



PELLA® IMPERVIA® 2.0 SLIDING PATIO DOOR KNOCK-DOWN ASSEMBLY INSTRUCTIONS

Parts List:

- Frame Assembly Package (see parts list below)
- Vent Panel
- Fixed Panel

Tool List:

- Sealant gun
- Drill with 1/8" bit
- Powered driver with Phillip's drive bit
- Ratchet straps or bar clamps
- Mallet
- Putty knife

SEE PAGE 3 FOR SAFETY INFORMATION.

BEFORE REMOVING PREVIOUSLY INSTALLED DOOR AND BEGINNING FRAME ASSEMBLY AND INSTALLATION:

Read through and understand all the assembly steps.

Open frame and panel boxes. Inspect for damage. Measure to confirm the door is the correct size for the opening.

Confirm all the parts a shown in images below are included.



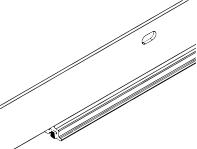
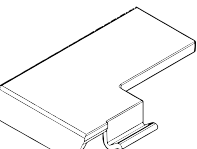
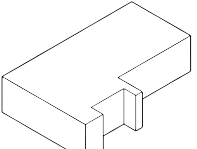
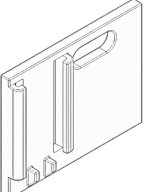
THESE PARTS ARE ASSEMBLY AND/OR INSTALLATION CRITICAL!

If any parts are missing...



DO NOT assemble!
Contact Pella Customer Service at: 877-473-5527.

Parts list continued on next page.

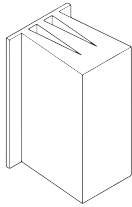
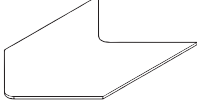
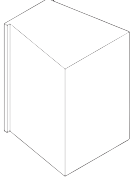




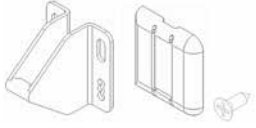
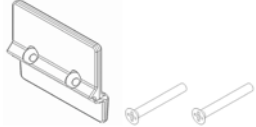


Part	Qty	Description
 Sill Cover	(1)	Black, plastic. Goes on sill prior to vent panel installation.
 Fixed Panel Cover	(1)	Black, plastic. Goes on sill/fixed panel.
 Head/Jamb Fin	(1) Head fin, (2) jamb fin, (1 per jamb)	White. Included only if ordered as fin unit.
 Fixed Jamb Corner Cover	(1)	Black, plastic. Goes on sill/fixed jamb corner.
 Fixed Jamb Corner Cover - Foam	(1)	Black, foam. Mates with fixed jamb corner cover prior to install.
 Fixed Panel Bristle Mount	(1)	Black, plastic. Goes on fixed panel.

Parts list
continued from
previous page.

If any parts are
missing...



**DO NOT
assemble!
Contact Pella
Customer
Service at:
877-473-5527.**

Part	Qty	Description
 Fixed Panel Bristle	(1)	Black, bristle pad. Mates with fixed panel bristle mount.
 Fin Corner Tape	(3)	Foil butyl tape.
 Bristle Pad, Lock Jamb	(1)	Black, bristle pad with adhesive back.
 Package - #8 x 5/8" Pan Head	(2) Bags including (3) screws each	Fixed panel to head and sill Bristle mount to fixed panel.
 Package - #10 x 3" Hex Head	Bag including: (12) screws	Frame to fixed panel.
 Package - #8 x 1/2" Flathead	Bag including: (8) screws	Frame cornerlock.
 Package - #8 x 1-1/2" Pan Head	Bag including: (6) screws	Sill to jamb.
 Package - Lock Strikes	Bag including: (2) lock strikes, (2) lock strike covers, (8) #10 x 1/2" screws, (1) instruction	Metal lock strikes, black plastic covers.
 Package - Panel Retainer	Bag including: (1) panel retainer, (2) machine screws, (1) Instruction	Black panel retainer. #6 x 1 1/2" machine screws.
 Package - #8 x 3" Flathead, #10 x 3" Pan Head	Bag including: (22) #8 x 3" screws, (2) #10 x 3" screws	Sill installation.
 Package - Installation Screw & Hole Plugs	Bag including: (24) screws, (24) plastic hole plugs	#10 x 3" screws. Color matched plastic hole plugs. Included only if Unit ordered as block frame.
Pella Installation Sealant	(1)	Color matched cartridge.
Touch-up Paint	(1)	Color matched pen.



IMPORTANT SAFETY AND PRODUCT INFORMATION – DOORS

CAUTION: Many doors in older homes are painted with lead-based paint. Removal of old doors may disturb this paint. Proper precautions must be taken to minimize exposure to dust and debris. Consult state or local authorities and/or go to www.epa.gov/lead for more information.

WARNING: To ensure safety and security and help prevent property damage, including possible damage to your window or door, close and lock windows and doors any time they are not being used for venting on a nice day, and particularly during high winds or rain.

IMPORTANT NOTICE

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 anticipated and unanticipated water infiltration; deficiencies in building design, construction and maintenance; failure to install Pella products in accordance with Pella's installation instructions; or the use of Pella products in wall 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 the Buyer or User, the architect, contractor, installer, or other construction professional and are not the responsibility of Pella.

Pella products should not be used in barrier wall systems which do not allow for proper management of moisture within the wall systems, such as barrier Exterior Insulation and Finish Systems (EIFS) (also known as synthetic stucco) or other non-water managed systems. Except in the states of California, New Mexico, Arizona, Nevada, Utah and Colorado, Pella makes no warranty of any kind on and assumes no responsibility for Pella windows and doors installed in barrier wall systems. In the states listed above, the installation of Pella Products in barrier wall or similar systems must be in accordance with Pella's installation instructions. Product modifications that are not approved by Pella Corporation will void the warranty.

CARE AND MAINTENANCE

Care and maintenance information is available by contacting your local Pella retailer. This information is also available at www.pella.com.

CLEANING INSTRUCTIONS

GLASS—Remove any protective film and labels and clean the glass, using a soft, clean, grit-free cloth and mild soap or detergent. Be sure to remove all liquid by wiping dry or use a clean squeegee.

FACTORY FINISHED PRODUCT: Pella Product that has been prefinished with stain or paint from the factory requires no additional finishing. Clean the surface with mild soap and water.

PELLA® ALUMINUM CLAD OR IMPERVIA FRAMES: The interior and exterior frame and panels are protected with a tough factory finish. Clean this surface with mild soap and water. Stubborn stains and deposits may be removed with mineral spirits. DO NOT use abrasives. DO NOT scrape or use tools that might damage the surface.

ENCOMPASS BY PELLA®/THERMASTAR BY PELLA® AND PELLA® 250 SERIES DOOR FRAMES: The vinyl frame may be cleaned using the same method as the glass. For stubborn dirt, a "non-abrasive" cleaner such as Bon-Ami® or Soft Scrub® may be used. Do not use solvents such as mineral spirits, toluene, xylene, naphtha or muriatic acid as they can dull the finish, soften the vinyl and/or cause failure of the insulated unit seal. Keep door tracks clear of dirt and debris. Keep weep holes open and clear of obstructions.

DO NOT use abrasives. DO NOT scrape or use tools that might damage the surface.

NOTICE: DO NOT use inappropriate solvents or brickwash or cleaning chemicals. If you do, permanent damage can result and the product failure, loss or damage would not be covered by the Limited Warranty.

FINISHING INSTRUCTIONS (WOOD PATIO DOORS AND FIBERGLASS ENTRY DOORS)

Paint or finish immediately after installation.

If products cannot be finished immediately, cover with clear plastic to protect from dirt, damage and moisture. Remove any construction residue before finishing. Sand all wood surfaces lightly with 180 grit or finer sandpaper. DO NOT use steel wool. BE CAREFUL NOT TO SCRATCH THE GLASS. Remove sanding dust. Pella products must be finished according to these instructions; failure to follow these instructions voids the Limited Warranty. Finishing panel edges is optional for Patio Doors.

Note: To maintain proper product performance do not paint, finish or remove the weatherstripping, mohair dust pads, gaskets or vinyl parts. Air and water leakage will result if these parts are removed. After finishing, allow venting Doors and doors to dry completely before closing them. If paint, stain or finish gets on the weatherstripping, wipe it off immediately with a damp cloth.

