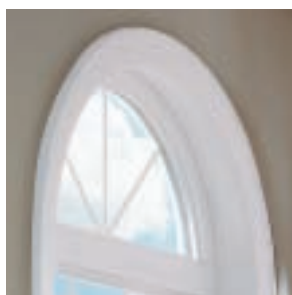


# *Imperial*

## LS™



*High Performance  
Windows and Doors*

# Our Promise to You

Soft-Lite Windows has been manufacturing window products since 1934. During those years many things in our world have changed. However, one thing has remained constant. Generation after generation, the desire to own a home and to improve it has never changed.

Today "improving your home" does not mean the same things it did 70 years ago. With the continually rising cost of energy now becoming a major cost and personal concern, it's important for window and door manufacturers to develop the most energy efficient products available, and to make them durable. Form and function come with experience, and the materials and designs used today to make windows have improved significantly over the years.

At Soft-Lite Windows we knew we wanted to offer the best-performing, most beautiful replacement window made today. None of the standard, conventional window designs available in the industry met our demanding criteria. So in early 2005 we set out to design and build "the window for a whole new generation of needs." Using our proven Imperial™ window line as our foundation, thus was born the Imperial LS Window.

## Don't just take our word for it...



### Efficient Windows Collaborative

Soft-Lite is a member of the Efficient Windows Collaborative (EWC) in which members have made a commitment to manufacture and promote energy-efficient windows. [www.efficientwindows.org](http://www.efficientwindows.org).



Soft-Lite products are Gold Label certified by the American Architectural Manufacturers Association (AAMA), the source of performance standards, product certification and educational programs for the window, door and skylight industry. [www.aamanet.org](http://www.aamanet.org)



The Champion of Industry Award recognizes exceptional achievements and contributions in a wide variety of American corporations. Companies must be considered to be positive "difference makers" within their industry to be selected. [www.championsaward.com](http://www.championsaward.com)



Soft-Lite is an Energy Star Partner. Energy Star is a joint program of the U.S. Environmental Protection Agency and the U.S. Department of Energy helping us all save money and protect the environment through energy efficient products and practices. [www.energystar.gov](http://www.energystar.gov)



Soft-Lite is a three-time winner of this award. *Window & Door Magazine* gathers a broad range of input to determine the industry's most innovative products, companies, organizations, and technologies. [www.windowanddoor.net](http://www.windowanddoor.net)



National Fenestration Rating Council®

Soft-Lite products are certified by the National Fenestration Rating Council. NFRC develops and administers comparative energy and related rating programs that serve the public. It provides fair, accurate and credible, user-friendly information on fenestration product performance. [www.nfrc.org](http://www.nfrc.org)

## Companies To Watch in 2005

Door and Window Manufacturer

Soft-Lite is a Company to Watch in *Door and Window Manufacturer* magazine. This trade journal annually profiles manufacturers and suppliers who lead the industry in innovation, performance, and professionalism.

## Window & Door TOP 100 MANUFACTURERS IN 2007

Every year since 1996 Soft-Lite has been placed on the Top 100 Manufacturers' annual list which presents North America's 100 largest manufacturers of residential windows, doors and/or skylights. The Top 100 highlights the activities of the industry's most influential leaders. [www.windowanddoor.net](http://www.windowanddoor.net)



In recognition of its dedication to excellence in using the Friedman ERP software system, Soft-Lite has established a web-based integrated ordering platform including Power Bids that delivers accurate quotes and quickens lead times. [www.friedmancorp.com](http://www.friedmancorp.com)



The Ohio Partnership for Excellence is a non-profit organization that uses the Malcolm Baldrige Criteria for Performance Excellence to continuously improve manufacturing quality. Soft-Lite is a winner of the prestigious OPE "Commitment to Excellence" Award. [www.ope.org](http://www.ope.org)

# Imperial LS™ Double Hung



Our Imperial LS double hung windows bring a whole new set of definitions to the words beauty, comfort, energy efficiency and durability.

