 SGD, OXX, COMPLETE UNIT,		
ONE PLACE DECIMAL ±0.2		CONTEMPORARY HANDLE,		
TWO PLACE DECIMAL ±0.06		SURFACE MOUNT BUMPER STOP		
THREE PLACE DECIMAL ±0.010		CLOSED		
MATERIAL		SIZE	DWG. NO.	REV
PROPRIETARY AND CONFIDENTIAL		B	50000085	0
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM WINDOWS & DOORS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS IS PROHIBITED.		SCALE: 1:20		
FINISH		SHEET 15 OF 16		

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	30000169	SURFACE MOUNT BUMPER STOP - CHASSIS	1
2	30000169	SURFACE MOUNT BUMPER STOP - COVER	1
3	92485A 628	FS-N8-PFH-TCS-410-SS-10	3
4	50000084	S3000 SGD, OXX, INTERMEDIATE PANEL	1



UNLESS OTHERWISE SPECIFIED:	DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES FRACTIONAL ± 1/8 ANGLES ± 1 DEG ONE PLACE DECIMAL ±0.2 TWO PLACE DECIMAL ±0.06 THREE PLACE DECIMAL ±0.010	BE	6/4/2026	
ENGINEER	DATE		
CONFIGURATION			
OXX - INTERMEDIATE PANEL - BUMPER STOP			
MATERIAL	SIZE	DWG. NO.	REV
	B	50000085	0
FINISH	SCALE: 1:20		
RAM WINDOWS & DOORS IS PROHIBITED FROM REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS			

TITLE:
SGD - INTERMEDIATE PANEL -
SURFACE MOUNT BUMPER
STOP INSTALLED



REFERENCE TABLE	
CONFIGURATION	BOTTOM RAIL - BUMPER STOP PROCESSING
OXX	AS SHOWN
XOX	MIRRORED
OXXX	AS SHOWN
XXXO	MIRRORED
OXXXXO	LEFT INTERMEDIATE - AS SHOWN
	RIGHT INTERMEDIATE - MIRRORED
OXX	FIXED PASSIVE PANEL - AS SHOWN
XOO	FIXED ACTIVE PANEL - MIRRORED
OXXOO	LEFT FIXED PASSIVE PANEL - AS SHOWN
	RIGHT FIXED ACTIVE PANEL - MIRRORED
XOOOXX	LEFT FIXED ACTIVE PANEL - MIRRORED
	RIGHT FIXED PASSIVE PANEL - AS SHOWN



NOTES:

- SEE REFERENCE TABLE FOR CONFIGURATION SPECIFIC PROCESSING REQUIREMENTS
- BUMPER STOP PROCESSING ONLY REQUIRED WHEN BOTH CONDITIONS ARE MET:
 - >2 TRACKS ARE USED
 - CONTEMPORARY HANDLE SELECTED

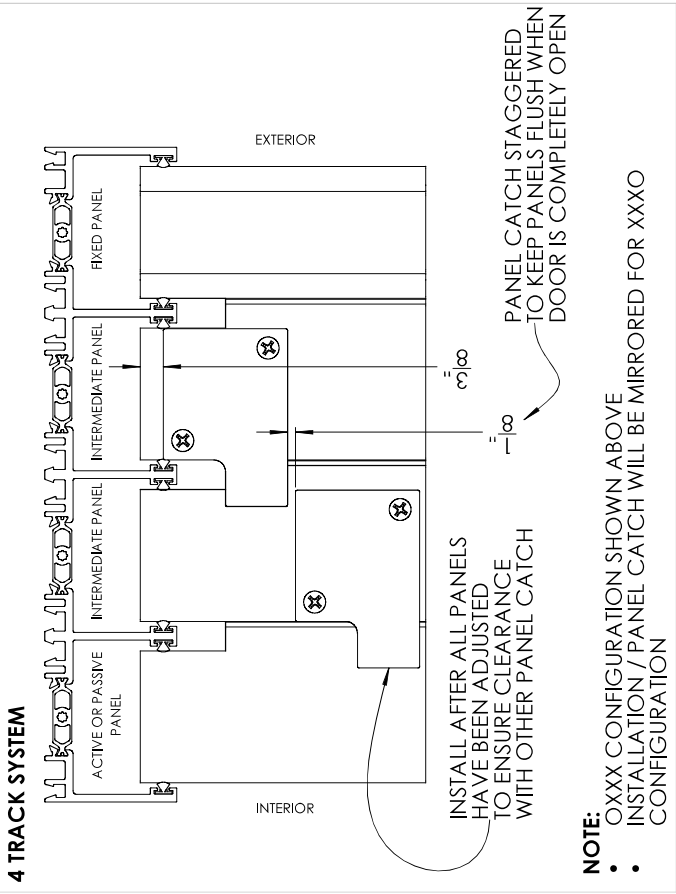
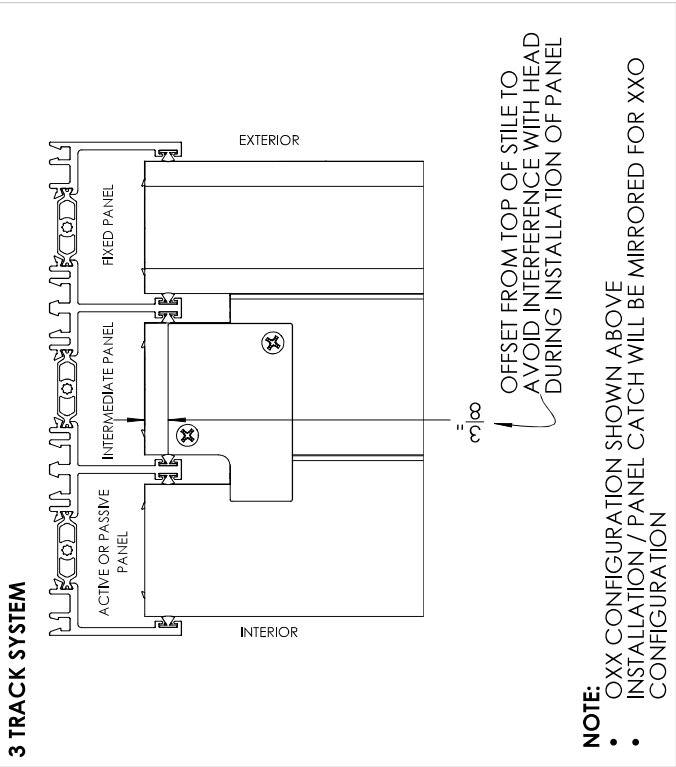
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DIMENSIONS ARE IN INCHES		ENG APPR.	BE	6/4/2026
DECIMALS: 1/8		TITLE:		
FRACTIONS: 1/8		SGD - BOTTOM RAIL - BUMPER STOP PROCESSING		
ANGLES: 1 DEG		OXX - INTERMEDIATE PANEL BOTTOM RAIL		
ONE PLACE DECIMAL: ±0.2		SIZE DWG. NO. 50000085		
TWO PLACE DECIMAL: ±0.06		REV 0		
THREE PLACE DECIMAL: ±0.010		SCALE: 1:5		
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM WINDOWS & DOORS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS IS PROHIBITED.		SHEET 13 OF 16		

