PELLA PRODUCT IDENTIFICATION AND HISTORY

Pella® Impervia® Fiberglass Products

TABLE OF CONTENTS

How to determine the product vintage:

Serial number locations on Pella® Impervia® Products PG-2
Glass Etches PG-3
Label/Etch for Pella® Impervia® Products PG-5

Pella® Impervia®:

- Introduced in 2003, Pella® Impervia® products are made of Pella's patented Duracast® material. An engineered composite material that's thermally cured for added stability, Duracast is the strongest, most durable material available for windows and doors. Pella® Impervia® Product has an Environmental Product Declaration (EPD), See PMB # 40-2025.

Awning / Casement / Large Awning, May 2009 – 03/2021 ..... PG-7
Awning / Casement, (Impervia 2.0) PG-9
Double-Hung, 2006 – Current PG-10
Fixed Frame Direct Set, 2005 – 2019 ..... PG-12
Direct Set, 2020 – Current PG-13
Fixed Window, 2003 – Current PG-14
Single-Hung, 2003 – Current PG-15
Sliding Window, 2003 – Current PG-17
Sliding Contemporary Door, 2005 – June/July 2021 ..... PG-19
Sliding Contemporary Door (Impervia 2.0), June 2021 - Current PG-21
Classic Design Sliding Patio Door, July 2022 - November 2022 ..... PG-22
Special Shapes, 2006 – Current PG-23
Bay or Bow, 2010 – Current PG-24

General Information

Product Introduced, Discontinued, Changes, Additions, etc.

Hardware PG-25
6" Lock Lever PG-25
Accessories PG-27
    Installation Accessories and Sealants PG-27
Colors and Finishes PG-29
Mullions PG-30
Grilles PG-31
Screens PG-31
Glass PG-31

SPACER SERIAL NUMBER BREAK DOWN:

IGCC® IGMA® PELLA JAN 01 2007 G0312345678 NFRC PEL-N-105

Example: This Unit Label break down

IGCC® IGMA = 3rd Party Certification

PELLA = Manufacturer

JAN 01 2007 = Month/Day/Year of Manufacture

G03 = Manufacturing Location

12345678 = Oracle Number or Unit ID

NFRC = National Fenestration Rating Council

NFRC pel-n-105

Manufacturing Locations

GETTYSBURG	VINYL	G03
MURRAY	AMD	M03
	VINYL	M02
PORTLAND	VINYL	P52
STORY CITY	VINYL	SC2
TUCSON	VINYL	T02
COLUMBIA	VINYL	W02
MACOMB	VINYL	M06

PELLA® IMPERVIA® PRODUCTS:

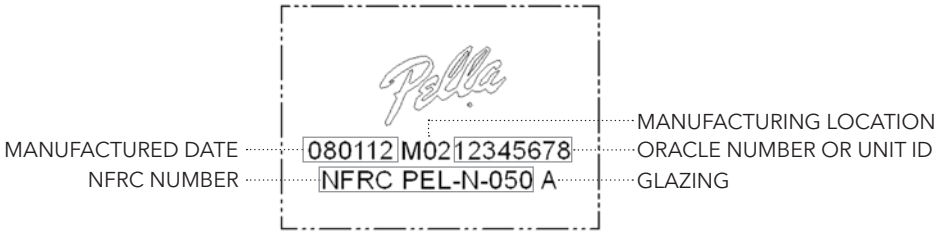
Pella Impervia products print a serial number on the spacer between the glass.



Impervia products may have the serial # printed on the spacer or etched on the glass". In 2021 Impervia products switched to IG with TPS (thermoplastic spacer) so serial number etched on glass and not on printed on spacer.

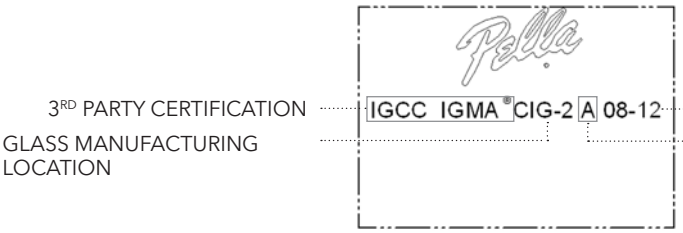


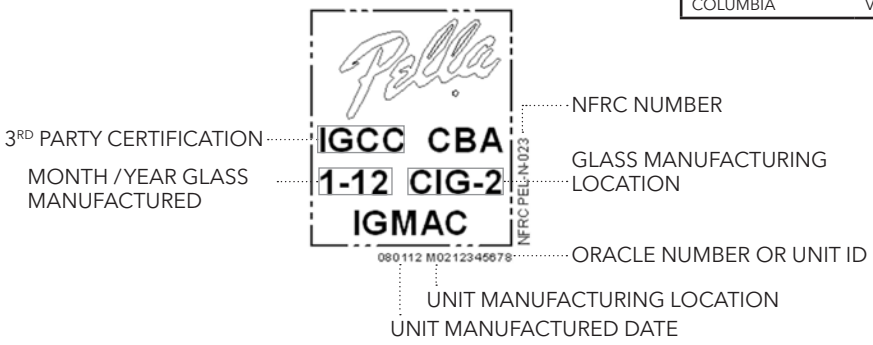
INSULATING GLASS IDENTIFICATION – 2011-2014:

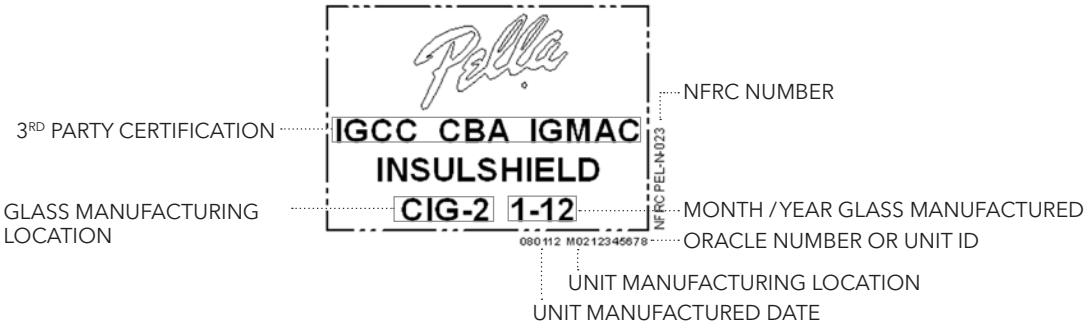


Glazing
A = LOW-E
B = CLEAR
C = SUNDEFENSE LOW-E
E = SUNDEFENSE DUAL LOW-E
F = ADVANCED LOW-E
H = NATURALSUN LOW-E
M = TRIPLE NATURAL SUN LOW-E
N OR S = TRIPLE ADVANCED LOW-E
P = TRIPLE SUN DEFENSE LOW-E
X = SPECIAL

Manufacturing Locations		
GETTYSBURG	VINYL	G03
MURRAY	AMD	M03
	VINYL	M02
PORTLAND	VINYL	P52
STORY CITY	CASEMENT	S09
	VINYL	SC2
TUCSON	VINYL	T02
COLUMBIA	VINYL	W02

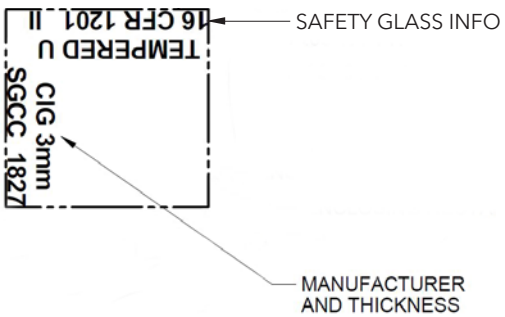




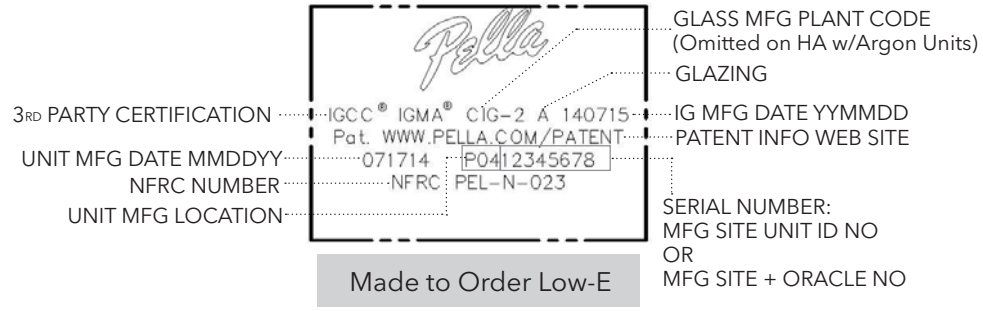


OTHER GLASS ETCHES:

Tempered glass etch will be on every pane of tempered glass and can be located in any corner and on any side of the glass, as long as it isn't on the same side as the Low-E coating.



INSULATING GLASS IDENTIFICATION – 2015-CURRENT:



Made to Order Low-E



Made to Stock Low-E

Glazing
A = LOW-E
B = CLEAR
C = SUNDEFENSE LOW-E
E = SUNDEFENSE DUAL LOW-E
F = ADVANCED LOW-E
H = NATURALSUN LOW-E
M = TRIPLE NATURAL SUN LOW-E
N or S = TRIPLE ADVANCED LOW-E
P = TRIPLE SUN DEFENSE LOW-E

Manufacturing Locations		
GETTYSBURG	VINYL	G03
MURRAY	AMD	M03
	VINYL	M02
PORTLAND	VINYL	P52

SERIAL NUMBER EXAMPLE:



SPACER SERIAL NUMBER BREAK DOWN:



