Venetian Blinds Technical Manual

Heze Huasheng Industry



Once we establish a cooperative relationship, we will provide long-term technical support for all the later stages.

2023.11.21

Huasheng Industry. was founded in 1996 and is located in Zhuangzhai Industrial Park, Heze City, Shandong Province, the largest paulownia processing and export base in China.











We started the blinds project in 2006 and as the first factory in China to promote paulownia. Over the years, we have promoted paulownia to different countries and gained recognition from our customers.

We have more than 20 local raw material wood suppliers, with a stock of 3000 square metre of large boards and we always keep 1600 cubic meters of slats in stock in our warehouse, when we receive orders from customers, we can deliver them quickly. Keep a stock of best-selling slats colors in the daily workshop, so that customers can emergency use them when they need them.













Huasheng Industry is your trusted partner, providing you with comprehensive protection and high quality products.

Huasheng Industry has been committed to achieving China's precision manufactur- ing of window decoration products worldwide for many years. We are centered around a first-class team. Design and manufacture first-rate products. We also have a professional customer service team to serve high-quality customers.

Huasheng Industry has always been in an open state. If you have any new projects in the window decoration category, welcome to find us and jointly create new window decoration products that belong to us.



RESEARCH

We always believe that research and development is the driving force for continuous progress. Our R&D team is constantly looking for new ways to improve our products. Ensure that our products are always at the forefront of the industry.

INNOVATE

Innovation is the engine of our progress.

Huasheng encourages employees to come
up with new ideas and invests in research
and development to develop new technologies and solutions.



DESIGN

Our graphics team is made up of experienced people who are proficient in CAD and other professional design tools to ensure that every design is accurate. We have also introduced advanced 3D printing technology that we have the ability to leverage to bring to life whatever the product.





QUALITY CONTROL

Quality is our commitment. We have established a comprehensive quality control system, including every link from raw material procurement to manufacturing to final product delivery.

LABORATORY

We have special experimental machines for product testing to ensure that any aspect of our products can meet your needs,we work tirelessly to ensure that every detail is impeccable.



华升实业 华升实验至攻奋洞里 Heze Huasheng Laboratory Equipment List 华升实验室设备清单

图片 Photo	名称 Name	功能 Function	操作过程 Operation process and
Portacle Pendi Scratch Tester	铅笔划痕实验仪器 Pencil scratch experimental instrument	测试产品耐划痕能力 Test the product's resistance to scratches	
	百格刀 Hundred grid knife	测式涂料的附着力 Test the adhesion of the paint	
	色差仪 Colorphoto meter	测试产品颜色的色差,亮度差 Test the color difference and brightness difference of the product color	
Cox Chan	颜色图表色旗 Color Chart	训练员工对于颜色判断能力 Train employees in color judgment	



恒温恒湿箱 Programmable temperature humidity chamber

测试产品在某种湿度和温度下的 性能变化 Test the performance change of the product under certain humidity and temperature





QUV试验箱 weathering

测试产品在紫外线照射下颜色的 变化,用于检测产品的色牢度 UV accelerated Test the color change of the product under ultraviolet testing machine radiation to detect the color fastness of the product





氙灯设备试验箱 Xenon Lamp Climate Testing Chamber

多种光谱模拟自然阳光照射下, 产品的色牢度, Color fastness of products under simulated natural sunlight with multiple spectra

烘箱法: 将一定质量的试样在一







电热鼓风干燥箱 (固含量测试) Electric blast drying oven

定温度下常压干燥一定时间,以 加热后的试样质量与加热前试样 质量的百分比表示含固量。 Oven method: Dry a certain mass of sample at a certain temperature and pressure for a certain time, and express the solid content as the percentage of the mass of the sample after heating to the mass of the sample before heating.





