

百叶帘技术手册

Venetian Blinds Technical Manual

--Version 2024



华升实业
HUASHENG INDUSTRY
Blinds since 2006



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华升供应百叶帘&材料种类 **Supplies blinds and material types**

类型 Type	成品 Finished products	半成品 Blinds componnets	配件 Accessories
1 桐木叶片 Paulownia Slats	√	√	√
2 椴木叶片 Basswood Slats	√	√	√
3 PVC 叶片 PVC Slats	√	√	√
4 竹木叶片 Bamboo Slats	√	√	√

桐木百叶工艺流程 Paulownia blinds Process



1. 桐木林地采料（8-10 年）
1.Paulownia wood gardens.（8-10 years）



2 原木原料(直径 80cm 以上)
2.Raw material.Over 80cm in diameter



3 户外自然晾晒库存
3.Natural dry large stock paulownia wood board.



4 意大利烘干窑技术烘干原料.
4.The drying in the Italian kiln promotes the redistribution of water in the wood.



5 烘干后的材料自然养生
5.Post kiln regimen.



6 木百叶专用多片锯开片
6.Enter the cutting machine for cutting slats.



7 QC 检验木片
7.QC check the raw slats.



8 确认订单后开始机器砂光
8.Start sanding slats after the order comes in.



9 手工打磨叶片边部
9.Workers hand sanding for the edge to make sure the edge smooths.



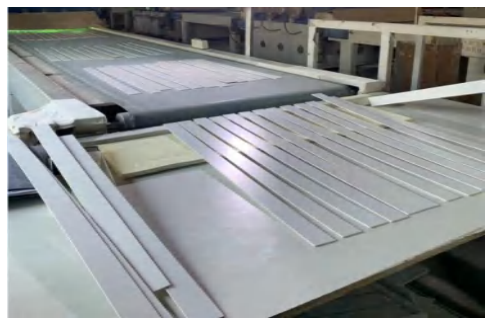
10 覆盖色叶片打底腻子（3 次）
10 Paint color Slats seal coat（3 times）



11 叶片进入喷边房进行喷边
11.Slats enter the paint room, spray edges.



12 喷边后再次砂光
12 Sanding again



11 油漆线开始油漆工艺
11.Insert paint line, producing painted.



12 最终再次进行检验
12.In the final step, workers QC each slat.

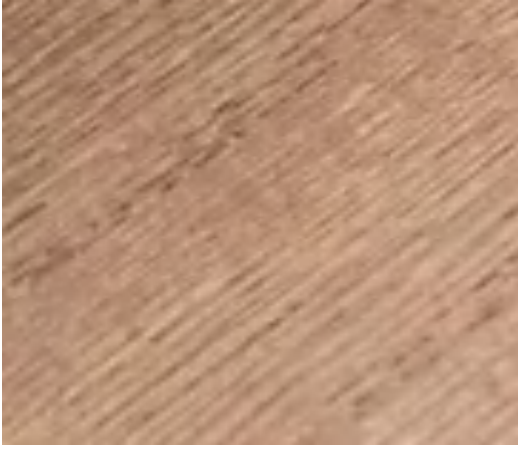


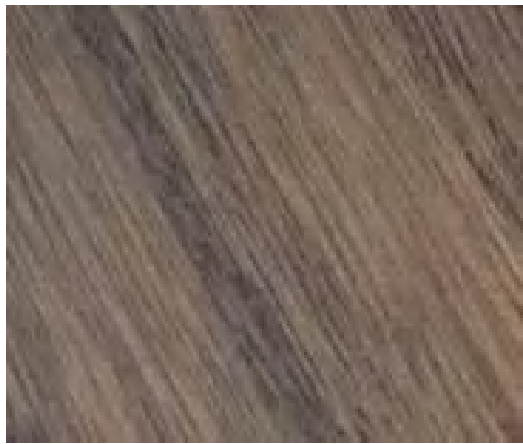
13 包装
13 Package

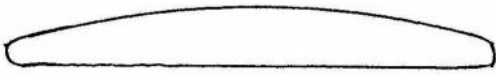
指接叶片的不同 Finger joined slats differences

	
前指接叶片： 前指接指开片前，把方木指接成长料，再进行开片。前指接叶片的宽度和实木叶片宽度一致。指接叶片可以做覆盖色和印刷色，因为有指接印一般不做染色和拉丝，但现在越来越流行用指接叶片做染色效果。 Pre finger jointed slats: Before cutting, connect the square wood with the long material and then cutting into slats. The width of the Pre finger jointed slats is consistent with the width of the solid wood slats. Pre finger jointed slats can be used for painted and printed colors, as finger joint trace generally does not made into stained and brushed colors, but it is increasingly popular to use Pre finger jointed slats made into stained color.	
后指接叶片： 后指接指把短的已经开好片的原木素片，指接为单个的长料。后指接叶片宽度会比实木叶片小 1.8mm. 同样，做染色会有指接印记。 Common finger jointed slats: Finger jointed every short raw wood material slats into long slats. The width is smaller than that of solid wood, about 1.8mm .And same,there have finger joint trace can be see on the slats face.	

桐木叶片和封板下轨款式 The style of Paulownia Slats/Valance/Bottom

叶片尺寸 Slats Size	叶片尺寸 Slats size: 25mm/35mm/50mm/63mm 实木叶片厚度 Solid wood slats Thickness: 3.0mm 指接叶片厚度 Fingering Slats Thickness: 2.8mm 	
颜色效果 Color	覆盖色 Painted / 染色 Stained / 印刷色 Printed / 拉丝 Brushed / 木蜡油色 Decking oil	
覆盖色 Painted		
染色 Stained		
印刷色 Printed		

拉丝 Brushed		
木蜡油色 Decking oil color		
B 封板 B-Valance	 3 size: 33*6.5mm 50.8*7mm 63.5*6.5mm	
B 封板带槽 B-Valance with slot	B 封板带槽，可以使用塑料封板挂钩。 B-Valance with slot, can used plastic valance clips 	

D 封板 D-Valance	 63.5*7mm	
D 封板带槽 D-Valance with slot	D 封板带槽，可以使用塑料封板挂钩。 D-Valance with slot , can used plastic valance clips 	
平面封板 Plane-Vanlance		
工形下轨 H Bottom	 25*15.5mm 35*15.5mm 50.8*16mm	
梯形下轨 T Bottom	 50.8*16mm	

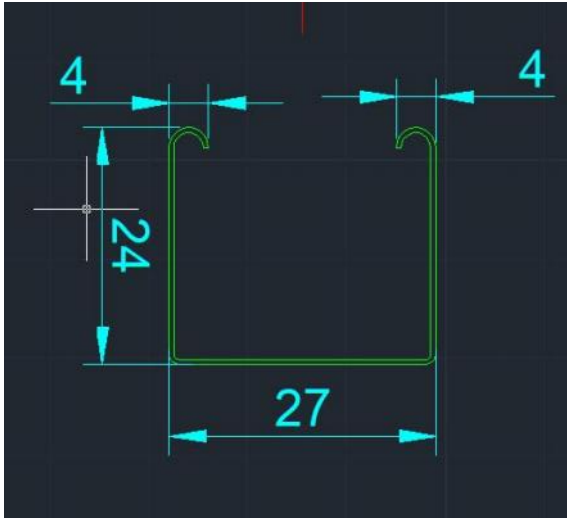
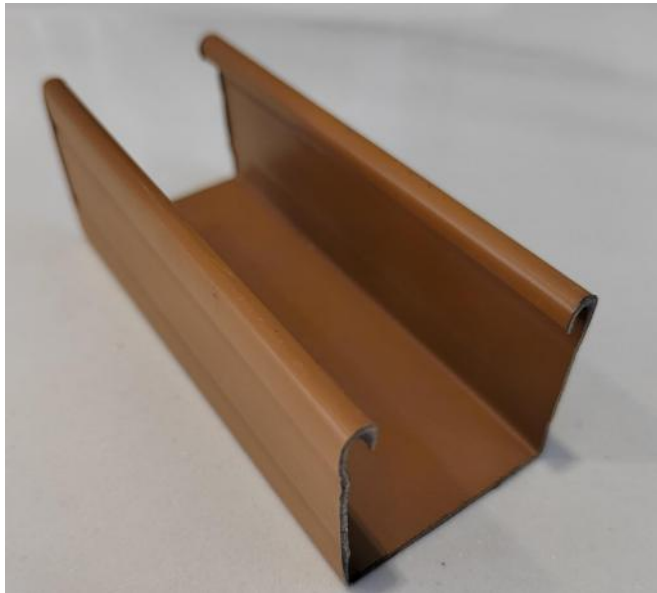
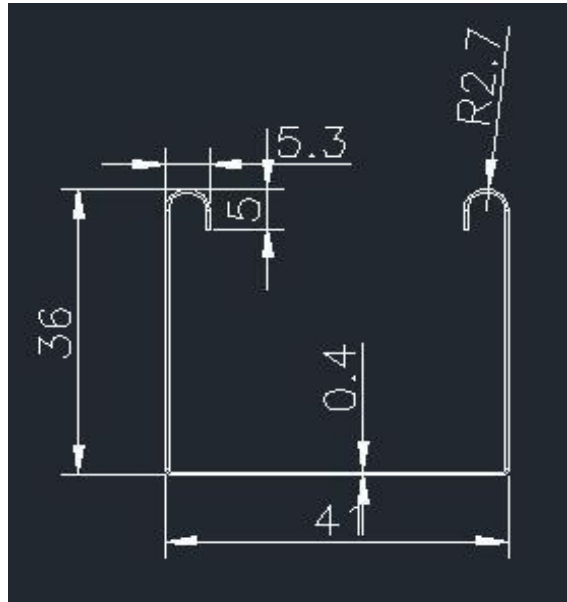
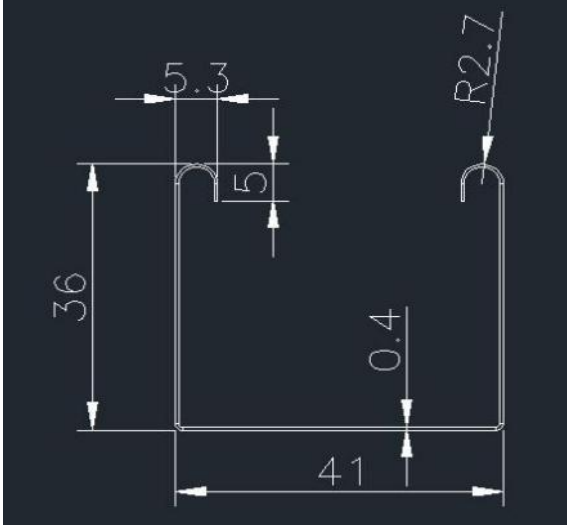
方形下轨 Square Bottom	
如果常规的封板和下轨选项没有您想要的款式，我们工厂支持免费开模。 Our factory can customizes the type of valance and bottom rail you want, providing you with a free open the mould.	

桐木叶片规范 Specification of Paulownia slats

No.	项目 Item	实木标准 Solid slats standard	指接标准 Normal jointed slats standard	误差 Tolerance
1	材质 Material	桐木 Paulownia	桐木 Paulownia	
2	结构 Structure	实木 Solid wood	指接 Finger jointed	
3	宽度 Width	50.8mm	49.0mm	± 0.5mm
4	厚度 Thickness	3.0mm	2.85mm	± 0.2mm
5	长度 Length	3ft - 8ft	6ft-12ft	
6	含水量 Moisture content	<10%	<10%	
7	侧弯 Camber (for length <4ft)	< 3.2mm	< 3.2mm	
	侧弯 Camber (for 4ft <= length < 7ft)	< 5.6mm	< 5.6mm	
	侧弯 Camber (for 7ft <= length <= 8ft)	<= 6.3mm	<= 6.3mm	
	侧弯 Camber (for 8ft < length <= 12ft)	Solid slats most length 9ft	<= 9.6mm	
8	面弯曲 Bow (for length <4ft)	< 2.4mm	< 2.4mm	
	面弯曲 Bow (for 4ft <= length < 7ft)	<4.2mm 少于	<4.2mm 少于	
	面弯曲 Bow (for 7ft <= length <= 8ft)	<= 4.8mm	<= 4.8mm	
	面弯曲 Bow (for 8ft < length <= 12ft)	Solid slats most length 9ft	<= 7.2mm	
9	测量方法 Measuring method	在玻璃桌面以 45 度角测量 To be measured by 45-degree angle on glass table	在玻璃桌面以 45 度角测量 To be measured by 45-degree angle on glass table	
10	外观 Appearance	木纹不平整是正常，但其他划痕、凹痕和凹痕不可接受。 Unevenness by wood grain is acceptable but other scratches, damages and dents are not acceptable.	木纹不平整是正常，但其他划痕、凹痕和凹痕不可接受。 Unevenness by wood grain is acceptable but other scratches, damages and dents are not acceptable.	
11	木材特性 Characteristics of wood	无死结 No die knots	无死结 No die knots	
12	颜色 Color	复制颜色需要客户确认 Color copy need confirm by customers	复制颜色需要客户确认 Color copy need confirm by customers	
13	亮度 Gloss	15 degrees	15 degrees	± 5 degrees

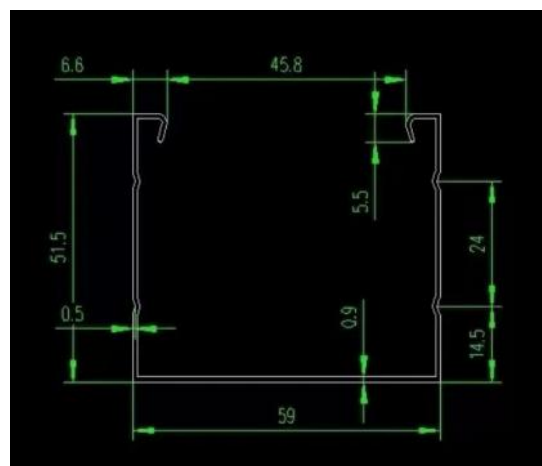
14	包装 Packing	150 片/箱 150pcs/carton	150 片/箱 150pcs/carton	
15	木材级别 Wood grade	根据不同颜色不同档次， 颜色越深档次越低 Based on different color different grade, colors darker grade lower	根据不同颜色不同档次， 颜色越深档次越低 Based on different color different grade, colors darker grade lower	
16	交货期 Lead time	货物通常在订单确认和定 金收到后 30 天内完成生产 (一个 20 英尺的集装箱接 受 4 种颜色，一个 40 英尺 的集装箱内接受 6 种颜色， 下订单后再次确认详细日 期) Goods usual be finished production in less than 30 days after order confirmed and deposit arrived (4 colors in one 20ft container, 6 colors in one 40ft container, detail date confirmed again once order placed)	货物通常在订单确认和定 金收到后 35 天内完成生 产 (一个 20 英尺的集装 箱接受 4 种颜色，一个 40 英尺的集装箱接受 6 种颜 色，下订单后再次确认详 细日期，12 英尺的长度最 好不超过 10000 个长度， 叶片越长交货期越久。 Goods usual be finished production in less than 35 days after order confirmed and deposit arrived (4 colors in one 20ft container, 6 colors in one 40ft container, detail date confirmed again once order placed, 12ft length better no more than 10,000 lengths, longer slats more delivery time longer)	
17	不良品率 Defect rate	<= 5%	<= 6%	
18	叶片重量/米 Weight of per meter for slats	覆盖色 47g/m Painted color: 47g/m	覆盖色 47g/m Painted color: 47g/m	
		染色 44g/m Stain color: 44g/m	拉丝 40g/m Brushed effected color: 40g/m	
19	下轨重量/米 Weight of per meter for bottom rail 	工形/H-shape 245g/m	工形/H-shape 245g/m	
		平面/Plane 260g/m	平面/Plane 260g/m	
		T 形/T shape 220g/m	T 形/T shape 220g/m	
20	封板重量/米 Weight of per meter for valance	63.5*6.5 B 型封板 135g/m B shape 220g/m	63.5*6.5 B 型封板 135g/m B shape 220g/m	
		70*10 封板 215g/m 70*10 valance 215g/m	70*10 封板 215g/m 70*10 valance 215g/m	

不同材质上轨道 Different materials Head rail

25mm / 35m / 50mm Metal Head rail		
25mm 不锈钢上 轨 Metal Head rail		
35mm 不锈钢上 轨 Metal Head rail		
50mm 不锈钢低 轨 Low metal Head rail		

50mm 不锈钢高轨 High metal Head rail	Technical drawing of the 50mm stainless steel high head rail cross-section. Dimensions include: total width 57, flange width 7, flange thickness 1.5, base thickness 0.7, and vertical dimensions of 51, 12, 24, and 15. Radii are specified as R3.5.
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2 英寸铝高轨
2"Aluminium
Head
rail

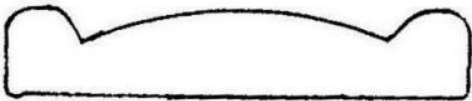
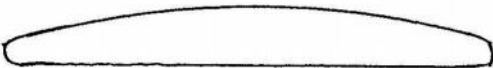
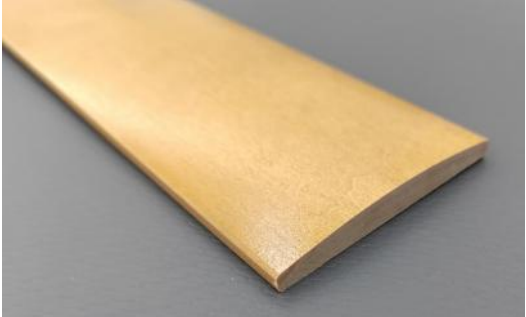


插片式双耳上轨
Binaural Head
rail



椴木叶片供应 Basswood supply

材料尺寸和厚度 Basswood size and thickness	叶片尺寸 Slats size: 25mm/35mm/50mm/63mm 叶片厚度 Thickness: 2.4mm/2.6mm/2.8mm	我们常规供应 2.8mm 厚度叶片 We usually supply 2.8mm thick slats
椴木材料产地 Basswood Producer	我们所有的椴木素材供应来自中国东北 All of our basswood supplies come from Northeast China	
椴木材料库存 Basswood Stock		3 个月椴木安全库存备货, 300 立方。 3 months of basswood safety stock stocking, 300 m³.
椴木色卡 Basswood Color		椴木提供覆盖色, 染色, 印刷三种颜色。 Basswood have 3 kinds of color: Painted, Stained, Printed

B 封板 B-Valance		
D 封板 D-Valance		
工形下轨 H Bottom		
方形下轨 Square Bottom		

椴木百叶工艺流程 Basswood blinds Process

我司采购已经开好片的素片到厂进行加工
Purchase pre made plain slats for processing at the factory



1QC 检验木片
1QC check the raw slats.



2 确认订单后开始机器砂光
2.Start sanding slats after the order comes in.



3 手工打磨叶片边部
3.Workers hand sanding for the edge to make sure the edge smooths.



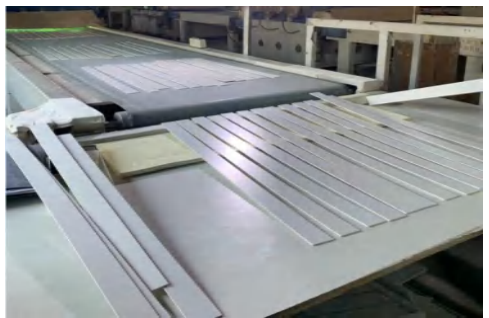
4 覆盖色叶片打底腻子（3次）
4 Paint color Slats seal coat（3 times）



5 叶片进入喷边房进行喷边
5.Slats enter the paint room, spray edges.



6 喷边后再次砂光
6 Sanding again



7 油漆线开始油漆工艺
7.Insert paint line, producing painted.



8 最终再次进行检验
8In the final step, workers QC each slat.



9 包装
9 Package

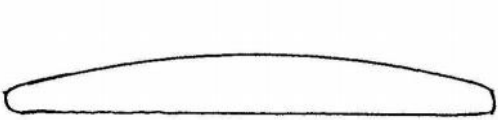
椴木叶片规范 Specification of Basswood slats

Item	Standard on Basswood slats	Tolerance 误差
Material 材质	Basswood 椴木	
Structure 结构	Solid wood slats 实木	
Width 宽	50.8mm	± 0.5mm
Thickness 厚	2.8mm	± 0.2mm
Length 长	3-9ft	
Moisure content 含水量	<10%	
Camber (for length <4ft) 侧弯	< 3.2mm	
Camber (for 4ft <= length< 7ft) 侧弯	< 5.6mm	
Camber (for 7ft <= length<=8ft) 侧弯	<= 6.3mm	
Camber (for 8ft < length<=12ft) 侧弯	Solid slats most length 9ft	
Bow (for length <4ft) 面弯曲	< 2.4mm	
Bow (for 4ft <= length< 7ft)面弯曲	<4.2mm 少于	
Bow (for 7ft <= length<=8ft) 面弯曲	<= 4.8mm	
Bow (for 8ft < length<=12ft)面弯曲	Solid slats most length 9ft	
Measuring method 测量方法	to be measured by 45-degree angle on galsses table	
Appearance 表面	Unevenness by wood grain is acceptable but other scratches, damages and dents are not acceptable.	
Characteristics of wood	no die knots	
Color	Color copy need confirm by customers	
Gloss	15 degrees	± 5 degrees
Production process	Flaking-sanding-QC-cut both ends of slats-edges painting-sanding-paint -Color check-QC- package	
Packing	150pcs/carton	
Wood grade	Based on different color different grade, colors darker grade lower	
Lead time	Goods usual be finished production in less than 30 days after order confirmed and deposit arrived if there is enough raw material in stock, there will be around 60 days if no stock raw material (less10 colors in one container, detail date confirmed	

	again if more colors)	
Defect rate	<= 5%	
Weight of per meter for slats	Stain color: 75g/m	
	Painted color: 85g/m	
Weight of per meter for bottom rail	385g/m	 2" (50.8x16mm)
	410g/m	

竹木叶片供应 Bamboo supply

材料尺寸和厚度 Bamboo size and thickness	叶片尺寸 Slats size: 25mm/35mm/50mm/63mm 叶片厚度 Thickness: 2.2mm	竹木特性, 目前只做一种厚度 Bamboo is special, currently only one thickness is produced
竹木材料产地 Bamboo Producer	我们所有的竹木素材供应来自武夷山脉一带 All of our bamboo supplies come from Wuyishan, China	可以提供 FSC 编号, 不在纸箱上加 FSC 标识 We could supplier FSC bamboo number, not supply Printed logo on box.
竹木材料库存 Bamboo Stock		竹木叶片库存需要防潮 Bamboo slats need to be kept dry and not damp
竹木色卡 Bamboo color		

D 封板 D-Valance		
D 封板 D-Valance 2		
方形下轨 Square Bottom		

竹木百叶工艺流程 Bamboo blinds Process

我司采购已经开好片的素片到厂进行加工
Purchase pre made plain slats for processing at the factory



1QC 检验木片
1QC check the raw slats.



2 确认订单后开始机器砂光
2.Start sanding slats after the order comes in.



3 手工打磨叶片边部
3.Workers hand sanding for the edge to make sure the edge smooths.



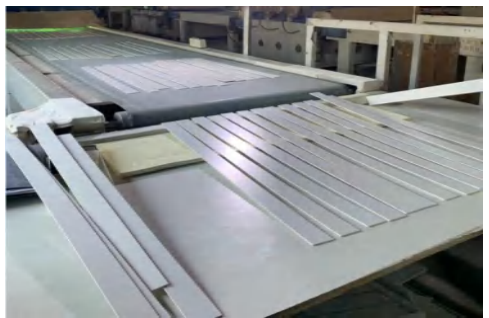
4 覆盖色叶片打底腻子（3次）
4 Paint color Slats seal coat（3 times）



5 叶片进入喷边房进行喷边
5.Slats enter the paint room, spray edges.