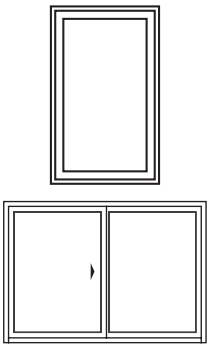
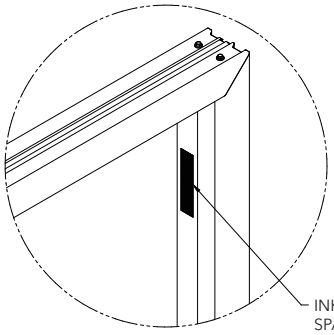
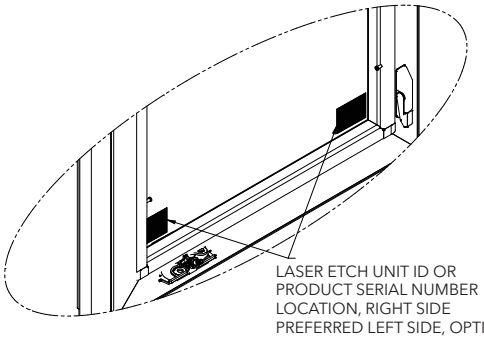
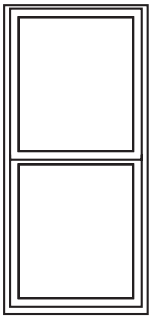
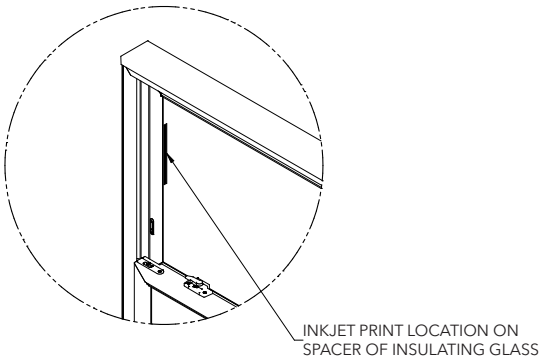
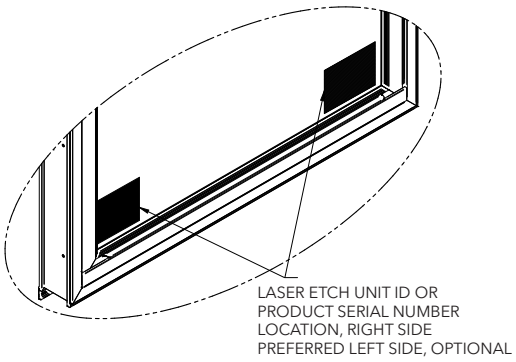
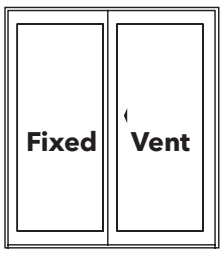
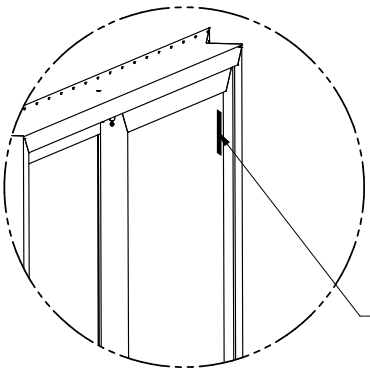
Example: Fiberglass & Vinyl IG Spacer Serial Number break down (Oracle Only) (2015 - Current)

IGCC® IGMA®	G03	12345678	NFRC PEL-N-105	PELLA	PAT. WWW.PELLA.COM/PATENT	Jul 15 2014	08:21	3-05
								Line Info
							Glass MFG Time	
						Jul 15 2014 = Glass MFG Date		
					WWW.PELLA.COM/PATENT = Patent Info Web Site			
				PELLA = Manufacturer				
			NFRC PEL-N-105= National Fenestration Rating Council					
		12345678 = Oracle Number or Unit ID						
	G03 = Unit Manufacturing Location							
IGCC® IGMA® = 3rd Party Certification								

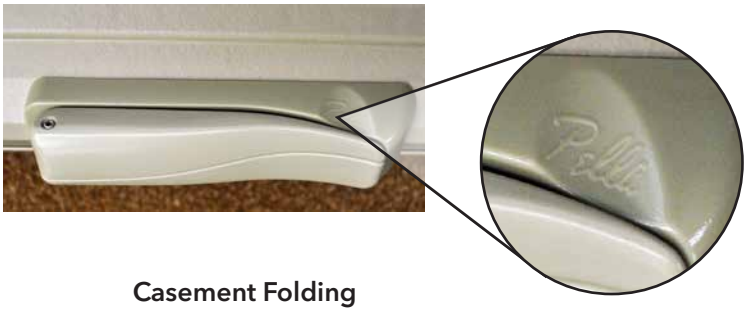
PELLA PRODUCT IDENTIFICATION AND HISTORY

Back to TOC

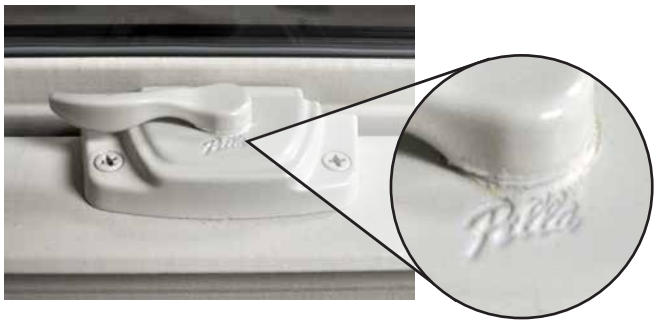
UNIT ASSEMBLY LABEL/ETCH LOCATION FOR IMPERVIA PRODUCTS:

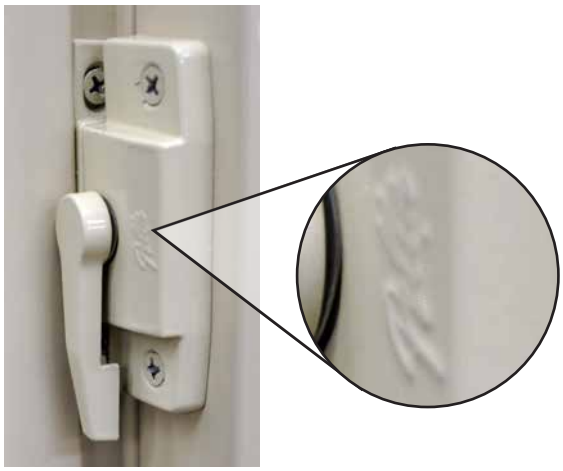
PRODUCT TYPE	LABEL TYPE / LOCATION
CASEMENT/SLIDING WINDOW 	 IMPERVIA VIEW FROM INTERIOR  IMPERVIA VIEW FROM INTERIOR
DOUBLE / SINGLE-HUNG 	 IMPERVIA VIEW FROM INTERIOR  IMPERVIA VIEW FROM INTERIOR
SLIDING DOOR 	 IMPERVIA VIEW FROM INTERIOR **Impervia 2.0:** The glass etching is now in the upper left hand corner of the panel.

WINDOWS



Casement Folding
Handle and Roto Cover





Sliding Window

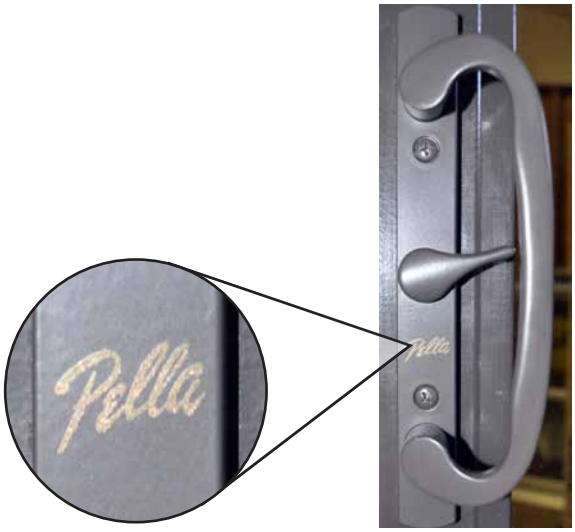
SLIDING DOOR



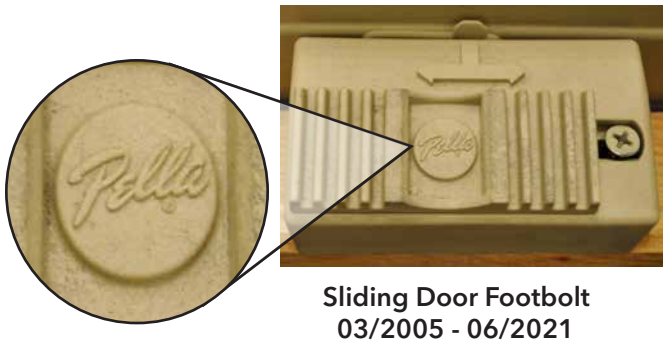
Interior Sliding
Door Handle
06/2021 - Current



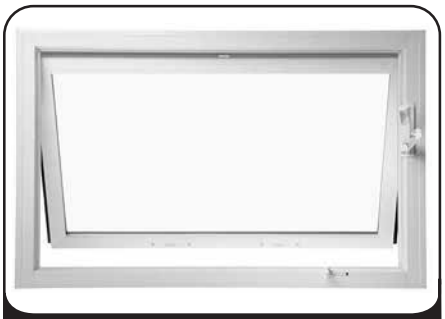
Interior Sliding
Door Handle
04/2010 - 06/2021



Interior Sliding Door handle
Pre-04/2010



Sliding Door Footbolt
03/2005 - 06/2021



Awning Interior



Awning Exterior



Casement Interior



Casement Interior

May 2009:

- Introduced, Features include: Stainless Steel operating arms and hinges, SureLock® system, Fold away handle. 3-1/4" frame depth (Cannot mull to existing 3" frame depth products). Available in special sizes to nearest 1/4" Available in White, Brown or Tan.
- Construction hardware included with every venting unit. PMB #58-2009.

January 2010:

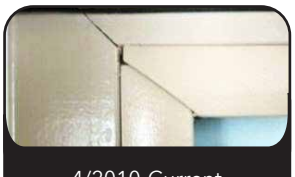
- 3-Way and 4-Way Casement and Awning factory assembled combinations now available.

April 2010:

- The glazing bead on Pella Impervia product changed to a miter angle corner cut which will match the frame and sash corner aesthetic. In addition, the update includes a material change from Duracast to a fiberglass resin part to improve ease of installation. (Running Change). PMB #26-2010.



Previous-Straight Design



4/2010-Current Pinwheel Pattern

May 2010:

- Pella Impervia windows and doors dual-color option available, Pella Impervia products can have a White interior and choice of a White, Tan or Brown exterior. Phased in launch; 10/2010, 03/2011 with full launch 6/2011. PMB #30-2010, #31-2010, #32-2011.

GBG:

- Match Interior and Exterior Finish.

Hardware:

- Match Interior Finish, optional available in Satin Nickel, Bright Brass or Oil Rubbed Bronze.

Frame Options:

- Block Frame.
- Block Frame with Standard Fin.
- Block Frame with Offset Fin.
- Flush Flange.
- Integral Nail Fin is not available. The Block Frame with Standard Fin should be ordered for new construction opportunities.

May 2010:

- Pella Impervia Bay and Bow windows now available.