Panel Cleaning and Prep Instructions for Unfinished or Primed Panels: Dry wipe dust from doors gently. Examine door for possible smudges or fingerprints made from normal handling or construction. To remove smudges, lightly wipe surface with warm water. DO NOT sand surface of fiberglass panel. Scuff sand with light grade sand paper or abrasive pad (220 grit or higher). Rinse surface with mineral spirits for fiberglass panels and warm water for steel panels. Let door and sidelight surfaces dry completely before applying finish. Finish the door panels as soon as possible after installation.

STAINING FIBERGLASS PANELS OR UNFINISHED INTERIOR FRAME MEMBERS: Fiberglass door and sidelight panels may be stained with a gel stain if a wood look is desired. Pella offers stain kits in a variety of colors. Apply and finish per the stain kit manufacturer's instruction. Ensure that all exposed panel edges are finished to minimize the chance of damage.

Unprimed interior frame parts may be stained with wood stains and should be finished with a minimum of two coats of a clear polyurethane finish. DO NOT bridge the top coat between the outer edge of the glazing frame and the door panel.

Note: The fiberglass base color tone will vary. This variance is normal and will not impact the stain color of the door.

PAINTING INSTRUCTIONS: Wood door frame exteriors, premium steel door panels and sidelights are factory primed. Wood doors require painting immediately after installation. The factory applied primer is not intended for long term exterior exposure. Sand all un-primed interior wood surfaces lightly with 180 grit or finer sandpaper before priming and painting. Fiberglass door and sidelight panels do not require priming. Use two coats of a 100% latex paint that has a good blocking resistance. On units with glass, do not bridge paint between the outer edges of the glazing frame and the door panel. On fiberglass products, brush the paint in the same direction as the simulated wood grain. For entry doors, ensure that all exposed panel edges are finished to minimize the chance of panel damage. Finishing panel edges is optional for Patio Doors.

Pella Corporation is not responsible for interior paint and stain finish imperfections for any product that is not factory-applied by Pella Corporation. For additional information on finishing see the Pella Owner's Manual or go to www.pella.com.

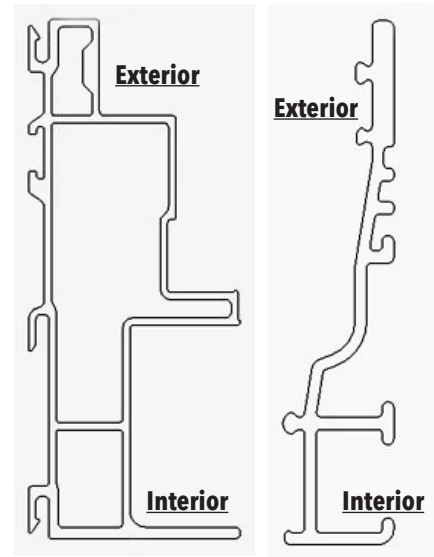
The use of unapproved finishes, solvents or cleaning chemicals may cause adverse reactions with door materials. Pella will not be responsible for problems caused by the use of unapproved materials. If in doubt, contact your local retailer or representative.

EXTERIOR FINISH OF EXISTING FRAME (POCKET REPLACEMENT)

It is the responsibility of the homeowner, contractor or installer to ensure any exposed unfinished wood is covered or finished. Possible methods include, however are not limited to, covering with aluminum coil stock or painting.

1 Frame Assembly Process:

- A. Place the frame parts exterior side up on cardboard or something else to protect the finish.



Frame - Head/Jamb

Frame - Sill

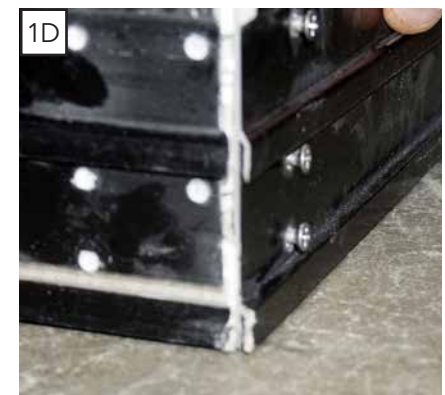
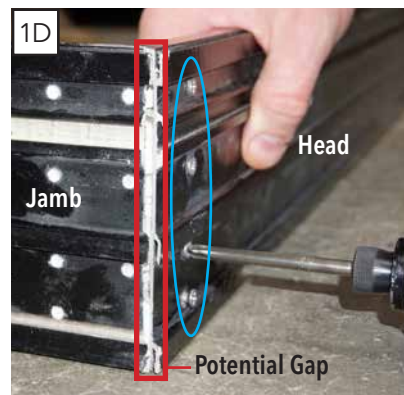
- B. Insert one end of head with cornerlock into one of the jambs.



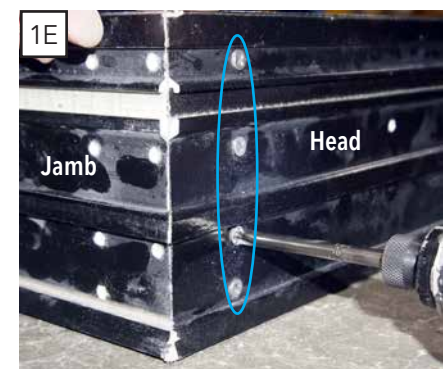
- C. If needed use a mallet to seat the cornerlock into the jamb.



- D. When inserting the head with cornerlocks into the jamb, make sure the miter is tight with no gap. If the miter won't close completely, loosen the (4) preinstalled screws and push the miter closed.



- E. Re-tighten the head cornerlock screws.

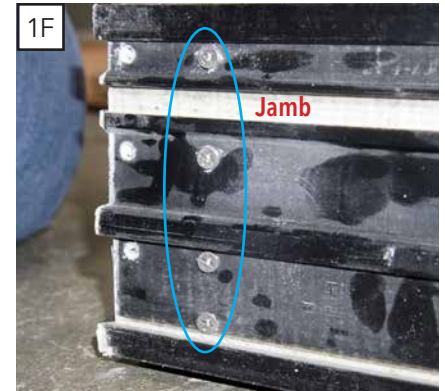
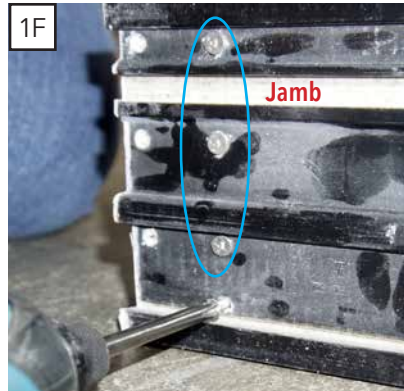


1 Frame Assembly Process (continued):

F. Install (4) #8 x 1/2" Phillips Flathead screws, into jamb corner.



#8x1/2" Flat Head Screw



G. Repeat B-F to insert and install the other head cornerlock into the other jamb.

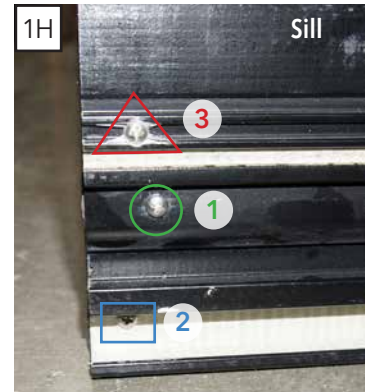
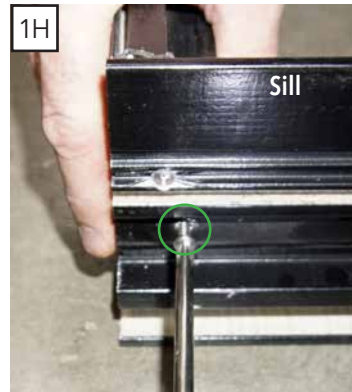
H. Install (3) #8 x 1 1/2" Phillips Pan Head screw into one end of sill.