6 喷边后再次砂光
6 Sanding again



7 油漆线开始油漆工艺
7.Insert paint line, producing painted.



8 最终再次进行检验
8In the final step, workers QC each slat.



9 包装
9 Package

竹木叶片规范 Specification of Bamboo slats

No.	Item	Standard	Tolerance 误差
1	Material 材质	Bamboo 竹木	
3	Width 宽	50.5mm	± 0.5mm
4	Thickness 厚	2.2mm	± 0.2mm
5	Length 长	4ft - 8ft	
7	Camber (for length <4ft) 侧弯	< 3.2mm	
	Camber (for 4ft <= length < 7ft) 侧弯	< 5.6mm	
	Camber (for 7ft <= length <=8ft) 侧弯	<= 6.3mm	
	Camber (for 8ft < length <=12ft) 侧弯	Solid slats most length 8ft	
8	Bow (for length <4ft) 面弯曲	< 2.4mm	
	Bow (for 4ft <= length < 7ft) 面弯曲	<4.2mm 少于	
	Bow (for 7ft <= length <=8ft) 面弯曲	<= 4.8mm	
	Bow (for 8ft < length <=12ft) 面弯曲	Solid slats most length 8ft	
9	Measuring method 测量方法	to be measured by 45-degree angle on galsses table	
12	Color	Color copy need confirm by customers	
13	Gloss	15 degrees	± 5 degrees
14	Production process	resourced inspection-sanding-QC-cut both ends of slats-edges painting-sanding-paint -Color check-QC- package	
15	Packing	150pcs/carton	
18	Defect rate	<= 5%	

供应不同材料的叶片长度 The length of different material slats supplied

1. 桐木叶片 Paulownia Slats:

25mm 叶片: 实木 4-7 英尺	25mm slats lenght: Solid 4-7ft
35mm 叶片: 实木 4-8 英尺	35mm slats lenght: Solid 4-8ft
50mm 叶片: 实木 4-9 英尺	50mm slats lenght: Solid 4-9ft
前指接: 最大长度 12 英尺	Pre finger jointed slats: Max. lenght 12ft
后指接: 最大长度 12 英尺	Common finger jointed slats: Max. lenght 12ft



2. 椴木叶片 Basswood slats:

25mm 叶片: 实木 3-8 英尺	25mm slats lenght: 3-8ft
35mm 叶片: 实木 3-8 英尺	35mm slats lenght: 3-8ft
50mm 叶片: 指接 3-12 英尺	Pre finger jointed 50mm slats lenght: 3-12ft

3. 竹木叶片 Bamboo slats:

25mm 实木叶片: 6 英尺	25mm slats lenght: 6ft
35mm 实木叶片: 实木 8 英尺	35mm slats lenght: 8 ft
50mm 实木叶片: 4-8 英尺	50mm slats lenght: 4-8ft
50mm 指接叶片: 4-9 英尺	50mm slats lenght: 4-9ft
63mm 叶片: 4-8 英尺	63mm slats lenght: 4-8ft

半成品包装 Blinds component Packing

包装规格 Packaging Standards		
	木头 Wooden slats	PVC
叶片 Slats	150pcs / carton	100pcs / carton
封板 Valance	30pcs / carton	20pcs / carton
下轨 Bottom	30pcs / carton	20pcs / carton
上轨 Top rail	1pcs/Bag ,20pcs/carton	High rail 12 pcs/carton
		

油漆工艺 Paint process

1 白色和黑色的油漆工艺步骤 White/Black slats Painting process steps:

白/黑：素片→1 遍涂腻子（封闭桐木毛细孔）→喷边→砂光→附着底→3 遍 UV 底漆→UV 面漆

White/Black :Raw slats→Seal coating once →Painting both side of slats→Machine sanding→Adhesion paint→UV paint 3 times→UV Finish paint

2 印刷/其他覆盖色：油漆工艺步骤 Printed/Painted Color slats Painting process steps:

素片→补腻子→喷边→砂光→NC 白底 x3-4→UV 底 →UV 面（印刷色是 UV 面纹路，覆盖色是 UV 清面）

Raw slats→Seal coating once →Painting both side of slats→Machine sanding→NC paint 3 times→UV paint→UV Finish paint

3 染色 Stained Color

素片→喷边→砂光→着色→UV 底 →UV 面

Raw slats →Painting both side of slats →Machine sanding→Stained Slats →UV paint→UV Finish paint

4 拉丝 Brushed Color

素片→喷边→拉丝→砂光→UV 底（白色才加这个工艺，防泛黄）NC 白底 x3-4 →UV 面漆

Raw slats →Painting both side of slats →Brush slats →Machine sanding→UV paint（just white color need）→NC paint 3 times→UV Finish paint

PVC 百叶工艺流程 PVC blinds Process



PVC 叶片粉末芯料
Powder Core materials



自主生产颗粒面料
Granular surface raw material
made by self



自造颗粒色料
Color material made by self



PVC 混料车间
Material mixing workshop



车间挤出线
Extrusion line workshop



共挤技术
Co extrusion technology



实心空心都可以生产
Both solid and hollow can be
extruded

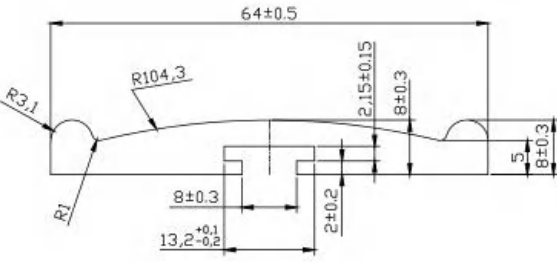
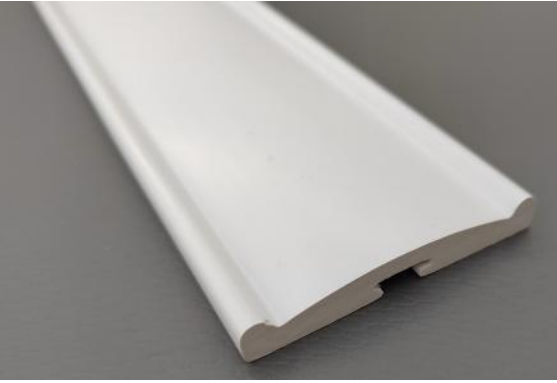


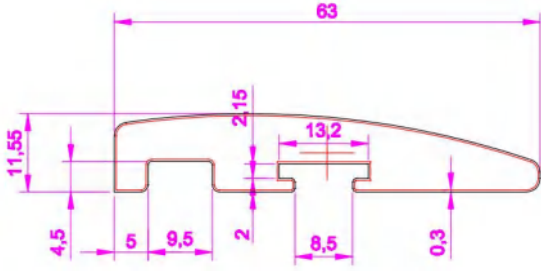
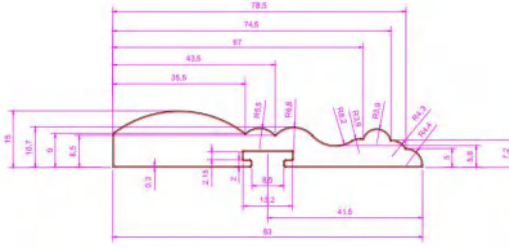
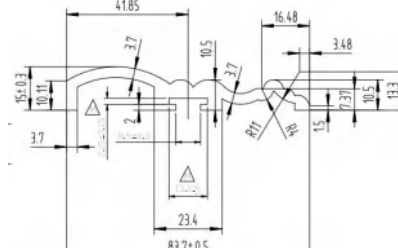
检验
QC

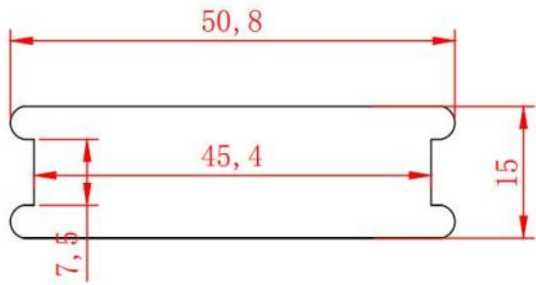
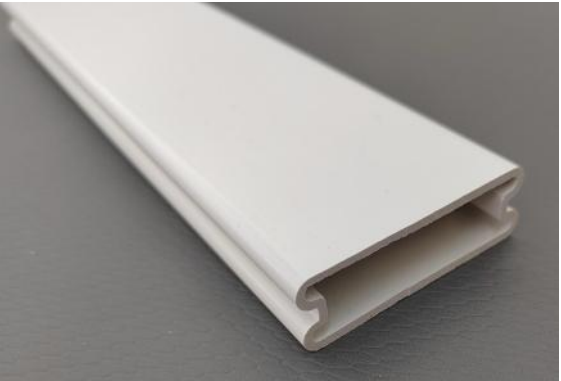
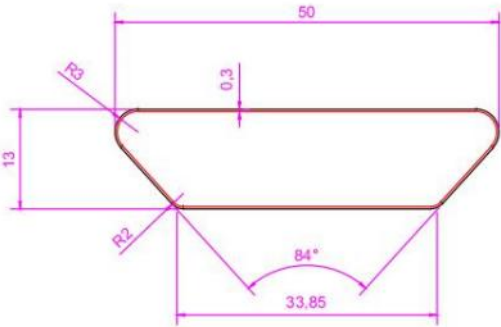
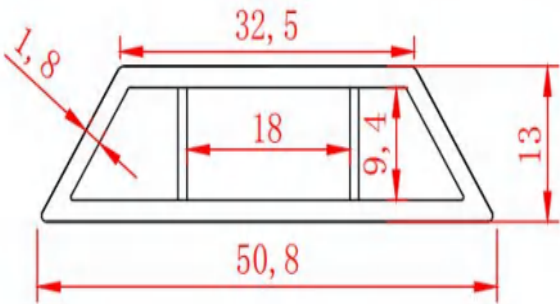
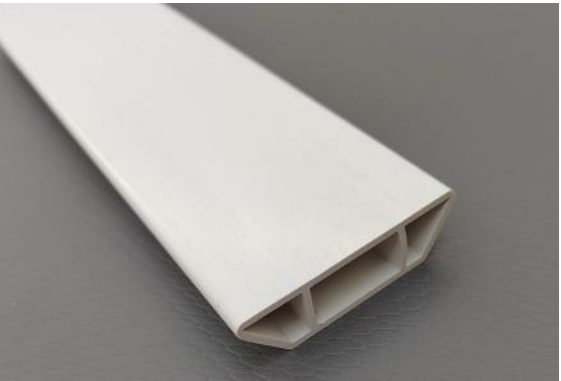


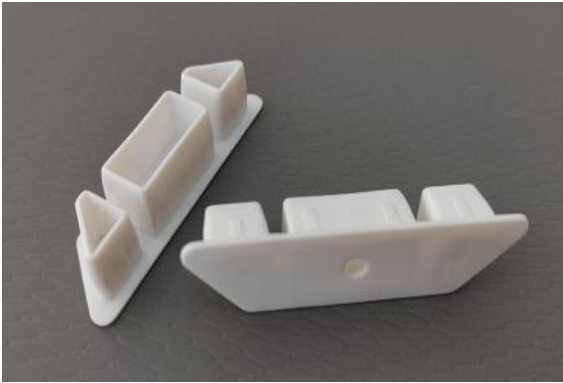
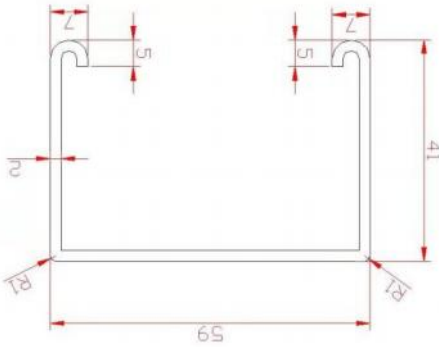
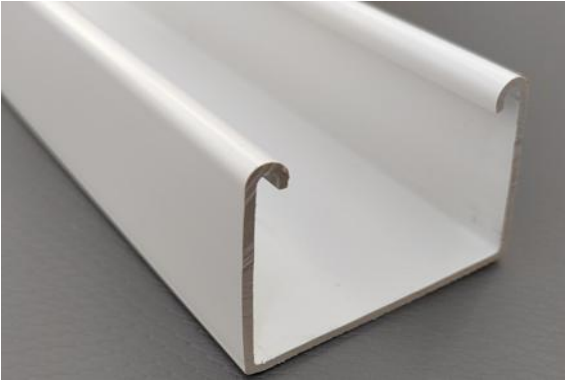
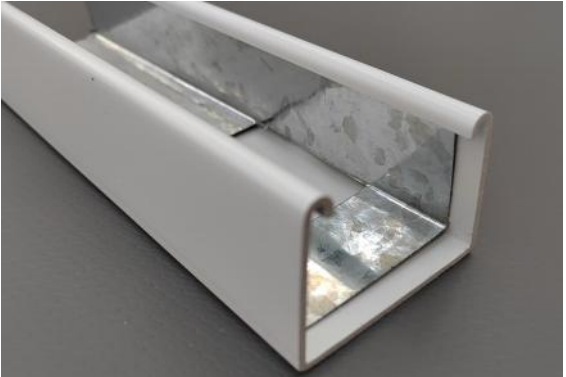
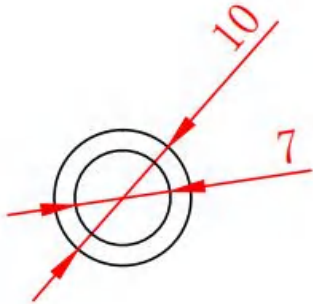
半成品塑料膜包装
Packaging of components

PVC 叶片和封板下轨款式 The style of PVC Slats/Valance/Bottom

叶片尺寸 Slats Size	叶片尺寸 Slats size: 25mm/35mm/50mm/63mm 叶片重量 Slats weight: 70g/80g/90g (常用 90g Regular 90) 
颜色效果 Color	纯色 Solid color/印刷色 Printed/压纹 Embossing
色卡 Color Car	
B 封板 B-Valance	可以做纯色, 不建议做印刷色 Can made solid color ,not made  

D 封板 D-Valance	颜色不受限制 Color unrestricted  Technical drawing of D-Valance cross-section showing dimensions: 63, 11.55, 4.5, 6, 9.5, 2, 13.2, 8.5, 0.3, 215.	 Photograph of D-Valance showing its profile.
空心 D 封板 Hollow D-Valance	颜色不受限制 Color unrestricted  Technical drawing of Hollow D-Valance cross-section showing dimensions: 64±0.5, 2-R1, 3.5, 2.15±0.15, 2±0.2, 13.2±0.2, 8±0.3, 3.5, R130, 4, 8±0.3.	 Photograph of Hollow D-Valance showing its profile.
实心皇冠封板 Crown Valance	可以做纯色，不建议做印刷色 Not made printed color  Technical drawing of Crown Valance cross-section showing dimensions: 78.5, 74.5, 97, 43.5, 35.5, 15, 10.7, 6, 6.5, 3.7, 2.15, 2, 10.5, 10.5, 16.48, 3.48, 13.2, 10.5, 13.2, 23.4, 83.7±0.5.	 Photograph of Crown Valance showing its profile.
空心皇冠封板 Hollow-Crown Valance	可以做纯色，不建议做印刷色 Not made printed color  Technical drawing of Hollow-Crown Valance cross-section showing dimensions: 41.85, 16.48, 3.48, 13.2, 10.5, 13.2, 23.4, 83.7±0.5.	 Photograph of Hollow-Crown Valance showing its profile.

实心工形下轨 H Bottom		
空心工形下轨 Hollow-H Bottom		
梯形下轨 T Bottom		
空心梯形下轨 Hollow T Bottom		

空心梯形下轨 2 Hollow T Bottom 2		
PVC 挤出上轨道 PVC Top rail		
PVC 上轨+铁内衬 PVC Top rail+Iron lining	铁内衬材质是铁，厚度 0.35mm Material: Iron, Thickness	
PVC 转棒 PVC wand		
半成品包装(内部裹塑料膜) Packing (Internally wrapped with plastic film)		

PVC 车间产能 PVC blinds workshop capacity

叶片生产线 18 条， 一台机器一天一夜挤出 5500 米叶片

Slats extrusion line: 18, 1 extrusion line can made 5500 meters every 24 hours

封板下轨上轨等 12 条， 每 24 小时可以生产下轨 1200 米 /封板 1300 米 /上轨 1300 米， 灰色跟其他带颜色的稍微慢一些。

Valance and top rail extrusion line: 5, 1 extrusion line can made 1200 meters bottom rail /valance 1300m/top rail 1300m

共计 30 条生产线

Extrusion line : Total 30

货物运输体积 Transport volume

成品 Finished product

大柜成品：约 3500 支 40GP : 3500pcs

小柜成品：约 1600 支 20GP : 1600pcs

半成品 Semi-finished productsBlinds (Slats,Bottom,Rail)

大柜：295000 米 40GP :295000m

小柜半品：145000 米 20GP :145000m

百叶帘系统配件 Blinds system accessory

● 25 拉绳系统 25mm system



固定座
String roll base



固定器
String roll



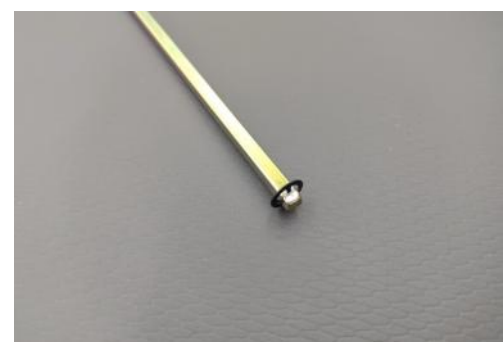
船型锁具
Cord lock



转棒式 OM
Tiltor for wood wand blinds



25 系统没有铁 OM
25mm No Iron OM



半圆形铁条 2.7*3.7mm
Bar iron 2.7*3.7mm



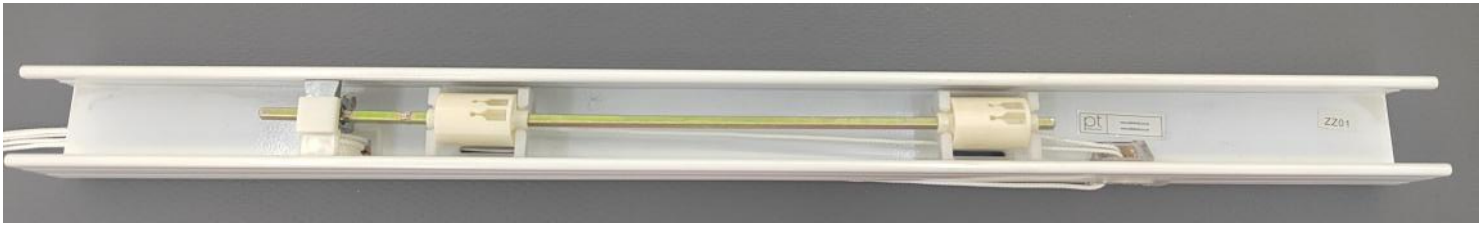
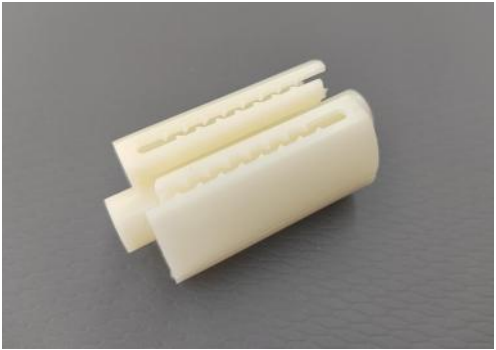
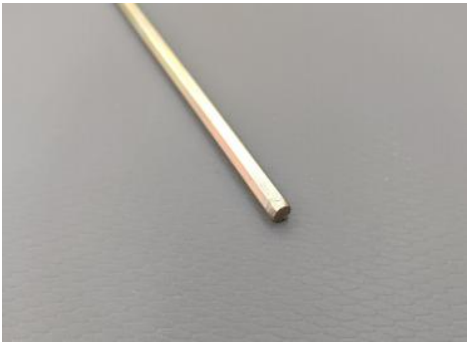
25 蜘蛛托架
25mm Metal bracket



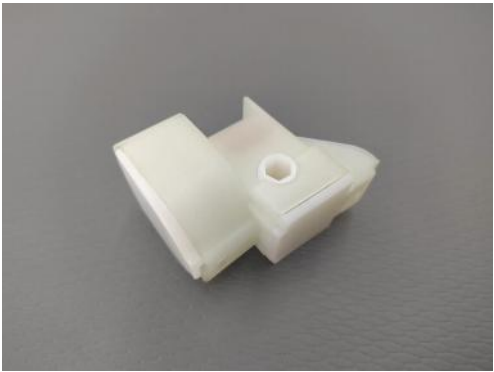
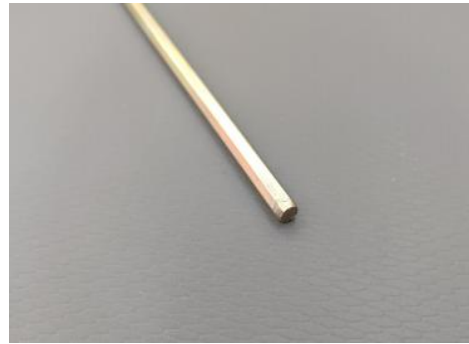
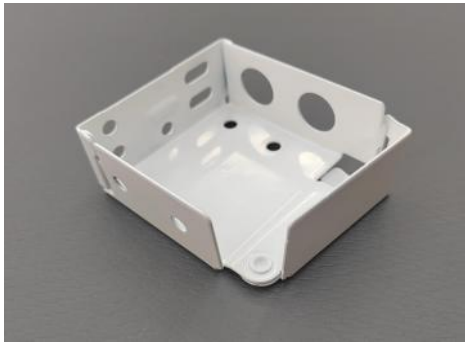
封套
Box bracket

25 系统幅宽较小时，可以选择 OM 和锁具在一面
When the system width is small, OM and locks can be selected on one side

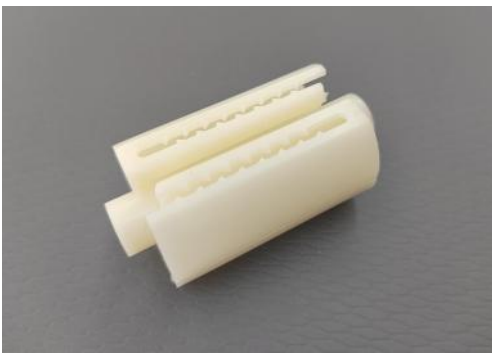
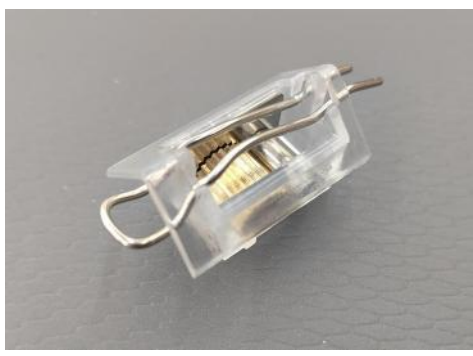
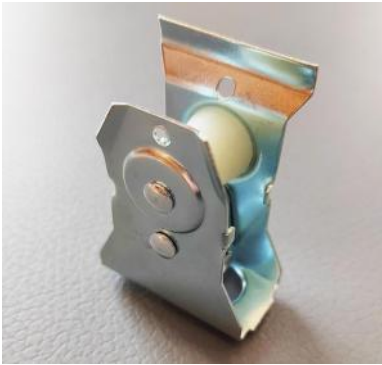
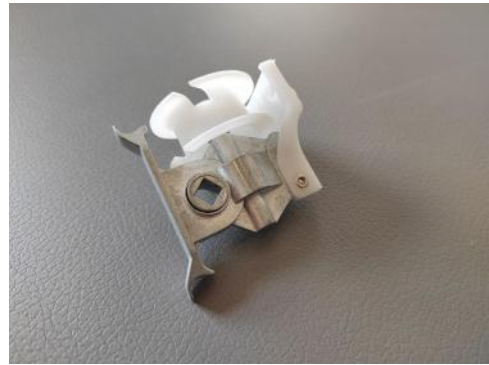
● 35 拉绳系统 35mm system