November 2013:

- New Casement Pivot Arm Roller Hinge featuring a stainless steel hinge, slide and fasteners along with a roller constructed of self-lubricating stainless steel added as standard to be installed on all new units and can be retro-fitted to existing 2009-2013 vintage units. PMB #36-2013.



January 2014:

- Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #06-2014.

Color combinations included:

- Black Exterior / Black Interior.
- Black Exterior / White Interior*.
- Morning Sky Gray Exterior/ Morning Sky Gray Interior.
- Morning Sky Gray Exterior / White Interior*.
  *Dual Color units available in Block Frame only.
- Black and Morning Sky Gray color-matched hardware available for all Impervia products.
- Mono and Dual-color GBG's available on all products.
  PMB # 32-2013.

January 2014:

- Impervia Bay & Bow interior finish options expanded to include, Natural, Golden Oak, Early American, Provincial, Special Walnut, Red Mahogany, Dark Mahogany, Cherry, Linen White & Bright White. This finish options added to current options of Unfinished, Pella Pre-finished White and Pella Primed. PMB #7-2014.

Continued on next page



March 2017:

- All Impervia vent Casements, come with a window opening control device (WOCD) installed in the factory prior to shipment.

April 2017:

- Construction hardware no longer included with venting units. PMB #29-2017.

June 2017:

- Pella Impervia vent casement windows will no longer include a factory installed Window Opening Control Device ("WOCD") on windows of the sizes meeting these parameters:
- No WOCD Required when unit size:
  - FW ≤ 29.5" or
  - FW ≤ 31.5 and FH ≤ 65.5" or
  - FW ≤ and FH ≤ 53.5" or
  - FH ≤ 48"
- This change is effective for products manufactured on or after June 12, 2017. All Impervia vent casements will receive the following enhancements.
  - Stop screw height increased on the sash hinge slides. This change significantly increases the stopping strength of the stop screw.
  - Metal bracket added which increases the force the roto-operator window opening mechanism can withstand prior to the roto-operator sustaining damage. The addition of this bracket more than doubles the strength of the operator when the window is in the closed and unlocked position.
- Pella Impervia vent casements on larger window sizes than those indicated above, will come with both the enhancements, and a factory installed WOCD. PMB #38-2017



Taller Head on Stop Screw



Metal bracket support

August 2017:

- A hardware enhancement kit made available for customers who wish to remove the WOCD hardware applied to all Impervia Casement vent units from March 30, 2017 to June 12, 2017. (See PMB # 38-2017). Kit includes service instructions, stop screws, roto-operator brackets, and a drill jig for 30 units to be converted. WOCD hardware May only be removed at a customer's request if it is not required by code and if it is a size no longer requiring a factory installed WOCD.
- No WOCD Required when unit size:
  - FW ≤ 29.5" or
  - FW ≤ 31.5 and FH ≤ 65.5" or
  - FW ≤ and FH ≤ 53.5" or
  - FH ≤ 48"
- The availability of the kit is NOT be marketed to customers. Kit available through Customer Service until 01/31/2018. PMB #56-2017

September 2017:

- Impervia awning and casement crank covers changed from snap-on to interior frame stop to an extended cover held in place with a screw. (Similar to wood AW and CM design.) PMB #62-2017.



December 2017:

- All Large Awning units now have Tempered Glass. All replacement glass and sashes must have tempered or tempered-laminate glass. PMB #1-2018

January 18, 2021:

- Ordering for Model 2 goes live for all PDSN Segments.
- Model 1 ordering for Retail is turned off.

February 8, 2021:

- Model 1 ordering for Trade is turned off.

March 15, 2021:

- Model 1 Ordering for Commercial is turned off.

April 30, 2021:

- Last ship date for Model 1 products. PMB #13-2021

November 2021:

- Model 1 replacement Awning and Casement sashes no longer available. Slight modifications have been made to model 2 sashes for certain sizes to make it compatible with model 1 frames. Pre2021 vintage will remain a pickable option but a model 2 sash will be received. PMB#75-2021

Reminder: There was an overlap period from January 2021 – May 2021 when both vintages of this product were being manufactured. Please be sure to verify which vintage is needed.

Pre 2021 Vintage Identification: Beveled Interior Cover profile, Sash cover on the exterior overlaps at the corner joint.

2021 - Current Vintage Identification: Squared off Interior Cover profile, no exterior sash cover and flush corner joint, groove glazed.



Awning



Awning Easy Slide Operator



Casement Roto Operator Crank



Casement Easy Slide Operator



Redesigned Lock Lever



Casement

Reminder: There was an overlap period from January 2021 – May 2021 when both vintages of this product were being manufactured. Please be sure to verify which vintage is needed.

Pre 2021 Vintage Identification: Beveled Interior Cover profile, Sash cover on the exterior overlaps at the corner joint.

2021 - Current Vintage Identification: Squared off Interior Cover profile, no exterior sash cover and flush corner joint, groove glazed.

January 2021:

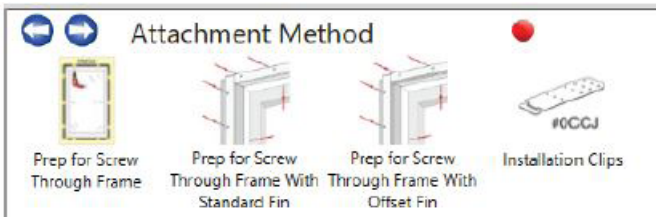
- Introduced. Squared off Interior Cover profile, no exterior sash cover and flush corner joint, groove glazed. Easy Slide Operator option, redesigned roto operator crank and lock lever. PMB #13-2021

December 2022:

- PQM updated to default and lock all commercial segment casement venting windows to either a Window Opening Control Device (WOCD) or a Limited Opening, Limited Travel (LOLT) hardware option. PMB #58-2022

August 2023:

- Impervia added Impact-Resistant Glazing to offering. This glazing addition will be on the Impervia 2.0 products only: Casement, Awning, rectangle Direct Set, and Sliding Patio Door. All product types will meet Wind Zone 2 / Missile C ratings.
- Impact-resistant glass only available on Block Frame with a Prep for Screw Through Frame or Installation Clips attachment methods. PMB #31-2023





Exterior



Interior

January 2006:

- Pella Impervia Double-Hung Window introduced.

March 2006:

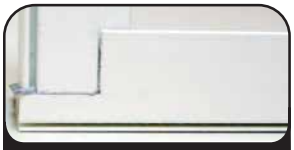
- Improved sash miter joints; New glass-reinforced sash cornerlock in addition to the staple and polyurethane injection.
- All DP 30 products now tape glazed.

May 2006:

- Jamb Weatherstrip modification.
- New rounded edges of the sash corners.
- Rounded edges on tilt-release latches.

January 2007:

- Design change - aesthetic improvement to the sill to jamb joint on DH products.



2006 - 2/2007



2/2007 - Current

- Factory assembled 2 and 3-Wide combinations will utilize a new vertical mull cover available in White, Tan and Brown.

February 2007:

Changes:

1) New center jamb weatherstrip, eliminated bulb weatherstrip, now mohair pile.
2) New interior jamb weatherstrip, eliminated bulb weatherstrip, now mohair pile.



Jamb mohair pile weatherstrip

3) New champagne color top sash tilt latches.
4) New champagne color bottom rail weatherstrip on White and Tan units and Brown color on Brown units.
5) Elimination of the sash cam on the jamb of the double hung window.

- Subsill mullion reinforcement end anchor now available.

September 2007:

- All Double-Hung units will incorporate a new bottom rail weatherstrip design installed in a groove in the bottom of lower sash (interior / exterior aesthetics will remain unchanged).



March 2006- September 19, 2007



September 20, 2007 - Current



Showing cut-out for replacing weatherstrip

December 2007:

- Fifty seven (57) new standard sizes including 3 standard sized fixed transoms.
- Introduced adjustable keeper.



Adjustable Keeper

May 2009:

- Foam Insulated frame and sash available on Pella Impervia Windows and Doors, except special shapes. (Only available with SunDefense™ Glazing option.) PMB #57-2009.

Continued on next page



Interior

April 2010:

- The glazing bead on Pella Impervia product changed to a miter angle corner cut which will match the frame and sash corner aesthetic. In addition, the update includes a material change from Duracast to a fiberglass resin part to improve ease of installation. (Running Change). PMB #26-2010.



Previous-Straight Design



4/2010-Current Pinwheel Pattern

May 2010:

- Pella Impervia Bay and Bow windows now available.
- Pella Impervia windows and doors dual-color option available, Pella Impervia products can have a White interior and choice of a White, Tan or Brown exterior. Phased in launch; 10/2010, 03/2011 with full launch 6/2011. PMB #30-2010, #31-2010, #32-2011.

GBG:

- Match Interior and Exterior Finish.

Hardware:

- Match Interior Finish, optional available in Satin Nickel, Bright Brass or Oil Rubbed Bronze.

Frame Options:

- Block Frame.
- Block Frame with Standard Fin.
- Block Frame with Offset Fin
- Flush Flange.
- Integral Nail Fin is not available. The Block Frame with Standard Fin should be ordered for new construction opportunities.

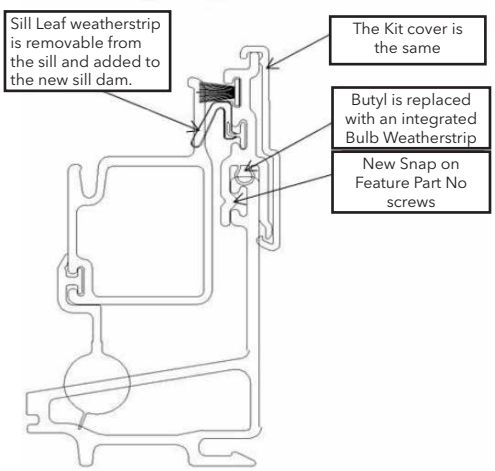
July 2010:

- All Pella Impervia double hung windows re-engineered with an enhanced accessory groove. This is a running change to be implemented July 12, 2010. After the double hung transitions to the new accessory groove on July 12th, all Pella Impervia windows will be manufactured with the interior and exterior accessory groove, with the exception of the flush flange frame remaining unchanged with no accessory groove. PMB #41-2010.

May 2012:

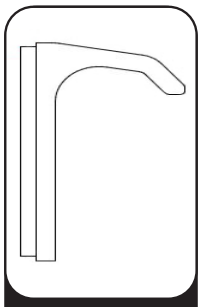
- Double-Hung High Performance Kit Redesign. Attaches to sill using snap fit, added integrated bulb gasket. PMB #38-2012.