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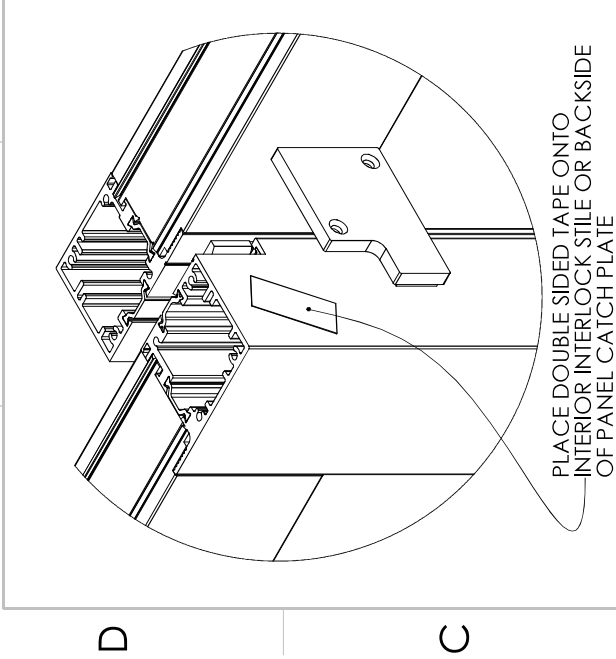
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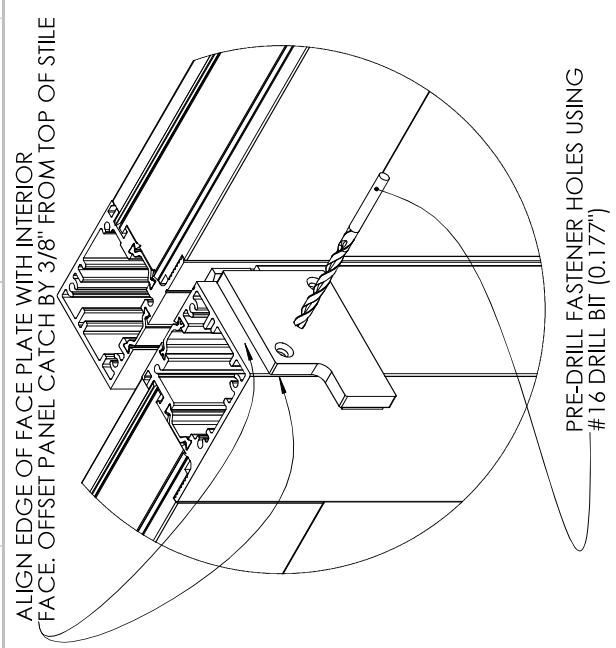
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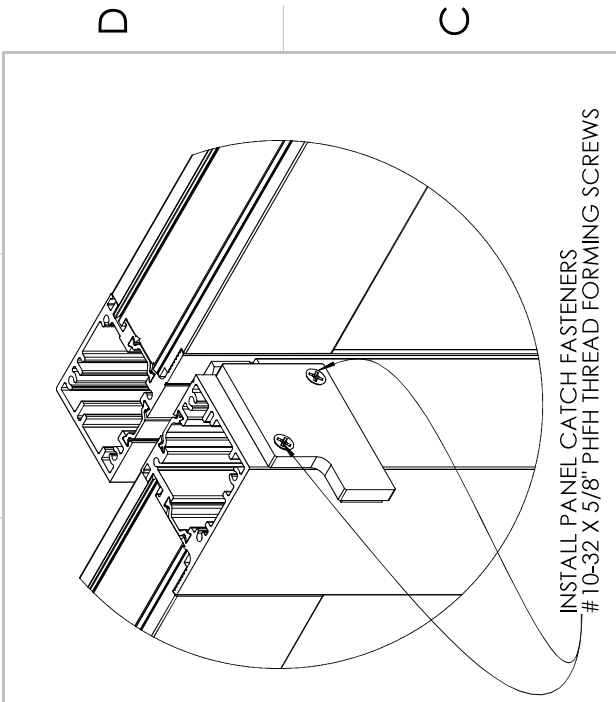
UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES		BE	6/4/2026
TOLERANCES UNLESS OTHERWISE SPECIFIED:			
FRACTIONS ± 1/8			
ANGLES ± 1 DEG			
ONE PLACE DECIMAL ±0.2			
TWO PLACE DECIMAL ±0.06			
THREE PLACE DECIMAL ±0.010			
PROPRIETARY AND CONFIDENTIAL			
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM WINDOWS & DOORS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS IS PROHIBITED.			
DRAWN		ENG APPR.	TITLE:
CONFIGURATION			S3000 SGD, OXX, PANEL CATCH INSTALL DETAILS
MATERIAL		SIZE	DWG. NO.
		B	50000085
FINISH		REV	0
		SCALE: 1:2	
		SHEET 12 OF 16	



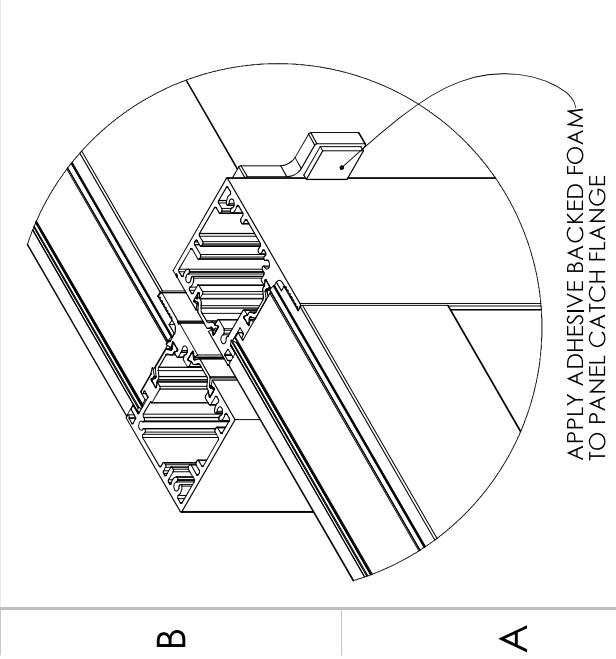
PLACE DOUBLE SIDED TAPE ONTO
INTERIOR INTERLOCK STILE OR BACKSIDE
OF PANEL CATCH PLATE



