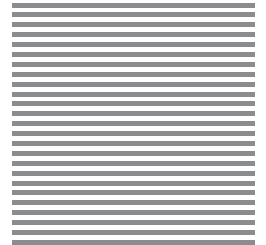


SL24P

VENETIAN BLIND



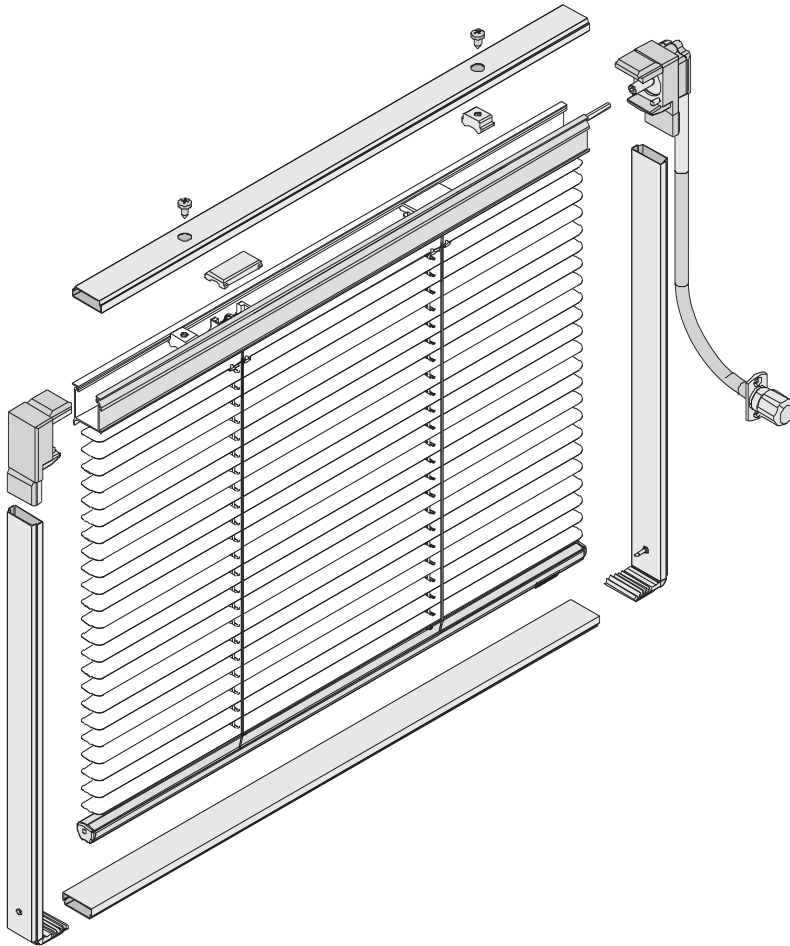
ScreenLine®

ScreenLine

double-glazed unit 24 mm

SL24P

VENETIAN BLIND



The venetian blind used in the ScreenLine® SL24P system is manufactured in accordance with high technical specifications and production standards. The venetian blind operation is achieved using a rotational magnetic transmission through the 'special' corner key, thereby guaranteeing the unit's hermetic seal. The tilting operation is achieved using a flexible wire drive via a rotational button on the window frame. The bottom rail of the blind is located on pins attached to the lateral side-guide that allow the blind to rotate through 180.

Height	300 ~ 3.000 mm
Width	190 ~ 3.000 mm
Max. Area	3 sqm

SL24P

VENETIAN BLIND

SL24P

Magnet composition

The casing is in Nylon 66 reinforced with glass-fibre. The gears and transmission components are made from carbon steel, and conventional bearings are used for the drive shafts. The worm gear is in brass. The magnets are manufactured from sintered neodymium, iron boron and have the following characteristics:

Energy produced	Bh max-Mg.Oe	33-35
Residual induction	Br-Gauss	11.000 / 12.000
Coercive force	Hc-Oestered	10.000
Maximum working temperature	°C	120
Curie temperature	°C	310
Reversible temperature factor	°C	-0.12%

Head rail

Extruded aluminium A6063S-T5 alloy. Dimensions: 23 mm width, 30 mm height + 6 mm external pelmet. Powder coated to colour co-ordinate with the slats.

Slat

Aluminium AA 6011-T8 alloy. Dimensions: 16 mm width, 0.2 mm thick.

High resistance polyester paint: available in 9 colours. The slats have a special treatment to eliminate possible paint emissions by U-V or Solar radiation i.e. non-fogging.

Solar and light performances of the slat only

SLAT COLOUR	S102	S106	S125	S130	S142	S149	S155	S156	S157
Solar reflection %	70	62	57	58	65	68	42	65	43
Light reflection %	78	72	63	65	69	75	48	62	44
Solar absorption %	31	38	43	42	35	32	59	35	57

Bottom rail

Extruded aluminium A6063S-T5 alloy. Dimensions: 14 mm width, 11 mm height - comprising two interlocking profiles. Powder coated to colour co-ordinate the slats.

Ladder tape

Thermo-fixed 100% polyester with 12 mm step.