#8 x 1-1/2" Pan Head Screw

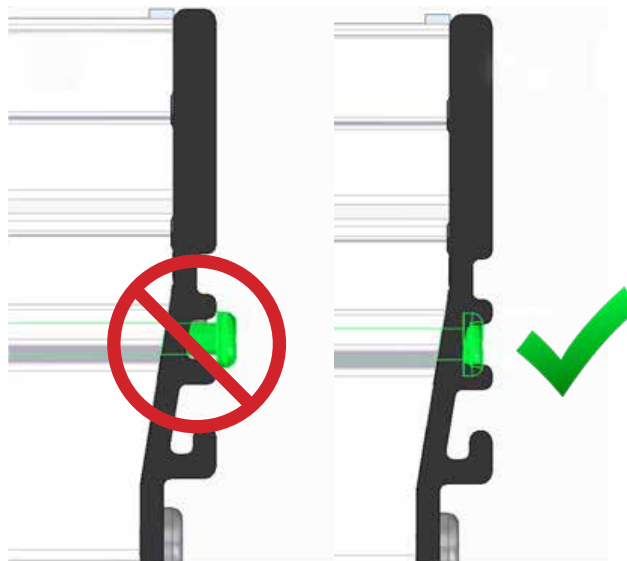
Tighten the screws in this sequence:

- Start by tightening the middle screw **first**
- Tighten the bottom screw **second**
- Tighten the top screw **third**



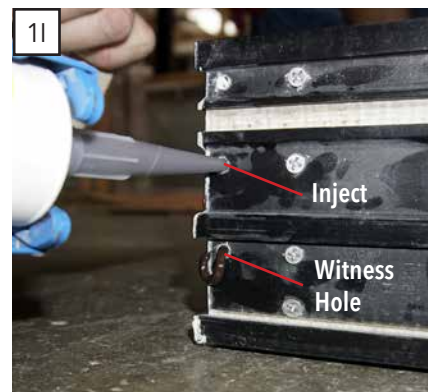
Tighten the top screw until it sits just below flush of the bottom of the sill.

After tightening all screws, repeat tightening sequence a second time to ensure proper compression of the sill to jamb joint.



1 Frame Assembly Process (continued):

I. At one head corner; inject cornerlock sealant into the center cornerlock injection hole until squeeze-out is visible in the bottom witness hole.



J. Inject cornerlock sealant into top cornerlock injection hole until squeeze-out is visible on the flat part of the exterior corner.

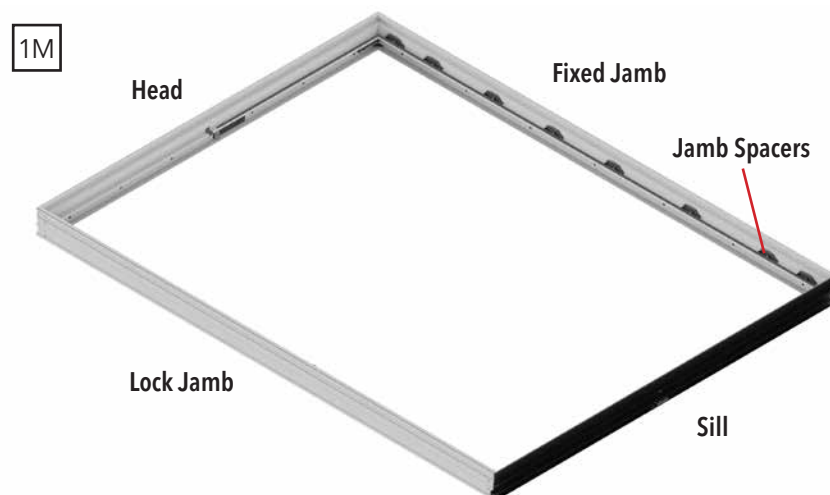


K. Clean off excess sealant.



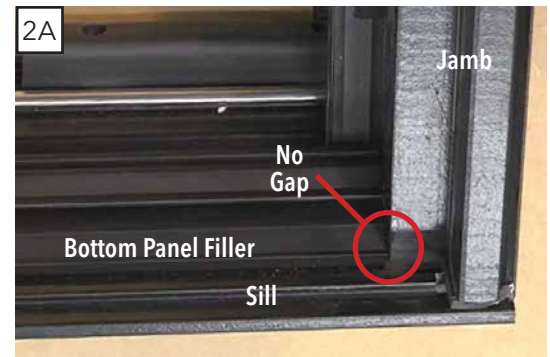
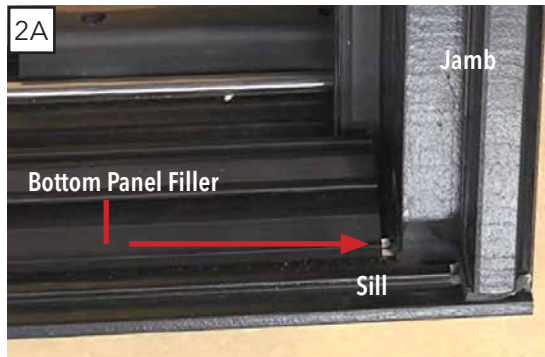
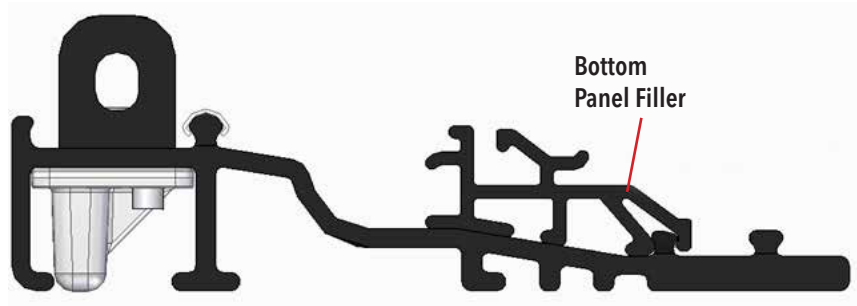
L. Repeat I-K on the other head/jamb corner.

M. Finished Frame, shown assembled, Exterior side up.



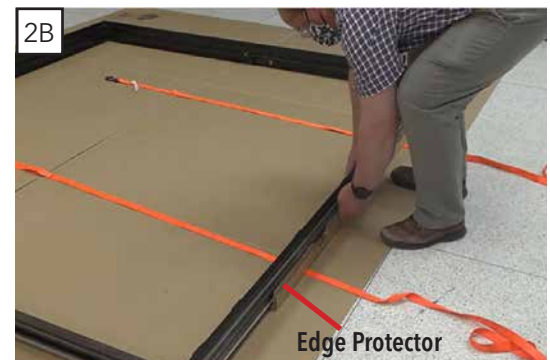
2 Fixed Panel Installation:

- A. Ensure bottom panel filler is slid over until it is flush with the jamb.



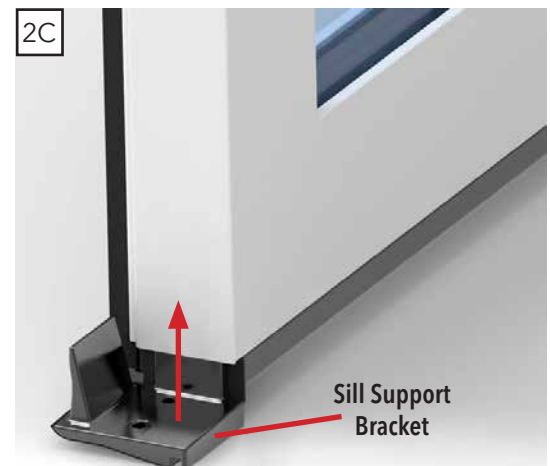
- B. After unpacking Fixed Panel, keep the cardboard edge protectors. These will be used to protect the frame when installing the Fixed Panel if using ratchet straps.

Lay out ratchet straps under fixed jamb. Use cardboard edge protector to protect the frame where ratchets straps wrap around the frame. Skip this step if using bar clamps instead of ratchet straps.



- C. On bottom of fixed panel, make sure the sill support bracket is pushed up towards the top of the panel.

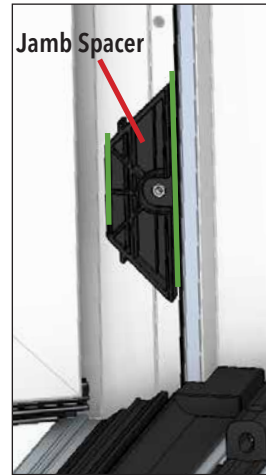
Note: This bracket can be moved into two positions. The "up" position is prior to installation of the panel into the frame. The "down" position is after the panel is installed into the frame.