Huasheng Industry factory & QC & Tsting room----2-5

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Our process flow:

部分叶片自己开片;大部分叶片外 购

Part of the slats are split by themselves; Most blades are purchased 修整板条端头,进行端头裁切修整

Trim the end of the strip and trim the end

挑选次品, 检查油漆效果

Select defective products and check the paint effect



目前, 封板, 下轨自己开材

At present, the valance and bottom rail are made by themselves

检查调整原材等级

Check and adjust raw material grade

不同的油漆工艺效果

Different paint process effects

进行打包出货

Packaging and delivery of products

Wooden blinds component process flow diagram

Paulownia wood gardens



Raw material



Natural Dry Large stock Paulownia Wood board







Enter the cutting machine for cutting slats,

Post kiln regimen

The drying in the Italian kiln promotes the redistribution of water in the wood, improves the plasticity of the wood, and prevents cracking

Wooden blinds component process flow diagram

QC slats





Slats enter the paint room, spray edges

Start sanding slats after the order comes in





Insert paint line, producing painted, stain, printed, brushed colors according to customer.

Workers hand sanding for the edge to make sure the edge smooth





In the final step, workers QC each slats!!





Pre finger jointed slats:

Pre finger jointed slats, the board then open the slats like the solid, size same as solid 50.8x3.0mm and available to painted and printed colors, not available to stain colors and brushed effected colors as the jointed visible. 前指接百叶片:前指接,然后像实心板一样打开板条,尺寸与实心板50.8x3.0mm相同,可用于覆盖色和印刷色,不可用于着色和拉丝效果颜色,因为连接处可见。

Common finger jointed slats:

Common finger jointed slats, then open the slats like a solid board, measuring 49.0mm x 29.85mm, and available to painted and printed colors, not available to stain colors and brushed effected colors as the jointed visible. 普通指接,然后像实心板一样打开板条,尺寸在49.0x29.85mm,可用于覆盖色和印刷色,不可用于着色和拉丝效果颜色,因为连接处可见

Paulownia slats

25mm slats lenght: solid 4-7ft

35mm slats lenght: solid 5-8ft

50mm slats lenght: solid 5-9ft

Pre finger jointed slats: Max. lenght 10ft

Common finger jointed slats: Max. lenght 12ft

Basswood slats

25mm slats lenght: 3-8ft

35mm slats lenght: 3-8ft

50mm slats lenght: 3-9ft

Bamboo slats

50mm slats lenght: 4-9ft



Pualownia slats lenght:

Basswood slats lenght:

Bomboo slats lenght:

Slats: 150pcs =1 carton

Valance: 30pcs= 1carton

Bottom rail: 30pcs= 1 carton

There are 20 wooden slats production lines in our factory, and one machine can squeeze out 5,500 meters of slats in one day and one night. valance and bottom rail has 8 production lines, which can produce about 220,000 meters of wooden slats in one month.

Paulownia slats MOQ is 5,000 meters, delivery time after the order is about 30 days. Basswood slats MOQ is 7,000 meters, delivery time after the order is about 45 days. Bamboo slats MOQ is 5,000 meters, delivery time after the order is about 35-40 days.





Fauxwood blinds component process flow diagram

PVC raw material preparation, with a powder base material





The base material and fabric are put into different silos respectively, and the machine is started to extrude slats

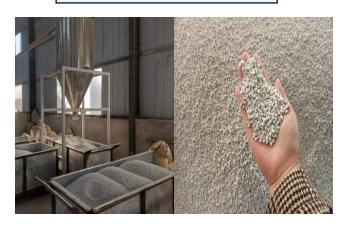
PVC/fauxwood blinds color fabric, extrusion according to customer demand different colors





Blinds component successfully extruded and directly entered the cold water area for cooling and shaping

Granular fabric





According to the requirements of the blinds component customer, the machine sets the cutting length and performs cutting

Fauxwood blinds component process flow diagram





QC

Packaging

Slats: 100pcs =1 carton

Valance: 20pcs= 1 carton

Bottom rail: 20pcs= 1 carton

Slats length: Only 9ft

Our factory PVC (fauxwood) blinds component workshop has a total of 33 production extrusion lines, including 28 slats production extrusion lines. A machine can squeeze out 5500 meters of slats a day and a night. The valance and bottom rail have five production extrusion lines. The valance can produce 1300 meters in 24 hours, the bottom rail can produce 1300 meters in 24 hours, and the production of gray and other colors is slightly slower.

