

Manufacturing Instructions

for YewdaleDefiant® roller blinds
(R20, R20C, R20S, R20W)

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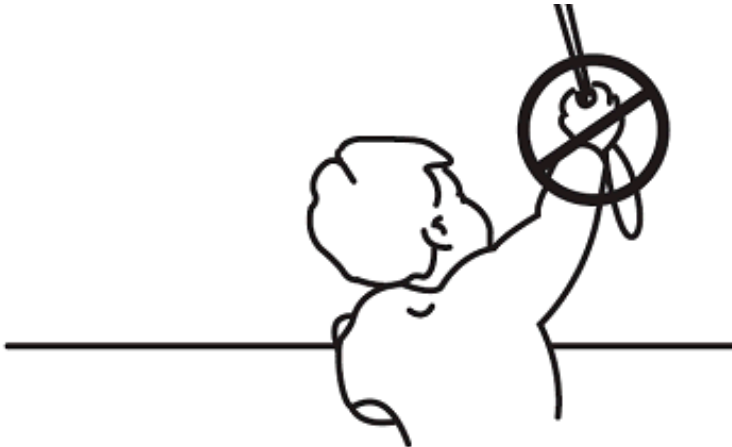
Manufacturing Instructions

YewdaleDefiant® roller blinds (R20, R20C, R20S, R20W)

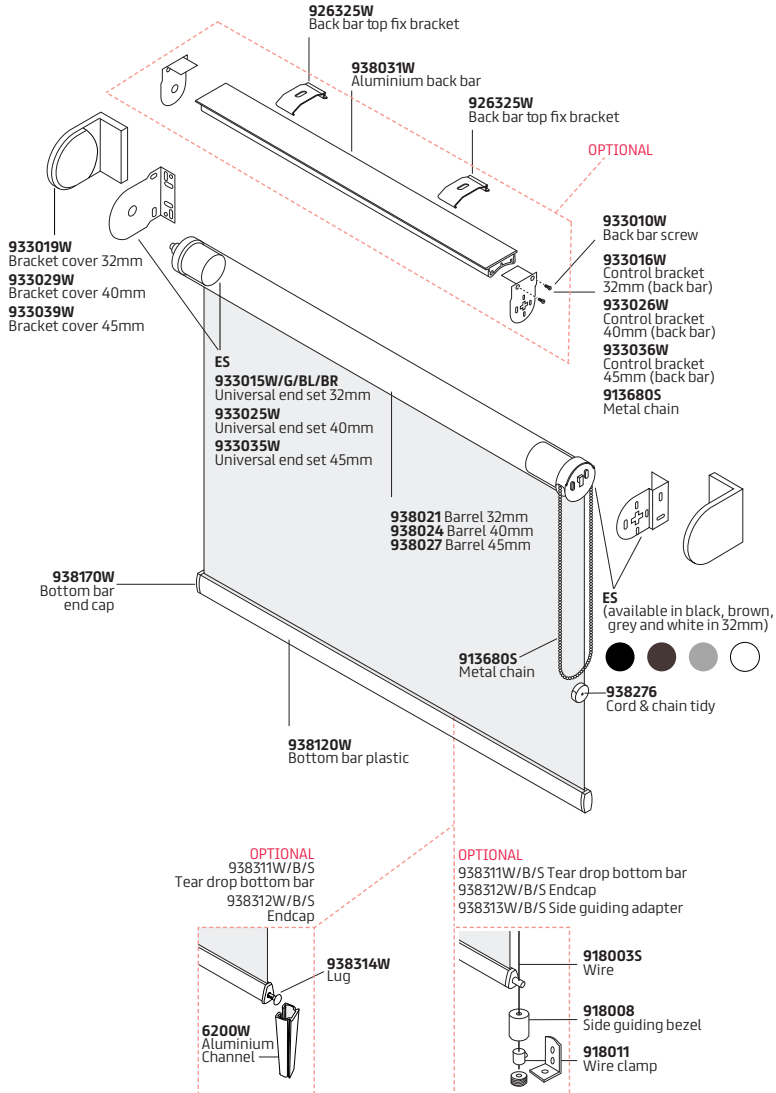
Safety Instructions:

1. Loops in pull cords, chains, tapes and inner cords that operate the product can cause strangulation
2. To avoid strangulation and entanglement, keep cords out of the reach of young children. Cords may become wrapped around a child's neck
3. Move beds, cots and furniture away from window covering cords
4. Do not tie cords together. Make sure cords do not twist and create a loop

Ensure the relevant child safety device is used to comply with BS EN13120:2009+A1:2014, BS EN16433:2014 and BS EN16434:2014 on all R20s.