September 2012:

- Field applied lower sash lift available for Impervia Double-Hung and Single-Hung units. PMB #46-2012.



Lower Sash Lift

January 2014:

- Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #06-2014.

Color combinations included:

- Black Exterior / Black Interior
- Black Exterior / White Interior*
- Morning Sky Gray Exterior/ Morning Sky Gray Interior
- Morning Sky Gray Exterior / White Interior*
  *Dual Color units available in Block Frame only.
- Black and Morning Sky Gray color-matched hardware available for all Impervia products.
- Mono and Dual-color GBG's available on all products.

January 2014:

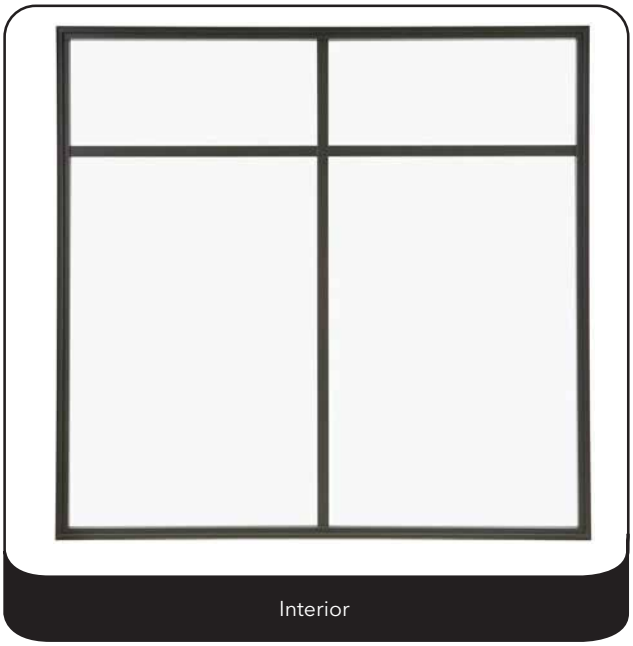
- Impervia Bay & Bow interior finish options expanded to include, Natural, Golden Oak, Early American, Provincial, Special Walnut, Red Mahogany, Dark Mahogany, Cherry, Linen White and Bright White. This finish options added to current options of Unfinished, Pella Pre-finished White and Pella Primed.

July 2020:

- Performance upgrade option no longer offered on Impervia equal sash and cottage sash Double Hung units with FW > 41-1/2" and a FH > 59-1/2". PMB #38-2019.



Exterior



Interior

June 2005:

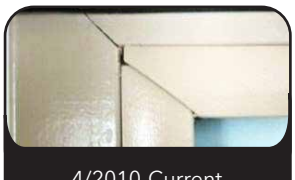
- Introduction of Pella Impervia Fixed Frame Window available with applied grilles.
- Foam Insulated frame and sash available on Pella Impervia Windows and Doors, except special shapes. (Only available with SunDefense™ Glazing option.) PMB #57-2009.

April 2010:

- The glazing bead on Pella Impervia products changed to a miter angle corner cut which will match the frame and sash corner aesthetic. In addition, the update includes a material change from Duracast to a fiberglass resin part to improve ease of installation. (Running Change).



Previous-Straight Design



4/2010-Current
Pinwheel Pattern

May 2010:

- Pella Impervia windows and doors dual-color option available, Pella Impervia products can have a White interior and choice of a White, Tan or Brown exterior. Phased in launch; 10/2010, 03/2011 with full launch 6/2011. PMB #26-2010 PMB #30-2010, #31-2010, #32-2011.

GBG:

- Match Interior and Exterior Finish.

Frame Options:

- Block Frame.
- Block Frame with Standard Fin.
- Block Frame with Offset Fin.
- Flush Flange.
- Integral Nail Fin is not available. The Block Frame with Standard Fin should be ordered for new construction opportunities.

January 2014:

- Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #06-2014.

Color combinations included:

- Black Exterior / Black Interior
- Black Exterior / White Interior*
- Morning Sky Gray Exterior/ Morning Sky Gray Interior
- Morning Sky Gray Exterior / White Interior*
  *Dual Color units available in Block Frame only.
- Black and Morning Sky Gray color-matched hardware available for all Impervia products.
- Mono and Dual-color GBG's available on all products.

January 2020:

- Current Design Direct Set Discontinued. (Stopped taking orders 12/31/2019.) Replacement glass and frame stops will continue to be available in PQM. PMB # 5-2020.

April 2025:

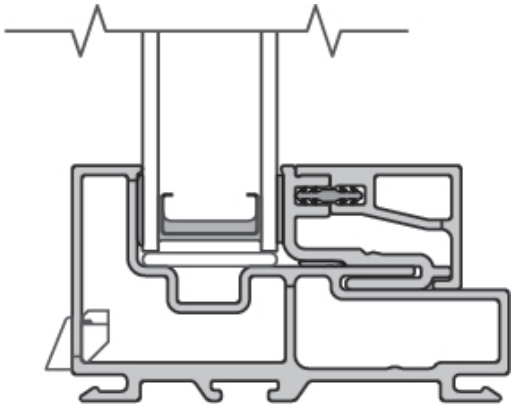
- Black jamb weatherstrip introduced for Black and brown Impervia double-hung units. White, tan and morning sky gray units will continue to receive gray weatherstrip in the jambs.
- Black weatherstrip added as service item.
  PMB #21-2025



Black DH with gray weatherstrip (Pre- 04/2025)



Black DH with black weatherstrip





January 2020:

Introduced new Direct Set Design

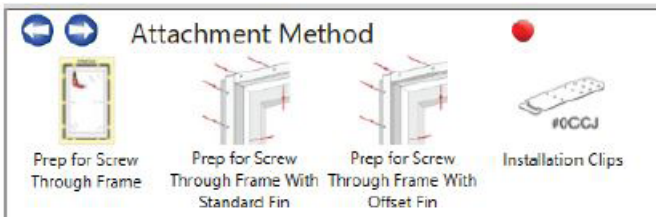
- 3-1/4: Frame Depth
- Glass stops and stop cover
- Overall 1/4" glass offset
- Weep System
- Attribute Additions
  - Sizing | 70 sq. ft
  - Triple Pane
  - Krypton
  - Performance Upgrade
    - 4mm Glass Addition
    - 5mm/6mm Options
- Glazing Serviceability
  - Dry Glaze – Interior Access Only Required
  - Wet Glaze – Exterior and Interior access required. PMB #44-2019.

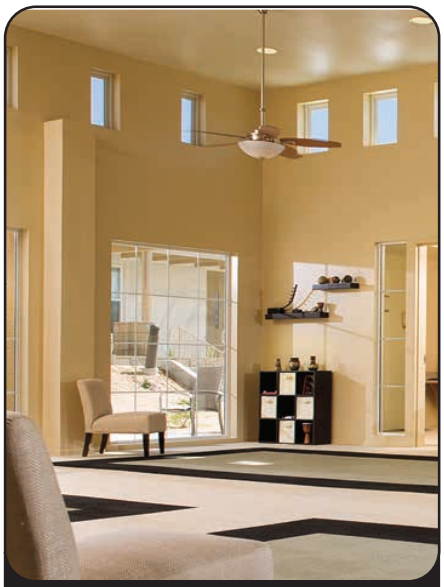
November 2020:

- Glazing Serviceability attribute, Exterior and Interior Access Required (Wet Glazed), removed from the Impervia Direct Set offering. System validation will be changed to allow an "Open Glazed Unit" (unit without glass) with this offering change. PMB #57-2020.

August 2023:

- Impervia added Impact-Resistant Glazing to offering. This glazing addition will be on the Impervia 2.0 products only: Casement, Awning, rectangle Direct Set, and Sliding Patio Door. All product types will meet Wind Zone 2 / Missile C ratings.
- Impact-resistant glass only available on Block Frame with a Prep for Screw Through Frame or Installation Clips attachment methods. PMB #31-2023





Interior



Interior

January 2003:

- Introduced.

January 2005:

- Tan color option added.

May 2005:

- Brown added as third color option for Pella Impervia - joining White and Tan.

August 2008:

- Open Frame Fixed window now available to integrate with PTAC louvers for Commercial applications.

May 2009:

- Foam Insulated frame and sash available on Pella Impervia Windows and Doors. (Only available with SunDefense™ Glazing option.) PMB #57-2009.

August 2009:

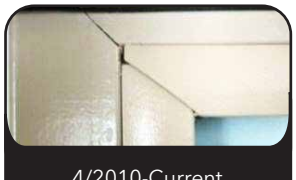
- An interior and exterior accessory groove integrated in the frame. (Exception - not on Flush Flange.) PMB #77-2009.

April 2010:

- The glazing bead on Pella Impervia products changed to a miter angle corner cut which will match the frame and sash corner aesthetic. In addition, the update includes a material change from Duracast to a fiberglass resin part to improve ease of installation. (Running Change). PMB #26-2010.



Previous-Straight Design



4/2010-Current
Pinwheel Pattern

May 2010:

- Pella Impervia windows and doors dual-color option available, Pella Impervia products can have a White interior and choice of a White, Tan or Brown exterior. Phased in launch; 10/2010, 03/2011 with full launch 6/2011. PMB #30-2010, #31-2010, #32-2011.

GBG:

- Match Interior and Exterior Finish.

Frame Options:

- Block Frame.
- Block Frame with Standard Fin.
- Block Frame with Offset Fin.
- Flush Flange.
- Integral Nail Fin is not available. The Block Frame with Standard Fin should be ordered for new construction opportunities.

January 2014:

- Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #06-2014.

Color combinations included:

- Black Exterior / Black Interior
- Black Exterior / White Interior*
- Morning Sky Gray Exterior/ Morning Sky Gray Interior
- Morning Sky Gray Exterior / White Interior*
  *Dual Color units available in Block Frame only.
- Black and Morning Sky Gray color-matched hardware available for all Impervia products.
- Mono and Dual-color GBG's available on all products.



Exterior



Interior

January 2003:

- Introduced, white color only.

January 2005:

- Tan color option added.

May 2005:

- Brown added as third color option for Pella Impervia - joining White and Tan.

March 2006:

- Improved sash miter joints; New glass-reinforced sash cornerlock in addition to the staple and polyurethane injection.
- Select sizes tape glazed, no option to choose tape or polyurethane glazing.

June 2006:

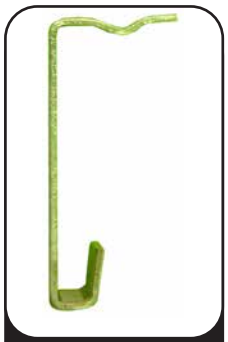
- Select sizes now taped glazed instead of PUR glazed Reference Bulletin 97-2006.

