



Zipscreen

ASSEMBLY MANUAL

v4.1 | February 2024



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DISCLAIMER

INTRODUCTION

This assembly manual for Zipscreen system has been produced by Rollease Acmeda to supply the necessary information for the safe and correct assembly of Zipscreen system.

DISCLAIMER

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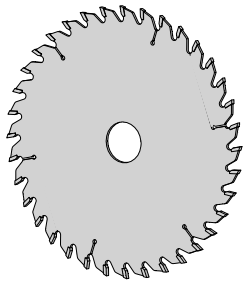
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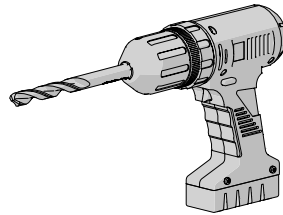


TOOLS REQUIRED

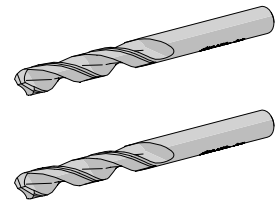
1 Circular Cutting Blade



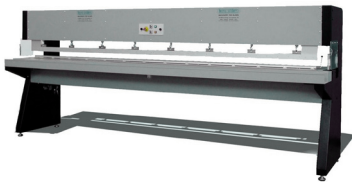
2 Drill



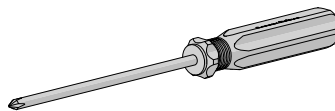
3 Drill Bits



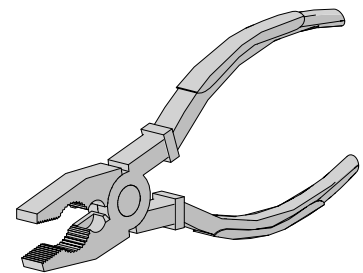
4 Impulse Welder + Zip Welding Jig



5 Philips Head Screwdriver



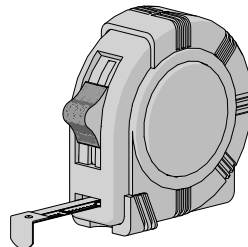
6 Pliers



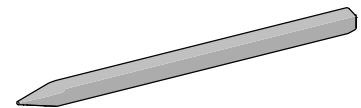
7 Scissors



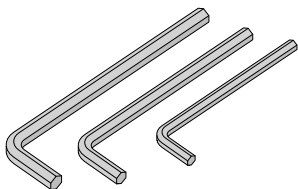
8 Measuring Tape



9 Pencil

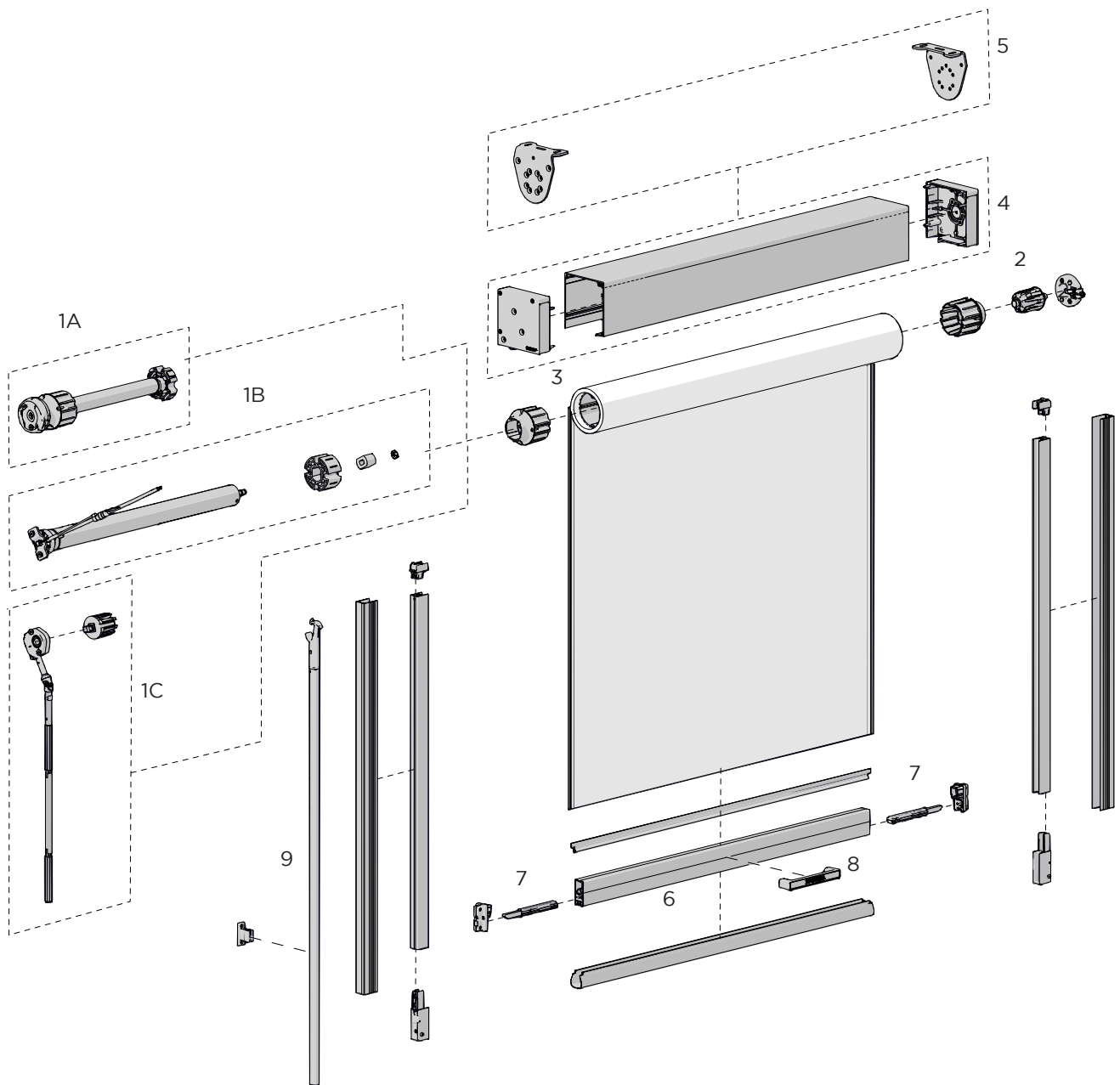


10 Allen Key Set (Metric)



OVERVIEW

GENERAL SCHEMATIC



SYSTEM INDEX:

1. CONTROLS:

- A - Booster
- B - Motor
- C - Crank

2. IDLER**3. TUBE:** 78mm/110mm/130mm**4. BOX:** 120/190**5. BRACKETS:** Square/Extreme**6. WEIGHT BAR:** F56/F72**7. LOCK:** Ultra Lock/Bolt Lock**8. HANDLE:** Plastic/Metal**9. PULL STICK**

BOM

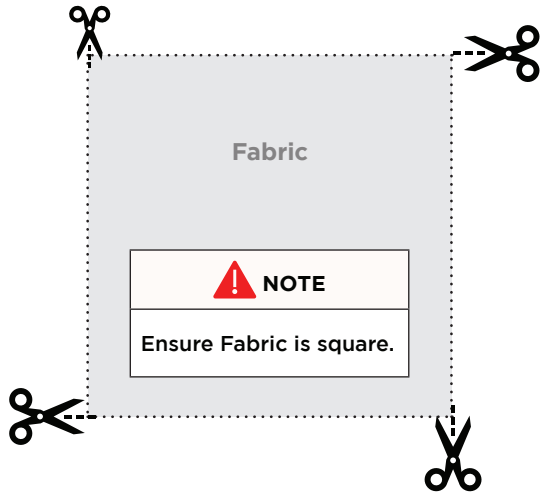
	PART NUMBER	DESCRIPTION	U.O.M	
BOX 120	RE01-1101-xxx120	Box 120 End Plates	Set	
	RE01-1105-xxx001	Box 190 – End Plates & Screws Only	Set	
BOX 190	RE01-1105-020100	Box 190 - Universal Bracket Extrusion (100mm)	Piece	
	RB80-1503-xxx110	Extreme Bracket Adaptor Kit (Motor & Idler Plate)	Set	
OPEN	SB03-1301-009190	Zipscreen Extreme Open Bracket Kit	Set	
	RB80-1503-xxx110	Extreme Bracket Adaptor Kit (Motor & Idler Plate)	Set	
	RE01-3030-xxx000	Open Brackets SQUARE Mild Steel	Set	
	RE01-3031-xxx000	Open Brackets SQUARE Stainless Steel		
SIDE CHANNELS	SB05-1412-050001	Funnel w/ Integrated Top Stop + Screw	Set	
	SB05-1511-050001	Inner Rail Bottom Cap Set	Set	
	HD82-1923-xxx013	Self-Drilling 8Gx1/2" Pan, C4 Galv, Painted	Piece	
SPRING 45mm	RE01-0421-050001	External Booster V2 COMPACT	Unit	
	RE01-0421-050002	External Booster V2 LIGHT		
	RE01-0421-050003	External Booster V2 STANDARD		
	RE01-0421-050004	External Booster V2 HEAVY DUTY		
	RE01-0421-050005	External Booster V2 EXTRA HEAVY DUTY		
	RE01-0421-050006	External Booster V2 ULTRA HEAVY DUTY		
GEAR	RE01-0513-xxx003	Gear 5:1 [7.5Nm] + Screws	Set	
	RE01-0517-xxx003	Gear 8:1 [20Nm] + Screws		
	RE01-0510-020000	RE01 Gear Universal Joint	Piece	
	RE01-0502-050045	Crank Adaptor 45mm	Piece	
	RB05-9102-xxx000	Gear/Crank Operation Arm Support	Piece	
	RB05-9101-xxxLLL	Gear/Crank Operation Control Arm - 100 / 150 / 200 cm	Piece	
MOTOR	MT01-1145-050001	AUTOMATE ARC FT Motor [Ø45/15Nm/15rpm] (AU)	Unit	
	MT01-1145-050012	AUTOMATE ARC FT Motor Long Conn. [Ø45/15Nm/15rpm] (AU)		
	MT01-1145-069003	AUTOMATE ARC FT SLIM Motor [Ø45/15Nm/32rpm] (US)		
	MT01-1145-0690xx	AUTOMATE ARC AX30 Motor (Refer catalogue for Part #'s)		
	MT01-1145-0690xx	AUTOMATE ARC AX50 Motor (Refer catalogue for Part #'s)		
		Refer Catalogue.	AUTOMATE Remotes, Sensors or Accessories	-
		RE01-0603-025000	AUTOMATE 45mm SLIM MOTOR 10mm Sq. Shaft (US)	Set
		RE01-0601-025000	AUTOMATE 45mm Motor Bracket Adaptor + Screws (US)	Set
		RE01-0680-050508	AUTOMATE 78mm Drive Wheel (Impact Detect)	Piece
		RE01-0680-050518	AUTOMATE 78mm Drive Wheel + Insert (Impact Detect) (US)	Set
		MTCLIP-35-45	Motor Drive Clip for 35/45mm Motors (US)	Piece
		RB56-0762-014050	Zamak Adaptor with Lock Ring & Screws	Set
		RB80-0301-073100	S100 - Universal Drive Wheel	Unit
		RB80-0701-073100	S100 - Universal Motor Crown	Unit
	MT03-0198-025008	AUTOMATE 30Nm/50Nm Extreme Drive Shaft Adaptor	Set	
IDLER	RE01-0214-050000	Idler/Spring Adaptor MKII + Screws	Set	
	RB80-0202-073100	EXTREME Bearing Idler Universal S100	Unit	
	RE01-0213-050045	Bearing Idler 45mm	Piece	
WEIGHT BAR OPTIONS	RE20-0303-xxx002	F56 HD End Cap Set Zipscreen (2 piece w/ screws)	Set	
	RE15-0512-xxx000	F72 Multi-Bar End Caps Zipscreen (2-piece w/ screws)	Set	
	SB07-2202-xxx000	External Weight Bar Pull Handle Metal	Set	
	SB07-2203-050001	External Weight Bar Handle Zipscreen		
	RE01-0420-050000	External Pull Stick Adjustable w/ Wall Clip	Set	
LOCKS	SB07-2103-050001	Weight Bar Bolt Lock Set	Set	
	RE15-0422-050001	Zipscreen Ultra-Lock V2 Set	Set	
TUBE PARTS	RB80-0501-073110	S100 - Zipscreen reducer end plate set - 110mm	Set	
	RB80-0501-073130	S100 - Zipscreen reducer end plate set - 130mm		
	RE20-0311-050178	Zipscreen Reducer 78mm to 45mm w/ Screws	Piece	