R20 Sidewinder control:



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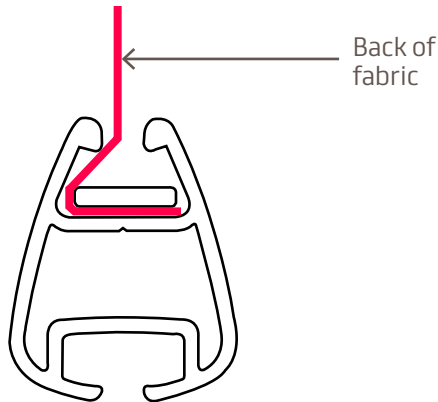
R20 Sidewinder control:

1. Checking the size of the blind required to be manufactured, select the appropriate size barrel using the chart below.

		Width																
		25½	33½	41½	49½	57	64½	72½	80½	88½	96½	104½	112	120	128	135½		
inches	mm	650	850	1050	1250	1450	1650	1850	2050	2250	2450	2650	2850	3050	3250	3450		
Drop	37½	950																
	49½	1250																
	61	1550																
	72½	1850																
	84½	2150																
	96½	2450																
	108½	2750																
	120	3050																
	131½	3350																
	143½	3650																
	155½	3950																
	167½	4250																
	179½	4550																
	190½	4850																

2. Ensuring the barrel (Part number 938021/938024/938027) is free from damage, cut this to the desired blind width minus 35mm.
3. Ensuring the bottom bar (Part number 938311W/B/S) is free from damage, cut this to the desired blind width minus 35mm.
4. Selecting the required fabric, cut the width to blind width minus 35mm and the drop to blind drop plus 250mm.
5. Cut the control chain (Part No 9136805) to length (blind drop x 2 minus 300mm) and make into a loop using a chain joining tool (939038).
6. Selecting the appropriate Slipstream Control Mechanism, (Part number 933015W/933025W/933035W) suppress the orange pin to allow the mechanism to release the control wheel. Loop the chain over the control wheel and click the Control Mechanism back together.
7. Using a recommended roller blind assembly table, lay the fabric, barrel and bottom bar in position.
8. Using the correct size Mylar tape (6mm for 200gsm fabric, 7mm for 300gsm fabrics and 8mm for 400gsm fabrics) attach the fabric to the barrel. N.B It is important that your own testing of the fabric and the appropriate Mylar tape is carried out.

9. To attach the tear drop bottom bar, cut the 10mm plastic strip (962499) and attach in line with the base of the fabric on the back, using the double sided adhesive tape on the strip. Attach one staple at each end and one in the middle of the fabric through the plastic strip using a heavy-duty stapler and suitable staples, ensure staples are completely compressed.
10. Folding the fabric as shown below, insert this into the tear drop bottom bar using a sliding process from either the left or the right-hand side of the blind.