Great dimensional stability with excellent U-V and Solar resistance.

The ladder tape has a special treatment to eliminate possible chemical emissions inside the double glazing unit due to U-V or Solar radiation. Colour co-ordinated with slats.

Cord

Thermo-fixed 100% polyester with excellent dimensional and colour stability. 1 mm dia. It is used to ensure parallelism of the ladder tape. Colour - white.

technical specification

1. technical features

Spacer bars

Electro-welded aluminium spacer bar.

Dimensions: 24 mm x 8 mm with corresponding corner keys.

Option: extruded aluminium L-profile, dimension 24 mm x 8 mm with 8 mm projection to close perfectly the gap between slats and side profile.

Standard knob

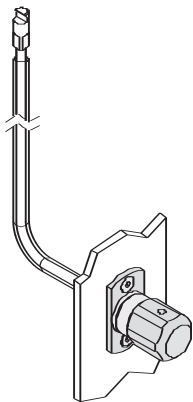
Black coated brass with mechanical stop to eliminate possible slat damage.

Flexible cable

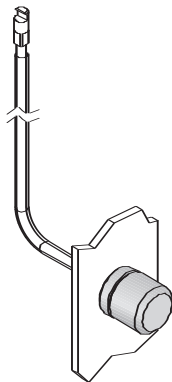
Steel cable 3.2 mm diameter - anti-twist. Protective sheath self-lubricating for longer life.

Possible choice among three types of knobs

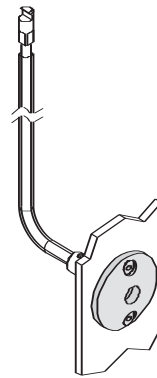
1. standard knob
2. round knob
3. hidden knob



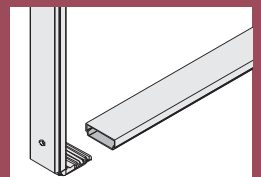
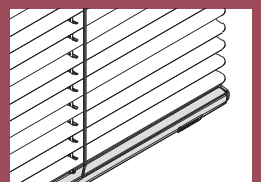
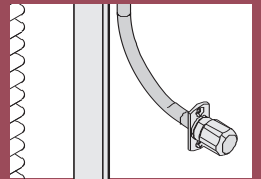
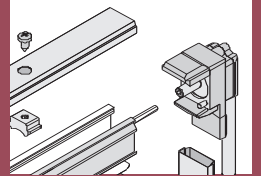
1