September 2007:

- Introduced adjustable keeper.
- New Take Out Clip Retaining Bracket (support bracket), service part.



Adjustable Keeper



Take-out clip support bracket

May 2009:

- Foam Insulated frame and sash available on Pella Impervia Windows and Doors, except special shapes. (Only available with SunDefense™ Glazing option.) PMB #57-2009.

August 2009:

- An interior and exterior accessory groove integrated in the frame. (Exception - not on Flush Flange.) PMB #77-2009.

October 2009:

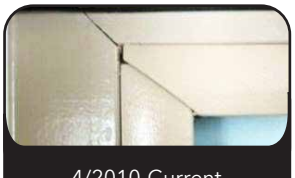
- Special sizes to the nearest 1/4" increment are available in single hung cottage and contemporary vent windows. PMB #96-2009.

April 2010:

- The glazing bead on Pella Impervia products changed to a miter angle corner cut which will match the frame and sash corner aesthetic. In addition, the update includes a material change from Duracast to a fiberglass resin part to improve ease of installation. (Running Change). PMB #26-2010.



Previous-Straight Design



4/2010-Current Pinwheel Pattern

May 2010:

- Pella Impervia windows and doors dual-color option available, Pella Impervia products can have a White interior and choice of a White, Tan or Brown exterior. Phased in launch; 10/2010, 03/2011 with full launch 6/2011. PMB #30-2010, #31-2010, #32-2011.

GBG:

- Match Interior and Exterior Finish.

Hardware:

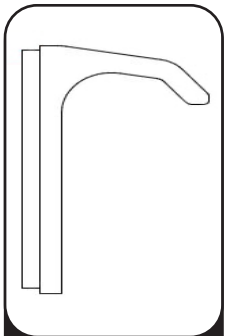
- Match Interior Finish, optional available in Satin Nickel, Bright Brass or Oil Rubbed Bronze.

Frame Options:

- Block Frame.
- Block Frame with Standard Fin.
- Block Frame with Offset Fin
- Flush Flange.
- Integral Nail Fin is not available. The Block Frame with Standard Fin should be ordered for new construction opportunities.
- Pella Impervia Bay and Bow windows available.

September 2012:

- Field applied lower sash lift available for Impervia Single-Hung and Double-Hung units. PMB #46-2012.

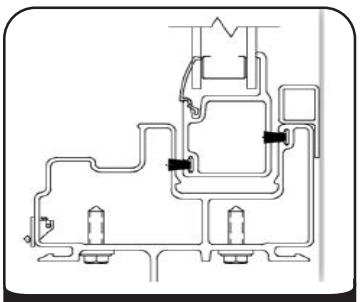


Lower Sash Lift

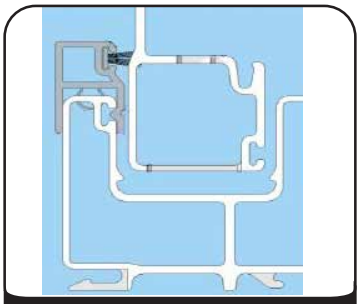
Continued on next page

November 2012:

- Single-Hung High Performance Kit Redesign. Attaches to sill using snap fit, added integrated bulb gasket. PMB#54-2012.



Pre-11/2012



11/2012 - Current

February 2013:

- Interlocker weatherstrip redesign features a strip of mohair with dual fins used as the interlocker plug for both the fixed and vent sash. Running Change, can retro-fit on previous vintages units. PMB #6-2013.



Impervia SH-SW 2013 – Current Fixed Interlocker Plug



Impervia SH-SW 2013 - Current Vent Interlocker Plug



Impervia SH-SW Previous Fixed Interlocker Plug



Impervia SH-SW Previous Vent Interlocker Plug

January 2014:

- Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #06-2014.

Color combinations included:

- Black Exterior / Black Interior.
- Black Exterior / White Interior*.
- Morning Sky Gray Exterior/ Morning Sky Gray Interior.
- Morning Sky Gray Exterior / White Interior*.
  *Dual Color units available in Block Frame only.
- Black and Morning Sky Gray color-matched hardware available for all Impervia products.
- Mono and Dual-color GBG's available on all products.



Interior



Interior

January 2003:

- Introduced.

January 2005:

- Tan color option added.

May 2005:

- Brown added as third color option for Pella Impervia - joining White and Tan.

March 2006:

- Improved sash miter joints; New glass-reinforced sash cornerlock in addition to the staple and polyurethane injection.
- Select sizes now tape glazed, no option to choose tape or polyurethane glazing.

June 2006:

- Design performance changes, Select sizes now taped glazed instead of PUR glazed. Reference Bulletin 97-2006.

March 2007:

- Roller enhancement with non corrosive housing, new dual nylon (rounded) rollers with a slimmer housing and new sill track. New roller housing is NOT retrofitable on previous vintage.



SW Roller Assembly 2003 - 2/28/2007



SW Track 2003 - 2/2007



SW Roller Assembly 3/2007 - Current



SW track 3/2007 - Current

August 2007:

- Introduced adjustable keeper.



Adjustable Keeper

April 2008:

- OX, XO Sliding Windows now available in shorter heights; XOX windows available in narrower widths.

May 2008:

- 2- and 3-Panel sliding windows now available with 6-Lite and 9-lite prairie GBG patterns with the option to choose no GBG in the center panel on 3-Panel sliding windows.

May 2009:

- Foam Insulated frame and sash available on Pella Impervia Windows and Doors, except special shapes. (Only available with SunDefense™ Glazing option.) PMB #57-2009.

August 2009:

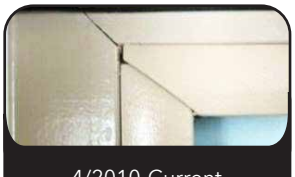
- An interior and exterior accessory groove integrated in the frame. (Exception - not on Flush Flange.) PMB #77-2009.

April 2010:

- The glazing bead on Pella Impervia products changed to a miter angle corner cut which will match the frame and sash corner aesthetic. In addition, the update includes a material change from Duracast to a fiberglass resin part to improve ease of installation. (Running Change). PMB #26-2010.



Previous-Straight Design



4/2010-Current Pinwheel Pattern

May 2010:

- Pella Impervia windows and doors dual-color option available, Pella Impervia products can have a White interior and choice of a White, Tan or Brown exterior. Phased in launch; 10/2010, 03/2011 with full launch 6/2011. PMB #30-2010, #31-2010, #32-2011.

GBG:

- Match Interior and Exterior Finish.

Hardware:

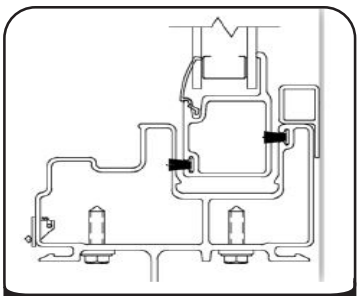
- Match Interior Finish, optional available in Satin Nickel, Bright Brass or Oil Rubbed Bronze.

Frame Options:

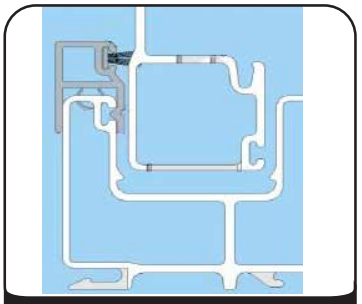
- Block Frame.
- Block Frame with Standard Fin.
- Block Frame with Offset Fin
- Flush Flange.
- Integral Nail Fin is not available. The Block Frame with Standard Fin should be ordered for new construction opportunities.
- Pella Impervia Bay and Bow windows available.

November 2012:

- Sliding Window High Performance Kit Redesign. Attaches to sill using snap fit, added integrated bulb gasket. PMB #54-2012.



Pre-11/2012



11/2012 - Current

February 2013:

- Interlocker weatherstrip redesign features a strip of mohair with dual fins used as the interlocker plug for both the fixed and vent sash. Running Change, can retro-fit on previous vintages units. PMB #6-2013.



Impervia SH-SW 2013 – Current Fixed Interlocker Plug



Impervia SH-SW 2013 - Current Vent Interlocker Plug



Impervia SH-SW Previous Fixed Interlocker Plug



Impervia SH-SW Previous Vent Interlocker Plug

January 2014:

- Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #06-2014.

Color combinations included:

- Black Exterior / Black Interior.
- Black Exterior / White Interior*.
- Morning Sky Gray Exterior/ Morning Sky Gray Interior.
- Morning Sky Gray Exterior / White Interior*.
  *Dual Color units available in Block Frame only.
- Black and Morning Sky Gray color-matched hardware available for all Impervia products.
- Mono and Dual-color GBG's available on all products.



Exterior



Interior



Interior

March 2005:

- Introduced.

July 2005:

- Sliding door keylocks now available in White, Brown or Tan.
- Stainless steel patio door lock hardware now available.

August 2007:

- New interior and exterior door hardware design.
- Interior handle - installation hole re-positioned and Pella® logo shifted.
- Exterior handle- sleeker, slim design with integrated keylock.
- New handle retro-fits to all units as long as both interior and exterior handles are same vintage.



Exterior - Pre-August 2007



Interior - Pre-August 2007



Exterior - August 2007-4/2010



Interior - August 2007-4/2010

March 2008:

- Complete offering available in custom sizes at 1/4" increments.

October 2008:

- Sliding Patio Door Fixed Panel available to be mulled to 2 panel door in the field using a fixed door mullion kit.
- October 2008 6-Lite (formerly named 9-lite perimeter pattern) and 9-lite GBG patterns now available.

May 2009:

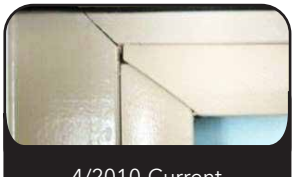
- Foam Insulated frame and sash available on Pella Impervia Windows and Doors, except special shapes. (Only available with SunDefense™ Glazing option.) PMB #57-2009.

April 2010:

- The glazing bead on Pella Impervia products changed to a miter angle corner cut which will match the frame and sash corner aesthetic. In addition, the update includes a material change from Duracast to a fiberglass resin part to improve ease of installation. (Running Change). PMB #26-2010.



Previous-Straight Design



4/2010-Current Pinwheel Pattern

Continued on next page.

April 2010:

- New Pella branded color matched hardware design for Pella Impervia patio sliding doors. Previous style hardware was available for 2 years as service part. PMB #27-2010.