DEDUCTIONS

PART NUMBER	DESCRIPTION	U.O.M	ZIPSCREEN FACE FIX				ZIPSCREEN SIDE / RECESS FIX						
			78mm OPEN	BOX 120	BOX 190	S100 OPEN	78mm OPEN	BOX 120	BOX 190	S100 OPEN			
BOX 120	RE01-0101-xxxLLL	Box 120 Back											
	RE01-0102-xxxLLL	Box 120 Front Cover		W - 71 (2.80)						W - 66 (2.60)			
	RE01-0103-xxxLLL	Box 120 Semi Cover											
	S991-0012-050300	Fabric Brush - 1" Slot - 10mm High											
	RE01-0106-xxxLLL	Box 190 Universal Extrusion (Top & Back)			W + 171 (6.73)						W + 176 (6.93)		
BOX 190	RE01-0107-xxxLLL	Box 190 Front Cover			W - 29 (1.14)							W - 24 (0.94)	
	S991-0516-050009	Foam Tape											
SIDE CHANNELS	S904-0701-xxxLLL	Zip Inner Rail			D - 143 (5.63) ^{^^} ^{^^} with Ultra-Locks D - 210 (8.27)	D - 186 (7.32)	FACE FIX: D - 193 (7.60) TOP FIX: D - 198 (7.80)	D - 143 (5.63) ^{^^} ^{^^} with Ultra-Locks D - 210 (8.27)	D - 186 (7.32)	FACE FIX: D - 193 (7.60) TOP FIX: D - 198 (7.80)			
	S904-0702-xxxLLL	U Mounting Rail			D - 125 (4.92) [^]	D - 183 (7.20)	FACE FIX: D - 175 (6.90) TOP FIX: D - 180 (7.08)	D - 125 (4.92) [^]	D - 183 (7.20)	FACE FIX: D - 175 (6.90) TOP FIX: D - 180 (7.08)			
	S904-0703-xxxLLL [^]	L Fixing Rail for Box 120											
	S904-0708-xxxLLL	L Fixing Rail for Box 190				D - 191 (7.52)				D - 191 (7.52)			
	S904-0705-xxxLLL	Face Fix U-Mounting Rail											
WEIGHT BAR OPTIONS	RE15-0101-xxxLLL	F56 HD Weight Bar											
	RE15-0112-xxxLLL	F72 Multi-Bar											
	S991-0409-050015	7mm Fabric Spine with 15mm tail 100m roll				W - 126 (4.96)				W - 121 (4.76)			
	S991-0001-050580	Weight Bar Bubble Seal Strip 8 x 12mm x 5.8 metre											
	S991-0019-050580	16mm Bubble Seal F56 5.8 metre Lengths				W - 94 (3.70)				W - 89 (3.50)			
	S991-0008-050050	Ultra-Lock Seal V3											
	S991-0018-050040	16mm Bubble Seal F72 40 Lm Rolls				W - 109 (4.29)				W - 104 (4.10)			
	S991-0013-050150	8mm Bubble Seal Push Fit 150Lm Roll											
	S991-1015-050200	F56 Ballast - 20 x 5mm Ballast x 2m (0.8kg/m) Wrapped											
	S991-1018-050200	F72 Ballast - 25 x 8mm Ballast x 2m (1.6kg/m) Wrapped				W - 155 (6.10) or with Ultra-Lock W - 455 (17.91)				W - 150 (5.91) or with Ultra-Lock W - 450 (17.72)			
TUBE PARTS	RE01-0377-000LLL	78mm STD V2 Tube w/ screw features											
	RE01-0380-000LLL	78mm HD V2 Tube w/ screw features											
	RE01-0378-000LLL	78mm STD Tube (US Only)			W - 119 (4.69)	W - 123 (4.84)				W - 114 (4.49)	W - 118 (4.65)		
	RE01-0379-000LLL	78mm HD Tube (US Only)											
	AW92-0901-000LLL	78mm Steel Tube											
	RB93-0110-xxxLLL	S100 - 110mm Aluminium Tube				W - 129 (5.08)				W - 124 (4.88)			W - 114 (4.49)
	RB93-0130-xxxLLL	S100 - 130mm Aluminium Tube											
	S991-0135-050200	Zip No. 6 Gauge, Double Sided (For 78AL Tube ONLY)											
	S991-0409-050015	7mm Fabric Spine w/ 15mm Tail 100m roll				W - 87 (3.43)				W - 82 (3.23)			
	FABRIC	NOT SUPPLIED	Fabric Width				W - 87 (3.43)				W - 82 (3.23)		
S991-0135-050200		Zip No. 6 Gauge, Double Sided											
IMPORTANT NOTES	[^] Face Fix Option: Replace 2x S904-0702 'U Mounting' & 2x S904-0703 'L Fixing' with 2x S904-0705 'Face Fix U-Mounting Rails, use the RECESS FIX Deductions column for all extrusions. If using the Face Fix U-Mounting Rails, use the RECESS FIX Deductions column for all extrusions. The 5mm Width difference is due to the L-Fixing Rails extending past the bracket 2.5mm per side.												
	^{^^} For Ultra-Lock V2, add 67mm (2.64) to Inner Rail deduction. (eg. W - 143 becomes W - 210)												

FABRIC PREPARATION

1 Cut fabric to size



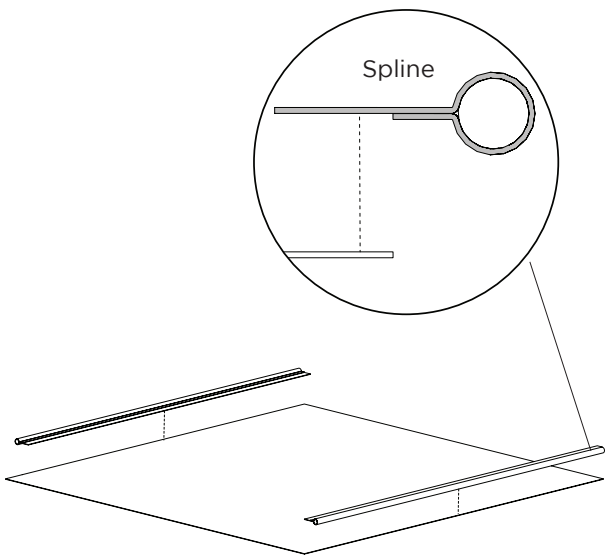
FABRIC TIPS:

Some fabric types should be used with caution as the weld quality can be problematic. Consult your fabric supplier for the recommended welding requirements of the following materials:

- Clear PVC
- Metallic backed
- Rubberised / foam backed
- Heavily textured / patterned
- Fabrics with bonding tapes (as fabric does not contain a plasticiser).