2



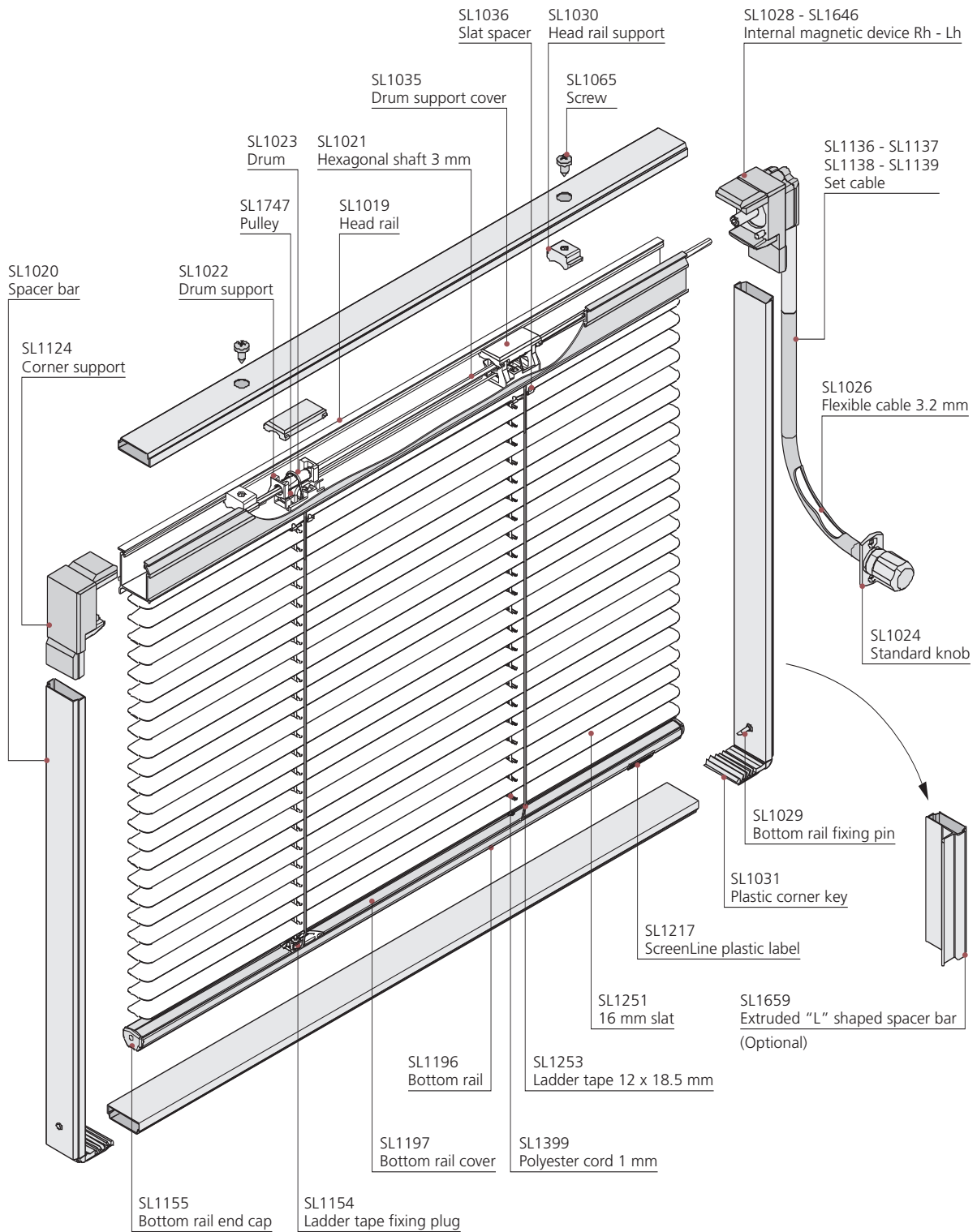
3



SL24P

2. technical drawings

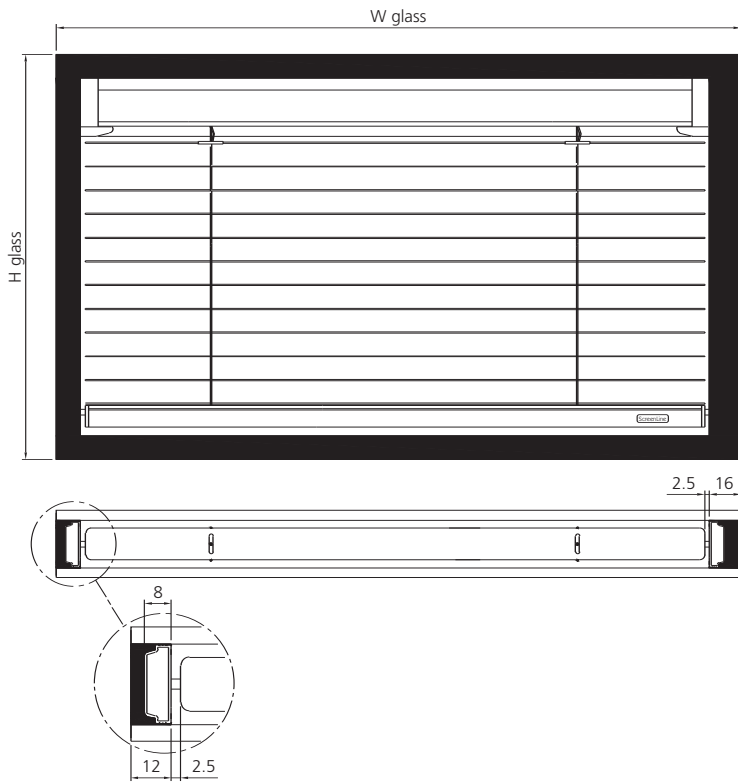
comprehensive drawing with component codes