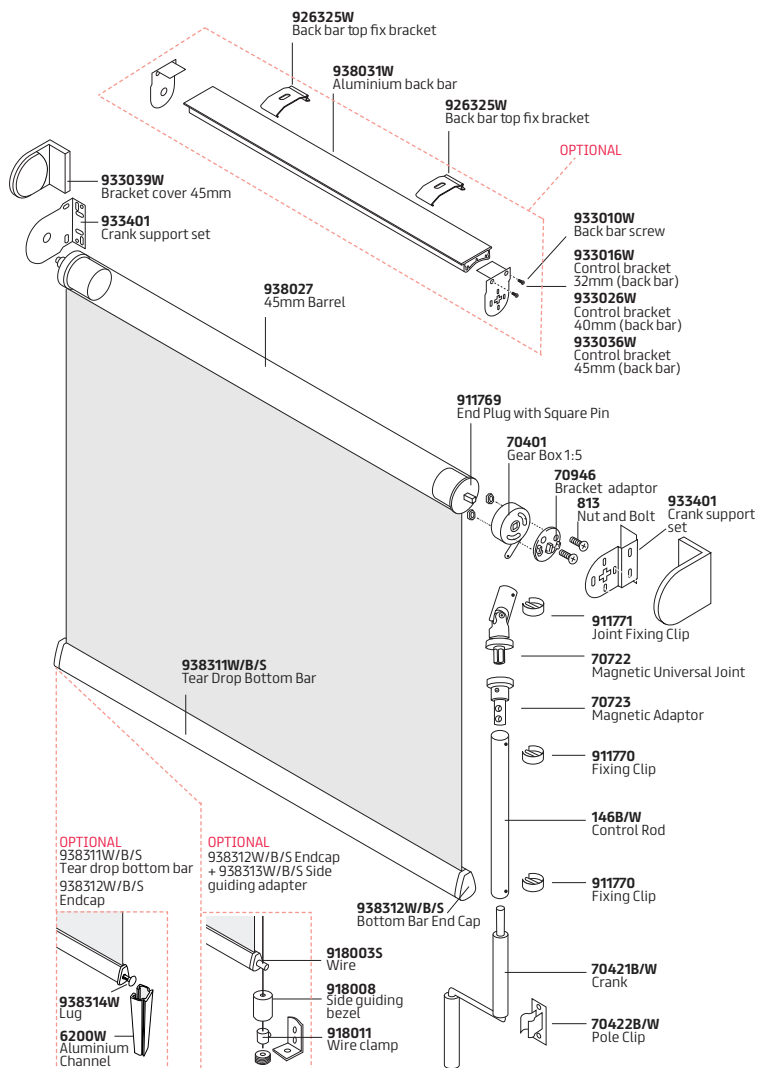


11. Secure the fabric in the bottom bar by pushing home the bottom bar end caps (Part No 938312W/B/S)
12. Secure the fabric in the barrel by pushing home the Slipstream Control Mechanism and pin end into the barrel
13. Lift the blind onto a test rig and inspect for any defects.

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R20C Crank control:





R20C Crank control:

1. Complete the R20 Slipstream process missing out points 5 and 6.

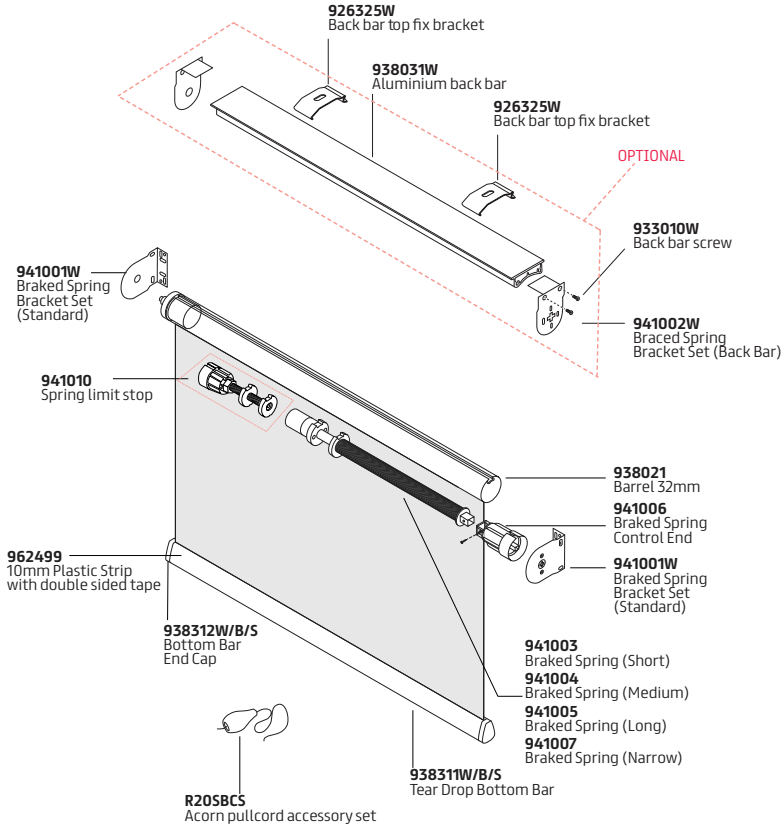
NB. The R20C is only available on the 45mm barrel (Part number 938027) then:

2. Insert end plug with square pin (Part number 911769) into the 45mm barrel (Part number 938027)
3. Fasten the gear box (Part number 70401) to the control bracket (Part number 9330135W) using the nut and bolt (Part number 813) making sure the gear box drive shaft is facing the correct way.
4. Attach the magnetic universal joint to the drive shaft of the gear box using the fixing clip (Part number 911771)
5. Cut the control rod (Part number 146B/W) to the correct length and drill a 4.1mm hole right through the rod 14mm from both ends.
6. Attach the magnetic adaptor (Part Number 70723) to the top of the rod and the crank (Part number 70421B/W) to the bottom of the rod by clipping a fixing clip on either end (Part number 911770)
7. Lift the control rod up and allow the magnetic adaptor (Part number 70723) to clip home onto the magnetic universal joint (Part number 70722).

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R20S Spring control:



NB. The R20S is only available on the 32mm barrel (Part number 938021)

1. Ensuring the barrel is free from damage, cut to the desired blind width minus 34mm. If a limit stop is to be used, deduct 36mm.
2. Ensuring the bottom bar (Part number 938311W/B/S) is free from damage, cut this to the desired blind width minus 20mm.
3. Ensuring the back bar (Part number 938031W) is free from damage, cut this to the desired blind width minus 4mm, and screw the back bar brackets (Part number 941002W) onto the back bar with the part 933010W screws.
4. Selecting the required fabric, cut the width to blind width minus 20mm and the drop to blind drop plus 250mm.

R2OS Spring control:

5. Selecting the appropriate spring using the chart below:

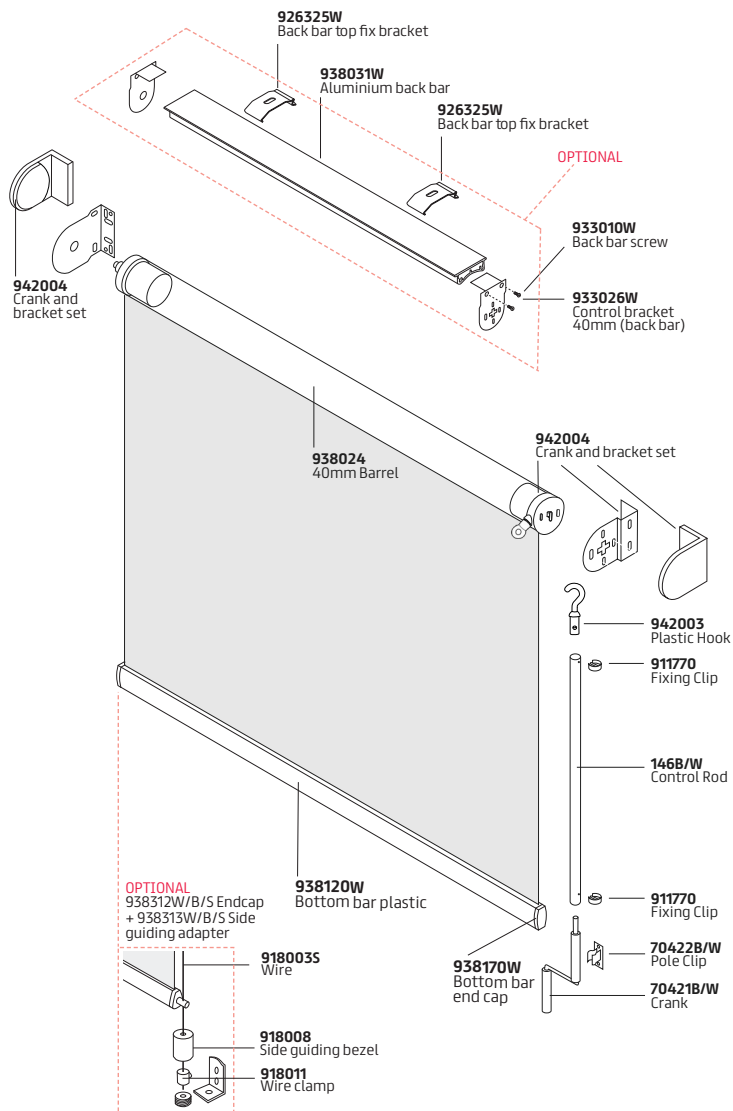
		Width						
		25½	33¼	41%	49%	57	64¾	72¾
		650	850	1050	1250	1450	1650	1850
Drop	inches	Short			Medium		Long	
	mm	Short			Medium		Long	
	37¼	Short			Medium		Long	
	49¼	Short			Medium		Long	
	61	Short			Medium		Long	
	72¾	Short			Medium		Long	
84½	Short			Medium		Long		
96¾	Short			Medium		Long		

