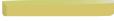




# FLUSH FLANGE ACCESSORY INSTALLATION – FOR ALL PELLA® WINDOWS AND DOORS WITH EXTERIOR ACCESSORY GROOVES

## MATERIAL REQUIRED:

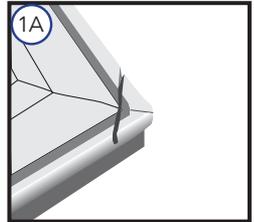
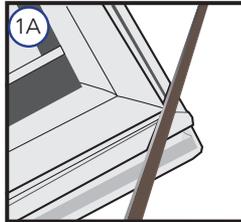
- Installation fin corners 
- Sealant 
- Gasket (Lineal Length)
- Flange (Lineal Length)
- Wood block with rounded ends 

## TOOLS REQUIRED:

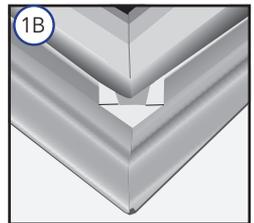
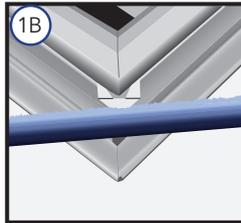
- Tape measure 
- Hammer 
- Hacksaw (metal cutting) 
- Pliers 
- Sealant gun 
- Putty knife 
- Utility knife 
- Power shears 
- Chop saw 
- Table saw 

# 1 Window Preparation

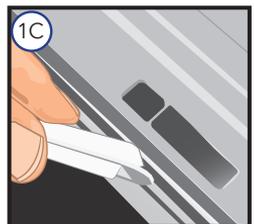
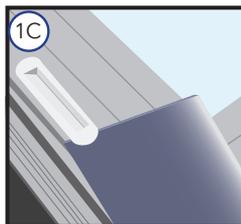
- A. **Notch each frame corner** by cutting through the outer accessory groove legs at a 45° angle with a hack saw. **DO NOT** Cut into the inner accessory groove wall or cut deeper than the accessory groove.



- B. **Cut through and remove outer accessory groove legs.** Turn the hack saw 90° and cut the outer accessory groove legs to remove them. **DO NOT** Cut into the inner wall of the accessory groove.



- C. **Remove weep covers.** If the unit has weep covers, it may be necessary to remove the weep covers and set them aside to be re-installed after the flange is installed.

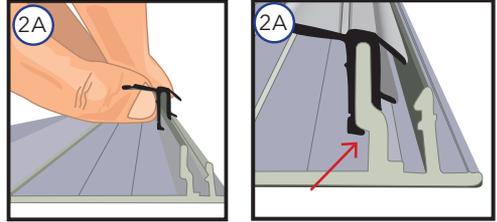


**Note:** If weep slots exist inside the accessory groove of the frame, notch the flange around the weep slot before completing Step 5.

**Note:** If windows or doors are to be mullied/joined together, complete the mulling process at this time.

# 2 Flush Flange Accessory Preparation

A. **Install gasket on flange.** The leaf on the gasket should point in the same direction as the flange. When the gasket is fully engaged, it will fit over the flange leg as shown. (2A)

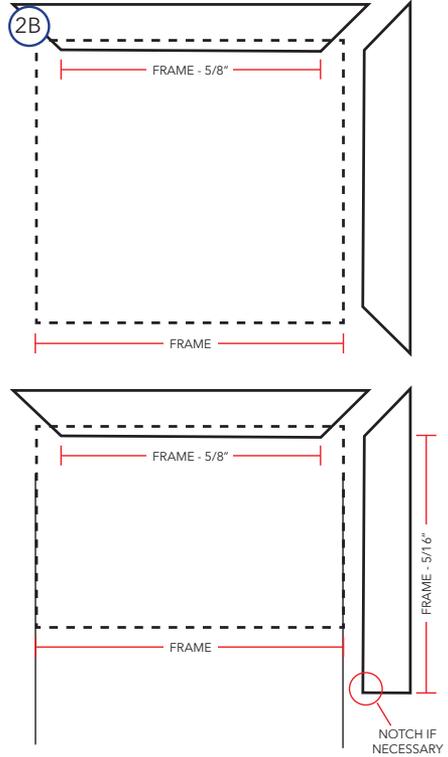


B. **Cut flanges to length.**

**Windows and Doors with accessory grooves on all four (4) sides:** Cut flanges (with gaskets installed) with 45° mitered corners. Cut the inner length of the flanges equal to the frame dimension minus 5/8".