ALIGN EDGE OF FACE PLATE WITH INTERIOR
FACE. OFFSET PANEL CATCH BY 3/8" FROM TOP OF STILE

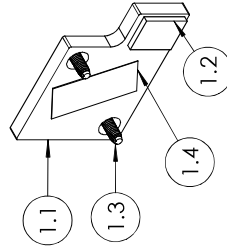


INSTALL PANEL CATCH FASTENERS
10-32 X 5/8" PHFH THREAD FORMING SCREWS



APPLY ADHESIVE BACKED FOAM
TO PANEL CATCH FLANGE

ITEM NO.	PART NUMBER	WTS PART NUMBER	DESCRIPTION	QTY.
1	30000094	WTS-SGD-CATCH-KIT	SGD PANEL CATCH KIT	1
1.1	30000219		PANEL CATCH PLATE	1
1.2	40000060		POLYURETHANE FOAM - ADHESIVE BACKED - 0.094 X 0.75 X 1.00	1
1.3	30000017		FLAT HEAD 10-32 X 5/8" THREAD FORMING TYPE - BLACK	2
1.4	30000222	-	DOUBLE SIDED TAPE	1



UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
FRACTIONS: 1/8
ANGLES: 1 DEG
ONE PLACE DECIMAL ±0.2
TWO PLACE DECIMAL ±0.06
THREE PLACE DECIMAL ±0.010

PROPRIETARY AND CONFIDENTIAL
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DRAWN	NAME	DATE
ENG APPR.	BE	6/4/2026
CONFIGURATION		
TITLE: S3000 SGD, OXX, PANEL CATCH INSTALL DETAILS		
MATERIAL	SIZE	DWG. NO.
FINISH	B	50000085
REV		0
SCALE: 1:2		SHEET 11 OF 16

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REFERENCE TABLE 2				
CONFIGURATION	QUANTITY			
	HEAD FOAM	SILL FOAM	EXTERIOR INTERLOCK FOAM	OPERABLE PANEL BOTTOM RAIL DUST PLUG
	HW-SGD-OP-PANEL-PLUG	FM-SGD-SILL-TRACK	FM-SGD-INTERLOCK-NOTCH	WTS-PILE-1.00x.500-SOFT-TCH-GRY
OX	1	1	2	3
OXX	3	5	4	6
OXXX	5	9	6	9
OXO	3	2	2	3
OXO	4	4	4	6
OXXXXO	8	12	8	12



UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES FRACTIONS: 1/8		BE	BE	6/4/2026
ANGLES: 1 DEG ONE PLACE DECIMAL +0.2 TWO PLACE DECIMAL +0.06 THREE PLACE DECIMAL +0.010		ENG APPR.		
CONFIGURATION		CLOSED		TITLE: S3000 SGD, OXX, FOAM & DUST PLUG REFERENCE TABLE
PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM WINDOWS & DOORS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS IS PROHIBITED.		MATERIAL		SIZE DWG. NO. B 50000085
FINISH		SCALE: 1:20		REV O SHEET 10 OF 16

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8 7 6 5 4 3 2 1

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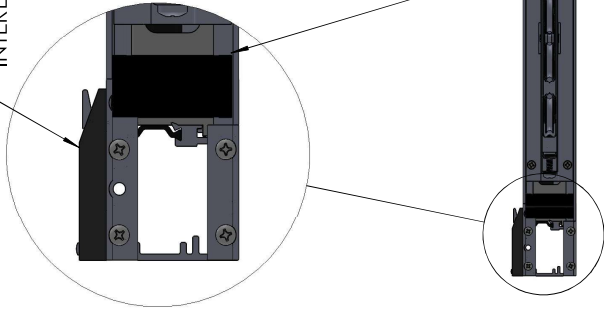
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INTERLOCK NOTCH FOAM

OPERABLE PANEL
BOTTOM RAIL DUST PLUG
[3 PER OPERABLE PANEL]

Ø



UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES		ENG APPR.	BE	6/4/2026
TOLERANCES UNLESS OTHERWISE SPECIFIED:		TITLE:		
FRACTIONAL $\pm 1/8$		S3000 SGD, OXX, OPERABLE		
ANGLES ± 1 DEG		PANEL BOTTOM RAIL DUST PLUGS		
ONE PLACE DECIMAL ± 0.2		CONFIGURATION		
TWO PLACE DECIMAL ± 0.06		CLOSED		
THREE PLACE DECIMAL ± 0.010		SIZE DWG. NO.		
PROPRIETARY AND CONFIDENTIAL		MATERIAL		REV
THE INFORMATION CONTAINED IN THIS		B		0
DRAWING IS THE SOLE PROPERTY OF		500000085		
RAM WINDOWS & DOORS. ANY		SCALE: 1:16		
REPRODUCTION IN PART OR AS A WHOLE		SHEET 9 OF 16		
WITHOUT THE WRITTEN PERMISSION OF				
RAM WINDOWS & DOORS IS PROHIBITED.				

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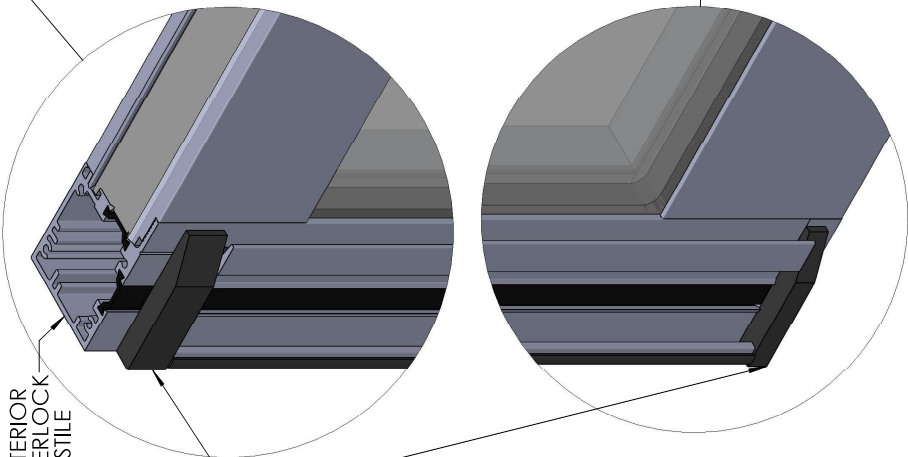
8 7 6 5 4 3 2 1

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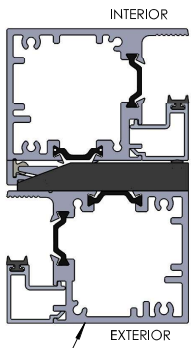
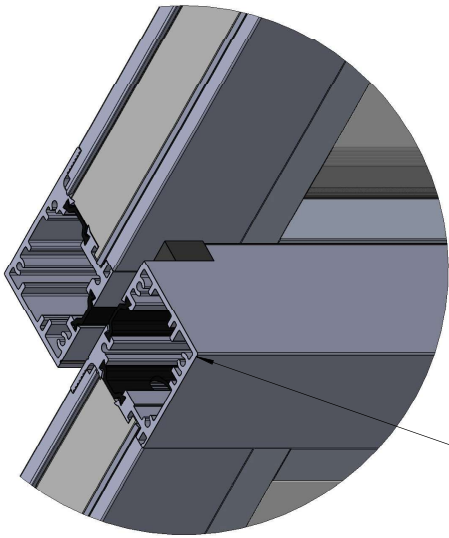
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INTERLOCK NOTCH FOAM
[2 PCS PER EXTERIOR INTERLOCK STILE]
TRIM WIDTH FOR PROPER FITMENT ONCE
ROLLERS HAVE BEEN ADJUSTED