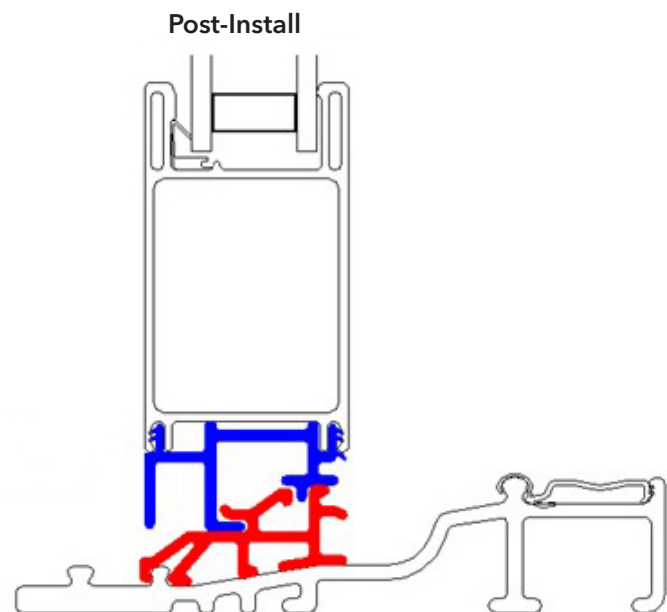
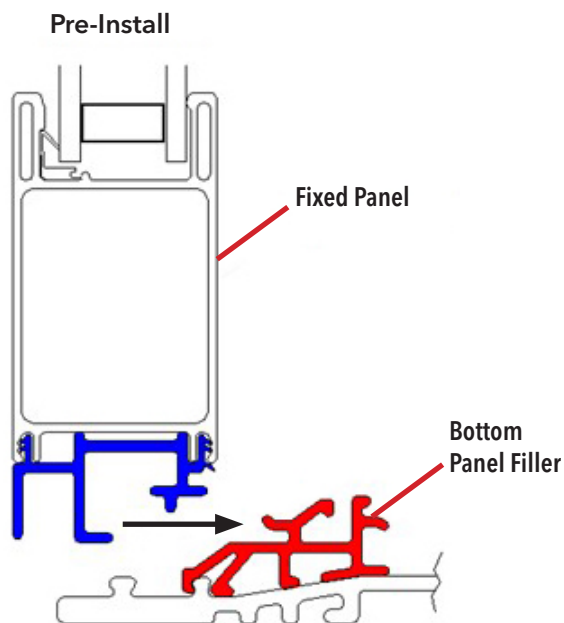
2 Fixed Panel Installation (continued):

- D. Install fixed panel. Position the side of the panel onto the jamb spacers in the fixed jamb, holding the other side of the panel up at an angle.

The images in this view show how the fixed panel edges and the spacers on the LH jamb are to align, (green lines meet).

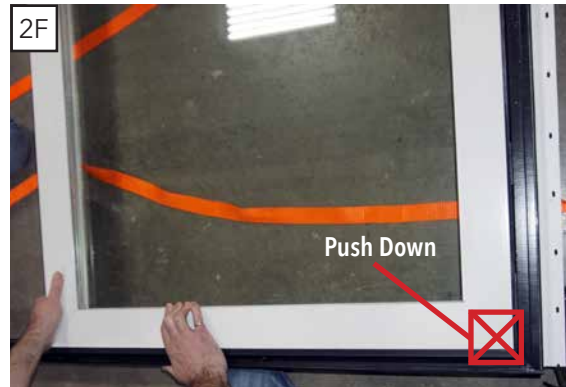


- E. Once seated on the jamb spacers, push the other side of the panel down until it snaps into the head and sill. The panel filler (blue) on the bottom of the fixed panel and the bottom panel filler (red), are to align and interlock as shown.

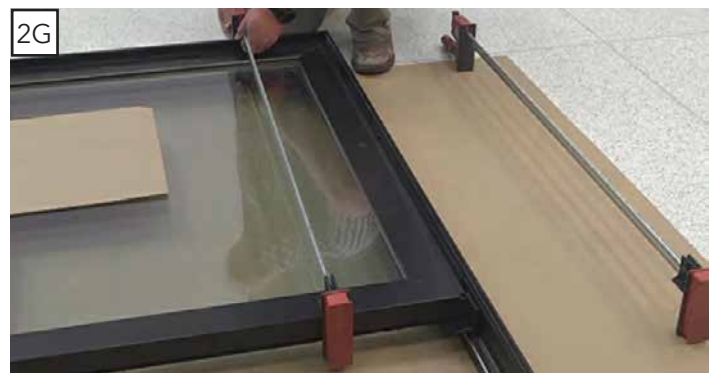
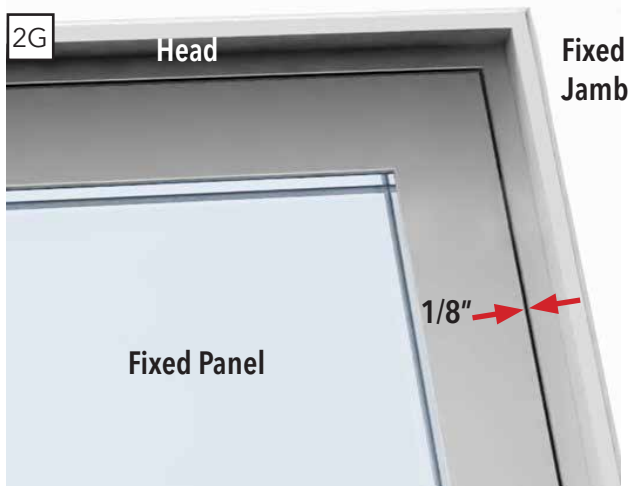


2 Fixed Panel Installation (continued):

- F. Be sure to apply pressure to the head and sill to prevent them from bowing away from the panel. The bottom corner of the fixed panel may need to be pushed down to seat the two panel fillers all the way.



- G. Tighten ratchet straps (or apply bar clamps) to hold the fixed panel in the proper place. Be sure to use edge protectors from step 2B between the straps and door to protect the unit from damage. Ensure there is consistent 1/8" spacing between the fixed panel and jamb along entire length.



2 Fixed Panel Installation (continued):

H. Install #10 x 3" Hex Head screws in the pre-drilled holes along the fixed jamb first, then the head. Be careful not to overdrive the screws.



#10 x 3" Hex Head Screw



I. Remove the Ratchet straps (or bar clamps).

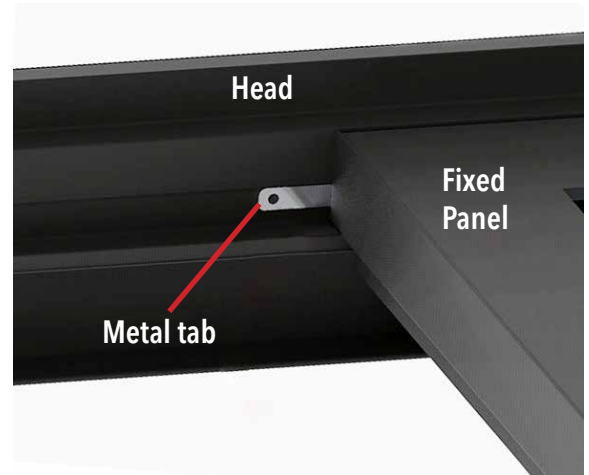
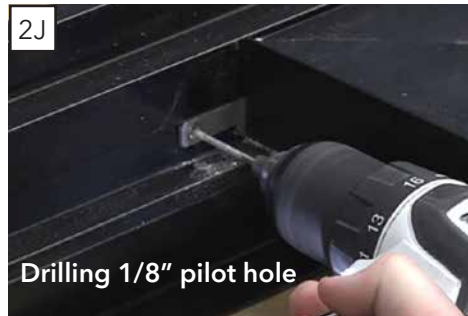


2 Fixed Panel Installation (continued):

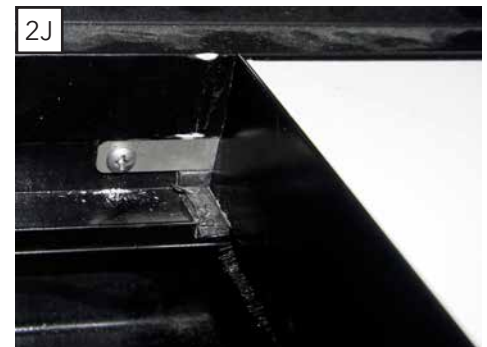
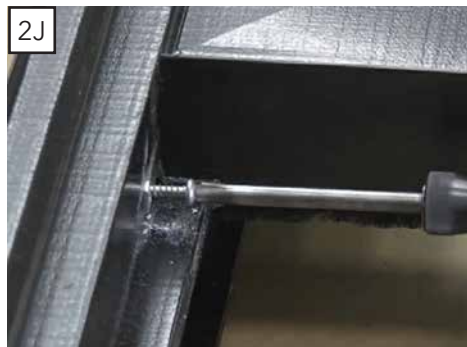
- J. At the junction of the head and fixed panel, locate metal tab. Using hole in metal tab as a guide, drill a 1/8" pilot hole.



