



INSTALLATION INSTRUCTIONS IMPERVIA® SLIDING PATIO DOOR HORIZONTAL AND VERTICAL MULLION ASSEMBLY

YOU WILL NEED TO SUPPLY:

- Pella Window and Door Installation Sealant or equivalent high quality, multi-purpose sealant (2 to 3 tubes per door)

FOR MULLION APPLICATIONS:

- I bar joining connector 
- Pella silicone foam tape 
- Mullion end plug (2)
- Field applied fins (4 pcs. per unit)
- Head drip fin (Vertical Mullion applications only)
- Optional jamb extension (horizontal mullion only)
- Optional interior Mull Cover (horizontal mullion only)



TOOLS REQUIRED:

- Sealant gun 
- #2 Phillips Screwdrivers 
- Rubber mallet 

Installation will require two or more persons for safety reasons.

REMEMBER TO USE APPROPRIATE PERSONAL PROTECTIVE EQUIPMENT

1 MULLION ASSEMBLY:

HORIZONTAL MULLION ASSEMBLY:

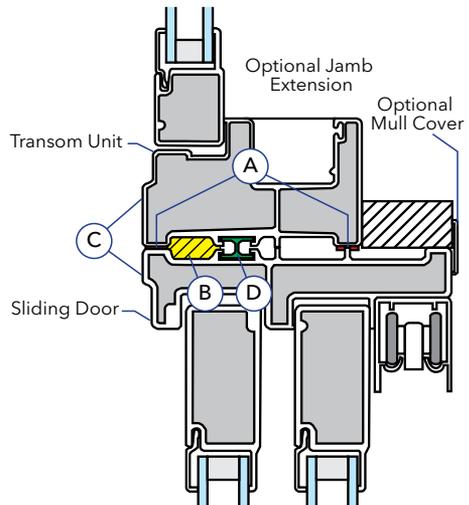
- A. **Apply two strips of foam tape** across the bottom of the transom frame.

Note: The tape must extend the full width of the transom frame.

- B. **Place a foam plug at each end of the top** between the exterior rib and the joining mullion groove.
- C. **Position and align** the transom with the sliding door.
- D. **Start the I bar joining connector** from one end and drive it to the full width of the units.

Note: A rubber mallet may be used to drive the I bar joining connector into position. If necessary, the I bar joining connector can be cut in half and driven from each end.

- E. **(Block Install Only):** Apply sealant to the ends of the mullion joint. The bead of sealant should extend from the center of the mullion joint to the exterior of the unit, covering the foam plug.

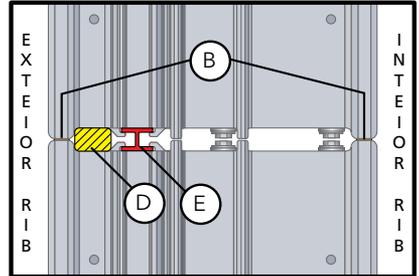


Always read the Pella Impervia Limited Warranty before purchasing or installing Pella Impervia products. By installing this product, you are acknowledging that this Limited Warranty is part of the terms of the sale. Failure to comply with all Pella Impervia installation and maintenance instructions may void your Pella Impervia product warranty. See Limited Warranty for complete details on <http://warranty.pellaimpervia.com>.

1 MULLION ASSEMBLY (CONTINUED):

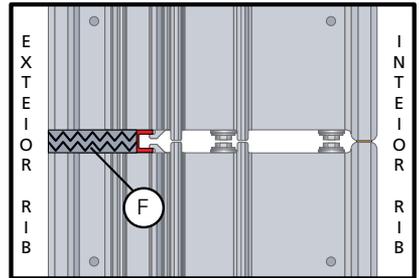
VERTICAL MULLION ASSEMBLY:

- A. **Lay the units on a smooth clean surface**, exterior side up to perform these steps.
- B. **Apply two strips of foam tape** down the fixed door frame sides. Place one strip on the interior rib and one strip on the exterior rib.
- C. **Position and align** the sliding door with the fixed door.
- D. **Place a foam plug at the top and bottom** between the exterior rib and the joining mullion groove.
- E. **Start the I bar joining connector** from one end and drive it to the full height of the doors.