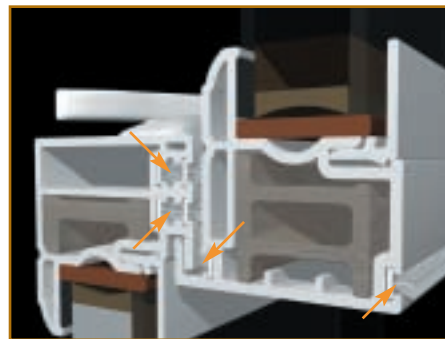
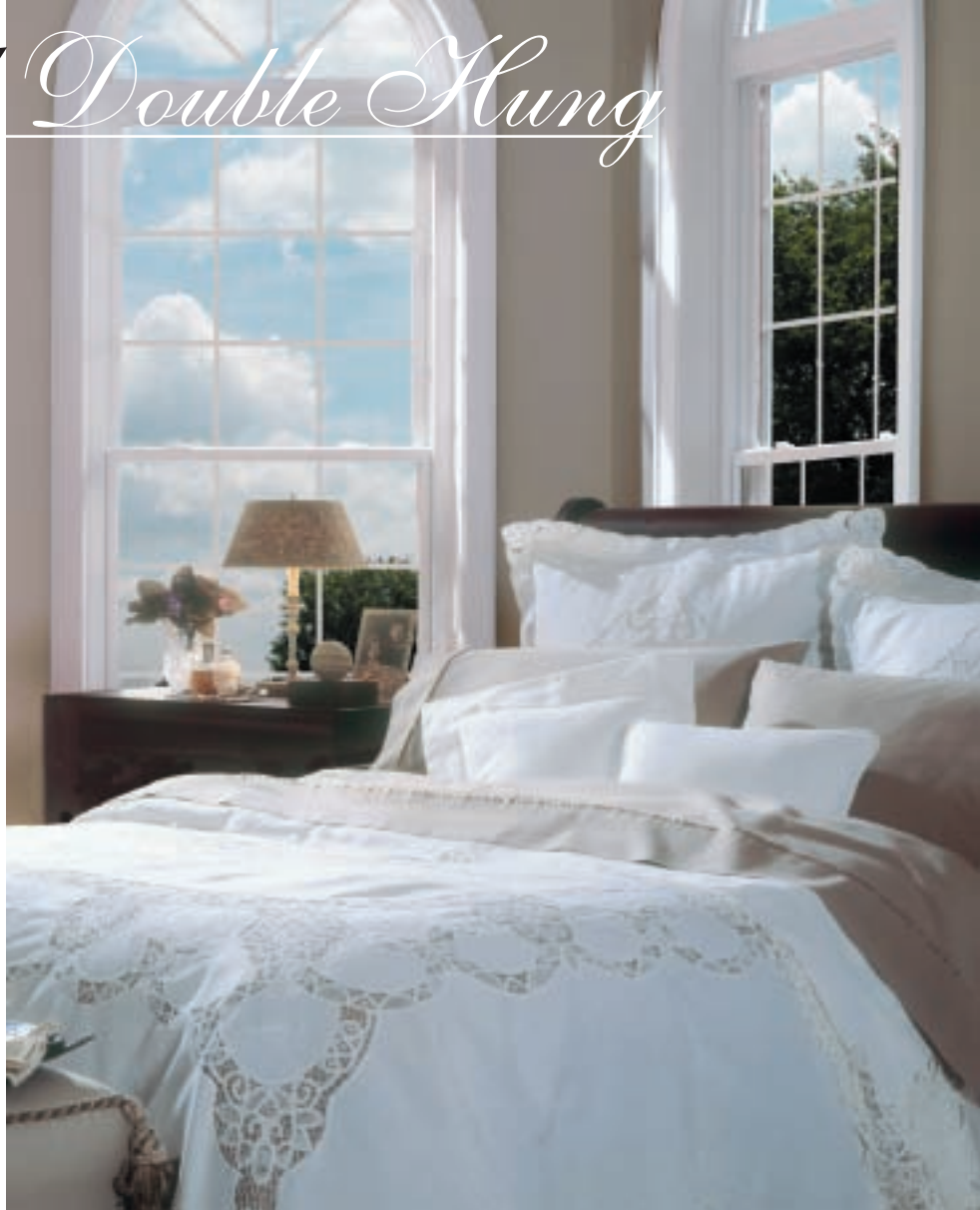
Beginning with our sculpted sash detail and very low profile sash locks, along with the ergonomically designed sash lift rails, you will begin to see and feel the difference between the ordinary window and Imperial LS.

But some of the most important features to consider are not necessarily easy to see. Ultra-Smart™ triple-fin weatherstrip on both sashes means less air infiltration into your home. Fully welded corners on sash and mainframe mean lasting durability, and the industry's strongest sash balance system assure you long lasting and effortless operation whenever you



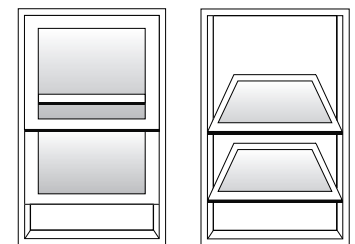
*Sleek sash lock and tilt latch reveal no screw heads as the Dura-Latch™ restricts sash travel.*

decide to open or close your window. An optional automatic lock feature, Auto-Majik™, ensures that whenever you close the sash of your window, the lock automatically engages leaving you with peace of mind regarding security and safety. You'll never "forget" to lock your windows again.



*Ultra-Smart™ triple-fin weatherstripping on all sashes and at interlocking meeting rail.*

Soft-Lite offers the widest selection of energy efficient low-e glass packages available. Upgrade from the standard double-pane low-e and argon package to our Ultimate™ glass featuring triple panes with four layers of low-e on two surfaces, krypton gas and Super Spacer®.

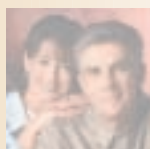


*Exterior view*

*Auto-Majik™ automatic lock feature*



# Sliders



Consider our traditional slider in areas where a tilt feature is not important. Just utilize our easy sash lift-out feature and remove your sash for cleaning.

All the same energy efficient and beautiful features which make our double hung windows a superior choice also apply to our slider line.

Tandem brass rollers ensure easy operation of our slider along with a

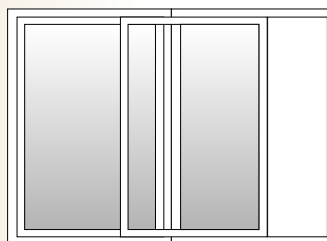
unique sill drainage system which lowers air infiltration and improves comfort.



*Durable brass sash rollers.*

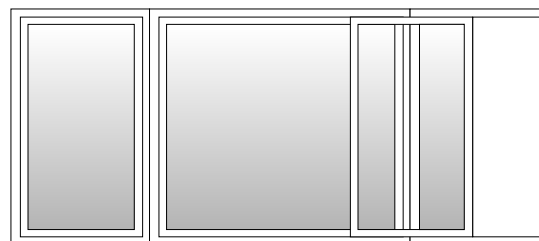


*Coming soon, our optional slide and tilt hardware will allow you to enjoy the benefits of being able to tilt your slider sash in for safe, easy cleaning from inside your home.*



2-lite

Both sashes slide open and closed.