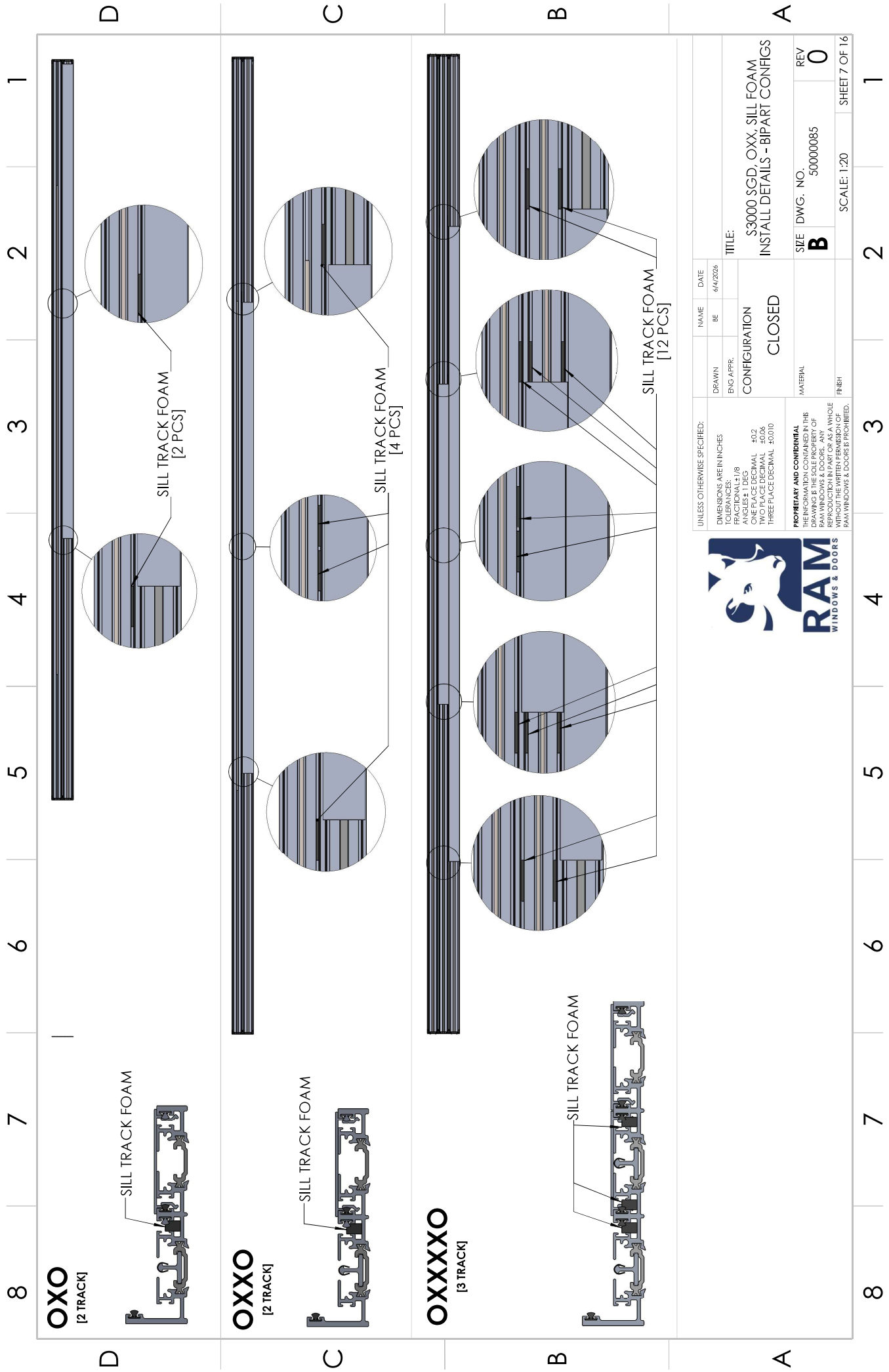


UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
DECIMALS: 1/8
FRACTIONS: 1/8
ANGLES: 1 DEG
ONE PLACE DECIMAL: ±0.2
TWO PLACE DECIMAL: ±0.06
THREE PLACE DECIMAL: ±0.010

DRAWN: BE
ENG APPR.:
CONFIGURATION: CLOSED

TITLE: S3000 SGD, OXX, EXTERIOR INTERLOCK NOTCH FOAM

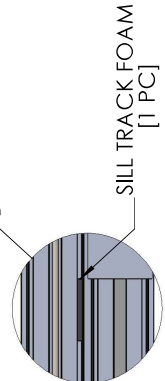
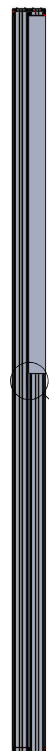
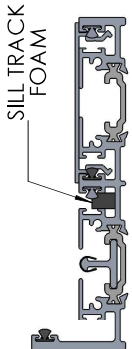
SIZE: DWG. NO. 50000085
REV: 0
SCALE: 1:16
SHEET 8 OF 16



UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES		BE	BE	6/4/2026
FRACTIONAL ± 1/8		TITLE:		
ANGLES ± 1 DEG		S3000 SGD, OXX, SILL FOAM		
ONE PLACE DECIMAL ±0.2		INSTALL DETAILS - BIPART CONFIGS		
TWO PLACE DECIMAL ±0.06		CONFIGURATION		
THREE PLACE DECIMAL ±0.010		CLOSED		
MATERIAL		SIZE	DWG. NO.	REV
PROPRIETARY AND CONFIDENTIAL		B	50000085	0
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM WINDOWS & DOORS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS IS PROHIBITED.		SCALE: 1:20		SHEET 7 OF 16

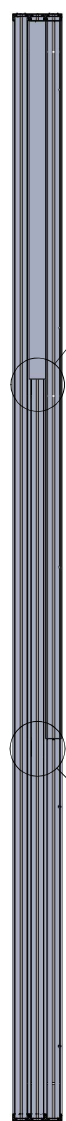
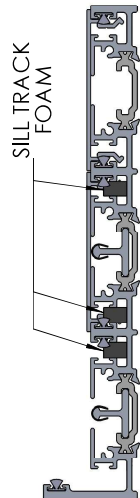
8 7 6 5 4 3 2 1

OX
[2 TRACK]



