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INSTALLATION INSTRUCTIONS FOR FRAME EXPANDER AND RECEPTOR

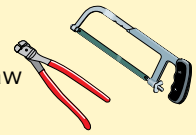
Install the window unit(s) per respective installation instructions. This instruction may be used for window replacement applications in typical siding or brick veneer construction. When using the frame expander system with your Pella windows, the exterior edge of the new window frame must be FLUSH with the exterior face of your existing trim and/or blocking. If it is not flush, either the window or the trim needs to be reworked to accomplish this for proper installation of the frame expander and receptor system.

YOU WILL NEED TO SUPPLY:

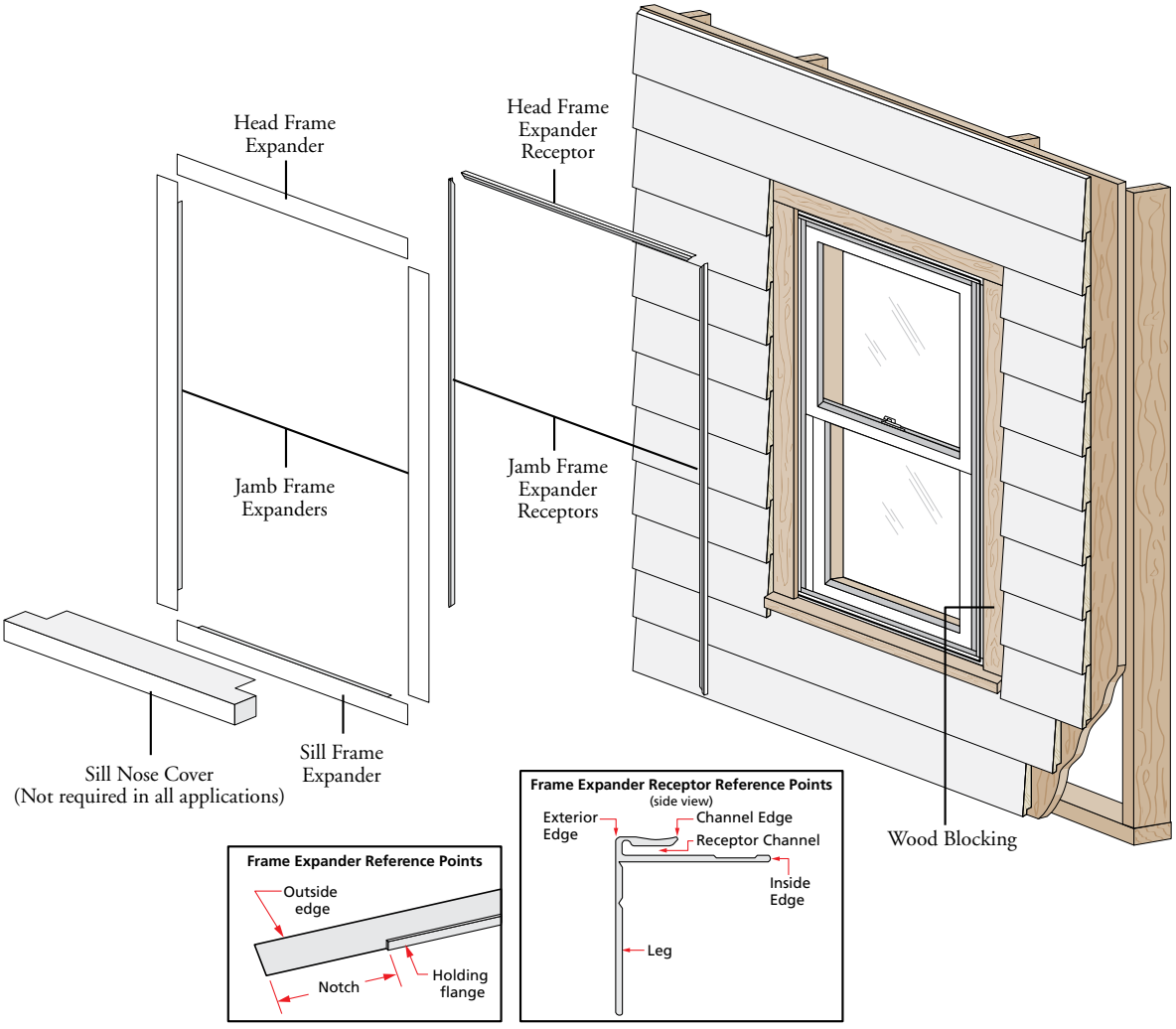
- High quality exterior grade polyurethane or silicone sealant 

