Pella® Vinyl Products

PRODUCT IDENTIFICATION AND HISTORY GUIDE

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Vinyl Windows and Door Manufactured by Pella Corporation:

- ThermaStar by Pella® was introduced in 2003. ThermaStar by Pella brand vinyl windows and doors are sold through Lowe's Home Improvement stores.
- Centera by Pella® introduced in 2007, sold through ProDealer and other National Accounts channels, other than Lowe's, discontinued 02/2012.
- Encompass by Pella® introduced in 2008, sold through the Pella Direct Sales Network (PDSN).
- Pella® 350 Series doors. Introduced in 2010. Sold through all sales channels.
- 15 Series DH, introduced July 2011, discontinued March 2015 (PMB #26-2015). Sold through Lowe's Home Improvement Centers East Region Only.
- Pella® 350 Series Window. Introduced August 2011. Sold through all sales channels.
- 250 Series Vinyl windows introduced in January 2014. PMB #41-2013 and PMB#4-2014.
- Designations 10/20/25 Series eliminated in Encompass by Pella and ThermaStar by Pella. PMB #9-2014.
- Fossil color added to Encompass® by Pella and Pella® 250 Series offerings in June 2018. PMB #34-2018.
- Eliminated the use of Endorsed Vinyl (Encompass and ThermaStar) in project openings 40 feet or higher (as measured from grade to the top of the opening). Exception: Until the 250 Series Patio Door is available the Endorsed Vinyl Patio Door May still be utilized on these projects and be covered under warranty. PMB #77-2018.
- Pella 150 Series introduced in 02/2020. Pella 150 Series brand vinyl (block frame only) windows are sold through Lowe's Home Improvement Stores, and only available in Double-Hung and Patio Door. PMB #28-2020.
- Pella 250 Series PSE (Project Sales Exteriors) Exclusive Bundle was introduced in 5/2020. The PSE Exclusive Bundle is only available through the PSE at Lowe's Home Improvement Stores. PMB #28-2020.
- ThermaStar by Pella PD eliminated in the East. November 2020.
- Pella® 350 Series Windows and Doors eliminated April 2021. NA-PMB #12-2021 & PMB #22-2021.
- ThermaStar by Pella brand eliminated - January 6th, 2022, NA-PMB #3-2022.

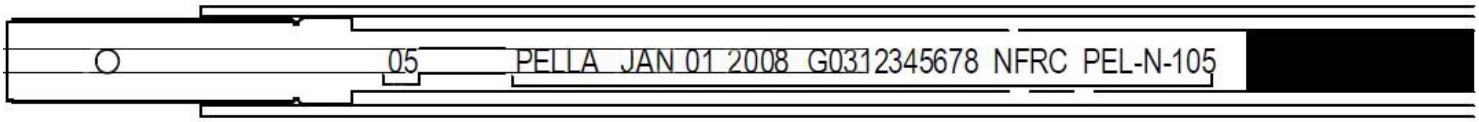
SERIAL NUMBER LOCATIONS:

Pella Vinyl Products made with Intercept IG system have a printed character string in an upper corner of the spacer channel. This permanent character string includes a Serial Number.



Pella Vinyl Products made with a Superspacer IG or box spacer IG system have a printed character string on a Pella Unit ID Sticker placed in the Lower RH Corner of the unit. The character string provides the same product information as the Intercept spacer provides. Fixed Frame and Radius Shape units use this type of IG System, as well as large rectangular units where 5 mm glass thickness is required.

The first three (3) characters of the Serial Number represent the producing Plant of the product (IE G03xxxx = Gettysburg Plant). This serial number can be entered into a look-up function from MyPella.com allowing Pella service personnel to view all the attributes of the product. (Glass Type--Dimensions--Product Type).



SPACER SERIAL NUMBER BREAK DOWN:

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

Example: This Unit Label break down

IGCC® IGMAPELLA Jan 01 2007 G0312345678 NFRC pel-n-105

- **NFRC** = National Fenestration Rating Council
- **12345678** = Oracle Number or Unit ID
- **G03** = Manufacturing Location
- **JAN 01 2007** = Month/Day/Year of Manufacture
- **PELLA** = Manufacturer
- **IGCC® IGMA** = 3rd Party Certification

Manufacturing Locations		
GETTYSBURG	VINYL	G03
MURRAY	AMD	M03
	VINYL	M02
PORTLAND	VINYL	P52
STORY CITY	VINYL	SC2
TUCSON	VINYL	T02
COLUMBIA	VINYL	W02
TROY	VINYL	V04
REIDSVILLE	VINYL	V02
OCALA	VINYL	CW1

Serial numbers with the following format were used on product built in Portland from 2004 – 05/2007:

P21 IG3 May6 2003 6 976156 08

Serial numbers from this time frame cannot be looked up on MyPella.com.

Another example of an older spacer serial number:

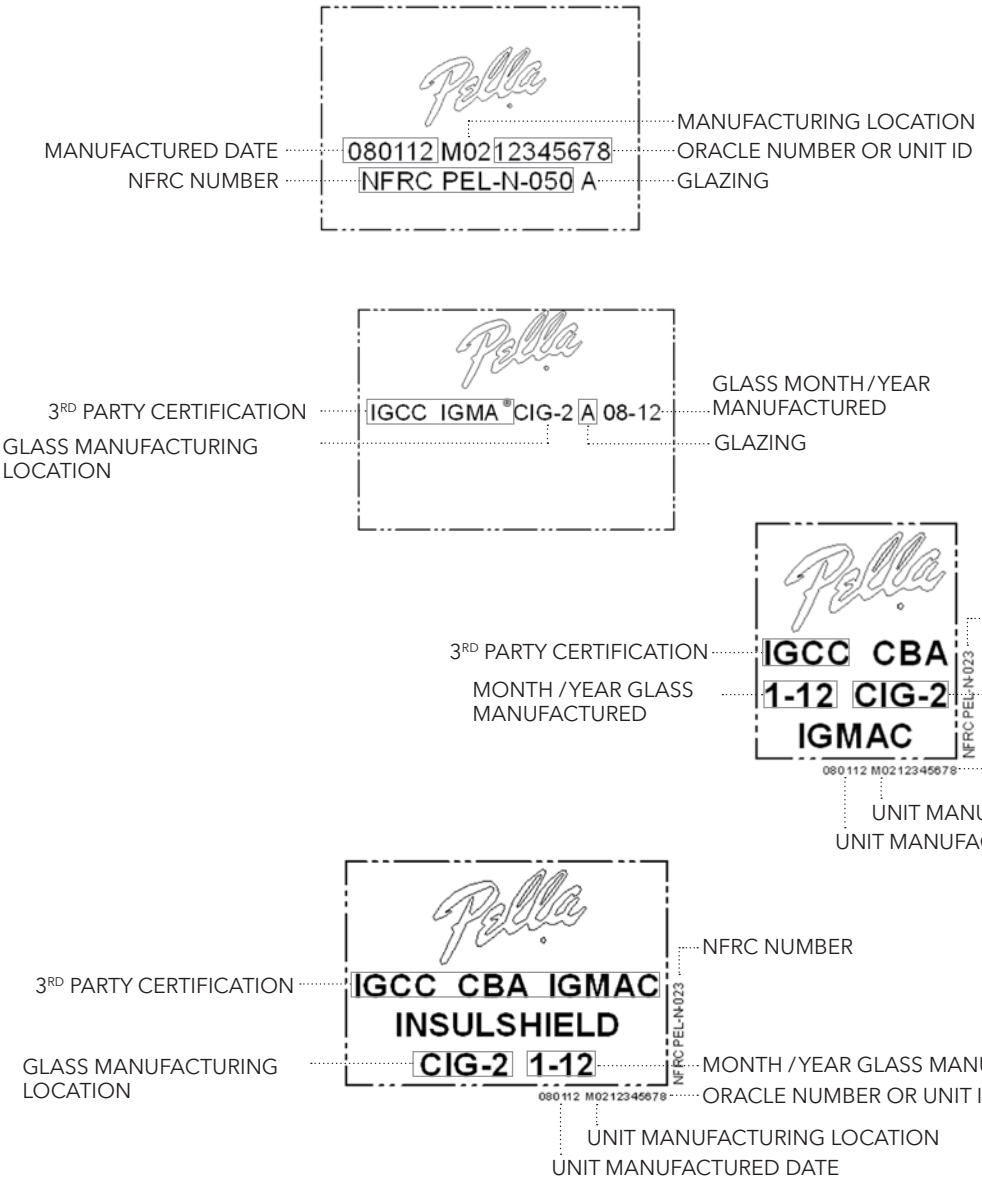
PELLA TSTAR DOUBLE HUNG G-0310047019-NFRC Apr 16 2003
Manufacturer, Window type, Plant Code & Serial Number, NFRC, Date

Vinyl sliding doors with Blinds-between-the-glass (BBG) have an identification sticker on the glass.

15 Series vinyl double-hungs have an identification sticker on either the left or right side of sash containing a unique serial number which is different than the serial numbers on IG spacers. There are two kinds of serial numbers, one indicates stock and the other SOS (Special order).



INSULATING GLASS IDENTIFICATION — 2011–2014:

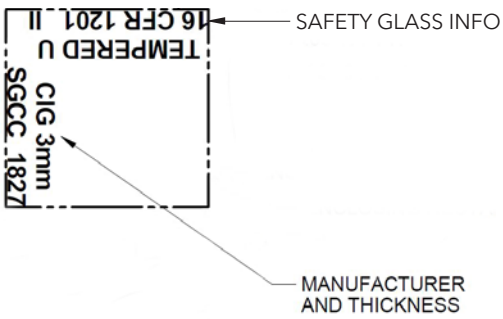


Glazing
A = LOW-E
B = CLEAR
C = SUNDEFENSE LOW-E
E = SUNDEFENSE DUAL LOW-E
F = ADVANCED LOW-E
H = NATURALSUN LOW-E
M = TRIPLE NATURAL SUN LOW-E
N OR S = TRIPLE ADVANCED LOW-E
P = TRIPLE SUN DEFENSE LOW-E

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

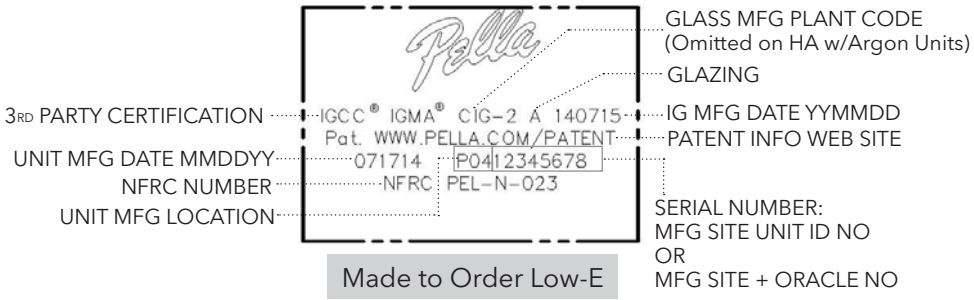
OTHER GLASS ETCHES

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 — 2015–03/2023:



Made to Order Low-E



Made to Stock Low-E

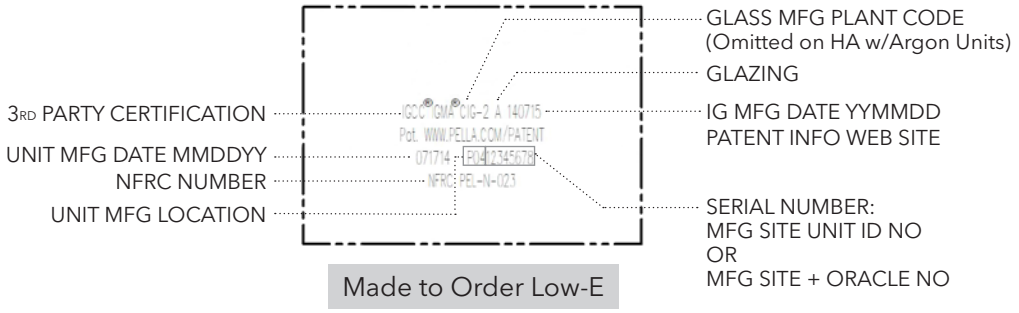
Glazing
A = LOW-E
B = CLEAR
C = SUNDEFENSE LOW-E
E = SUNDEFENSE DUAL LOW-E
F = ADVANCED LOW-E
H = NATURALSUN LOW-E
M = TRIPLE NATURAL SUN LOW-E
N or S = TRIPLE ADVANCED LOW-E
P = TRIPLE SUN DEFENSE LOW-E

Manufacturing Locations		
GETTYSBURG	VINYL	G03
MURRAY	AMD	M03
	VINYL	M02
PORTLAND	VINYL	P52
MACOMB	VINYL	M06
TROY	VINYL	V04
REIDSVILLE	VINYL	V02
OCALA	VINYL	CW1

SERIAL NUMBER EXAMPLE:



INSULATING GLASS IDENTIFICATION — 2023-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
MACOMB	VINYL	M06
TROY	VINYL	V04
REIDSVILLE	VINYL	V02
OCALA	VINYL	CW1

SERIAL NUMBER EXAMPLE:

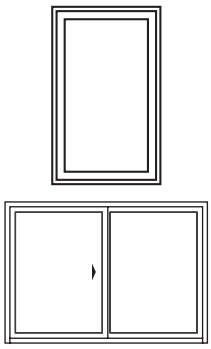
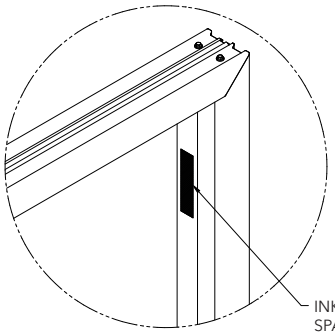
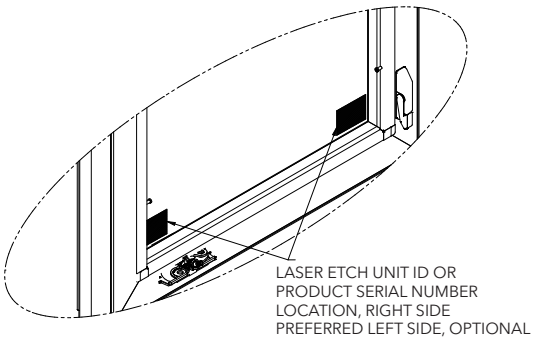
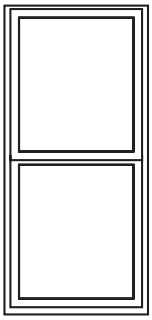
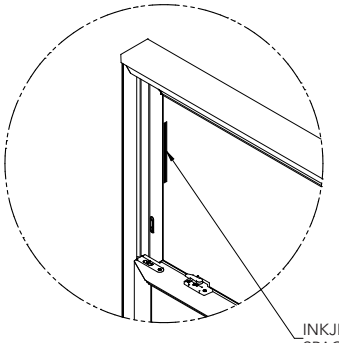
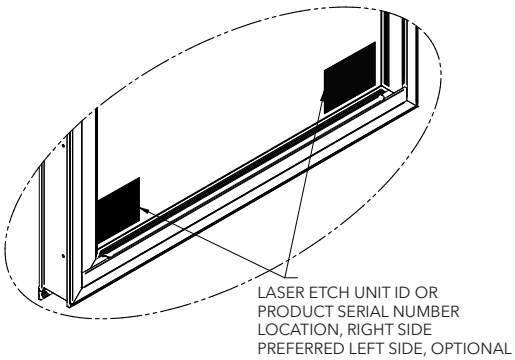
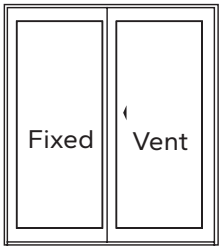
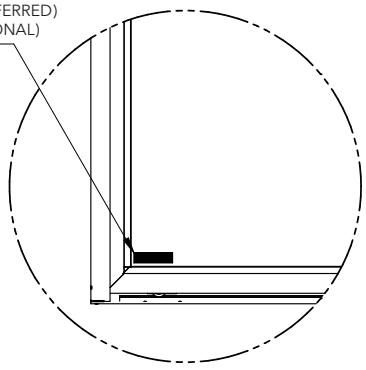
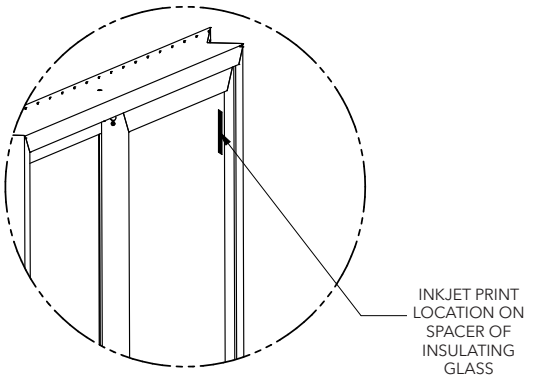


SPACER SERIAL NUMBER BREAK DOWN:

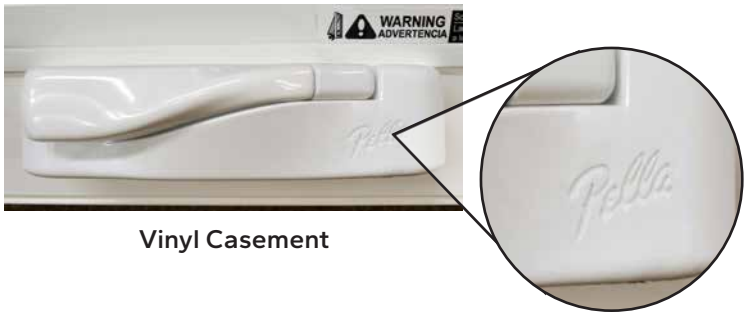


Example: Fiberglass & Vinyl IG Spacer Serial Number break down (Oracle Only) (2015 - Current)

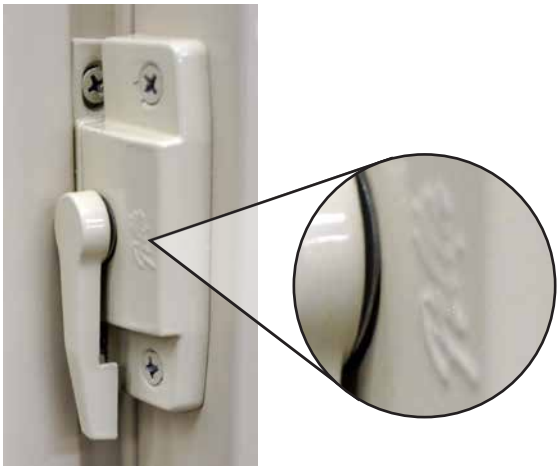
IGCC® IGMA®	**G03**	**12345678**	**NFRC PEL-N-105**	**PELLA**	**PAT. WWW.PELLA.COM/PATENT**	**Jul 15 2014**	**08:21**	**3-05** Line Info
							Glass MFG Time	
						Jul 15 2014 = Glass MFG Date		
					WWW.PELLA.COM/PATENT = Patent Info Web Site			
				PELLA = Manufacturer				
			NFRC PEL-N-105= National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

PRODUCT TYPE	LABEL TYPE / LOCATION
CASEMENT / SLIDING WINDOW 	 ALL VINYL BRANDS VIEW FROM INTERIOR  ALL VINYL BRANDS VIEW FROM INTERIOR
DOUBLE / SINGLE-HUNG 	 ALL VINYL BRANDS VIEW FROM INTERIOR  ALL VINYL BRANDS VIEW FROM INTERIOR
SLIDING DOOR 	CLEAR LABEL APPLIED ON LOWER RIGHT OR LEFT CORNER (RIGHT SIDE PREFERRED) (LEFT SIDE OPTIONAL)  ALL VINYL BRANDS VIEW FROM INTERIOR  ALL VINYL BRANDS VIEW FROM INTERIOR

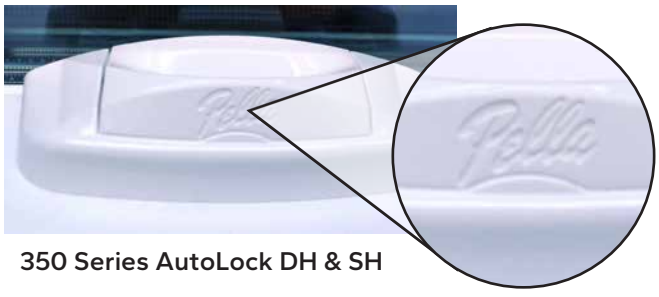
WINDOWS



Vinyl Casement



Vinyl Sliding Window



350 Series AutoLock DH & SH

SLIDING DOOR



Vinyl – Encompass By Pella
Interior Sliding door handle
04/2010 - Current



Pella® 350 Series Interior
Sliding door

VINYL PRODUCT HISTORY

Casement / Awning

2003 – 2018

Back to TOC



Exterior



Interior



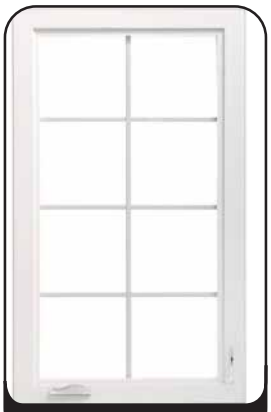
Interior



Interior



Interior



Interior



Interior

January 2003:

- Introduced as ThermaStar by Pella®.

January 2006:

- (TSE) New Factory Applied Jamb Extensions for Casement and Awning offering (East Region).

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

March 2007:

- (TSE) (TSW) Limited opening travel hardware device available for Casement and Awning windows.

January 2008:

- (EE) (EW) Encompass by Pella® - Additional brand name for Vinyl Windows and Doors available from the PDSN.

February 2008:

- (TSE) (TSW) (EE) (EW) 19 new factory combinations added to Casement offering. New Casement radius stand alone shapes also available.

April 2008:

- (EW) (TSW) New glass offerings (West Region): High Performance Low-E^3 and Expanded Obscure Glass patterns (glue chip pattern).

July 2008:

- New flanged screen design, use to replace all screens.

January 2009:

- West Region Only - Rain pattern - Obscure glass pattern now available all series and product types. PMB #13-2009.

June 2009:

- (EE) (EW) New 3-3/8" replace block frame available for CM/AW and complementary fixed products. Installation holes pre-drilled on CM and AW vent units. PMB #72-2009.