		
		
固定座 String roll base	固定器 String roll	船型锁具 Cord lock
		
35mm 不做转棒 35mm No wand system	35 系统 OM 35mm OM	六角铁条 Hexagonal Bar iron
		
蜘蛛托架 35mm Metal bracket	封套 Box bracket	

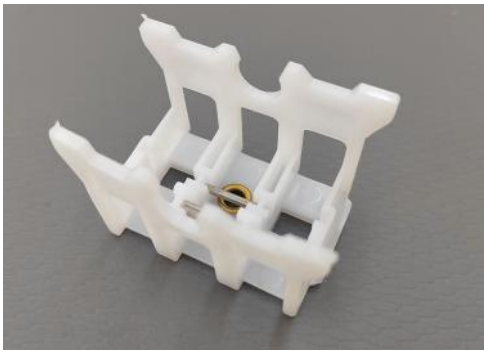
● 50 低轨系统 50mm Low headrail system

		
		
固定座 String roll base	固定器 String roll	船型锁具 Cord lock
		
35mm 不做转棒 35mm No wand system	50mm OM	六角铁条 Hexagonal Bar iron
		
蜘蛛托架 50mm Metal bracket	封套 Box bracket	

● 50 高轨系统 50mm High headrail system

		
		
固定座 String roll base	固定器 String roll	船型锁具 Cord lock
		
铁锁具 Iron Lock	50mm OM-1	50mm OM-2
		
高轨蜘蛛托架 50mm High rail Metal bracket	六角铁条 Hexagonal Bar iron	

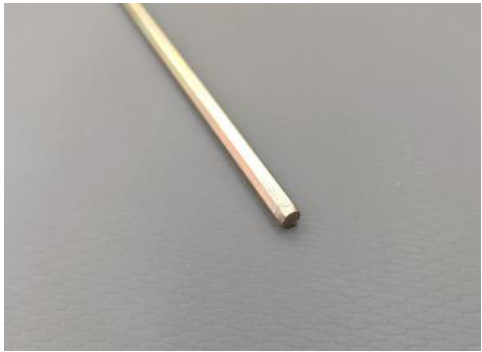
● 无拉系统 Cordless system



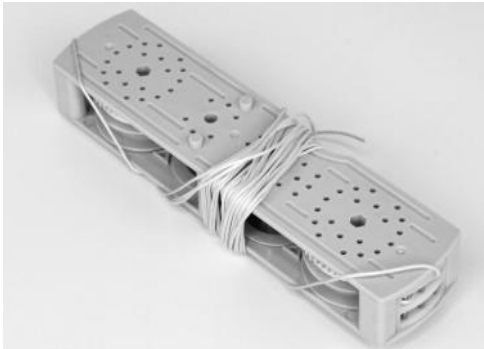
固定座
String roll base



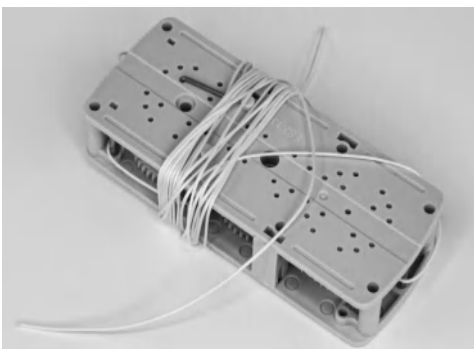
固定器
String roll



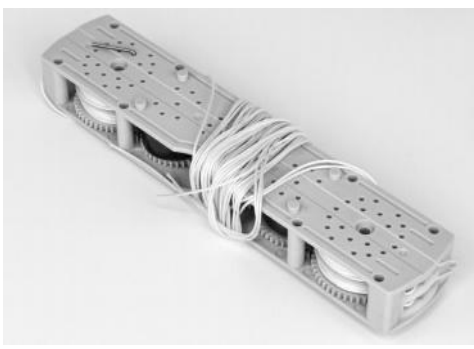
六角铁条
Hexagonal Bar iron



EF 机构盒
EF Module



ES 机构盒
ES Module



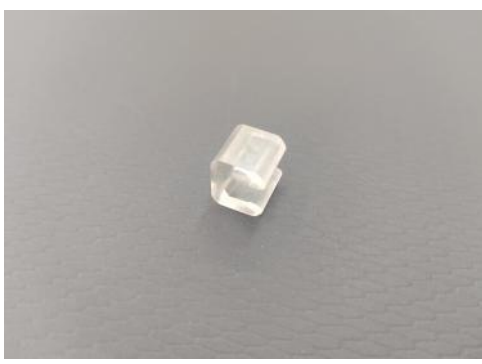
EW 机构盒
EW Module



PVC 转棒式 OM
Tiltor for PVC wand blinds



机构盒固定器
Module holder



C 型扣
Rod Stopper

● 弹簧马达参数表 Module parameter

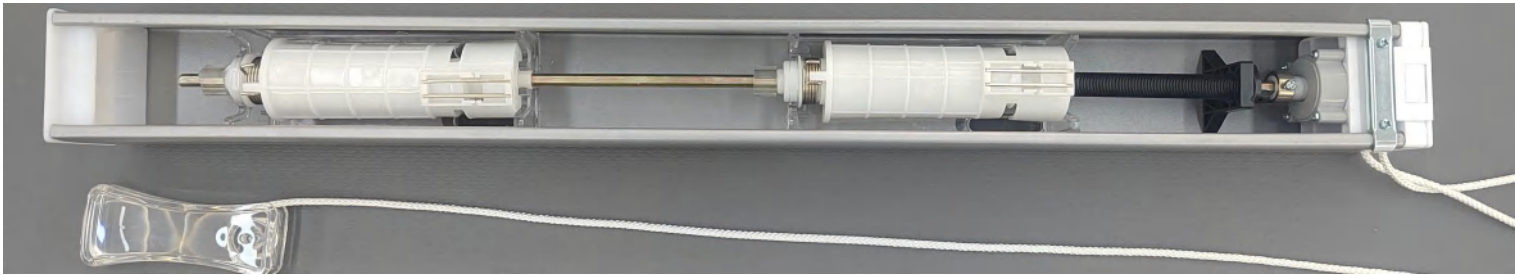
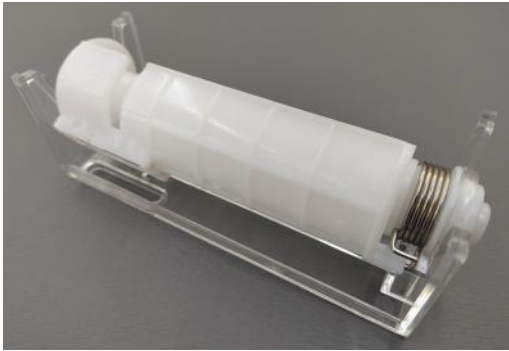
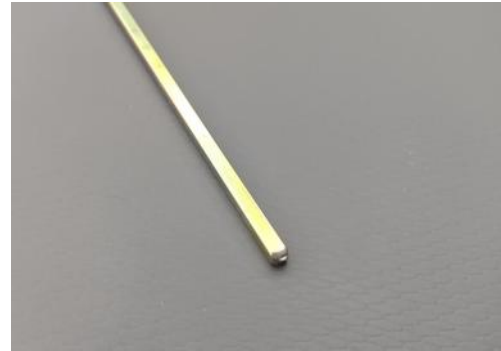
ES 马达应用规格表 ES Module parameter					
序号 No	编号 No	组成 Structure	应用范围 Scope of use		
	双线 2 wires		最小承重 Min load (kg)	最大承重 Max load (kg)	说明 Notes
1	ES2-11-72	T=0.11mm, 单簧片 Single spring plate	0.16	2	
2	ES2-12-72	T=0.12mm, 单簧片 Single spring plate	0.14	2.5	
3	ES2-13-72	T=0.13mm, 单簧片 Single spring plate	0.18	2.7	
4	ES2-15-72	T=0.15mm, 单簧片 Single spring plate	0.25	3.3	
5	ES2-16-72	T=0.16mm, 单簧片 Single spring plate	0.33	3.8	
6	ES2-15-72X	T=0.15mm, 单簧片 Single spring plate	0.2	4.2	

EF 马达应用规格表 EF Module parameter						
序号 No	编号 No			应用范围 Scope of use		
	双线 2 wires	四线 4 wires	组成 Structure	最小承重 Min load (kg)	最大承重 Max load (kg)	说明 Notes
1	EF2-11-96	EF4-11-96	T=0.11mm, 单簧片 Single spring plate	0.14	1.85	特殊情况下 可以配置三 线 specially , 3 wires can be provided
2	EF2-12-96	EF4-12-96	T=0.12mm, 单簧片 Single spring plate	0.17	2.4	
3	EF2-13-96	EF4-13-96	T=0.13mm, 单簧片 Single spring plate	0.2	2.7	
4	EF2-15-96	EF4-15-96	T=0.15mm, 单簧片 Single spring plate	0.28	3.2	
5	EF2-16-96	EF4-16-96	T=0.16mm, 单簧片 Single spring plate	0.33	3.6	
6	EF2-11-96X	EF4-11-96X	T=0.11mm, 单簧片 Single spring plate	0.16	2.1	
7	EF2-12-96X	EF4-12-96X	T=0.12mm, 单簧片 Single spring plate	0.16	2.7	
8	EF2-13-96X	EF4-13-96X	T=0.13mm, 单簧片 Single spring plate	0.18	3	
9	EF2-15-96X	EF4-15-96X	T=0.15mm, 单簧片 Single spring plate	0.25	3.5	
10	EF2-16-96X	EF4-16-96X	T=0.16mm, 单簧片 Single spring plate	0.33	4	

EW 马达应用规格表 EW Module parameter						
序号 No	编号 No			应用范围 Scope of use		
	双线 2 wires	四线 4 wires	组成 Structure	最小承重 Min load (kg)	最大承重 Max load (kg)	说明 Notes
1	EW2-11-96	EW4-11-96	T=0.15mm, 双簧片 2 spring plate	0.32	4	特殊情况下 可以配置三 线
2	EW2-12-96	EW4-12-96	T=0.15mm, 双簧片 2 spring plate	0.4	4.5	
3	EW2-13-96	EW4-13-96	T=0.13mm, 双簧片 2 spring plate	0.48	5	
4	EW2-15-96	EW4-15-96	T=0.15mm, 双簧片 2 spring plate	0.66	5.9	
5	EW2-16-84	EW4-16-84	T=0.16mm, 双簧片 2 spring plate	0.8	7	
6	EW2-11-96X	EW4-11-96X	T=0.15mm, 双簧片 2 spring plate	0.28	4.1	specially , 3 wires can be provided
7	EW2-12-96X	EW4-12-96X	T=0.15mm, 双簧片 2 spring plate	0.35	5	
8	EW2-13-96X	EW4-13-96X	T=0.13mm, 双簧片 2 spring plate	0.45	5.6	
9	EW2-15-96X	EW4-15-96X	T=0.15mm, 双簧片 2 spring plate	0.55	6.4	
10	EW2-16-84X	EW4-16-84X	T=0.16mm, 双簧片 2 spring plate	0.75	7.6	

1 一般下梁的重量不能小于最小承重，叶片或面料加下梁的重量一般小于最大承重。 Bottom rail weight > Min Load ， All Slats +Bottom weight < Max Load
2 无拉系统的高度一般控制在 72 英寸，及 183cm 的高度，特殊情况可以订制 96 英寸。 最小幅宽是 50CM， 最大幅宽是 180CM。 Cordless blinds height not more than 183cm. Specially, 243cm height is OK. Min width 50CM, Max width 180cm.
3 为了保证受力平衡或叶片不弯曲，一般宽度 40cm 有一条拉绳，根据面料或叶片的宽度选用合适的马达。 In order to ensure force balance or prevent the slats from bending, there is usually a rope with a width of 40cm, and a suitable motor is selected according to the width of the blinds.
4 本马达可应用在 2 英寸无拉百叶、无拉竹罗马帘，分别与不同的配套配件组合使用。 This motor can be applied to 2-inch non pull blinds and non pull bamboo, Roman blinds, and can be combined with different matching accessories.
5 本马达采用优质 POM 材料制作，采用不锈钢弹簧片，寿命超过 5000 次。 This motor is made of high-quality POM material and uses stainless steel spring plates, with a lifespan of over 5000 times.

● 循环拉绳系统 Loop cord blinds headrail system

		
		
卷绳器 Rope coiler	限位器 Stopper	六角孔制头 Rotator
		
六角铁条 Hexagonal Bar iron	C 型扣 Rod Stopper	透明手柄 Transparent handle
		
四角孔制头 Quadrangle-Rotator	3.6mm 拉绳 3.6mm Cord	拉珠 Bead rope
循环拉绳系统也可以选择四角的（卷绳器，限位器，制头和铁条全部四角匹配） Loop cord also can choose Quadrangle-Rotator(include Rope coiler,Stopper,bar iron)		

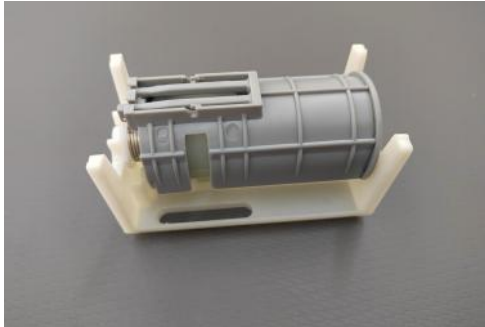
● 电动系统 Motor system



杜亚电机
DOOYA Motor



奥科电机
A-KO Motor



卷绳器



转棒连接器



电机卡座

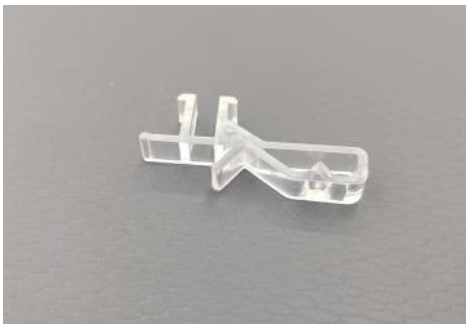
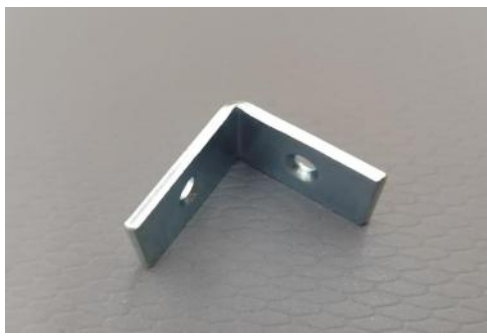
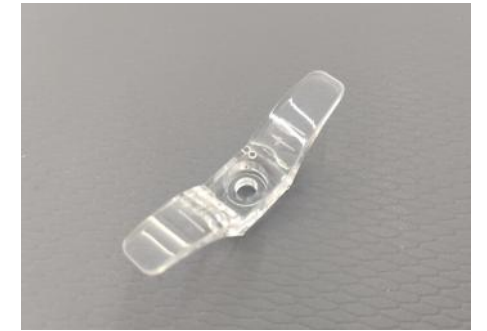
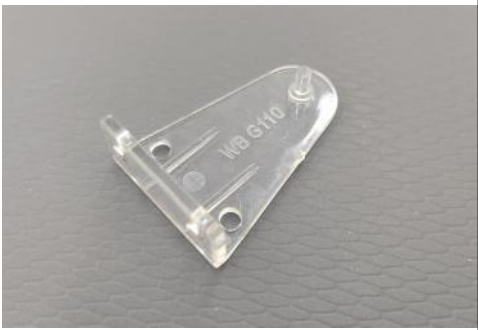
电动定制帘：定制款的电机可以做到幅宽 2.4 米，垂长可以做到 3 米。再大的垂长可以做，但是在窗帘下降的时候在 3 米以上的区间会有断断续续的停留，因为超过 3 米的垂长的绳子是卷在第一圈绳子的上面。超过 3 米的不参与质保。

Customized motor blinds: The customized motor can achieve a width of 2.4 meters and a vertical length of 3 meters. No matter how long the drape is, it can be done, but there will be intermittent stops in the range of more than 3 meters when the blinds is descending, because the rope with a drape length of more than 3 meters is coiled on top of the first circle of rope. Items exceeding 3 meters are not covered by warranty.

- 插片式上轨系统 **Valance free high headrail system**



百叶帘其他配件 Blinds auxiliary accessory

		
封板挂钩 valance clips	封板挂钩 valance clips	磁吸封板挂钩 Magnet valance clips
		
两段式封板挂钩 2 parts valance clips	皇冠封板挂钩 Valance clip for Crown Valance	封板转角连接器
		
封板转角连接器 Valance return connector	单孔单牛角 Single Cord Cleats	单孔双牛角 Cord cleats
		
叶片夹 Slats Clip	三角片 Hold Down brackets	PVC 下扣 PVC Bottom Rail end cap

		
省力下扣 Labor saving end cap	宽布梯带下扣 Big wooden button for ladder tape	普通梯带下扣 Empty wooden button for ladder string
		
木拉环 Wood tassel	塑料拉环 Plastic tassel	拉绳分离器 Cord release device

成品包装类型 Packaging type



吸塑包装
Blister Packaging



抽屉盒包装
Drawer box packing



彩盒包装
Colour Box packing



PET 盒包装
PET Box packing

如何组建百叶帘车间 How to set up blinds workshop

What you think the difficult actually is very simple! !

Slats, valance and bottom rails
Cutting machine (Four
processes require only 1
worker)

Slats punching machine



Bottom rail holes drilling
machine

Valance metre machine

Headrail cutting machine
+ Head rail punching
machine (Only 1 worker)

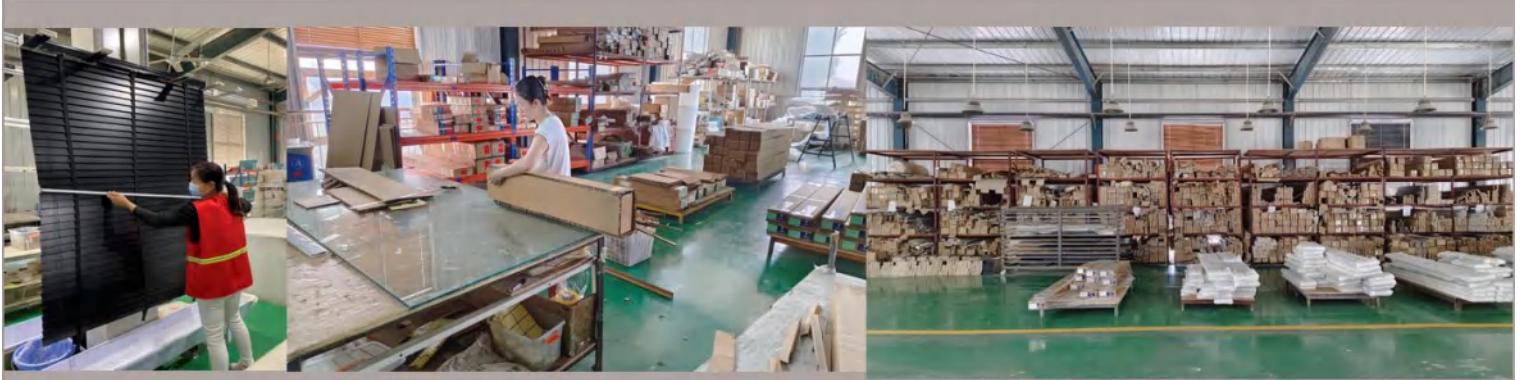
Assemble blinds headrail
(1 worker)



The machine for staple
lead to string (1 worker)

Assemble the blinds
need 2 or 3 workers, 1
worker can assemble 30
blinds one day

So set up your workshop total need about $4+3+1+2=10$ workers! !
It only takes 500 M² to set up your production and stock workshop!



QC (1 worker)

Packing need 2 workers

Blinds material inventory storage area

Taiwan fully automatic punching slats,
about \$20,188



Basswood material is hard,
and we use punching knife
with rake cut 62 degree.



Pualownia slats material is relatively
light and soft compared to basswood,
so used the punching knife with rake
20 degree.

百叶帘款式 Blinds type

裁切帘 Cut down blinds

裁切百叶帘是批量生产的百叶帘，梯子留有固定长度，客户可以从末端切割宽度，并重新调整叶片，以达到需要的百叶帘的高度，可以在自己的工厂或工厂使用一台切割机定制尺寸。Cut down blinds are mass produced blinds with ladders left to fixed length, customers can cut the width from the ends and restring the slats to request height of the blinds for custom made sizes in their own factories or facilities with one cut down machine.