3-lite

In a 1/4-1/2-1/4 configuration the center sash is fixed while the two side sashes slide open and closed for ventilation. Also available in a 1/3-1/3-1/3 configuration.

# Casements

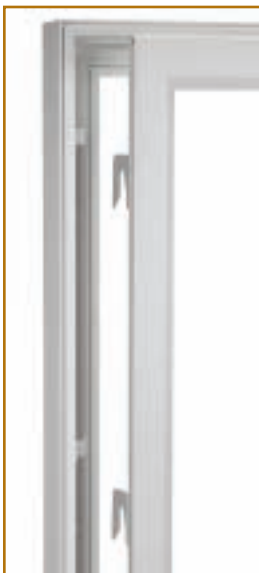


Casement windows define a special look and feeling for your home. Whether in multi-window configurations or as individual windows, casements offer many aesthetic choices.

Our single-lever lock handle effortlessly engages and locks multiple lock points within the casement mainframe when closed. Our easy to use, durable, crank handle and hardware assures that you will be able to open and close your casement windows with ease, so that you can enjoy those beautiful days and evenings in style, comfort and security.



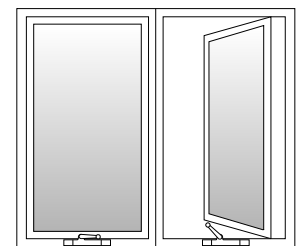
*Robust strength in a low-profile, optional fold-down handle design. Easy to open and close handle and hardware last a lifetime.*



*Hidden corrosion-resistant steel locking claws engage in self-lubricating keepers, ensuring a positive, secure and weather-tight seal.*



*Multi-point lock activator engages or disengages multiple sash locks with one easy single lever design.*

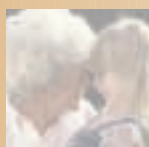


Interior view

*Unique hinge design allows you to slip your arm between the sash and frame for unbelievably easy cleaning of the outside of the window from the inside of your home.*



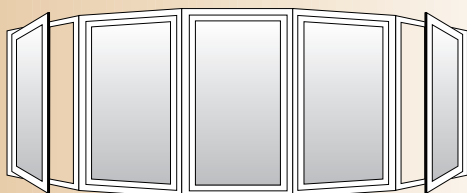
# Bows, Bays & Gardens



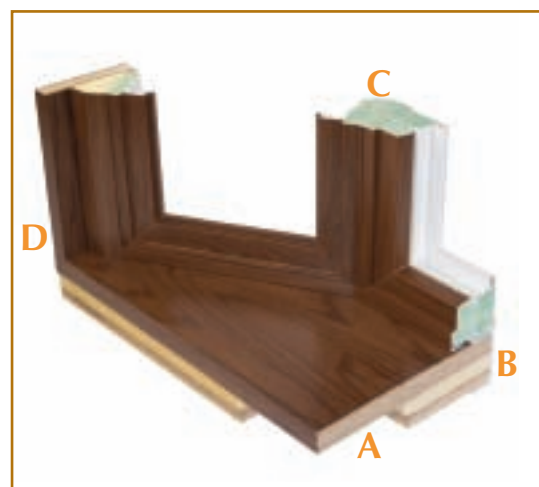
Thinking of a room addition? Think about a stunning new bay or bow window. Or, if you are contemplating a kitchen or bath remodel, include our beautiful garden window in your plans.

No other window style will actually change the look and feel of a room like a bay, bow or garden window, at a fraction of the cost of a major remodeling job.

Your Imperial LS bay, bow or garden window comes packed with features other manufacturers omit or charge extra for. Each and every bay, bow or garden window shell features a full 1 1/4" thick furniture grade laminated hardwood (Birch is standard) seat, head and side jamb along with edge banding for a finished touch of class. We include an R-9 Super-Seat™ that features high-density polyisocyanurate foam to fight condensation and energy loss with a protective capping.



Exterior view



*Sectional portion of typical Bay window construction highlighting performance features to enhance your home.*

*A. 1.25" thick laminated hardwood.*

*B. Standard R-9 insulated seatboard with 3/4" exterior-capped plywood.*

*C. All window and mull cavities are insulated completely with Comfort-Foam™ for maximum energy efficiency.*

*D. Factory finished interior edge banding is beautiful protection for your Super-Seat™.*

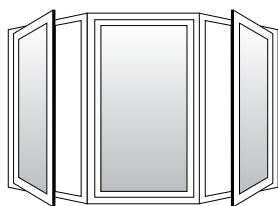


Each mullion and window frame is also fully Comfort-Foam™ insulated for maximum energy savings, the highest possible!

Of course, you have your choice of operating or fixed casement windows or double hung windows in your bay or bow.



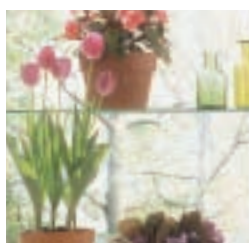
*Weather-resistant factory-applied exterior seal.*



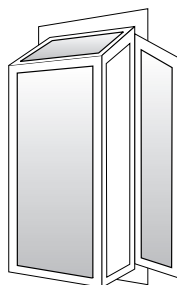
Exterior view



Our Garden Vue™ window is designed to combine the aesthetic appeal of clean lines with a structural design that assures lasting durability. It features specially-built trapezoidal operating side casement windows that open wide to let you enjoy the outdoors from the comfort of your home. Full trapezoidal screens cover the interior openings. Dual compression seals and locking hardware on the casements provide air and water tightness while weep channels at the window's top and bottom keep the interior dry. The Garden Vue™ window comes standard with adjustable height, PVC-coated shelves or optional glass shelves.