KEY:
TSE = ThermaStar by Pella® East Region
TSW = ThermaStar by Pella® West Region
EE = Encompass by Pella® East Region
EW = Encompass by Pella® West Region

August 2010:

- (EE) (EW) Announcing a new Fold-down Handle on our Encompass by Pella® Casement and awning products. With this change, we are also adding optional factory applied egress hardware (side pivot hardware) and stainless steel operating hardware to our east offering. Both of these options are already available to our west region.
- Lock Lever – the Casement will also have a new lock lever design – with a lower profile not to interfere with window treatments.



- Flange Screen includes a flange on 4-sides giving a better fit and overall performance. PMB #53-2010.

Continued on next page.

January 2011:

- (EW) West Region - New 20 Series 3-3/8" OAW replacement frame available with a double wall on the exterior flange (flange width = 2-1/4") for reinforcement, increased stability and for use in stucco pocket replacement applications. Installation holes pre-drilled on vent units.

February 2012:

- Centera by Pella™ brand discontinued.

January 2014:

- **Effective January 12th**, with the launch of the new Pella® 250 Series offering includes 4-9/16" vinyl jamb extensions on all Pella 250 Series products! In conjunction with this new offering we no longer offer the Encompass 4-9/16" (6"OAW) East New Construction Double-Hung (the all vinyl jamb). Below is a summary of the new jamb extension offering for Pella 250 Series and Encompass by Pella products.

Jamb Extension Chart

Jamb Extension	Pella® 250 Series	Encompass by Pella®
4-9/16" vinyl	All Rectangle Windows	NA
4-9/16" (Jamb 6" OAW)	NA	Discontinued (NC DH)
4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows

- In an effort to simplify the Encompass by Pella® Vinyl Windows and Doors product line and ThermaStar by Pella®, we no longer reference the 10/20/25 Series designations. Encompass and ThermaStar now repositioned as Endorsed Vinyl. The Series designation in PQM for Encompass and ThermaStar vinyl windows and doors is being removed and to configure Encompass by Pella® products; select a frame type in the questions and answers. This is consistent with how Pella 350 Series and Pella 250 Series are configured. PMB #09-2014

April 2016:

- West only - locations and width variations choices added to Casement Composites. PMB #12-2016

April 2018:

- (EE) East Region - ThermaStar by Pella® and Encompass by Pella® Casement/Awning discontinued. Replacement parts, including replacement sash available. Full units NOT available.
  PMB #10-2018 and PMB #20-2018

May 2018:

- (EW) West Region - ThermaStar by Pella® and Encompass by Pella® Casement/ Awning discontinued. Replacement parts, including replacement sash available. Full units NOT available. PMB #22-2018

July 2022:

- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience.
  PMB #26-2022

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

VINYL PRODUCT HISTORY

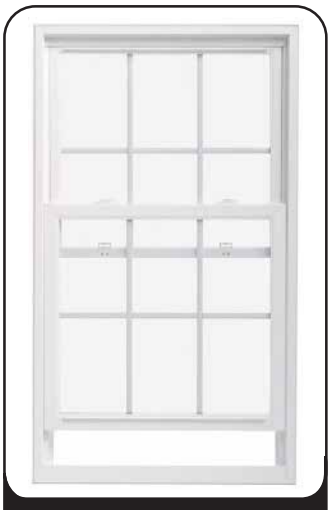
Double-Hung

2003 – Current (Includes Replacement Windows)

Back to TOC



Exterior



Interior



Interior

January 2003:

- Introduced as ThermaStar by Pella® East Only.

October 2003:

- (TSE) 20 and 25 Series DH Improved secondary sash weatherstrip which provides additional .060" (1/16") of weatherstrip coverage on each side of the sash.

September 2005:

- Night latch no longer included on 20 Series EAST Double-Hung product.

October 2005:

- Night latch will once again be included on 20 Series EAST Double-Hung product.

January 2006:

- (TSE) New 25 Series Double-Hung 2-9/16" Factory Applied Jamb Extensions (East Region).

April 2006:

- (TSE) 10 Series product offering includes factory-applied Jamb Extensions.

May 2006:

- (TSE) Nail fin frame only available on 10 Series.

September 2006:

- (TSE) Weatherstrip Enhancement Kit for 10 Series Single-Hung and
- 20/25 Series Double-Hung is available (East Region).

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

May 2007:

- (TSE) Expansion of Double-Hung size range and performance changes related to certification.

April 2007:

- (TSE) Implementing an improved Double-Hung upper vent stop (aka = Night Latch).

October 2007:

- (TSE) 26 new factory combinations available to 25 Series offering (East Region).

December 2007:

- (TSE) Addition of new factory combinations increasing allowable square footage from 40 to 70 square feet.

January 2008:

- (EE) Encompass by Pella® - Windows and Doors available from the PDSN.

February 2008:

- (TSE) 19 new factory combinations added to Double-Hung offering.

April 2008:

- (TSE) Custom sized Bay windows introduced.

January 2009:

- New nail fin only frame type available, adds flexibility in siding materials and aftermarket accessories such as AZEK trim. PMB #11-2009.

May 2009:

- Half (1/2) screen available for Encompass by Pella DH windows.
- The 1/2 screen can be used in the upper sash position if the homeowner chooses to do so; however, an additional piece of weatherstrip would need to be applied to block the space between screen and sash. This weatherstrip is the same that is used on the top of the screen when in the bottom sash position. PMB #54-2009.

June 2009:

- Head Expander and Sill Adapter on 20 Series DH (East Only) are optional rather than standard. PMB #73-2009.

July-September 2010:

- (EE) Snap-in exterior weep covers have been added to all double-hung units.
- The weep holes on the new system have been enlarged to accommodate the new snap-in weep covers. The new snap-in weep covers are retrofitable to prior vintage units with some modification to the existing weep holes. PMB #72-2010.

September 2010:

- (EE) An additional weatherstrip has been added on all double-hung lower sash stiles.
- The additional weatherstrip was also implemented as a running change in early September at the (3) East Region Plants. This third weatherstrip is not visible from either the exterior or interior when the lower sash are in the closed position.

February 2012:

- Centera by Pella™ brand discontinued.

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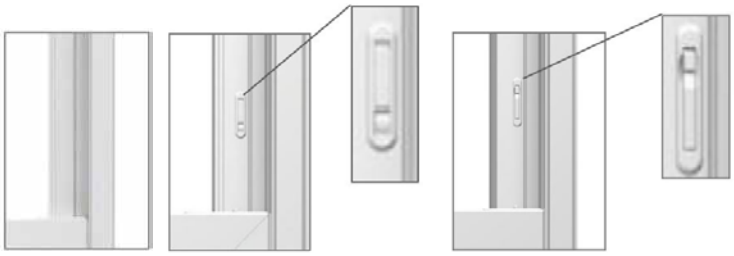
KEY:
TSE = ThermaStar by Pella® East Region
TSW = ThermaStar by Pella® West Region
EE = Encompass by Pella® East Region
EW = Encompass by Pella® West Region

January 2014:

- **Effective January 12th**, with the launch of the new Pella® 250 Series offering includes 4-9/16" vinyl jamb extensions on all Pella 250 Series products! In conjunction with this new offering we no longer offer the Encompass 4-9/16" (6"OAW) East New Construction Double-Hung (the all vinyl jamb). Below is a summary of the new jamb extension offering for Pella 250 Series and Encompass by Pella products.
- In an effort to simplify the Encompass by Pella® Vinyl Windows and Doors product line and ThermaStar by Pella®, we no longer reference the 10/20/25 Series designations. Encompass and ThermaStar now repositioned as Endorsed Vinyl. The Series designation in PQM for Encompass and ThermaStar vinyl windows and doors is being removed and to configure Encompass by Pella® products; select a frame type in the questions and answers. This is consistent with how Pella 350 Series and Pella 250 Series are configured. PMB #09-2014.

Jamb Extension Chart

Jamb Extension	Pella® 250 Series	Encompass by Pella®
4-9/16" vinyl	All Rectangle Windows	NA
4-9/16" (Jamb 6" OAW)	NA	Discontinued (NC DH)
4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows



No Vent Stop New Construction (Formerly 25 series) No Vent Stop

Current Replacement (Formerly 20 series) Vent Stop

NEW! New Construction and Replacement New Vent Stop Design

July 2015:

- Double-Hungs produced with a new vent stop design! Formerly, the new construction frame did not have a vent stop and the replacement frame had a different design. The new design is standard on the new construction and replacement frame. The vent stop is integrated into the top sash of the Encompass Double-Hung; similar to the Pella® 250 Series and Pella® 350 Series vent stop.
- This enhancement commonizes the vent stop for vinyl Double-Hung units and allows for replacement of the standard vent stop with a Window Opening Control Device (WOCD) as an out of unit service part.
- All upper vent replacement sashes, including for new construction DH units, built after July 13th will have the new vent stop design PMB #37-2015.

December 2015:

- WOCD now offered as a **factory installed option** for all Encompass Double-Hungs. This added offering creates alignment across all vinyl brands. The factory installed Window Opening Control Device on Encompass, 250 Series, and 350 Series Double-Hung is ASTM F2090 compliant to meet the code in your area. PMB #50-2015.



Window Opening Control Device

Sash Stop

December 2015 & February 2016:

- Encompass by Pella Double-Hungs (East) converted to an inverted constant force balance, which is the same balance system used on Pella 250 Series® products and the Encompass Single Hung. With the change to the inverted constant force balance, the Encompass Double-Hung has a new sash stop which allows the balance to be serviced from the top of the unit and provides easier access to installation holes on replacement frame types. No change in egress sizes on Double-Hung units due to the sash stop change.
- December 14th: DH out of Gettysburg have constant force balances.
- Replacement sashes retrofit to both block and tackle and constant force balances
- February 15th: DH out of Murray have constant force balances.
- The previous block and tackle balances for Double-Hung products available in PQM. PMB #50-2015.

July 2016:

- Tempered bottom sash only option. PMB #37-2016.

June 2018:

- (EE)(EW) Fossil added as a solid color (extruded) option. PMB #34-2018.

Continued on next page

KEY:
TSE = ThermaStar by Pella® East Region
TSW = ThermaStar by Pella® West Region
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February 2020:

- Introduced as Pella 150 Series in East only. Only available in Block Frame, white, single punch openings; no mulls.
- Differentiated block frame features include: New lock and tilt latch, InView Screen, Balance Pocket Cover, and Perimeter Foam.



Perimeter Foam

(Exclusive to block frame double-hung)



Lock

Lock for Encompass, ThermaStar, and 150 in the East. West will keep current lock.

November 2020, East only:

- Pella 150 Series expanded to full SOS product offering, including expanding the stock offering to include nail fin double-hung.
  Differentiated features of nail fin double-hung: New lock and tilt latch, In-View Screen, Balance Pocket Cover.
- Encompass by Pella, ThermaStar by Pella, and 150 Series have a new cam-action lock. The old cam-action lock will not be vintaged.
- 1" Contour GBG's removed from the offering.

January 2022

- ThermaStar by Pella Double-Hung elimination. Configured and catalog service parts still available, but not complete units.
  NA-PMB #3-2022

July 2022:

- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience.
- Also, the Encompass by Pella Auto-Lock and Bronze Low-E Insulated Glass Option will also be eliminated from complete units. Both will remain available for configured service, and the Auto-Lock will also remain available as a catalog part. Pella 250 Series will also be the direct substitute for complete units with an Auto-Lock or Bronze Low-E.
  PMB #26-2022

January 2023:

- Double-Hung upper sash stop eliminated.
- If replacement DH Upper Sash Stops are needed, order a replacement Balance Pocket Cover Set through configured service frame service items. Suitable replacements will be provided for all earlier vintage stops.
  PMB #04-2023

April 2025:

- Removed 150 Series tilt latch cover. Tilt latch now matches Encompass.
- Sill Adapter is now optional rather than standard on 1-wide block frame units.



April 2025:

- Encompass East Offering Only –
- The DH screen updated from a plunger to a leaf spring with pull tab design to match 250 Series.
- Half screen option for new units eliminated.
- Previous screen design of full and half screen available as service item.
  PMB #17-2025



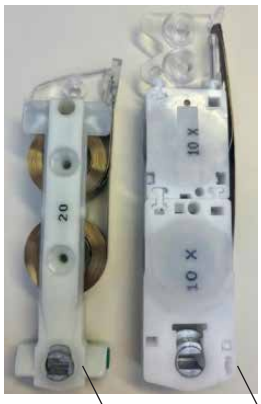
June 2025:

- Encompass East Offering Only-
- Double Hung units ordered with a Nail Fin changed from a 4-3/16" Frame Depth to a 3-1/4" Frame Depth to align with
- the Block Frame with Mull Groove Frame Depth.
- The corresponding Fixed Frame units with Nail Fin also moved to a 3-1/4" Frame Depth.
- Nail Fin with J-Channel no longer offered as a selectable Frame Type option and instead be offered as an aftermarket J-Channel Accessory Item.
  PMB #17-2025

July 2025:

- Transitioned to a new constant force balance in Encompass by Pella® East Double and Single-Hung units. Performance values and product certification not impacted by this conversion.
- Transitioned from an open coil balance to a closed coil balance.
- Moving to the closed coil design will require use of a production balance and a (different) modular design service balance.
- Production balances will be installed in factory-assembled units while modular design service balances will be used for field service applications.
- All Encompass by Pella® East Double and Single-Hung units built after December 2014 will be serviced with the new modular design.
- When servicing a unit with the old design installed, new pivot bars and friction screws designed for the closed coil balance are necessary to install the new design.

PMB #43-2025



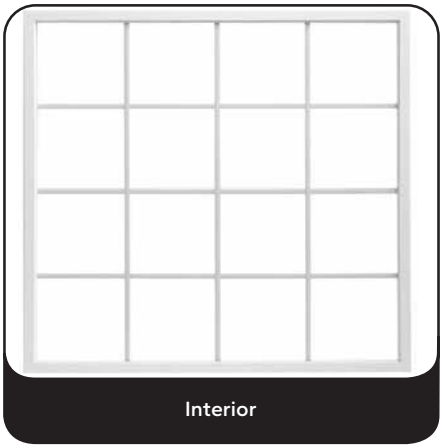


VINYL PRODUCT HISTORY

Fixed Frame

2003 – Current

Back to TOC



Interior



Interior

KEY:
TSE=ThermaStar by Pella® East Region.
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EE = Encompass by Pella® East Region.
EW = Encompass by Pella® West Region.

January 2003:

- Introduced as ThermaStar by Pella®.

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

January 2007:

- (EE) (EW) Encompass by Pella™ - Windows and Doors available from the PDSN.

September 2007:

- Inclusion of screw covers with all 20 Series Products (WEST Region).

January 2008:

- (EE) (EW) Encompass by Pella® - Windows and Doors available from the PDSN.

April 2008:

- (TSW) (EW) New glass offerings (West Region): High Performance Low-E^3 and Expanded Obscure Glass patterns (glue chip pattern).

January 2009:

- West Region Only - Rain pattern - Obscure glass pattern now available all series and product types. PMB #13-2009

January 2011:

- (EW) West Region - New 20 Series 3-3/8" OAW replacement frame available with a double wall on the exterior flange (flange width = 2-1/4") for reinforcement, increased stability and for use in stucco pocket replacement applications. Installation holes pre-drilled on vent units.
- Fixed Frame Rectangles.

February 2012:

- Centera by Pella™ brand discontinued.

January 2014:

- **Effective January 12th**, with the launch of the new Pella® 250 Series offering includes 4-9/16" vinyl jamb extensions on all Pella 250 Series products! In conjunction with this new offering we no longer offer the Encompass 4-9/16" (6"OAW) East New Construction Double-Hung (the all vinyl jamb). Below is a summary of the new jamb extension offering for Pella 250 Series and Encompass by Pella products.

Jamb Extension Chart		
Jamb Extension	**Pella® 250 Series**	**Encompass by Pella®**
4-9/16" vinyl	All Rectangle Windows	NA
4-9/16" (Jamb 6" OAW)	NA	Discontinued (NC DH)
4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows

- In an effort to simplify the Encompass by Pella® Vinyl Windows and Doors product line and ThermaStar by Pella®, we no longer reference the 10/20/25 Series designations. Encompass and ThermaStar now repositioned as Endorsed Vinyl. The Series designation in PQM for Encompass and ThermaStar vinyl windows and doors is being removed and to configure Encompass by Pella® products; select a frame type in the questions and answers. This is consistent with how Pella 350 Series and Pella 250 Series are configured. PMB #09-2014

February 2015:

- Added exterior accessory groove on block frame and nail fin Fixed units.



Pre-2015 Units - No Exterior Accessory Groove



2015 - Current Units with Exterior Accessory Groove

- 1/2 Flanged Frame (Florida Flange) transition to 5/8" flange. On Fixed units the single wall flange will remain integrated in the frame.
- Fixed windows use the same profile as the Single-Hung Head. When a fixed unit is mulled above a SH unit the upper glass of the SH and the Fixed unit glass will align in the same plane. PMB #02-2015.

April-May 2018:

- (EE) East Region, (EW) West Region - Eliminated all 3-3/8" frame profiles. PMB #15-2018, PMB #6-2018, PMB #20-2018, PMB #22-2018

June 2018:

- (EE)(EW) Fossil added as a solid color (extruded) option. PMB #34-2018.

November 2020, East only:

- Eliminated fixed frame units from the ThermaStar offering.
- 1" Contour GBG removed from Encompass, ThermaStar, and 150 Series product offering.

July 2022, West only:

- Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. PMB #26-2022

July 2022:

- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience. PMB #26-2022

April 2025:

- Eliminated 4-3/16" base frame depth nail fin and nail fin with j-channel.

VINYL PRODUCT HISTORY

Garden Window (West Only)

2003 – 2016

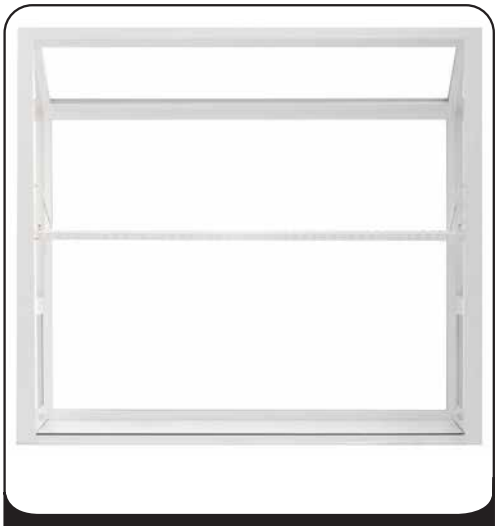
Back to TOC



Interior



Interior



Interior

Garden window
(Available in West Region Only)

January 2003:

- Introduced as ThermaStar by Pella®.

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

January 2008:

- (EW) Encompass by Pella® - Additional brand name for Vinyl Windows and Doors available from the PDSN.

April 2008:

- (TSW) Introducing Custom Sized Bay Windows.
- New glass offerings (West Region): High Performance Low-E^3 and Expanded Obscure Glass patterns (glue chip pattern).

January 2009:

- West Region Only - Rain pattern - Obscure glass pattern available on all series and product types. PMB #13-2009.

February 2012:

- Centera by Pella™ brand discontinued.

January 2014:

- **Effective January 12th**, with the launch of the new Pella® 250 Series offering includes 4-9/16" vinyl jamb extensions on all Pella 250 Series products! In conjunction with this new offering we no longer offer the Encompass 4-9/16" (6"OAW) East New Construction Double-Hung (the all vinyl jamb). Below is a summary of the new jamb extension offering for Pella 250 Series and Encompass by Pella products.

Jamb Extension Chart		
Jamb Extension	**Pella® 250 Series**	**Encompass by Pella®**
4-9/16" vinyl	All Rectangle Windows	NA
4-9/16" (Jamb 6" OAW)	NA	Discontinued (NC DH)
4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows

- In an effort to simplify the Encompass by Pella® Vinyl Windows and Doors product line and ThermaStar by Pella®, we no longer reference the 10/20/25 Series designations. Encompass and ThermaStar now repositioned as Endorsed Vinyl. The Series designation in PQM for Encompass and ThermaStar vinyl windows and doors is being removed and to configure Encompass by Pella® products; select a frame type in the questions and answers. This is consistent with how Pella 350 Series and Pella 250 Series are configured. PMB #09-2014.

September 2016:

- Garden Window eliminated, service parts still available. PMB #27-2016.

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EW = Encompass by Pella® West Region

VINYL PRODUCT HISTORY

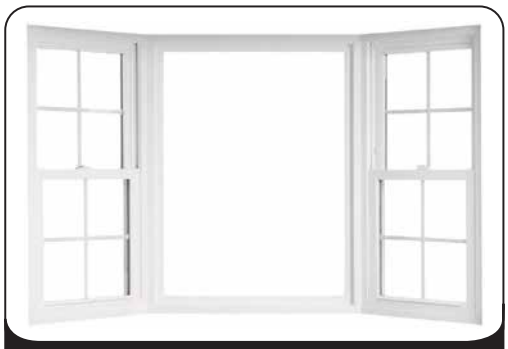
Bay / Bow

2003 – Current

Back to TOC



Casement Bay, Interior



Double-Hung Bay, Interior



Casement Bay, Interior

January 2003:

- Introduced as ThermaStar by Pella®.

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

January 2008:

- (EE) (EW) Encompass by Pella® - Additional brand name for Vinyl Windows and Doors available from the PDSN.

April 2008:

- (TSE) (TSW) Introducing Custom Sized Bay Windows.
- New glass offerings (West Region): High Performance Low-E^3 and Expanded Obscure Glass patterns (glue chip pattern).

January 2009:

- West Region Only - Rain pattern - Obscure glass pattern now available all series and product types. PMB #13-2009

July 2009:

- (EE) (EW) New replacement bay and bow added to offering.
  Bay: New frame type and 3 new jamb depths - 4-9/16", 5-9/16", 6-9/16".
  Bow: New frame type, Custom size bows, 3 and 5 wide bows added, optional head/seat board, Vent flanker units only.
  PMB #74-2009

February 2012:

- Centera by Pella™ brand discontinued.

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January 2014:

- **Effective January 12th**, with the launch of the new Pella® 250 Series offering includes 4-9/16" vinyl jamb extensions on all Pella 250 Series products! In conjunction with this new offering we no longer offer the Encompass 4-9/16" (6"OAW) East New Construction Double-Hung (the all vinyl jamb). Below is a summary of the new jamb extension offering for Pella 250 Series and Encompass by Pella products.