- No. 5 and No. 7 galvanized box nails
  (Stainless steel nails are required when using treated wood)
- Frame expanders
- Frame expander receptors
- Sill nose cover (optional)

TOOLS REQUIRED:

- Tape measure 
- Hammer 
- Tin snips 
- Corner notching tool or hacksaw 
- Needle nose pliers 

REMEMBER TO USE APPROPRIATE PERSONAL PROTECTIVE EQUIPMENT.
Pella recommends that you have someone there to assist you with the installation.



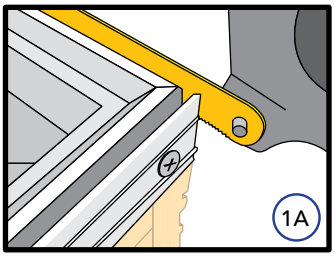
Always read the Pella® Limited Warranty before purchasing or installing Pella products. By installing this product, you are acknowledging that this Limited Warranty is part of the terms of the sale. Failure to comply with all Pella installation and maintenance instructions may void your Pella product warranty. See written Limited Warranty for details, including exceptions and limitations at pella.com/warranty, or contact Pella Customer Service at 877-473-5527.

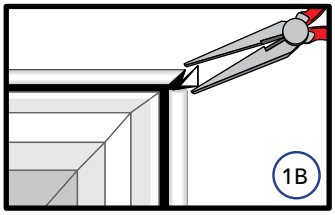
1 CORNER NOTCHING (if required):

Note: When installing combinations of products into one opening, notch the corner of theproducts at the mullion joints to allow the holding flange to be attached as one continuous piece. If notching is not required, proceed to Step 2.

A. **Determine which corners require notching** and align the saw blade with the adjoining groove. Cut through the corner of the accessory groove. DO NOT cut deeper than the accessory groove.

B. **Bend off the cut corner** using needle nose pliers.





2 SILL NOSE COVER (if required):

Note: In certain situations where an existing sill nose will remain, a sill nose cover must be installed. If a sill nose cover is not required, proceed to Step 3.

A. **Cut the sill nose cover** 2-1/2" longer than the existing sill nose and notch to fit the existing exterior jamb trim or blocking. (Notch equals exterior jamb trim or blocking width plus 1-1/4".)

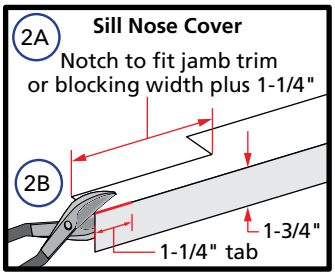
Note: Make sure that the sill nose cover extends as far as possible under the bottom of the window. If the existing wood sill is more than 1-3/4" thick, it must be reworked by removing the wood on the bottom edge to reduce the thickness to 1-3/4".

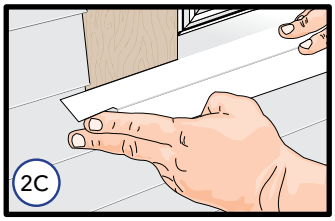
B. **Make tabs on each end of the sill nose cover** by cutting the seam approximately 1-1/4".

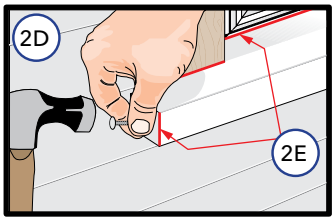
C. **Place the sill nose cover over the existing sill.** Fold the front tab in first, then fold the top tab down, covering the front tab.

D. **Nail the sill nose cover in place** by driving one No. 5 galvanized box nail at each end and one every 12" on the top inside edge.