Paulownia wood slats

Painted Colors:







Brushed Colors:

Stain Colors:







Printed Colors:







Basswood wood slats

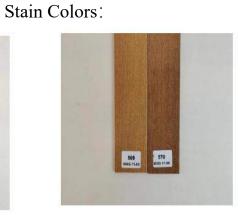
Painted Colors:











Fauxwood wood slats

Printed Colors:





Painted Colors:







Printed Colors:





Embossed:



Gloss Colors:



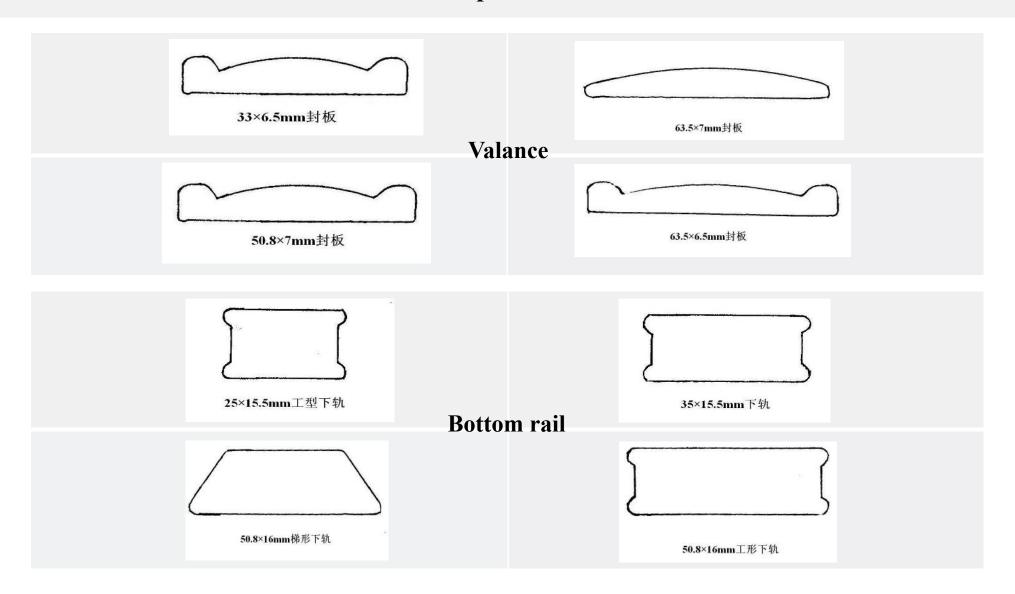
Bamboo wood slats





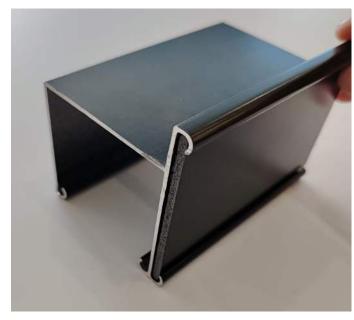


Our factory can customizes the type of valance and bottom rail you want, providing you with a free open the mould.



Insert valance

3.