Jamb Extension Chart

Jamb Extension	Pella® 250 Series	Encompass by Pella®
4-9/16" vinyl	All Rectangle Windows	NA
4-9/16" (Jamb 6" OAW)	NA	Discontinued (NC DH)
4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows

- In an effort to simplify the Encompass by Pella® Vinyl Windows and Doors product line and ThermaStar by Pella®, we no longer reference the 10/20/25 Series designations. Encompass and ThermaStar now repositioned as Endorsed Vinyl. The Series designation in PQM for Encompass and ThermaStar vinyl windows and doors is being removed and to configure Encompass by Pella® products; select a frame type in the questions and answers. This is consistent with how Pella 350 Series and Pella 250 Series are configured. PMB #09-2014

April-May 2018:

- April (EE) East Region, May (EW) West Region.
- Single-Hung Bay eliminated.
- Encompass Casement Bays eliminated due to elimination of Encompass Awnings and Casements. PMB #10-2018, PMB #15-2018, PMB #20-2018 and PMB #22-2018

June 2018:

- (EE)(EW) Fossil added as a solid color (extruded) option.
  PMB #34-2018

November 2020: East and West regions

- Bay/Bow removed from Encompass and ThermaStar offering. (Not offering in 150 Series)

July 2022:

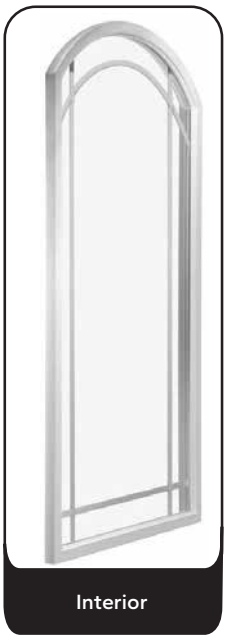
- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience. PMB #26-2022

VINYL PRODUCT HISTORY

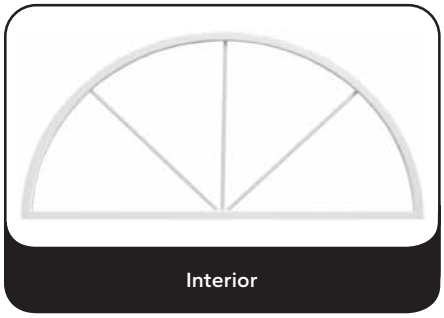
Radius Shapes

2003 – Current

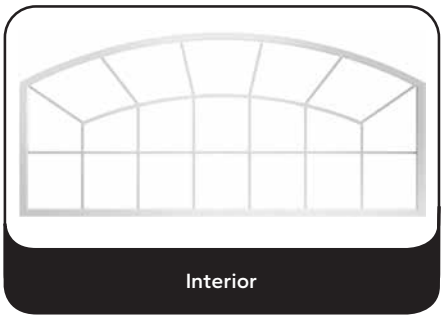
Back to TOC



Interior



Interior



Interior



Exterior

January 2003:

- Introduced as ThermaStar by Pella.

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

June 2007:

- (TSE) (TSW) Significant enhancements to Grilles-Between-the-Glass offerings in Radius Windows.

January 2008:

- (EE) (EW) Encompass by Pella® - Windows and Doors available from the PDSN.

April 2008:

- (TSW) (EW) New glass offerings (West Region): High Performance Low-E^3 and Expanded Obscure Glass patterns (glue chip pattern).

January 2009:

- Partial Arch Head Shape now available in East Region (already available in West Region). PMB #12-2009
- West Region Only - Rain pattern - Obscure glass pattern now available all series and product types. PMB #13-2009

February 2012:

- Centera by Pella™ brand discontinued.

January 2014:

- **Effective January 12th**, with the launch of the new Pella® 250 Series offering includes 4-9/16" vinyl jamb extensions on all Pella 250 Series products! In conjunction with this new offering we no longer offer the Encompass 4-9/16" (6"OAW) East New Construction Double-Hung (the all vinyl jamb). Below is a summary of the new jamb extension offering for Pella 250 Series and Encompass by Pella products.

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TSE = ThermaStar by Pella® East Region
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Jamb Extension Chart

Jamb Extension	Pella® 250 Series	Encompass by Pella®
4-9/16" vinyl	All Rectangle Windows	NA
4-9/16" (Jamb 6" OAW)	NA	Discontinued (NC DH)
4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows

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April-May 2018:

- (EE) East Region, (EW) West Region - Eliminated all 3-3/8" frame profiles. PMB #15-2018, PMB #6-2018, PMB #20-2018, PMB #22-2018

June 2018:

- (EE)(EW) Fossil added as a solid color (extruded) option. PMB #34-2018.

November 2020, East only:

- Radius shapes removed from the ThermaStar offering.
- 1" Contour GBG removed from Encompass, ThermaStar, and 150 Series product offering.

July 2022, West only:

- Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. PMB #26-2022

July 2022:

- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience. PMB #26-2022

VINYL PRODUCT HISTORY

Single-Hung

2003 – Current

Back to TOC



Interior



Interior



Interior

January 2003:

- Introduced as ThermaStar by Pella®.

September 2005:

- (TSW) New AutoLock Hardware on 20 and 25 Series (West Region).

April 2006:

- (TSE) 10 Series product offering now has factory-applied Jamb Extensions.

May 2006:

- (TSE) Nail fin frame only available on 10 Series.

September 2006:

- (TSE) Weatherstrip Enhancement Kit for 10 Series Single-Hung and 20/25 Series Double-Hung is now available (East Region).

October 2006:

- (TSE) (TSW) Introduction of a Drywall PassThru Single Hung.

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

April 2007:

- (TSE) New 10 Series Mull Kit (East Region).

September 2007:

- (TSW) Inclusion of screw covers with all 20 Series products (West Region).

October 2007:

- (TSE) 26 new factory combinations available to 25 Series offering (East Region).

December 2007:

- (TSE) (TSW) Addition of new factory combinations increasing allowable square footage from 40 to 70 square feet.

January 2008:

- (EE) (EW) Encompass by Pella® - Windows and Doors available from the PDSN.

April 2008:

- (TSW) (EW) New glass offerings (West Region): High Performance Low-E^3 and Expanded Obscure Glass patterns (glue chip pattern).

May 2008:

- (TSE) (EE) Addition of a 20 Series Replacement Single-Hung product offering.

December 2010:

- (TSW) (EW) New Autolock Design for 20 and 25 Series Single-Hung and Sliding Windows (Standard). Also available as an option on 10 and 20 Series SH and SW. Not interchangeable with previous autolock. PMB #1-2011.

January 2011:

- (EW) West Region - New 20 Series 3-3/8" OAW replacement frame available with a double wall on the exterior flange (flange width = 2-1/4") for reinforcement, increased stability and for use in stucco pocket replacement applications. Installation holes pre-drilled on vent units.

February 2012:

- Centera by Pella™ brand discontinued.

August 2013:

- In Southern Markets - Ability to select 30" lower sash height for Encompass by Pella Single-Hung units is available. The 24" lower sash height for Encompass by Pella is already available. PMB #27-2013.

September 2013

- Launch of a Curve Top Single-Hung in the Encompass by Pella product line. This option will be available on the current 10 and 20 Series products, and will include the following shapes:
  - Springline
  - Arch Head
  - Partial Arch Head
  - Partial Springline

  PMB #34-2013.

Continued on next page

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January 2014:

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Jamb Extension Chart		
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4-9/16" vinyl	All Rectangle Windows	NA
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4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows

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February 2014:

- Now can select a 24" or a 30" lower sash height for Encompass by Pella Florida Flange Single-Hung units. PMB #13-2014

December 2014:

December 2014 - February 2015 (running change)

- Now using the inverted constant force balance similar to 250 Series. (Replacement sashes will be sent with two sets of pivot bars, one for Constant Force balances and one for Block & Tackle balances.)
- Added exterior accessory groove on block frame and nail fin SH units.


Pre-2015 Units - No Exterior Accessory Groove


2015 - Current Units with Exterior Accessory Groove

- 1/2 Flanged Frame (Florida Flange) transition to 5/8" flange. On SH units the single wall flange will remain integrated in the frame. PMB # 02-2015.

July 2015:

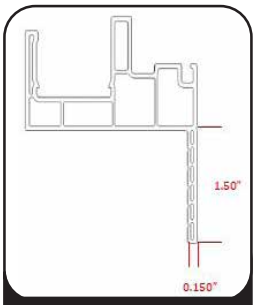
- Encompass by Pella® Single-Hung now has Window Opening Control Device (WOCD) capability with an in Jamb Adapter. The Jamb Adapter and WOCD are sold together as an out of unit service part for field installation. This Jamb Adapter is also available with a vent stop. PMB #37-2015


WOCD

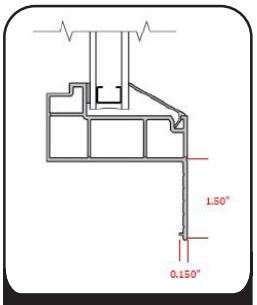

Vent Stop

August 2016:

WEST ONLY - New Flush Flange profile; design enhancement to thicken the flange. PMB #02-2015



August 15, 2016 - Current Flange Profile



Pre-August 15, 2016 Flange Profile

April-May 2018:

- (EE) East Region, (EW) West Region - Eliminated all 3-3/8" frame profiles. PMB #15-2018, PMB #6-2018, PMB #20-2018, PMB#22-2018

June 2018:

- (EE)(EW) Fossil added as a solid color (extruded) option. PMB #34-2018

November 2020, East only:

- ThermaStar by Pella single-hung window offering reduced to white only, nail fin single-hung. Single punch openings only, no mulls.
- 1" Contour GBG removed from Encompass and ThermaStar offering.
- Upgraded lock introduced to Encompass, ThermaStar, and 150 Series.
- No vintage will be offered on the old lock.

November 2020, East only:

- Dry wall pass though available on Encompass by Pella single-hung two-wide composites meeting the following criteria. The pass through window will always be on the left side, viewed from the exterior, which matches 250 Series today.
- Valid if frame width ≥ 29.5 and ≤ 35.5" AND frame height ≥ 59.5" and ≤ 71.5"

February 2021:

- Encompass by Pella and ThermaStar by Pella brands launched new cam-action lock in the West. The old cam-action lock will not be vintaged. National Accounts- PMB #06-2021 and PMB #15-2021


Lock

January 2022

- ThermaStar by Pella single-hung elimination. Configured and catalog service parts still available, but not complete units. NA-PMB #3-2022

Continued on next page

July 2022:

- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience.
- Also, the Encompass by Pella Auto-Lock and Bronze Low-E Insulated Glass Option will also be eliminated from complete units. Both will remain available for configured service, and the Auto-Lock will also remain available as a catalog part. Pella 250 Series will also be the direct substitute for complete units with an Auto-Lock or Bronze Low-E. PMB #26-2022

July 2024:

- The Pella Encompass East Single Hung sash stop changed in length from 1.375 inches to 1.5 inches. This change reduced the clear opening height on all Encompass East Single Hung units with equal split sashes by 0.125 inch. PMB #41-2024

July 2025:

- Transitioned to a new constant force balance in Encompass by Pella® East Double and Single-Hung units. Performance values and product certification not impacted by this conversion.
- Transitioned from an open coil balance to a closed coil balance.
- Moving to the closed coil design will require use of a production balance and a (different) modular design service balance.
- Production balances will be installed in factory-assembled units while modular design service balances will be used for field service applications.
- All Encompass by Pella® East Double and Single-Hung units built after December 2014 will be serviced with the new modular design.
- When servicing a unit with the old design installed, new pivot bars and friction screws designed for the closed coil balance are necessary to install the new design.

PMB #43-2025



Old Balance — New Balance



New modular service balance — New factory-installed balance

VINYL PRODUCT HISTORY

Curve Top Single-Hung

2013 – Current

Back to TOC



Exterior



Interior

October 2013:

- Introduced into Southern US markets a Curve Top Single-Hung in Encompass By Pella product line. Available option in 10 and 20 Series products in Springline, Arch Head, Partial Springline and Partial Arch Head shapes. PMB #34-2013

March & June 2015:

- Curve Top SH offering Expanded to select areas beyond the Southern US Market. Florida Flange not available.
  PMB #20-2015 and PMB #33-2015

April-May 2018:

- (EE) East Region, (EW) West Region - Eliminated all 3-3/8" frame profiles.
  PMB #15-2018, PMB #6-2018, PMB #20-2018, PMB #22-2018

June 2018:

- (EE)(EW) Fossil added as a solid color (extruded) option.
  PMB #34-2018

November 2020, East only:

- ThermaStar by Pella curve top single-hung window offering eliminated.
- 1" Contour GBG removed from Encompass and ThermaStar offering.
- Upgraded lock introduced to Encompass, ThermaStar, and 150 Series. No vintage will be offered on the old lock.



Tilt Latch



Lock

Lock for Encompass, ThermaStar, and 150 in the East. West will keep current lock.

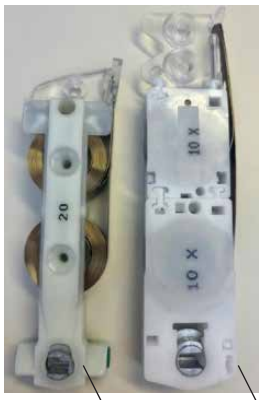
July 2022:

- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience.
- Also, the Encompass by Pella Auto-Lock and Bronze Low-E Insulated Glass Option will also be eliminated from complete units. Both will remain available for configured service, and the Auto-Lock will also remain available as a catalog part. Pella 250 Series will also be the direct substitute for complete units with an Auto-Lock or Bronze Low-E.
  PMB #26-2022

July 2025:

- Transitioned to a new constant force balance in Encompass by Pella® East Double and Single-Hung units. Performance values and product certification not impacted by this conversion.
- Transitioned from an open coil balance to a closed coil balance.
- Moving to the closed coil design will require use of a production balance and a (different) modular design service balance.
- Production balances will be installed in factory-assembled units while modular design service balances will be used for field service applications.
- All Encompass by Pella® East Double and Single-Hung units built after December 2014 will be serviced with the new modular design.
- When servicing a unit with the old design installed, new pivot bars and friction screws designed for the closed coil balance are necessary to install the new design.

PMB #43-2025



Old Balance — New Balance



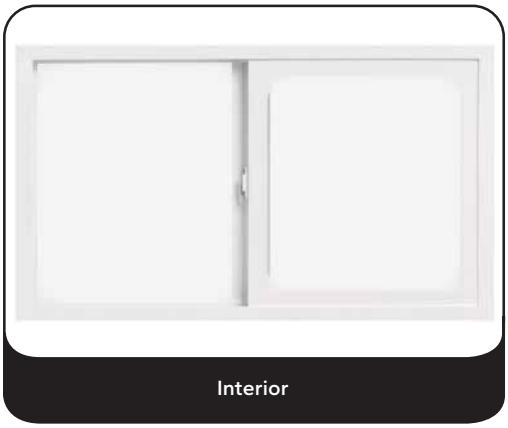
New modular service balance — New factory-installed balance

VINYL PRODUCT HISTORY

Sliding Window

2003 – Current

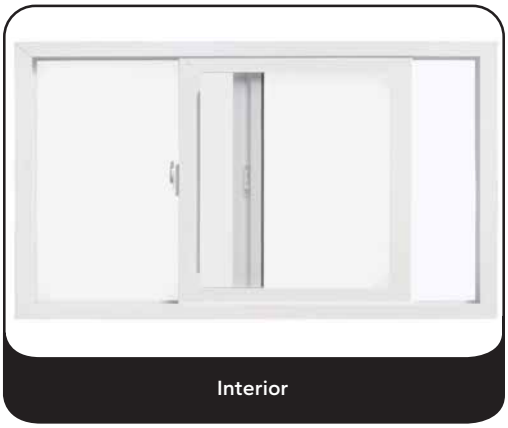
Back to TOC



Interior



Interior



Interior

January 2003:

- Introduced as ThermaStar by Pella® (Includes Basement Sliding Window).

September 2005:

- (TSW) New AutoLock Hardware on 20 and 25 Series (West Region).

February 2006:

(TS) Implemented the following design changes to 10 and 20 Series Sliding Windows:

1) Sill extrusion redesigned to eliminate the removable track.
2) Jamb extrusion redesigned to look consistent with the sill extrusion.
3) Full perimeter interior accessory groove.

April 2006:

- (TSE) 10 Series product offering now has factory-applied Jamb Extensions.

May 2006:

- (TSE) Nail fin frame only available on 10 Series.

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

April 2007:

- (TSE) New 10 Series Mull Kit (East Region).

September 2007:

- (TSW) (EW) Inclusion of screw covers with all 20 Series products (West Region).

October 2007:

- (TSE) 26 new factory combinations available to 25 Series offering (East Region).

December 2007:

- (TSE) (TSW) Addition of new factory combinations increasing allowable square footage from 40 to 70 square feet.

January 2008:

- (EE) (EW) Encompass by Pella® - Windows and Doors available from the PDSN.

KEY:
TSE = ThermaStar by Pella® East Region
TSW = ThermaStar by Pella® West Region
EE = Encompass by Pella® East Region
EW = Encompass by Pella® West Region

February 2008:

- (TSE) (TSW) (EE) (EW) 19 new factory combinations added to offering.

April 2008:

- (TSW) (EW) **New glass offerings (West Region):** High Performance Low-E^3 and Expanded Obscure Glass patterns (glue chip pattern).

January 2009:

- West Region Only - Rain pattern - Obscure glass pattern now available all series and product types. PMB #13-2009.

December 2010:

- (TSW) (EW) New Autolock Design for 20 and 25 Series Single-Hung and Sliding Windows (Standard). Also available as an option on 10 and 20 Series SH and SW. Not interchangeable with previous autolock. PMB #1-2011.

January 2011:

- (EW) West Region - New 20 Series 3-3/8" OAW replacement frame available with a double wall on the exterior flange (flange width = 2-1/4") for reinforcement, increased stability and for use in stucco pocket replacement applications. Installation holes pre-drilled on vent units.

February 2012:

- Centera by Pella™ brand discontinued.

January 2014:

- **Effective January 12th**, with the launch of the new Pella® 250 Series offering includes 4-9/16" vinyl jamb extensions on all Pella 250 Series products! In conjunction with this new offering we no longer offer the Encompass 4-9/16" (6"OAW) East New Construction Double-Hung (the all vinyl jamb). Below is a summary of the new jamb extension offering for Pella 250 Series and Encompass by Pella products.

Jamb Extension Chart		
Jamb Extension	**Pella® 250 Series**	**Encompass by Pella®**
4-9/16" vinyl	All Rectangle Windows	NA
4-9/16" (Jamb 6" OAW)	NA	Discontinued (NC DH)
4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows

- In an effort to simplify the Encompass by Pella® Vinyl Windows and Doors product line and ThermaStar by Pella®, we no longer reference the 10/20/25 Series designations. Encompass and ThermaStar now repositioned as Endorsed Vinyl. The Series designation in PQM for Encompass and ThermaStar vinyl windows and doors is being removed and to configure Encompass by Pella® products; select a frame type in the questions and answers. This is consistent with how Pella 350 Series and Pella 250 Series are configured. PMB #09-2014.

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December 2014:

- (December 2014 - January 2015 running change) Added exterior accessory groove on block frame and nail fin SW units.



Pre-2015 Units - No Exterior Accessory Groove



2015 - Current Units with Exterior Accessory Groove

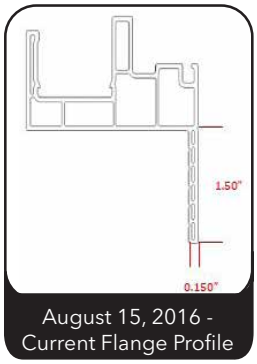
- 1/2 Flanged Frame (Florida Flange) transition to 5/8" flange. On SW units the flange will be a single wall snap-in flange. PMB #02-2015.

April 2016:

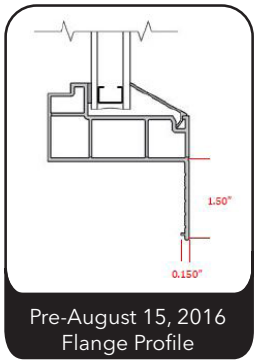
WEST ONLY - For XO/OX added 1/4 vent, 24" vent and customer split options. For XOX added 1/3 vent and custom split option. PMB #13-2016.

August 2016:

WEST ONLY - New Flush Flange profile; design enhancement to thicken the flange. PMB #41-2016



August 15, 2016 - Current Flange Profile



Pre-August 15, 2016 Flange Profile

April-May 2018:

- (EE) East Region, (EW) West Region - Eliminated all 3-3/8" frame profiles. PMB #15-2018, PMB #6-2018, PMB #20-2018, PMB #22-2018

June 2018:

- (EE)(EW) Fossil added as a solid color (extruded) option. PMB #34-2018

November 2020, East only:

- ThermaStar by Pella sliding window offering is eliminated.
- 1" Contour GBG removed from Encompass and ThermaStar offering.
- Upgraded lock introduced to Encompass, ThermaStar, and 150 Series. No vintage will be offered on the old lock.



Lock

Lock for Encompass, ThermaStar, and 150 in the East. West will keep current lock.

February 2021:

- Encompass by Pella and ThermaStar by Pella brands launched new cam-action lock in the West. The old cam-action lock will not be vintaged. National Accounts-PMB #06-2021 and PMB #15-2021

July 2022:

- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience.
- Also, the Encompass by Pella Auto-Lock and Bronze Low-E Insulated Glass Option will also be eliminated from complete units. Both will remain available for configured service, and the Auto-Lock will also remain available as a catalog part. Pella 250 Series will also be the direct substitute for complete units with an Auto-Lock or Bronze Low-E. PMB #26-2022

VINYL PRODUCT HISTORY

Sliding Doors

2003 – Current

Back to TOC



Interior



Interior



Interior

January 2003:

- Introduced as ThermaStar by Pella®.

February 2006:

- 30 Series patio door repositioned as 10 Series patio door. No actual product change.

July 2006:

- (TS) Stainless steel rollers, (including attachment and screws) for Patio Doors as a service part is available.

December 2006:

- Centera by Pella™ - Additional brand name for Vinyl Windows and Patio Doors available through Pro Dealers.