**Doors with accessory grooves on three (3) sides:** Measure the door frame width, cut a flange for the head (with gaskets installed) with 45° mitered corners. Cut the inner length of the flanges equal to the frame dimension minus 5/8".

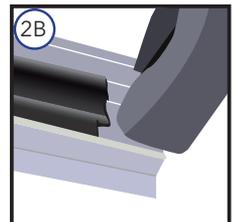
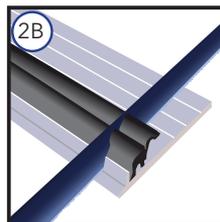
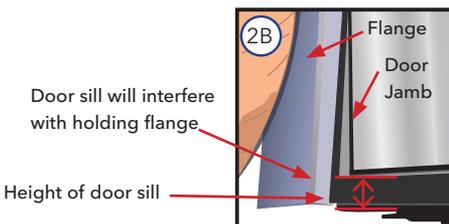
Measure the door frame height, cut flanges for each jamb with 45° mitered corners. At the top only; cut the inner length to the frame dimension minus 5/16".



Where the flange meets the door sill remove a portion of the holding flange that will interfere with the door sill.

Measure the height of the door sill at the exterior. Measure from the bottom of the sill to the end of the jamb accessory groove, this is the dimension to cut. Using a hacksaw or other cutting tool, cut through the holding flanges to the back of the flange.

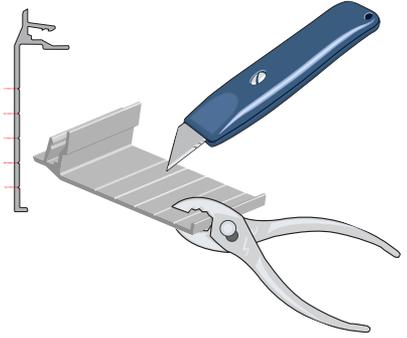
Use pliers to bend and remove the portion of the holding flange that will interfere with the door sill.



# 3 Trim Flush Flanges, if Necessary

If the flange will be installed against a surface that is recessed such as a masonry wall with a recessed wood buck or a stucco wall with a decorative surround, measure to ensure that the total flange width will not be greater in width and height than the inside dimension of the masonry opening or decorative surround.

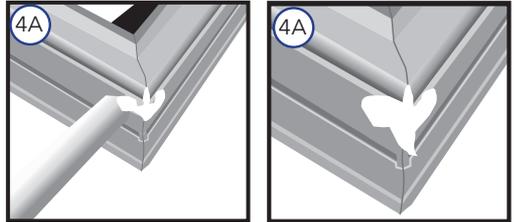
If the flange dimension is too large, remove the extra material by cutting the flange on a table saw or by scoring the back of the flange along one of the 1/4" grooves with a utility knife and removing the material with a pliers. The flange can also be trimmed after it is installed on the window or door (before installed in the opening) using a metal power shears or nibbler.



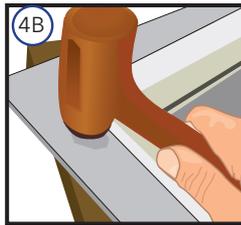
**Note:** remove an equal amount of flange on all sides or ensure the window or door will be centered in the opening to allow for proper installation.

# 4 Install Flush Flanges

A. **Apply Frame Corner Sealant.** With the unit lying on a flat surface with the exterior side up, fill the accessory groove with sealant 3/4" from the corner in each direction. Place additional sealant at the corner notch until the sealant stands off the frame at least 1/8" in both directions.



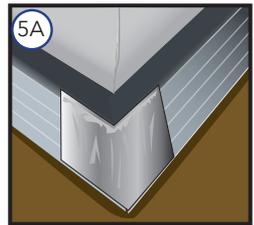
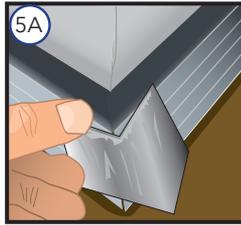
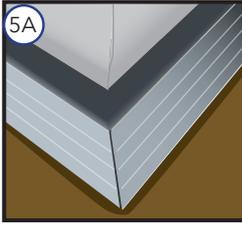
B. **Drive flange into accessory groove.** Start at the corner and press the flange tightly into the corner. Using a rubber mallet or hammer and block of wood with smoothed round edges, drive the flush flange accessory into the unit accessory groove. When the flange is fully engaged, the back of the flange should make contact with the surface of the frame.