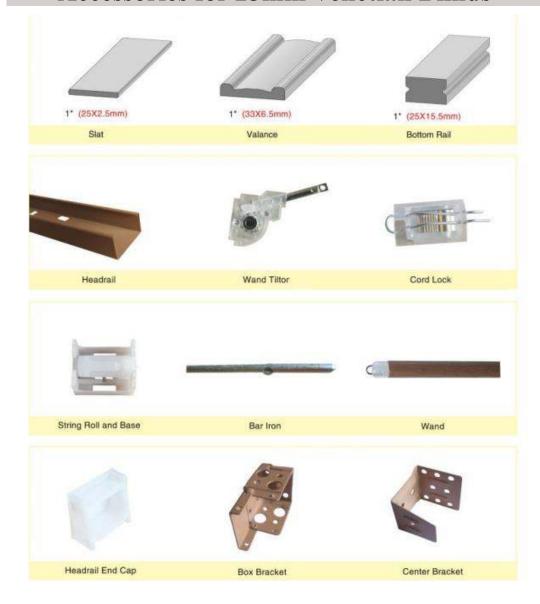






- New valance accessories---Insert valance, this sample may bring you and me some new inspiration, you can contact us to discuss this new project with us.
- This valance is very convenient to use, and it also saves the cost of purchasing valance separately in terms of price. It can be completed using 63.5mm slats, which is convenient for cleaning. Also perform DIY. If you customers don't like this slats color, can plug in different colors.

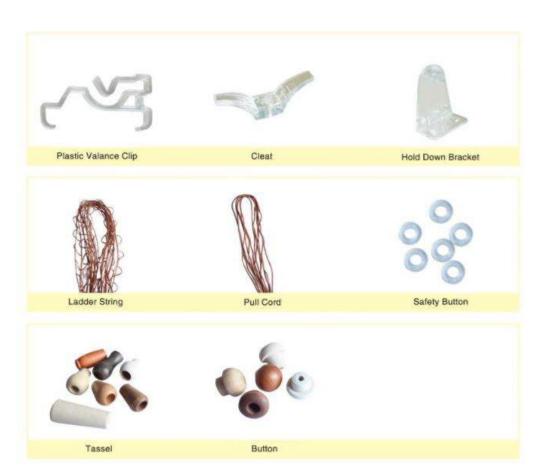
Accessories for 25mm Venetian Blinds





Accessories for 35mm Venetian Blinds





Accessories for 50mm Low Venetian Blinds





Accessories for 50mm High Venetian Blinds

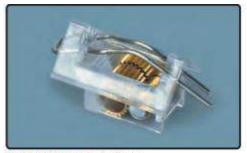




Accessories for 50mm Cordless fauxwood Blinds



WHB032 50mm 调频 Tilt mechanism



WHA014 双孔滑止 Cord lock



WHP005 50mm下固 Hold down bracket



WHH010 50mm转轮 Tape roll



WHF018 50mm内塞端盖 Head rail cap (Inside type)



WHF020 50mm内外塞端盖 Head rail cap (Inside&outside type)



WHI031H 50mm 斜拉转轮座 Tape roll support



WHI015H 50mm 直拉转轮座 Tape roll support



WHI032H 50mm 转轮座 Tape roll support



WHI015H 50mm 直拉转轮座 Tape roll support



WHI030DH 50mm 转轮座 (双轴) Tape roll support



WHN009 50mm 下封套 Bottom rail cap

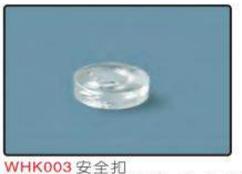
Accessories for 50mm cordless fauxwood Blinds



WHL007 50mm 塑胶片 Tape spacer



WHS002 50 mm下塞 Down plug

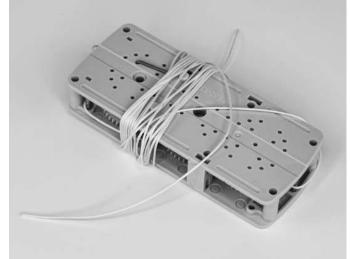


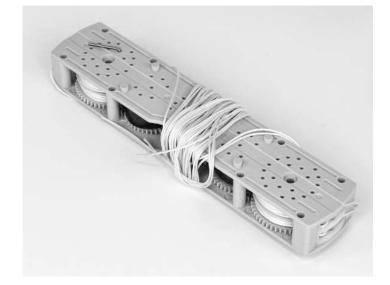
WHK003 安全扣 Safety lock (Φ9.5xΦ4.0x2.5)