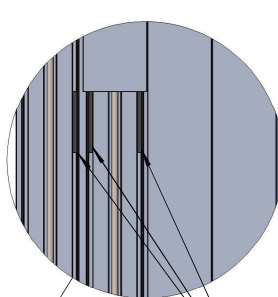
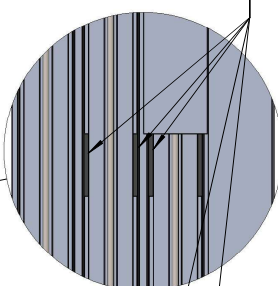
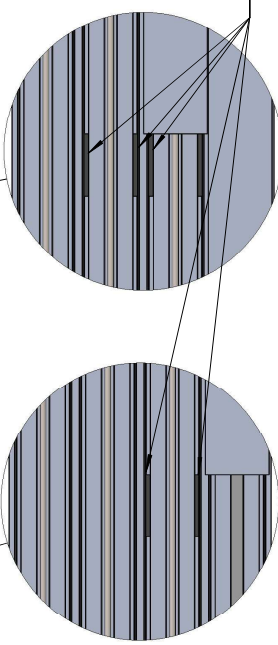
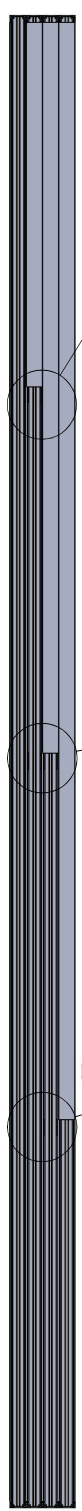
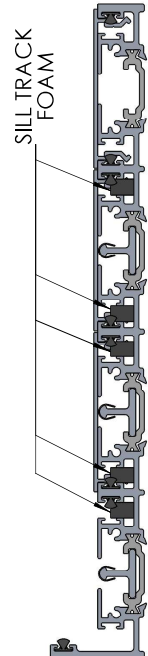
D

OXX
[3 TRACK]



C

OXXX
[4 TRACK]



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UNLESS OTHERWISE SPECIFIED:				NAME	DATE
DRAWN		ENG APPR.	CONFIGURATION	BE	6/4/2026
DIMENSIONS ARE IN INCHES		TITLE:			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		S3000 SGD, OXX, SILL FOAM			
FRACTIONAL ± 1/8		CLOSED			
ANGLES ± 1 DEG					
ONE PLACE DECIMAL ±0.2					
TWO PLACE DECIMAL ±0.06					
THREE PLACE DECIMAL ±0.010					
MATERIAL				SIZE	DWG. NO.
PROPRIETARY AND CONFIDENTIAL				B	50000085
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM WINDOWS & DOORS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS IS PROHIBITED.				REV	0
FINISH				SCALE: 1:20	
				SHEET 6 OF 16	

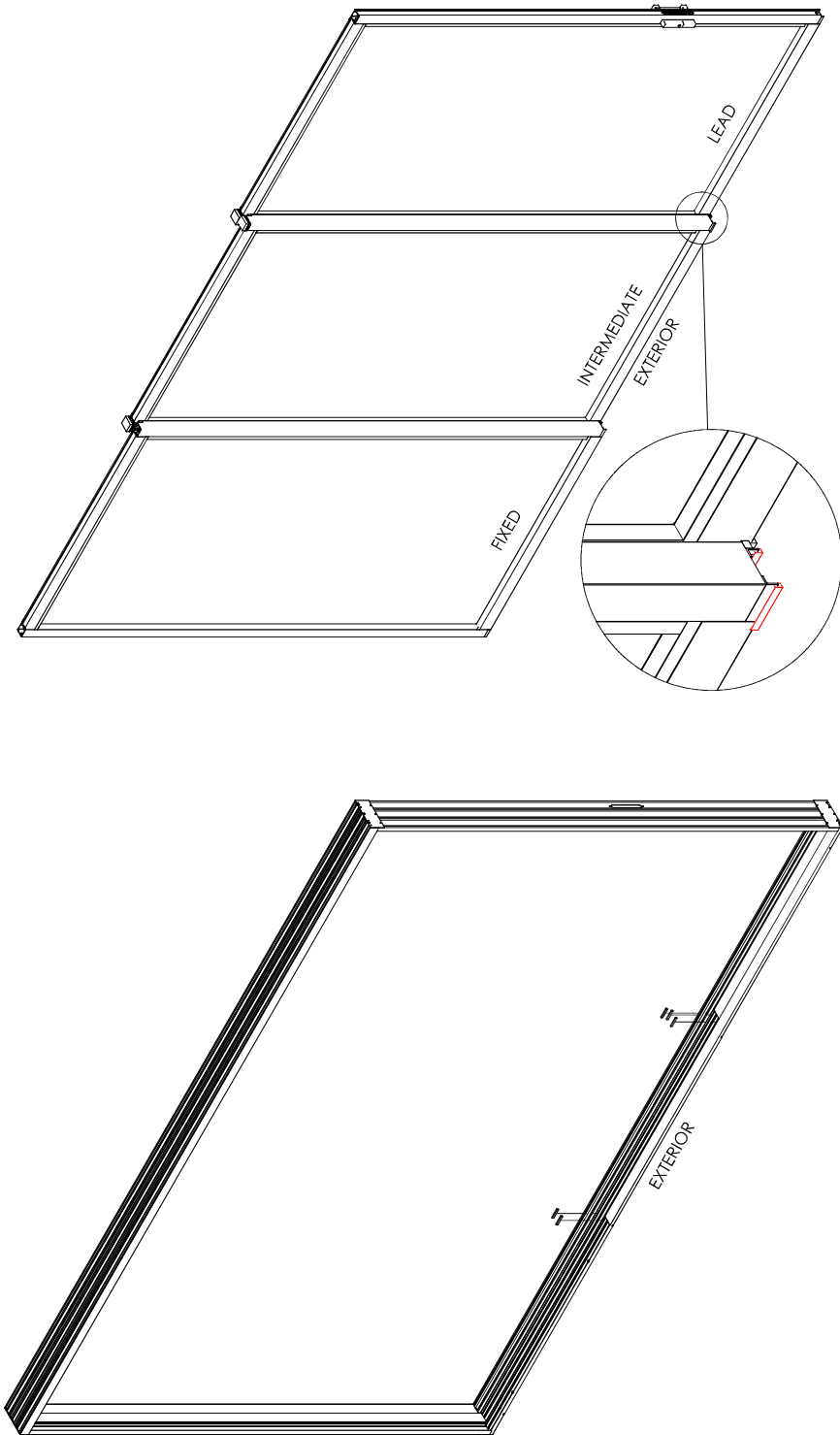


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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D C B A