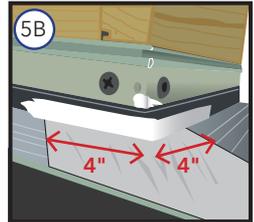
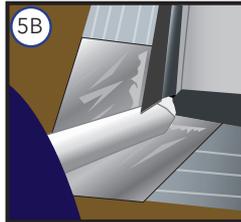
C. **Clean off any excess sealant** squeeze out at the corners.

# 5 Seal Flanges

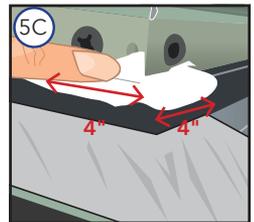
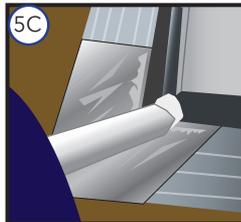
- A. **Apply Flashing tape.** Carefully turn the unit over so (the interior of the unit) back of the flanges are facing up. Apply Pella Smartflash corner seal pieces at each flange joint by removing the backing and placing the corner seal tightly into the corner under the gasket. Press the corner seal tape down firmly starting at the frame and moving outward to the edge of the flange. If the corner seal tape is wider than the flange, trim excess with a utility knife. If the corner seal tape falls short of the outer edge of the flange, add an additional corner seal by starting at the out edge over lapping the first corner seal.



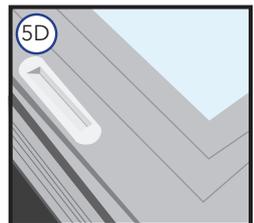
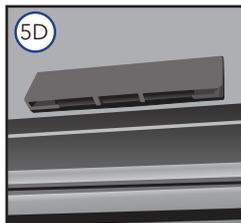
- B. **Apply sealant below gasket leaf** at the point where the corner seal tape, gasket miter and the flange miter meet (below the leaf on the gasket). Apply sealant 4" in each direction from the corner between the gasket and the back of the flange (below the lead of the gasket). Tool this sealant, pressing it into the corner and removing any excess sealant. Repeat at each flange corner.



- C. **Apply sealant above gasket leaf** at the point where the gasket miter and the frame meet (above the leaf on the gasket). Apply sealant 4" in each direction from the corner. Tool this sealant, pressing it into the corner and removing any excess sealant. Repeat at each flange corner.

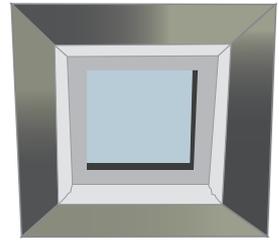


- D. **Re-install weep hole covers** if they were removed in Step 1C.



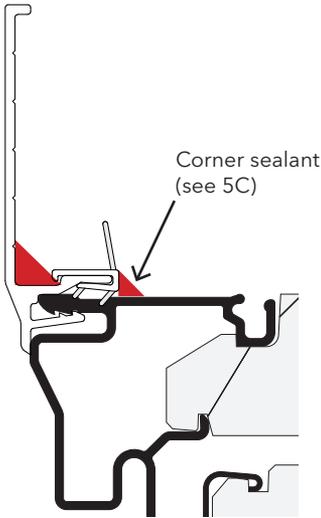
Impervia Direct Set Weep

Refer to the appropriate flush flange installation instruction to complete unit installation.

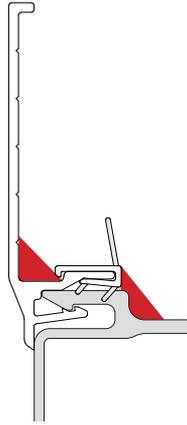


The following details show how flush flange accessory is installed on the different Pella Product materials.

**Clad/Wood Products**



**Impervia® Products**



**ThermaStar by Pella®/  
Encompass by Pella®/  
Centera**