April 2007:

- (TSE) Addition of 25 Series Patio Door featuring a Heavy Duty Screen. Expanded Hardware finishes (added Satin Nickel and Oil Rubbed Bronze to current Bright Brass offering) - available for 10 and 25 Series Patio Door. (East Region).
- White Blinds-Between-the-Glass (BBG) available only through Lowe's. (East Region).

December 2007:

- (TSW) Addition of 25 Series patio door featuring a Heavy Duty Screen. Expanded Hardware finishes (added Satin Nickel and Oil Rubbed Bronze to current Bright Brass offering) - available for 10 and 25 Series Patio Door. (West Region).
- White Blinds-Between-the-Glass (BBG) available only through Lowe's. (West Region).

January 2008:

- (EE) (EW) Encompass by Pella® - Windows and Doors available from the PDSN.

February 2008:

- Encompass by Pella (For PDSN); White Blinds-Between-the-Glass (BBG) and heavy duty screen along with expanded hardware finishes.

April 2008:

- (TSW) (EW) New glass offerings (West Region): High Performance Low-E^3 and Expanded Obscure Glass patterns (glue chip pattern).

January 2009:

- West Region Only - Rain pattern - Obscure glass pattern available all series and product types. PMB #13-2009.

April 2010:

- New Pella branded color matched hardware design for Encompass by Pella, ThermaStar by Pella & Centera by Pella patio sliding doors. Interior and Exterior handle plus key cylinder changed. Previous style hardware to be available for 2 years as service part.

July 2010:

- Encompass by Pella and ThermaStar by Pella 10 Series Beveled Frame Patio Door introduced. PMB #49-2010.

KEY:
TSE = ThermaStar by Pella® East Region
TSW = ThermaStar by Pella® West Region
EE = Encompass by Pella® East Region
EW = Encompass by Pella® West Region

Features and options:

- 4-1/2" frame depth (3-1/8" wall depth).
- Nail fin only with interior/exterior accessory grooves.

2 standard frame size options only:

- East = 58.75" x 79.5" or 70.75" x 79.5"
- West = 59.5" x 79.5" or 71.5" x 79.5".
- Choice of OX or XO (can be field reversed).
- PG 30 (DP 30).

Glazing options:

- Advanced Low-E,
- Advanced Low-E with Argon,
- High Altitude for both options above (West Only).
- White frame / White hardware only
- Screen separate – can order standard or premium as an accessory option.

January 2011:

- (EW) West Region - New 20 Series 3-3/8" OAW replacement frame available with a double wall on the exterior flange (flange width = 2-1/4") for reinforcement, increased stability and for use in stucco pocket replacement applications. Installation holes pre-drilled on vent units.

March 2012:

- (EE)(EW) 10/20/25 Series Nail fin doors - Existing steel reinforcements modified and screen frame pocket weeps added out the face of the frame. (Does not apply to 10 Series Beveled Frame.) PMB #18-2012

Continued on next page

April 2012:
- Encompass by Pella and ThermaStar by Pella 20 Series Flush Flange (West only) and 25 Series Nail Fin BBG sliding door products available in a new 5' width as well as a 6' width High Performance option (East only).
- 25 Series Sliding door offering now a BBG only product with only valid glazing option as "clear".
- Premium screen now available with 10 Series sliding doors. PMB#29-2012

May 2012:
- Encompass by Pella and ThermaStar by Pella 10 Series Beveled frame door eliminated. PMB #29-2012

February 2012:
- Centera by Pella™ brand discontinued.

January 2014:
- **Effective January 12th**, with the launch of the new Pella® 250 Series offering includes 4-9/16" vinyl jamb extensions on all Pella 250 Series products! In conjunction with this new offering we no longer offer the Encompass 4-9/16" (6"OAW) East New Construction Double-Hung (the all vinyl jamb). Below is a summary of the new jamb extension offering for Pella 250 Series and Encompass by Pella products.

Jamb Extension Chart		
Jamb Extension	**Pella® 250 Series**	**Encompass by Pella®**
4-9/16" vinyl	All Rectangle Windows	NA
4-9/16" (Jamb 6" OAW)	NA	Discontinued (NC DH)
4-9/16"primed Wood	All Windows	All Windows
6-9/16"primed Wood	All Windows	All Windows

- In an effort to simplify the Encompass by Pella® Vinyl Windows and Doors product line and ThermaStar by Pella®, we no longer reference the 10/20/25 Series designations. Encompass and ThermaStar now repositioned as Endorsed Vinyl. The Series designation in PQM for Encompass and ThermaStar vinyl windows and doors is being removed and to configure Encompass by Pella® products; select a frame type in the questions and answers. This is consistent with how Pella 350 Series and Pella 250 Series are configured. PMB #09-2014.

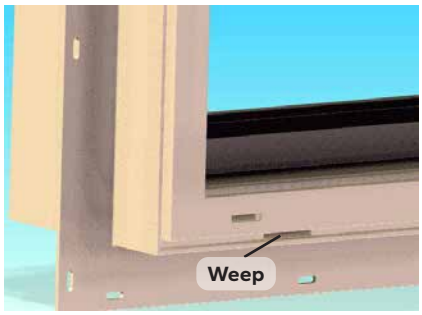
February 2016:
- 8" Tall Sliding Patio Door introduced (East Region Only). Doors with heights > 82" not available with GBG or in high performance. PMB #6-2016

June 2018:
- (EE)(EW) Fossil added as a solid color (extruded) option. PMB #34-2018

February 2020:
- Introduced Pella 150 Series in East only. At time of store roll-out, ThermaStar by Pella patio door in East will be eliminated. Store roll-outs will occur by region and will extend into 2021. No functional design change between ThermaStar by Pella and Pella 150 Series. New packaging was created and BBG coating switched from Clear to Low-E at time of launch. All ThermaStar Clear BBG is serviceable through Pella 150 Series Low-E BBG.

April 2020
- All East Encompass BBG doors now feature a Low-E glass style, and Clear is no longer available. Clear BBG replacement Vent Panels and Fixed Interlocker Panels also no longer available, and all service will be fulfilled using Low-E BBG. PMB #18-2020

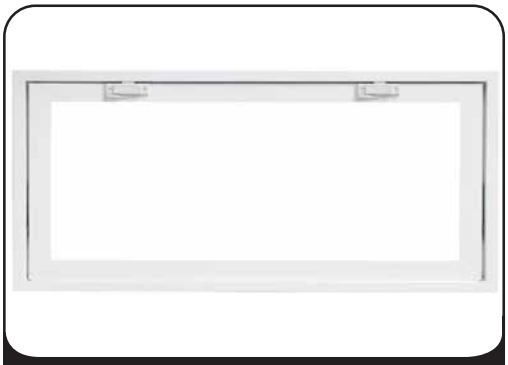
November 2020, East only:
- ThermaStar by Pella Sliding Patio Door removed from the offering.



June 2022:
- Remaining Beveled Patio Door Catalog parts removed from the offering.

July 2022, West only:
- Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. PMB #26-2022

July 2022:
- (WEST ONLY) Complete units with Almond and Fossil Block Frame and Flush Flange frame types will be eliminated from all product types within the Encompass by Pella offering. White will remain available for complete units for both frame types, and configured service will remain available on Almond and Fossil. Pella 250 Series is the direct substitute for these units and provides a full offering for the replacement audience. PMB #26-2022



Interior



Interior



Interior

January 2003:

- Introduced. The Vinyl Basement Hopper window opens to a 50 degree angle. The hopper window is hinged at the bottom and opens to the interior, (roomside).

January 2005:

- Basement hopper windows now feature 2 locks instead of one. When a sash with one lock is replaced with a sash with two, the second lock will also fit into the groove that runs across the frame, so there is no keeper or strike needed to be added or relocated.

May 2015:

- Encompass by Pella® Basement Hopper discontinued.
- Service parts still available. PMB #27-2015.

15 SERIES VINYL PRODUCT HISTORY

Double-Hung

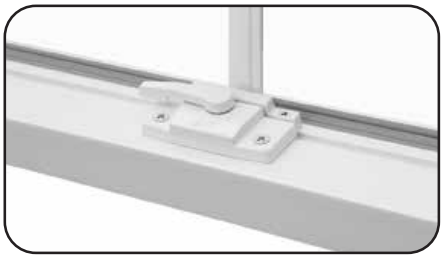
2011 – 2015

Back to TOC



Interior







August 2011:

- (TSE) Introduced, sold through Lowe's only.
- Available in white only.
- Coil balances. PMB #48-2011.

April 2015:

- No Longer Available as of April 19, 2015.
- Service parts still available. PMB #26-2015.

December 2025:

- 15 Series double-hung configured service parts no longer available. Items no longer available include the following:
- Replacement Sash
- Glazing Bead
- Replacement IG
- Replacement Screens

PMB #05-2026

350 SERIES VINYL PRODUCT HISTORY

Awning

2011 – April 2021

Back to TOC



Interior



Exterior



Interior



Interior

August 2011:

- Introduced. PMB #26-2011, PMB #50-2011.

Product Specifications

- Pella® Branded Premium Vinyl Platform.
- Complete Nationwide Product Line.
- Most popular glazing options with a few extra benefits, including higher STC ratings and triple-pane IG for exceptional energy efficiency.
- GBG and SDL without spacer grille options in multiple patterns.
- Standard and Performance Upgrade options on most product types
- White, Almond and Brown Exterior / White Interior Frame Color Options.

December 2012:

- Launch of HurricaneShield® impact-resistant glazing and combination mulls.
- 1" Dual IG with Low-E options and tints.
- All frame types excluding 3-1/4" pocket replacement block frame.
- Awnings automatically upgrade to stainless steel hardware.
- Factory-assembled combinations with 1" mulls (no integral composite mulls). PMB #01-2013.

December 2012:

- Non-Impact laminated glazing added with options of annealed or tempered laminated dual IG. PMB #01-2013.

June 2017:

- Units will receive a black rainstrip, regardless of unit color. Replacement sashes will also receive the black rainstrip. PMB #44-2017.

July 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #47-2017.

August 2020:

- With the launch of new Pella Hurricane Shield Series and Pella Defender Series (PMB #24-2020) Pella 350 Series Impact certifications removed and 350 Impact offering eliminated. PMB #27-2020.

April 2021:

- Pella® 350 Series Windows and Doors eliminated. Complete units eliminated April 2021, service will continue to be offered. Sales tools, corner sections, and POP Kit components eliminated with April elimination. NA-PMB #12-2021, PMB #22-2021 & PMB#40-2021

350 SERIES VINYL PRODUCT HISTORY

Casement

2011 – April 2021

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Interior



Interior



Exterior

August 2011:

- Introduced.

Product Specifications

- Pella® Branded Premium Vinyl Platform.
- Complete Nationwide Product Line.
- Most popular glazing options with a few extra benefits, including higher STC ratings and triple-pane IG for exceptional energy efficiency.
- GBG and SDL without spacer grille options in multiple patterns.
- Standard and Performance Upgrade options on most product types
- White, Almond and Brown Exterior / White Interior Frame Color Options.

December 2012:

- Launch of HurricaneShield® impact-resistant glazing and combination mulls.
- 1" Dual IG with Low-E options and tints.
- All frame types excluding 3-1/4" pocket replacement block frame.
- Casements automatically upgrade to stainless steel hardware.
- Factory-assembled combinations with 1" mulls (no integral composite mulls). PMB #01-2013.

December 2012:

- Non-Impact laminated glazing added with options of annealed or tempered laminated dual IG. PMB #01-2013.

June 2017:

- Units will receive a black rainstrip, regardless of unit color. Replacement sashes will also receive the black rainstrip. PMB #44-2017.

July 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #47-2017.

August 2020:

- With the launch of new Pella Hurricane Shield Series and Pella Defender Series (PMB #24-2020) Pella 350 Series Impact certifications removed and 350 Impact offering eliminated. PMB #27-2020.

April 2021:

- Pella® 350 Series Windows and Doors eliminated. Complete units eliminated April 2021, service will continue to be offered. Sales tools, corner sections, and POP Kit components eliminated with April elimination. NA-PMB #12-2021, PMB #22-2021 & PMB#40-2021

350 SERIES VINYL PRODUCT HISTORY

Double-Hung

2011 – April 2021

Back to TOC



Interior



Interior



Exterior



Exterior

August 2011:

- Introduced.

Product Specifications

- Pella® Branded Premium Vinyl Platform.
- Complete Nationwide Product Line.
- Most popular glazing options with a few extra benefits, including higher STC ratings and triple-pane IG for exceptional energy efficiency.
- GBG and SDL without spacer grille options in multiple patterns.
- Standard and Performance Upgrade options on most product types
- White, Almond and Brown Exterior / White Interior Frame Color Options.

Upgrade hardware options:

- Sash Lifts (available on hung products).

December 2012:

- Autolock available for 350 Series Double-Hung in white, almond, satin nickel, bright brass and oil rubbed bronze. PMB #2-2013

April 2014:

- On Pella 350 Series Double-Hung, the upper vent stops will now utilize the Pella 250 Series standard vent stop design. This design change allows the use of an optional Window Opening Control Device (WOCD), which meets ASTM F2090 - Standard Specification for Window Fall Prevention Devices With Emergency Escape (Egress) Release Mechanisms. WOCD is a type of device that is becoming more prevalent in code requirements.
- NOTE: The WOCD cannot be used on Pella® 350 Series DH with Maximum Opening Hardware Components.
- Utilizing the new design of vent stops modifies the size of the hole in which the vent stops are inserted, so the previous Pella 350 Series vent stops parts will have a vintage date of Pre-April 2014. Replacement sashes will not have a vintage and will always use the new vent stop design. PMB #20-2014



Standard Vent Stop
Vintage:
Pre-April 2014



Standard Vent Stop
Vintage:
April 2014 - Current



WOCD Vent Stop
Vintage:
April 2014 - Current

June 2017:

- Units will receive a black rainstrip, regardless of unit color. Replacement sashes will also receive the black rainstrip.
  PMB #44-2017.

July 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #47-2017.

August 2020:

- With the launch of new Pella Hurricane Shield Series and Pella Defender Series (PMB #24-2020) Pella 350 Series Impact certifications removed and 350 Impact offering eliminated. PMB #27-2020

April 2021:

- Pella® 350 Series Windows and Doors eliminated. Complete units eliminated April 2021, service will continue to be offered. Sales tools, corner sections, and POP Kit components eliminated with April elimination. NA-PMB #12-2021, PMB #22-2021 & PMB #40-2021

350 SERIES VINYL PRODUCT HISTORY

Single-Hung

2011 – April 2021

Back to TOC



Interior



Interior



Interior



Exterior

August 2011:

- Introduced.

Product Specifications

- Pella® Branded Premium Vinyl Platform.
- Complete Nationwide Product Line.
- Most popular glazing options with a few extra benefits, including higher STC ratings and triple-pane IG for exceptional energy efficiency.
- GBG and SDL without spacer grille options in multiple patterns.
- Standard and Performance Upgrade options on most product types
- White, Almond and Brown Exterior / White Interior Frame Color Options.

Upgrade hardware options:

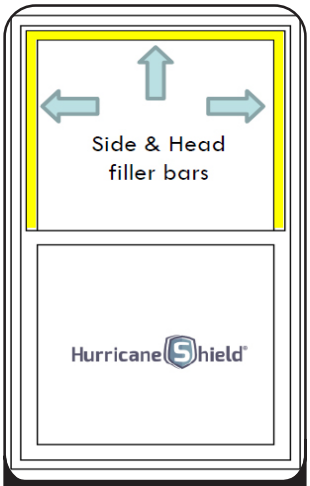
- Sash Lifts (available on hung products).
- Auto-lock (available on sliding window and single hung only).

December 2012:

- Launch of HurricaneShield® impact-resistant glazing and combination mulls.
- 1" Dual IG with Low-E options and tints.
- All frame types excluding 3-1/4" pocket replacement block frame.
- All Single-Hungs include two sash locks and upper sash filler bars.
- Factory-assembled combinations with 1" mulls (no integral composite mulls). PMB #01-2013.

December 2012:

- Non-Impact laminated glazing added with options of annealed or tempered laminated dual IG tempered option only in lower sash of SH. PMB #01-2013.



SH Impact Performance with filler bars

August 2013:

- The ability to select a 24" and 30" lower sash height for Pella 350 Series Single-Hung units is available. PMB #27-2013.

June 2017:

- Units will receive a black rainstrip, regardless of unit color. Replacement sashes will also receive the black rainstrip. PMB #44-2017.

July 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #47-2017.

August 2020:

- With the launch of new Pella Hurricane Shield Series and Pella Defender Series (PMB #24-2020) Pella 350 Series Impact certifications removed and 350 Impact offering eliminated. PMB #27-2020.

April 2021:

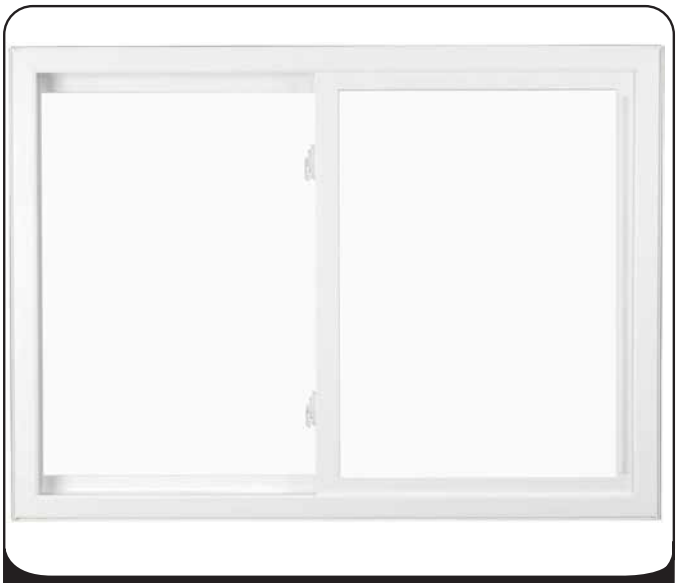
- Pella® 350 Series Windows and Doors eliminated. Complete units eliminated April 2021, service will continue to be offered. Sales tools, corner sections, and POP Kit components eliminated with April elimination. NA-PMB #12-2021, PMB #22-2021 & PMB#40-2021

350 SERIES VINYL PRODUCT HISTORY

Sliding Window

2011 – April 2021

Back to TOC



Interior



Interior

August 2011:

- Introduced.

Product Specifications

- Pella® Branded Premium Vinyl Platform.
- Complete Nationwide Product Line.
- Most popular glazing options with a few extra benefits, including higher STC ratings and triple-pane IG for exceptional energy efficiency.
- GBG and SDL without spacer grille options in multiple patterns.
- Standard and Performance Upgrade options on most product types
- White, Almond and Brown Exterior / White Interior Frame Color Options.

Upgrade hardware options:

- Auto-lock (available on sliding window and single hung only).

July 2016:

- Enhanced aesthetics on Pella 350 Series 3-1/4" block, nail fin, and nail fin with J-channel frame types brown exterior sliding windows! The face of the exterior glazing leg on Pella 350 Series brown sliding windows now painted with our DuraColor™ finish. Prior to this change, this leg was unpainted and the white face was visible from the exterior when a screen wasn't installed in the unit. Prior design will NOT be available.
- 4-1/2" block, double wall flush flange, and integral 5/8" flange frame types schedule to switch to new paint coverage in October. PMB #32-2016.



Previous Paint Coverage



07/2016 - Current Paint Coverage

July 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior.
  PMB #47-2017.

August 2020:

- With the launch of new Pella Hurricane Shield Series and Pella Defender Series (PMB #24-2020) Pella 350 Series Impact certifications removed and 350 Impact offering eliminated.
  PMB #27-2020.

April 2021:

- Pella® 350 Series Windows and Doors eliminated. Complete units eliminated April 2021, service will continue to be offered. Sales tools, corner sections, and POP Kit components eliminated with April elimination.
  NA-PMB #12-2021, PMB #22-2021 & PMB#40-2021



August 2011:

- Introduced.

Product Specifications

- Pella® Branded Premium Vinyl Platform.
- Complete Nationwide Product Line.
- Most popular glazing options with a few extra benefits, including higher STC ratings and triple-pane IG for exceptional energy efficiency.
- GBG and SDL without spacer grille options in multiple patterns.
- Standard and Performance Upgrade options on most product types
- White, Almond and Brown Exterior / White Interior Frame Color Options.

December 2012:

- Launch of HurricaneShield® impact-resistant glazing and combination mulls.
- 1" Dual IG with Low-E options and tints.
- All frame types excluding 3-1/4" pocket replacement block frame.
- All Single-Hungs include two sash locks and upper sash filler bars.
- Factory-assembled combinations with 1" mulls (no integral composite mulls). PMB #01-2013.

December 2012:

- Non-Impact laminated glazing added with options of annealed or tempered laminated dual IG tempered option only in lower sash of SH. PMB #01-2013.

July 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #47-2017.

August 2020:

- With the launch of new Pella Hurricane Shield Series and Pella Defender Series (PMB #24-2020) Pella 350 Series Impact certifications removed and 350 Impact offering eliminated. PMB #27-2020.

April 2021:

- Pella® 350 Series Windows and Doors eliminated. Complete units eliminated April 2021, service will continue to be offered. Sales tools, corner sections, and POP Kit components eliminated with April elimination.
  NA-PMB #12-2021, PMB #22-2021 & PMB#40-2021



August 2011:

- Introduced.

Product Specifications

- Pella® Branded Premium Vinyl Platform.
- Complete Nationwide Product Line.
- Most popular glazing options with a few extra benefits, including higher STC ratings and triple-pane IG for exceptional energy efficiency.
- GBG and SDL without spacer grille options in multiple patterns.
- Standard and Performance Upgrade options on most product types
- White, Almond and Brown Exterior / White Interior Frame Color Options.

December 2012:

- Launch of HurricaneShield® impact-resistant glazing and combination mulls.
- 1" Dual IG with Low-E options and tints.
- All frame types excluding 3-1/4" pocket replacement block frame.
- Factory-assembled combinations with 1" mulls (no integral composite mulls). PMB #01-2013.

December 2012:

- Non-Impact laminated glazing added with options of annealed or tempered laminated dual IG tempered option only in lower sash of SH. PMB #01-2013.

July 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #47-2017.