- NOTES:
- SEE REFERENCE TABLE 2 FOR CONFIGURATION SPECIFIC FOAM/DUST PLUG QUANTITIES
 - INSTALL IN SILL RAIL EXTENSION CAVITY DIRECTLY BELOW OPERABLE PANEL INTERLOCK STILE RAIL EXTENSIONS
 - FOR BIPARTING CONFIGURATIONS ADDITIONAL BLOCKS ARE TO BE INSTALLED DIRECTLY BELOW THE ACTIVE STILE AND PASSIVE STILE RAIL EXTENSION [EXTERIOR SIDE ONLY]



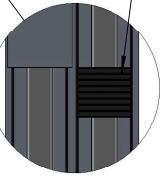
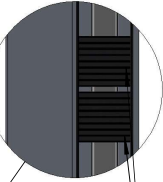
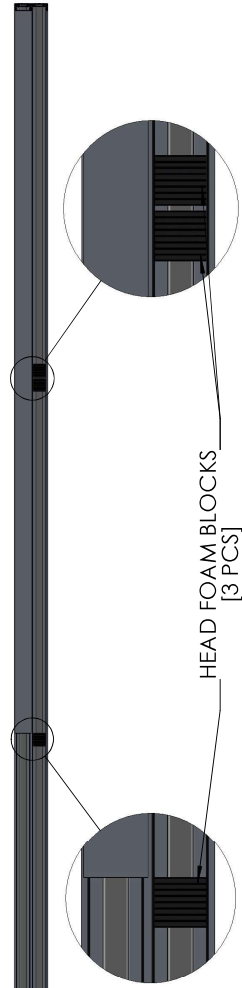
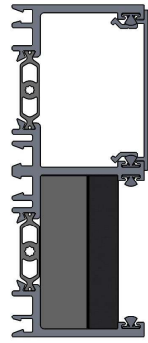
UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES		BE	BE	6/4/2026
FRACTIONAL ± 1/8		TITLE:		
ANGLES ± 1 DEG		S3000 SGD, OXX, SILL FOAM		
ONE PLACE DECIMAL ±0.2		INSTALL DETAILS		
TWO PLACE DECIMAL ±0.06		CONFIGURATION		
THREE PLACE DECIMAL ±0.010		CLOSED		
PROPRIETARY AND CONFIDENTIAL		MATERIAL		SIZE
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM WINDOWS & DOORS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS IS PROHIBITED.		FINISH		DWG. NO.
				B
				500000085
				REV
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				SCALE: 1:25
				SHEET 5 OF 16

8 7 6 5 4 3 2 1

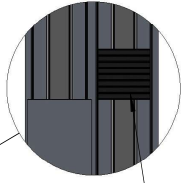
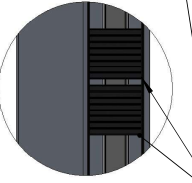
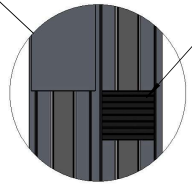
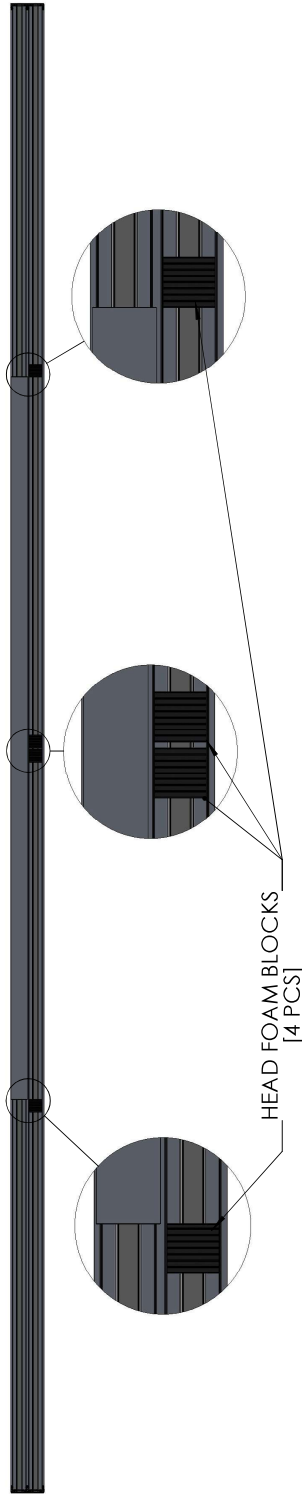
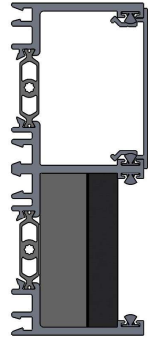
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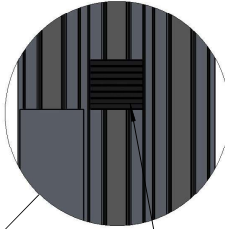
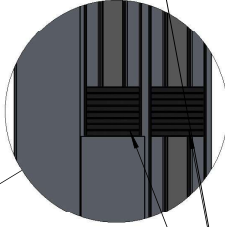
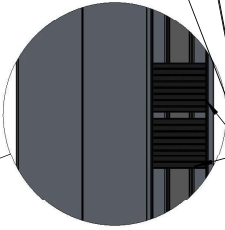
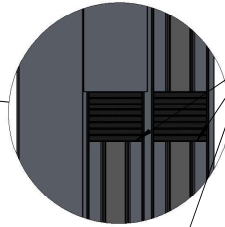
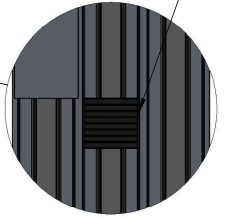
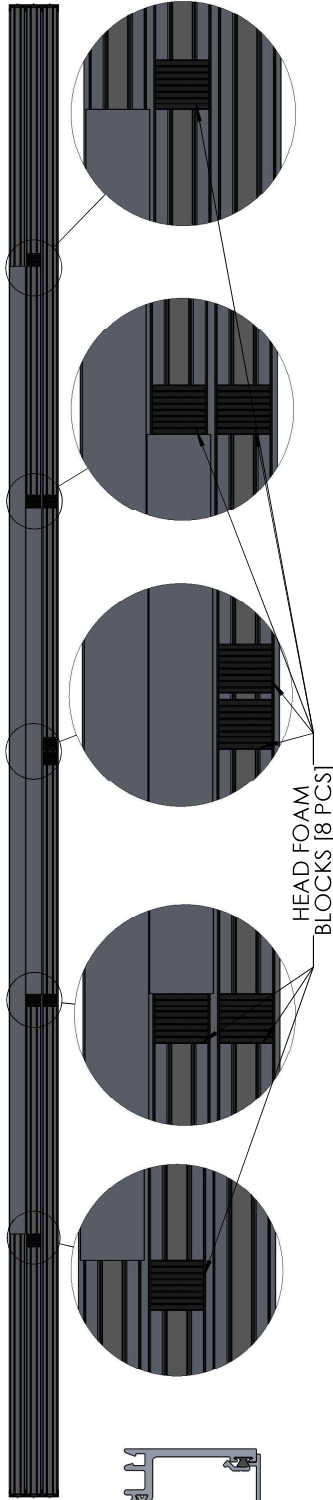
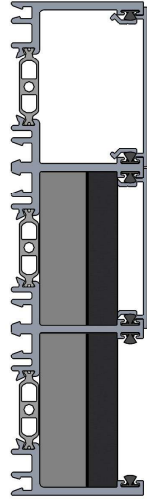
OXO
[2 TRACK]