可生产材质：桐木/椴木/竹木/PVC
Support Material :
Paulownia/Basswood/Bamboo/PVC



成品百叶帘 Ready made blinds

可生产材质：桐木/椴木/竹木/PVC
Support Material :
Paulownia/Basswood/Bamboo/PVC

系统 System:

桐木：拉绳，无拉，循环，电动，
Paulownia:Cord/cordless/Loop cord blinds/Motor

椴木：拉绳
Basswood:Cord

竹木：拉绳
Bamboo:Cord

PVC：拉绳，无拉，
PVC: Cord /Cordless

叶片 Slats:
25mm/35mm/50mm/63mm



定制百叶帘 Custom made blinds

我们的定制百叶窗样品盒包括 26 种定制颜色。
不同类型的帷幔和底部栏杆，以及与颜色匹配的梯带。
认证：FSC，ISO，SGS。
系统：传统/链式/电动
材料：桐木/PVC。
叶片：50mm、63mm
叶片油漆：UV
颜色：桐木 26 色，PVC 5 色。
MOQ:1
交付时间：3-7 天
包装：标准邮购包装
Our custom blinds sample box includes 26 custom colors.
Different types of valance and bottom rails, and a ladder tape that matches the color.
Certificata:FSC,ISO,SGS.
System: Traditional/ Chain Mechanism/ Motorised
Material:Paulownia/PVC
Slats:50mm,63mm
Paint for wood slats:UV
Color:26 color for wooden blinds,5 color for faux wood blinds.
MOQ:1
Leading time: 3-7 days
Packing: Standard mail order packing



垂直百叶帘 Wooden vertical blinds

桐木垂直帘
半成品叶片支持颜色定制
起定量 500m/色
叶片类型：指接

Paulownia vertical curtain

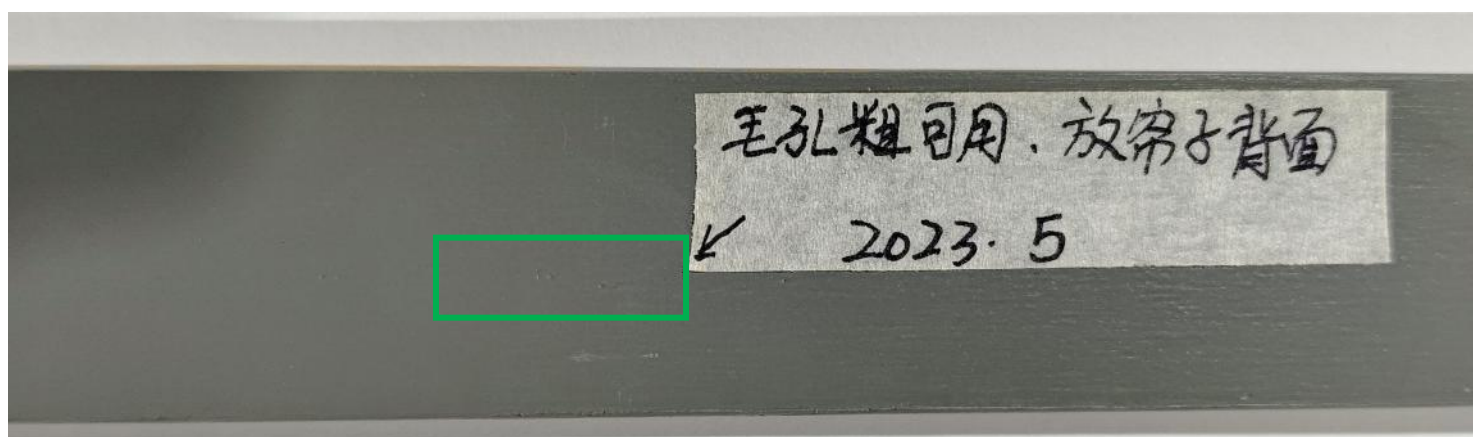
Semi finished blades support color customization

MOQ: 500m/color

Blade type: finger joint

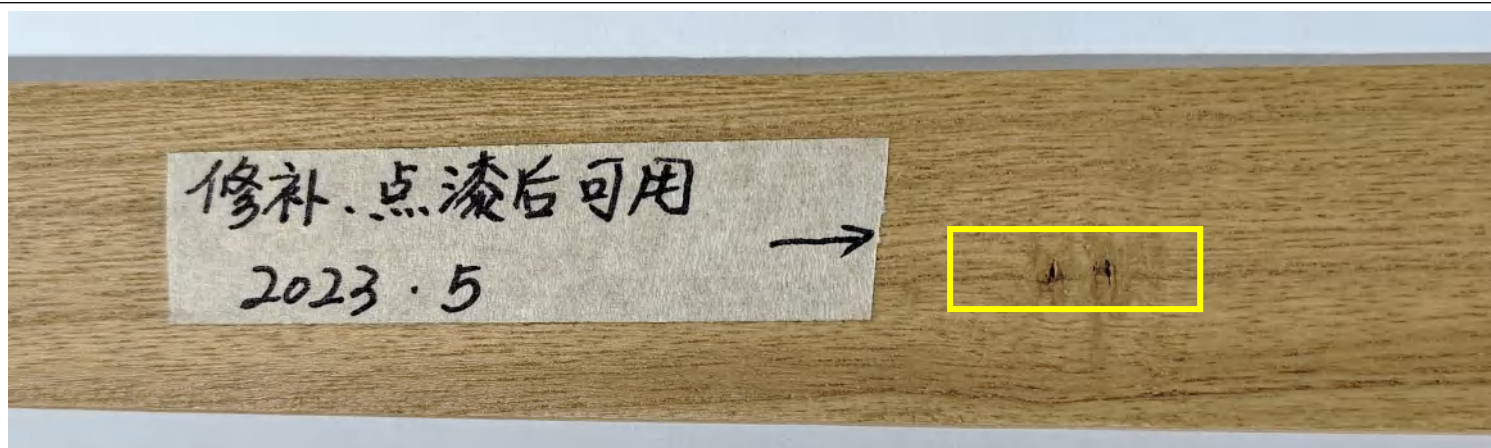


百叶帘品质验收标准 Blinds Quality acceptance standards



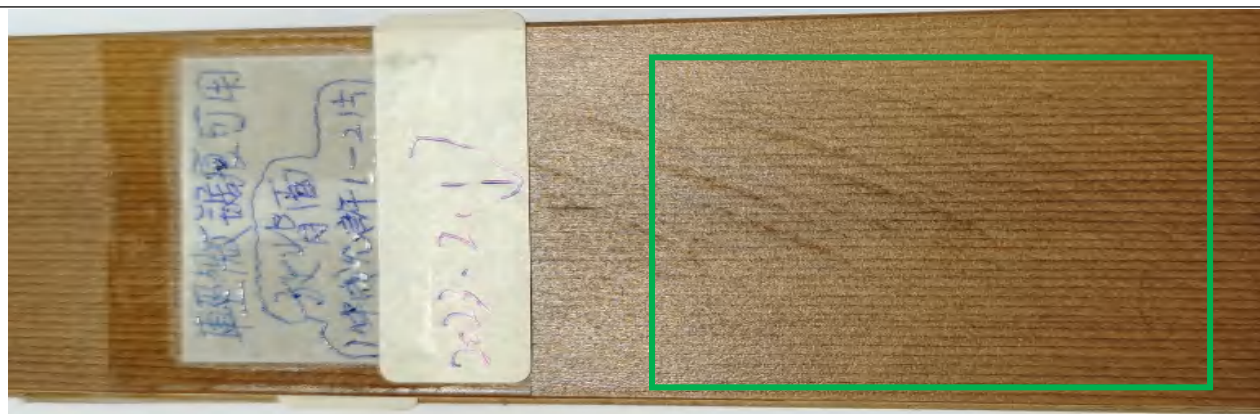
毛孔粗，可接受，通常用在帘子背面。✓

Blinds with fine pores, it is OK. Use on the back of blinds ✓



修补点漆后可以使用 ✓

After repairing with paint, it can be used. ✓



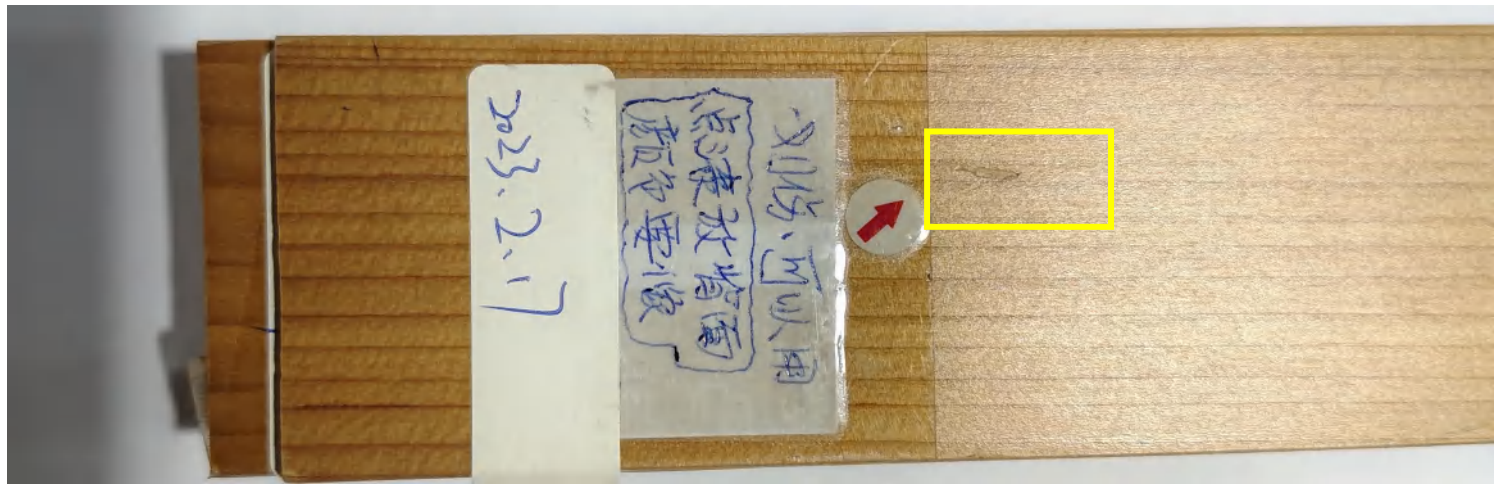
轻微锯痕，可以使用，放在成品背面。每 100 片，允许 2-3 片出现 ✓

Slight saw marks, can be used , and placed on the back of the finished product. Every 100 pcs allow 2-3 pcs. ✓



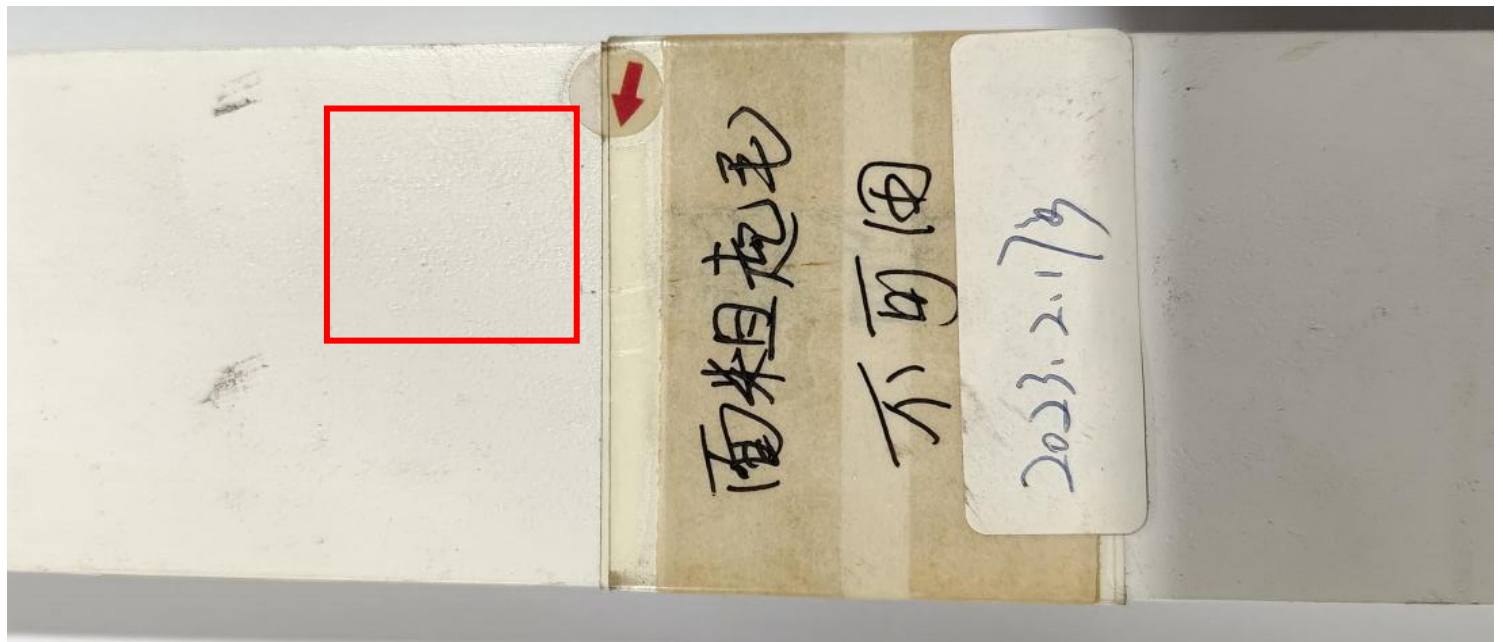
轻微油漆不良品，可以用，在成品背面 ✓

Minor paint defects can be used on the back of the finished product. ✓



划伤，点漆修补后可以用，颜色要接近，放在背面 ✓

Scratches can be repaired with paint and it is OK to be used. The color should be similar and placed on the back of blinds ✓



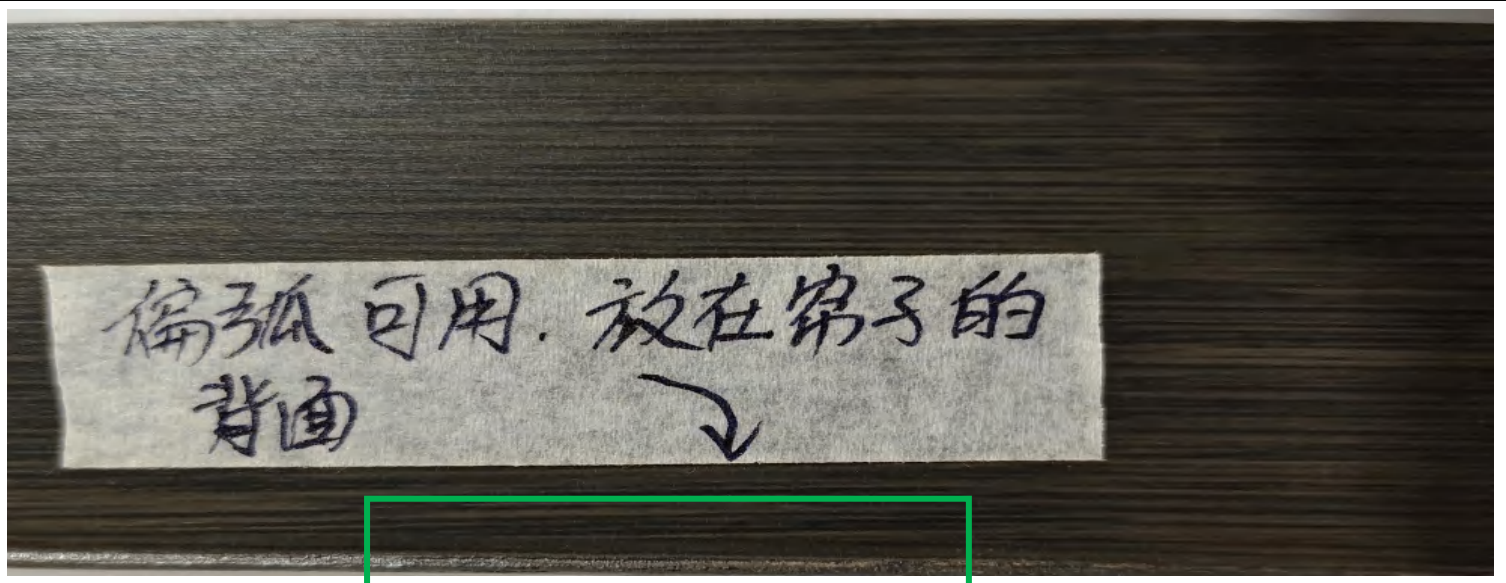
表面粗糙起毛，不可以接受。×

Surface roughness and fuzzing are unacceptable. ×



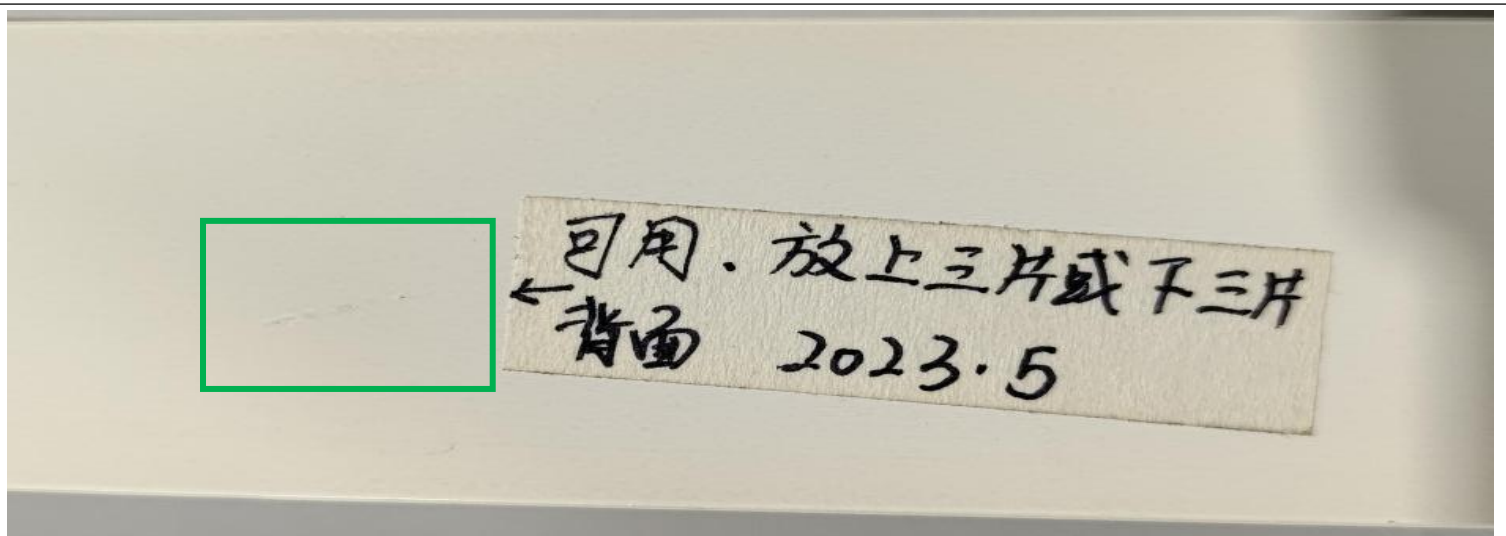
轻微锯痕，可以使用，放在成品背面。每 100 片，允许 2-3 片出现 ✓

Slight saw marks, can be used, and placed on the back of the finished product. Every 100 pcs allow 2-3 pcs. ✓



偏弧，可以接受，用在背面。✓

Radians slightly skewed, it is OK, and used on the back of blinds. ✓

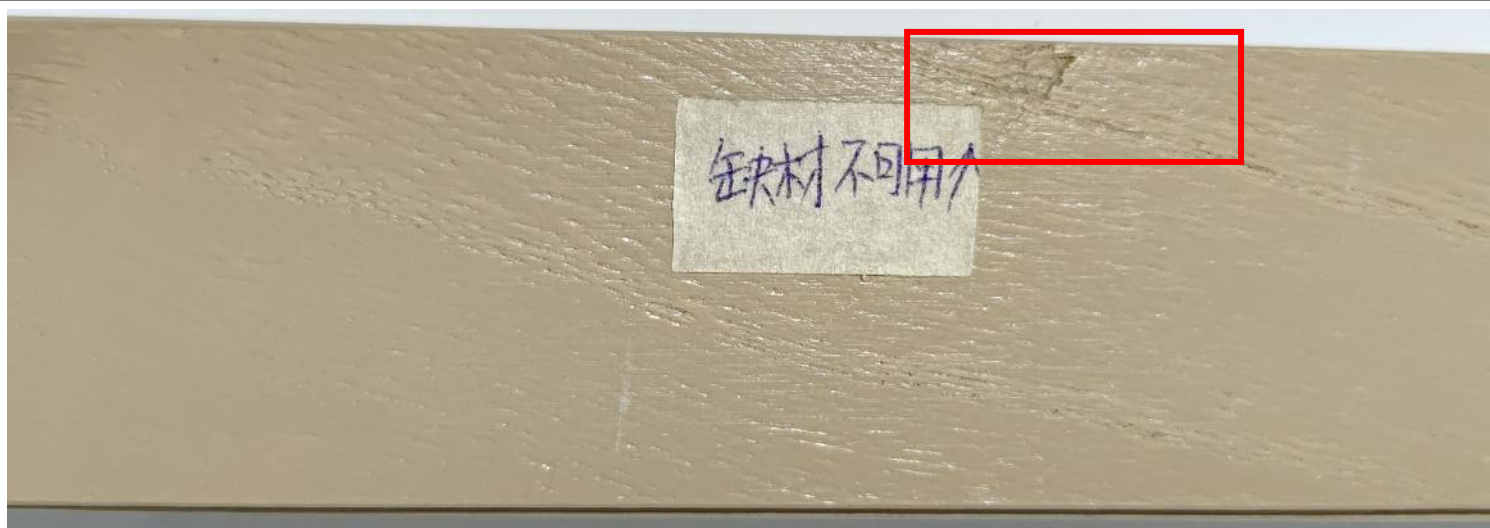


可以接受 ✓

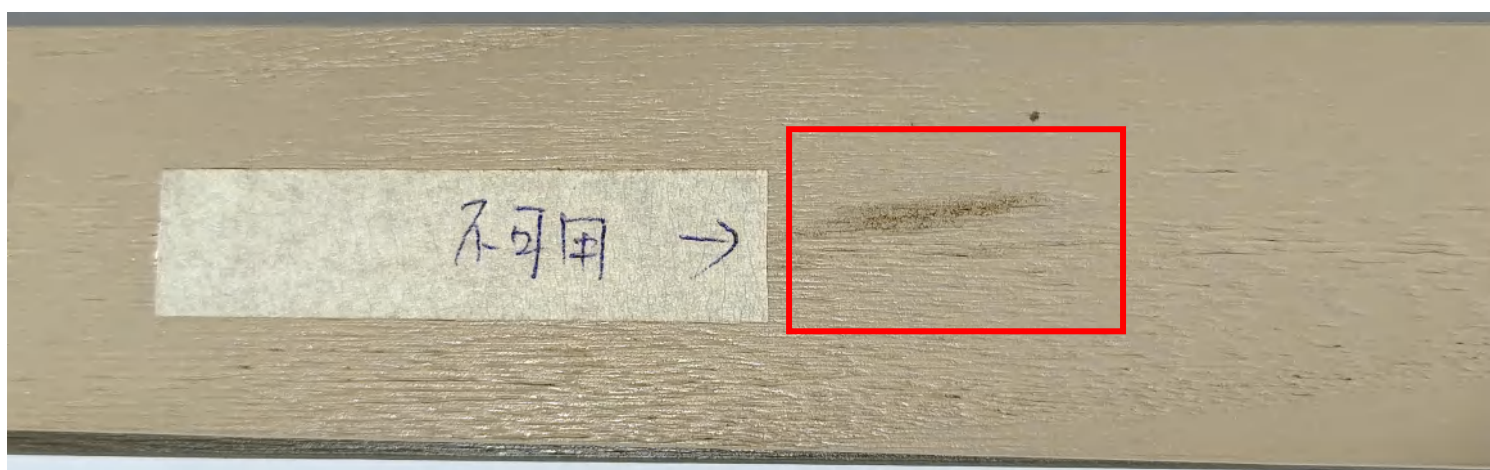
It is OK, used on the top 3 slats or bottom 3 slats of blinds ✓