#8 x 5/8" Pan Head Screw



- Install (1) #8 x 5/8" Pan Head screw.



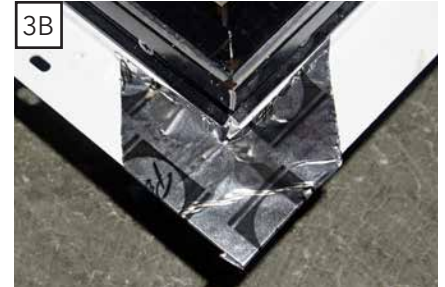
3 Final Adjustments:

- A. Slide jamb fins into their slots. Check to make sure fins are notched back far enough. Bend the top flaps of the jamb fins down and slide the head fin into its slot. Head fin flaps are on top for watershed.

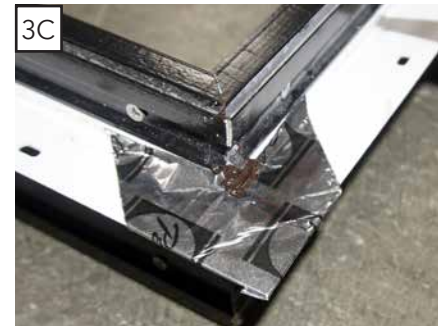
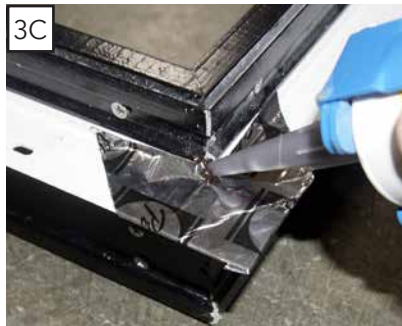


3 Final Adjustments (continued):

B. Cover corners with fin corner tape.



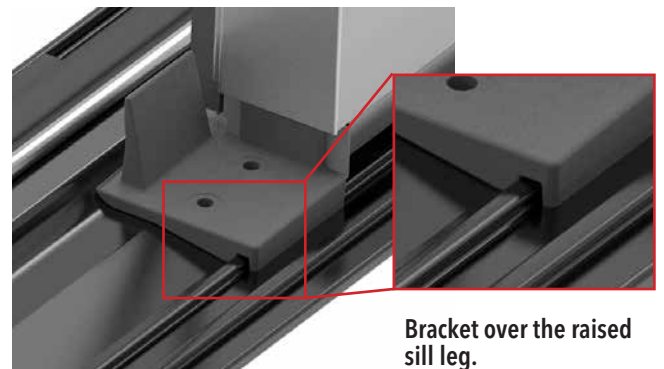
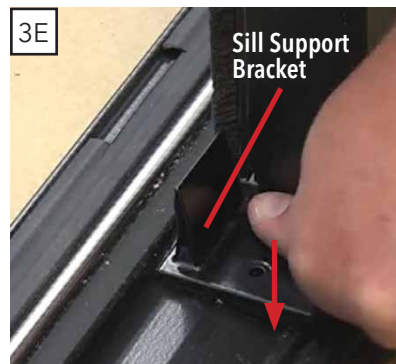
C. Place a small bead of sealant to cover the inside corners where all the fins meet.



D. Stand the unit up.



E. Push sill support bracket down against sill. Make sure the notch in the bracket is locked over the raised leg on the sill.

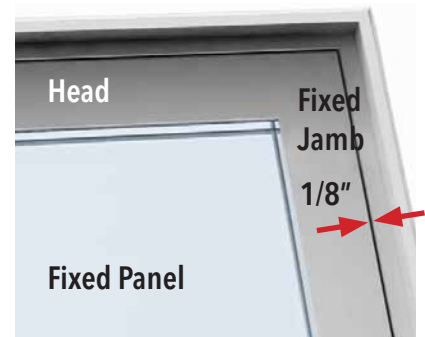
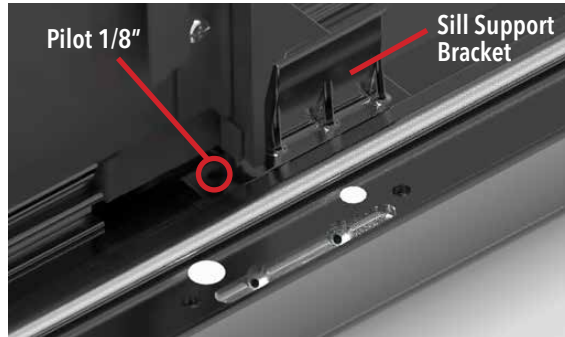


3 Final Adjustments (continued):



NOTE: Before drilling pilot holes in sill, ensure the gap between the fixed panel and jamb is at a consistent 1/8" spacing. If not, use a bar clamp or ratchet strap to pull the fixed panel tight to the jamb.

F. On interior side of fixed panel, drill 1/8" pilot hole in existing hole in sill support bracket. Add sealant to hole before installing screw.



Install (1) #8 x 5/8" Pan Head screw.



#8 x 5/8" Pan Head Screw



On Exterior side of fixed panel, drill a 1/8" pilot hole in both holes in sill support bracket.

Install (2) #8 x 5/8" Pan Head screws.



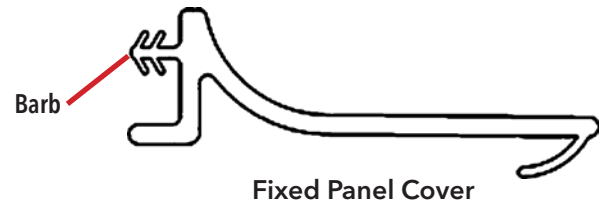
#8 x 5/8" Pan Head Screw



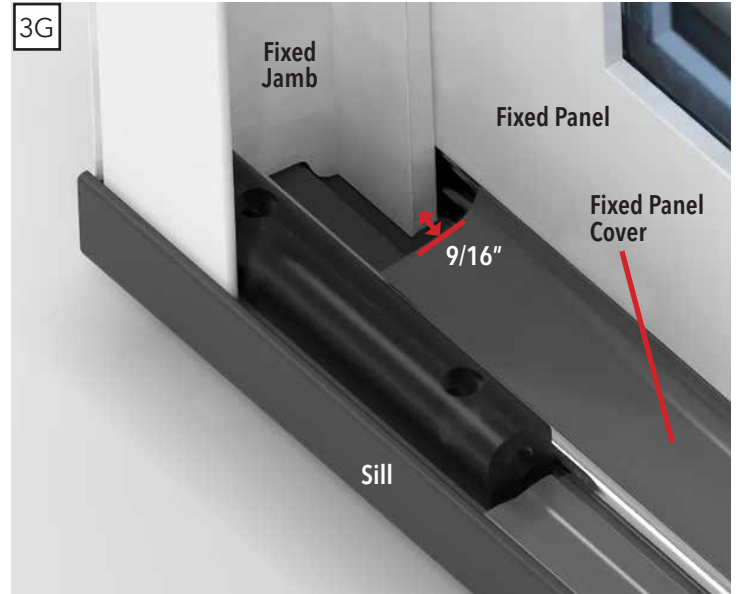
NOTE: After unit is installed in rough opening, the two screws on the exterior of the sill support bracket may be required to be removed and replaced with #10 x 3" Pan Head screws as identified in the installation instructions. Sealant must be added to all screw holes in the sill for screws intended to be permanently in place.