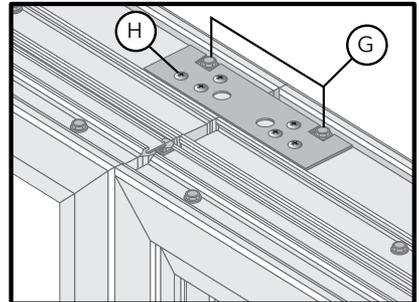


Note: A rubber mallet may be used to drive the I bar joining connector into position.

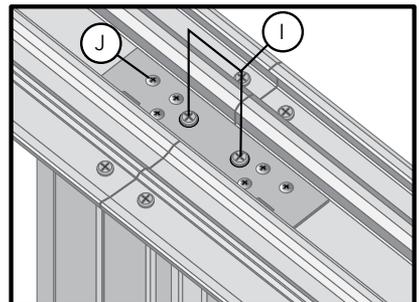
- F. **Apply a bead of sealant, covering the mullion joint** from the center of the I bar joining connector to the exterior. For Block Install - apply sealant at the head only.



- G. **Apply a reinforcement plate at the head** using the square notches to align the plate to the head frame screws in the 1-1/2" wide flat groove to the interior side of the frame.
- H. **Secure the plate** with #8 x 1" pan head sheet metal screws, using three screws per door head.



- I. **Align the reinforcement plate at the sill** using the center 3/8"W diameter holes to align the plate to the sill frame screws in the 1-1/2" wide flat groove.
- J. **Secure the plate** with #8 x 1" pan head sheet metal screws, using three screws per door sill.

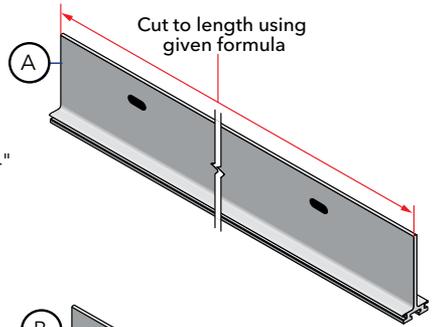


Block install; Assembly is complete.
Fin Install; Proceed to step 2.

2 APPLYING INSTALLATION FINS:

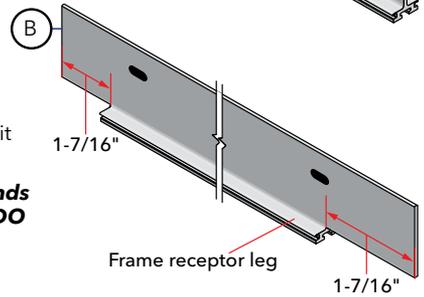
- A. **Cut the fins to length.** Using the following formula, cut the fins to length, making sure the end cut is square on both ends.

Heads: Length = Combination width + 2-1/2"
Jams: Length = Combination height + 1-1/4"



- B. **Notch the ends of the fins.** Measure and mark 1-7/16" from each end of the fins. Using a hacksaw, cut the fin receptor leg at the mark. Finish removing the bottom receptor legs by scoring the fin with a utility knife and snapping it off the fin.

Note: When using fins on all four sides, all ends must be notched. If no fin is used at the sill, DO NOT notch the bottom of the jamb fins.

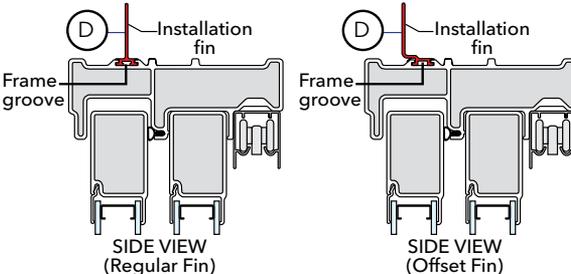
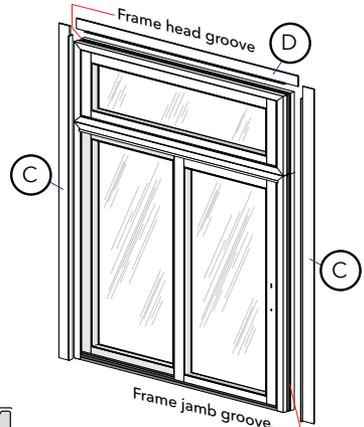


- C. **Install the two side fins** into the top of the frame jamb grooves located on the side frame members of the door. Slide the fins into place.