OXO
[2 TRACK]



OXXXXO
[3 TRACK]

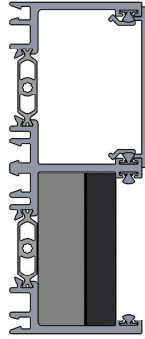


UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES		BE	BE	6/4/2026
FRACTIONAL ± 1/8		TITLE:		
ANGLES ± 1 DEG		S3000 SGD, OXX, HEAD FOAM		
ONE PLACE DECIMAL ±0.2		INSTALL DETAILS - BIPART CONFIGS		
TWO PLACE DECIMAL ±0.06		CLOSED		
THREE PLACE DECIMAL ±0.010		CONFIGURATION		
CLOSED		MATERIAL		
PROPRIETARY AND CONFIDENTIAL		SIZE		
THE INFORMATION CONTAINED IN THIS		DWG. NO.		
DRAWING IS THE SOLE PROPERTY OF		B		
RAM WINDOWS & DOORS. ANY		500000085		
REPRODUCTION IN PART OR AS A WHOLE		REV		
WITHOUT THE WRITTEN PERMISSION OF		O		
RAM WINDOWS & DOORS IS PROHIBITED.		SCALE: 1:20		
		SHEET 4 OF 16		

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

OX
[2 TRACK]



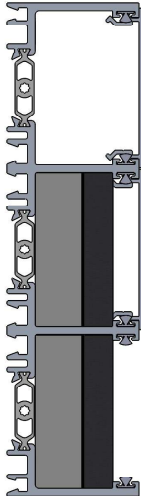
HEAD FOAM BLOCK
[1 PC]



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[3 TRACK]



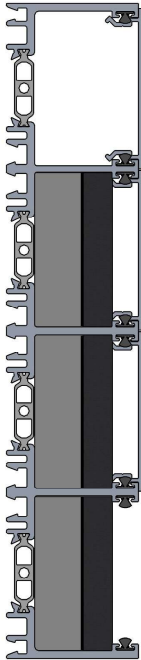
HEAD FOAM BLOCK
[3 PCS]



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OX
[4 TRACK]



HEAD FOAM BLOCK
[5 PCS]



B

B



UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
FRACTIONAL ± 1/8
ANGLES ± 1 DEG
ONE PLACE DECIMAL ±0.2
TWO PLACE DECIMAL ±0.06
THREE PLACE DECIMAL ±0.010

DRAWN
ENG APPR.
CONFIGURATION
CLOSED

NAME
BE

DATE
6/4/2026

TITLE:
S3000 SGD, OXX, HEAD FOAM
INSTALL DETAILS

PROPRIETARY AND CONFIDENTIAL
THE INFORMATION CONTAINED IN THIS
DRAWING IS THE SOLE PROPERTY OF
RAM WINDOWS & DOORS. ANY
REPRODUCTION IN PART OR AS A WHOLE
WITHOUT THE WRITTEN PERMISSION OF
RAM WINDOWS & DOORS IS PROHIBITED.

MATERIAL

SIZE
DWG. NO.
B 50000085

REV
O

SCALE: 1:20

FINISH

SHEET 3 OF 16

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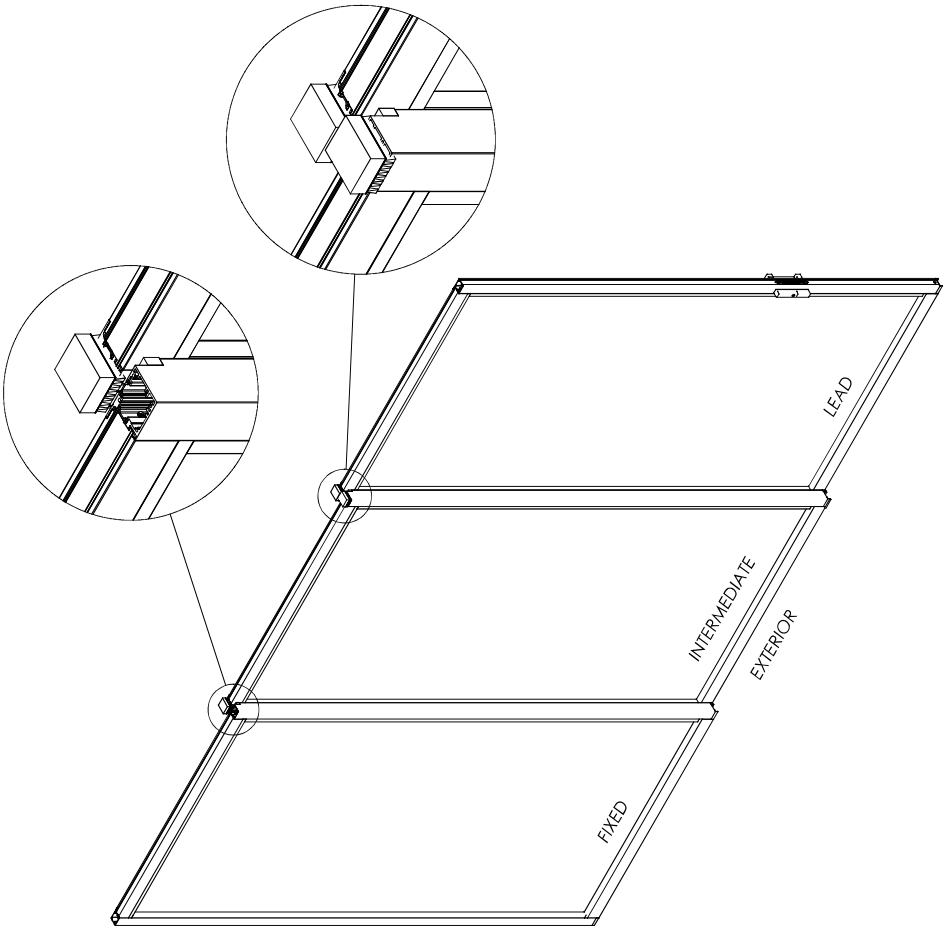
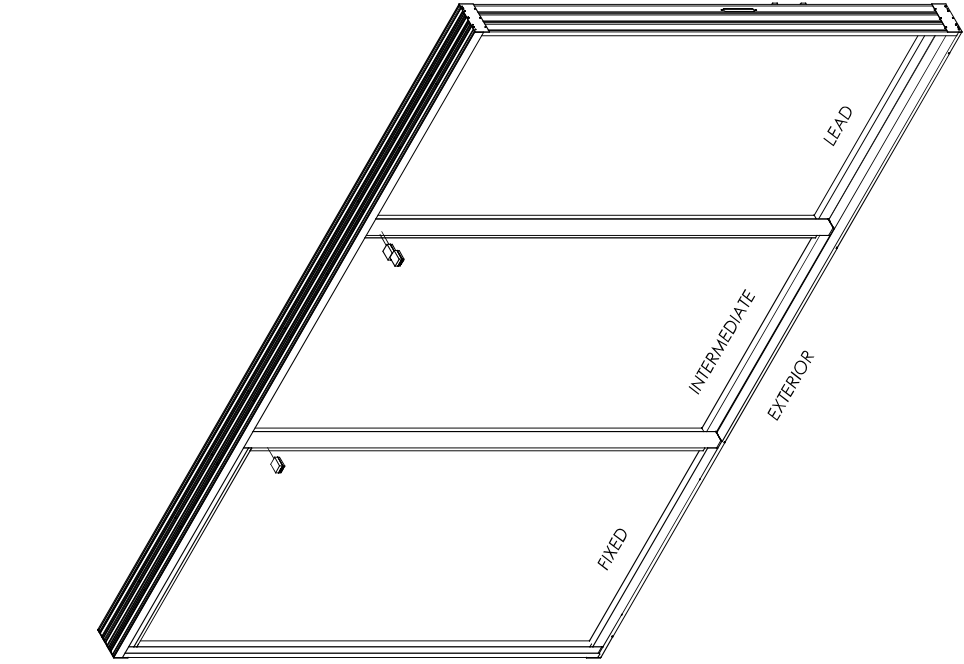
8 7 6 5 4 3 2 1