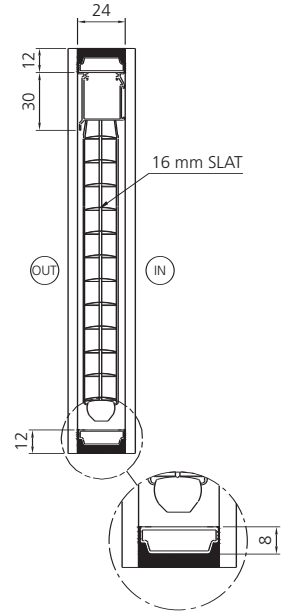
SL24P drawing with component codes

venetian blind

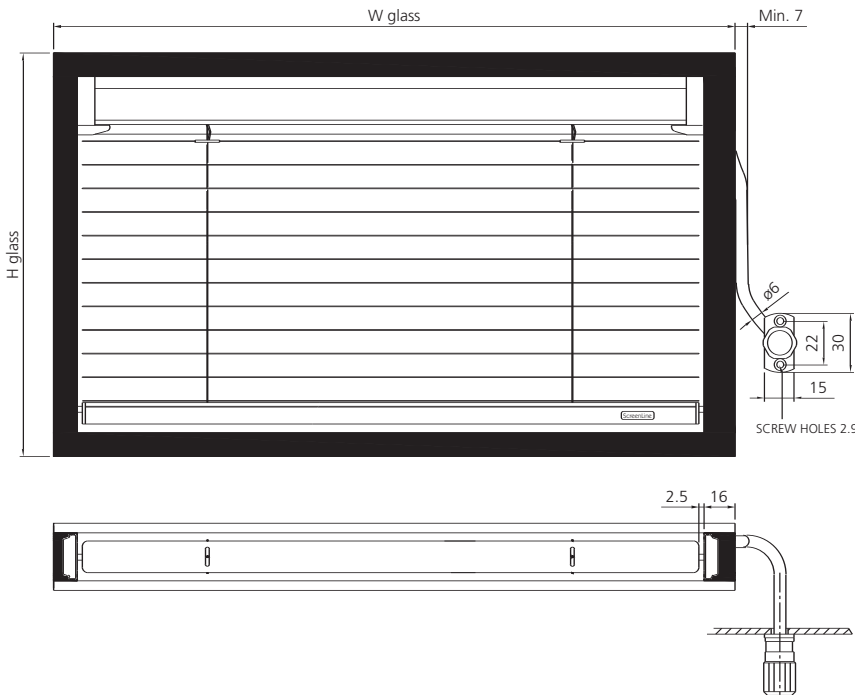
SL24P



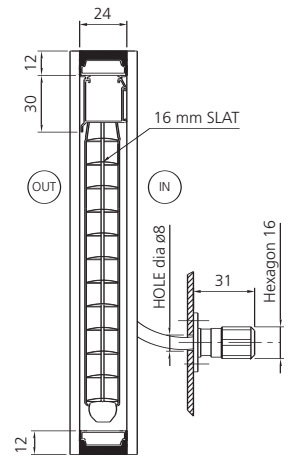
ELECTRO-WELDED SPACER BAR

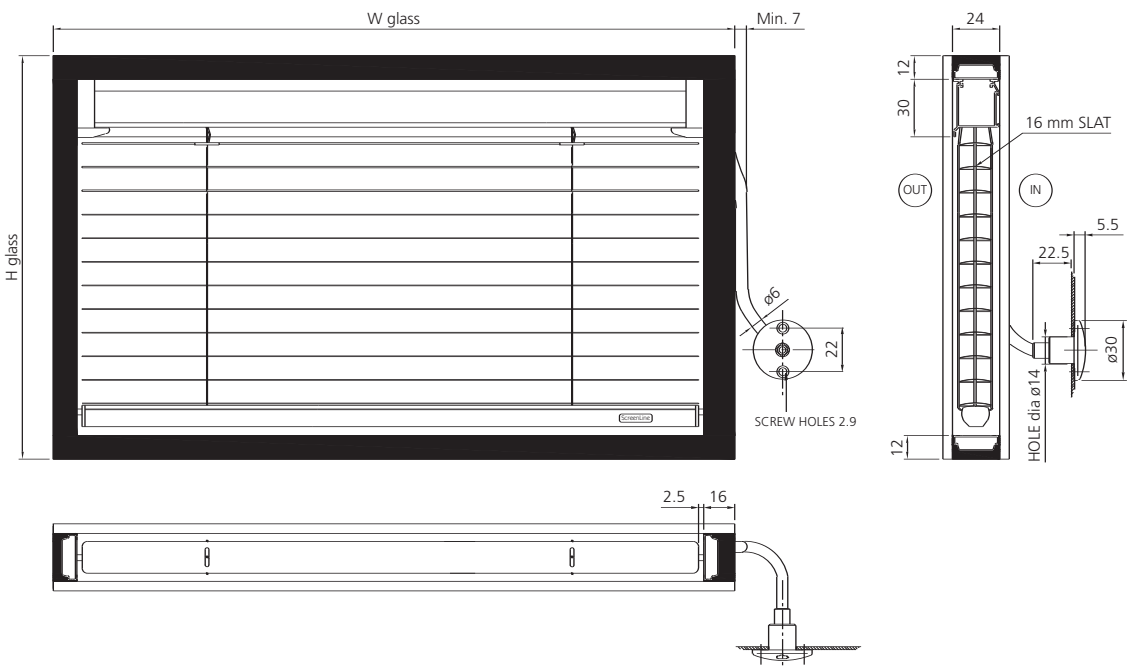
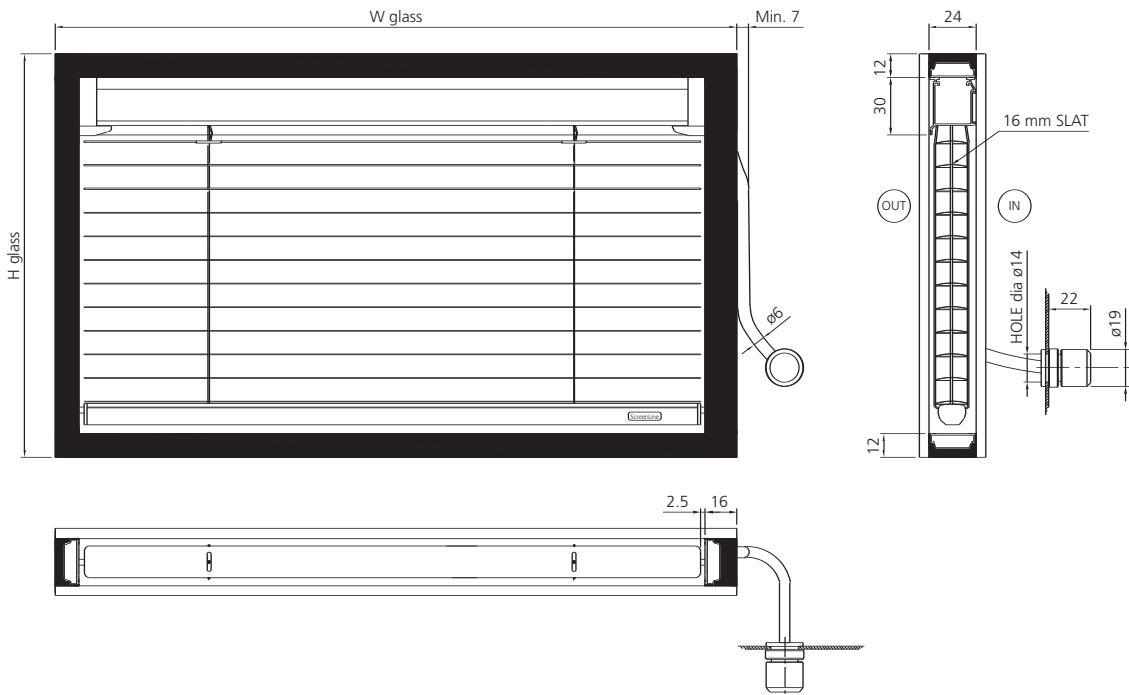