Note: Spray a solution of water and soap on the frame jamb grooves to reduce sliding friction.

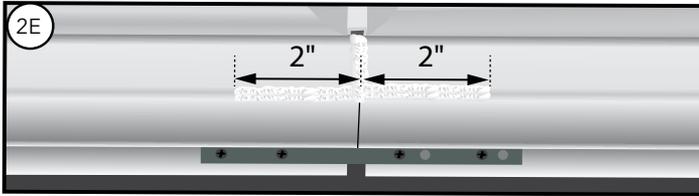
- D. **Install and slide the top fin** into the frame head groove located in the top frame member.

Note: The top fin must overlap the exterior of the side fins.



2 APPLYING INSTALLATION FINS (CONTINUED):

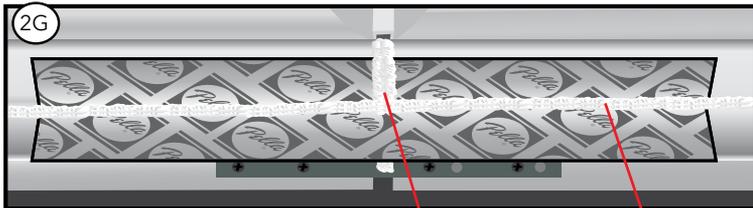
- E. **(For Fin Units only)** Apply sealant at the mullion ends from the exterior face of the unit back to the fin and 2" both directions along the fin on the interior and exterior side of the fin, as shown in the Horizontal Mullion step 1E.



- F. **(For Fin Units only)** Apply tape over the sealant, set back 1/4" from the exterior face.

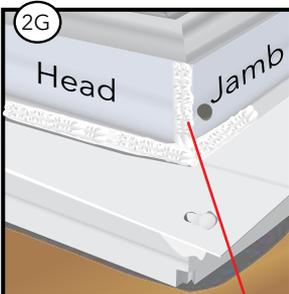


- G. **Apply sealant at the top of the exterior mullion cover** to seal the space between the mullion cover and window frame heads. Also apply sealant at each end of the top of the combination and across the top of the entire combination at the joint where the fin and frame connect to prep for installation of the head drip fin. Install the drip fin immediately after applying sealant to the head either in the shop or at the job site when installing the combination unit in the opening. Apply a piece of flashing tape at each end overlapping the head drip fin and nailing fin to hold the fin in place while the sealant sets up.

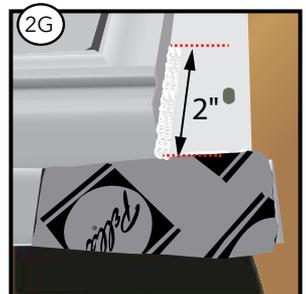
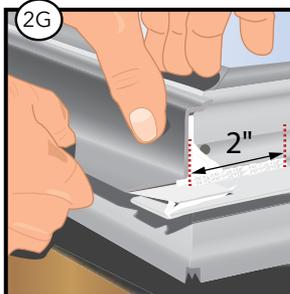


Sealant at mullion joint and across the top of the combination

Sealant in corner across the top of the combination



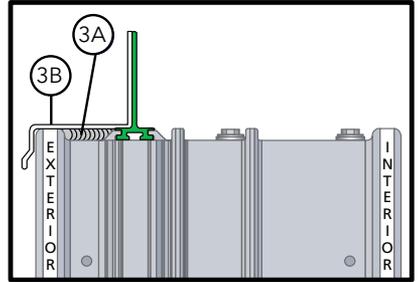
Sealant at each end and across the top of the combination.



3 APPLYING HEAD DRIP FIN - REQUIRED FOR VERTICAL MULLION APPLICATIONS:

- A. **Apply a bead of sealant** along the whole width of the mulled composite behind the exterior rib.
- B. **On vertical mulls, cut the head drip to the width of the units.** Attach the head drip to the top of units aligning the ends and seal to the frame on both ends.

Note: The head drip may either be riveted to the fin or installed when the unit is installed. If the head drip is being installed with the unit, perform Step A at this time.



- C. **Apply a piece of flashing tape** at each end overlapping the head drip fin and nailing fin to hold the fin in place while the sealant sets up.

