

VENETIAN SHADES

Component Specification for 25mmVB system

HD Headrail

Code : **L13-1**
Description : Rollformed U-profile
Material : Steel 0.5 mm
Finish : colour according to order
Dimensions : 25 x 24 mm

HD Bottomrail

Code : **L13-3**
Description : Rollformed C- profile
Material : Steel 0.5mm
Finish : colour according to order
Dimensions : 19.5 x 10mm

Ladder string

Code : **L13-18a**
Description : Braided stringtape, two parallel twisted ladder threads
Material : High tenacity polyester
Finish : Colour according to order
Pitch : 21.5 mm
Width : 28 mm

Cord 1.4mm

Code : **L13-19a**
Description : Round braided Nylon cord
Material : High tenacity polyester
Finish : Colour according to order
Diameter : 1.2 mm

Tiltrod

Code : **V13-14**
Description : D-shaped tilt rod
Material : Steel, cold rolled
Dimensions : 4 mm

Bearing Bracket

Code : V13-6
Description : 25mm Tape roll support: allows easy cording and insertion of tape roll from below.
Material : Polyetherimid (PEI), wear resistant plastic
Finish : Colour white

Tape roll

Code : V13-7
Description : Plastic tape roll with tape retaining clip, small diameter for light operation and optimal closure
Material : Polyetherimid (PEI), wear resistant plastic
Finish : colour white

Wand Tilter

Code : V13-28
Description : 25mm Wandtilter, 1:10 gear ratio for light and positive tilting: suits 4mm D-shaped
Material : SAN / Polycarbonate / Polyacetal
Finish : Transparent

Cord Lock Right Hand

Code : V13-32c
Description : 25mm Cordlock, suited for 2 to 6 cords: two serrated locking Rolls clamp the cords against a serrated surface : a wire bracket is Included for cord retaining and separation: included one sided metal protector for wear & tear resistance and smooth operation.
Material : Polycarbonate / Brass / Steel (zinc plated)
Finish : Transparent

Cord Lock Left Hand

Code : V13-32d
Description : 25mm Cordlock, suited for 2 to 6 cords: two serrated locking Rolls clamp the cords against a serrated surface : a wire bracket is Included for cord retaining and separation: included one sided metal protector for wear & tear resistance and smooth operation.
Material : Polycarbonate / Brass / Steel (zinc plated)
Finish : Transparent

Cord Corrector

Code : V13-26b
Description : Cord connector 1.2, allows leveling of up to 4 1.2 mm
Material : Polycarbonate
Finish : Colour according to order

Clear Wand Hollow / Clear

Code : V13-25a
Description : Hexagonal, hollow wand
Material : PMMA
Finish : Transparent
Dimensions : hex. 7.0 mm ?

Snap Hook for Clear Wand

Code : V13-23
Description : Wandhook connects wand to wandtilter
Material : Polycarbonate
Finish : Transparent

Snap Button for Wand Tube

Code : V13-24
Description : Wandknob, consisting of transparent knob
Material : PMMA
Finish : Transparent

Inner Button for Hollow Clear Wand

Code : V13-24a
Description : End plug for hollow clear wand.
Material : Polycarbonate
Finish : Transparent

Tassel Large

Code : V13-14
Description : Cordknob, consisting of grey cover and transparent knob, cord connected by means of bayonet lock
Material : PMMA
Finish : Transparent

Tape spacer 25mm

Code : V13-31
Description : Transparent tape spacer, quick assembly
Material : Polycarbonate
Finish : Transparent
Dimensions : 25mm

Tape Lock Button for Bottomrail

Code : V13-8
Description : 25mm Tape button, fits HD bottomrail
Material : Polycarbonate
Finish : Transparent/white

Headrail Endcap

Code : L13-9
Description : 25mm headrail endcap, fits ultimate headrail
Material : Polycarbonate
Finish : Transparent/white

Bottomrail Endcap

Code : L13-13
Description : 25mm bottomrail endcap, fits HD bottomrail
Material : Polycarbonate
Finish : Transparent/white

Wand Tilter Adapter

Code : V13-29
Description : Cover to conceal the tilter, mechanism and ensure perfect fit inside the headrail
Material : Polycarbonate
Finish : Transparent/white

Hunter Douglas Department of Process & Material Development

Specification for HD Venetian Blindstrip

1. Aluminium.

1.1 General.

The main aluminium alloy used for Hunter Douglas Venetian Blind strip 100017 is alloy AA 6011.