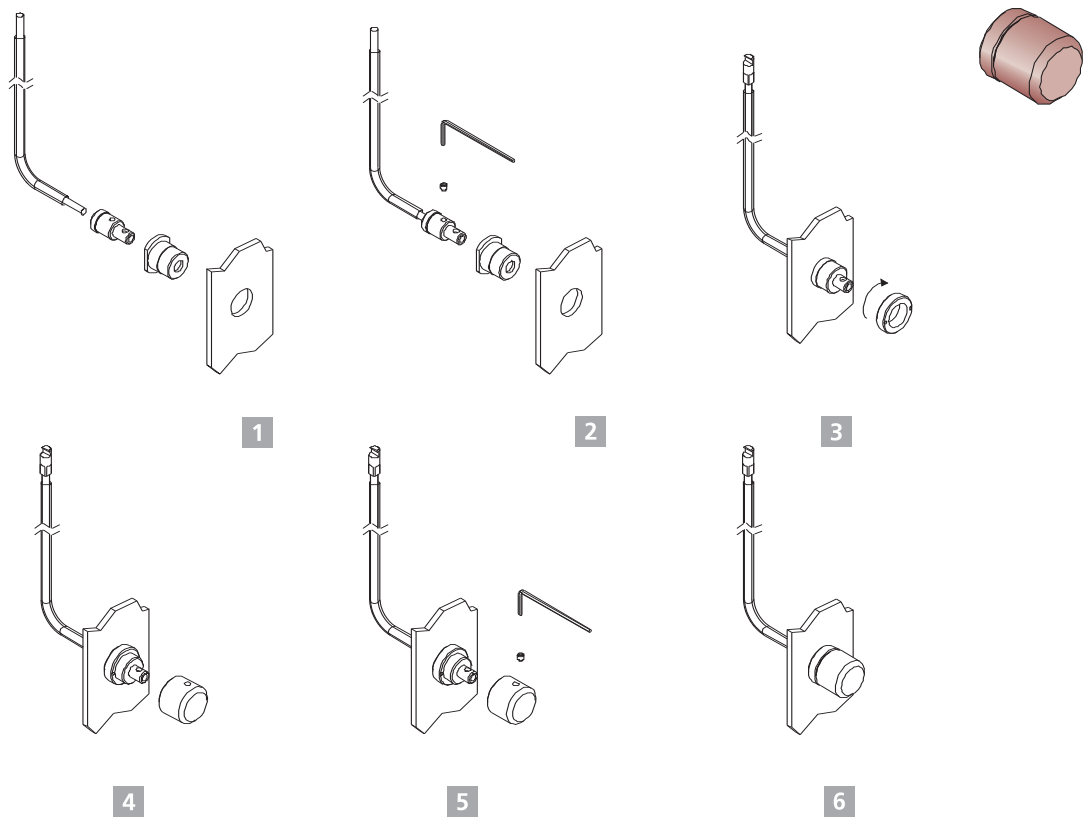
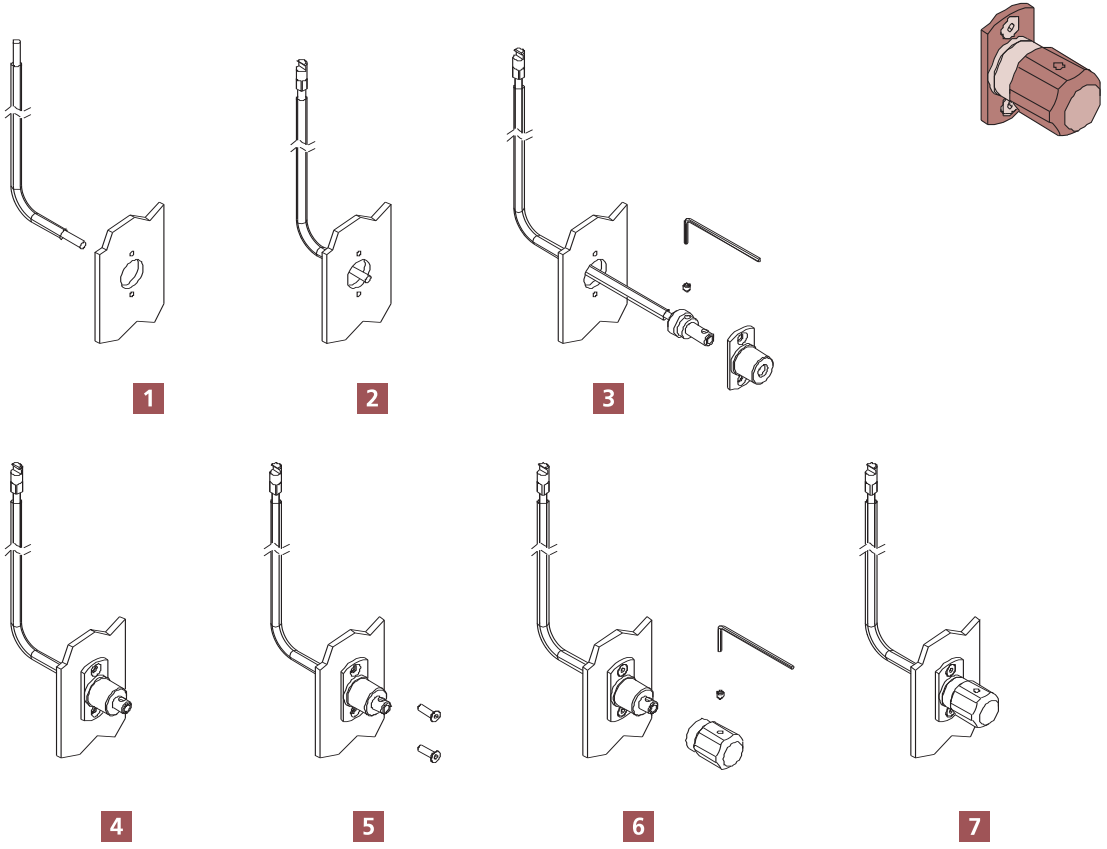
ELECTRO-WELDED SPACER BAR