Optional glass shelf



Exterior view.  
Window opens to a wide 70 degree angle.





# French Hinged Doors



Elegance, style and versatility allow you to be the architect when it comes to specifying your new patio door from Soft-Lite.

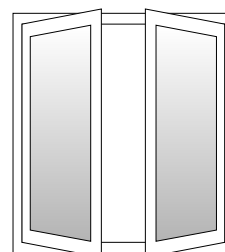
Choose a center-hinged Bellemeade XLS™ door with a fixed side panel or a more traditional side hinged French style door (shown above with optional side lite panels) with both panels that operate. The choice of style and options are only limited by your creativity. Rich interior wood grains along with many exterior color choices will embolden your creative spirit.

Internal lift and tilt blinds (shown above) add a refined touch, hermetically sealed and protected from dirt, dust, pets, and children. Brushed nickel or brass hardware is available.

Security has never been more important than today and our Bellemeade XLS™ hinged doors all come standard with four individual laminated steel locking bolts, two of which are hook-shaped to actually reach out and grab the side jamb for optimum strength and security.



*Brushed nickel-finish handle. Also available in polished brass.*

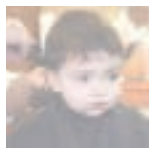


Interior view



# Thermal

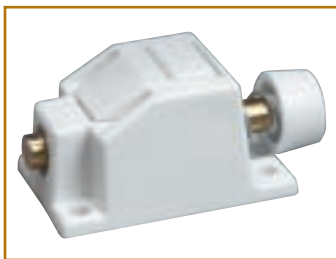
# Glide™ Doors



Our very popular Soft-Lite Thermal Glide™ sliding patio door is always easy to operate utilizing four heavy-duty steel rollers on each operating door panel.



Security has never been better in a sliding patio door with our optional four point multi-directional locking system.



*Our optional heavy-duty patio door vent stop adds security while allowing ventilation.*



Frustrating old sliding door designs skimped on the screens. Often you will find the screen and frame resting alone at the side of the house, forgotten and unused because it was flimsy and always fell off the slide rail. Your Thermal Glide™ sliding patio door screen is built to remain strong by using a heavy duty extruded aluminum screen door frame which resists twisting, warping and "rack jumping."

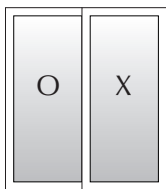


*Optional brushed nickel-finish handle. Also available in polished brass.*

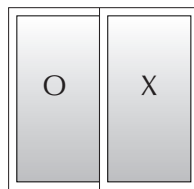


*Outside view.*

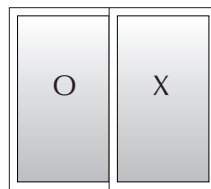
## Patio Door Configurations



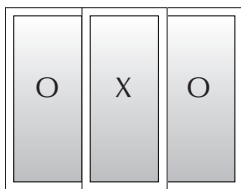
5'0" x 6'8"



6'0" x 6'8"



8'0" x 6'8"



9'0" x 6'8"



12'0" x 6'8"

"O" designates fixed panel.  
"X" designates operating panel.

All perspectives viewed from inside looking out.

Choose your preference of right-hand or left-hand operating panels.

# Technical Information

## WHAT MAKES SOFT-LITE IMPERIAL LS™

**WINDOWS BETTER?** Shop and compare. We think you will see why Soft-Lite Windows are one of the best investments for your home. **Technology, engineering, craftsmanship, robotic precision manufacturing and people who care** about every single window we make means that we will manufacture only the best for you.

## uPVC FRAMES AND SASHES

All of our windows are made using the finest quality, specially blended, un-plasticized poly vinyl chloride, or uPVC, frames and sash. Your window frame and sash material will **never rot like wood windows** are prone to do; it

will **never corrode like metal windows.**

uPVC is good for the environment because it saves energy better than other materials. It never needs refinishing (no need to use environmentally harsh varnishes or stains) and it lasts much, much longer than wood or other materials. This inherent durability means that the likelihood of having to replace your uPVC windows again in

the future is much less than if you used wood or metal.

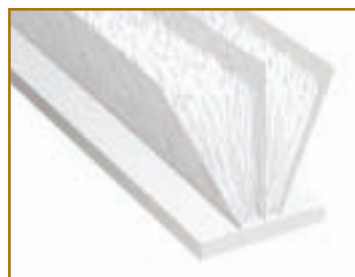
It is also important that you choose **WELDED vinyl windows** because the corners are **permanently fused** together and **will never separate.** Many vinyl windows today are screwed or stapled at the corners just like wood or metal windows. Some are welded on very old, single- or double-weld machines. The corners can separate and leak air and water. Choose only fusion welded vinyl produced with robotic 4-point welding equipment.