The chemical composition of alloy AA 6011 is in accordance with the designation of the Aluminium.

Association and is chosen for its high and stable mechanical properties.

1.2 Mechanical properties.

AA 6011 T8	100017
Tensile strength	>330 N/mm.
Yield strength	>320 N/mm.
Elongation (50mm)	> 3%

1.3 Chemical composition.

Aluminium alloy AA 6011 has the following composition:

Si:	0,6-1,2 %
Fe:	< 1,0 %
Cu:	0,40-0,9 %
Mn:	< 0,8 %
Mg:	0,6-1,2 %
Cr:	< 0,30 %
Ni:	< 0,20 %
Zn:	< 1,5 %
Ti:	< 0,20 %.

2. Pre-treatment of aluminium.

Hunter Douglas has gained an outstanding reputation for its environmentally friendly, yet top class pre- treatment systems. This pre-treatment of all cold-rolled strip guarantees a perfect and permanent paint adhesion and results in a reliable resistance against humid conditions.

3. Paintfinishes.

The chemically pre-treated aluminium strip is provided with a decorative finish suitable for interior application. This finish usually consists of one coat paint film. All finishes are applied on constantly controlled paintlines, thus guaranteeing attractive, tough, smooth and uniform venetian blind material. In this product only thin coatings are used.

The special Hunter Douglas coil coating process ensures a consistent level of colour reproduction and our method of paint application makes certain that edges are always coated. Only finishes that meet our rigid specifications are accepted. The main part of our paint systems are based on polyester chemistry. Testing is carried out in accordance with ECCA or other internationally accepted test methods and specifications.

4. Testing: Methods and specifications.

4.1 Film thickness.

4.1.1 Test method: ECCA T1

4.1.2 Conventional paints: 7-12 mu each side
Transparent metallic paints: 4-10 mu each side
Specialties: upon request.

4.1.3 Variation within one batch:

- up to 10 mu: ± 2 mu
- 10 mu and above: ± 3 mu.

4.2 Specular gloss.

4.2.1 Test method ECCA T2.

4.2.2 Conventional glossy paints: $>70\%$
Conventional s.g.(special gloss) paints: 25-50%
Specialties: upon request.

4.2.3 Gloss variation within one batch:

- up to 20%: $\pm 3\%$
- between 20 and 50%: $\pm 5\%$
- 50% and above: $\pm 7\%$

4.3 Colour difference.

4.3.1 Test method ECCA T3 (CIELAB).

4.3.2 Colour difference between batches:

- plain non-metallics: E 4 units
- others: L= ± 4 units.

4.3.3 Colour difference within one batch:

- plain non-metallics: E 2 units
- others: L= ± 2 units.

4.4 Pencil hardness.

4.4.1 Test method ECCA T4.

4.4.2 Conventional paintfilms: phh $>F$
Other systems upon request.

4.5 Adhesion.

4.5.1 Test method ISO 2409, with Scotch cellotape no. 600, 3/4" wide.

4.5.2 Conventional paints: Better than or equal to rating 1, other paints upon request.

4.6 Resistance to salt spray fog.

4.6.1 Test method ECCA T8.

4.6.2 After 100 hours testing undercreep from the (unprotected) edges nor from the cross shall exceed 2mm.

Blistering shall not exceed F 8, according to ASTM method D714-56.

4.7 Water immersion resistance.

4.7.1 Test method ECCA T9

4.7.2 After 100 hrs testing blistering shall not exceed F 8, according to ASTM method D 714-56.

4.8 Colour fastness.

4.8.1 Test method DIN 54004.

4.8.2 All finishes shall have a colour fastness of at least 6.

5. Dimensions and tolerances.

5.1 Gauge.

The thickness of the substrate is $0,155 \pm 0,01$ mm.

5.2 Width.

The width of the strip is $25,0 \pm 0,2$ mm.

6. Shape of the strip.

Camber.

Camber shall not exceed 3 mm on 2 m striplength.