August 2020:

- With the launch of new Pella Hurricane Shield Series and Pella Defender Series (PMB #24-2020) Pella 350 Series Impact certifications removed and 350 Impact offering eliminated. PMB #27-2020.

April 2021:

- Pella® 350 Series Windows and Doors eliminated. Complete units eliminated April 2021, service will continue to be offered. Sales tools, corner sections, and POP Kit components eliminated with April elimination.
  NA-PMB #12-2021, PMB #22-2021 & PMB#40-2021

350 SERIES VINYL PRODUCT HISTORY

Sliding Door

2011 – April 2021

Back to TOC



Interior



Interior

July 2010:

- Introduced.

Features and options:

- Heavy-duty, fully-welded frame.
- 2-, 3- or 4-Panel configurations.
- 6" standard overall frame depth on all constructions.
- Available in nail fin, block replacement or flange replacement frames.
- Enhanced hardware with 5 interior finish options and a standard Schlage® key way.
- Standard color-matched, heavy-duty aluminum extruded screen.
- Available in White or Almond.
- **Between-the-glass features:** color-matched grilles, White blinds or Linen-colored cellular shades (blinds/shades only available in select standard sizes).
- Double or triple insulating glass – multiple Low-E options based on customer needs. PMB #49-2010.

October 2010:

- HurricaneShield® impact resistant glass now available on 2- and 3-Panel doors plus sidelights and transoms.
- Available in nail fin and block replacement frames.
- Stainless steel rollers standard with impact resistant offering.
- Same standard sizes and custom sizes to the 1/8" increment as within the non-impact offering.
- Single-pane and dual-pane insulated impact resistant glass options. PMB #74-2010.

February 2012:

- Blinds-Between-the-Glass (BBG) / Shades-Between-the-Glass (SBG) now available in a new 2.5' width panel size, (59.5" Frame width). PMB #14-2012.

May 2012:

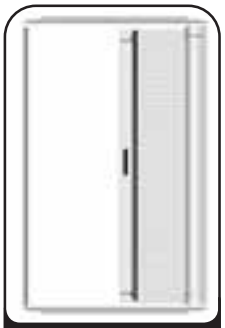
- 4-Panel (OXXO) HurricaneShield launched, panels shipped out of unit.
- Removal of foam insulation option for all HurricaneShield impact-resistant patio doors. PMB #32-2012.

March 2013:

- The offering of the Shades-Between-the-Glass on Pella® 350 Series Sliding Patio Doors was suspended. PMB #11-2013.

April 2013:

- Sliding Door Rolscreen retractable screen introduced as field-installed option for 2-, 3-, and 4-Panel doors. PMB #17-2013.



Retractable Screen

May 2013:

- Pella® 350 Series Sliding Patio Door Replacement Panels with Shades Suspended. PMB #21-2013.

October 2014:

- Shades Between-the-Glass relaunched, overall IG thickness changed from 1" to 1-3/8" - the change in IG thickness also applies to Blinds Between-the-Glass.
- Service Support: New part numbers for Pella 350 Series operator tracks with handles will be implemented at the same time. The glazing bead used for these panels will also change to match what is currently used on our triple pane units. The current vintage for operating tracks for blinds on Encompass by Pella® Sliding Patio Doors remains the same with a naming change. The names better reflect the part which should be ordered in conjunction to the year the door was manufactured. PMB #43-2014.

July 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #47-2017.

August 2020:

- With the launch of new Pella Hurricane Shield Series and Pella Defender Series (PMB #24-2020) Pella 350 Series Impact certifications removed and 350 Impact offering eliminated. PMB #27-2020.

April 2021:

- Pella® 350 Series Windows and Doors eliminated. Complete units eliminated April 2021, service will continue to be offered. Sales tools, corner sections, and POP Kit components eliminated with April elimination. NA-PMB #12-2021, PMB #22-2021 & PMB#40-2021



Casement Interior



Awning Interior

April 2018:

- Introduced (East Region). PMB #11-2018.

Product Specifications:

- Pella® Branded Vinyl line
- The new frame profile has approximately 1" of additional visible glass on the width and the height of the unit compared to the Encompass Casement.

May 2018:

- Introduced (West Region) PMB #16-2018.

Product Specifications:

- Pella® Branded Vinyl line
- The new frame profile has approximately 1" of additional visible glass on the width and the height of the unit compared to the Encompass Casement.

June 2018:

- Fossil added as a solid color (extruded) option. The painted Fossil option will remain available in Pella 250 Series. PMB #34-2018.

May 2020:

- Introduced in the PSE Exclusive Bundle

Features include:

- Satin Nickel and Oil-Rubbed Bronze upgraded hardware options
- Double Strength 3mm/3mm glass, In-View Screen.
- Foam Insulated Sash and Frame.

Nov. 2020:

- West only: Nail Fin with J-Channel and Integral 5/8" Flange removed from offering.

August 2023:

- Northeast Region Only
- Vinyl Flat Casing launched.
- Factory applied, no option for field application or replacement. Full unit replacement required when flat casing replacement is needed.
- Available in white, almond and fossil.
- Nail fin frame type only.

PMB #32-2023



Flat Casing with End Cap

December 2023:

- Almond and Fossil flat casing colors suspended. PMB #49-2023

October 2025:

- Lock handle hardware utilized on Pella® 250 Series casement and awning units updated. This update impacted both complete units and replacement sashes with no impact to performance values. As white hardware was the most critical component within this transition, this hardware transitioned first with almond and fossil following.

PMB #65-2025



Pre-10/2025 CM Lock Lever



10/2025 - Current CM Lock Lever



Interior



Interior

January 2014:

- Introduced. PMB #41-2013.

Product Specifications:

- Pella® Branded Vinyl line.
- Most popular glazing options available with an upgrade option of triple pane IG for exceptional energy efficiency.
- Standard or performance upgrade option available.
- Several GBG and SDL grid pattern options.
- White and Almond frame color options
- Enhanced screen design.

Upgrade hardware options:

- Autolock available.

November 2014:

- Pella 250 Series single hung and Double-Hung units will have a new sash stop that allows for additional sash travel and expanded egress sizes. The new sash stop will come standard on all Pella 250 Series single and Double-Hung units and allows the bottom sash to travel approximately an extra 3/4 of an inch. PMB #50-2014.



Pre-11/2014



11/2014 - 2016

August 2015:

- Double Wall Flush Flange frame type now available. PMB #41-2015.

January 2017:

- The balance service access, located at the bottom of the jamb, moved to the top of the jamb. The new service access is longer to allow for easier servicing of double and triple coil balances used on heavy sashes. As a result, the sash stop will no longer be needed and will not be sent on new units.
- New lower sash stop and balance pocket cover. New stop and balance cover used to replace all previous vintage stops. PMB #4-2017.



Previous Sill End Balance Jamb Service Access



Previous Sill End Balance Jamb Service Access with Sash Stop



2017 - Current; No Jamb Balance Service Access at Sill



Previous Head End Balance Jamb Service Access



2017 - Current; Longer Head End Balance Jamb Service Access Also shows new lower sash stop and balance pocket cover.

Continued on next page

January 2017:

- Double-Hung and Single-Hung; A foam pad added to seal the gap between the sill interlocker and the jamb. Additionally, the weatherstrip used on the sash stiles and interlocker changed to a triple fin design from a single fin design. PMB #4-2017.



Previous Sill Interlocker with Gap



2017 - Current; Sill Interlocker with Foam Plug

September 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #64-2017.

June 2018:

- Fossil added as a solid color (extruded) option. The painted Fossil option will remain available in Pella 250 Series. PMB #34-2018.

May 2020:

- Introduced in the PSE Exclusive Bundle

Features include:

- Exclusive Comfort Lock (auto lock) and Home Comfort Tilt Latches.
- Satin Nickel and Oil-Rubbed Bronze upgraded hardware options on the Comfort Lock, Double Strength 3mm/3mm glass.
- In-View Screen, and Foam Insulated Sash and Frame.

November 2020:

- West only: Nail Fin with J-Channel and Integral 5/8" Flange removed from offering.

April 2022:

- Pella 250 Series Double-Hung, products will be expanding to a maximum frame height on a Double-Hung of 86". Due to the weight of the sash, there will be a few attribute dependencies for frame width, venting configurations, hardware type and glass strength. Please see details on PMB #25-2022.

Important Notes:

- Available to branches that are sourced out of East vinyl plants only.
- Not available to the commercial segment at this time.
- No new standard sizes will be added
- Expanded sizes are available with dual pane glass only.
- No factory mulling or integral mulls will be offered on the expanded size range.

August 2022:

- A design enhancement made to the over-travel clip on 250 Series Double Hung products which allows the over-travel clip to be compatible with the hidden screen. As a reminder, an over-travel stop is used on units taller than 66" and Cottage style windows.
- The current in-field solution was to remove the sash travel limiters not compatible with the hidden screen and replace those with a pan head screw in each upper balance channel. The new part now comes factory installed on all applicable units. This will be a running change, with all applicable units getting the new part by August 31.
- The service parts package (V985020) will be updated to include the new part. This part requires a slight notch in the jamb of the frame so it is not retrofittable. PMB #44-2022

July 2023:

- Expanded Sizes to 53.5" x 86" To the West vinyl branches & entire Commercial segment.
- Several Attribute Considerations:
  - Sash split (Double Hung max height available only in Equal sash, Single Hung max height available only in Contemporary sash)
  - Glass strength (Tempered glass will limit the available sizing)
  - IG Type (Current Triple IG limitations still exist)
  - Lock type (Cam or Auto Lock will impact the available sizing in Double Hung products)
  - Mulling (Integral Mulls are not available with the updated sizing)

  PMB #28-2023 (See also PMB #25-2022.)

August 2023:

- Northeast Region Only
- Vinyl Flat Casing launched.
- Factory applied, no option for field application or replacement. Full unit replacement required when flat casing replacement is needed.
- Available in white, almond and fossil.
- Nail fin frame type only.

  PMB #32-2023



Flat Casing with End Cap

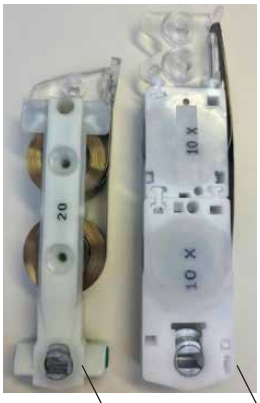
December 2023:

- Almond and Fossil flat casing colors suspended. PMB #49-2023

August 2025:

- Began phased transition to a new constant force balance design in our Pella® 250 Series Double and Single-Hung units. Transition to be complete by October 13.
- Transitioned from an open coil balance to a closed coil balance.
- Moving to the closed coil design will require use of a production balance and a (different) modular design service balance.
- Production balances will be installed in factory-assembled units while modular design service balances will be used for field service applications.
- All Pella® 250 Series Double and Single-Hung units built after December 2014 will be serviced with the new modular design.
- When servicing a unit with the old design installed, new pivot bars and friction screws designed for the closed coil balance are necessary to install the new design.
- Pivot bars will no longer be factory installed in replacement sashes. Instead, a pivot bar replacement package including all vintages will be provided with any replacement sash, shipped taped to the sash.
- Pivot bars will no longer be factory installed in replacement sashes. Instead, a pivot bar replacement package including all vintages will be provided with any replacement sash, shipped taped to the sash.

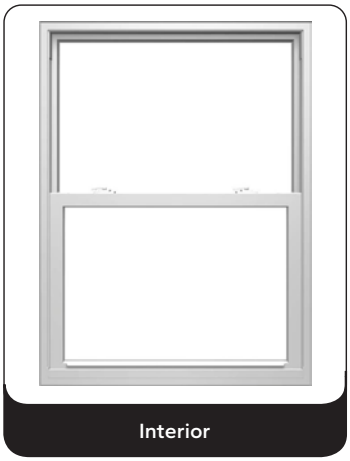
PMB #55-2025



Old Balance — New Balance



New modular service balance — New factory-installed balance


Interior


Interior

January 2014:

- Introduced. PMB #41-2013.

Product Specifications:

- Pella® Branded Vinyl line.
- Most popular glazing options available with an upgrade option of triple pane IG for exceptional energy efficiency.
- Standard or performance upgrade option available.
- Several GBG and SDL grid pattern options.
- White and Almond frame color options.
- Enhanced screen design.

Upgrade hardware options:

- Autolock available.

November 2014:

- Pella 250 Series single hung and Double-Hung units will have a new sash stop that allows for additional sash travel and expanded egress sizes. The new sash stop will come standard on all Pella 250 Series single and Double-Hung units and allows the bottom sash to travel approximately an extra 3/4 of an inch. PMB #50-2014.


Pre-11/2014

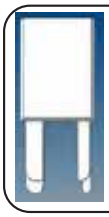

11/2014 - 2016

August 2015:

- Double Wall Flush Flange frame type now available. PMB #41-2015.

January 2017:

- New lower sash stop and balance pocket cover. New stop and balance cover used to replace all previous vintage stops. PMB #4-2017.


2017 - Current SH Lower Sash Stop

January 2017:

- Double-Hung and Single-Hung; A foam pad added to seal the gap between the sill interlocker and the jamb. Additionally, the weatherstrip used on the sash stiles and interlocker changed to a triple fin design from a single fin design.


Previous Sill Interlocker with Gap


2017 - Current; Sill Interlocker with Foam Plug

September 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #64-2017.

June 2018:

- Fossil added as a solid color (extruded) option. The painted Fossil option will remain available in Pella 250 Series. PMB #34-2018.

May 2020:

- Introduced in the PSE Exclusive Bundle

Features include:

- Exclusive Comfort Lock (auto lock) and Home Comfort Tilt Latches.
- Satin Nickel and Oil-Rubbed Bronze upgraded hardware options on the Comfort Lock, Double Strength 3mm/3mm glass.
- In-View Screen, and Foam Insulated Sash and Frame.

November 2020:

- West only: Nail Fin with J-Channel and Integral 5/8" Flange removed from offering.

April 2022:

- Pella 250 Series Double-Hung, products will be expanding to a maximum frame height on a Single-Hung of 96". Due to the weight of the sash, there will be a few attribute dependencies for frame width, venting configurations, hardware type and glass strength. Please see details on PMB #25-2022.

Important Notes:

- Available to branches that are sourced out of East vinyl plants only.
- Not available to the commercial segment at this time.
- No new standard sizes will be added
- Expanded sizes are available with dual pane glass only.
- No factory mulling or integral mulls will be offered on the expanded size range.

Continued on next page

July 2023:

- Expanded Sizes to 53.5" x 96" with Contemporary sash split to the West vinyl branches & entire Commercial segment.
- Several Attribute Considerations:
  - Sash split (Double Hung max height available only in Equal sash, Single Hung max height available only in Contemporary sash)
  - Glass strength (Tempered glass will limit the available sizing)
  - IG Type (Current Triple IG limitations still exist)
  - Lock type (Cam or Auto Lock will impact the available sizing in Double Hung products)
  - Mulling (Integral Mulls are not available with the updated sizing)

PMB #28-2023 (See also PMB #25-2022)

August 2023:

- Northeast Region Only
- Vinyl Flat Casing launched.
- Factory applied, no option for field application or replacement. Full unit replacement required when flat casing replacement is needed.
- Available in white, almond and fossil.
- Nail fin frame type only.

PMB #32-2023



Flat Casing with End Cap

December 2023:

- Almond and Fossil flat casing colors suspended. PMB #49-2023

August 2025:

- Began phased transition to a new constant force balance design in our Pella® 250 Series Double and Single-Hung units. Transition to be complete by October 13.
- Transitioned from an open coil balance to a closed coil balance.
- Moving to the closed coil design will require use of a production balance and a (different) modular design service balance.
- Production balances will be installed in factory-assembled units while modular design service balances will be used for field service applications.
- All Pella® 250 Series Double and Single-Hung units built after December 2014 will be serviced with the new modular design.
- When servicing a unit with the old design installed, new pivot bars and friction screws designed for the closed coil balance are necessary to install the new design.
- Pivot bars will no longer be factory installed in replacement sashes. Instead, a pivot bar replacement package including all vintages will be provided with any replacement sash, shipped taped to the sash.
- Pivot bars will no longer be factory installed in replacement sashes. Instead, a pivot bar replacement package including all vintages will be provided with any replacement sash, shipped taped to the sash.

PMB #55-2025



Old Balance — New Balance

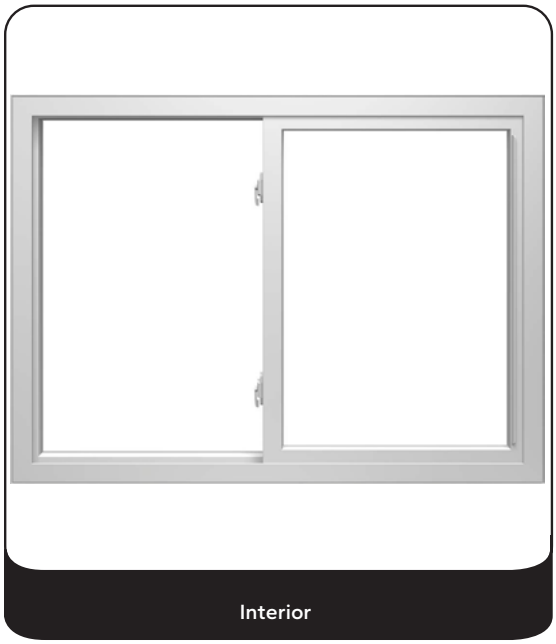


New modular service balance — New factory-installed balance



November 2024:

- Curved Top Single Hung launched in Southeast, South, Southwest and West regions.
- Product configurations or Partial Springline, Springline, Arch Head and Partial Arch Head.
- Sunburst grille pattern available in Arch Head, Springline and Partial Arch Head.
- PMB #66-2024



Interior



Interior

January 2014:

- Introduced. PMB #41-2013.

Product Specifications:

- Pella® Branded Vinyl line.
- Most popular glazing options available with an upgrade option of triple pane IG for exceptional energy efficiency.
- Standard or performance upgrade option available.
- Several GBG and SDL grid pattern options.
- White and Almond frame color options.
- Enhanced screen design.

Upgrade hardware options:

- Autolock available.

August 2015:

- Double Wall Flush Flange frame type now available. PMB #41-2015.

September 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #64-2017.

June 2018:

- Fossil added as a solid color (extruded) option. The painted Fossil option will remain available in Pella 250 Series. PMB #34-2018.

May 2020:

- Introduced in the PSE Exclusive Bundle

Features include:

- Exclusive Comfort Lock (auto lock).
- Satin Nickel and Oil-Rubbed Bronze upgraded hardware options on the Comfort Lock, Double Strength 3mm/3mm glass.
- In-View Screen, and Foam Insulated Sash and Frame.

November 2020:

- West only: Nail Fin with J-Channel and Integral 5/8" Flange removed from offering.

April 2022:

- Pella 250 Series Double-Hung, products will be expanding to a maximum frame height on a Double-Hung of 86". Due to the weight of the sash, there will be a few attribute dependencies for frame width, venting configurations, hardware type and glass strength. Please see details on PMB #25-2022.

Important Notes:

- Available to branches that are sourced out of East vinyl plants only.
- Not available to the commercial segment at this time.
- No new standard sizes will be added
- Expanded sizes are available with dual pane glass only.
- No factory mulling or integral mulls will be offered on the expanded size range.

August 2023:

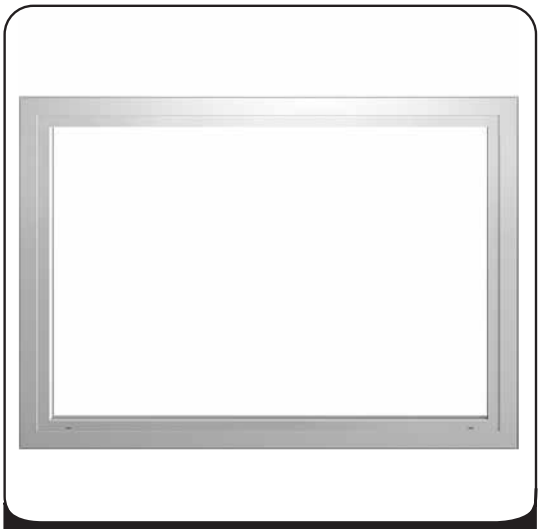
- Northeast Region Only
- Vinyl Flat Casing launched.
- Factory applied, no option for field application or replacement. Full unit replacement required when flat casing replacement is needed.
- Available in white, almond and fossil.
- Nail fin frame type only.
  PMB #32-2023



Flat Casing with End Cap

December 2023:

- Almond and Fossil flat casing colors suspended. PMB #49-2023



Exterior

January 2014:

- Introduced. PMB #41-2013.

Product Specifications:

- Pella® Branded Vinyl line.
- Most popular glazing options available with an upgrade option of triple pane IG for exceptional energy efficiency.
- Standard or performance upgrade option available.
- Several GBG and SDL grid pattern options.
- White and Almond frame color options.

August 2015:

- Double Wall Flush Flange frame type now available. PMB #41-2015.

September 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #64-2017.

June 2018:

- Fossil added as a solid color (extruded) option. The painted Fossil option will remain available in Pella 250 Series. PMB #34-2018.

May 2020:

- Introduced in the PSE Exclusive Bundle

Features include:

- Double Strength 3mm/3mm glass.
- Foam Insulated Sash and Frame.

November 2020:

- West only: Nail Fin with J-Channel and Integral 5/8" Flange removed from offering.

August 2023:

- Northeast Region Only
- Vinyl Flat Casing launched.
- Factory applied, no option for field application or replacement. Full unit replacement required when flat casing replacement is needed.
- Available in white, almond and fossil.
- Nail fin frame type only.

PMB #32-2023



Flat Casing with End Cap

December 2023:

- Almond and Fossil flat casing colors suspended. PMB #49-2023

April 2024:

- Update of the size charts for 250 Series rectangle and radius shape direct set windows. These sizes will be offered in select markets, based on identified regional market needs.
- Radius shape direct set units will be expanding sizes within the Block & Nail fin frame types in several shapes & dimensions.