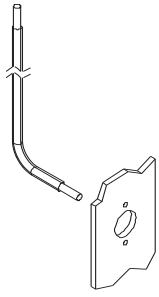


SCREW HOLES 2.9

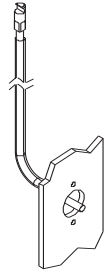




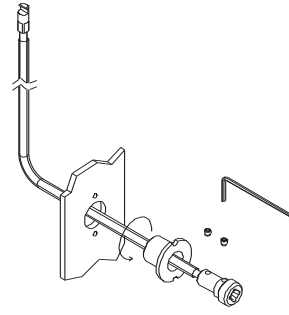




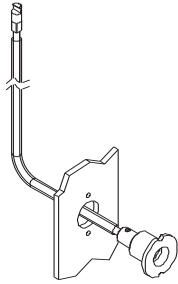
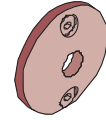
1



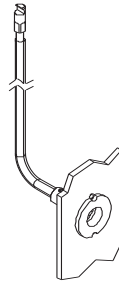
2



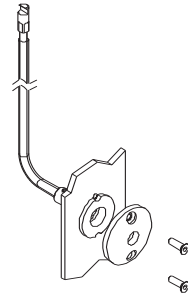
3



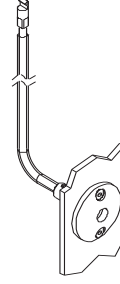
4



5



6



7

ScreenLine® kit components

On receipt of goods, check integrity of package and confirm components as detailed on Purchase Order.

The elements of the kit comprise: **A**

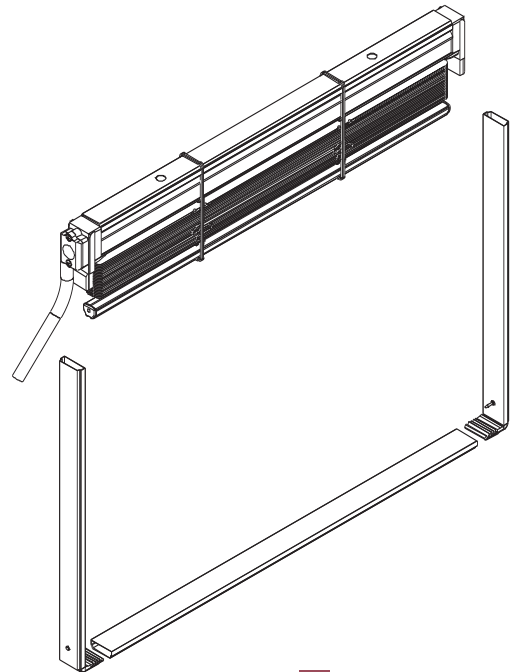
- venetian blind with head-rail / top spacer bar (attached) / special corner keys (one with flexible coupling) altogether with factory applied double sided adhesive tape
- 1 No. bottom spacer bar
- 2 No. standard profile spacer bar with 'pins' factory fixed (height)
- 2 No. standard corner keys
- standard knob control complete with flexible cable, flexible cable cover and connection.