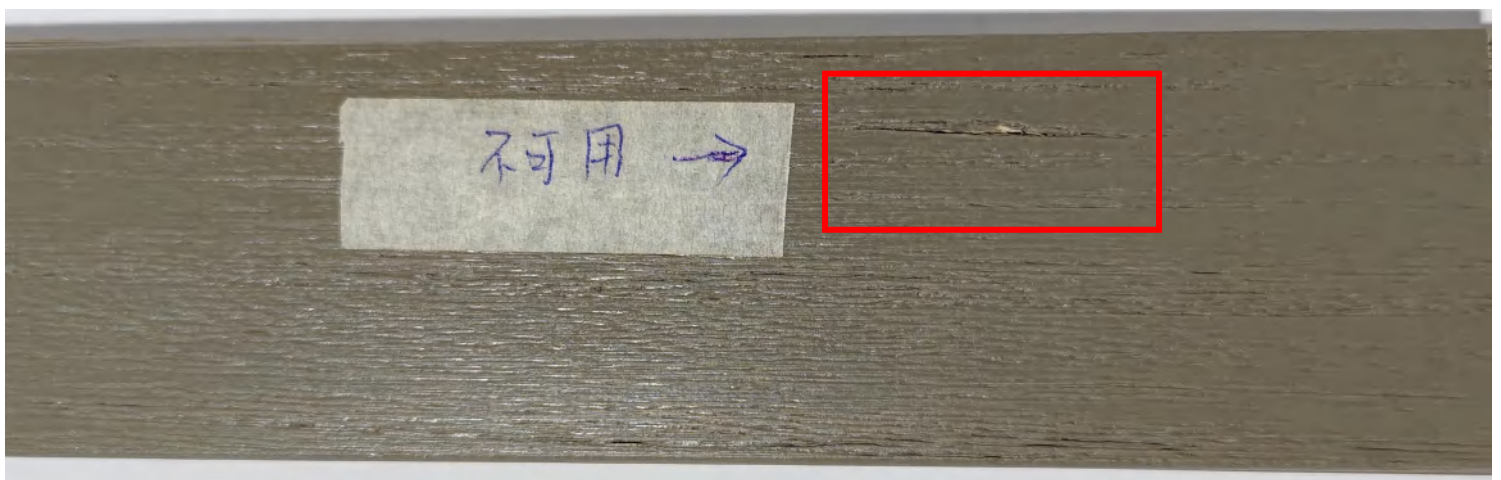
不可以×
Not can be used ×



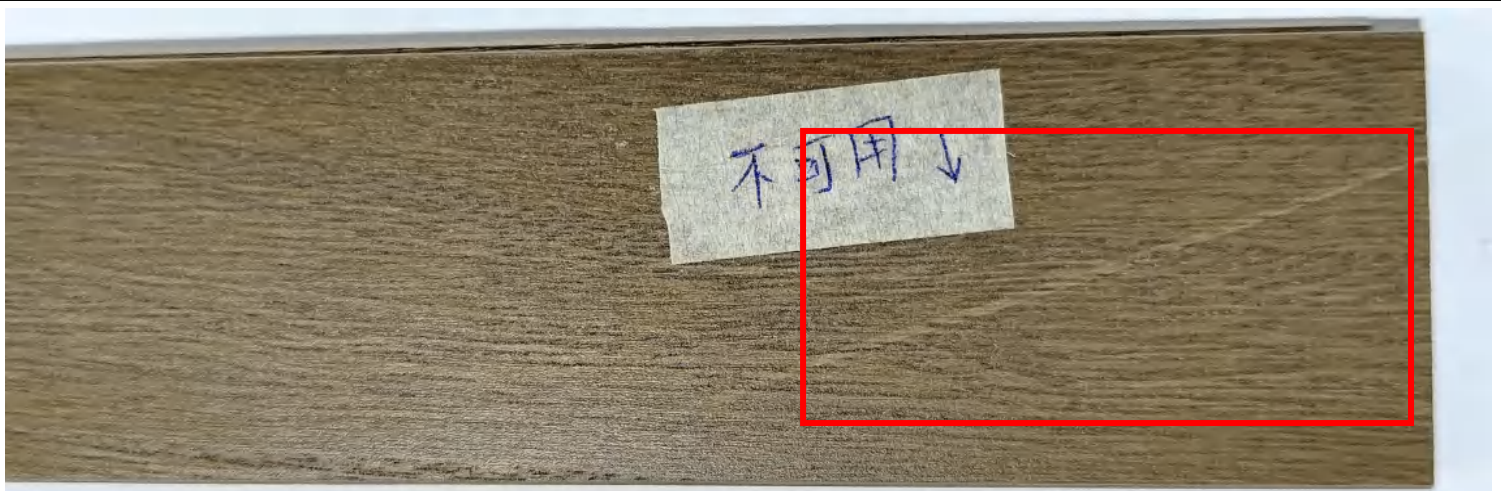
缺材不可用×
Lack of wood,not OK ×



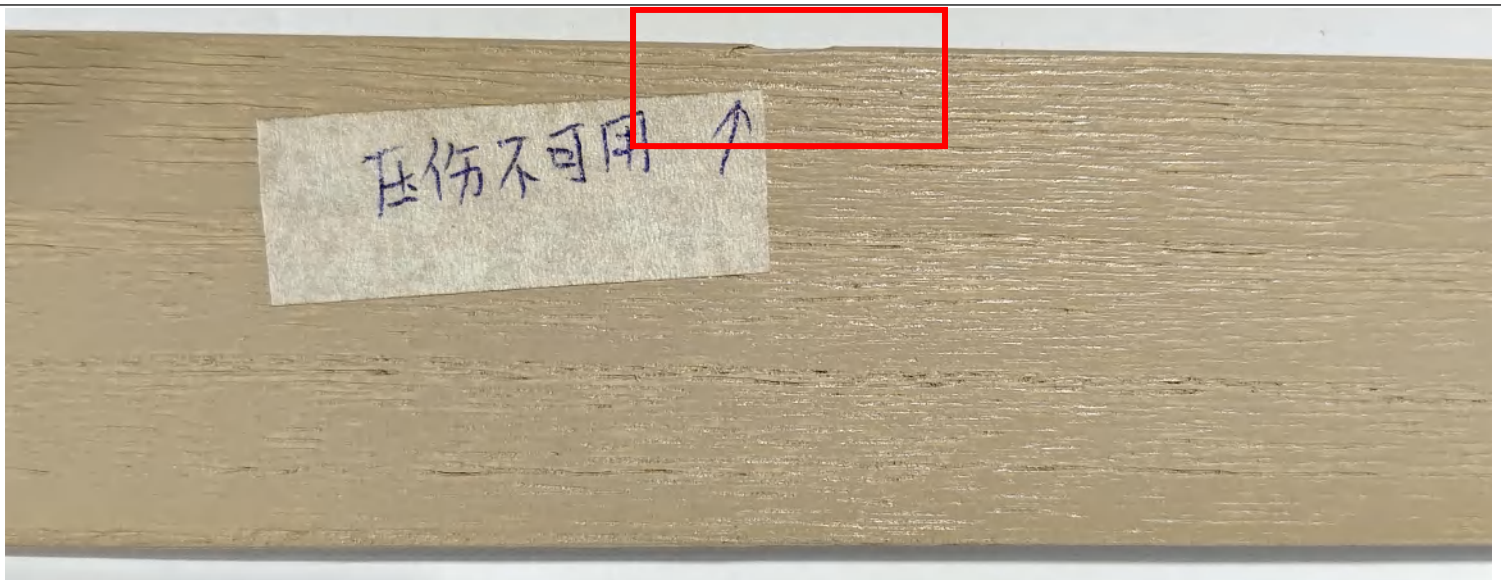
不可以×
Not can be used ×



不可以×
Not can be used ×



不可以×
Not can be used ×

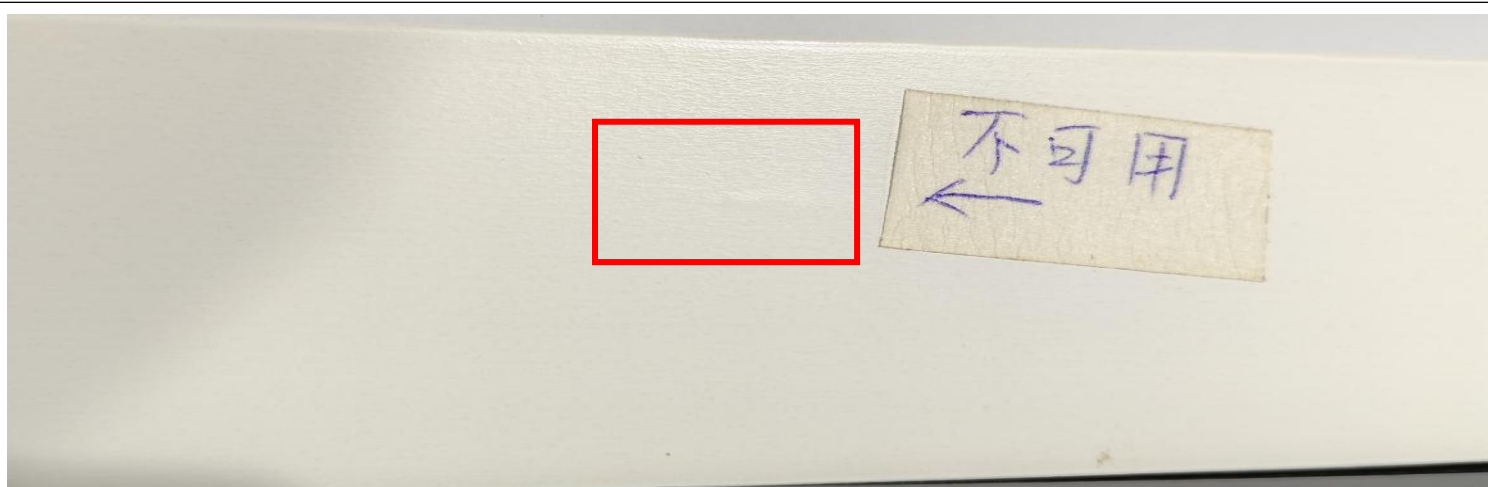


压伤不可以×
Pressure injury, not can be used ×



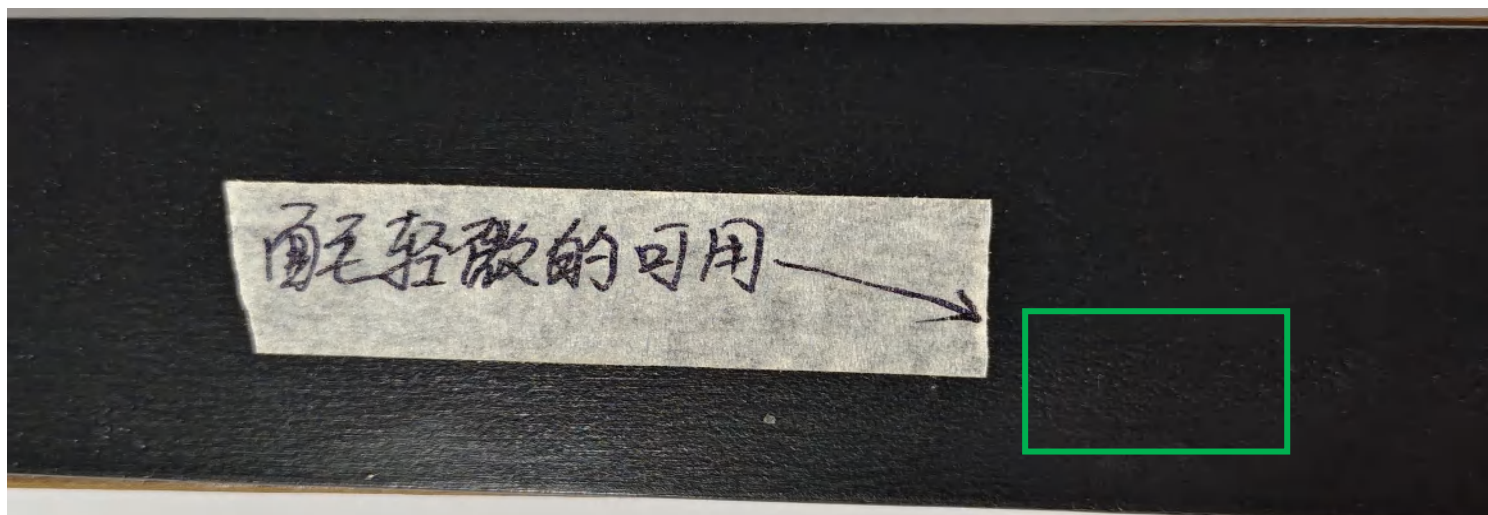
毛孔粗，不可接受×

Blinds with fine pores, not OK. ×



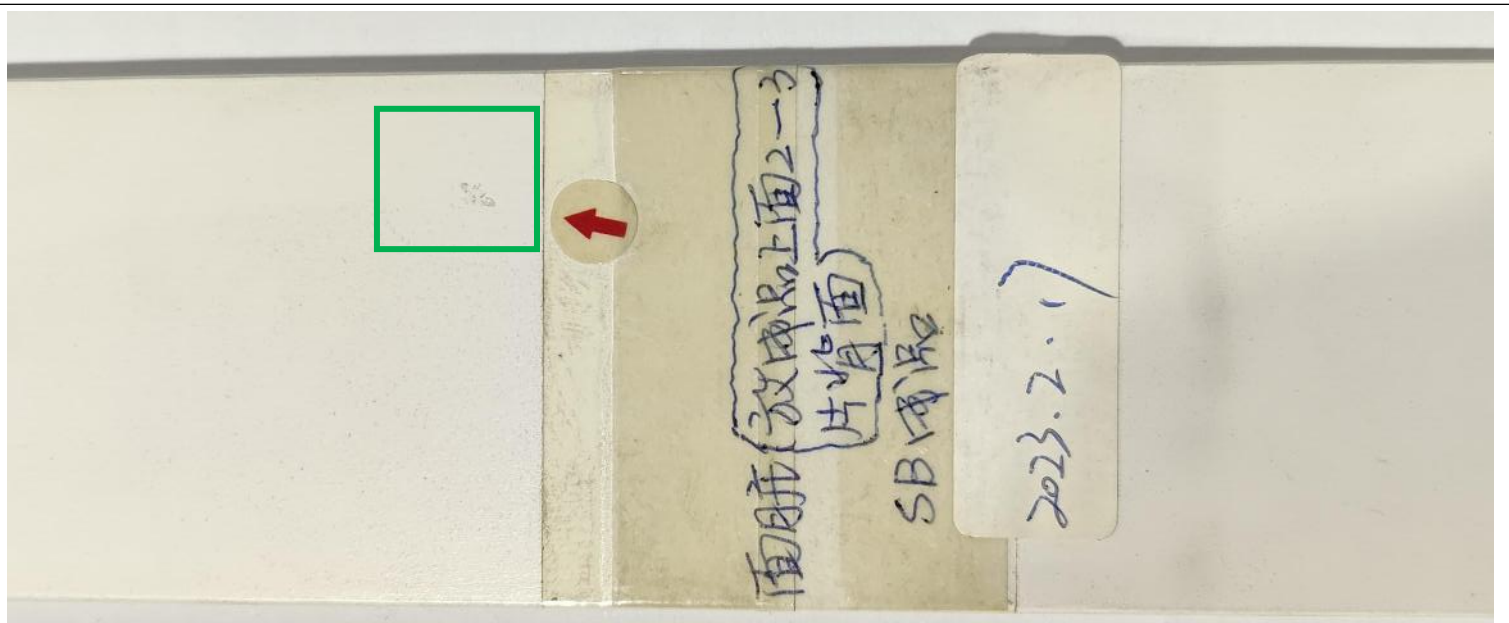
不可以×

Not can be used ×



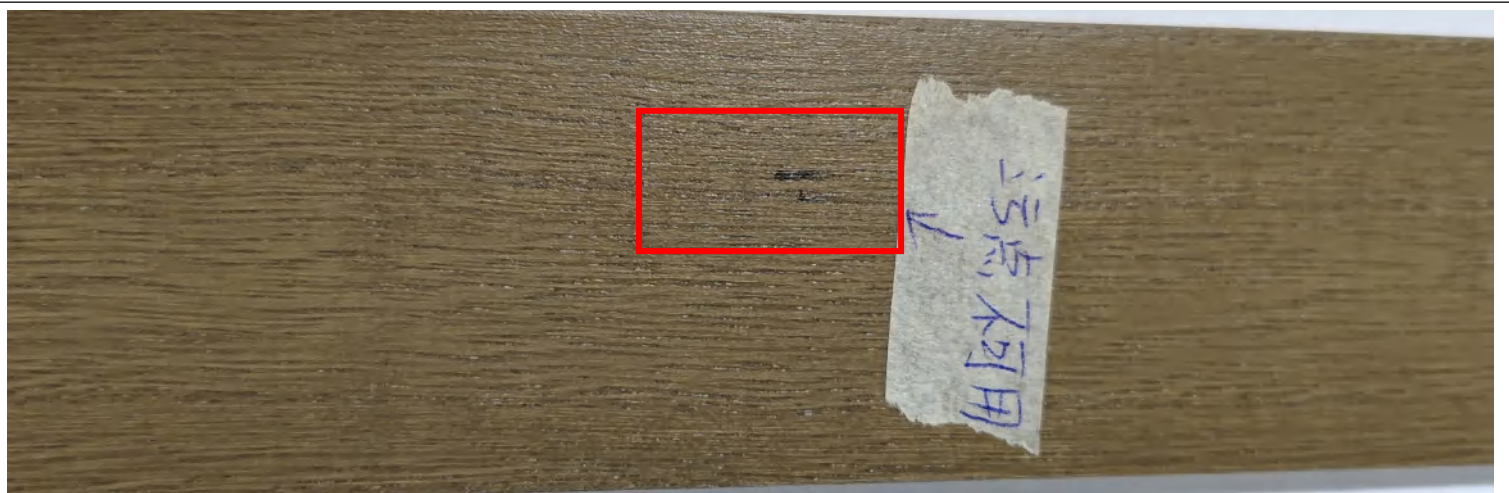
轻微起毛，可以用✓

Slight fuzzing, can be used ✓



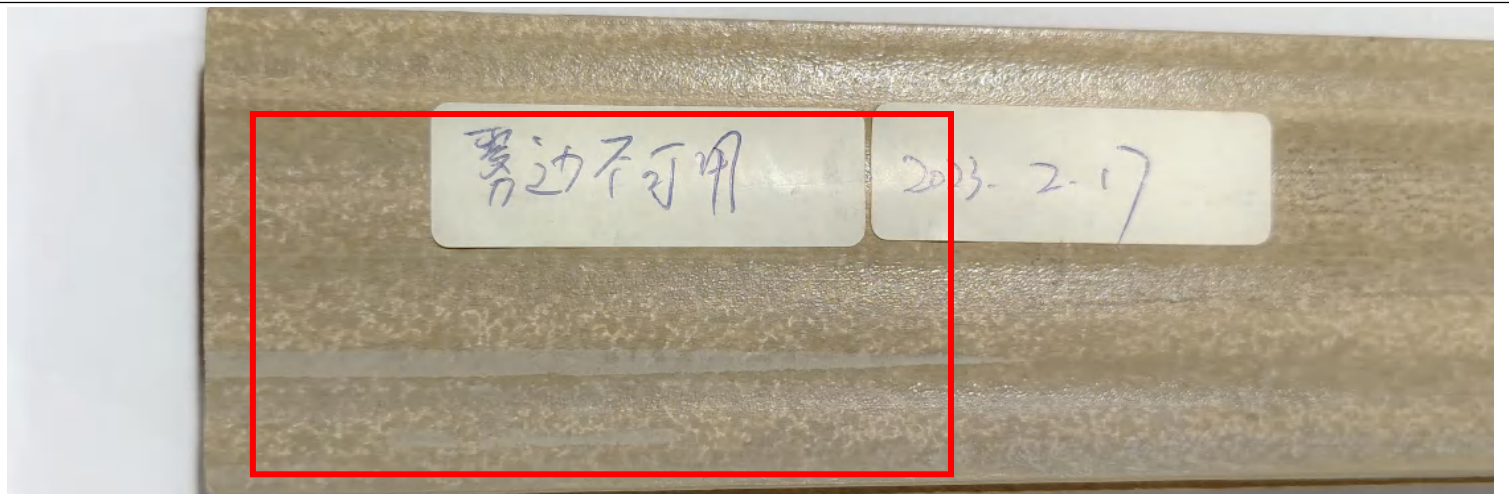
表面轻微脏污，可以使用，放在成品顶部 2-3 片背面。

The surface is slightly dirty and can be used. Used on top 2-3 slats back of the finished product.