Arch Head / Partial Arch Head

- Minimum Height Decrease from 17.5" to 11.5"
- Minimum Height Decrease from 8" to 6"

Springline

- Short Side Minimum Height Decrease from 8" to 6"
- Minimum Height Decrease from 20.5" to 17.75"
- Minimum Width Decrease from 29.5" to 23.5"

Half Circle

- Minimum Width Decrease from 29.5" to 23.5"
- All Radius Shapes Minimum Radius Allowed of 11.75"
  - This updated radius shape direct set size offering will be available to customers in the following states: Alabama, Alaska, Arizona, Arkansas, California, Colorado, Florida, Georgia, Hawaii, Idaho, Kentucky, Louisiana, Maryland, Mississippi, Montana, Nevada, New Mexico, North Carolina, Oklahoma, Oregon, and Wyoming.
- Other frame types like Nail Fin w/ J Channel, Double Wall Flush Flange, and 5/8" Florida Flange will not see adjustments to their size charts in these shapes.
- Rectangle direct set units will be expanding the available short side length to 10" from the current 11.5" today. In coordination with this update, we have also removed a ratio limitation in PQM that prevented units from being configured with more than a 10:1 glass ratio. This enables us to achieve the complete size chart at 10" width or height (up to the current 108" limitation). All other existing glass limitations will apply to units at the updated size.
  - This updated rectangle direct set size offering will be available to customers in the following states: Alabama, Alaska, Arizona, Arkansas, California, Colorado, Hawaii, Idaho, Kentucky, Louisiana, Mississippi, Montana, Nevada, New Mexico, Oklahoma, Oregon, Tennessee, Texas, Utah, Washington, and Wyoming.

PMB #22-2024





January 2014:

- Introduced. PMB #41-2013.

Product Specifications:

- Pella® Branded Vinyl line.
- Most popular glazing options available with an upgrade option of triple pane IG for exceptional energy efficiency.
- Standard or performance upgrade option available.
- Several GBG and SDL grid pattern options.
- White and Almond frame color options.

August 2015:

- Double Wall Flush Flange frame type now available. PMB #41-2015.

September 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #64-2017.

June 2018:

- Fossil added as a solid color (extruded) option. The painted Fossil option will remain available in Pella 250 Series. PMB #34-2018.

November 2020:

- West only: Nail Fin with J-Channel and Integral 5/8" Flange removed from offering.

April 2024:

- Update of the size charts for 250 Series rectangle and radius shape direct set windows. These sizes will be offered in select markets, based on identified regional market needs.
- Radius shape direct set units will be expanding sizes within the Block & Nail fin frame types in several shapes & dimensions.

Arch Head / Partial Arch Head

- Minimum Height Decrease from 17.5" to 11.5"
- Minimum Height Decrease from 8" to 6"

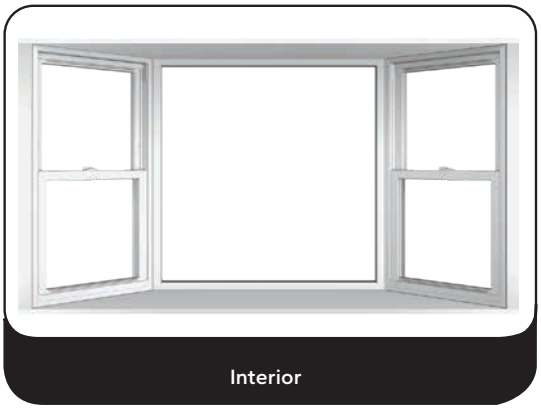
Springline

- Short Side Minimum Height Decrease from 8" to 6"
- Minimum Height Decrease from 20.5" to 17.75"
- Minimum Width Decrease from 29.5" to 23.5"

Half Circle

- Minimum Width Decrease from 29.5" to 23.5"
- All Radius Shapes Minimum Radius Allowed of 11.75"
  - This updated radius shape direct set size offering will be available to customers in the following states: Alabama, Alaska, Arizona, Arkansas, California, Colorado, Florida, Georgia, Hawaii, Idaho, Kentucky, Louisiana, Maryland, Mississippi, Montana, Nevada, New Mexico, North Carolina, Oklahoma, Oregon, and Wyoming.
- Other frame types like Nail Fin w/ J Channel, Double Wall Flush Flange, and 5/8" Florida Flange will not see adjustments to their size charts in these shapes.
- Rectangle direct set units will be expanding the available short side length to 10" from the current 11.5" today. In coordination with this update, we have also removed a ratio limitation in PQM that prevented units from being configured with more than a 10:1 glass ratio. This enables us to achieve the complete size chart at 10" width or height (up to the current 108" limitation). All other existing glass limitations will apply to units at the updated size.
  - This updated rectangle direct set size offering will be available to customers in the following states: Alabama, Alaska, Arizona, Arkansas, California, Colorado, Hawaii, Idaho, Kentucky, Louisiana, Mississippi, Montana, Nevada, New Mexico, Oklahoma, Oregon, Tennessee, Texas, Utah, Washington, and Wyoming.

PMB #22-2024



Interior

January 2014:

- Introduced. PMB #41-2013.

Product Specifications:

- Pella® Branded Vinyl line.
- Most popular glazing options available with an upgrade option of triple pane IG for exceptional energy efficiency.
- Standard or performance upgrade option available.
- Several GBG and SDL grid pattern options.
- White and Almond frame color options.
- Enhanced screen design.

September 2017:

- Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #64-2017.

April 2018:

- Introduced 250 Casement 15 Deg Bow and 45 Deg Bay (East Region) PMB #11-2018.

May 2018:

- Introduced 250 Casement 15 Deg Bow and 45 Deg Bay (West Region). PMB #22-2018.

June 2018:

- Fossil added as a solid color (extruded) option. The painted Fossil option will remain available in Pella 250 Series. PMB #34-2018.

May 2020:

- Introduced in the PSE Exclusive Bundle.

November 2020:

- West only: Nail Fin with J-Channel and Integral 5/8" Flange removed from offering.

November 2023:

- Added Brown and Black Laminate finish to Pella 250 Series Bay and Bow complete units. This will also be allowed for configured service.
- Laminates offered on the following products: Casement Unit Bay, Casement Unit Bow, Hung Unit Bay, Hung Unit Bow.
  PMB #48-2023

September 2024:

- All 250 Series Bay and Bow units, previously available with almond and fossil exterior-colored boards, now come with white exterior boards.
  PMB #58-2024





March 2026

Sliding Door Platform redesign

- 5-15/16 frame depth
- Two panel styles available.
- Aluminum reinforced panels.
- Black interior and exterior frame options.
- New Handle design and upgraded flush handle.
- Multipoint locking hardware.
- Composite roller mechanisms.
- New Flush Secure Vent Lock (replaces footbolt).
- Aluminum Threshold, panel support and screen track.
- Enhanced screen design.
- Narrower sight lines.

PMB #07-2026, PMB #13-2026, PMB #23-2026

250 SERIES VINYL PRODUCT HISTORY

Sliding Patio Door (Classic)

2019 – 04/2026

Back to TOC



Interior

July 2019:

- Introduced 2-Panel sliding patio door, transom and sidelight configurations.
- Available in solid colors of White, Almond and Fossil.
- Blinds Between-the-Glass available in White, Silver Moon, Slate Gray, Clay, Espresso and Sand.
- Blinds Between-the-Glass available in special frame size options.
- Integrated Footbolt option.

September 2019:

- 3-Panel OXO configurations in OXO vent left or vent right, up to 12' wide.
- 4-Panel OXXO configuration up to 16' wide.
- All 3- and 4-Panel configurations have a knock down frame only.
- Dual color frame options with a painted exterior, white interior.
- Value Add options include factory mulling, simulated-divided-lite grilles.
- Service items for additions.

October 2019:

- Extruded (solid) color Fossil option removed until further notice. Exterior painted Fossil with interior white still available.

January 2020:

- Extruded Fossil (Fossil Int/Ext) returned as product option.
- Upon further review of vinyl material color compared to the BBG color options, it was determined that Sand color BBG's are not compatible with extruded Fossil color. To prevent confusion and make selection easier, Sand BBG's were removed from the options when Fossil Int/Ext is selected. PMB #12-2020.

May 2020:

- Introduced in the PSE Exclusive Bundle
- Foam insulated will come standard, all other features and options will be pickable.

November 2020:

- West only: Nail Fin with J-Channel and Integral 5/8" Flange removed from offering.

July 2022:

- High Performance (R50) option for 2-panel only Pella® 250 Series sliding patio doors released up to 8' x 8'. There have been design enhancements made to the offering beyond our traditional standard patio door design to meet the R50 performance requirements. Doors not ordered as performance upgrades will not be retrofittable to achieve an R50 rating
- Changes to design include (varies based on size):
  - Unique stiffener package in panels
  - Additional sill weeps
  - Sill Track End Caps (pre-installed in frame jambs)
  - Sill Riser (field installed, shipped as a separate line item with scannable label)
- Service panels will now ask the performance option question. High performance must be selected to get replacement panels for doors with an R50 rating. PMB#32-2022

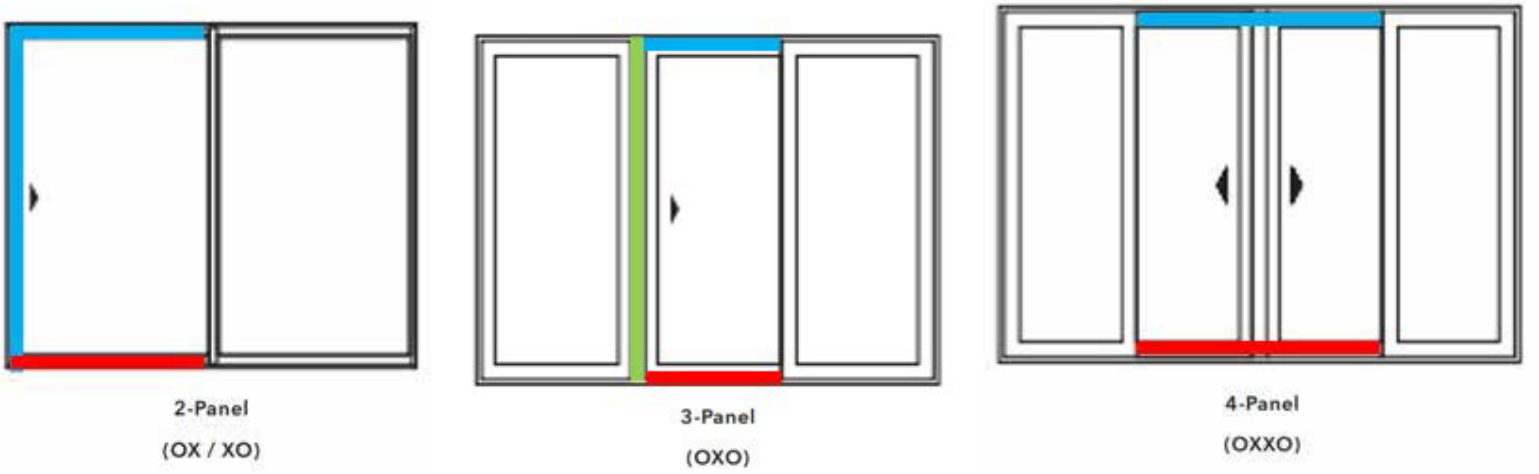
August 2023:

- New standard width added to the Pella 250 Series Sliding Patio Door offering. This 80" call width (79.5" frame width) allows Pella to have a the frame width which has a 32" clear opening as a standard size. PMB #34-2023

August 2023:

- Changed existing 250 Series Sliding Patio door name to include "Classic" to create separation and avoid confusion with the Standard and Premium (Win-Dor) product additions. PMB # 37-2023

Continued on next page



September 2023:

- A change was made to the color of the Threshold and Pocket Covers of the 250 Series Sliding Patio doors to a more complimentary color match. This change impacts black and brown exterior doors, and the updated material will provide a more complementary aesthetic to both exterior colors.
- When servicing a laminated door built before 9/7/2023 you will need to service both the Threshold and Pocket Covers. Replacing all parts will help ensure a seamless and visually appealing door. A soft warning will be added to PQM to advise users to replace all parts. Both parts will not need to be replaced when servicing a painted door, this is only applicable for laminated doors.

PMB #41-2023

Door Configurations

This affects the following door configurations depicted below: OXXO, OXO, XO or OX.

Red indicates the Threshold which will be changing.

Blue indicates the Pocket Covers which will be changing.

Green indicates the Pocket Cover laminated which will not be changing. This specific Pocket Cover is only part of the pocket cover kit for an OXO.

July 2024:

- On April 5, 2024, a modification was implemented in the manufacturing process to shorten the length of the lower screen track by 3-inches from either side. This shorter length is to accommodate units ordered as High Performance (DP50) to minimize restrictions to the weep system.
- To reduce complexity in manufacturing processes, the shorter length was implemented across all doors although it is only required for High Performance. Due to feedback received, we are reverting to the original length (1/2-inch from jambs) for all units, while providing installation instructions on how to cut the track past the weep system for any units with High Performance requirements. Reprocessing orders began on Monday July 1, to ensure the correct lower screen track size is sent.

PMB #39-2024





March 2026:

- Classic service parts being removed: PD keeper and screws (Almond)
- BBG Operator kits in Clay, Sand and Silver Moon
- Individual handles in White, Almond, and Fossil (If replacement is needed, order full interior/exterior handle sets).
- Discontinuation of handle colors: Tan, Poplar White, Portobello, Morning Sky Gray, Hartford Green, Brick Red, Satin Nickel, Oil Rubbed Bronze, and Bright Brass

PMB #2#-2026

July 2026:

- July 3, 2026 - Final day to order Classic SPD Frame Service Items, Including: Frame, Pocket covers and Sill riser
- Classic Screen No longer available (PMB #30-2026)

PMB #34-2026

August 2026:

- Pella® 250 Series Classic Sliding Patio Door Replacement Screen transitioned to the new screen platform used on the new 250 Series Sliding Patio Door. The following parts no longer available:
  - Classic Screen
  - Classic Upper Screen Track
  - Screen Astragal
  - Screen Stop
  - Sliding Door Screen Carriage
  - 250 Patio Door Screen Mounting Screw Pack

PMB #44-2026



Bifold Window

250 Series (Standard) | 2750 Series

October 2023:

- Pella 250 Series (Standard) Bifold Window added as an option. PMB #43-2023

December 2023:

- All Pella 250 Series Standard and Premium Door products will transition from Painted Bronze to Brown Laminate. This change will allow the exterior color to match the Brown Laminate currently offered on Pella 250 Series products. As a reminder the Black Laminate already matches across the full 250 Series Portfolio.
- All service parts for Painted Bronze will be available except for full units. PMB #53-2023

April 2024:

All Pella 250 Series

- Standard and Premium Door products transitioned from Brushed Chrome hardware to Satin Nickel.
- This change allows the hardware color to match the Satin Nickel currently offered on Classic Pella.
- 250 Series products. PMB #24-2024

May 2024:

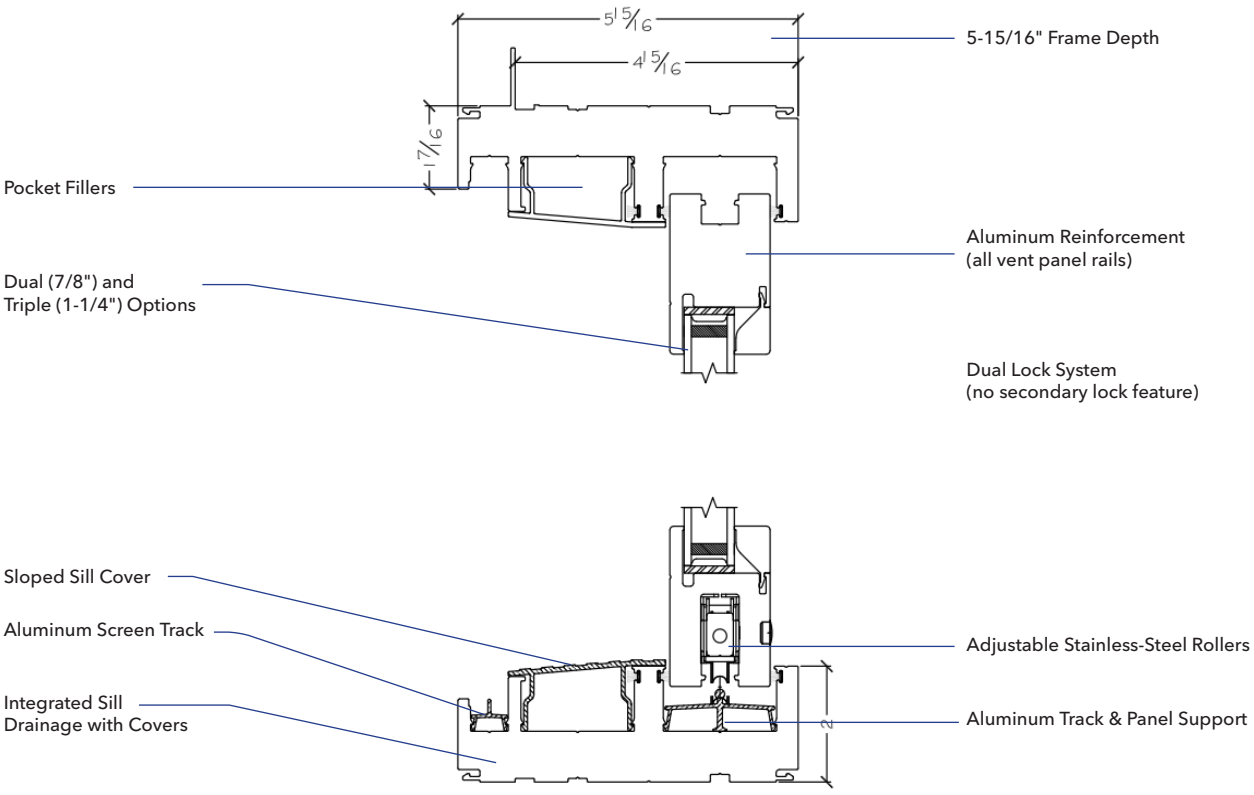
- Officially branded as Pella 250 Standard. PMB #33-2024

250 SERIES VINYL (STANDARD) – WIN-DOR 2750 SERIES PRODUCT HISTORY

Sliding Patio Door

04/2023 – 05/2024

Back to TOC



August 2023:

- Added Pella 250 Series Standard and Premium (Win-Dor 2750 & 3750) 2, 3 and 4 panel Sliding Patio Door products to the offering.
- Premium 4 panel product provides a black interior/black exterior 4 panel option in a non-wood solution.
- The 250 Series Sliding Patio door name to include "Classic" to create separation and avoid confusion with the Standard and Premium product additions. PMB #37-2023

December 2023:

- All Pella 250 Series Standard and Premium Door products will transition from Painted Bronze to Brown Laminate. This change will allow the exterior color to match the Brown Laminate currently offered on Pella 250 Series products. As a reminder the Black Laminate already matches across the full 250 Series Portfolio.
- All service parts for Painted Bronze will be available except for full units. PMB #53-2023

April 2024:

All Pella 250 Series

- Standard and Premium Door products transitioned from Brushed Chrome hardware to Satin Nickel.
- This change allows the hardware color to match the Satin Nickel currently offered on Classic Pella.
- 250 Series products. PMB #24-2024

May 2024:

- Officially branded as Pella 250 Standard. PMB #33-2024



Multi-Slide

250 Series (Standard) | 2750 Series

April 2023:

- Win-Dor offering integrated into 250 Series brand.
- For customer service-related questions, please contact Pella Customer Service. PMB #18-2023

December 2023:

- All Pella 250 Series Standard and Premium Door products will transition from Painted Bronze to Brown Laminate. This change will allow the exterior color to match the Brown Laminate currently offered on Pella 250 Series products. As a reminder the Black Laminate already matches across the full 250 Series Portfolio.
- All service parts for Painted Bronze will be available except for full units. PMB #53-2023

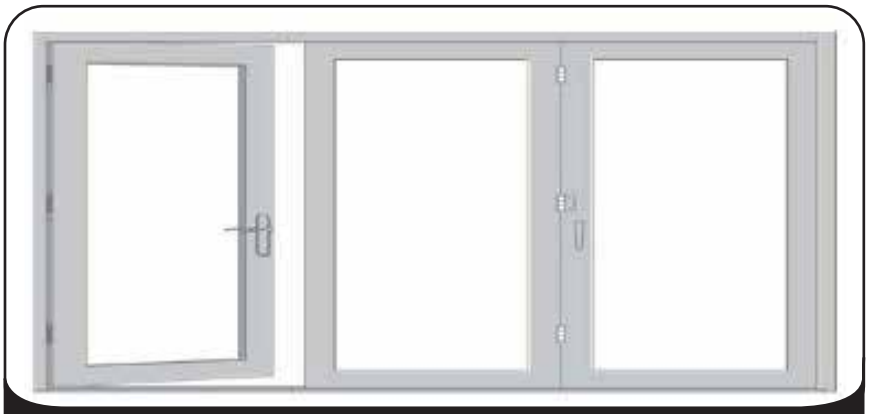
April 2024:

All Pella 250 Series

- Standard and Premium Door products transitioned from Brushed Chrome hardware to Satin Nickel.
- This change allows the hardware color to match the Satin Nickel currently offered on Classic Pella.
- 250 Series products. PMB #24-2024

May 2024:

- Officially branded as Pella 250 Standard. PMB #33-2024



Bifold Window

250 Series (Premium) | 3750 Series

April 2023:

- Win-Dor offering integrated into 250 Series brand.
- For customer service-related questions, please contact Pella Customer Service. PMB #18-2023

December 2023:

- All Pella 250 Series Standard and Premium Door products will transition from Painted Bronze to Brown Laminate. This change will allow the exterior color to match the Brown Laminate currently offered on Pella 250 Series products. As a reminder the Black Laminate already matches across the full 250 Series Portfolio.
- All service parts for Painted Bronze will be available except for full units. PMB #53-2023

April 2024:

All Pella 250 Series

- Standard and Premium Door products transitioned from Brushed Chrome hardware to Satin Nickel.
- This change allows the hardware color to match the Satin Nickel currently offered on Classic Pella.
- 250 Series products. PMB #24-2024

May 2024:

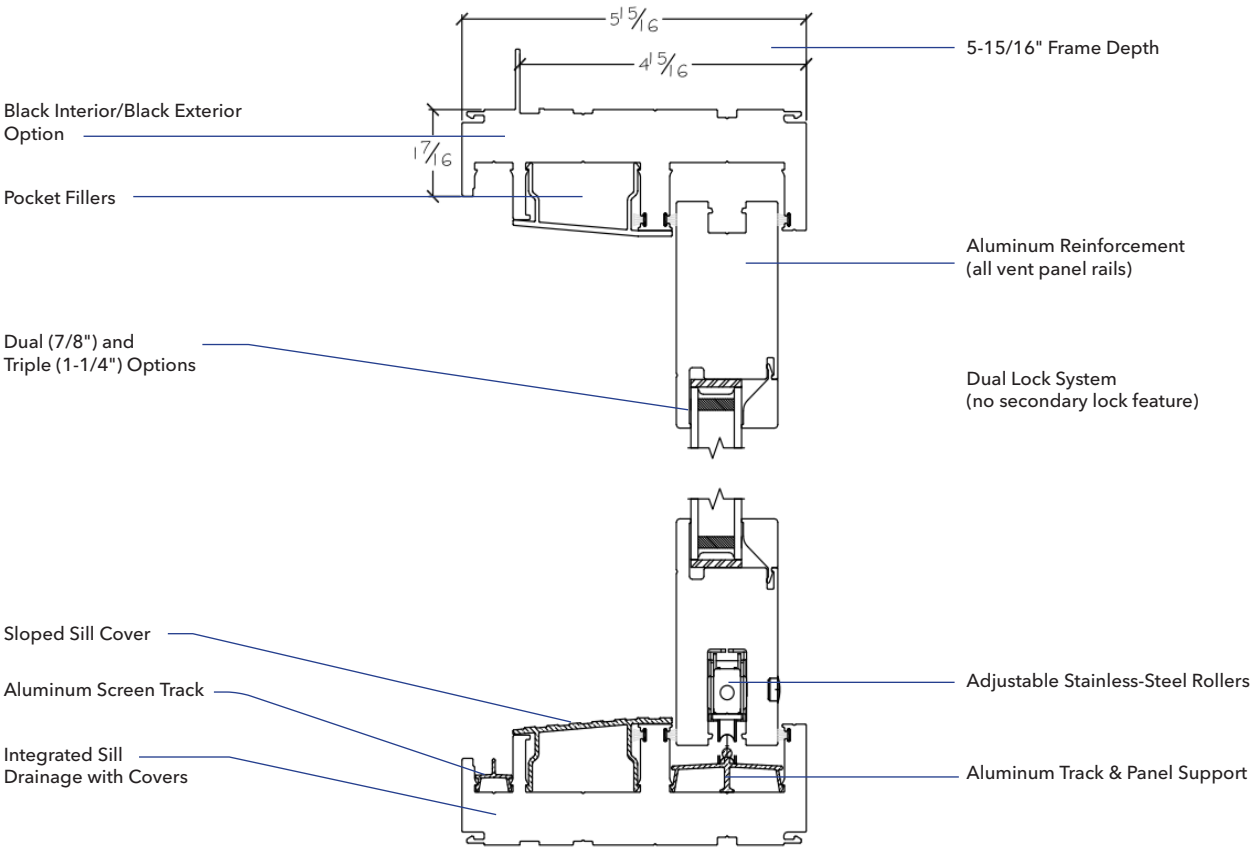
- Officially branded as Pella 250 Standard. PMB #33-2024

250 SERIES VINYL (PREMIUM) – WIN-DOR 3750 SERIES PRODUCT HISTORY

Sliding Patio Door

04/2023 – 05/2024

Back to TOC



August 2023:

- Added Pella 250 Series Standard and Premium (Win-Dor 2750 & 3750) 2, 3 and 4 panel Sliding Patio Door products to the offering.
- Premium 4 panel product provides a black interior/black exterior 4 panel option in a non-wood solution.
- The 250 Series Sliding Patio door name to include "Classic" to create separation and avoid confusion with the Standard and Premium product additions. PMB #37-2023

December 2023:

- All Pella 250 Series Standard and Premium Door products will transition from Painted Bronze to Brown Laminate. This change will allow the exterior color to match the Brown Laminate currently offered on Pella 250 Series products. As a reminder the Black Laminate already matches across the full 250 Series Portfolio.
- All service parts for Painted Bronze will be available except for full units. PMB #53-2023

April 2024:

All Pella 250 Series

- Standard and Premium Door products transitioned from Brushed Chrome hardware to Satin Nickel.
- This change allows the hardware color to match the Satin Nickel currently offered on Classic Pella.
- 250 Series products. PMB #24-2024

May 2024:

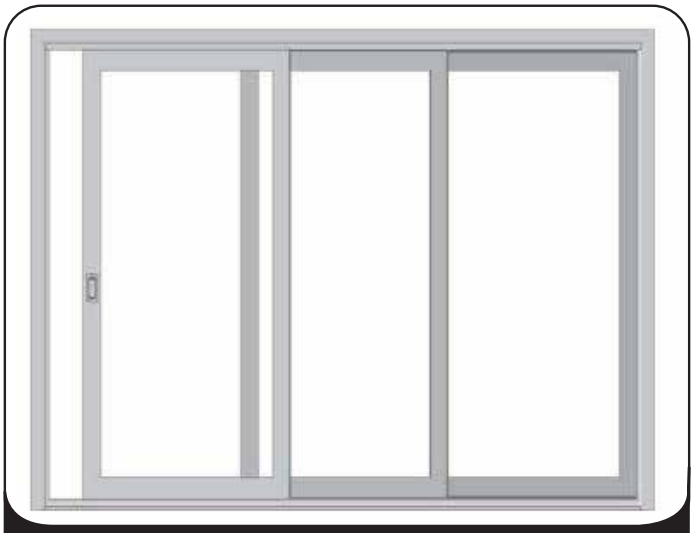
- Officially branded as Pella 250 Standard. PMB #33-2024

250 SERIES VINYL (PREMIUM) – WIN-DOR 3750 SERIES PRODUCT HISTORY

Multi-Panel Door

04/2023 – 05/2024

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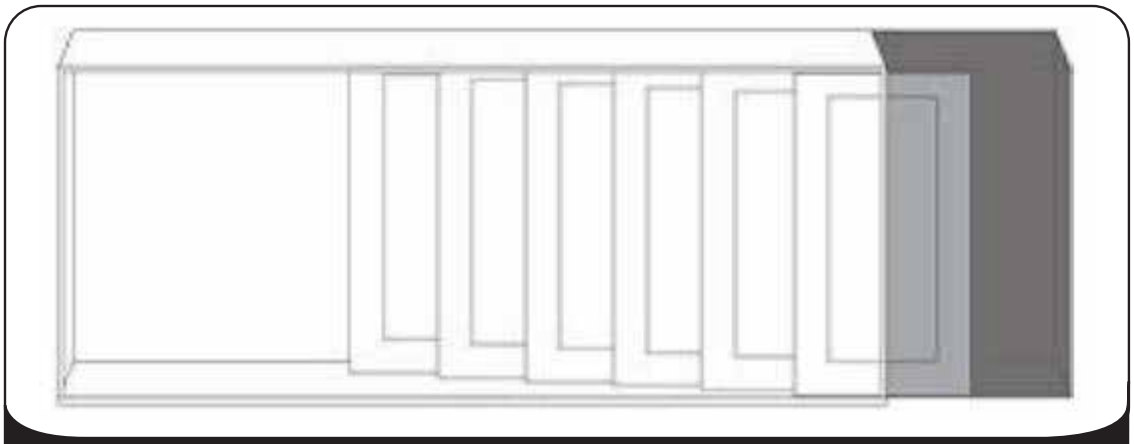
Multi-Slide

250 Series (Premium) | 3750 Series



Bifold Door

250 Series (Premium) | 3750 Series



Pocket Multi-Slide

250 Series (Premium) | 3750 Series

April 2023:

- Win-Dor offering integrated into 250 Series brand.
- For customer service-related questions, please contact Pella Customer Service. PMB #18-2023

December 2023:

- All Pella 250 Series Standard and Premium Door products will transition from Painted Bronze to Brown Laminate. This change will allow the exterior color to match the Brown Laminate currently offered on Pella 250 Series products. As a reminder the Black Laminate already matches across the full 250 Series Portfolio.
- All service parts for Painted Bronze will be available except for full units. If service is needed, please follow the existing Win-Dor service process. PMB #53-2023

April 2024:

All Pella 250 Series

- Standard and Premium Door products transitioned from Brushed Chrome hardware to Satin Nickel.
- This change allows the hardware color to match the Satin Nickel currently offered on Classic Pella.
- 250 Series products. PMB #24-2024

May 2024:

- Officially branded as Pella 250 Standard. PMB #33-2024

250 SERIES VINYL (PREMIUM) – WIN-DOR 3750 SERIES PRODUCT HISTORY

Hinged Door

04/2023 – 05/2024

Back to TOC



Hinged Door

250 Series (Premium) | 3750 Series

April 2023:

- Win-Dor offering integrated into 250 Series brand.
- For customer service-related questions, please contact Pella Customer Service. PMB #18-2023

December 2023:

- All Pella 250 Series Standard and Premium Door products will transition from Painted Bronze to Brown Laminate. This change will allow the exterior color to match the Brown Laminate currently offered on Pella 250 Series products. As a reminder the Black Laminate already matches across the full 250 Series Portfolio.
- All service parts for Painted Bronze will be available except for full units. PMB #53-2023

February 2024:

- Addition of optional Hinge Door Sidelights and Transoms to complement Out-swing or In-swing, 1 or 2 panel hinge doors.
- Configured units will come with Factory Assembled frames and Factory Tight Mulls. PMB #14-2024

May 2024:

- Officially branded as Pella 250 Standard. PMB #33-2024

June 2025:

- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

PMB #39-2025



Bifold Window

250 Series Standard

May 2024:

- Officially branded as Pella 250 Standard. PMB #33-2024

June 2025:

- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

PMB #39-2025

250 SERIES VINYL (STANDARD) PRODUCT HISTORY

Hinged Door

2024 – Current

Back to TOC

May 2024:

- Officially branded as Pella 250 Standard. PMB #33-2024

June 2025:

- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

PMB #39-2025

250 SERIES VINYL (STANDARD) PRODUCT HISTORY

Multi-Panel Door

2024 – Current

Back to TOC



Multi-Slide

250 Series Standard

May 2024:

- Officially branded as Pella 250 Standard. PMB #33-2024

June 2025:

- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

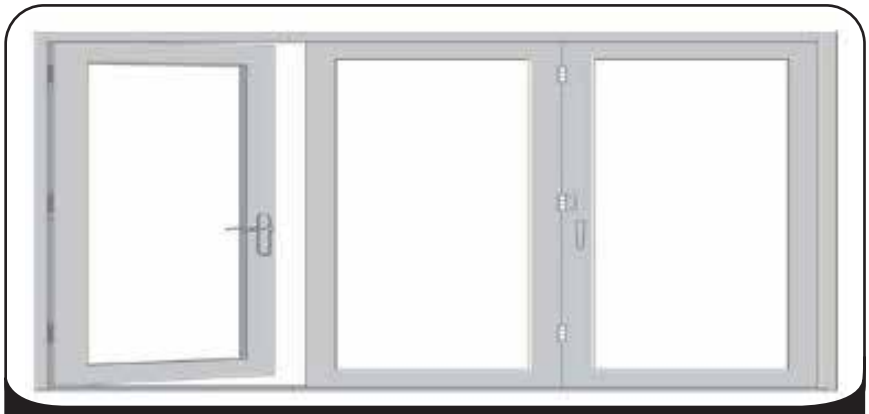
PMB #39-2025

250 SERIES VINYL (PREMIUM) PRODUCT HISTORY

Folding Window

2024 – Current

Back to TOC



Bifold Window

250 Series Premium

May 2024:

- Officially branded as Pella 250 Premium. PMB #33-2024

June 2025:

- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

PMB #39-2025

May 2024:

- Officially branded as Pella 250 Premium. PMB #33-2024

June 2025:

- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

PMB #39-2025

250 SERIES VINYL (PREMIUM) PRODUCT HISTORY

Multi-Panel Door

2024 – Current

Back to TOC



Multi-Slide
250 Series Premium



Pocket Multi-Slide
250 Series Premium

May 2024:

- Officially branded as Pella 250 Premium. PMB #33-2024

June 2025:

- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

PMB #39-2025



Bifold Door

250 Series Premium

May 2024:

- Officially branded as Pella 250 Premium. PMB #33-2024

June 2025:

- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

PMB #39-2025

250 SERIES VINYL (PREMIUM) PRODUCT HISTORY

Hinged Door

2024 – Current

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Hinged Door

250 Series Premium

May 2024:

- Officially branded as Pella 250 Premium. PMB #33-2024

June 2025:

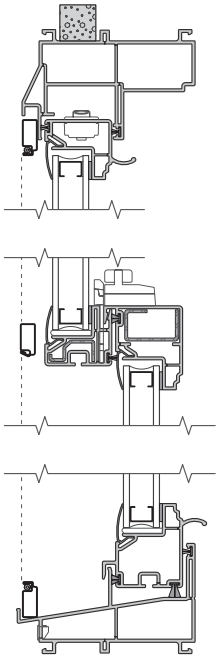
- Transition from an interior / exterior color of Beige to Almond. This change allows the user to match Standard and Premium doors to 250 Series Classic doors or windows, where Almond is already available.
- Black interior color. This addition will allow the Black/Black option.
- Frame Service Items and Sash Panel Service Items requiring the color Beige will continue to be available as service parts.
  In addition, Almond will be added as an available color selection for the same configured service items that are available in Beige.
- Beige and Almond are a close, complementary match to each other, the catalog items such as plugs, screws and other small items, will be used on both Beige and Almond units.

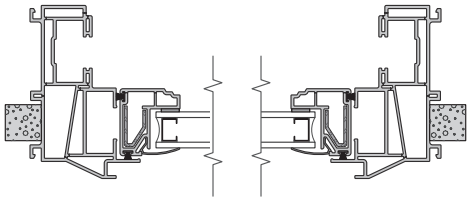
PMB #39-2025

150 SERIES VINYL PRODUCT HISTORY

Double-Hung

Back to TOC





February 2020:

- Introduced as Pella 150 Series in East only. Only available in Block Frame, white, single punch openings; no mulls.
- Differentiated block frame features include: New lock and tilt latch, InView Screen, Balance Pocket Cover, and Perimeter Foam.

May 2020:

- Pella 150 Series is a stock only product for Lowe's only available in the East and offered in a Double-Hung and patio door. The Double-Hung includes a unique lock and tilt latch, perimeter foam, an In-View Screen, and a balance pocket cover. The lock and tilt latch can be serviced through the Pella Catalog, and the screen and balance pocket cover can be serviced through the 150 Series catalog, along with the patio door. The perimeter foam is not serviceable. PMB #28-2020.

November 2020, East only:

- Encompass by Pella, ThermaStar by Pella, and 150 Series have a new cam-action lock. The old cam-action lock will not be vintaged.
- 1" Contour GBG's removed from the offering.
- Full SOS offering is available for 150 Series in all frame types, and white/almond/fossil.
- Nail Fin DH introduced into stock: features include: In-View Screen, Balance Pocket Cover, Upgraded lock and tilt latches.



Perimeter Foam

(Exclusive to block frame double-hung)



Lock

Lock for Encompass, ThermaStar, and 150 in the East. West will keep current lock.

April 2025:

- Removed 150 Series tilt latch cover. Tilt latch now matches Encompass.



July 2025:

- Transitioned to a new constant force balance in Pella® 150 Series East Double and Single-Hung units. Performance values and product certification not impacted by this conversion.
- Transitioned from an open coil balance to a closed coil balance.
- Moving to the closed coil design will require use of a production balance and a (different) modular design service balance. Production balances will be installed in factory-assembled units while modular design service balances will be used for field service applications.
- All Encompass by Pella® East Double and Single-Hung units built after December 2014 will be serviced with the new modular design.
- When servicing a unit with the old design installed, new pivot bars and friction screws designed for the closed coil balance are necessary to install the new design.

PMB #43-2025

November 2020, East only:

- Upgraded lock introduced to Encompass, ThermaStar, and 150 Series. No vintage will be offered on the old lock.

July 2025:

- Transitioned to a new constant force balance in Pella® 150 Series East Double and Single-Hung units. Performance values and product certification not impacted by this conversion.
- Transitioned from an open coil balance to a closed coil balance.
- Moving to the closed coil design will require use of a production balance and a (different) modular design service balance.
- Production balances will be installed in factory-assembled units while modular design service balances will be used for field service applications.
- All Encompass by Pella® East Double and Single-Hung units built after December 2014 will be serviced with the new modular design.
- When servicing a unit with the old design installed, new pivot bars and friction screws designed for the closed coil balance are necessary to install the new design.

PMB #43-2025



Lock

Lock for Encompass, ThermaStar, and 150 in the East. West will keep current lock.

November 2020, East only:

- Upgraded lock introduced to Encompass and ThermaStar. No vintage will be offered on the old lock.



Lock

Lock for Encompass, ThermaStar, and 150 in the East. West will keep current lock.

November 2020, East only:

- 150 Series fixed frame offering introduced.

April 2025:

- Nail fin & nail fin with j-channel no longer offered at 4 3/16".
- Nail fin frame depth to match block frame at 3 1/4" and can add j-channel assembly part if needed.

November 2020, East only:

- 150 Series Radius/Angle Shapes product offering introduced.

February 2020:

- Introduced Pella 150 Series in East only. At time of store roll-out, ThermaStar by Pella patio door in East will be eliminated. Store roll-outs will occur by region and will extend into 2021. No functional design change between ThermaStar by Pella and Pella 150 Series. New packaging was created and BBG coating switched from Clear to Low-E at time of launch. All ThermaStar Clear BBG is serviceable through Pella 150 Series Low-E BBG.

May 2020:

- Pella 150 Series is a stock only product for Lowe's only available in the East and offered in a Double-Hung and patio door. The Double-Hung includes a unique lock and tilt latch, perimeter foam, an In-View Screen, and a balance pocket cover. The lock and tilt latch can be serviced through the Pella Catalog, and the screen and balance pocket cover can be serviced through the 150 Series catalog, along with the patio door. The perimeter foam is not serviceable.
  PMB #28-2020.

March 2021:

- Pella 150 Series stock sliding patio door for Lowe's available in West in stores in Pella branded 150 Series packaging. BBG doors transitioning to Low-E from clear. ThermaStar by Pella sliding patio door eliminated and replaced by this 150 Series door. Service for ThermaStar by Pella doors will continue, complete units not longer available. All ThermaStar clear BBG will be replaced with Low-E BBG. National Accounts-PMB #11-2021.

September 2024:

- A PVB material interlayer now being used in place of SGP interlayer for all 2-Panel OX and XO HVHZ rated Impact Hurricane Shield Sliding Patio Doors (8900 Series only) under 96-in in width and/or 96-in in height and at 60 DP or less. The PVB interlayer meets all the same testing requirements as the SGP interlayer for all affected units.
  PMB #65-2024

November 2024:

- Pella Hurricane Shield Hinged Doors are being suspended due to supplier constraints. This suspension includes one panel
- hinged doors, two panel hinged doors and sidelights for hinged doors. Orders will not be accepted after 10/31/24. The offering will be removed from PQM on 11/5/24.
  PMB #64-2024

PELLA® HURRICANE SHIELD™ SERIES PRODUCT HISTORY

Casement, Awning, Single-Hung, Sliding Window, Direct Set, Sliding Patio Door, Multi-Slide Patio Door, Hinged Door

Back to TOC

April 2020:

- New coastal, impact capable vinyl product line.

This launch was enabled through the recent acquisition of Custom Window Systems. Based in Ocala, Florida, CWS specializes in impact-resistant products that are designed to meet the most stringent requirements for hurricane zones in coastal regions. CWS has been successful in the marketplace in many areas, including:

- A broad, complete offering and certification.
- Advanced technology in their order, manufacturing, and distribution systems.
- Local manufacturing and market expertise.

We have re-branded the CWS WindPact Plus, Storm Strong, and Aria product offerings not only in name, but truly integrated as a part of the Pella offering. This includes Pella Branding (hardware, window cling) and coverage under the Pella warranty.

- Pella Hurricane Shield Series will take the place of the CWS WindPact Plus (8000 Series) offering.
- Staggered releases by market (Florida and other Primary Coastal Markets) to help our team effectively launch and manage the new volume for the Ocala facility. At this time, the markets will receive these products:

April 26, 2020:

- Pella Hurricane Shield Series PQM Release (Florida).
  - Single-Hung
  - Sliding Window
  - Direct Set
  - Sliding Patio Door
- Product Changes (hardware, cling, etc.) live on Pella Hurricane Shield Series and Defender Series orders (through PQM and PrefSuite).

May 13, 2020:

- Pella Hurricane Shield Series PQM Release (Florida and Primary Coastal Markets).
  - Casement
  - Awning
  - Multi-Slide Patio Door
  - Configured Mulls and Grille Alignment.

Additional products will be released in subsequent systems releases through August. PMB #24-2020

May 2021:

- Catalog service parts available in new catalog section of PQM for Pella HurricaneShield and Defender Series products. Search functionality coming at a later date.
  PMB #47-2021

December 2022:

- Pella Hurricane Shield Series Hinged Patio Door added to offering. PMB #05-2023

January 2023:

- Defender Series DH, SW, and FX DH Profile products eliminated. PMB #07-2023

September 2024:

- A PVB material interlayer is being used in place of SGP interlayer for all 2-Panel OX and XO HVHZ rated Impact Hurricane Shield Sliding Patio Doors (8900 Series only) under 96-in in width and/or 96-in in height and at 60 DP or less. The PVB interlayer meets all the same testing requirements as the SGP interlayer for all affected units. PMB #65-2024

October 2024:

- Pella Hurricane Shield Hinged door (1-Panel, 2-panel and sidelights) suspended. PMB #64-2024

November 2024:

- A black IG spacer used in place of current shiny gray spacer for Hurricane Shield and Defender Series Insulated glass units. PMB #71 - 2024

July 2025

- Launched new Hurricane Shield single hinged door in white.
- Fusion-welded panel and frame.
- Adjustable hinges

PMB #47-2025

February 2026:

- All service parts for Legacy Hurricane Shield products (suspended ion October 2024) are no longer available. PMB #14-2026

March 2026

- Pella launched the second phase of the Hurricane Shield Hinge Patio Door project, bringing two key enhancements to the offering:
  1. Introduction of a double door.
  2. Performance grade increase to DP60 on both single and double door products.
- To enable the performance increase to DP60, the handle on both the single and double doors updated to a new design. All orders placed on or after March 17th will feature this new design, as well as three additional finish options including black, satin nickel, and oil rubbed bronze.