WHR010 50mm上塞 Up plug







EF Module ES Module EW Module

Cordless modules matching weigh

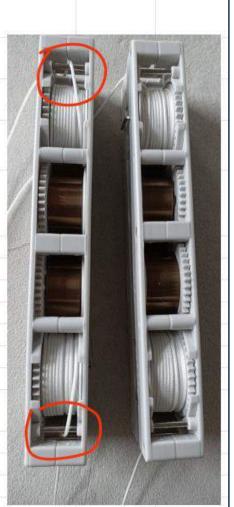
轨道尺寸Headrail	内部空间Inside size≥55mm
转轮座类型Roller cord type	2英寸两针转轮座 2" fauxwood blind use with 2 pins roller
最大垂长 Most length of blinds	96 inch (2430mm)

Chart for module to take the weight as follow:

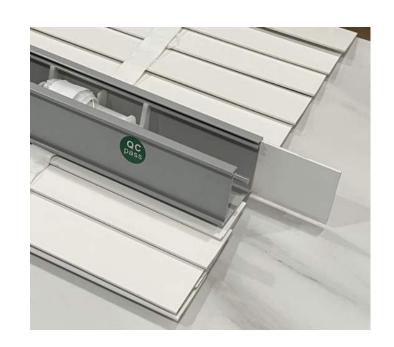
型 号 Cordless module Spec.	弹簧规格 Spring spec.	承 重 Can take the weight	下轨重量Bottom rail and slats weight of blinds	拉绳绳数量 PCS of cord qty	拉绳直径 Diameter of Cord
CX2-11-72	0.11	≤2.3KG	≥0.15KG	2	0.9mm
CX2-13-72	0.13	≤3.7KG	≥0.1KG	2	0.9mm
CX2-15-72	0.15	≤4.1KG	≥0.15KG	2	0.9mm
C4-10-72-120	0.1	≤1.1KG	≥0.1KG	4	0.9mm
C4-11-72-120	0.11	≤1.6KG	≥0.2KG	4	0.9mm
C4-13-72-120	0.13	≤2.3KG	≥0.3KG	4	0.9mm
C4-15-72-120	0.15	≤2.9KG	≥0.37KG	4	0.9mm

The weight of 2" fauxwood slats calculated as 27.4g/ft

The weight of hollow trapezoid bottom rail as 105.156g/ft



Valance free high headrail system







When our team went to Turkey on a business trip, we found that Valance free system blinds, whose design uses slats can be directly inserted into headrail, helping customers save some fund.

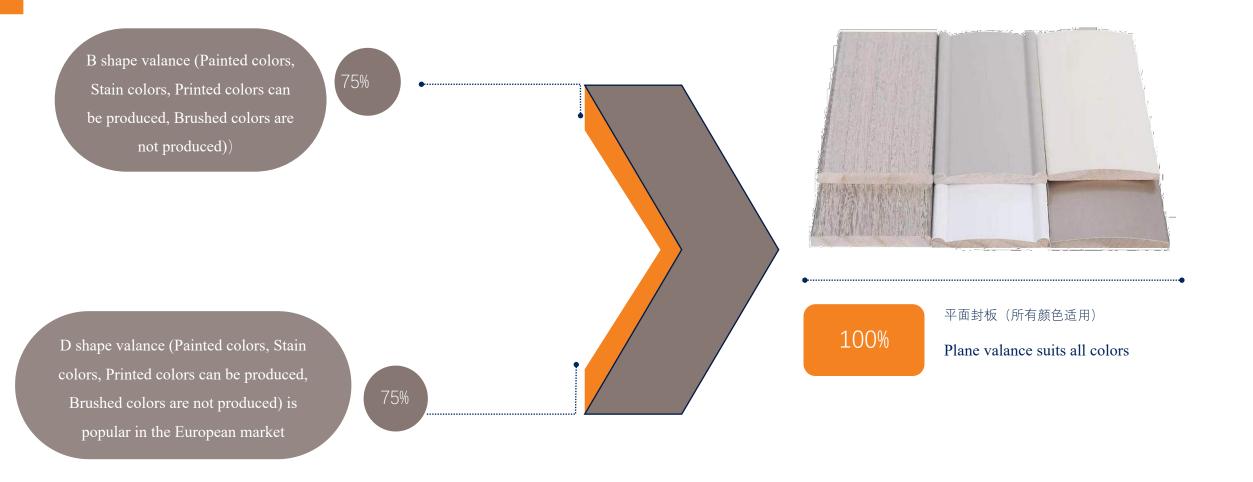
After we brought the samples back to the factory and discussed with our R&D team, we have now designed the finished product, fast and time-saving, you can also add colors of your choice to headrail.