3 Final Adjustments (continued):

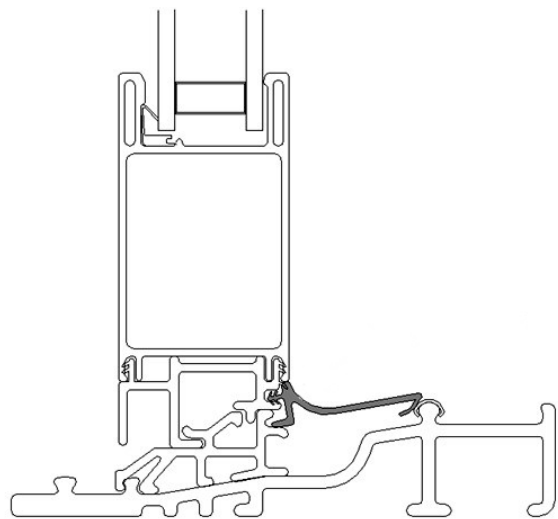
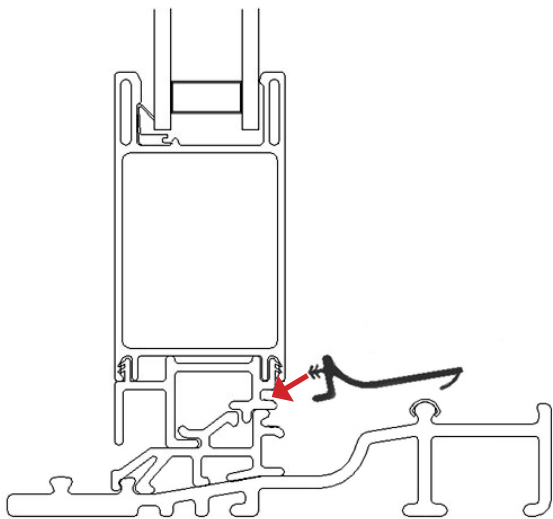
G. Install Fixed Panel Cover - Mating to fixed panel and sill:



Position the Fixed Panel Cover 9/16" from the fixed jamb of the frame.

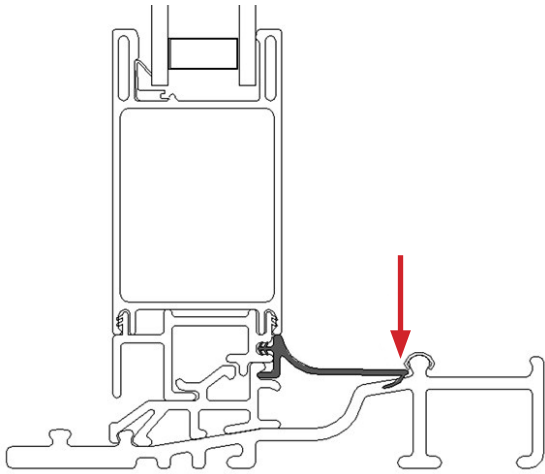


Insert the barb into the slot in the top of the panel filler along the length of the part.

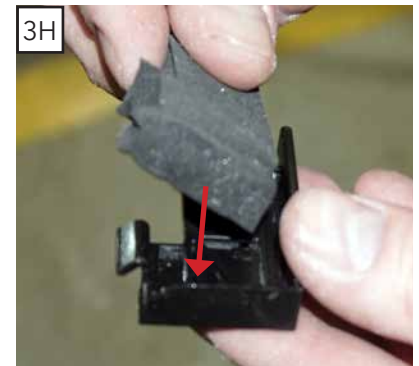
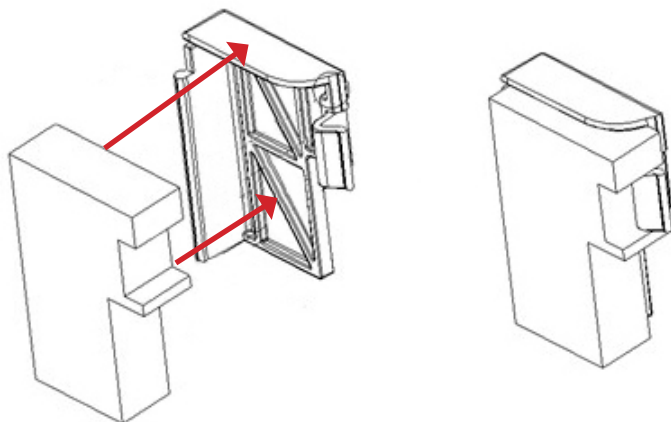
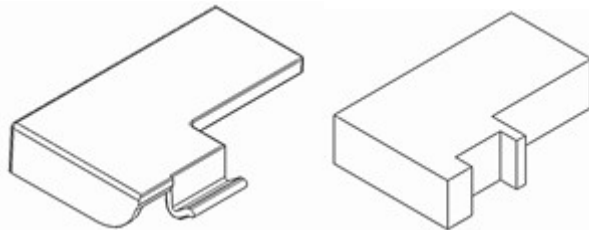


3 Final Adjustments (continued):

Press the Fixed Panel Cover down to snap it under the stainless track along the length of the part.

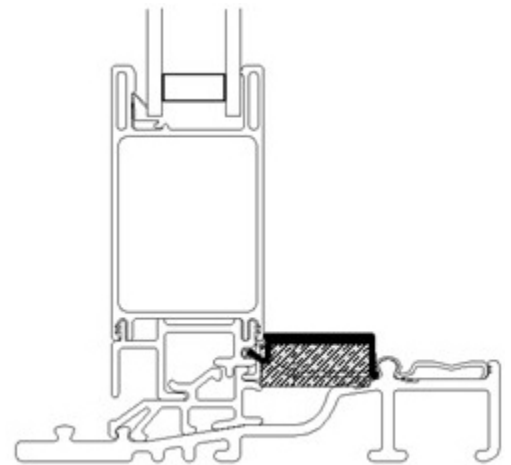
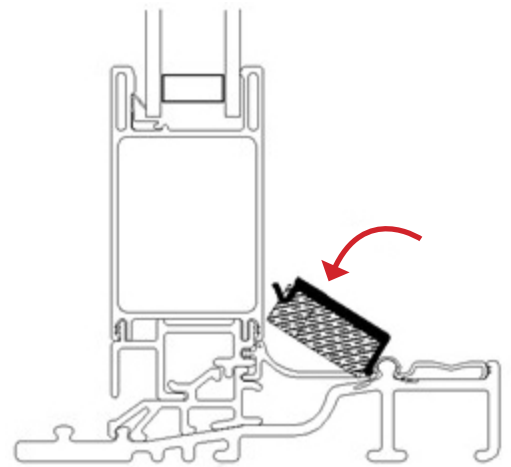
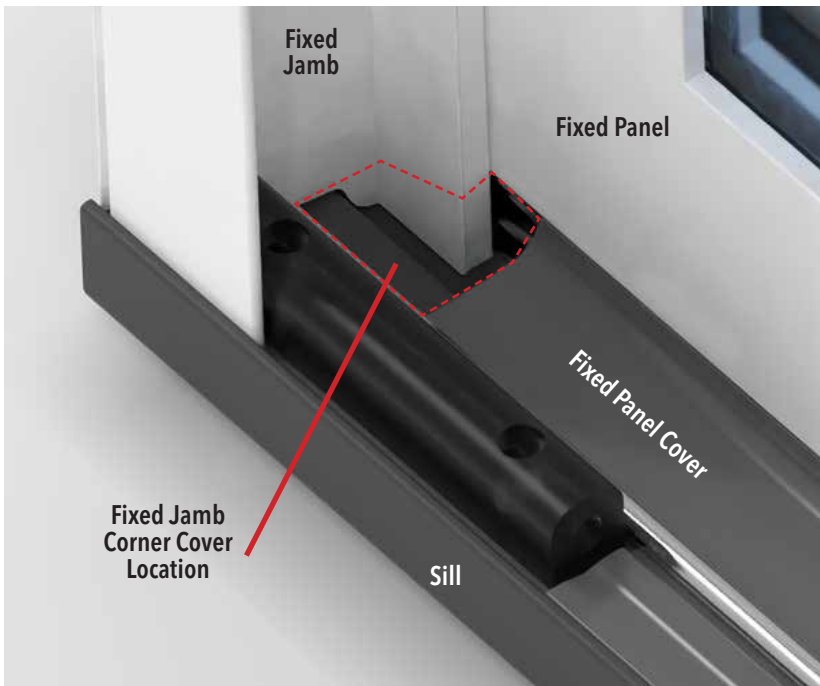