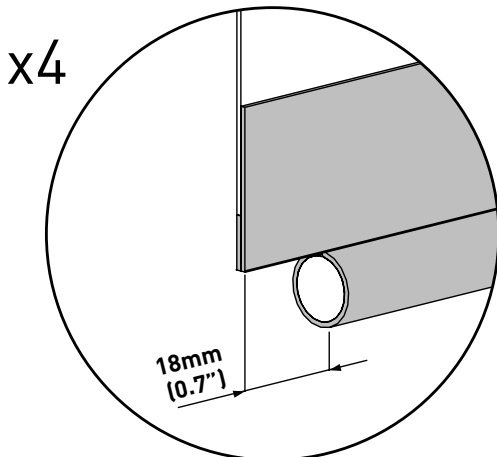
2 Weld fabric Spline to top & bottom edges

WELDING TIPS



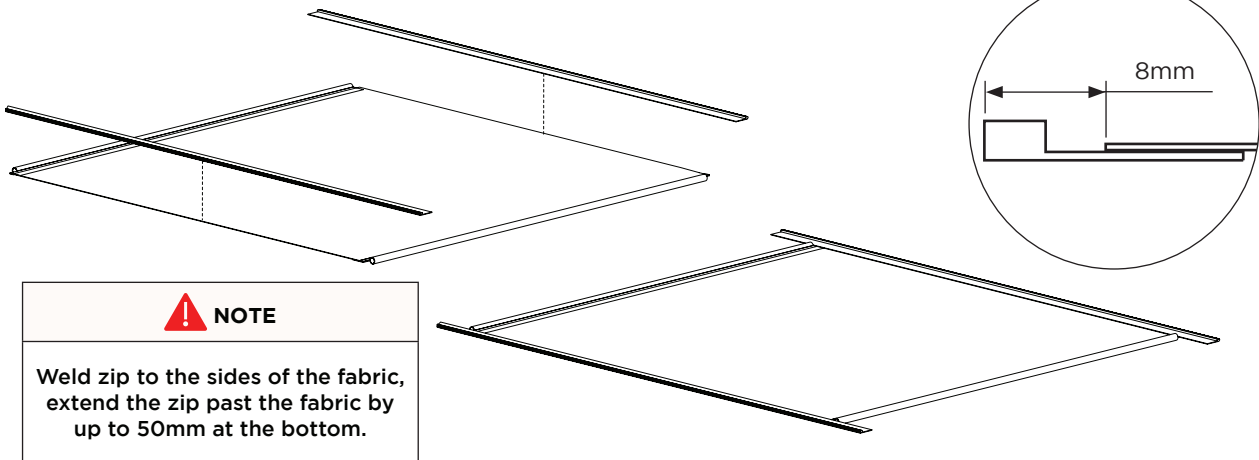
- Ensure welding area and fabric is clean and free from dust and dirt. If dust and dirt is evident this will lead to sparking and burning of the fabric.
- Before welding your fabric, undertake weld testing on scrap pieces.
- If the temperature / amperage on the welding machine is too low, the weld will not bond the fabric properly, this is referred to as a 'cold weld'.
- If the temperature / amperage on the welding machine is too high, the fabric will burn.
- When using a High Frequency Welding Machine, ensure the welding overlap is at least 50mm. If the overlap is any shorter than this a 'cold weld' may occur at this area.
- For fabrics with a higher content of plastic in them, a higher-level sheen will be evident. When using a High Frequency Welding Machine and the fabric is overlapped to achieve a quality weld, the level of sheen on the fabric at this area will be reduced.

3 Trim Spline 18mm on all 4 corners



FABRIC PREPARATION

- 4 Weld zip to the fabric on the opposite side to the fabric spline

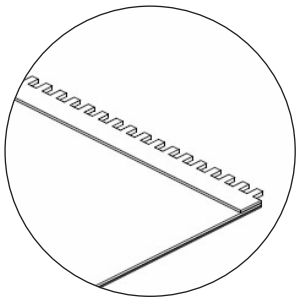


NOTE

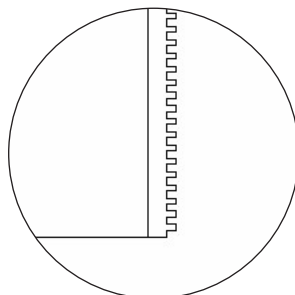
Weld zip to the sides of the fabric, extend the zip past the fabric by up to 50mm at the bottom.

VISUAL CHECKS

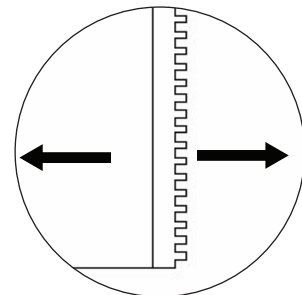
1. Fabric at weld should have a consistent sheen



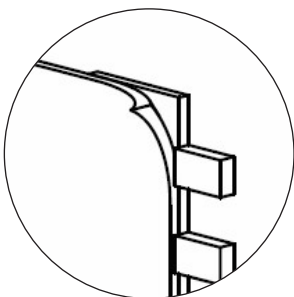
2. Check the Zip is welded straight



3. Pull the weld to ensure that the fabric does not separate



4. Peel zip from fabric



A good weld **will** peel - check if the coating from the fabric has adhered to the zip.

Screen Fabrics: Fibres from fabric become exposed.

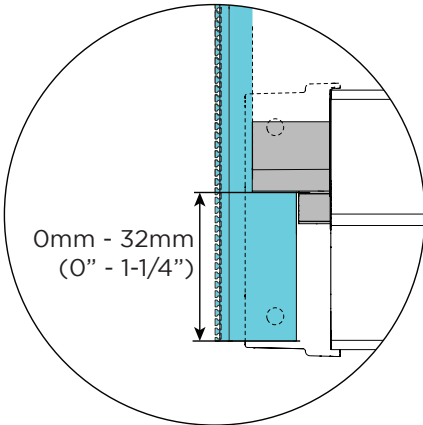
NOTE

A bad weld will also peel, if the coating on the fabric and zip remain intact and do not bond this means the melting point has not been achieved. Increase welding temperature.

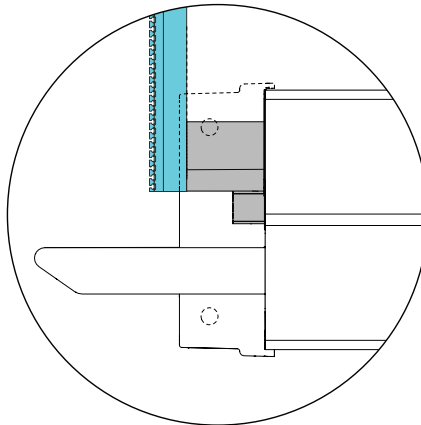
If the test weld passes both tests, proceed with welding your blind fabric. Rollease Acmeda recommends the above testing is undertaken prior to each welding session and when the fabric comes from different batches. Inconsistencies in welding will hinder the performance of the Zipscreen Blind.

FABRIC PREPARATION

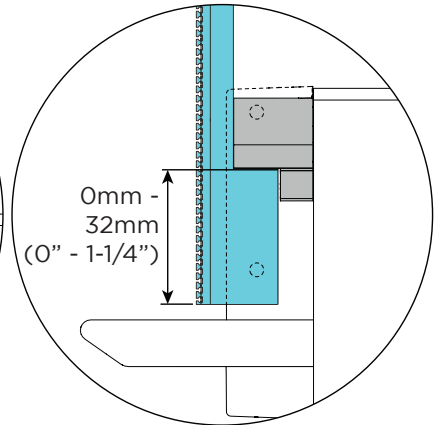
5 Trim zip ends at the bottom



F56



F56 with Ultra-Lock



F72 with or without Ultra-Lock

NOTE

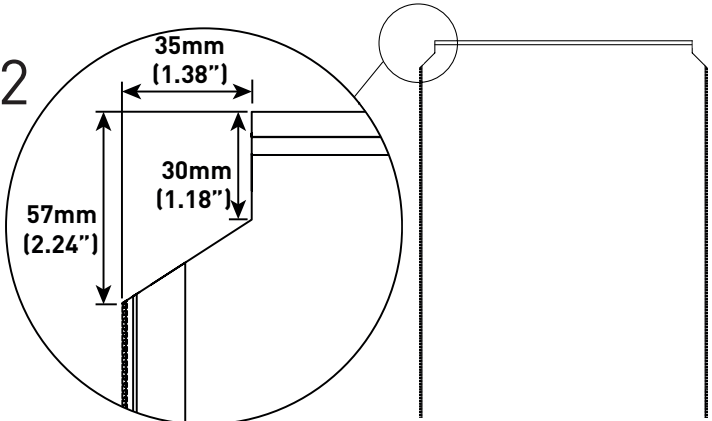
The zip 'tail' may be left longer to increase zip engagement in the Zipscreen Inner Rail. This length is dependent on the weight bar and if the Ultra-Lock is being installed.

6 Mark out & cut fabric scallops

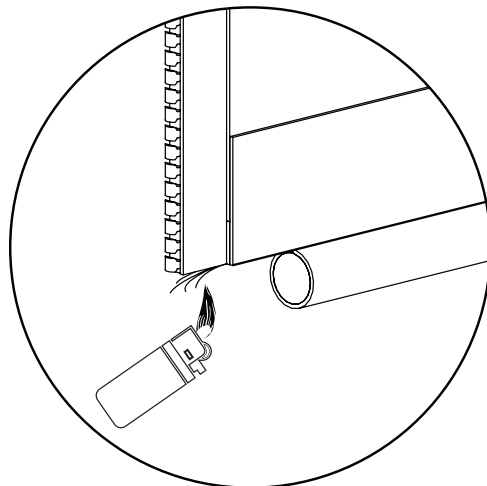
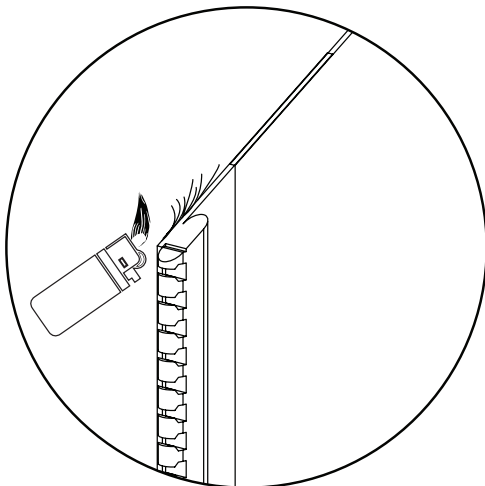
NOTE

Scallop detail is symmetrical. If additional fabric wrap is used, trim the Zip the additional distance i.e. if 300mm of pre-wrap is added, trim the Zip back 300mm. This will reduce the Zip build up.

x2

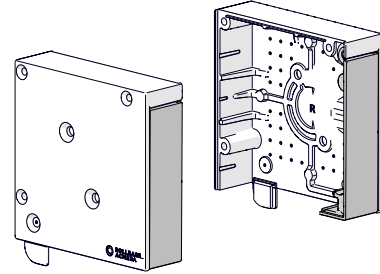
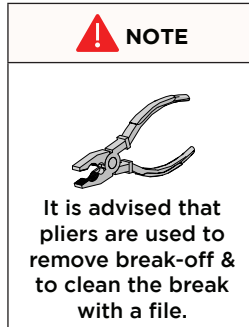
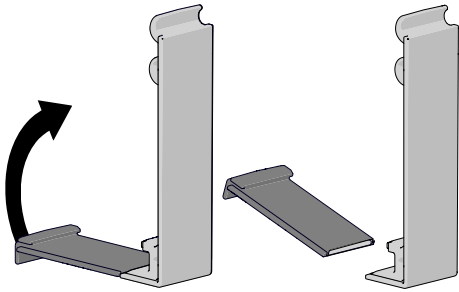


7 Melt zip at each end to prevent fraying

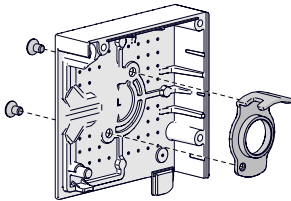


78MM TUBE | BOX 120 END PLATES

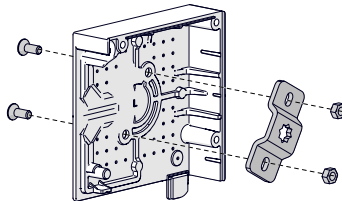
- 1** Remove end plate cover leg
This is only required:
- At one end when using a crank control.
 - At both ends when using the Box 120 Semi Front Cover.