Assembly of the integral blind unit

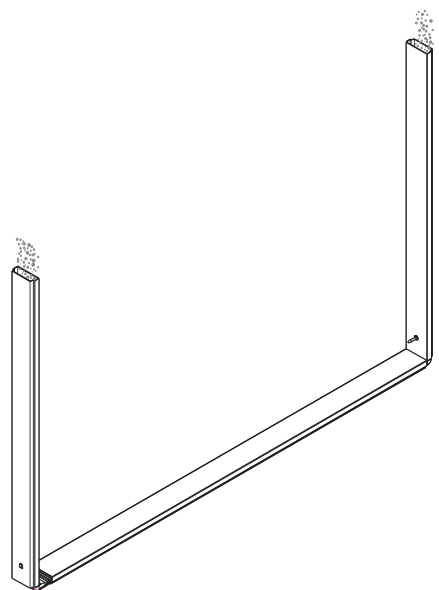
Spacer bar preparation

Fill with the required amount of molecular sieve the spacer bars. **B** Remove the plastic wrap from the head-rail / blind, unwind the cords from the head-rail but keep the slats stacked. Holding the spacer frame vertically, remove the temporary corner keys, position the head-rail / integral corner keys over their respective spacer and assemble. **D**

Extrude hot butyl on them, without interruption according to the rule EN 1279-2. **C**

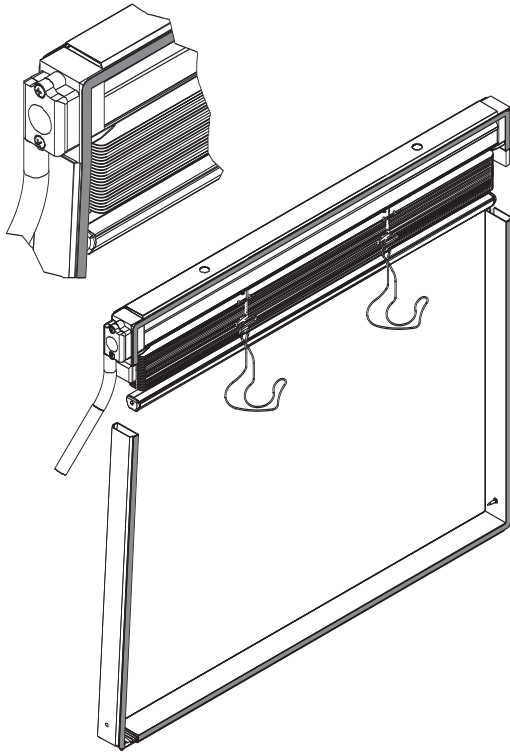


A kit composition

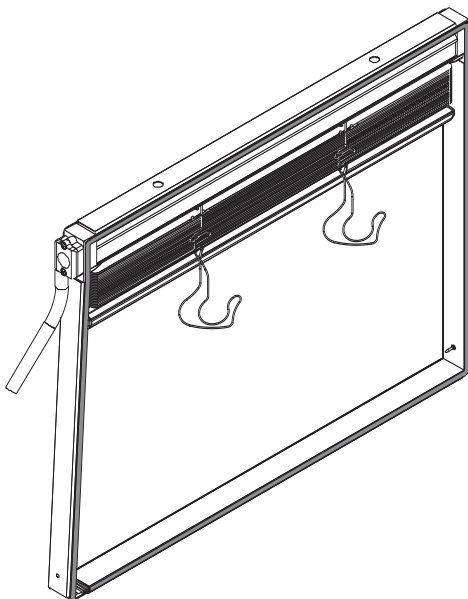


B desiccant filling

assembly instructions



C spacer assembly



D kit assembly

Line assembly

Pass the first glass through the washing machine on its base. Lower the blind within the assembled spacer frame taking great care not to damage or contaminate the slats with butyl. **E** Insert the bottom rail onto the retaining 'pin' on one side of the unit. Open the corner key in the opposite corner, locate the bottom rail on the second restraining 'pin' and then close the corner key taking care to complete the butyl seal. **E1** Position the assembled blind and spacer frame on the first clean glass **F** and ensure that it is parallel and square (no inner deflection on the vertical spacers). Press firmly to achieve good adhesion and check that there is an 8 mm clearance between the vertical spacer and the edge of the glass on the 'wire' drive side. During this operation avoid the contact between slats and butyl of the spacer bars. Ensure that the pellet of the head rail lies against the external glass and that the slats rotate and are positioned with the slat face convex to the external glass. Now assemble the clean second glass and proceed with the press machine procedure.

Gas filling

Using the appropriate equipment and following the requisite procedures replace the internal air with Argon.