## COMFORT-FOAM™ INSULATION

*(depicted in illustration at right)*

Using our CFC-free, environmentally-friendly Comfort-Foam™ insulation within the cavities of the vinyl frames saves even more energy. This means **lower monthly fuel bills, energy conservation and helping save the Earth's resources.**

## ULTRASmart™ WEATHERSTRIPPING



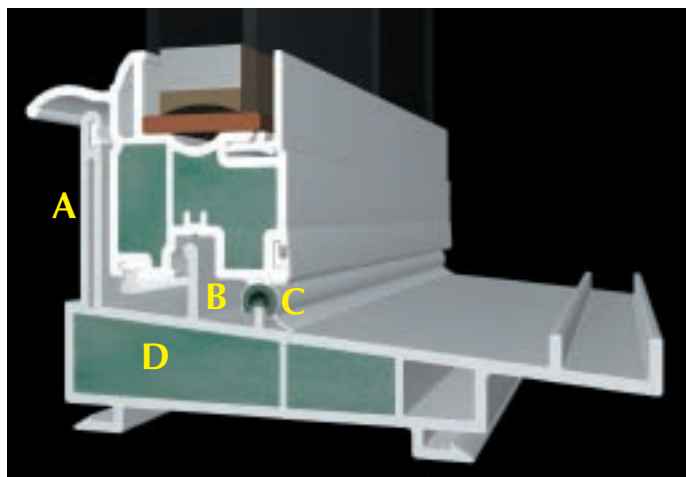
Ultrafab® Tri-Fin® Gold Series weatherstripping with built-in Ultra-Fresh® antimicrobial protection minimizes drafts, dust, and pollen and fights the growth of mold on the weatherstripping material.

600 inches of UltraSmart™ weatherstripping is used in an average sized double hung window.

## INSULATED GLASS PACKAGES

Our technologically-advanced, robotically manufactured insulated glass packages offer a choice of insulating performance which can be tailored to your geographic location. The finest in multiple layered glass and argon or krypton insulating gas, along with super energy efficient “warm edge” sealing technology, **assure maximum energy savings and resistance to condensation.**

## DOUBLE HUNG SILL/SASH PROFILE

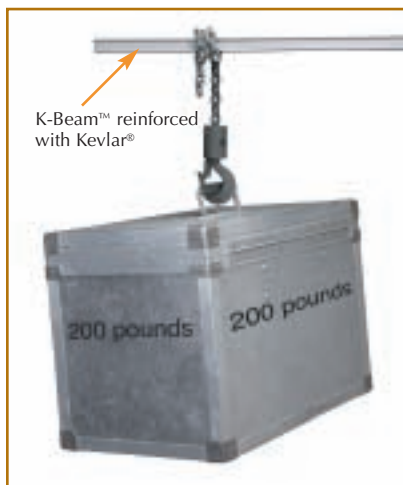


- A. A unique sill dam which extends into the window mainframe for unitized strength and seal.
- B. Our interlocking sill-sash rail keeps the sash in place against the sill dam weatherstrip when the window is under extreme wind-load stress.
- C. Our Q-Ion® compression gasket system straddles the sill rail when the sash is locked shut to add barriers and diversions for impressive water resistance.
- D. Comfort-Foam™ insulation.





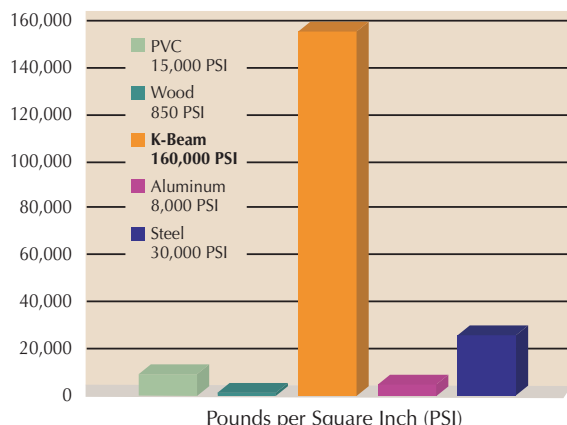
## COMPOSITE SASH RAIL REINFORCED WITH KEVLAR®



Patent-pending K-Beam™ features DuPont® Kevlar® that is also used to make bullet-proof vests and in Mars Pathfinder ropes, U.S. Navy mooring ropes, jet engine shields, run-flat tires, safety gloves in glass and metal factories, kayaks, skis, helmets, racquets and lots more.

DuPont™  
**KEVLAR®**

### K-BEAM™ STRENGTH



K-Beam™ is over **5 times stronger** than steel. It is also more than **700 times warmer** than aluminum, which means that it blocks the transfer of heat and cold 700+ times better than aluminum.

We reinforce the sash keeper rail in our double hung and slider windows with a unique resin-based glass-filled composite material. K-Beam™ utilizes Kevlar® fibers for additional **strength and the lowest thermal conductivity** meaning **extra energy efficiency**. Most manufacturers of vinyl windows today use aluminum or steel to reinforce their vinyl, which works like a thermal short circuit due to the poor thermal properties of the metal. K-Beam™, our advanced composite reinforcement with Kevlar®, assures **maximum strength, energy efficiency and durability** for the life of your home.

## ENDURA-FORCE™ BALANCE SYSTEM

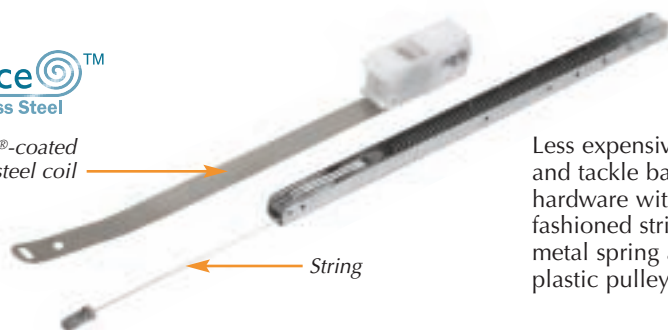
When you choose a double hung window configuration there are additional features to look for. A sash can be moved up and down for ventilation purposes. Insulated glass is heavy, especially if you are using the higher insulating and more energy efficient triple pane glass combinations of today. Balance hardware is used to help offset the sash weight so that a homeowner can operate their window with ease.