Interior Handle
4/2010 - 06/2021

May 2010:

- Pella Impervia windows and doors dual-color option available, Pella Impervia products can have a White interior and choice of a White, Tan or Brown exterior. Phased in launch; 10/2010, 03/2011 with full launch 6/2011. PMB #30-2010, #31-2010, #32-2011.

GBG:

- Match Interior and Exterior Finish.

Hardware:

- Match Interior Finish, optional available in Satin Nickel, Bright Brass, Antique Brass, Chrome or Oil Rubbed Bronze.

Frame Options:

- Block Frame.
- Block Frame with Standard Fin.
- Block Frame with Offset Fin.
- Flush Flange.
- Integral Nail Fin is not available. The Block Frame with Standard Fin should be ordered for new construction opportunities.
- Pella Impervia Bay and Bow windows now available.

March 2011:

- Bumper location changed to allow a greater clearance between the interior operating handle and frame of fixed panel when operating vent panel. PMB #16-2011.

Important Changes to sizing:

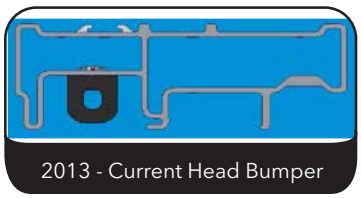
- New Clearance Between handle and frame = 1-3/4".
- Clear Opening Width = (Frame Width / 2) – 7-7/16".
- ADA Requirements = 32" clearance (Minimum door frame width is 78-3/4" to meet ADA Requirements).
- Frame Width must be greater than 54-3/4" to meet 20" egress requirements.

January 2013:

- Sliding Patio door bumper re-designed for better bumper retention.
- Sill bumper has slit to wrap around the vent panel track and sit against the jamb to help absorb the load.
- Head bumper is attached with two rivets and sits against the jamb. PMB #4-2013



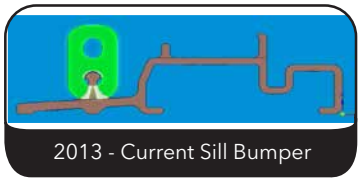
2005 - 2012 Head Bumper



2013 - Current Head Bumper



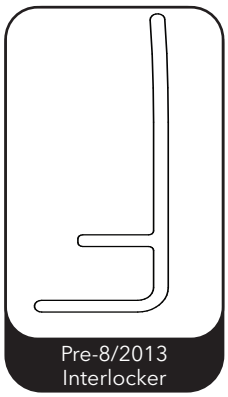
2005 - 2012 Sill Bumper



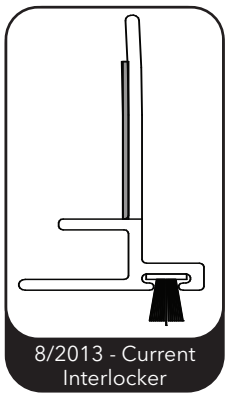
2013 - Current Sill Bumper

August 2013:

- Vent Panel interlocker profile changed.

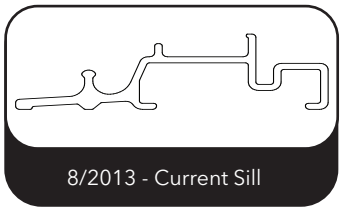


Pre-8/2013
Interlocker

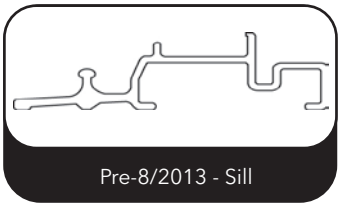


8/2013 - Current
Interlocker

- Sill profile changed.



8/2013 - Current Sill



Pre-8/2013 - Sill

January 2014:

- Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #06-2014.

Color combinations included:

- Black Exterior / Black Interior
- Black Exterior / White Interior*
- Morning Sky Gray Exterior/ Morning Sky Gray Interior
- Morning Sky Gray Exterior / White Interior*
  *Dual Color units available in Block Frame only.
- Black and Morning Sky Gray color-matched hardware available for all Impervia products.
- Mono and Dual-color GBG's available on all products.

December 2021:

- Model 1 Impervia Sliding Door Screen no longer available. All model 1 (Pre2021) replacement screens will be the model 2 design. Model 2 screen is retrofittable to model 1 frame but will require a few modifications. PMB#86-2021

June 2021:

- Impervia 2.0 Sliding Patio Door launched. PMB #35-2021, #53-2021, #58-2021



Secondary Lock

August 2021:

- 9' and 10' heights with knock-down capability added to the Impervia 2.0 sliding patio door offering. PMB#65-2021

August 2023:

- Impervia added Impact-Resistant Glazing to offering. This glazing addition will be on the Impervia 2.0 products only: Casement, Awning, rectangle Direct Set, and Sliding Patio Door. All product types will meet Wind Zone 2 / Missile C ratings.
- Impact-resistant glass only available on Block Frame with a Prep for Screw Through Frame or Installation Clips attachment methods. PMB #31-2023

July 2022:

- Impervia 1.0 Sliding Patio Door relaunched as Impervia Classic Design Sliding Patio Door, with a limited offering. Available exclusively to Commercial, Trade and Pro-Dealer. PMB #29-2022

Product Information



Size:
6′ x 6′8″
71.5″ x 79.5″ Frame Size

Color:
Black/Black
White/White
Brown/Brown
No Tan
No Morning Sky Gray
No Dual Color

Venting:
Fixed / Vent
Vent / Fixed

Included Attributes:
Advanced Low-E
Tempered
Foam- Standard
Removable Standard
Nail Fin
In-View Screen Only

Excluded Attributes:
No Footbolt
No GBGs
No Variances

Performance Attributes:
LC-PG35
STC27
OITC 22
0.30 U-Value
0.29 SHGC

November 2022

- Impervia 1.0 Classic Design Sliding Patio Door discontinued. PMB #54-2022



Interior



Interior

June 2006:

- Introduced Half Circle.
- Full Arch Head.

July 2006:

- Added Partial Arch Head.
- Springline.
- Quarter Circle.

September 2006:

- Added Right and Left Trapezoid.
- Pentagon.
- Right and Left Triangle.
- Isosceles Triangle.

August 2009:

- An interior and exterior accessory groove integrated in the frame of Pella special shape 3" frame. (Exception - not on Flush Flange.) PMB #77-2009

January 2014:

- Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #06-2014

Color combinations included:

- Black Exterior / Black Interior
- Black Exterior / White Interior*
  *Dual Color units available in Block Frame only.
- Morning Sky Gray Exterior/ Morning Sky Gray Interior
- Morning Sky Gray Exterior / White Interior*
  *Dual Color units available in Block Frame only.
- Black and Morning Sky Gray color-matched hardware available for all Impervia products.
- Mono and Dual-color GBG's available on all products.



Double-Hung Bay, Interior



Casement Bow, Exterior



Casement Bow, Interior

May 2010:

Pella Impervia Bay and Bow windows introduced:

- Interiors and exteriors on Pella Impervia windows are available in White, Tan or Brown. Exterior bay and bow frame is Aluminum Cladding to match window colors.
- Bay and bow frame interior is Wood.
- Optional birch and oak headboards and 3/4" insulated seatboards. Non-insulated seatboard is also available. Bay and bow wood frames come in choice of five prefinished stains, prefinished White, primed or unfinished. PMB #35-2010.

July 2012:

- Head and seat board material options for 8' and 10' bays and bows changed from Birch and Oak to Maple and Oak. This applies to both the square and angle designs. PMB #43-2012.

January 2014:

- Interior frame finish options expanded from Unfinished, Pella Pre-finished White and Pella Primed to include, Natural, Golden Oak, Early American, Provincial, Special Walnut, Red Mahogany, Dark Mahogany, Cherry, Linen White, and Bright White. PMB #07-2014.

HARDWARE

Pella Impervia

Accessibility lock lever with elongated lever that when paired with Easy Slide Operator allows to meet 5 pounds of operation force. PMB#56-2021	 6" Lock Lever	June 2021
Black hardware finish on all Impervia windows and doors changed from glossy finish to a matte finish. Glossy Black not available as service part, all replacements will be Matte Black. PMB #62-2017.		September 2017
Oil-Rubbed Bronze finish on Impervia windows changing from living finish to a non-living finish. (ORB finish on Impervia patio door is already a non-living finish). ORB living finish not available as service part, all replacements will be non-living finish. PMB #62-2017.		September 2017
Impervia awning and casement crank covers changed from snap-on to interior frame stop to an extended cover held in place with a screw. (Similar to wood AW & CM design.) PMB #62-2017.		September 2017
Construction Hardware no longer shipped with Impervia venting Casement, Awning and Large Awning units. PMB #29-2017.		April 2017
All patio door hardware - All Key cylinders changed to a Key-Way (Kwikset) cylinder, eliminating current (Schlage) cylinder. PMB # 33-2016.		July 2016
New Pella branded color matched hardware design for Encompass by Pella, ThermaStar by Pella and Pella Impervia patio sliding doors. Interior and Exterior handle plus key cylinder changes for Encompass by Pella. Only the interior handle design changed for Pella Impervia Patio doors. Previous style hardware was available for 2 years as service part. PMB #27-2010.	 Pre-4/2010 Handle  4/2010 - 06/2021	April 2010

WINDOW OPENING CONTROL DEVICE (WOCD) AND LIMITED OPENING / LIMITED TRAVEL (LOLT) HARDWARE FOR ALL PELLA IMPERVIA PRODUCTS VENTING WINDOWS

Pella Impervia

The window opening control device (WOCD) available on Impervia casement windows has been updated. The new design enables improved quality, installation and operation. The new design updates sizing limitations. The new design is not able to be installed on units with a Frame Width less than 20". This means units with a width of 17.5" up to 20" must have Limited Opening Hardware if a fixed opening is required. PMB #32-2025	  	May 2025
PQM updated to no longer lock all commercial segment casement venting windows to either a Window Opening Control Device (WOCD) or a Limited Opening, Limited Travel (LOLT) hardware option. WOCD and LOLT hardware options will continue to be pickable options in PQM. This will affect Pella Impervia in addition to other brands. Casements in the Commercial segment will be defaulted to having a WOCD device but can be deselected. PMB #38-2023		August 2023
NEW Casement Window Opening Control Device on Pella Impervia. New WOCD Key design features: • The sash arm hangs more vertically and features reliable engagement. • The carriage feature locks the sash arm into the frame track. • The sash arm tab and backstop allow for back-pressure for engagement with the frame track carriage. • The device is easily released by pressing and sliding the red release button upwards. • A stop feature limits the carriage travel. Impervia – Both Frame holes will be visible – should be filled with silicone sealant. Neither Sash hole will be visible. PMB #43-2020.		November 2020
WOCD Hardware removal kit available through Customer Service until January 31, 2018. PMB #56-2017		August 7, 2017