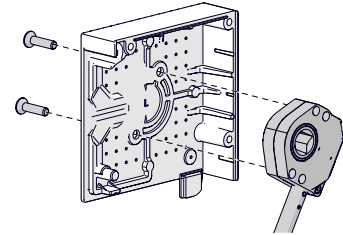
- 2** Attach control hardware
BOX 120 | SPRING CONTROL



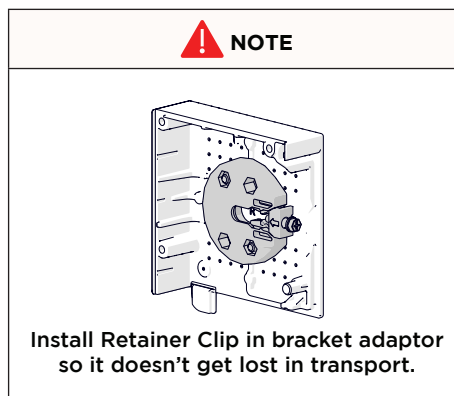
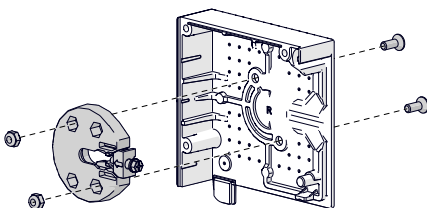
BOX 120 | MOTOR CONTROL



BOX 120 | CRANK CONTROL

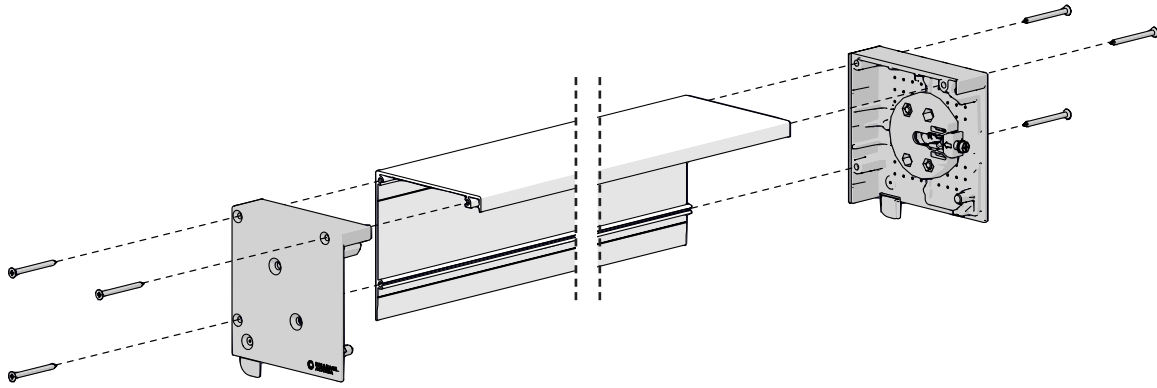


- 3** Attach Idler hardware
BOX 120 | IDLER ADAPTOR

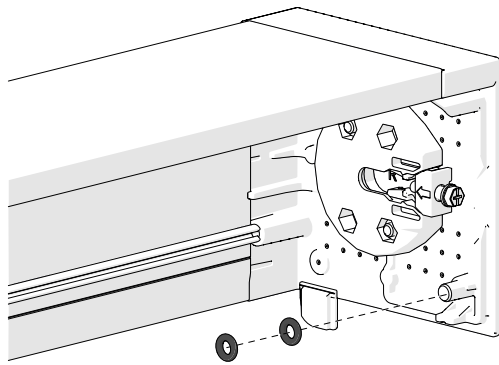


78MM TUBE | BOX 120 CASSETTE

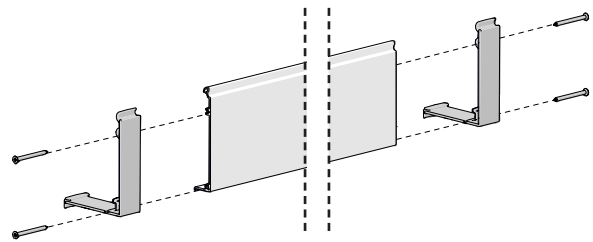
- 1** Attach end plates to box



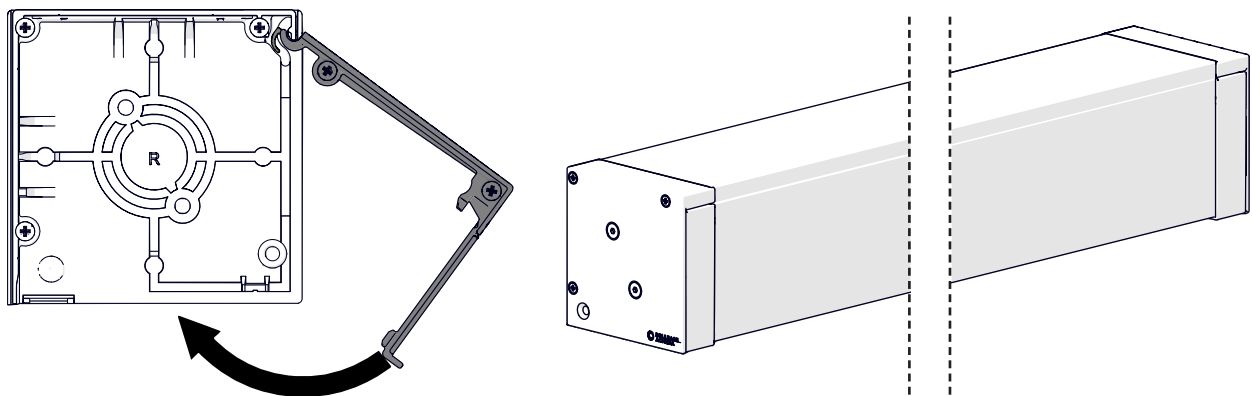
- 2** Attach 2x O-Rings to each side



- 3** Attach front cover end plates



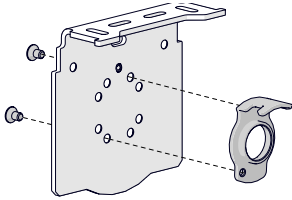
- 4** Attach front cover assembly to box assembly



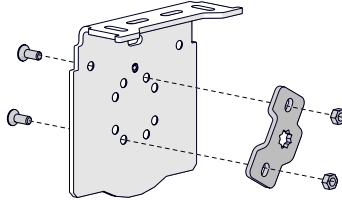
78MM TUBE | OPEN BRACKETS

1 Attach control hardware

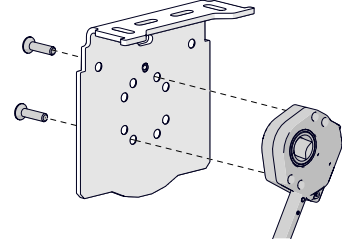
SPRING ADAPTOR



MOTOR CONTROL

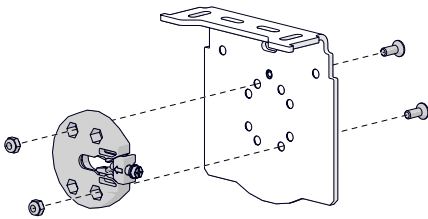


GEAR CONTROL

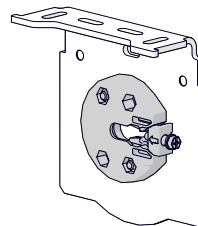


2 Attach Idler hardware

BOX 120 | IDLER ADAPTOR



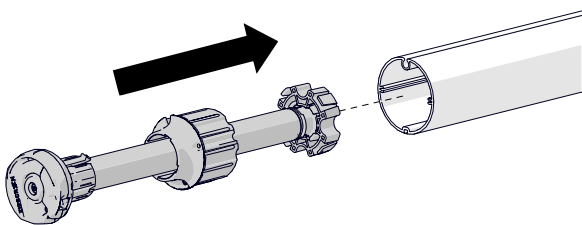
NOTE



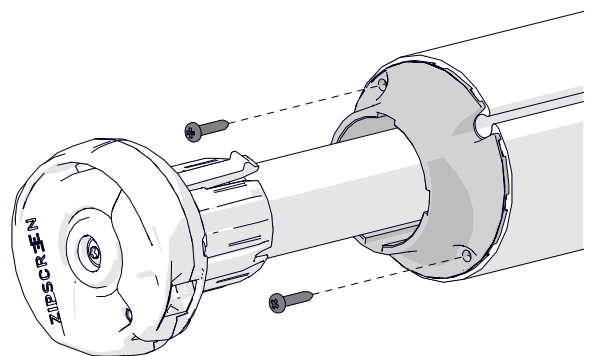
Ensure Idler opening is horizontal to installation orientation.