There are several balance types in use today. It's important to know the differences because they can make a big impact on how smoothly your windows operate over time. Soft-Lite uses a **new, heavy-duty, constant-force balance**. Our balance is a **Teflon®-coated, stainless steel coil** protected inside a thermal housing which makes it **strong, silent and thermally superior**.

With a 3/4" inch steel band width and a fully encapsulated thermal chassis that resists dirt and dust accumulation, our Endura-Force™ balance system will give you decades of **effortless, maintenance-free operation**. Spiral balancers are a thing of the past. Block and tackle balancers depend on a string, a spring, and pulleys that are housed in a metal chassis that does not help the thermal performance of the window they are in. These are among the reasons we developed the Endura-Force™ system and made it a standard part of every Imperial LS double hung window.

**Endura-Force™**  
Teflon-Coated Stainless Steel

Endura-Force™ Teflon®-coated  
AAMA class 3 stainless steel coil



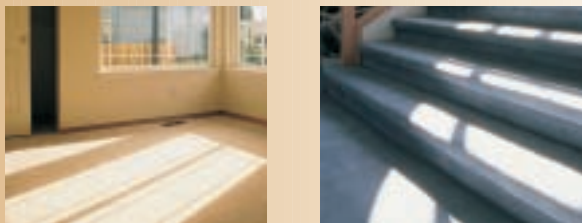
Less expensive block and tackle balance hardware with old-fashioned string, metal spring and plastic pulleys.

# High-Performance and Energy Efficiency

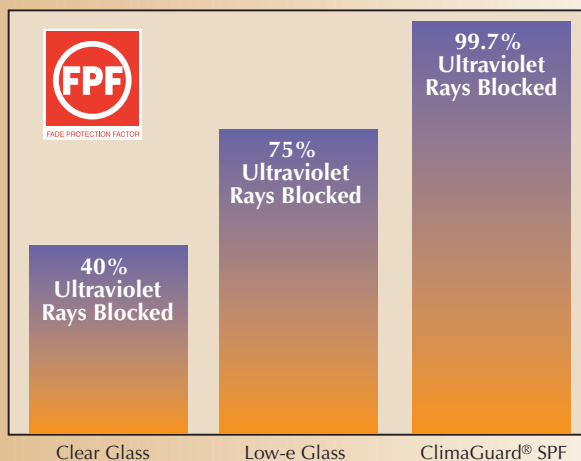
## Clima-Guard® SPF

UV light is responsible for up to 60% of fading damage. Now you can protect your furnishings and carpet with Clima-Guard® SPF, available from Soft-Lite®. Clima-Guard® SPF offers the best performance in fade control and uses the most advanced coating technology available today.

Clima-Guard® SPF blocks 99.7% of harmful ultraviolet light. It gives you high visible light transmittance with extremely low fading characteristics.



UV Light is responsible for up to 60% of fading damage. Fade Protection Factor (FPF) provides homeowners with a clear indication of fade protection.

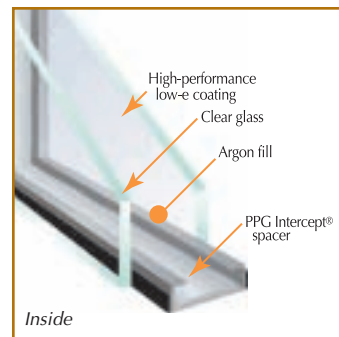


**Clima-Guard® SPF is NOT low-e glass. Its dedicated function is to prevent UV-A and UV-B rays from entering your living space.**

## Energy Efficient Glass

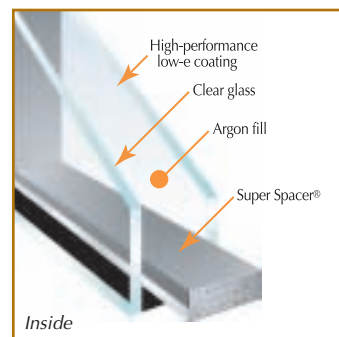
### Double-Pane with Intercept®

- 7/8" insulated glass with argon gas
- Utilizes the most advanced low-e coating available in the industry today.
- Sealed with PPG Intercept® spacer to reduce condensation.
- Warranted for a lifetime against seal failure.
- Reduces outside noise and fabric fading.
- Center of glass R-value of **3.8 SSB; 4.0 DSB**.
- Condensation Resistance Factor of **53**.



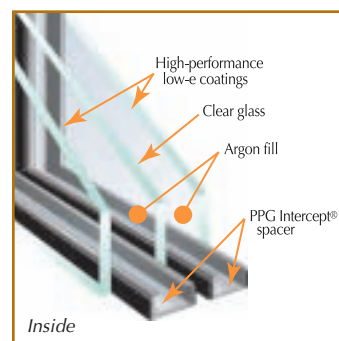
### Double-Pane with Super Spacer®

- 7/8" insulated glass with argon gas
- Utilizes the most advanced low-e coating available in the industry today.
- Sealed with Super Spacer® warm edge technology to reduce condensation.
- Warranted for a lifetime against seal failure.
- Reduces outside noise and fabric fading.
- Center of glass R-value of **3.8 SSB; 4.0 DSB**.
- Condensation Resistance Factor of **58**.