H. Assemble the Fixed Jamb Foam Corner by installing the corner foam into the plastic cover.



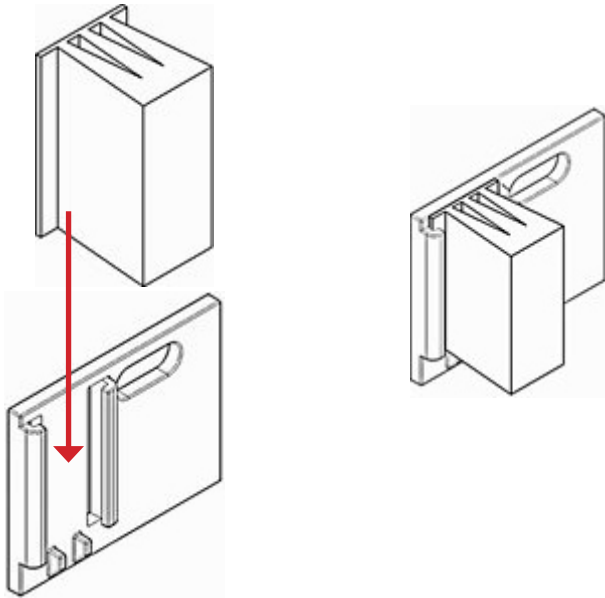
3 Final Adjustments (continued):

- I. Install the assembled fixed jamb cover with foam, under stainless track and rotate down and snap into place.

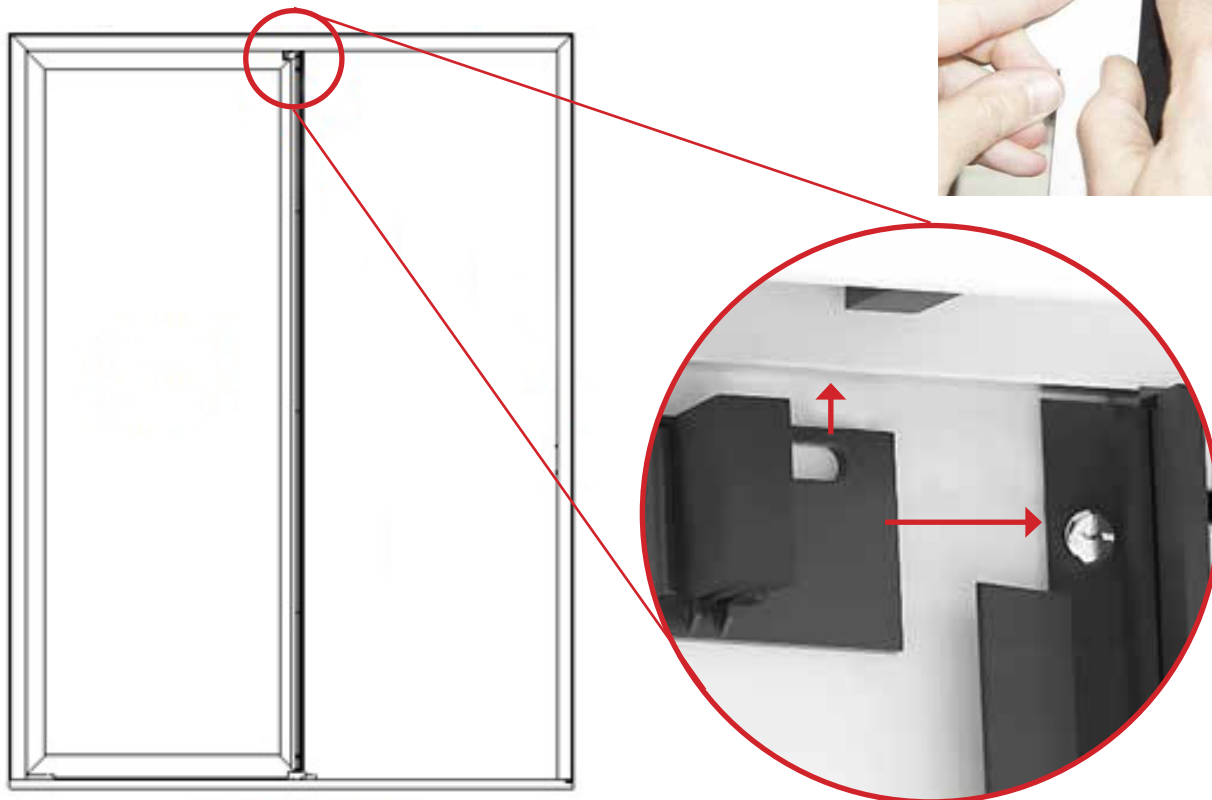


3 Final Adjustments (continued):

- J. Assemble the Fixed Panel Bristle by inserting the mohair into the top of the plastic base.

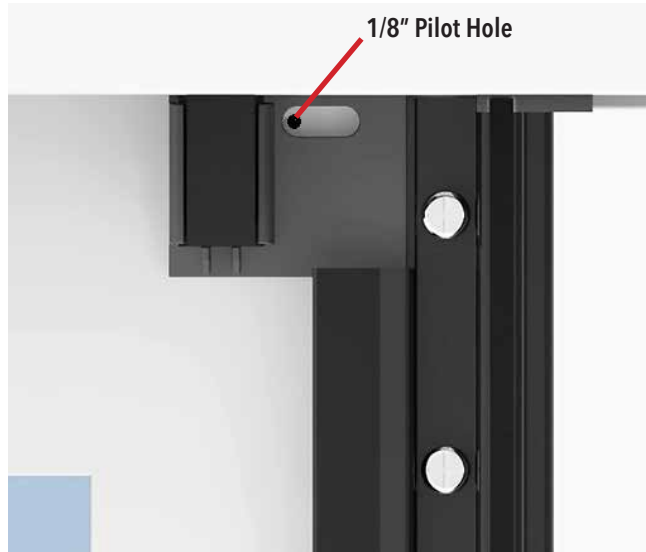


Place assembly onto face of fixed panel. Top of assembly will go against the head and the side of the assembly by the slot, goes against the interlocker.



3 Final Adjustments (continued):

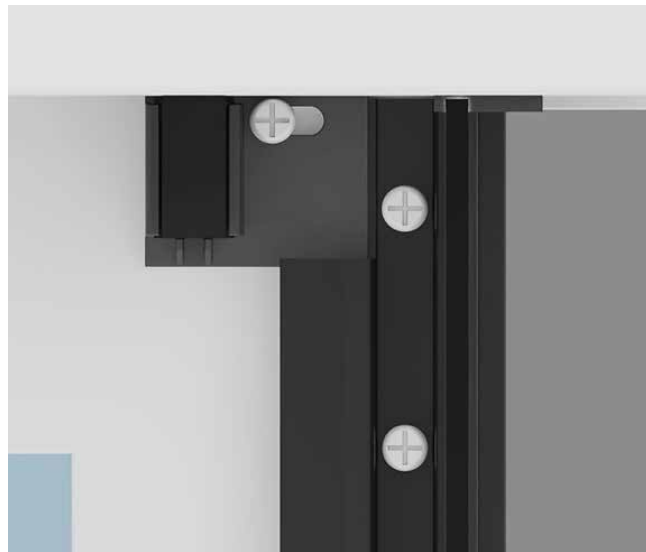
While holding assembly, drill 1/8" pilot hole into the fixed panel. The hole must be at the end of the slot, closest to the bristle. This is to allow adjustment afterwards if needed.



Install (1) #8 x 5/8" Pan Head screw.