Continued on next page

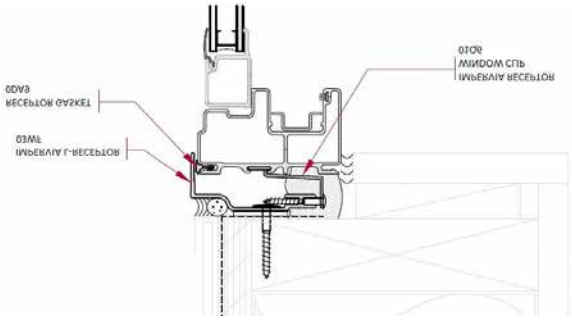
LIMITED OPENING / LIMITED TRAVEL HARDWARE FOR ALL PELLA PRODUCTS VENTING WINDOWST

Pella Impervia

As of June 12, WOCD no longer installed on all Impervia Casements based on enhancements: 1) increasing the height of the stop screws on sash hinge slides. 2) Metal bracket added which increases the force the roto-operator window opening mechanism can withstand prior to the roto-operator sustaining damage. PMB #38-2017	June 2017
All Impervia vent Casements, come with a window opening control device (WOCD) installed in the factory prior to shipment. 	March 30, 2017
Limited opening hardware available factory installed on Sliding Window, Awning and Large Awnings variance no longer required.	March 30, 2017
Window Opening Control Device (WOCD) hardware available as out of unit accessory for all brands of Casements and Awnings available to meet ASTM F- 2090 Standard. PMB #31-2014.	June 2014
Window Opening Control Device (WOCD) hardware is non-integrated and available as an out of unit accessory for all brands of Double-Hung, Single-Hung and Sliding Windows available to meet ASTM F- 2090 Standard. Please note this hardware is different than the 250 DH and Pella® 350 Series DH WOCD vent stop hardware. PMB #25-2014.	April 2014
Pella® double-hung, single-hung, or sliding window products - after-market (Roto-Frank) WOCD to meet ATSM Standard F2090-10 code requirement. Available finishes: White, Chrome and Oil Rubbed Bronze. PMD #42-2012.	July 2012
Double Hung, an aftermarket limited opening device solution to meet ASTM Standard F2090-08 from Mighton Products available in White, chrome and oil rubbed bronze finishes. PMB #80-2010.	November 2010
Casement/Awning (Available as Out-of Unit Accessory). PMB #101-2009.	October 2009
Double Hung (Available as Out-of Unit Accessory).	February 2007
Single Hung (Available as Out-of Unit Accessory).	February 2007
Sliding Window (Available as Out-of Unit Accessory).	February 2007

ACCESSORIES

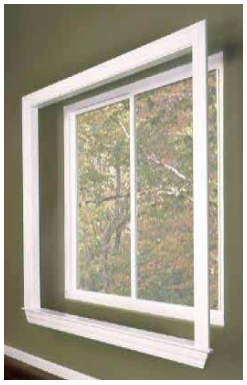
Installation Accessories

All Brands - the following 7 installation sealant colors will no longer be standard pickable but these colors will be available through product variance / special order but will not be a pickable option in PQM due to supplier capability constraints. Matte Gray, Sage, Blue Ash, Frost Blue, Spice Red, Pearl Gray , Satin Steel. PMB #37-2026	August, 2026
Impervia now offering factory applied jamb extensions. Factory applied jamb extensions available on all product types except Sliding Patio Door and non-rectangular Direct Set shapes. Impervia's jamb extension offering includes jamb extended wall depths of 4 9/16" and 6 9/16" in three different finishes: Prime, Black Stain, and Pre-Finished White. Jamb extensions are available on block frame with slide in fin or nail fin frame types. The jamb extension will fit into the interior accessory groove and will be attached with clips. Field kit options will be available as well and installation instructions will be available on PERL. PMB #01-2024	January 2024
Azek Exterior Trim offering eliminated. Includes all Azek trim ordered as a configured items with complete units OR Ordered as a Service Item. PMB #45-2018.	August 2018
Ready Trim, Ready Trim Knockdown, Ready Trim Plus, and Ready Trim Plus Knockdown eliminated as configured interior trim options from all brands and all product types. Curve Trim is not affected. 72" trim lineal, in existing styles and widths, added to the lineal collection. Encourages use of shorter lengths (ongoing challenge to source 144" material). 72" lineal can be used to trim out most single unit window openings. PMB #13-2018.	March 2018
The Impervia L-Receptor can be ordered directly in the Pella® Catalog. Impervia L-Receptor: Commercial Applications. The intent of the Impervia L-Receptor is for Commercial Projects requiring the unit to be installed from the interior. ***Please Note: When ordering the Impervia L-Receptor, it is necessary to also order the Receptor Gasket (0DA9) and the Impervia Receptor Installation Clips (01Q6)***. The Impervia L-Receptor is available in 192" length, and in quantities of 1 or 10. The L-Receptor is also available in all 5 Impervia Colors: White, Tan, Brown, Black, and Morning Sky Gray. PMB #12-2014. 	February 2014
Ready Trim Plus Knock Down with Stool; (Stool length update.) Stool length provided as (Frame Width + 14") to allow for returns on the ends of the stool to be used. PMB # 15-2014.	February 2014
Curved Interior Trim offering expanded to be offered in all 34 Pine and 25 Oak profiles to compliment the lineal offering. Curved interior trim comes pre-assembled. Curved trim comes with a 1" minimum excess on both ends for trimming in field to ensure a tight fit against lineal trim sections. PMB #14-2013.	April 2013
Non-Wood drywall installation clip to be used in brick applications with a drywall return when replacing aluminum windows or patio doors. Clip spans the mortar joint and is designed to provide improved unit attachment. Clip intended for use with Pella® Impervia. PMB #3-2013. 	January 2013
Translucent silicone sealant added to sealant offering. PMB #48-2012.	September 2012

Continued on next page

ACCESSORIES

Installation Accessories

Flush flange installation kit available for Impervia® casements, awnings and fixed windows using pocket replacement installation. PMB #31-2012.	May 2012
Interior trim/casing offering expanded and casing names revised. PMB #16-2012.	March 2012
Pella Installation tape available in pallet quantities. PMB #50-2020	October 2020
Introduced Pella Window and Door sealant, a multi-purpose sealant for exterior, interior and bedding applications. Also custom colors and textured sealant is available. PMB #12-2012 	January 2012
Reversible rough/smooth Exterior trim now available to order in single 10' lineal lengths. Available primed and in 1 x 4 and 1 x 6 widths. PMB #1-2012.	December 2011
Plastic "U-shims" made of high impact polystyrene available for purchase. Each shim is 4-1/8" long x 1/16" thick with 5/8" fastener slot with segmented tabs for desired length. PMB #34-2011	June 2011
Installation Accessories kitted from the factory available for all PDSN's, for ALL segments. Products kitted together by job for your convenience include: Pella installation tape in 50' and 150' rolls, Exterior sealant tubes, Great Stuff gun foam 20 oz. cans, Installation clips – 6" and 8", Jamb extension screws in pkgs of 5 or 50, 3/8" closed cell backer rod. PMB #10-2011	January 2011
READY TRIM and READY TRIM PLUS introduced in all Pella trim profiles, (factory "knock down" or factory assembled (PDSN only). PMB #25-2010. 	April 2010
OSI QUAD Sealant is available in all 27 Pella EnduraClad exterior colors and is designed to deliver superior durability and performance on every installation. PMB#18-2010	April 2010
Pella Flashing Tape available in 6" widths. PMB #61-2009	June 2009
Exterior Surrounds made with AZEK trim available to be used on all Pella Products. PMB #46-2009	April 2009
Three (3) additional Interior trim profiles available for rectangular units - 2-1/2" 2-Step Colonial, 2-1/2" Frontier, 3-1/2" 2-Step Colonial for all Pella products.	March 2009
Introduced 4-3/8" flat casing option. Pre-assembled AZEK trim expansion for all Pella Products.	June 2008
Pella Flashing Tape to be Lapped 1/2" onto the Frame during fin installation.	February 2008
AZEK® Trim available to order out of unit for all Pella products.	April 2007

COLORS AND FINISHES

Pella Impervia

Tan and Morning Sky Gray re-introduced to the Impervia offering. All Impervia product types available and on standard product lead time. Tan and Morning Sky Gray will be available in single color only. Dual color offering will remain available through the Custom Solutions Variance process. PMB #20-2023	May 2023
Enhancements have been made to our Pella Impervia color match between Impervia fiberglass and our shapes. This color enhancement began with Black and White shapes in April, followed by Brown shapes in May. Our supplier is now using a formulation resulting in a closer match to Pella's Impervia powder coat color/texture and passes our UV exposure testing. We are in the process of implementing the new acrylic caps. • Acrylic cap material traditionally is only available in gloss levels that are very low (dull) or very high (shiny). Our supplier has developed a unique acrylic cap blend that brings the gloss level of the Impervia shapes much closer to the powder coated fiberglass used in the rest of the product line. • While the new Impervia shapes material is a solid step forward in color and gloss, it will continue to have a smooth finish versus the textured finish of fiberglass. This will result in aesthetic differences customers must be made aware of as they purchase Impervia shapes. PMB #17-2023	April 2023
Dual-color was re-launched for Black and Brown only. PMB #57-2022	December 2022
Tan and Morning Sky Gray eliminated from the Impervia product offering. Continuing suspension of all dual color black and brown throughout 2022. PMB #81-2021 & PMB #82-2021	March 2022
Morning Sky Gray and Tan colors and all Two-Color Options (including Black / White and Brown / White) suspended from the Impervia product offering. PMB #38-2021	September 2021
Black and Morning Sky Gray added to the entire Impervia product line. Colors align with wood clad palette therefore clad accessories can be used. PMB #32-2013 & PMB #06-2014	January 2014
Pella Impervia windows and patio doors offer dual-color option, Pella Impervia products can have a White interior with the choice of White, Tan or Brown exterior. Pella Impervia windows and patio doors arrive pre-finished with a powder-coat paint finish on both interior and exterior. PMB #32-2011	June 2011