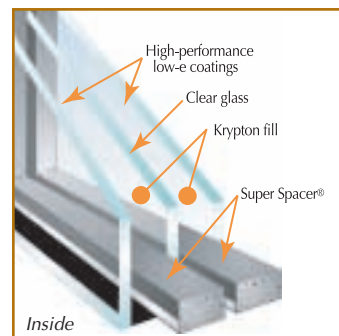
### Ultra™ Triple-Pane with Intercept®

- 1" insulated glass with argon gas in both chambers.
- Utilizes the most advanced low-e coating available in the industry today.
- Sealed with PPG Intercept® spacer to reduce condensation.
- Warranted for a lifetime against seal failure.
- Reduces outside noise and fabric fading.
- Center of glass R-value of **6.7**.
- Condensation Resistance Factor of **62**.



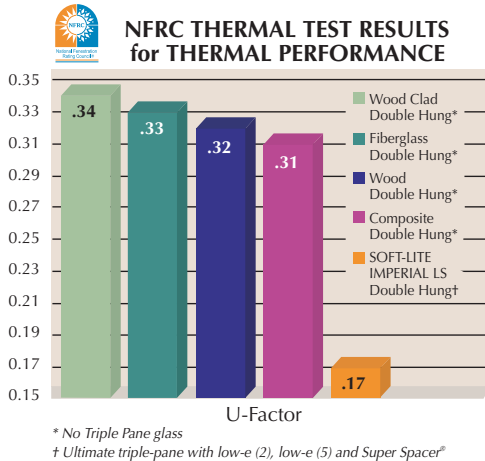
### Ultimate™ Triple-Pane with Super Spacer®

- 1" triple pane glass with two panes of low-e coating and one pane of clear glass with krypton gas in both chambers.
- Sealed with Super Spacer® warm edge technology to reduce condensation.
- Warranted for a lifetime against seal failure.
- Reduces outside noise and fabric fading.
- Keeps room comfortable all year round.
- Center of glass R-value of **10.0**.
- Condensation Resistance Factor of **72**.





# Certification

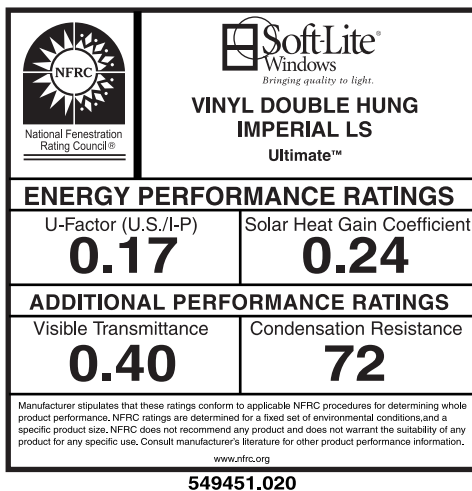


## THERMAL PERFORMANCE

1. U-Factor
2. Solar Heat Gain Coefficient
3. Visible Transmittance



The **National Fenestration Rating Council** ([www.nfrc.org](http://www.nfrc.org)) is an independent agency organized to help you quantify manufacturer's thermal efficiency claims. Working closely with Energy Star to help consumers fight the waste of valuable energy, the NFRC measures the overall thermal performance of a test specimen window. The official results are published on the NFRC label that is placed by the manufacturer on every window. Results are also published on the NFRC website. The glass package, the window material and its components, and the form and function of the window selected will affect the overall U-factor of the finished product. The lower the U-factor is, the better the window's overall thermal performance. Soft-Lite worked deliberately to design Imperial LS with key thermal features that make it one of the best-performing windows you can buy. We have selected materials for our product that work well together as a system to produce the lowest possible U-factor so you can stop wasting energy and live in a more comfortable, efficient, and beautiful home. Imperial LS is one of the best-performing NFRC certified products in the window industry.

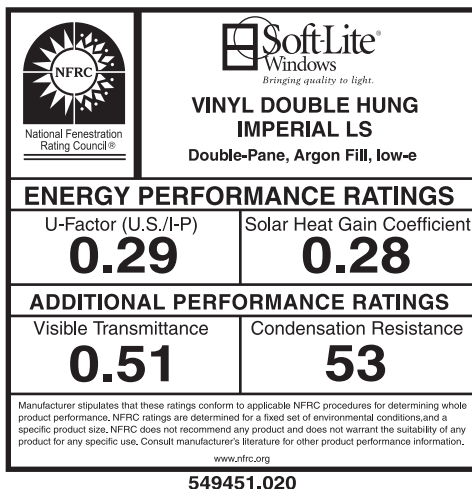


## STRUCTURAL DESIGN PERFORMANCE

1. Air Leakage
2. Water Penetration
3. Wind Load Design Pressure



The **American Architectural Manufacturer's Association** ([www.aamanet.org](http://www.aamanet.org)) is the source of performance standards, product certification and educational programs for the window, door and skylight industry. Soft-Lite has been an AAMA Gold Label Certified Member which is the highest available designation, for many years. AAMA executes no test for thermal performance like the NFRC. Instead, AAMA measures and quantifies the overall performance characteristics of the window design itself. First, the test specimen window is tested for air leakage by a fraction of cubic feet per minute at 25 mph winds. Next, the same window is subjected to the equivalent of an exceptional 8" per hour rainfall at increasing wind speed until water actually penetrates established barriers and diversions in design through the window. Finally, the same window is blown dry under increasing wind speed until it eventually breaks. Imperial LS is one of the best-performing AAMA Gold Label Certified products in the window industry.