E. **Apply a continuous bead of sealant** along the top inside edge and ends of the sill nose cover.







3 FRAME EXPANDER RECEPTOR (if desired):

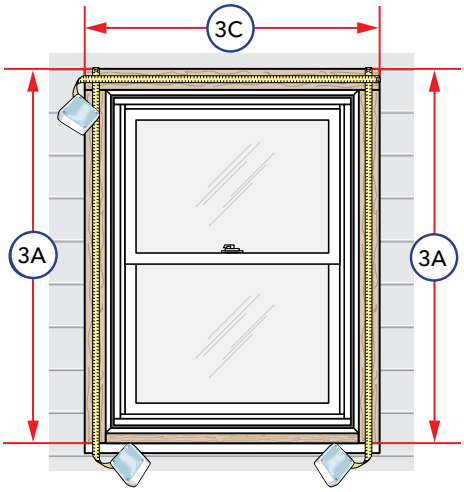
Note: Installation where the leg on the frame expander receptor interferes with the existing trim or brick, will require removal of the leg. Bend the leg back and forth until it breaks off.

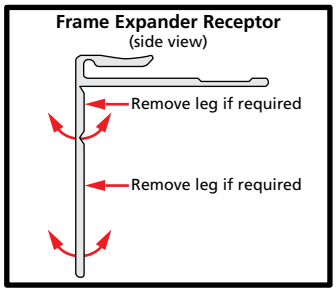
A. **Measure and cut the receptors for the jambs** to length and miter (45°) the top ends.

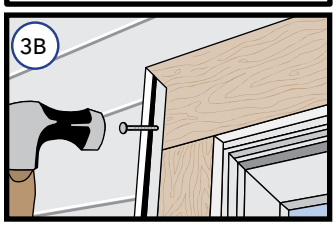
B. **Install both jamb receptors** to the exterior trim or blocking. Align the exterior edge and attach with No. 7 galvanized box nails. Nails should be placed 2" from each end and not more than 12" on center.

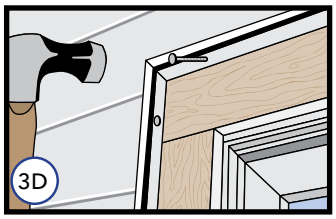
C. **Measure and cut the receptor** for the head to length and miter (45°) both ends.

D. **Install the head receptor** to the exterior trim or blocking. Align the exterior edge and attach with No. 7 galvanized box nails. Nails should be placed 2" from each end and not more than 12" on center.





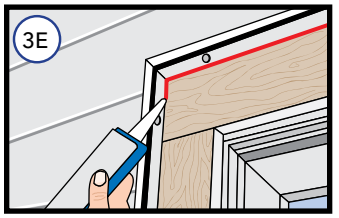




3 FRAME EXPANDER RECEPTOR (continued):

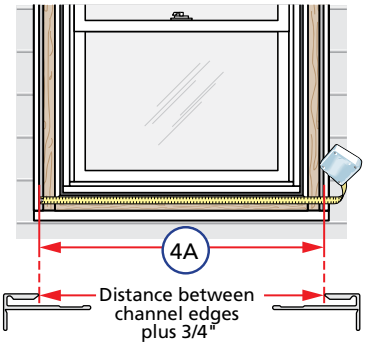
E. **Apply a continuous 1/4" bead of sealant** on the inside edge of the receptor to the exterior trim or blocking.

Note: Follow sealant manufacturer's recommendation for specific applications.



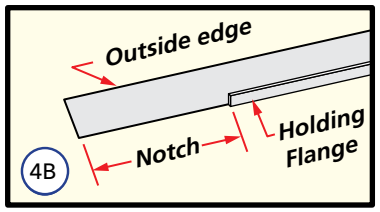
4 FRAME EXPANDER:

A. **Measure and cut the frame expander for the sill to length.** (Length equals distance between the channel edges on the frame expander receptors at the jambs plus 3/4" for the depth of the receptor channels.)



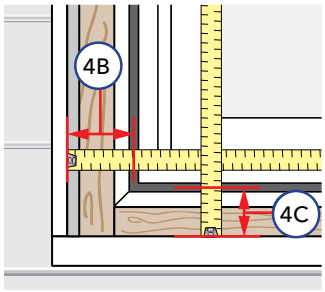
B. **Notch the holding flange** back on each end as required to avoid interference with the blocking at the jambs. (Notch equals distance from the channel edge on the jamb frame expander receptor to the center of the accessory groove plus 3/8".)