Loop cord blinds headrail system

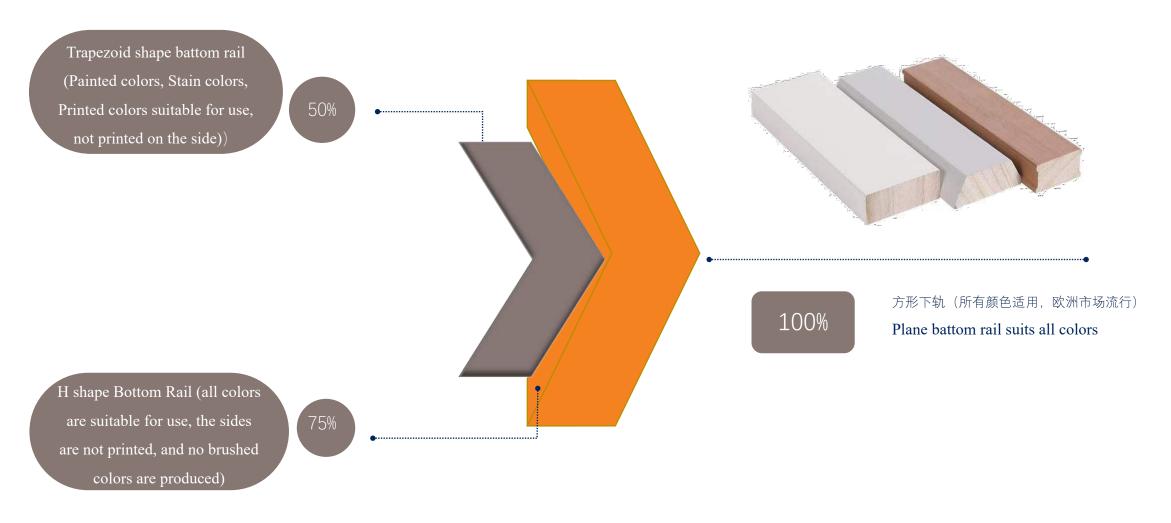




The types of Valance and their color applicability:



The types of Battom rail and their color applicability:



Understanding of color system and painting process of different color systems 色系认识以及不同色系的油漆工艺

白色/黑色: 补腻子>喷边>砂光>附着底>UV底 x3 >UV面

White / black colour: One time clear gesso to cover the paulownia texture and avoid the painting soaking into the material, then spray paint sides of slats, then one time slight sanding, then put the slats on UV painting line doing 4 times UV base painting and one time UV surface painting last. Dry under the UV-light



印刷,覆盖色: 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)

Printed colour, Painted colour: One time clear gesso to cover the paulownia texture and avoid the painting soaking into the material, then spray paint sides of slats, then one time slight sanding, then put the slats on painting line do three or four times NC base painting, then one time UV base painting (one time UV print if printed colors) and one time UV surface panting.



Understanding of color system and painting process of different color systems 色系认识以及不同色系的油漆工艺

着色: 喷边>砂光>着色>UV底>UV面

Stain colour: Spray paint sides of slats, then one time slight sanding, then paint the colour, and one time UV base painting, one time UV surface painting.