78MM TUBE | CONTROL SUB-ASSEMBLY | SPRING

1 Insert spring assembly in tube

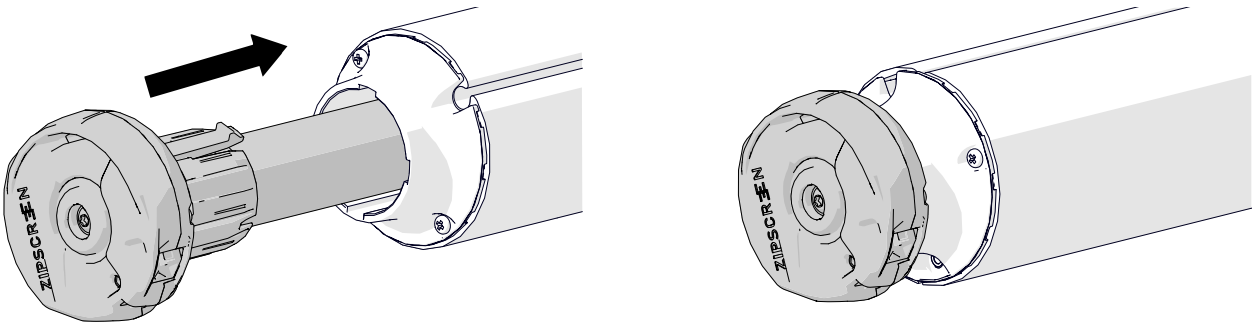


2 Fasten reducer in place



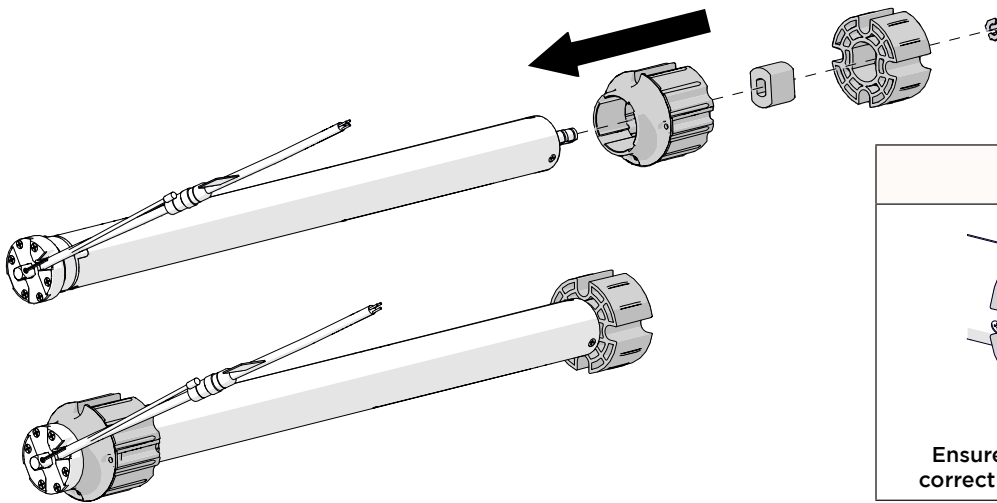
78MM TUBE | CONTROL SUB-ASSEMBLY | SPRING

- 3** Slide spring into reducer until it clicks

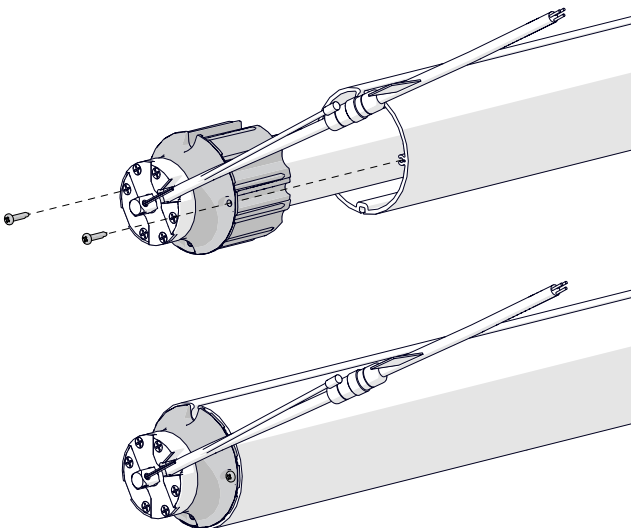


78MM TUBE | CONTROL SUB-ASSEMBLY | MOTOR

- 1** Assemble reducer, impact detect insert, drive wheel and clip

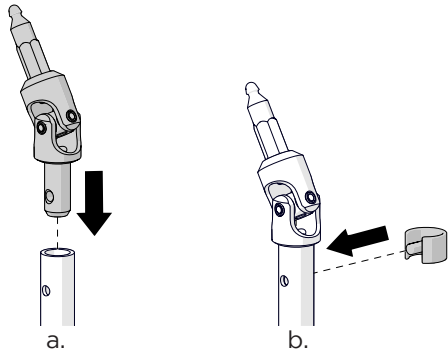


- 2** Insert motor in tube and fasten reducer in place

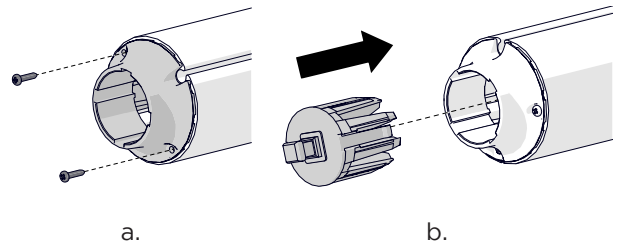


78MM TUBE | CONTROL SUB-ASSEMBLY | CRANK

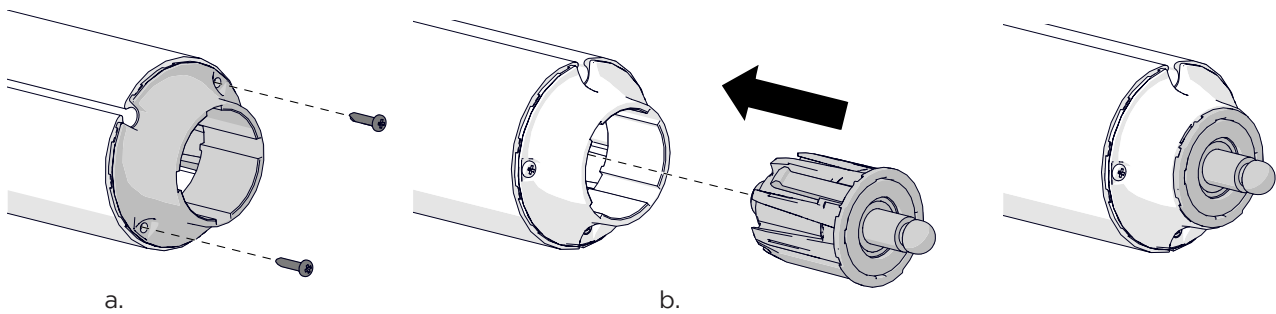
- 1** a. Insert uni-joint into crank handle.
b. Insert c-clip pin through shaft hole to secure uni-joint.



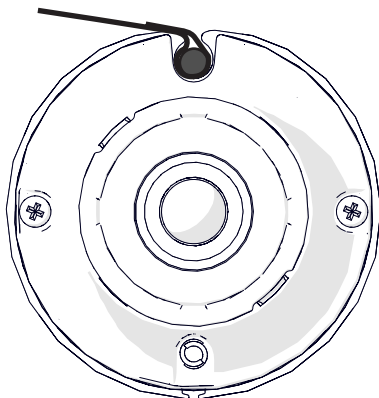
- 2** a. Insert reducer into tube and fasten into place.
b. Insert crank adaptor into reducer until it locks into place.

**78MM TUBE | CONTROL SUB-ASSEMBLY | IDLER**

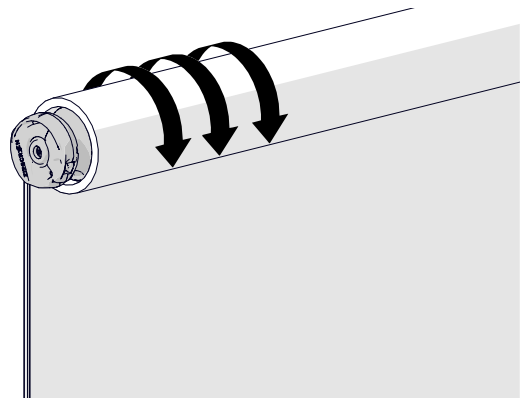
- 1** a. Insert reducer into tube and fasten into place.
b. Insert idler into reducer until it locks into place.

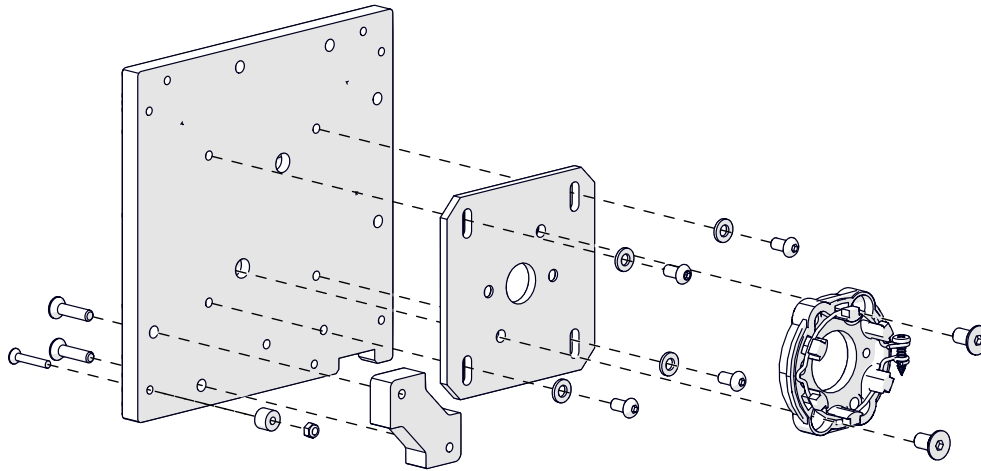
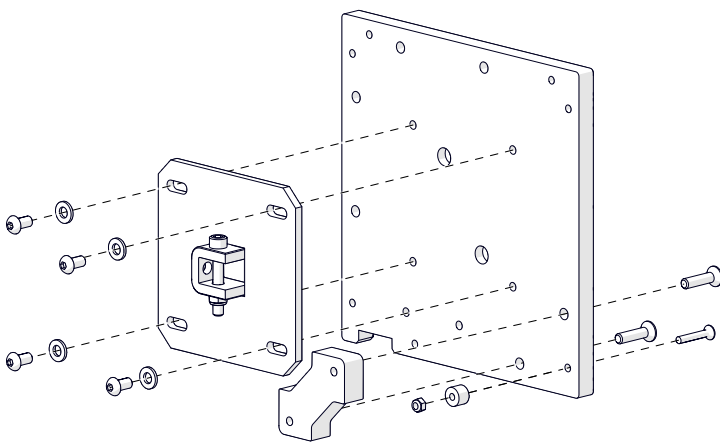
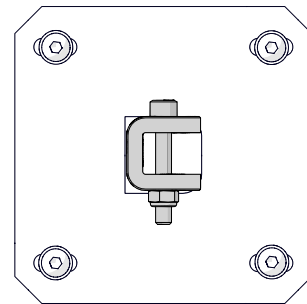
**78MM TUBE | FABRIC ASSEMBLY**