Note: If frame expanders were factory notched, the notch typically needs to be lengthened. Factory notches are left slightly short to accommodate frame and combination tolerances.

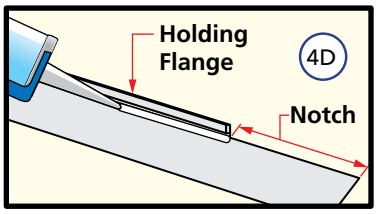


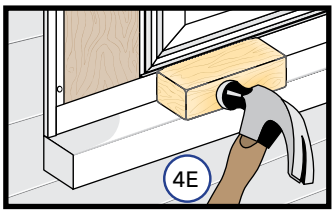
C. **Measure and cut the outside edge of the frame expander** to height as required to fit the sill. (Height equals distance from top of sill to the center of the sill accessory groove.)

Note: If the height dimensions are not equal at each end, make sure the expander is cut so it will fit properly when installed.



D. **Apply a continuous bead of sealant** on the inside holding flange of the sill frame expander.



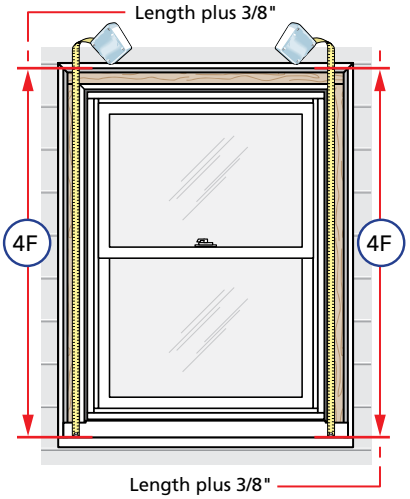


E. **Install the sill frame expander** by tapping it into position using a hammer and soft wood block with rounded edges.

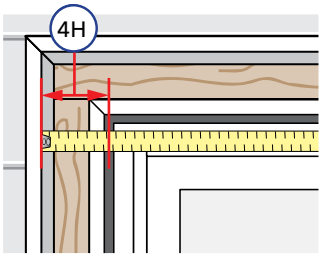
Note: You may need to slightly bow the frame expander to get both ends into the receptors. Once the frame expander is locked into the accessory groove it cannot be removed.

F. **Measure and cut the frame expanders** for the jambs to length. (Length equals distances from top of sill to the channel edge on the head frame expander receptor plus 3/8".)

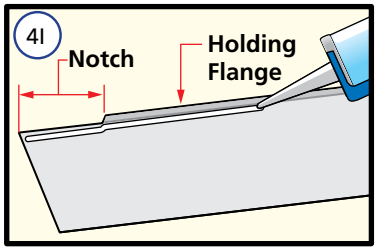
G. **Notch the holding flange back** as required to avoid any interference with the sill frame expander and blocking at the head. (Top notch equals distance from the channel edge on the head frame expander receptor to the center of the head accessory groove plus 3/8". Bottom notch equals distance from top of sill to center of the sill accessory groove.)



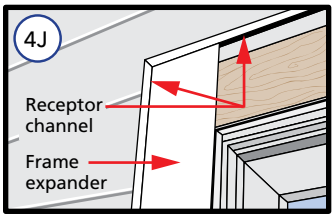
H. **Measure and cut the outside edge** of the frame expander to width as required to fit the jambs. (Width equals distance from the jamb channel edge on the jamb frame expander receptor to the center of the jamb accessory groove plus 3/8".)



I. **Apply a continuous bead of sealant** on the inside holding flange of the jamb frame expander and across the relief cut at the sill end.



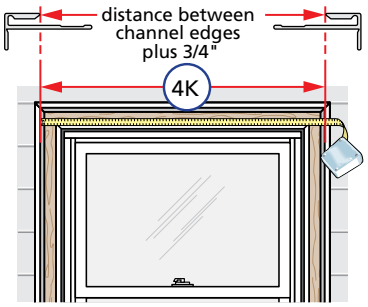
4 FRAME EXPANDER (continued):



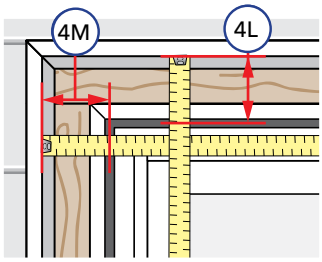
J. **Install the frame expanders on the jambs.** Slide the outside edge of the frame expander into the frame expander receptor. Tap it into position using a hammer and a soft wood block with rounded edges.