Previous Design Handle

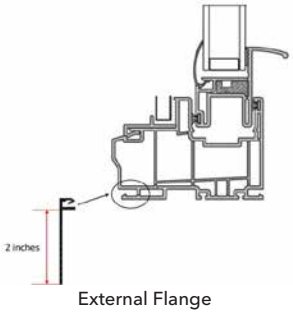


New Design Handle

October 2026

- External Flange will be available as an Exterior Trim option for Pella® Hurricane Shield Series™ and Pella® Defender Series™ complete units. External Flange is available only on Block/Box Frame rectangle units and is not available with any other frame type or on fixed or operable shape units. When the External Flange attribute is selected, the unit will receive four pieces of material cut to length per the unit dimensions. Material is factory supplied and shipped uninstalled with the unit.
- **Please Note** - the External Flange is not an attachment method and must not be used to anchor the unit. Units must be installed in accordance with the applicable FPA instructions before the External Flange material is properly inserted into the frame accessory groove.

PMB #59-2026



External Flange

HARDWARE

VINYL

Lock handle hardware used on Pella® 250 Series casement & awning units updated. This impacted both complete units & replacement sashes with no impact to performance values. White hardware transitioned first with almond & fossil following. PMB #65-2025 (Insert images "Pre-10-2025 CM Lock Lever" & "10-2025-Current CM Lock Lever" and label them as such.)	October 2025
All Pella 250 Series: Standard and Premium Door products transitioned from Brushed Chrome hardware to Satin Nickel. This change allows the hardware color to match the Satin Nickel currently offered on Classic Pella 250 Series products.	April 2024
Encompass by Pella (West only) Auto-Lock Option eliminated from complete units. Auto-Lock will also remain available as a catalog part. Still available in the East. PMB #26-2022	July 2022
250 Series, Endorsed and 150 Series Brass sliding patio door handle eliminated. PMB #81-2021	December 2021
Vinyl West Single-Hung and Sliding Window lock update. Upgraded cam-action lock includes haptic feedback, making a 'click' noise when locked. Current lock will not be vintaged and any order will come with this lock. PMB #15-2021 	February 2021
Vinyl East, new cam-action lock on Single-hung, Double-hung, and sliding windows introduced. Old lock will not be vintaged.	November 2020
Pella 250 Series PSE Exclusive Comfort Lock (auto lock) introduced. May 2020. Only available through Lowe's PSE in the PSE Exclusive Bundle.	May 2020
All patio door hardware - All Key cylinders changed to a Key-Way (Kwikset) cylinder, eliminating current (Schlage) cylinder. PMB #33-2016.	July 2016
Autolock available for 350 Series Double-Hung in white, almond, satin nickel, bright brass and oil rubbed bronze. PMB #02-2013.	December 2012
New Autolock Design for Vinyl (West Only) 20 and 25 Series Single-Hung and Sliding Windows (Standard). Also available as an option on 10 and 20 Series SH and SW. Not interchangeable with previous autolock. PMB #1-2011 	December 2010
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 to be available for 2 years as service part. PMB #27-2010	April 2010
Vinyl West Region only, new autolock on 20 & 25 series Single-Hung and Sliding Window introduced.	September 2005

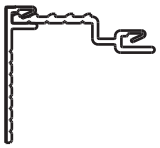
LIMITED OPENING / LIMITED TRAVEL HARDWARE FOR ALL PELLA PRODUCTS VENTING WINDOWS

250 SERIES, 350 SERIES, THERMASTAR BY PELLA (VINYL)

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 250 Series 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 following Brands: 250 Series, 380 Series (field installation only). 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. 250 Series – The WOCD frame bracket from the previous version will remain on the unit. This will not hinder the operation, and will only be visible when the window is open. PMB #43-2020. Rolling Phase-in.	August 2020
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 available as out of unit accessory for all brands of Double-Hung, Single-Hung and Sliding Windows available to meet ASTM F- 2090 Standard. 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. PMB #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.	November 2010
New Fold-down Handle on our Encompass by Pella® Casement and awning products. With this change, we are also adding optional factory applied egress hardware (side pivot hardware) and stainless steel operating hardware to our east offering. Both of these options are already available to our west region	June 2010
Lock Lever – new Casement lock lever design – with a lower profile not to interfere with window treatments.	June 2010
Limited Opening/Limited Travel templates available to order from Medalist Manufacturing for vinyl awnings.	June 2007
Casement (Available as Out-of Unit Accessory).	March 2007
Awning (Available as Out-of Unit Accessory).	March 2007
Sliding Window (Available as Out-of Unit Accessory).	March 2007
Single Hung (Available as Out-of Unit Accessory).	March 2007
Double-Hung (Available as Out-of Unit Accessory).	March 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
Pella® 350 Series – Receptors, Jamb Extension Receptors and Patio Door Frames and the following from the Installation and Trim Linear Accessories Catalog, eliminated Vinyl Head Expander, J-Channel, J-Channel Cover, 5/8" Flange, Head Drip Cap, Block Frame, Head Drip Cap, Nail Fin Eliminated PMB #81-2021	July 2022
Pella® 350 Series Sill Adapters, Head Expanders, Drywall Return eliminated. PMB #81-2021	July 17, 2022
Pella® 350 Series Frame Expanders and Field Mull Kits from Installation and Trim Lineal Accessories catalog. PMB #81-2021	November 2021
Pella® 350 Series Installation and Trim Accessories eliminated.	July 2021
Pella Installation tape available in pallet quantities. PMB #50-2020.	October 2020
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
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
Pella 350 Series 3-1/4" Block Frame Sill Adaptor system redesigned; now a two-piece system using a new Sill Frame Extender and re-purposes existing Frame Expander as new Sill Adaptor. Sill adaptor and Sill Fame Extender May be trimmed as needed on the sloped sill. Applies to Double-Hung, Single-Hung, Sliding Window, Fixed Direct Set Rectangles and Shapes. PMB #10-2013.  **Pre-02/2013 Sill Adaptor**  **02/2013 - Current Sill Adaptor System**	February 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 Encompass by Pella®, Pella® Impervia or Pella® 350 Series. PMB #3-2013. 	January 2013
Translucent silicone sealant added to sealant offering. PMB #48-2012.	September 2012

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ACCESSORIES

INSTALLATION ACCESSORIES

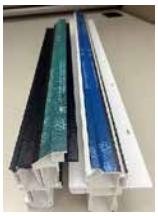
Thirty four (34) casing profiles available in lineal offering available in Ready Trim selections (PDSN only). Available for all 350 Series products and Encompass Entry Doors.	August 2012
Flush flange installation kit available for Impervia® casements, awnings and fixed windows using pocket replacement installation. PMB #31-2012.	May 2012
J-channel assembly part is now available for Encompass & 150 Series Double-Hungs with nail fin frame type.	April 2025
Interior trim/casing offering expanded and casing names revised.	March 2012
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.	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
Vinyl Head Expander and Sill Adapter on 20 Series DH (East Only) are optional rather than standard. PMB #73-2009.	June 2009
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
Vinyl products - Factory applied jamb extensions available for 10 single unit and factory assembled combinations (Excludes Flange Frame and 10 Series Patio door).	April 2006
Vinyl products - Factory applied jamb extensions (for 4-9/16" and 6-9/16" wall depths) available for 25 Series DH with 2-9/16" wall depth and all Casement and Awnings.	January 2006

COLORS AND FINISHES

VINYL (EE) (EW)

Almond color option for Encompass® by Pella complete units eliminated in the West region. Almond-colored Encompass® by Pella complete units (West) no longer available for any segment outside of service and no-charge replacement beginning March 18, 2026. Complete units will be fully removed from service and no-charge replacement effective May 12, 2026. This change applies only to complete units and only within the West region. Service parts will remain available. PMB #11-2026	March 2026
Fossil added as a solid color (extruded) option. PMB #34-2018.	June 2018

250 SERIES VINYL

Pella® 250 Series – Effective immediately, Brick Red, Hartford Green, Morning Sky Gray, Polar White and Portobello will be placed on an extended lead time. On February 17, 2026, these colors will be removed from the PQM system. Black and Brown painted exterior configured service items are still showing demand and therefore will remain in the offering. However, starting immediately any order for Black or Brown painted exterior finishes will be automatically transitioned to laminate. After evaluating the appearance of units containing a mix of laminated and painted components, negligible visuals were noted. On February 17, 2026, the system will begin reflecting laminate exclusively. PMB # 10-2026	February 2026
Eliminated the following exterior touch-up paint colors from the 250 and 350 series offering: Tan, Fossil, Poplar White, Portobello, Morning Sky Gray, Hartford Green and Brick Red. Customers can work with their local Sherwin-Williams store referencing any Pella PR code to achieve a paint match based on their decision of paint quality and type. The Sherwin-Williams store must look up the Pella account prior to searching for the PR code. PMB #05-2024	January 2024
All Pella 250 Series Standard and Premium Door products will transition from Painted Bronze to Brown Laminate. This change will allow the exterior color to match the Brown Laminate currently offered on Pella 250 Series products. As a reminder the Black Laminate already matches across the full 250 Series Portfolio. All service parts for Painted Bronze will be available except for full units. If service is needed, please follow the existing Win-Dor service process. PMB #53-2023	December 2023
For additional protection during the manufacturing and logistics process a protective film is added to the exterior of all laminated products. Remove this film immediately following the installation process. Leaving the film on after the installation process will cause the film to become difficult to remove. The black exterior will come with green film and the brown exterior will come with blue film. PMB #08-2023 	January 2023
Changed the black and brown exterior color solution on Pella 250 Series products from painted to laminated. PMB #01-2023	January 2023
Colors - Hartford Green, Brick Red, Fossil, Portobello, Tan, Morning Sky Gray, and Poplar White eliminated. PMB #8102021	December 2021
Fossil added as a solid color (extruded) option. The painted Fossil option will remain available in Pella 250 Series. PMB #34-2018	June 2018
White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #64-2017	September 2017

350 SERIES VINYL

Pella® 350 Series – Effective immediately, all Black and Brown configured service has been discontinued. PMB #10-2026	February 2026
Eliminated the following exterior touch-up paint colors from the 250 and 350 series offering: Tan, Fossil, Poplar White, Portobello, Morning Sky Gray, Hartford Green and Brick Red. Customers can work with their local Sherwin-Williams store referencing any Pella PR code to achieve a paint match based on their decision of paint quality and type. The Sherwin-Williams store must look up the Pella account prior to searching for the PR code. PMB #05-2024	January 2024
Introduced painted colors of Tan, Brown, Poplar White, Fossil, Hartford Green, Morning Sky Gray, Black, Brick Red, and Portobello which are be dual-colors consisting of a white interior with a colored exterior. PMB #47-2017	July 2017

MULLION

DIRECT AND STRUCTURAL MULLIONS

Integral mull option for 250 Series Direct Set offering eliminated. This integral mull option for direct set units eliminated in favor of the joining and aluminum factory mull options offering higher performance and more configuration flexibility. All configuration options currently available with the integral mull will be available in other mull types after the elimination. PMB #19-2023	May 2023
The naming in PQM for the Pella 250 Series Mull kit utilized with the 5/8" Flange Frame has been updated to "Pella 250 Series 1" Structural Tube Mull Kit" from - "250 Series 1" Structural Mull Kit (Pre 2018)." PMB#31-2022	June 2022
Offering box quantities of pre-finished jamb extensions and mullion covers.	June 2007

GRILLES

Pella® 250 Series: Simulated Divided Light & 1" Contour GBG eliminated. PMB #81-2021	December 2021
6-Lite Prairie Grille Pattern available in SH, DH, SW and Transoms. PMB #24-2016	June 2016
Vinyl radius windows have Prairie and Perimeter GBG grille options available and Sunburst and Starburst offering expanded.	June 2007

SCREENS

Pella® 250 Series Classic Sliding Patio Door Replacement Screen transitioned to the new screen platform used on the new 250 Series Sliding Patio Door. (1st announcement) PMB #44-2026	August 2026
Classic Sliding Patio Door screen no longer available. All replacements transitioned to the Enterprise screen which is used on the new 250 Series platform and can be retrofitted to the Classic door. PMB #30-2026	July 2026
Pella® 250 Series Hidden Screen updates: • SH / DH Sill Clip & Bracket Consolidation • SH / DH Sill Tape Update • SH / DH Bottom Strike Profile Change • SH / SW Bug Blocker Profile Change • Pleat Count Reduction PMB #41-2025	June 2025
Encompass and 150 Series DH half screen eliminated. 04/2025-Current Full screen will have with leaf spring. Pre-04/2025 with plungers and half screen available as service item. PMB # 17-2025	April 2025
Expanded the 250 Series Hidden Screen offering to include laminate Black and Brown exterior colors. This will be available for all product types where Hidden Screen is available (Double Hung, Single Hung, & Sliding Window). Please review the slide on "Color Matching" within the "Hidden Screen Product Knowledge & Sales Training" on Allego for a reference of color matched Hidden Screen components – all other components not listed will be black or gray in color and are not primarily visible to customers. Attached below in this bulletin are examples of each of the three product types with Hidden Screen + Black Laminate Exterior at various angles to assist with setting customer expectations. PMB #15-2024	February 2024
Pella offered a private branded aftermarket Sliding Patio Door Rolscreen, for part of the life span of our 350 Series product line. The aftermarket supplier has stopped making service items for this particular screen design. We are now unable to offer the full suite of configured service items, the following parts are affected: • Rolscreen Tracks • Rolscreen Assembly and Tracks • Rolscreen Assembly • Rolscreen Magnet Set, • Rolscreen Lead Stile with Handle If an issue cannot be resolved with the available service parts, a flat screen + credit for the difference of the cost between a flat screen and a Rolscreen will be the replacement option covered under the screen warranty. For more details see - PMB #16-2023 (Service Parts Catalog Updated 09/20/23.)	March 2023
Pella will begin pre-drilling cord terminal holes for Hidden Screens in all 250 Double-Hung products, including units ordered with a standard screen. Due to the location of the holes on Double-Hung product, the predrilled hoes will not be visible when the sashes are closed. Installation hole plugs can be used to fill these holes if a hidden screen is not present. This will be a running change with every Double-Hung having pre-drilled holes by May 1, 2022. Note: Sliding Window products ordered with a Hidden Screen will already be factory prepped with predrilled holes for the sash hooks. Pella is NOT prepping Sliding Windows not ordered with a Hidden Screen as the prep holes will be exposed on the exterior. No factory prep is necessary on a Single Hung product. PMB#24-2022	May 2022
250 Series Double-Hung, Single-Hung & Sliding Window Hidden Screen introduced for Retail Branches. PMB #07-2022	February 2022
InView screen cloth standard in the Pella 250 Series PSE Exclusive Bundle.	May 2020
InView screen cloth standard on Pella 150 Series Double-Hung.	February 2020
350 Series Sliding Patio Door Rolscreen available for 2-, 3-, and 4-Panel door configurations. (Field-Installed option only) PMB #17-2013.	April 2013
NEW InView™ screen cloth optional on all Pella Impervia windows and doors.	March 2010
New flanged screen design for vinyl casement and awning.	July 2008

BLINDS-BETWEEN-THE-GLASS (BBG)

250 Series; BBG colors Sand, Clay and Silver moon eliminated. PMB #81-2021	December 2021

GLASS

IG, LOW-E, INSULSHIELD

Due to supplier changes, Turtle Glass is being updated for Pella® Hurricane Shield Series™ and Defender Series products. Turtle Glass (Pre Jul 2026) (formerly Turtle Glass Low-E with Cardinal 340) is available only for Configured Service orders (Glass, Sash Only, and Replacement Panels) and must be ordered with Tempered glass. Turtle Glass Low-E remains available for Complete Units and Configured Service and now uses Cardinal 340+ with built-in Neat+™ coating, providing the same solar heat and glare protection. These configurations must include the Insulated Glass Option with Neat. PMB # 35-2026	July 2026
5mm/5mm Bronze Low-E and 4mm/4mm Triple Insulated Glass adjusted to allow Tempered only for Complete Unit and Configured Service within the September 16th PK release. These updates only impacted fixed and venting Pella® 250 Series windows at this time. For replacement application in which 5mm Bronze Annealed or 4mm Triple Annealed was purchased in the original unit and validation does not allow Tempered - a variance request must be submitted. PMB #57-2025	September 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
Bronze, Gray, Blue, Bronze Obscure, Gray Obscure, and Blue Obscure Insulated Glass Options no longer available with Annealed Glass Strength on all coastal products. All tinted glass will continue to be available in combination with a Tempered Glass Strength. PMB #25-2025	April 15, 2025
A black IG spacer used in place of current shiny gray spacer for Hurricane Shield and Defender Series Insulated glass units. PMB #71 - 2024	November 2024
A PVB material interlayer is being used in place of SGP interlayer for all 2-Panel OX and XO HVHZ rated Impact Hurricane Shield Sliding Patio Doors (8900 Series only) under 96-in in width and/or 96-in in height and at 60 DP or less. The PVB interlayer meets all the same testing requirements as the SGP interlayer for all affected units. PMB #65-2024	September 2024
Bronze Low-E eliminated from Complete Unit opening price point vinyl product offering for all products. Bronze Low-E Insulated Glass Options still available as part of configured service items. In addition, it will continue to be offered in 250 Series product lines. PMB#29-2024	May 2024
New glass options; NaturalSun+ and SunDefense+ introduced. PMB #44-2023	October 2023
Replacement Glazing Beads and Replacement Glass (IG) of 350 Series Radius Shapes no longer available. PMB #42-2023	October 2023
AdvancedComfort Low-E Insulating Glass has been added to the Encompass by Pella brand in the West (only in the West). First of several steps being taken within Pella vinyl product lines to prepare for increasingly stringent energy performance requirements, including the Energy Star V7 criteria changing fall of 2023. PMB #24-2023	May 2023
Glass etch will no longer have Pella script logo on all vinyl brands and products. PMB #11-2023	March 2023
250 Series Vent Double-Hung Glazing Performance Updates: **Northern:** Vent DH - Advanced Low-E with argon and foam insulation – Must use NaturalSun w/Argon and foam insulation to meet ENERGY STAR in the future. **North Central & South Central:** Vent DH - Sun Defense Low-E with air and foam insulation – Must use SunDefense w/ Argon and foam insulation to meet ENERGY STAR in the future. PMB #09-2023	February 2023
Encompass by Pella (West Only) - Bronze Low-E Insulated Glass Option eliminated from complete units. Still available in the East. PMB# 26-2022	July 2022
High Altitude removed from 250 Series offering in the East Only. Service will continue to be offered for replacements, however full units will no longer be available. PMB #46-2020.	September 2020
Introduced for 250 Series vinyl products an option for 5mm/3mm sound glazing. Service Parts; A vintage question for 250 casements will be asked to determine if the original insulated glass overall thickness was 3mm/5mm or 5mm/3mm. The applicable service replacement parts will then be provided. PMB #20-2020.	April 2020
Pella Branded Glass and Window Cleaner discontinued.	January 2020
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

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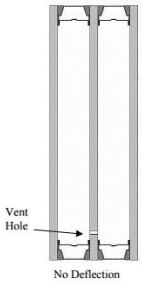
GLASS

IG, LOW-E, INSULSHIELD

Tempered bottom sash only option available in Encompass Double-Hung. — July 2016

Different glass strengths available within a composite or combination. PMB #24-2016 and #44-2016. — June 2016

Triple pane Pella® 250 Series and Pella® 350 Series units now have a small vent hole inserted in the corner of the center pane of glass. This vent in the center pane will allow equalization of pressure between the two airspaces, resulting in minimal deflection of the center pane and less stress on the edge seals. This change is aesthetically minimal and will not affect energy or sound performance. The laser cut hole will be located 1" from actual glass edges in the same corner as the Pella etch. On annealed units, the small hole will be 1mm in diameter. On tempered units, the diameter will be 3.2mm. PMB #32-2015. Running change.



June 2015 - December 2015

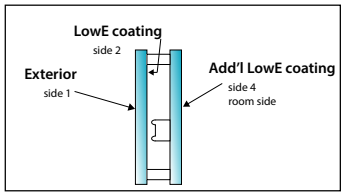
NaturalSun Low-E glass style to added Encompass by Pella product line. PMB #37-2014. — August 2014

Encompass by Pella Bronze Low-E Insulated Glass Option eliminated from complete units. PMB #26-2022 — July 2022

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.



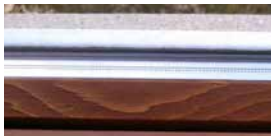
High Altitude removed from 250 Series offering in the East Only. Service will continue to be offered for replacements, however full units will no longer be available. PMB #46-2020. — September 2020

Double Strength 3mm/3mm glass standard in the Pella 250 Series PSE Exclusive Bundle. — May 2020

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®, and Pella® 350 Series products.





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

Pella Glass & Window Cleaner introduced.
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.



November 2013

Non-impact laminated glazing added to Pella 350 Series - Casement and Awning, Single-Hung, Direct Set Rectangles & Shapes. Non-impact laminated glass options are annealed or tempered laminated dual IG, and will increase the STC rating. PMB #01-2013. — December 2012

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GLASS

IG, LOW-E, INSULSHIELD

HurricaneShield Impact-resistant glazing added for 350 Series- Casement and Awning, Single-Hung, Fixed Frame Direct Set Rectangles and Shapes. 1" Dual IG w/ Low-E options. PMB #01-2013.	December 2012
Standard Low-E insulating glass eliminated as standard glazing option.	February 2010
NaturalSun Low-E introduced.	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 Encompass by Pella® and ThermaStar by Pella® products. PMB #109-2009.	October 27, 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™ (Vinyl East) introduced and Expanded High Performance Glazing (Vinyl West) offering to all series and all product types. **SunDefense™ Low-E:** Cardinal's Low-E 366 has 1 coating stack made up of 3 silver layers. **SunDefense™ Dual Low-E:** This Dual Low-E glass has the same coating stack as standard SunDefense™ Low-E IG (described above), plus an additional durable Low-E (room-side) made up of an additional single layer of tin oxide in the coating stack. The combination of these two coating stacks results in the Dual Low-E. PMB #36-2009.	April 16, 2009
West Region Only - Rain pattern - Obscure glass pattern now available all series and product types. PMB #13-2009.	January 2009