MULLION

Direct and Structural Mullions

Any block frame (non-nail fin) factory assembled combinations with 1/2" or 1" structural mullion (with or without reinforcement) manufacture on or after July 8, 2021 will no longer be assembled with mullion end anchors. This change requires block frame combinations to be installed with additional screws through the frame, installation clips or receptor clips on both sides of the mullion ends to carry the mullion end load int the wall structure. See updated anchor schedule in the published installation instructions. All field mullion kits will continue to include the end anchors which are optional to use. PMB#62-2021	July 2021
Dual-sided foam tape and primer wipes replaced the butyl tape in all 1/2" and tight mullion kits. Service packages of butyl tape seal now obsolete. PMB #34-2014	June 2014
Impervia Mull Kit Re-design - The butyl tape included with all 1/2" and tight mull kits is being replaced by dual-sided foam tape and primer wipes. The primer wipes allow better adherence of sealant to the units. PMB#34-2014	June 2014
For Pella Impervia Window Combinations the 1/2" Offset Frame Mull Cover, the Direct Offset Frame Mull Cover can be ordered directly in the Pella® Catalog. 1/2" Offset Frame Mull Cover and Direct Frame Mull Cover: Residential and Commercial Applications. The intent of both the 1/2" Offset Frame Mull Cover and the Direct Offset Frame Mull Cover is to bridge our current 3" and 3-1/4" Frame depth products. Both Covers can be used in both horizontal and vertical applications. Both Covers are available in 144" lengths, and in quantities of 1 or 10. Both Covers are also available in all 5 Impervia. PMB #12-2014	February 2014
The mulling process for new accessory groove was outlined in Product Marketing Bulletin #04-2010 and is updated below to include the double hung window: Factory and field mulling process for Pella Impervia double hung, casement, awning, large awning, single hung, sliding window, fixed frame, and fixed window utilizes the accessory groove to join windows together. The mull process for the aforementioned windows has been modified to use a butyl tape versus wet sealant. The new mull process significantly reduces the amount of wet sealant used for a clean and more consistent assembly. The instruction still calls out for a small amount of wet sealant injected at the ends of the mull joint. The sliding patio door mull process remains unchanged and uses the I-bar joining mullion and foam tape. The sliding patio door was expected to receive the accessory groove by late 2011. PMB #41-2020	July 2010
Pella Impervia 1/2" Reinforcing Mullion and Subsill redesigned and integrates with the entire Pella Impervia window offering to allow larger mullion spans in the field, including window ribbon walls. The new design integrates with the 3" and 3-1/4" frame depths, accessory grooves, double hung slope sill and multiple frame options. PMB #42-2010	June 2010
3 and 4-way casement and awning factory assembled combinations are available to quote and order. Factory and field mulling process for Pella Impervia casement, awning, large awning, single hung, sliding window, fixed frame, and fixed window utilizes the accessory groove to join windows together. The mull process for the aforementioned windows has been modified to use a butyl tape versus wet sealant. The new mull process significantly reduces the amount of wet sealant used for a clean and more consistent assembly. The instruction still calls out for a small amount of wet sealant injected at the ends of the mull joint. The double hung and sliding patio door mull process remains unchanged and uses the I-bar joining mullion and foam tape. PMB #04-2010	January 2010
New 1/2" reinforcing mullion accessories available: 1) An external mull cover that integrates horizontally using the weep hole design. 2) An interior sliding patio door to window transom cover. PMB #84-2007	July 2007
Offering box quantities of pre-finished jamb extensions and mullion covers. PMB #74-2007	June 2007
Pella Impervia subsill mullion reinforcement end anchor available. End anchor integrates with Impervia subsill to be used with the 1/2" mullion accessories. PMB #40-2007	February 2007
The new mull cover is designed to be installed vertically into the interior and/or exterior accessory groove on all double hung products, and replaces the aluminum mull cover previously used. The mull cover design snaps into one accessory groove, therefore has the flexibility to be combined vertically with a double hung product and non-accessory groove product, like the fixed window. Once installed, the cover conceals the accessory groove and edges of the frames of the two adjoining windows. The mull cover is designed to enhance combination aesthetics and does not impact performance, therefore does not replace the foam mulling tape. PMB #18-2007	January 2007
Pella Impervia - 1/2" reinforcing mullion introduced. PMB #82-2006	June 2006

GRILLES

Pella Impervia 2- and 3-Panel sliding windows now available with 6-Lite and 9-lite prairie GBG patterns with the option to choose no GBG in the center panel on 3-Panel sliding windows.	May 2008
Impervia Top Row only GBG horizontal bar spacing standardized at 14" from visible glass.	July 2005

SCREENS

Model 1 Impervia Sliding Door Screen no longer available. All model 1 (Pre2021) replacement screens will be the model 2 design. Model 2 screen is retrofittable to model 1 frame but will require a few modifications. PMB#86-2021	December 2021
Due to a supply chain outage, the screen clips use on Impervia Double-Hung units will have a running changes from the current DH style (PN: 0CDH) to the current Wood Casement screen clips (PN: 060S) All screen clips will be mill finish. At this time all replacement DH Screen clips are also unavailable. PMB#84-2021	November 2021
NEW InView™ screen cloth optional on all Pella Impervia windows & doors. PMB #16-2010.	March 2010
Pella Impervia window and patio door screens now available, to order in-unit and ship separately on a different need date. PMB #04-2009.	December 2008

GLASS

IG, Low-E, InsulShield

Pella's Insulated Glass Options of Bronze Low-E, Gray Low-E, and Green Low-E updated to primarily a tempered only offering for Impervia products. PMB #44-2025	July 2025
Renamed "Coastal Low-E Insulating Glass" to "Turtle Glass". This change is to better align with industry norms for coastal offerings. PMB #35-2025	May 2025
New glass options; NaturalSun+ and SunDefense+ introduced. PMB #44-2023	October 2023
Impervia added Impact-Resistant Glazing to offering. This glazing addition will be on the Impervia 2.0 products only: Casement, Awning, rectangle Direct Set, and Sliding Patio Door. All product types will meet Wind Zone 2 / Missile C ratings. Impact-resistant glass only available on Block Frame with a Prep for Screw Through Frame or Installation Clips attachment methods. Two glass types will be added: PVB (Polyvinyl butyral) and SGP (SentryGlas Plus). Glass type will be locked by product type and unit size. If an upgrade from PVB to SGP glass is desired, this can be quoted via the variance process through Custom Solutions; these quotes will follow Impervia's standard variance quoting guidelines. PMB #31-2023	August 2023
Began to progressively introduce a Thermo Plastic Spacer (TPS) system into the Pella Impervia product line. TPS is an integrated spacer directly applied onto the glass allowing for a tight bond between spacer and glass. The progressive (running change) introduction began with Direct Set products, then Sliding Patio Door, then DH/SH/SW/FX and lastly CM/AWN. Not all glass types moving to the TPS system as some glass systems are still purchased from external suppliers. The goal is to use TPS on the commonly used glass types across the brand. The introduction of this spacer system does create a slight variation in aesthetic within a product type and across the Impervia platform as the spacer will be black. The serial number will no longer be printed on the spacer itself; it will be in the glass etching for all TPS product. PMB #39-2021  Intercept Unit  TPS Unit	April 2021
Pella Branded Glass and Window Cleaner discontinued.	January 2020
Tints, laminates, and mixed thickness glazing options added to all Pella® Impervia® products. Spandrel added for rectangular direct sets. PMB #63-2017.	September 2017
The maximum allowable glass area for annealed glass changed from 48 ft.^{2} to 36 ft.^{2} in PQM. Any unit exceeding a glass area of 36 ft.^{2} will require tempered glazing. Impacts Impervia rectangular direct sets.	June 2017

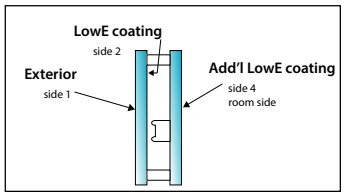
Continued on next page

GLASS

IG, Low-E, InsulShield

NEW! AdvancedComfort Low-E Insulating Glass for Pella® Wood Windows & Patio Doors and Pella Impervia® Fiberglass Windows & Patio Doors — December 2013

AdvancedComfort Low-E should be used in locations in need of minimal winter heat loss and reduced solar heat gain. This new glazing features two Low-E coating stacks which result in a lower center of glass U-value when compared to our other Low-E glazing's. This glass features the new IG spacer (see Product Marketing Bulletin #03-2014). This glass is also being introduced as a quality improvement and replacement for our existing SunDefense™ Dual Low E Insulating glass.



There are no special cleaning requirements associated with this new glazing. This coating system has shown to have a high clarity and a smooth durable surface. We DO NOT recommend using abrasive cleaners, such as Bar Keeper's Friend, on this glass.

Pella Impervia Products:

We are pleased to announce AdvancedComfort Low-E as an additional insulating glass option for all Pella Impervia Products. This additional energy efficient low-E insulating glazing option features two Low-E coating stacks and will provide your customers with an energy efficient product will meet or exceed anticipated 2015 ENERGY STAR criteria.

New IG spacer helps provide improved thermal performance. — December 2013

- All AdvancedComfort Low-E Insulated Glass (see Product Marketing Bulletin 02-2014) will use this new IG spacer.
- This spacer will be implemented as a running change on all Pella® Wood Windows and Patio Doors by Q2 of 2014.
- This spacer will be used on select glazings for Encompass by Pella®, Pella® 350 Series, and Pella® Impervia products.





Current IG Spacer used in select Encompass by Pella, Pella 350 Series, and Pella Impervia products

---

Pella Glass & Window Cleaner introduced. — November 2013

The Pella Glass & Window Cleaner has been tested against other premium cleaners and delivers outstanding cleaning performance on all glass surfaces. It has been specially formulated to be environmentally friendly and does not contain harmful detergents, bleach or ammonia. The product is offered in a 24 oz. bottle with an ergonomic handle and foaming trigger for optimal cleaning performance. In addition, a 1 gallon refill is available.



The cleaner will be produced by Bryson Industries, Inc. out of Greensboro, North Carolina.

Standard Low-E insulating glass eliminated as standard glazing option. — February 2010

NaturalSun Low-E introduced. PMB #29-2010. — May 16, 2010

Revised the standard IG thickness on **interior glazed** support products. Products were previously available in a standard 5/8" and 1" IG are available in a standard 13/16" and I" IG. — December 2009

Announcing Advanced Low-E insulating glass option for all Impervia® products. PMB #109-2009. — November 29, 2009

Advanced Low-E introduced. (There is one Low-E coating stack (in the airspace) made up of two silver layers.) PMB #109-2009. — October 26, 2009

SunDefense™ (SunDefense and SunDefense Obscure) in High Altitude with argon available in Pella Impervia products to use in Altitudes between 3500 ft. and 8500 ft. PMB #75-2009. — July 2009

Pella Impervia and Pella Special Shape Products available with SunDefense™ Low-E Glazing. — May 2009