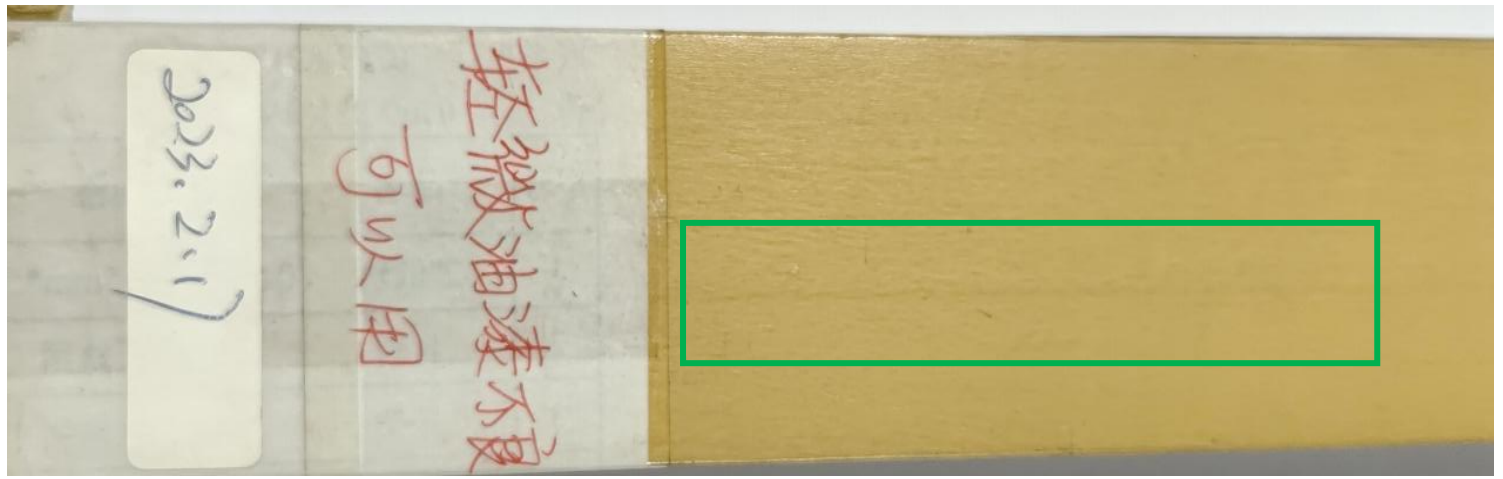
污点不可用×

Taint, not can be used.×



雾边不可以×

Misting of edge paint, not can be used×



轻微油漆不良品，可以用，在成品背面 ✓

Minor paint defects can be used on the back of the finished product. ✓



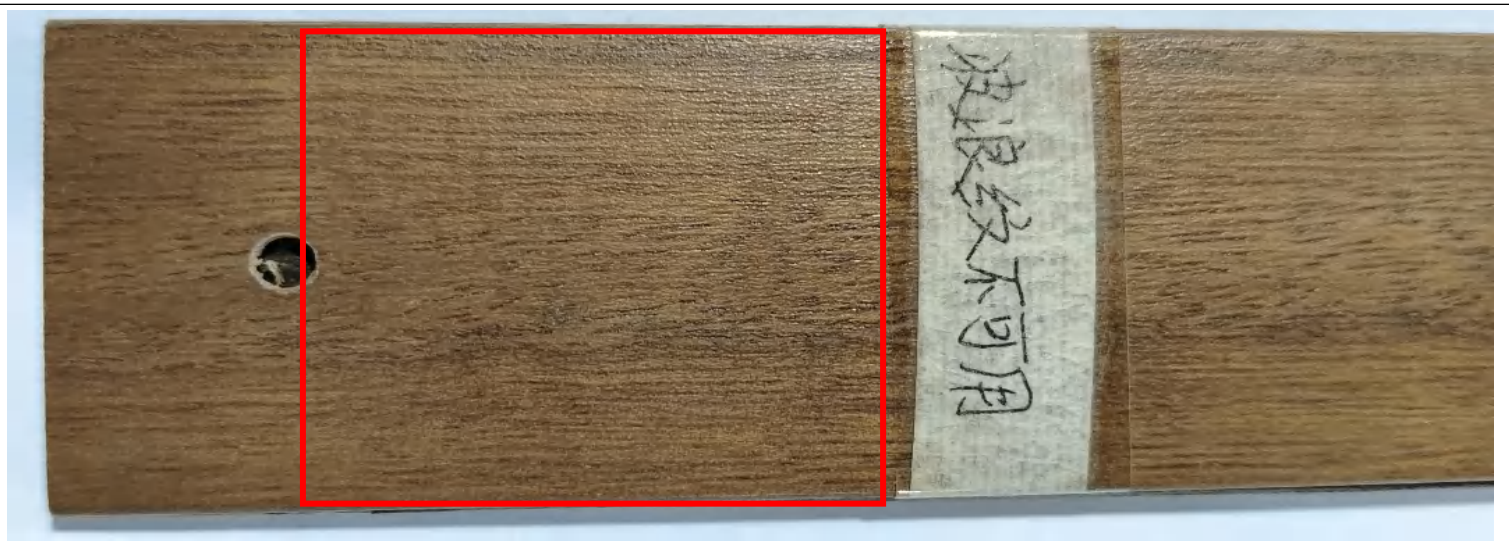
表面粗糙，不可以 ×

The surface is rough, not can be used ×

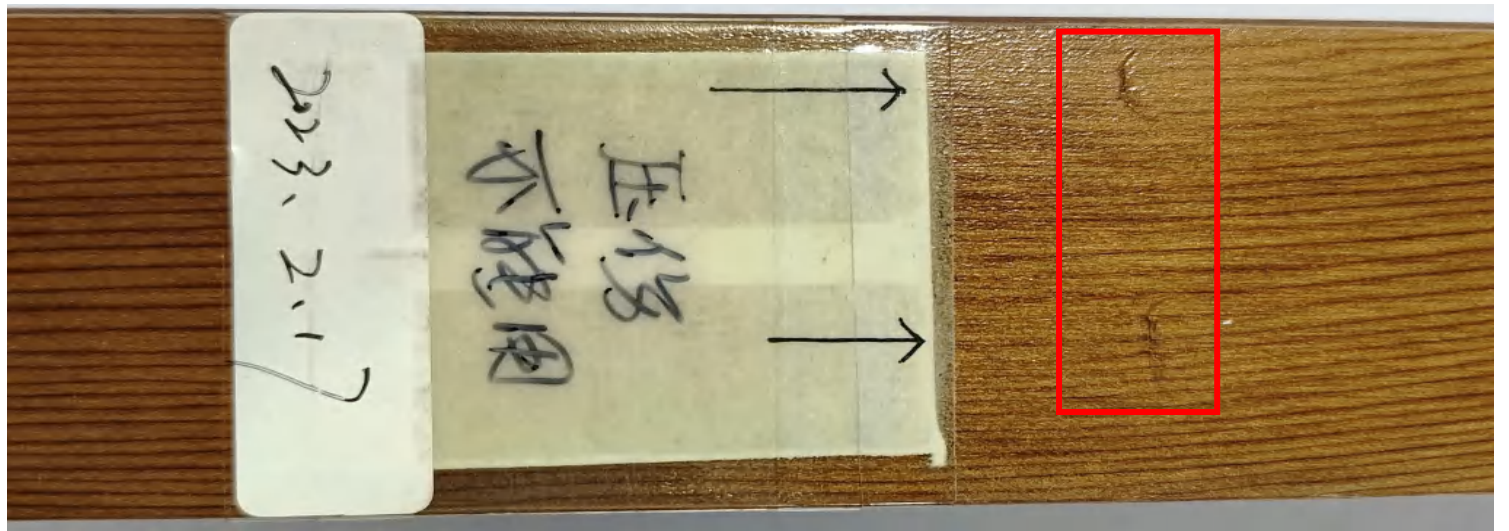


素材有斑点，不可以使用 ×

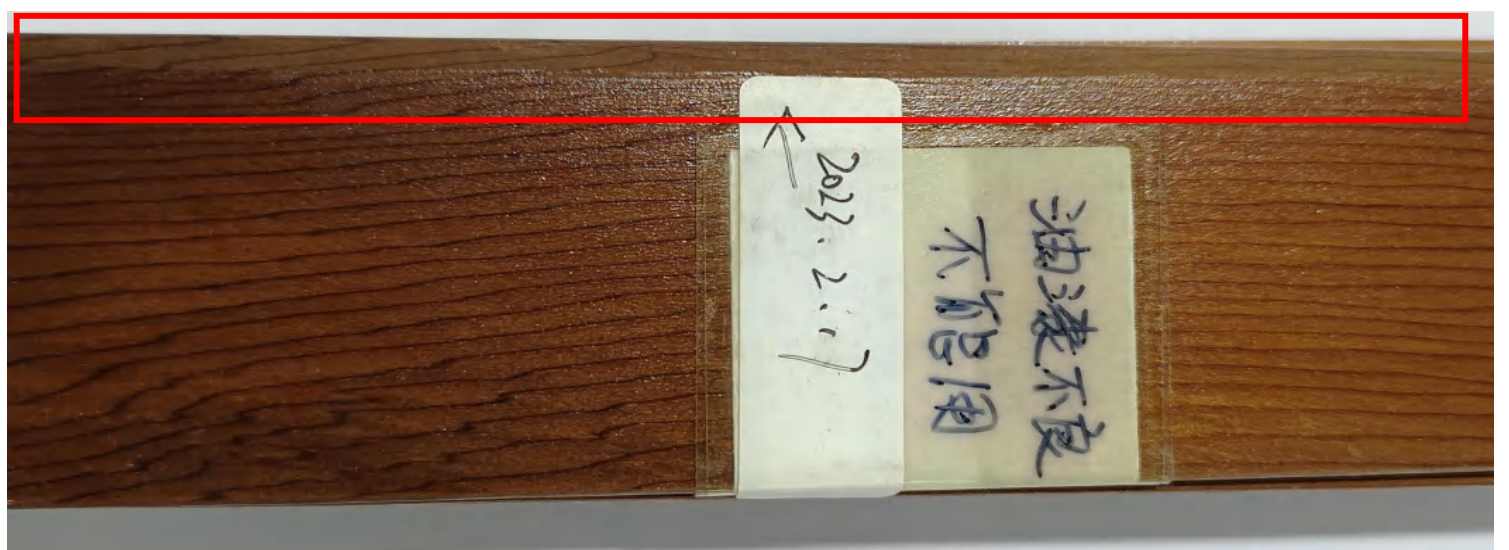
The material has spots, not can be used ×



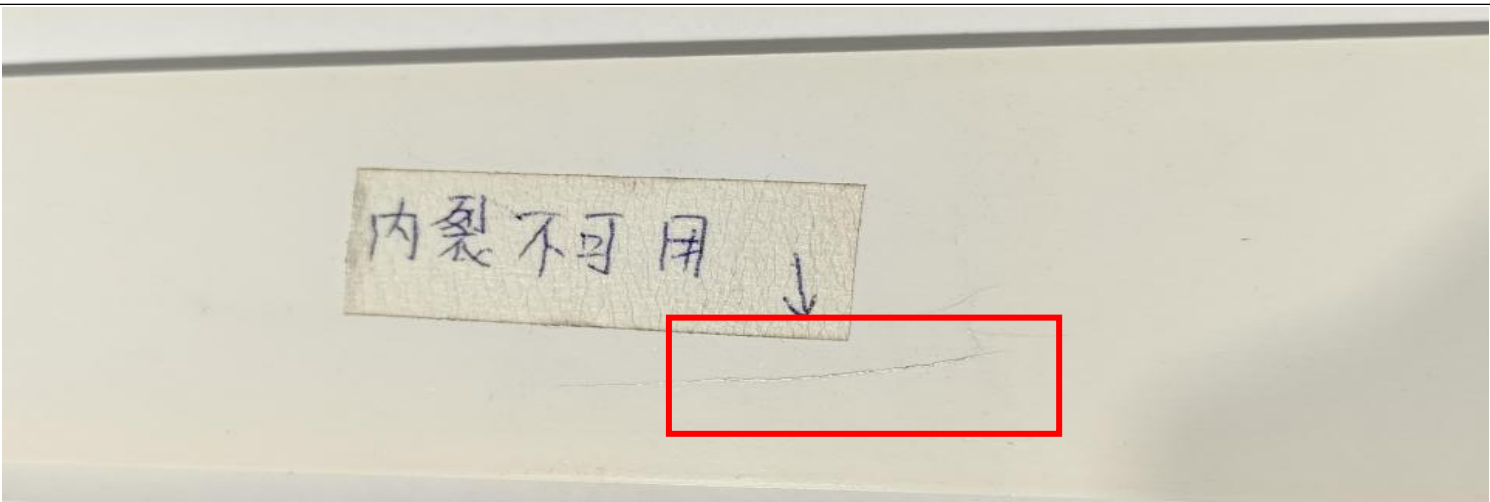
波浪纹，不可以×
Wave pattern, not allowed×



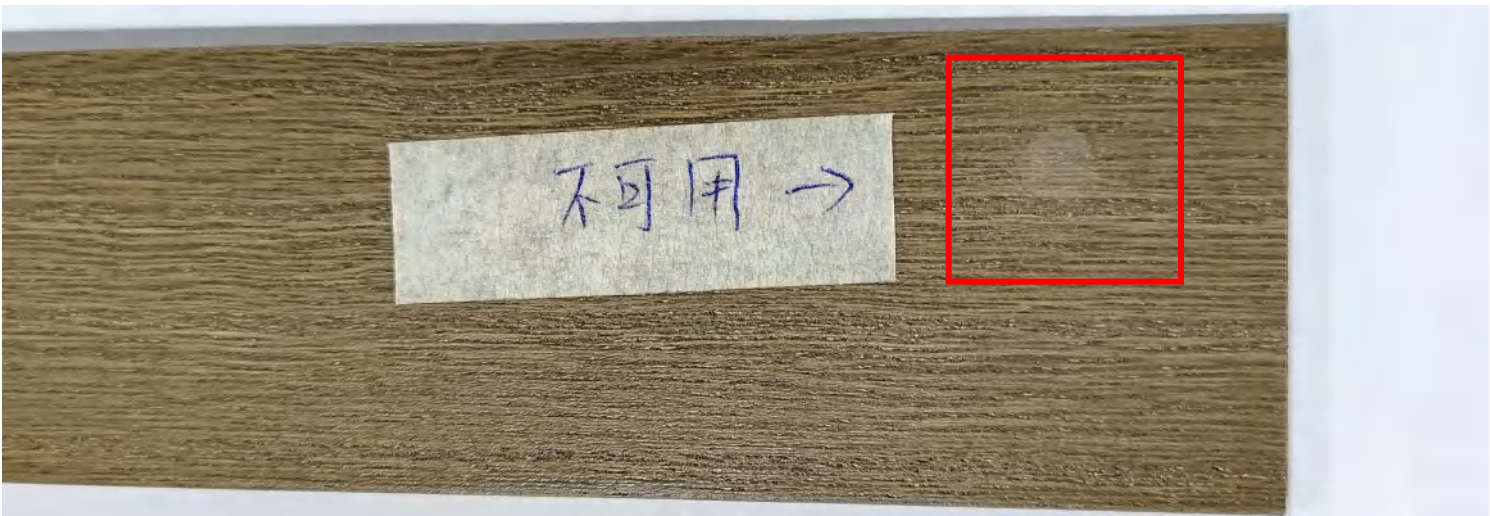
压伤不可以×
Pressure injury, not can be used ×



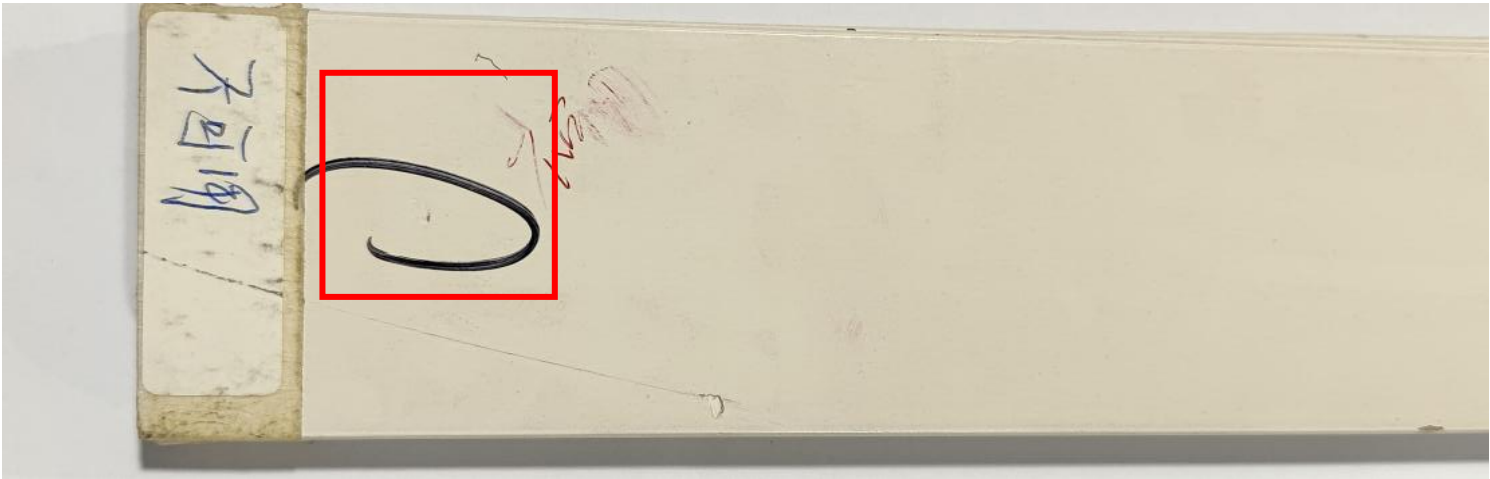
油漆不良，不可用×
The paint has defects and uneven edges, bot can be used. ×



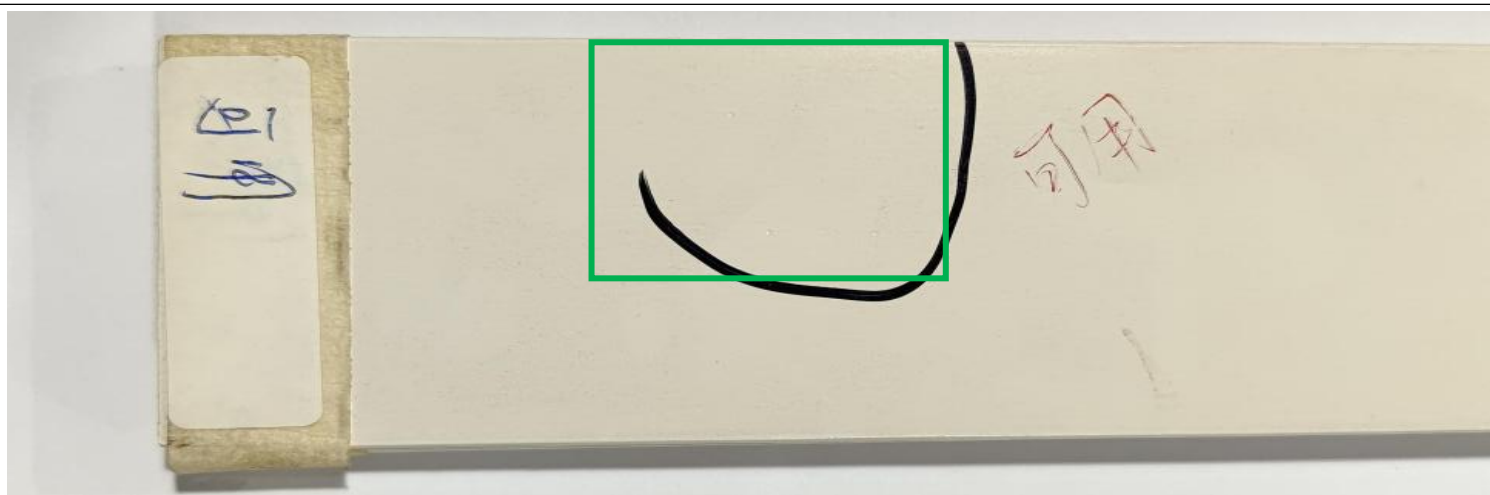
内部开裂，不可用×
Internal cracking, not can be used×