- 1** Insert fabric into tube

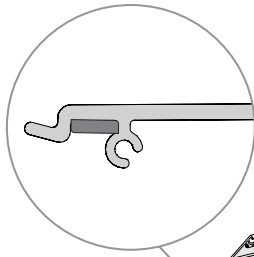


- 2** Roll fabric around tube

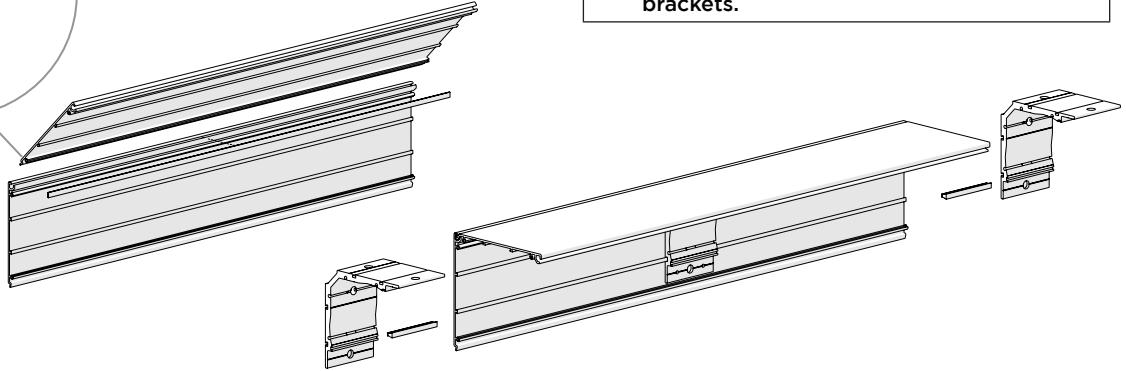


S100 TUBE | BOX 190 END PLATES | MOTOR CONTROL**1** Attach control hardware**2** Attach idler hardware**NOTE**

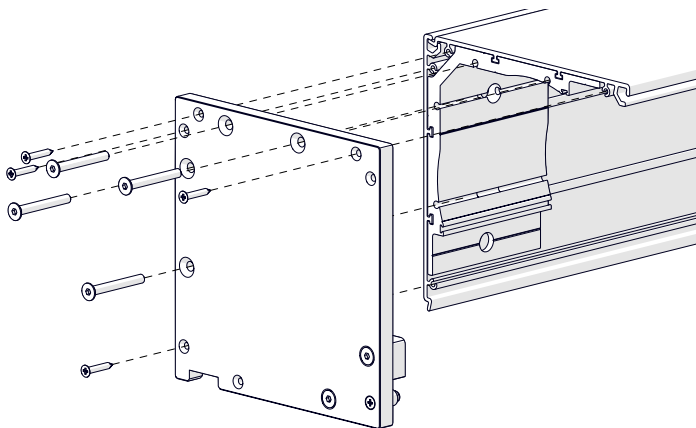
Ensure 'U' shaped saddle is orientated correctly.

S100 TUBE | BOX 190 CASSETTE**1** Assemble top & back cassette extrusions

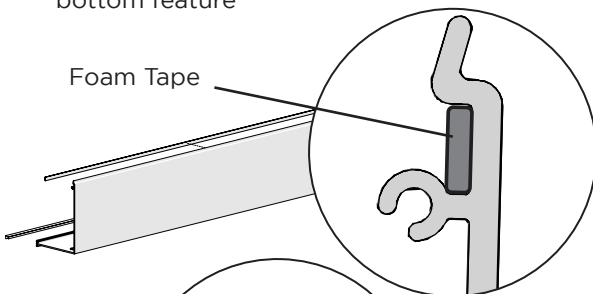
Insert Foam Tape into groove as shown

**NOTE**

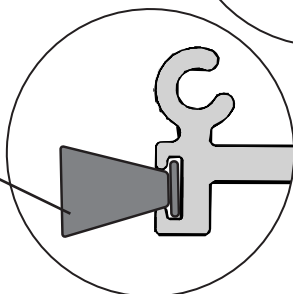
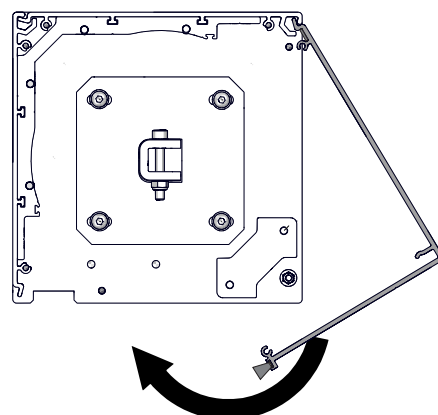
- Assemble with additional Universal Bracket Extrusion for systems wider than 4m [158"].
- Cut brush to 100mm [4"] lengths to fit brackets.

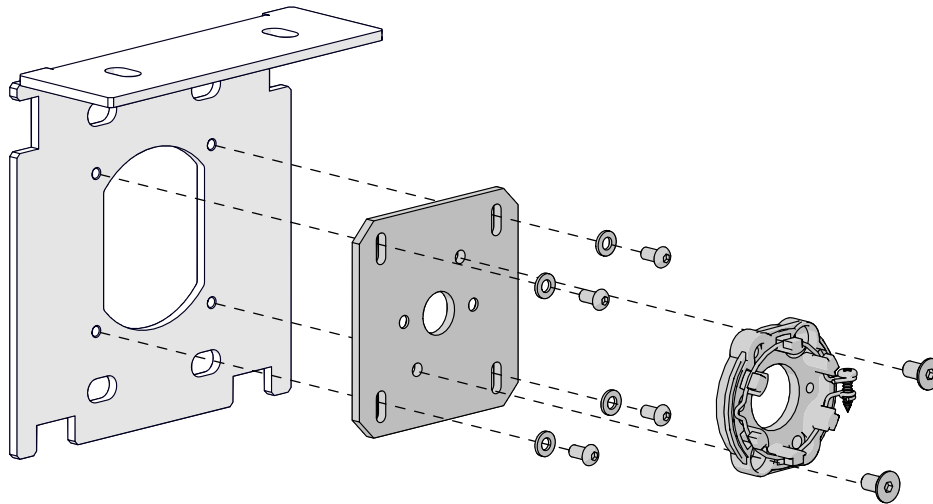
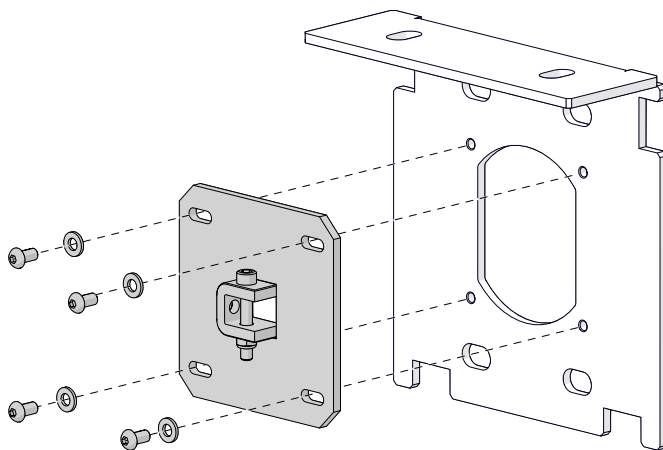
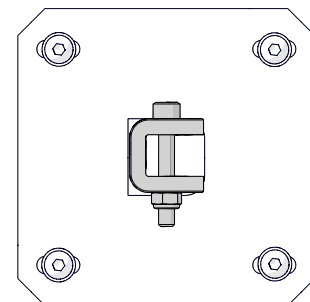
2 Attach end plates to cassette assembly**3** Assemble Foam Tape in top joint, and brush in bottom feature

Foam Tape



Brush

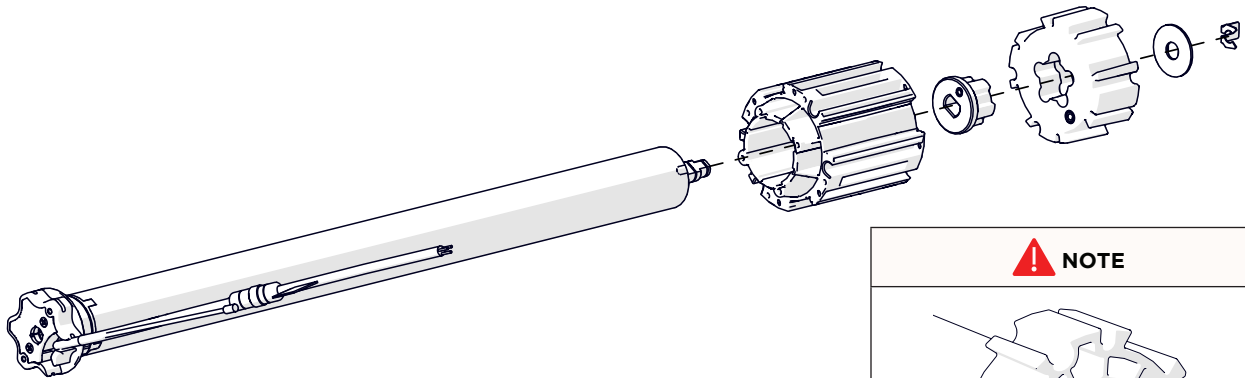
**4** Attach front cover assembly to box assembly

S100 TUBE | OPEN BRACKETS**1** Attach control hardware**2** Attach idler hardware**NOTE**

Ensure 'U' shaped saddle is orientated correctly.