普通拉丝: 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

Brushed effected colors: Spray paint sides of slats, then make brushed on slats and then one time slight sanding, and one time UV base painting(use this process on white colour only for avoiding turning yellow), three or four times NC base painting, one time UV surfacepainting



No.	Item	Standard on Solid slats	Standard on normal jointed slats	Tolerance 误差
1	Material 材质	Paulownia 桐木	Paulownia 桐木	
2	Structure 结构	Solid wood slats 实木	Normal finger jointed slats 后指节	
3	Width 宽	50.8mm	49.0mm	± 0.5mm
4	Thickness 厚	3.0mm	2.85mm	± 0.2mm
5	Length 长	3ft - 8ft	6ft-12ft	
6	Moisure content 含水量	<10%	<10%	
-	Camber (for length <4ft) 侧弯	< 3.2mm	< 3.2mm	
7	Camber (for 4ft <= length< 7ft) 侧弯	< 5.6mm	< 5.6mm	1
1	Camber (for 7ft <= length<=8ft) 侧弯	<= 6.3mm	<= 6.3mm	1
	Camber (for 8ft < length<=12ft) 侧弯	Solid slats most length 8ft	<= 9.6mm	
8	Bow (for length <4ft) 面弯曲	< 2.4mm	< 2.4mm	
	Bow (for 4ft <= length< 7ft)面弯曲	<4.2mm 少于	<4.2mm 少于	Ī
8	Bow (for 7ft <= length<=8ft) 面弯曲	<= 4.8mm	<= 4.8mm	1
	Bow (for 8ft < length<=12ft)面弯曲	Solid slats most length 8ft	<=7.2mm	
9	Measuring method 测量方法	to be measured by 45-degree angle on galsses table	to be measured by 45-degree angle on galsses table	
10	Appearance 表面		Unevenness by wood grain is acceptable but other scratches, dameges and dents are not acceptable.	
11	Characteristics of wood	no die knots	no die knots	
12	Color	Color copy need confirm by customers	Color copy need confirm by customers	
13	Gloss	15 degrees	15 degrees	± 5 degrees

14	Production process	Flaking-sanding-QC-cut both ends of slats-edges painting-sanding-paint - Color check-QC- package	Jointed short solid slats-sanding-QC-cut both ends of slats-edges painting- sanding-paint -Color check-QC- package	S
15	Packing	150pcs/carton	150pcs/carton	*
16	Wood grade	Based on different color different grade, colors darker grade lower	Based on different color different grade, colors darker grade lower	
17	Lead time	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)	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)	
18	Defect rate	<= 5%	<= 6%	
40	Mainte de la companya	Stain color: 44g/m	Painted color: 47g/m	*
19	19 Weight of per meter for slats	Painted color: 47g/m	Brushed effected color: 40g/m	9 9
20	Weight of nor mater for bottom will	245g/m	245g/m	2* (50.8x16mm)
20	Weight of per meter for bottom rail	260g/m	260g/m	



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

Slats punching machine

What you think the difficult actually is very simple!!



Bottom rail holes drilling machine

Valance metre machine

Headrail cutting machine
+ Head rial 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







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

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







Material: Paulownia wood, Basswood, PVC.

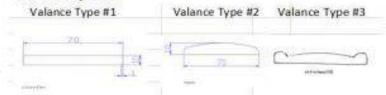
Slats size: 25mm, 35mm, 50mm, 63mm.

Options: Cut-down Blinds, Ready made Blinds,

Custom made Blinds, Eazy lift Blinds,

Cordless Blinds, Motor control Blinds.

Valance options:



Bottom rail options:



Control type: Cord control, Wand control.







Custom made blinds sample box

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: Wooden and faux wood.

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





Cut-down Blinds

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 fa-cilities with one cut down machine.



Ready made Blinds

Ready made blinds are mass produced blinds that come with a small range but popular sizes, which normal sell in shops, malls and supermarkets. The buyers can mount the blinds to the window directly themselves after buying to home.

For ready made blinds width from 40cm to 240cm and height 130cm, 160cm 180cm, 210cm and 240cm usually. Detail according customer request.