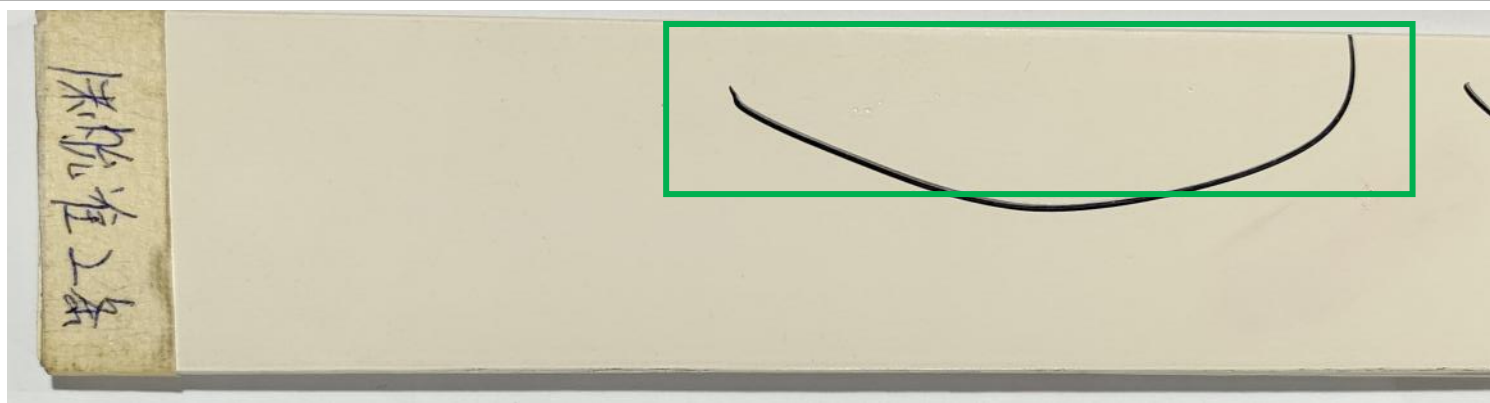
脏污不可用×
Taint, not can be used×



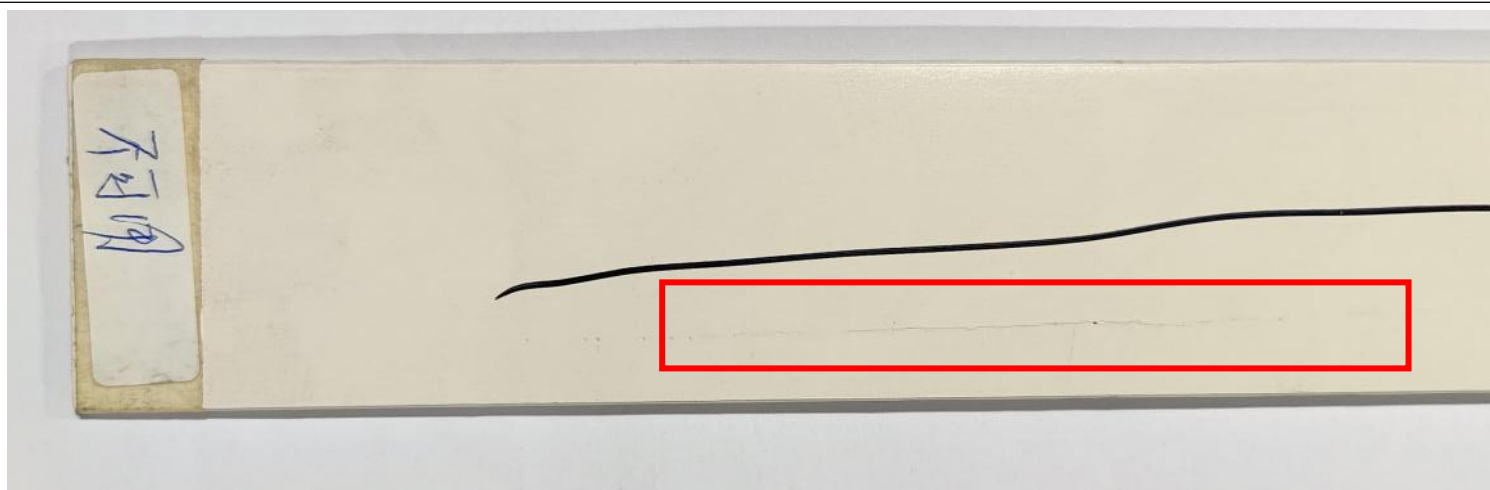
不可以×
Not can be used ×



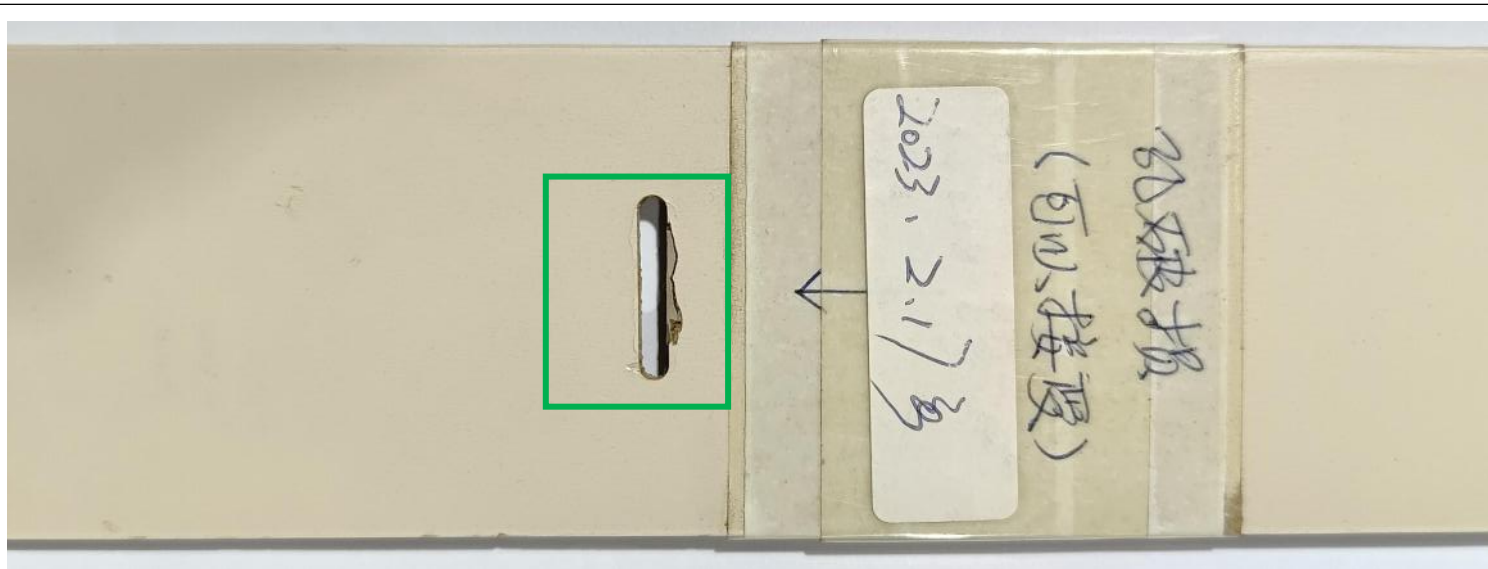
可以 ✓
It is OK ✓



可以，一米内允许有 2 条 ✓
It is OK, 2 pieces are allowed within 1 meter slats ✓



不可以 ×
Not can be used ×



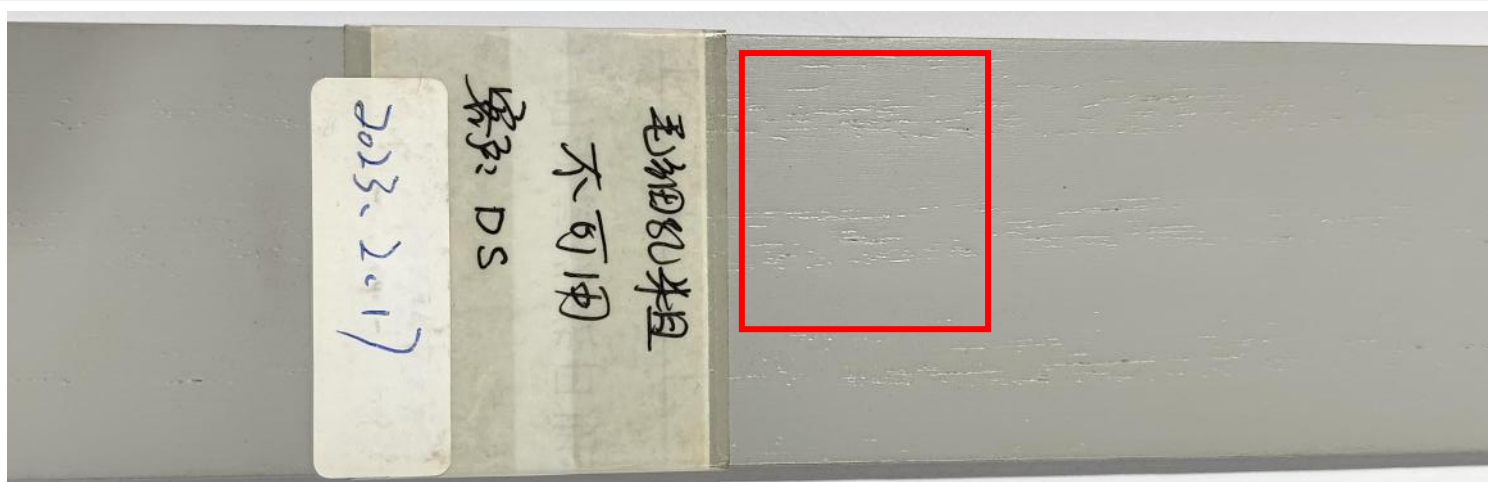
轻微孔破损，可以 ✓

It is OK ✓



不可以 ×

Hole not can be used ×

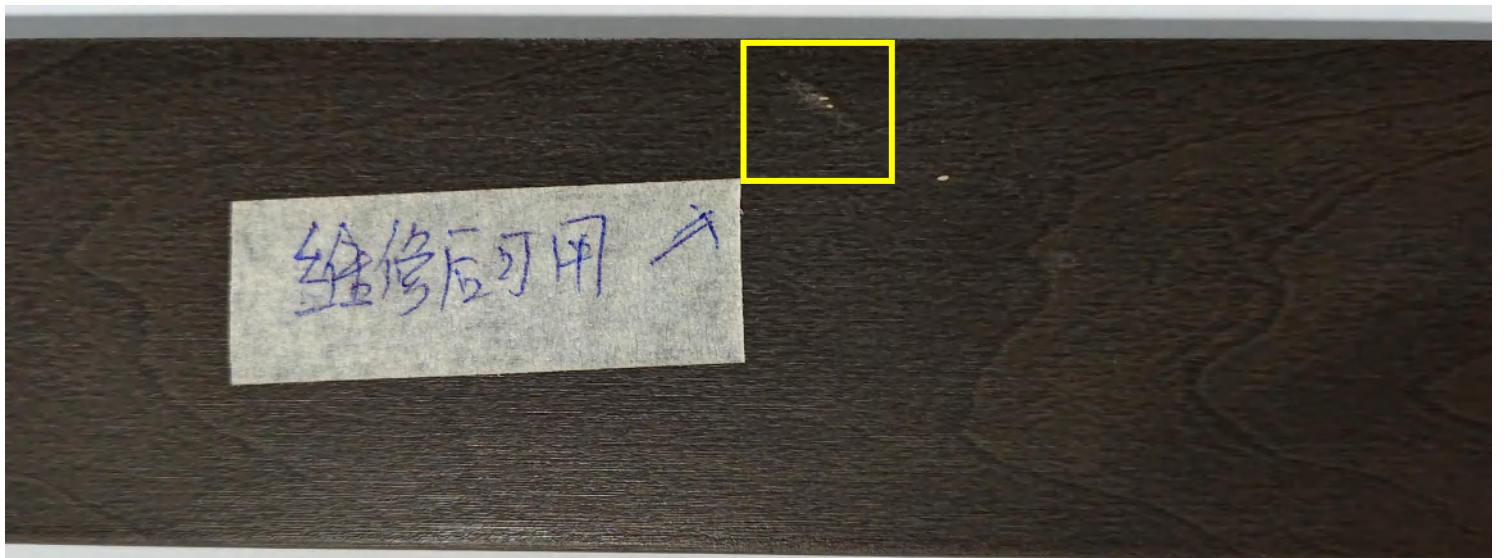


不可以 ×

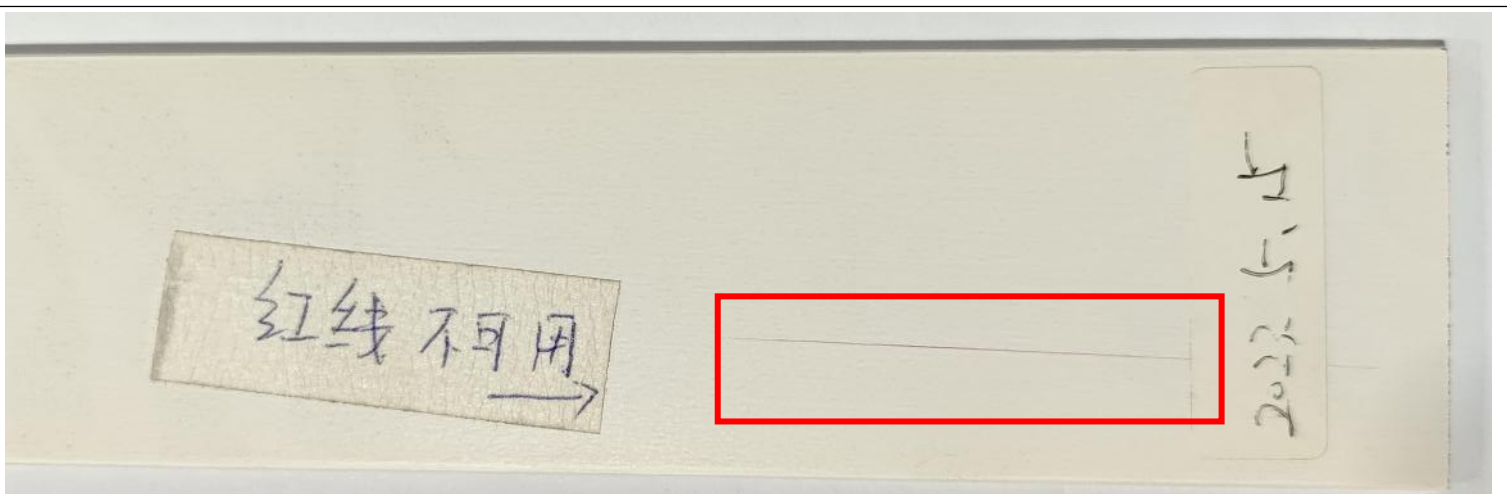
Not can be used ×



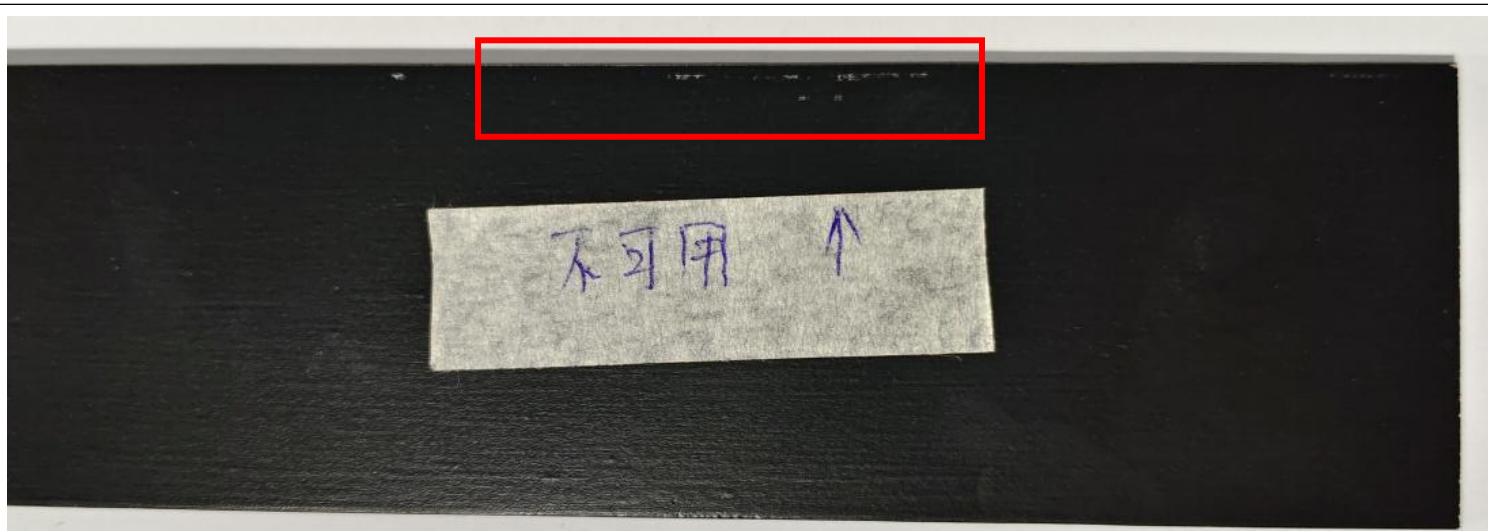
修补后可用 ✓
Can be used after repair ✓



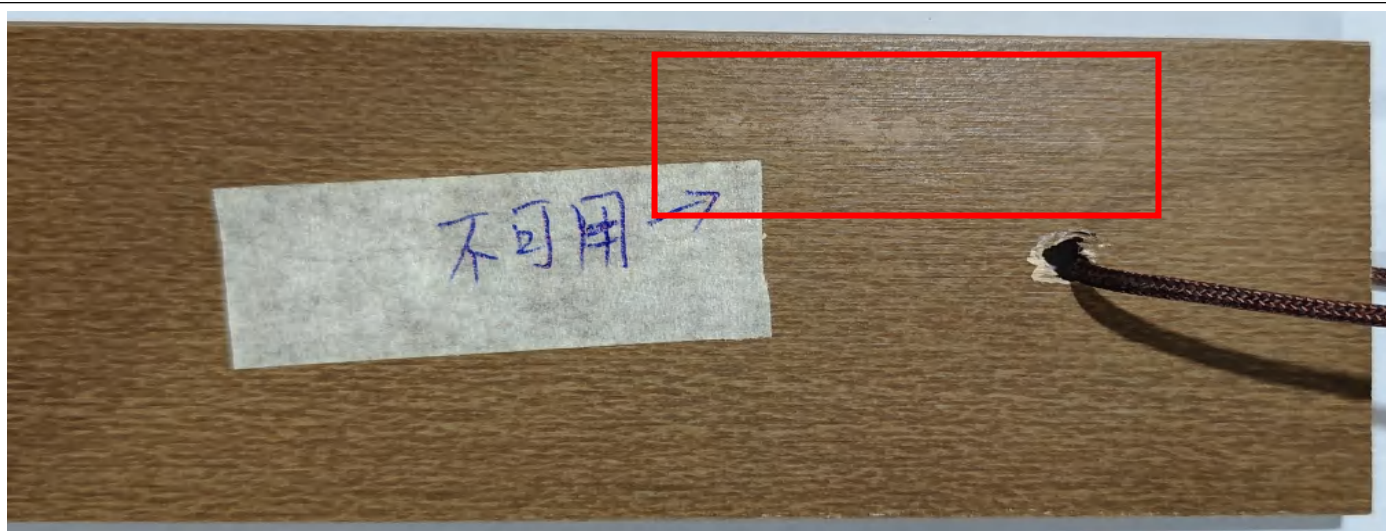
修补后可用 ✓
Can be used after repair ✓



表面有红线，不可用 ×
Red line, not can be used ×



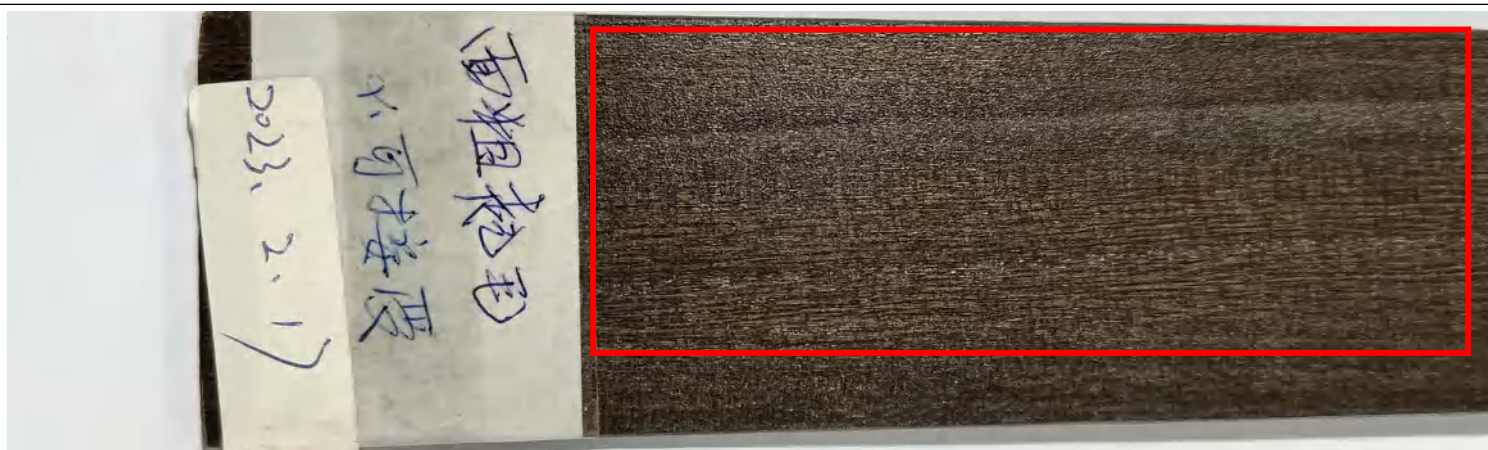
不可以×
Not can be used ×



不可以×
Not can be used ×

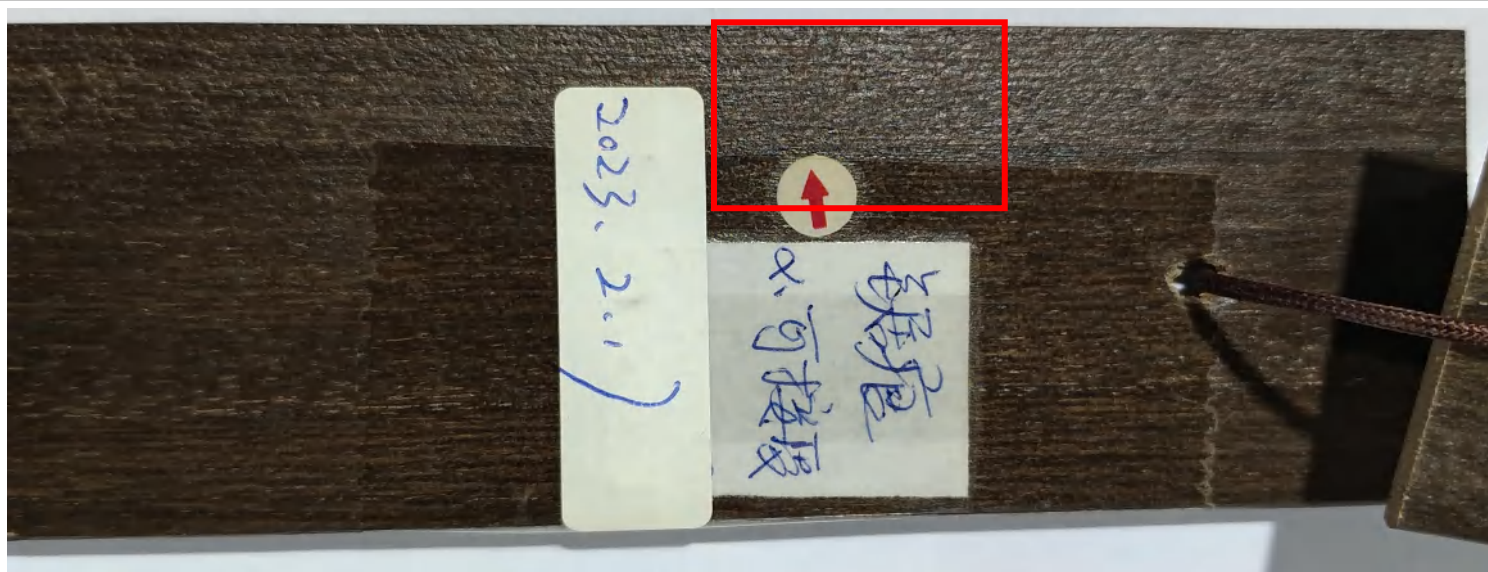


油漆太厚，表面不平整，不可以×
The paint is too thick and the surface is uneven. Not can be used ×