6. Insert the spring into the right-hand end of the barrel. If using a limit stop, insert this in the left-hand end of the barrel.
7. Using a recommended roller blind assembly table, lay the fabric, barrel and bottom bar in position.
8. Using the correct size Mylar tape (6mm for 200gsm fabric, 7mm for 300gsm fabrics and 8mm for 400gsm fabrics) attach the fabric to the barrel. The fabric should cover the spring also to give maximum window coverage.
9. The spring can now be tensioned should you wish to do so before installation. Put the blind onto a test rig and bring the blind down from its up position by pulling down on the bottom bar (or handle) and locking off in the down position. Take the blind out of brackets and roll the fabric back by hand back on to the barrel by approx. 50%. Put the blind back on the test rig and test operation.
10. If the blind has been fitted with a limit stop, this may need to be checked prior to installation. Roll the blind up to the desired stop point, the limit stop will be on the left (for reverse roll blinds, this will be on the right). Turn the square centre pin counter-clockwise until it stops. (On a blind in a back bar this is controlled with a cross head screw on the bracket.) The limit stop is now set.
11. If the fabric does not wind up completely when the blind is operated greater spring tension can be applied as follows:
- Bring the blind down 250mm from its uppermost position.
 - Remove the blind from the brackets and roll the fabric by hand back onto the barrel.
 - Replace the blind in the brackets.
 - If tension is still not enough, repeat steps a to c.
 - If tension is too much, follow the above but in reverse i.e. remove the blind from brackets and unroll the fabric by hand off the roller.
12. Ensure the blind is not over tensioned as it will result in the bottom bar crashing into the blind and potentially jamming.
13. Attach the cord and acorn to the bottom bar using Part number R2OSBC.

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YewdaleDefiant® roller blinds (R20, R20C, R20S, R20W)

R20W Light Duty Crank control:





R20W Light Duty Crank control:

1. Ensuring the barrel (Part number 938025) is free from damage, cut this to the desired blind width minus 38mm.
2. Ensuring the bottom bar (Part number 938311W/B/S) is free from damage, cut this to the desired blind width minus 38mm.
3. Selecting the required fabric, cut the width to blind width minus 38mm and the drop to blind drop plus 250mm.
4. Using a recommended roller blind assembly table, lay the fabric, barrel and bottom bar in position.
5. Using the correct size Mylar tape (6mm for 200gsm fabric, 7mm for 300gsm fabrics and 8mm for 4000gsm fabrics) attach the fabric to the barrel.

NB. It is important that you carry out your own testing of the fabric to ensure the correct Mylar tape is used.

6. To attach the tear drop bottom bar, cut the 10mm plastic strip (Part number 962499) and attach in line with the base of the fabric on the back, using the double sided adhesive tape on the strip. Attach one staple at each end and one in the middle of the fabric through the plastic strip using a heavy-duty stapler and suitable staples, ensure staples are completely compressed.
7. Folding the fabric as shown in the diagram on page 5, insert this into the tear drop bottom bar using a sliding process from either the left or the right-hand side of the blind.
8. Secure the fabric into the bottom bar by pushing home the bottom bar end caps (Part number 938312W/B/W).
9. Secure the fabric in the barrel by pushing home the control mechanism and pin end (Part number 942004).
10. Lift the blind onto a test rig and test and inspect for defects
11. To build the handle cut the control rod (Part number 146B/W) to the correct length and drill a 4.1mm hole right through the rod 14mm from both ends.
12. Attach the plastic hook (Part Number 942003) to the top of the rod and the crank handle (Part number 70421B/W) to the bottom of the rod by clipping a fixing clip on either end (Part number 911770).
13. Lift the control handle up and locate hook within the control mechanism.



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