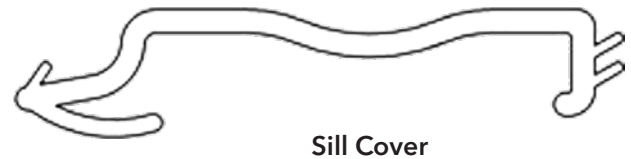


#8 x 5/8" Pan Head Screw



3 Final Adjustments (continued):

K. Install the sill cover.



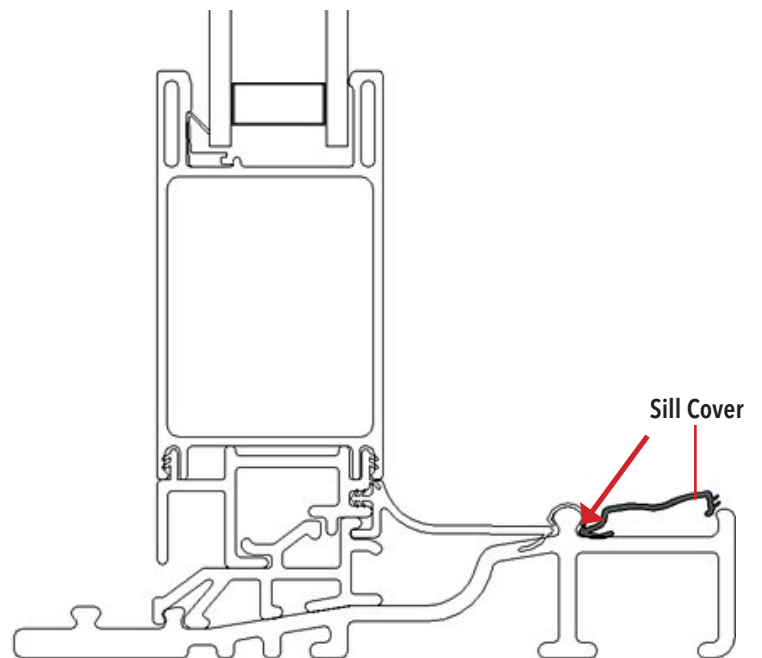
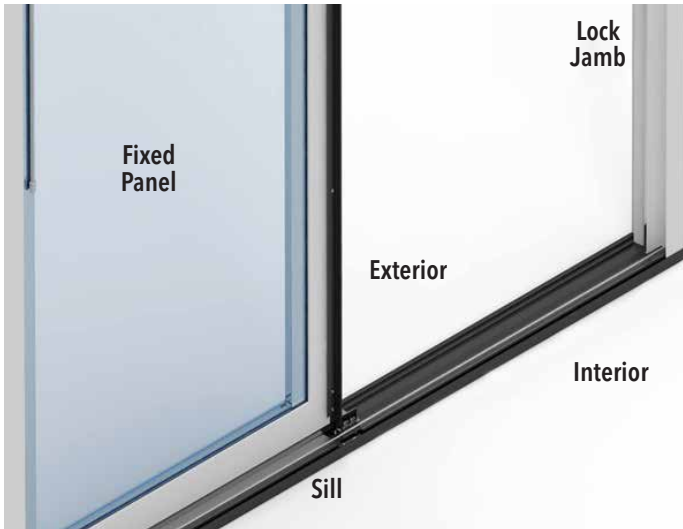
Sill Cover



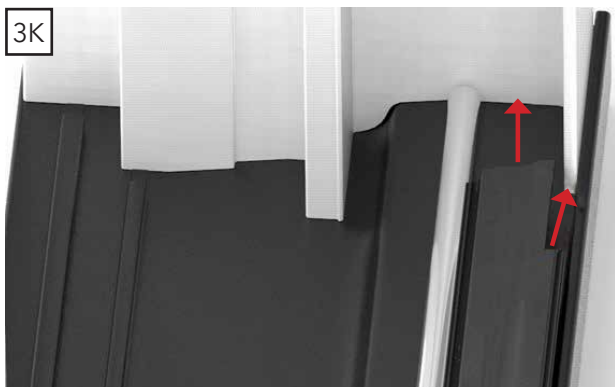
NOTE: The Bristle Pad which is positioned on the Lock Jamb, is installed after the Sill Cover. Before the Sill Cover can be installed, the Unit should be installed into the rough opening and screws need to be driven through the sill. Reference the Installation Instructions for details on the sill screw installation. After the sill screws are installed, the Sill Cover may be installed.



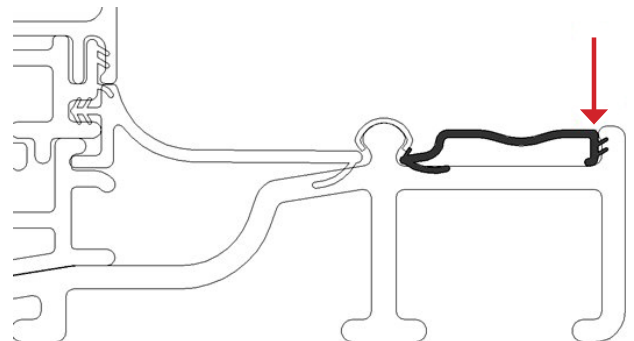
Place Sill Cover into interior sill cavity as shown, first placing the end under the stainless-steel track. Start closest to lock jamb.



The notch in the end of the Sill Cover must be pushed all the way against the Lock Jamb.



With the Sill Cover against the Lock Jamb, and one end under the Stainless-Steel Track, push the opposite end of the Sill Cover down across the length of the part.

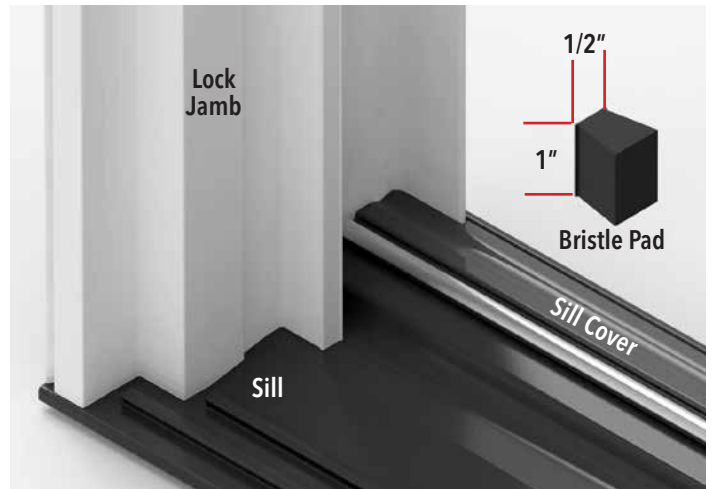


3 Final Adjustments (continued):

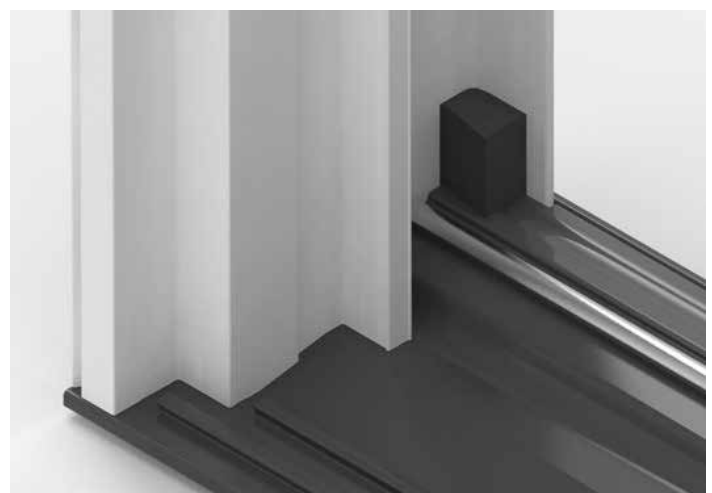
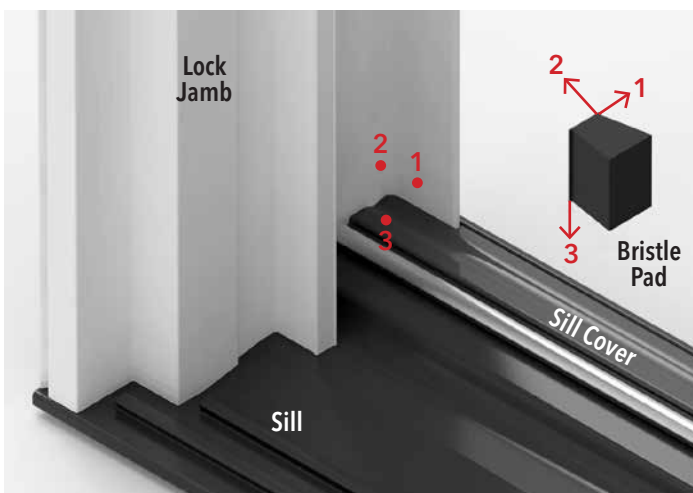
L. Remove liner from Bristle Pad, exposing adhesive back.



Orientate the 1" tall by 1/2" wide bristle pad with the 1" going vertically.



Position the Bristle Pad in place (1) along the inner edge of the Lock Jamb, (2) Against the end of the Lock Jamb, (3) and on top of the Sill Cover.



Continue with installation, following installation instructions.