K. **Measure and cut the head frame expander to length.** (Length equals distance between the channel edges on the frame expander receptors at the jambs, plus 3/4" for the depth of the receptor channels.)

L. **Measure and cut the outside edge of the head frame expander** to height as required to fit the head. (Height equals distance from channel edge on the head frame expander receptor to the center of the head accessory groove plus 3/8".)

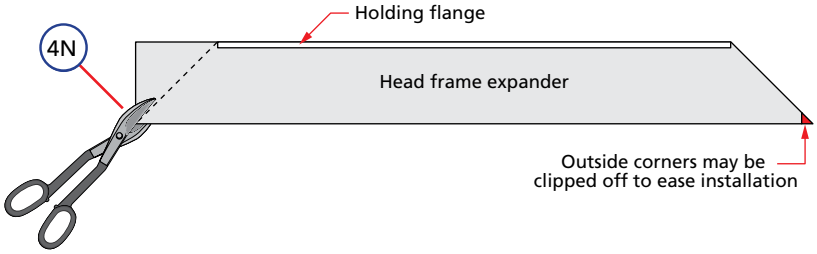


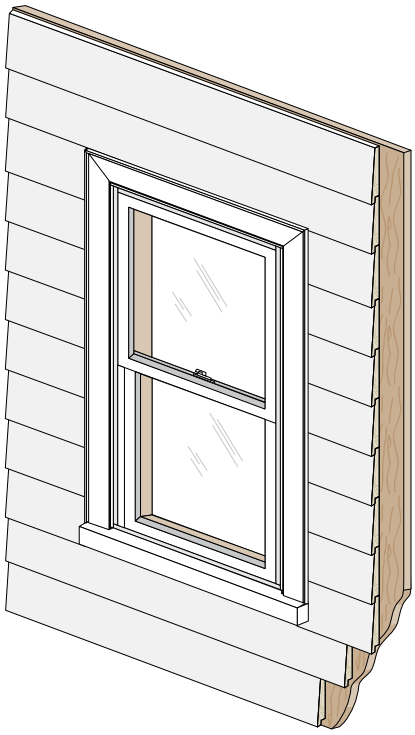
M. **Notch the holding flange back** on each end as required to avoid interference with the frame expander at the jambs. (Notch equals distance from the channel edge on the jamb frame expander receptor to the center of the accessory groove plus 3/8".)



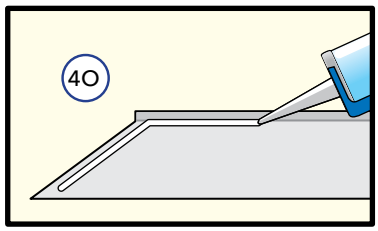
N. **Angle each end of the head frame expander.** Cut from the top corner to the edge of the holding flange on each end. These angles will give the appearance of mitered corners.

Note: The outside corner of the head frame expander may be clipped off to ease installation into the receptor.





O. **Apply a continuous bead of sealant** on the inside holding flange of the head frame expander and across the angled cut on each end.



P. **Install the head frame expander** by sliding the outside edge of the frame expander into the head frame expander receptor. Tap it into position using a hammer and a soft wood block with rounded edges.

NOTE

Because all construction must anticipate some water infiltration, it is important that the wall system be designed and constructed to properly manage moisture. Pella Corporation is not responsible for claims or damages caused by unanticipated water infiltration; deficiencies in building design, construction and maintenance; failure to install Pella products in accordance with these instructions; or the use of Pella products in systems which do not allow for proper management of moisture within the wall systems. The determination of the suitability of all building components, including the use of Pella products, as well as the design and installation of flashing and sealing systems are the responsibility of you, your architect, or a construction professional. Moisture problems, including unacceptable water infiltration, have been associated with barrier systems, such as EIFS (also known as synthetic stucco). Pella products should not be used in barrier EIFS systems unless Pella's current, recommended installation procedures for installation of windows and doors into EIFS are used. Any other use of Pella products with barrier EIFS systems will void the Limited Warranty.

Product modifications that are not approved by Pella Corporation will void the Limited Warranty.