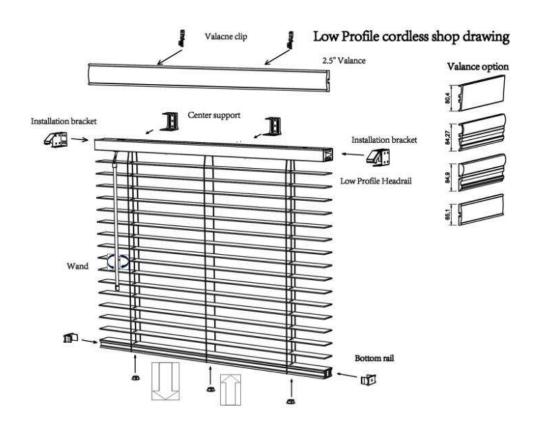




Cordless fauxwood Blinds

Min. width/height: 55cm Max. width/height: 180cm

Wand tilt and cord lift controls allow for easy adjustments. Faux Wood Blinds are available in different sizes to best fit your windows. These durable blinds are easy to install and easy to clean.



Loop cord Blinds

Min. width/height: 47cm Max. width/height: 300cm

Instead of two separate strings, common on standard blinds, loops cord are made of one continuous cord wrapped around the top part of the blind. They function quite similarly to a pulley system. If you pull on one strand, the blinds will open. Pull on the other, and the blinds will close. Very convenient.













Easy Fit Blinds

Slat size: 25mm

Maximum width: 60cm

You just need connect the blinds to the frames from your local, and install it directly to your customers window with brackets, not need screws.

Our produce 25mm blinds them with the right system, now samples ready with top and bottom rail.

It will help you save much time and labor cost if you buy this blinds from us for your Easy Fit Blinds.











Motor control Blinds

Min. width/height: 62cm Max. width/height: 300cm

Motor blinds, the width should be more than 62cm, to make blinds with tilt and lift. But it doesn't matter with ladder string or tape.

There is charge with line for each motor, as default, but the line is not very long, so it need socket near to the motor blinds.

Your venetian blinds are smart in a minute with Motor Blinds. Install them wirelessly, easily connect them to your smart home and control them from anywhere, in any way.

We can provide matching motor.











35mm paulownia venetian blinds







Our 35mm paulownia venetian blinds that are both aesthetically pleasing and durable.

The difference between this blinds product and others is that both the wands and pull cord are on the right side, making it easier to control the slats light closure and blinds up and down adjustment

We are confident that these blinds will add a touch of sophistication and elegance to any space.

Shutter-Blinds Plus



Slats size: 25mm /50mm /63mm

The shutter blinds plus is a affordability window treatment which looks same as plantation shutters when people stand out of the window.

This product fully utilizes the advantages of shutter and blinds, with frame fixed to the window to prevent it from swaying back and forth when the wind blows.

Using blinds slats intead of shutter louvers. It looks very fashionable and the price is cheaper than Shutter to enough to meet customer needs.

Wooden vertical blinds



New product - Wooden Vertical Blinds.

At present, horizontal blinds are common in the market, and wooden vertical blinds is a perfect substitute for horizontal blinds. It can also cover larger french window.

Our wooden vertical blinds can be made in various configurations, eg. controls left or right, blinds slats opening from left to right or right to left, fully reflecting the beauty of modern technology and traditional wood.



Cordless Paulownia Wood Blinds



Cordless paulownia wood blinds offer a few unique advantages over their corded counterparts.

At present, the common cordless PVC/fauxwood blinds on the market are cheap, but they are heavy in weight and relatively less heat-resistant than wooden material. This Cordless paulownia wood blinds is a good opportunity to seize more orders in the market as a new product in 2024!



The appearance of traditional wooden blinds, made of real wood, which is easy to operate and clean.

Bamboo blinds



Min. width/height: 40cm Max. width/height: 270cm

While the whole world is talking about green and sustainable products, do you know that you can play a part in the future green project by choosing bamboo blinds for your window treatment?



The natural design and texture of the bamboo creates a perfectly calm, relaxing, and sophisticated feel. Bamboo blinds are more commonly installed at balconies, service yards and patios of landed property and shophouses.

Blinds website: www.blinds-supplier.com

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!

Please check our factory address: No.8 industry zone Zhuangzhai Town Heze City Shandong Province, China Fax: 86-0530-6219565

Thank you for watching!

Huasheng Industry