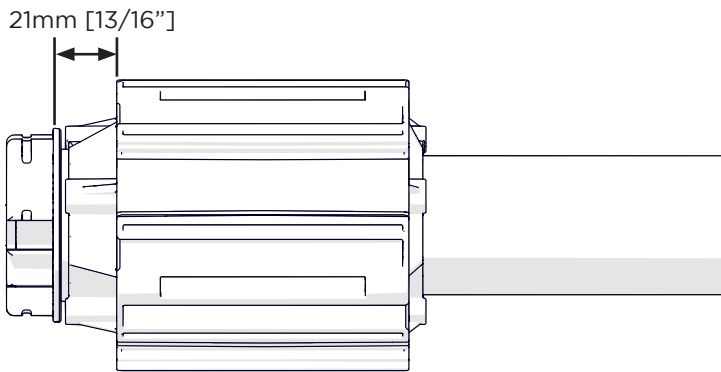
S100 TUBE | CONTROL SUB-ASSEMBLY | MOTOR

1 Assemble motor with crown, drive & adaptor kit



NOTE

Ensure the clip is attached correctly with the drive shaft

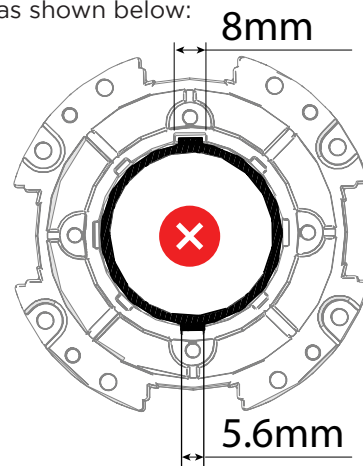
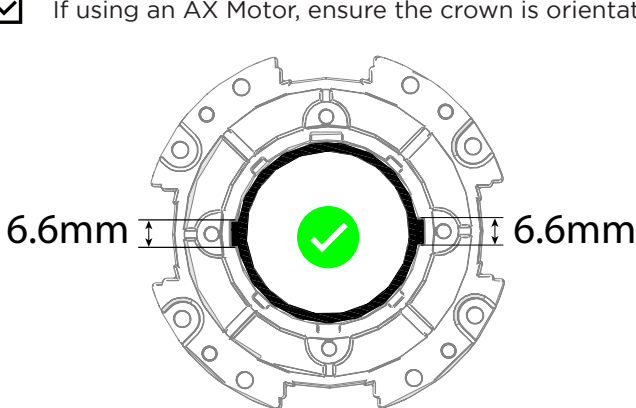


NOTE

Ensure crown is installed in the correct orientation for Zipscreen

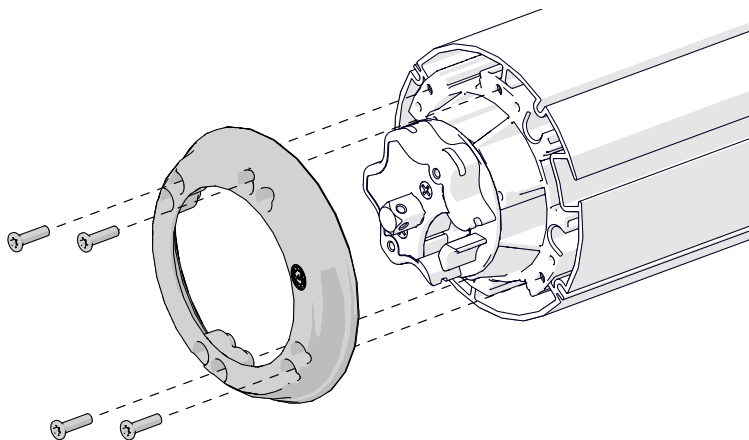
VISUAL CHECK

If using an AX Motor, ensure the crown is orientated correctly as shown below:

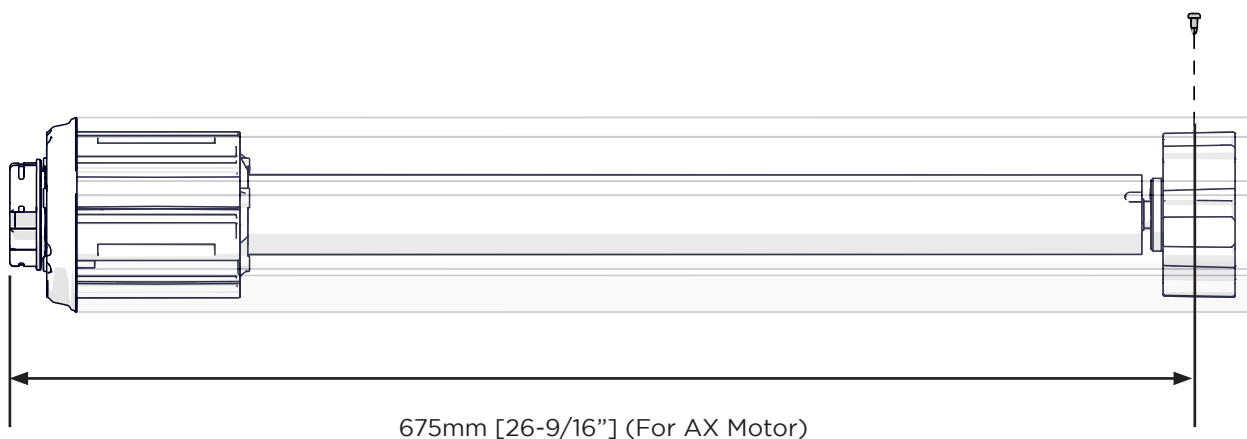


S100 TUBE | CONTROL SUB-ASSEMBLY | MOTOR

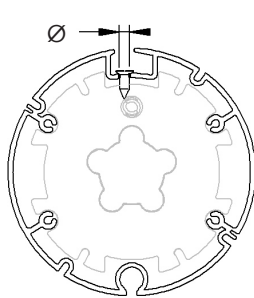
- 1 Insert motor assembly into tube & fasten reducer in place



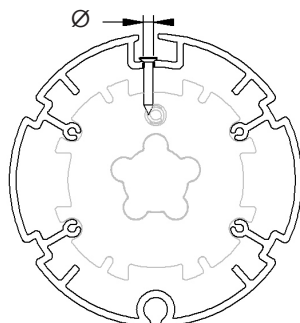
- 2 Secure drive wheel to tube with counter sunk screw



HOLE = Ø4.5mm (0.18")



110mm

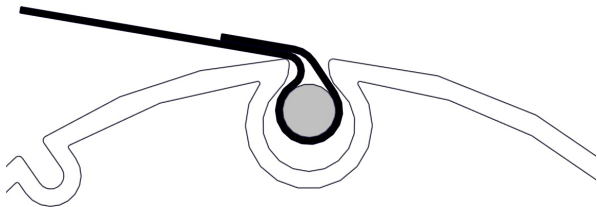


130mm

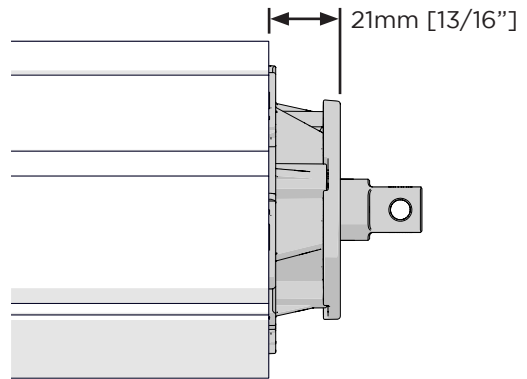
TUBE	SCREW
110mm	#8 x 1/2"
130mm	#8 x 1" Screw

S100 TUBE | FABRIC ASSEMBLY

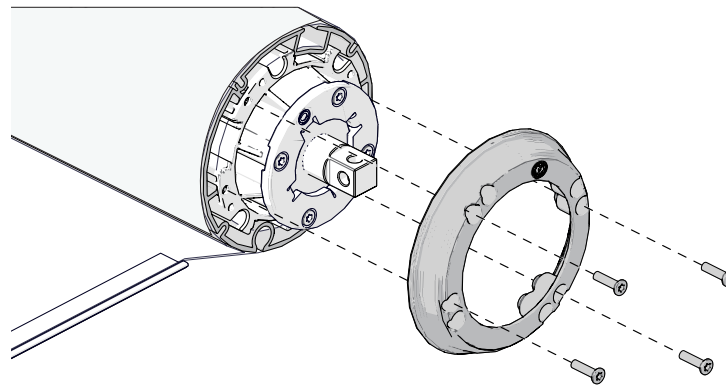
- 1** Insert fabric into tube



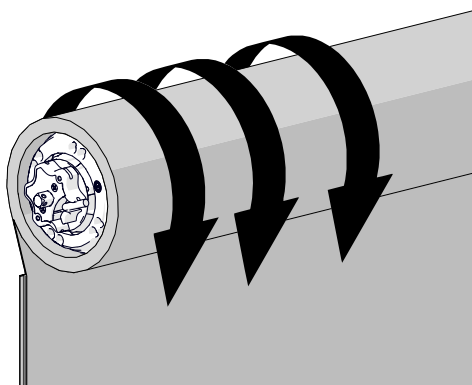
- 2** Insert idler into tube, ensure correct idler orientation



- 3** Fasten reducer in place



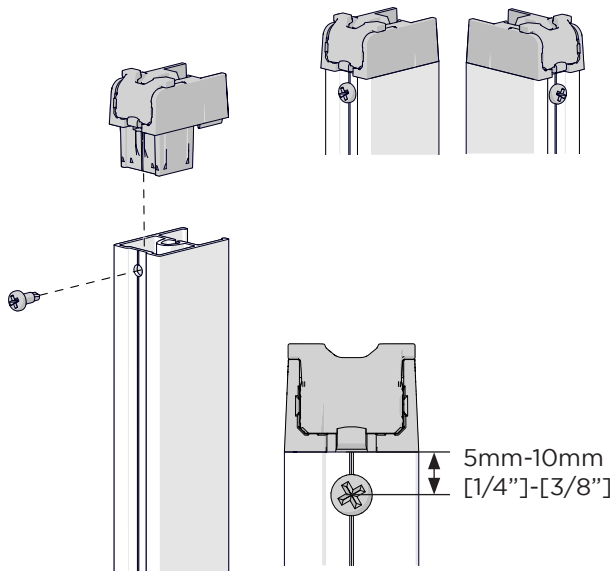
- 4** Roll fabric around tube



INNER RAIL ASSEMBLY

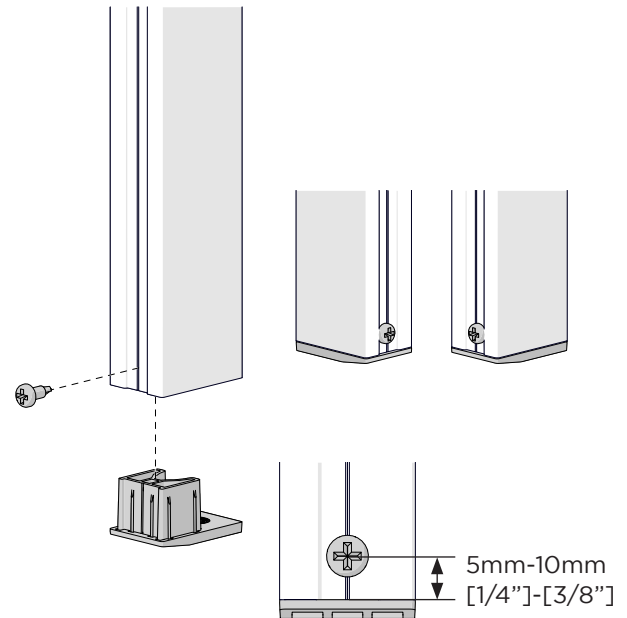
- 1** Fasten the Top Stops in the Inner Rail with the supplied screws.