Test

Prior to the final seal it is recommended that the blind operation is checked by means of the short flexible drive. The unit must be vertical with the head-rail horizontal at the top of the unit. Check that the slat clearance with the spacer bar is uniform and then rotate the slats. At the end of the test procedure, reposition the protective PVC sleeve over the wire drive.

Final seal

Rotate the slats to their mid-position i.e. open, and apply the final seal **G** according to the rule EN 1279-2. It is essential that the area around the wire drive is fully enclosed with sealant. During this operation it is important that the plastic protective sleeve covers the wire drive in order to prevent sealant contamination.

It is recommended that a small wedge is used to keep the wire drive free of the sealant until it is cured when the protective PVC sleeve may be removed. **H**

Note

SL24P systems must not be inverted (vertically or horizontally) and should only be stored or moved in the vertical plane.

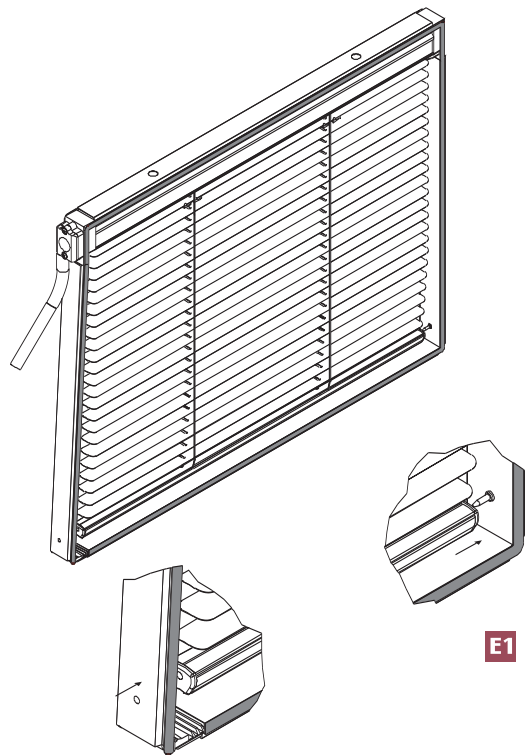
The knob control system should be in place on the window frame prior to or during glazing.

The transport of the integrated blind system must be done with the slats in the open position to avoid slat contamination resulting from contact with the primary butyl seal.

Transport and Storage

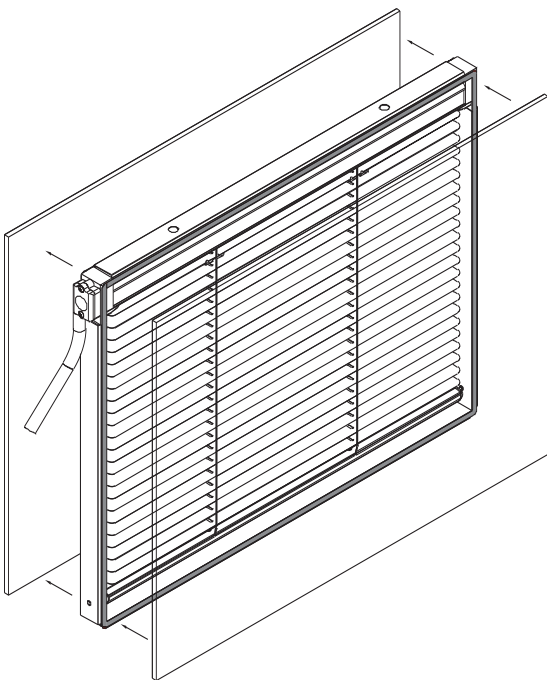
For transport and stock procedure please check the recommendations contained in the relevant part of the ScreenLine®

Technical Catalogue.

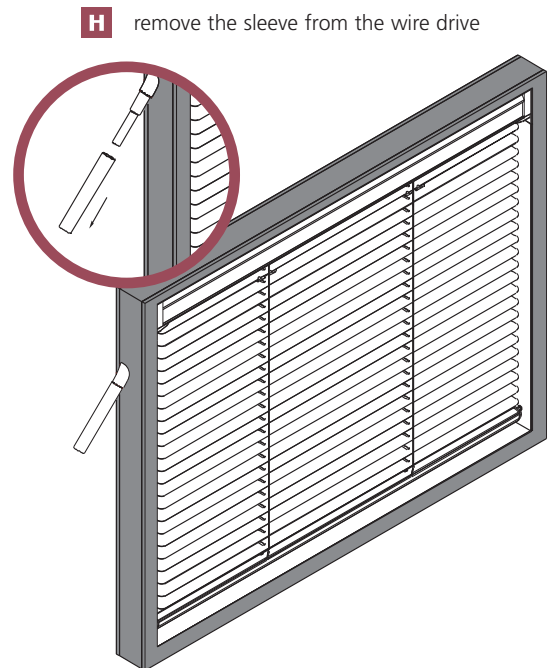


E1

E position the restraining pins into the bottom rail



F glass assembling



H remove the sleeve from the wire drive

G unit sealing