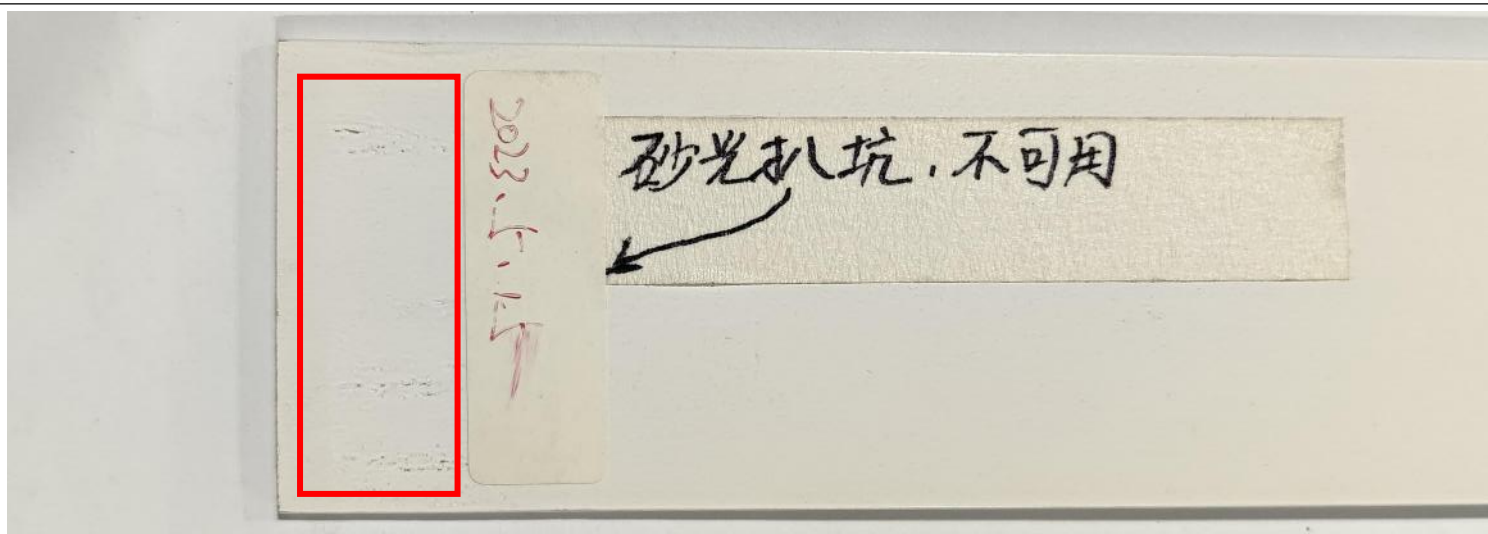
面部粗糙起毛，不可用×

Rough surface with fuzzing, not can be used×



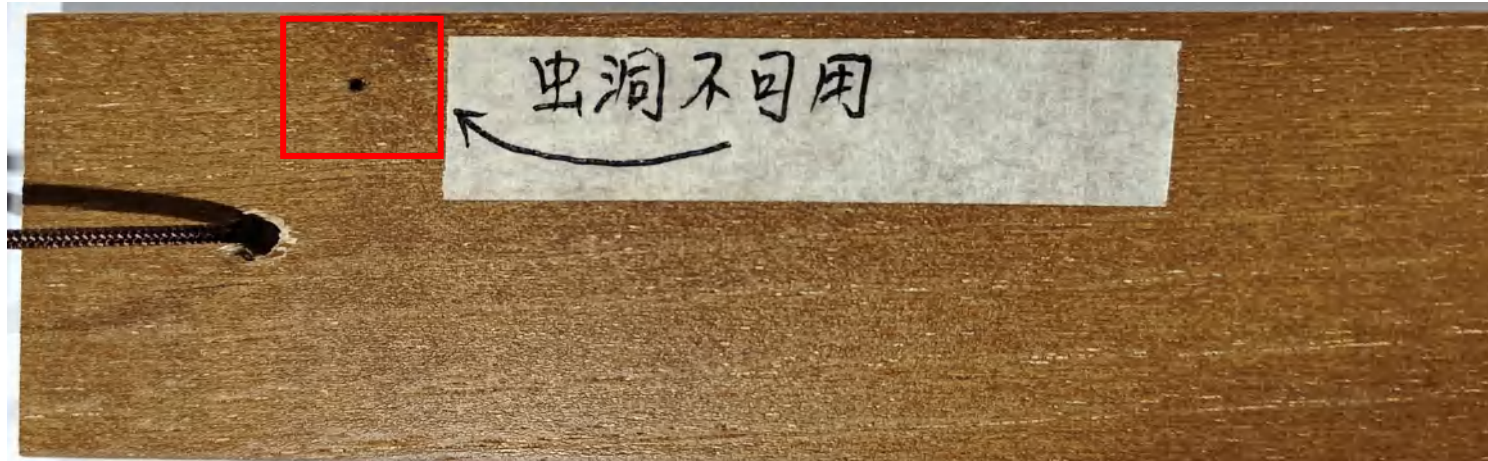
锯痕不可用×

Saw mark, not can be used ×



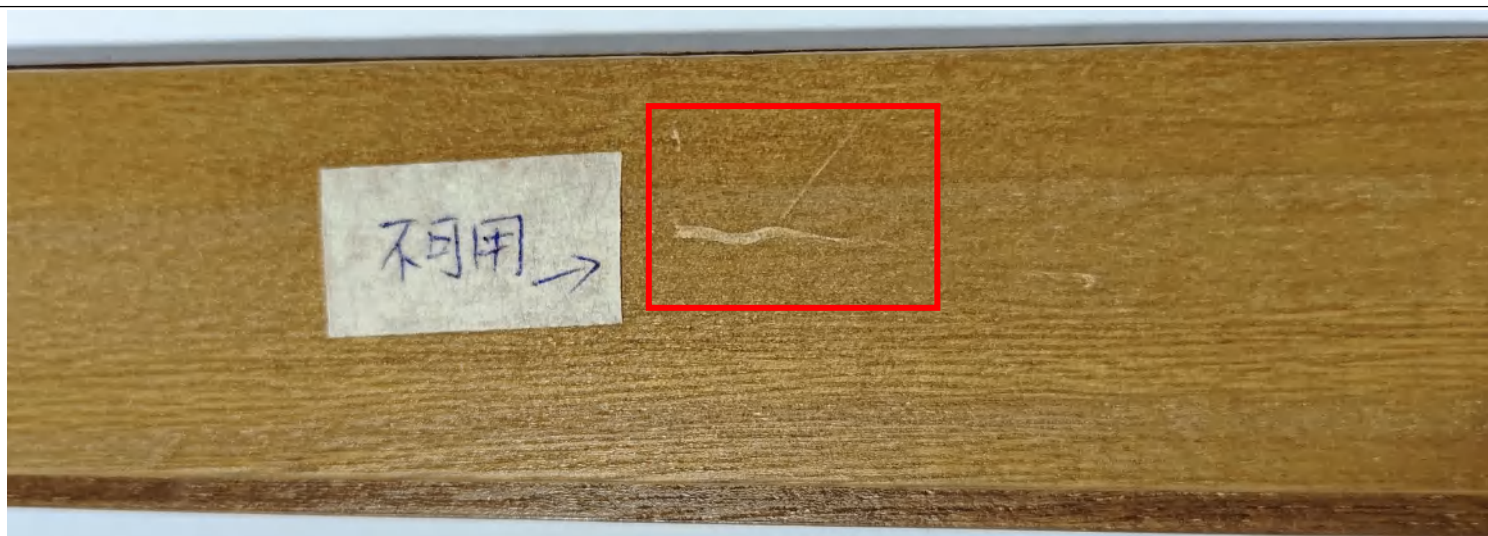
砂光扒坑，不可用×

Pit pulled out by sanding, not can be used×



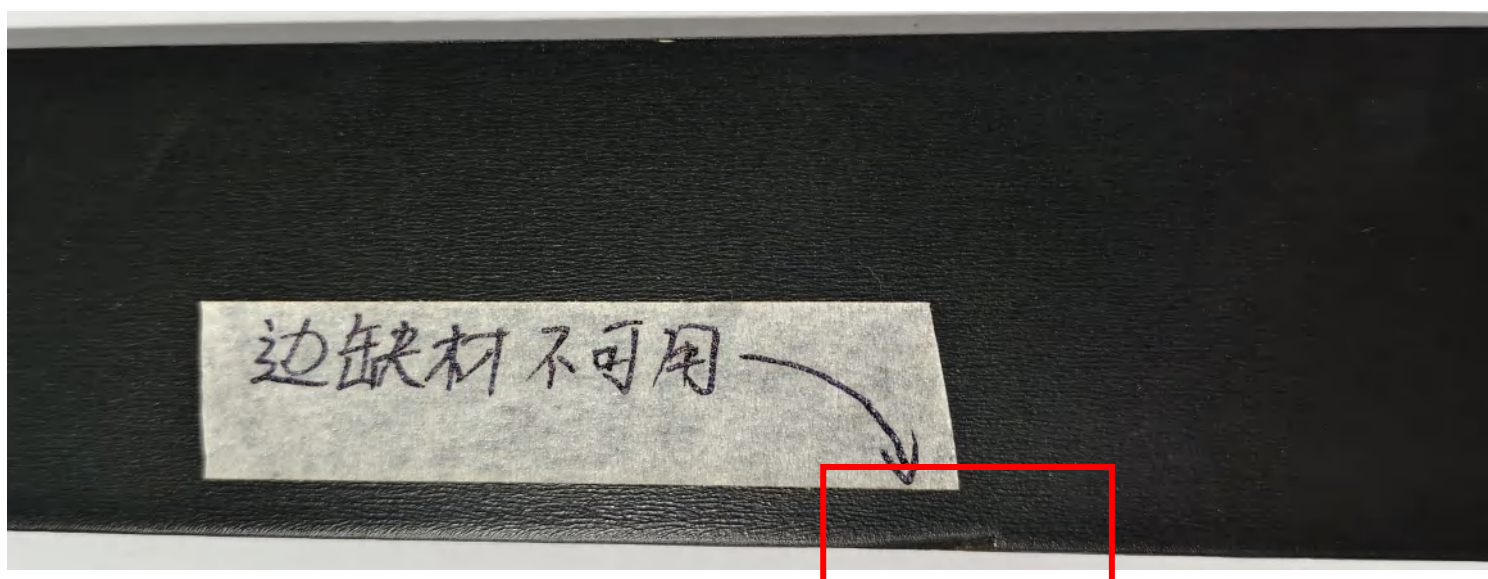
虫洞不可用×

Wormhole ,not canbe used ×



不可以×

Not can be used ×



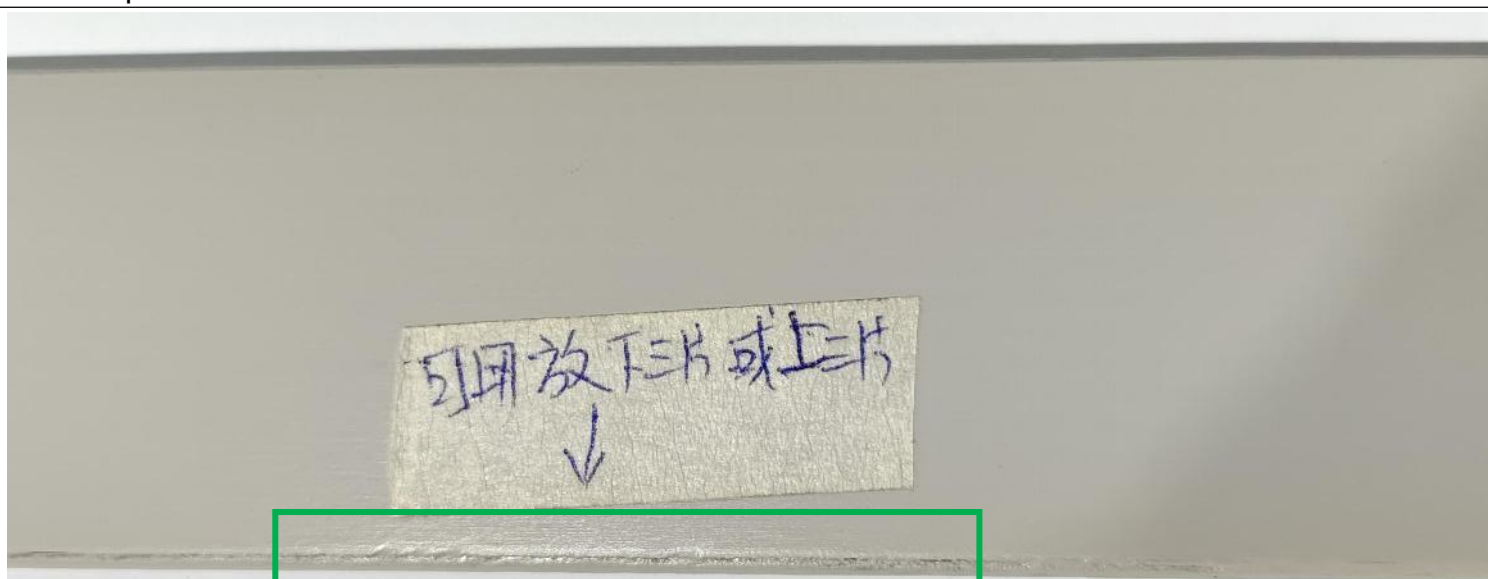
边缘缺材，不可以×

Lack of wood ,not can be used ×



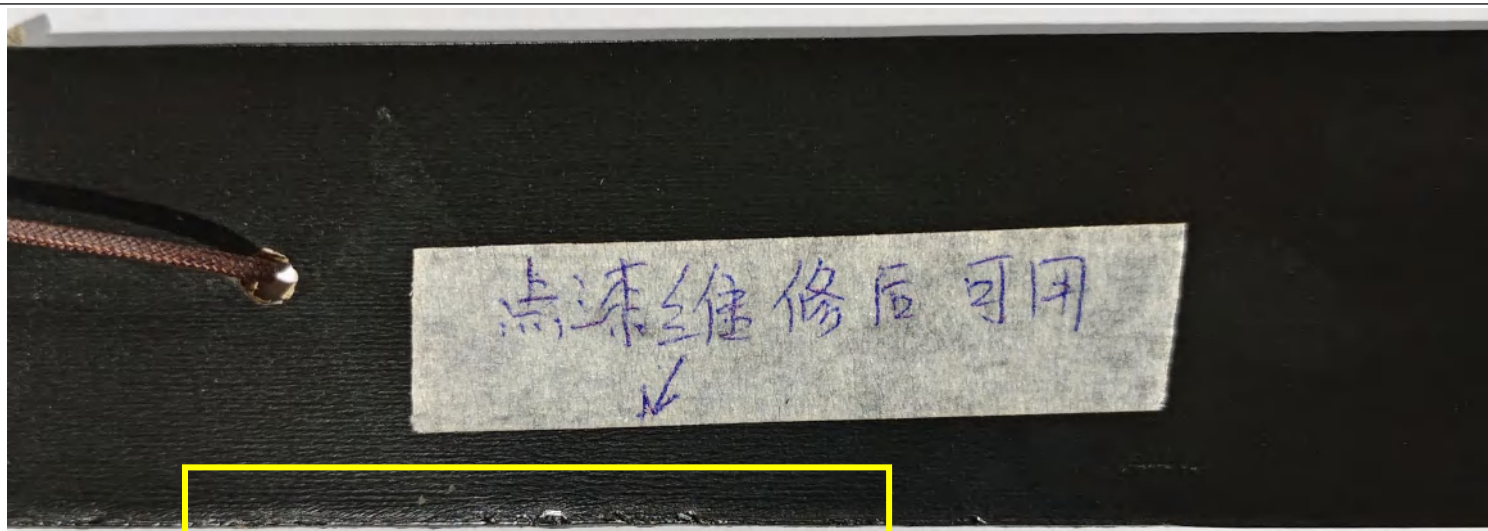
表面严重的颗粒，不可用×

Serious particles on the surface, not can be used×



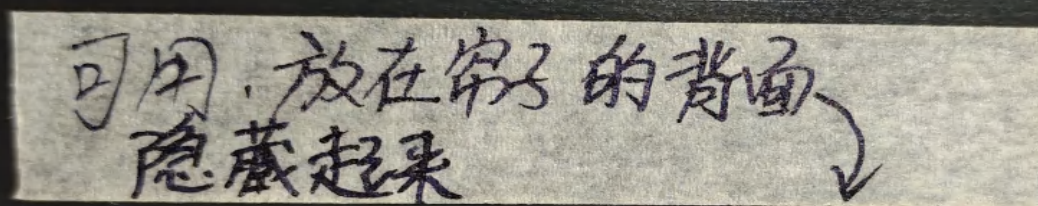
可以接受✓

It is OK,used on the top 3 slats or bottom 3 slats of blinds ✓



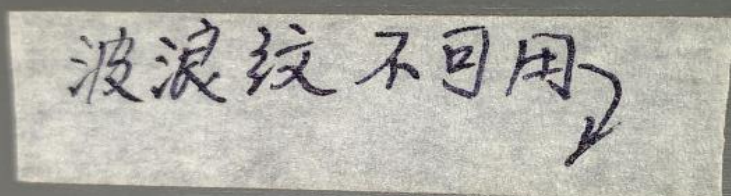
点漆修补后可用✓

Can be used after paint repair ✓



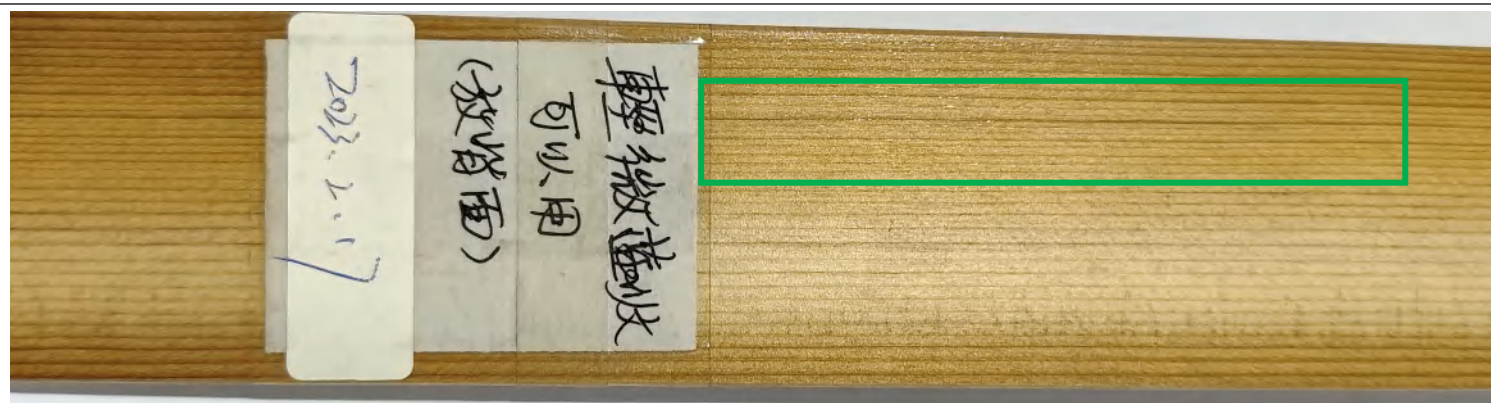
可以用在背面 ✓

Can be used on the back of blinds ✓



波浪纹，不可以 ✕

Wave pattern, not allowed ✕



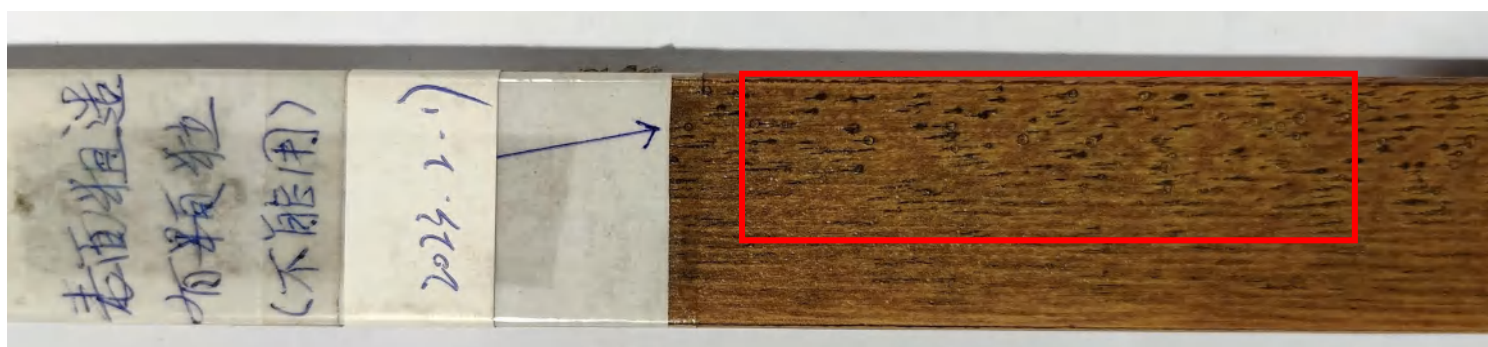
轻微蓝线纹路，可以用在背面 ✓

Slight blue line, can be used on the back of blinds ✓



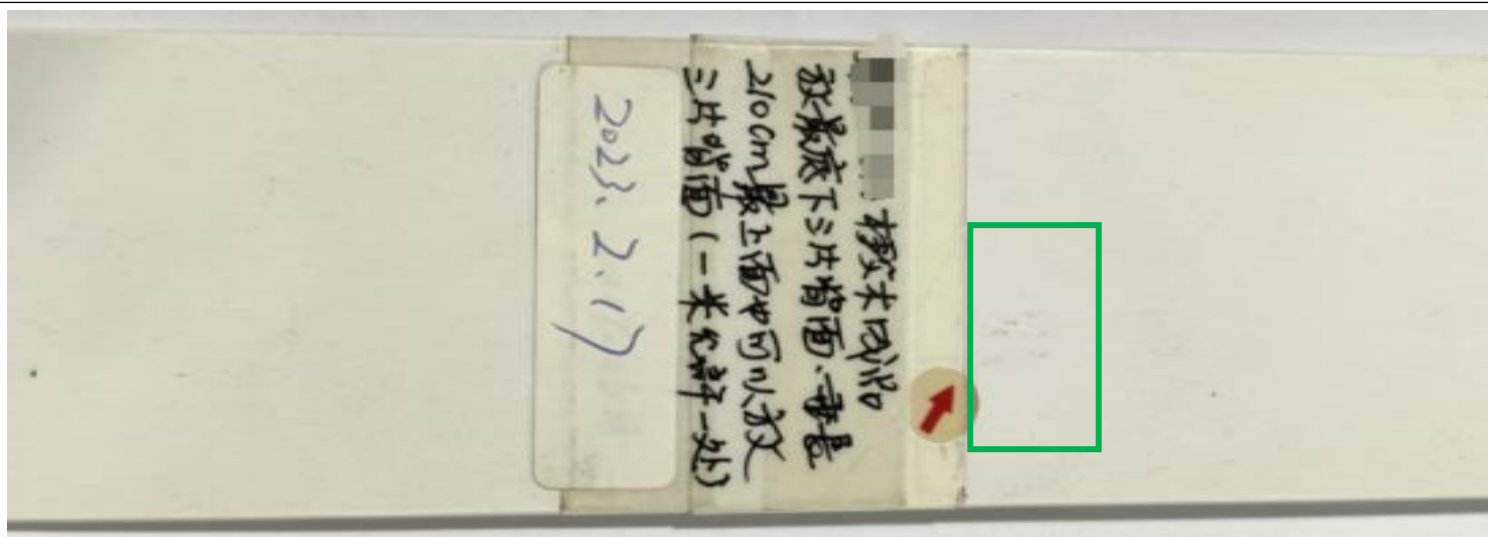
可以接受，用在背面顶部 ✓

Can be used on the back top slats of blinds ✓



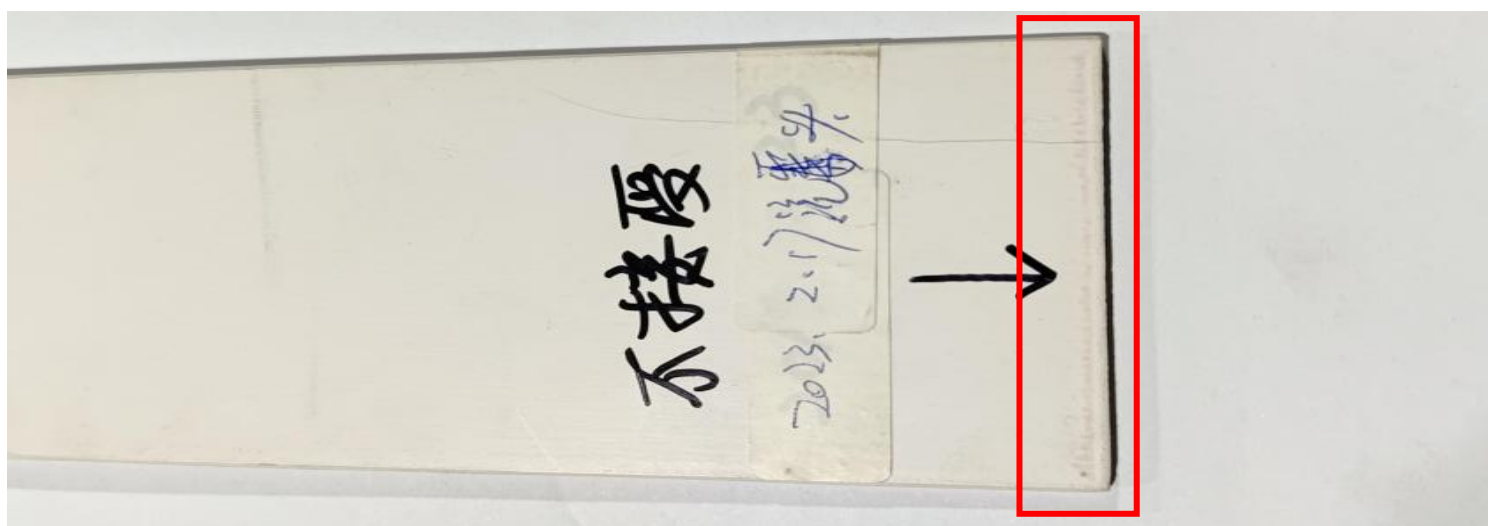
表面严重的颗粒，不可用 ×

Serious particles on the surface, not can be used ×



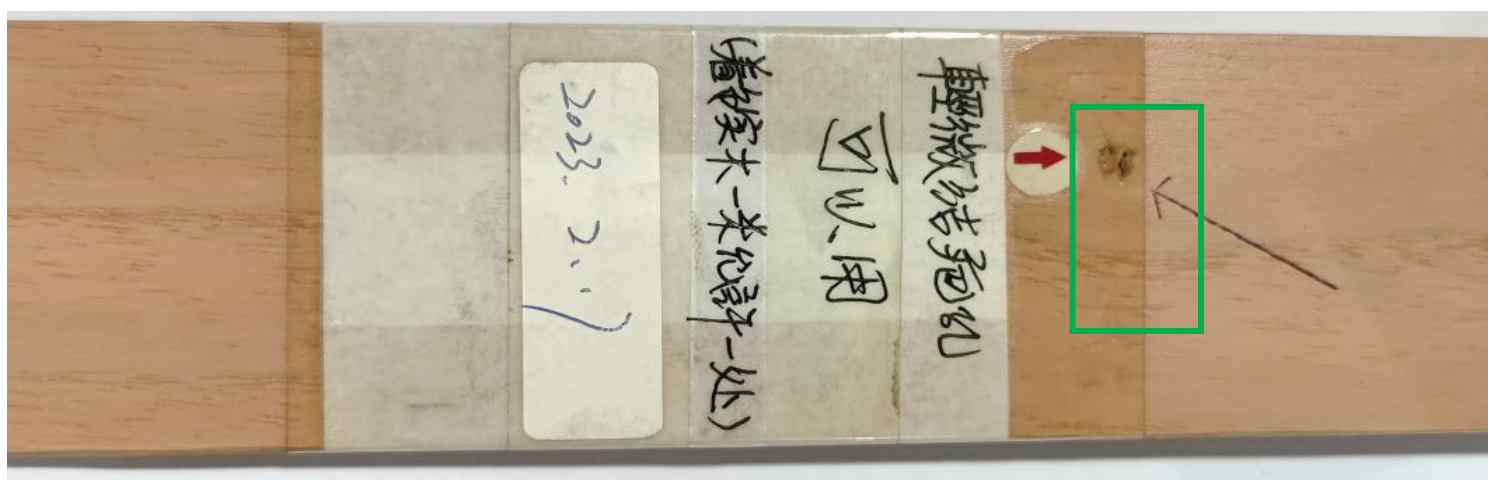
用在背面，一米允许 1 个

Used on the back of blinds .Every 1 meter allow1 pcs. ✓



不可以×

Not can be used ×



轻微疤结可以用，染色 1 米允许 1 处 ✓

Slight Scar nodules, can be used .Every 1meter allow1 pcs. ✓



对于红雪松，疤结可以使用 ✓

For red cedar, scar knots can be used. ✓

Find Us

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Shutter website: www.shutter-suppliers.com

Shade website: www.shadesupplier.com

Total website address: www.huashengindustry.com



If you click to view our website and social media, you are becoming increasingly interested in us, we greatly welcome you to visit our factory at any time !

Address: No.8 industry zone Zhuangzhai Town Heze City Shandong Province, China

Tell: 86-0530-6219566

Mobile:0086 15806997933

Email: admin@huashengindustry.com