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- NOTES:
- SEE REFERENCE TABLE 2 FOR CONFIGURATION SPECIFIC FOAM/DUST PLUG QUANTITIES
 - INSTALL IN HEAD CAVITY ABOVE ALL OPERABLE PANEL INTERLOCKS
 - FOR BIPARTING CONFIGURATIONS ADDITIONAL BLOCKS ARE TO BE INSTALLED ABOVE THE ACTIVE STILE (1) AND PASSIVE STILE (1)

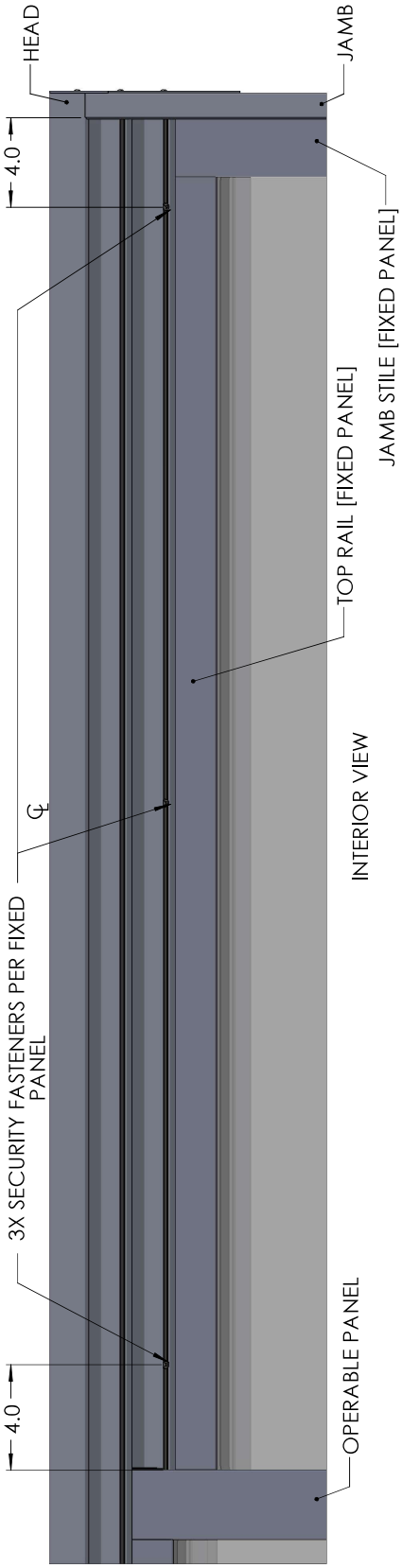


UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES		BE	BE	6/4/2026
TOLERANCES UNLESS OTHERWISE SPECIFIED:		ENG APPR.		
FRACTIONAL $\pm 1/8$		CONFIGURATION		
ANGLES ± 1 DEG		CLOSED		
ONE PLACE DECIMAL ± 0.2				
TWO PLACE DECIMAL ± 0.06				
THREE PLACE DECIMAL ± 0.010				
PROPRIETARY AND CONFIDENTIAL		MATERIAL		SIZE
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM WINDOWS & DOORS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM WINDOWS & DOORS IS PROHIBITED.				DWG. NO.
				B
				50000085
				REV
				0
				SCALE: 1:25
				SHEET 2 OF 16

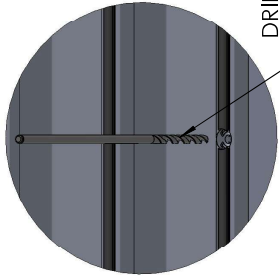
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8 7 6 5 4 3 2 1

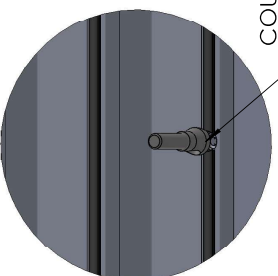
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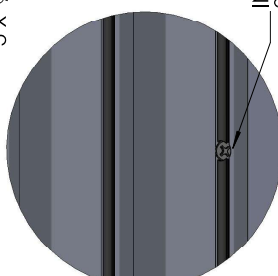
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IMPORTANT
VERIFY FASTENER HEAD IS SEATED BELOW WEATHERSTRIP T-SLOT FLANGES.
IF SCREW HEAD IS PROTRUDING, REMOVE FASTENER, AND COUNTERSINK SLIGHTLY DEEPER.
THIS IS TO ENSURE SCREW HEAD CLEARANCE WITH OPERABLE PANELS.



UNLESS OTHERWISE SPECIFIED:		DRAWN	NAME	DATE	
DIMENSIONS ARE IN INCHES		ENG APPR.	BE	6/4/2026	
TOLERANCES:		CONFIGURATION			
FRACTIONAL ± 1/8					
ANGLES ± 1 DEG					
ONE PLACE DECIMAL ±0.2					
TWO PLACE DECIMAL ±0.06		TITLE: S3000 SGD, OXX, FIXED PANEL SECURITY FASTENER DETAILS			
THREE PLACE DECIMAL ±0.010					
PROPRIETARY AND CONFIDENTIAL					
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		FINISH	B	50000085	0
			SCALE: 1:10		SHEET 1 OF 16

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