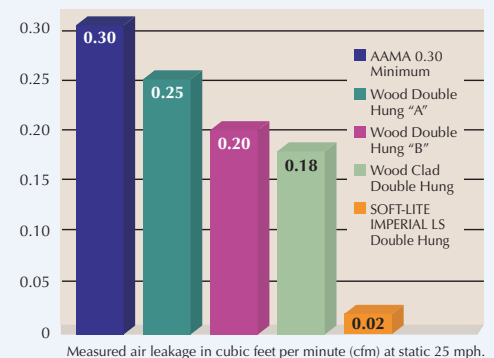
*"I visited the AAMA and NFRC websites. After finding out what those two organizations are all about, I'll never buy a window or door that doesn't carry the AAMA and NFRC labels."*

— Bob Michaud

## AAMA PERFORMANCE RATINGS

AAMA Criteria	Industry Minimum	Soft-Lite Imperial LS	Results
AIR	.30	.02	15 times better
WATER	33 mph	59 mph	79% better
STRUCTURAL LOAD	94 mph	195 mph	2 times better

## AAMA GOLD LABEL CERTIFICATION for AIR PERFORMANCE



# Designer Glass

A true work of art, every custom designer glass unit is hand cut and assembled to your specifications, to fit your tastes and the size of your custom window choice. Then it is sealed between two panes of glass for an energy efficient, beautiful addition to your home. All designs consist of triple-pane insulated clear, textured or colored glass held together by your choice of metal coming. Our products are LEAD FREE. We offer four coming options: Zinc, Brass, Patina, & Nickel.

*A silver, gold, or black aluminum spacer is used to match your selection. Unit designs may vary based on size and can be tempered or annealed, however any unit 15 square feet or over must be tempered for safety reasons.*



Avondale



Gretna



Keokuk



LaCrosse



Natchez



Savanna



Tallulah



Colonial



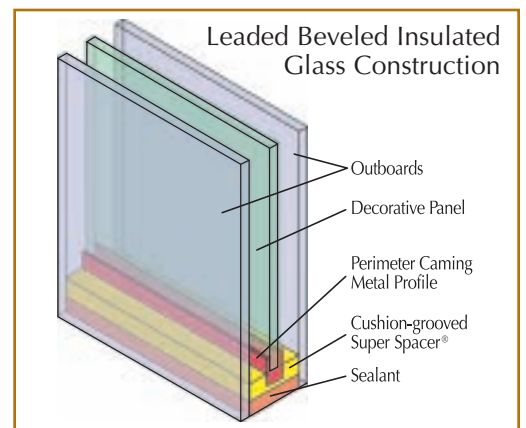
Diamond



Double Prairie



Florentine



## Stained Glass Colors and Textures



100W



136RR



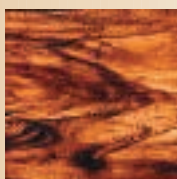
142RR



161A



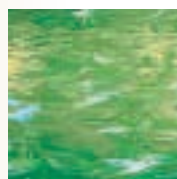
Irid1



41115G



1308V



3291S

## Caming Options



Brass



Nickel



Patina



Zinc



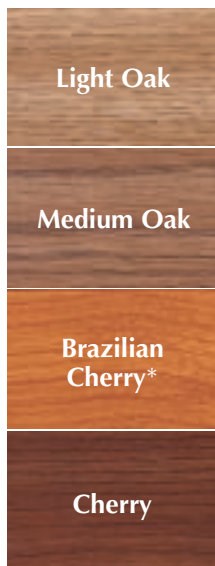
# Additional Options

## Interior/Exterior Vinyl Colors



*\*Coming soon.*

## Interior Woodgrain Colors



## Exterior Foil Laminates\*



## Standard Exterior Vinyl Colors



Additional custom colors to match any exterior available. Please see your Soft-Lite Dealer for details about our custom color program!

Actual color samples may vary from printed brochure. See your Soft-Lite Dealer for more precise color representations.

# Decorative Grids

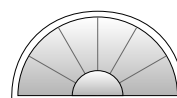


Standard grids

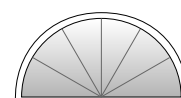


Contour grids

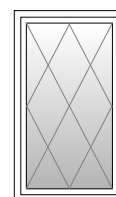
Standard and contour grids offered in a variety of options. Actual color samples may vary from printed brochure. Grid patterns vary based on size and configuration of window. See your Soft-Lite Dealer for more precise color representations and configuration availability.



Sun Burst  
(standard only)



Star Burst  
(standard and contour)



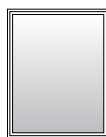
Diamond  
(standard only)



Colonial  
(standard and contour)

# Special Shapes

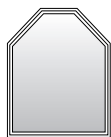
For special openings we offer special shapes with matching frame profiles and glass options. All special shapes are custom built, like all of our windows, to your specifications.



Rectangle



Arch Top



Double Clip Corner



Oval



Hexagon



Octagon



Circle Top



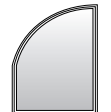
Elliptical



Partial Elliptical



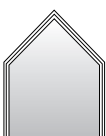
Quarter Round



Uneven Leg Arch



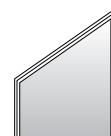
Eyebrow



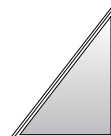
Peak Pentagon



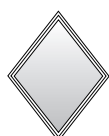
Angled Pentagon



Trapezoid



Right Triangle



Diamond

# Miniblinds

Never clean miniblinds again. All windows (except awning windows and some special shapes) are available with internal miniblinds in a tilt-only option. Patio doors are available with internal miniblinds that both tilt and raise. Certain restrictions apply.



Internal miniblinds are available in white, beige, cream and chrome.





*Imperial* *Authorized Dealer*  
LS

LITSL-IMPLS

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