Repeat for both Inner Rails.

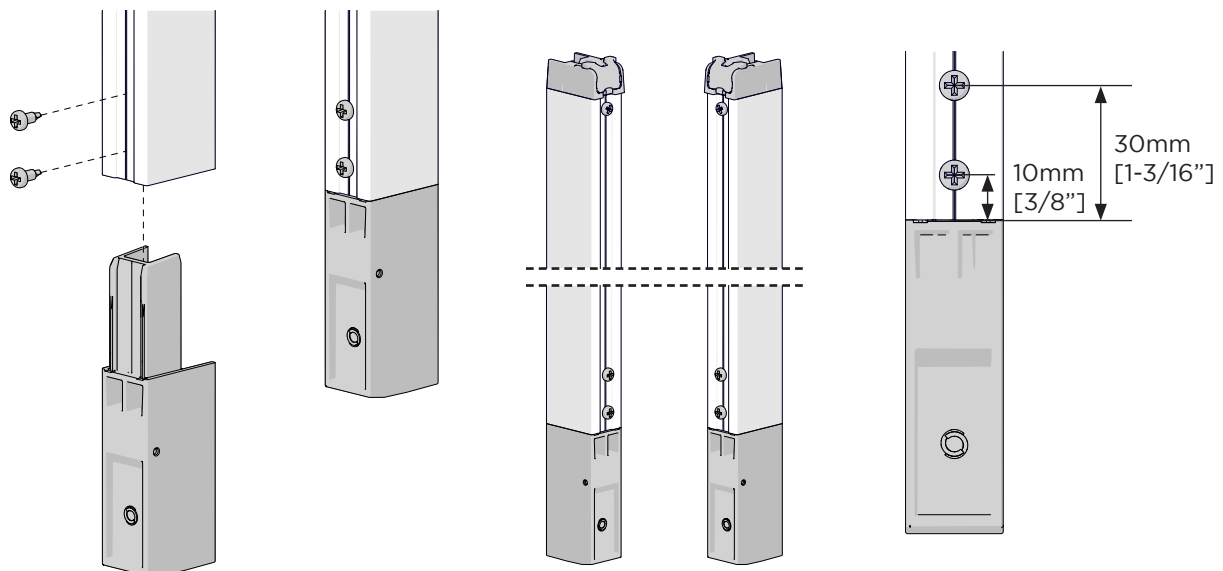


- 2** Fasten the Bottom Stops in the Inner Rail with the supplied screws.

Repeat for both Inner Rails (**skip to step 3 for Ultra-Lock**).

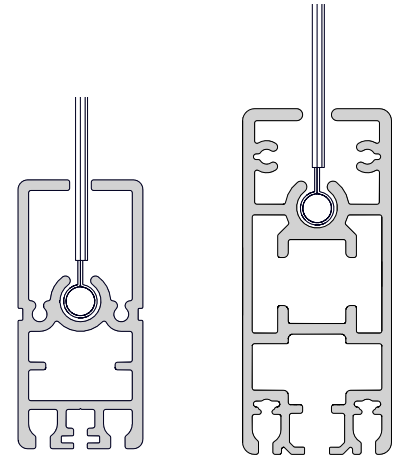
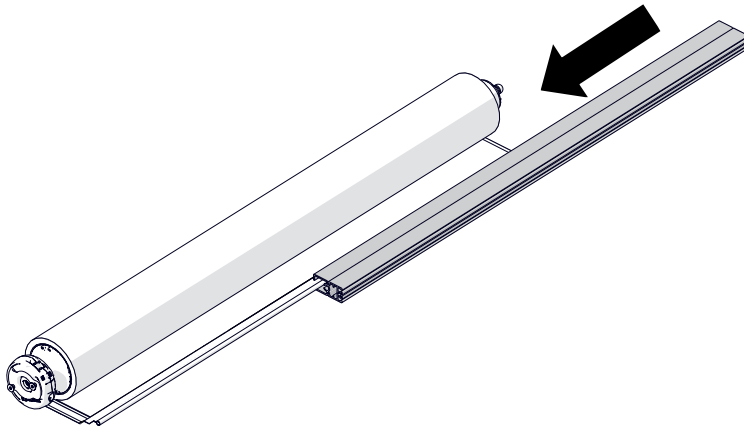


- 3** (Only for Ultra-Lock) - Fasten the Ultra-Lock Housing in the Inner Rail with the supplied screws. Repeat for both Inner Rails.



WEIGHT BAR ASSEMBLY

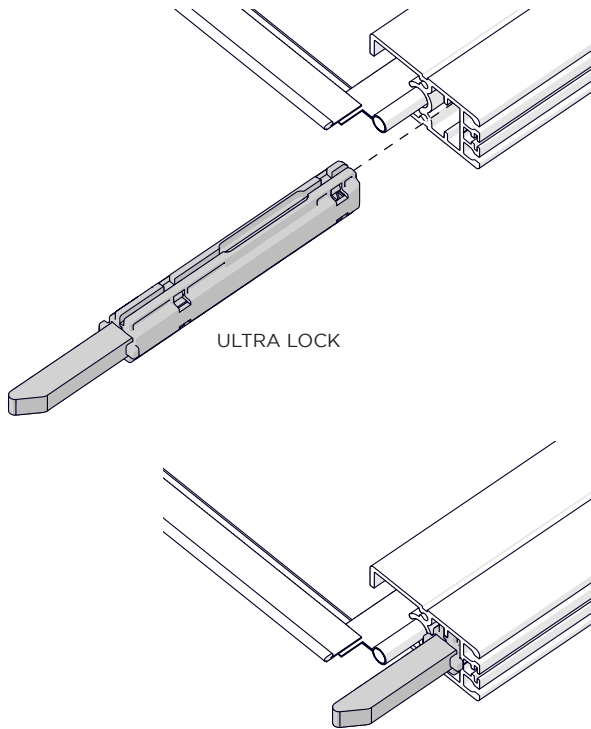
1 Slide weight bar onto fabric



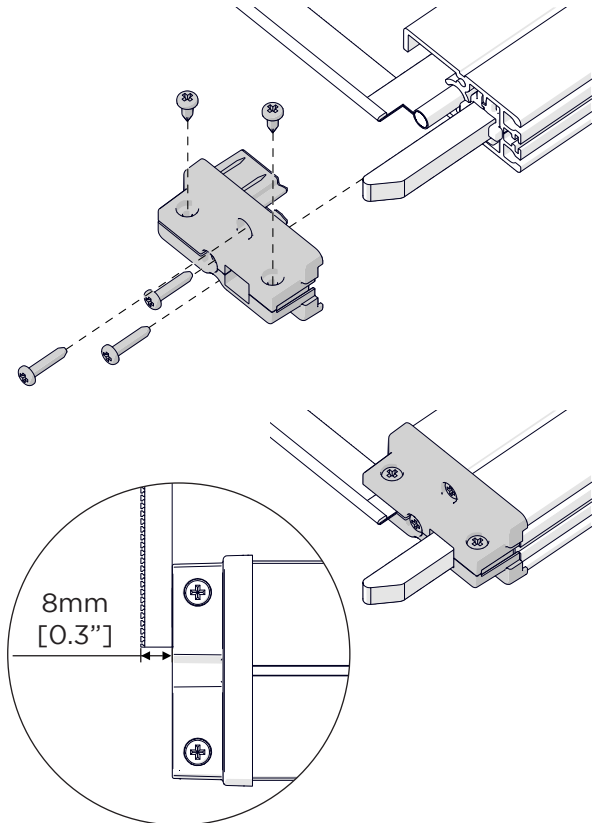
F56 WEIGHT BAR

F72 WEIGHT BAR

2 (Only for Ultra-Lock) - Insert ultra lock on one end

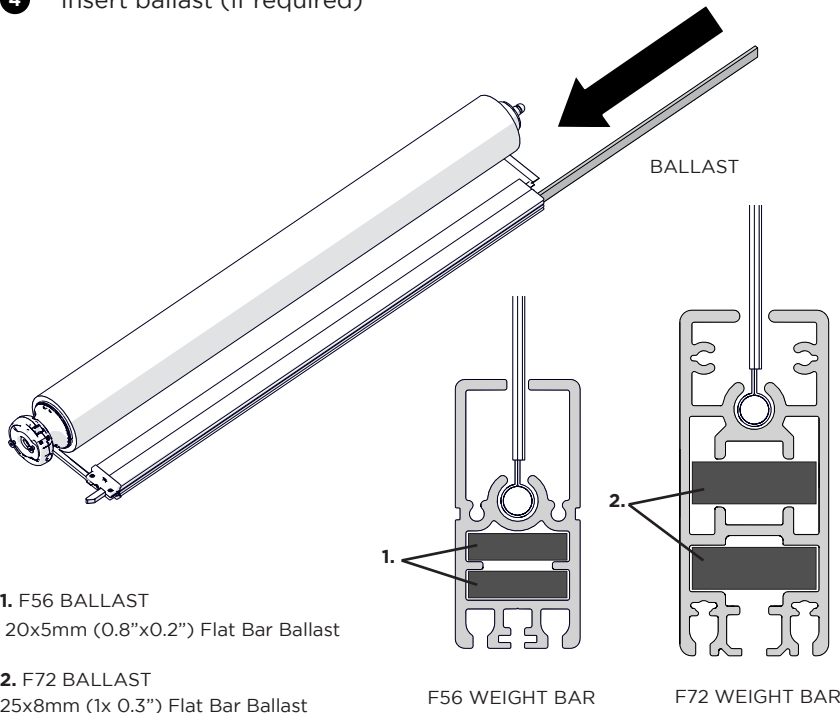


3 Insert end caps



WEIGHT BAR ASSEMBLY

4 Insert ballast (if required)

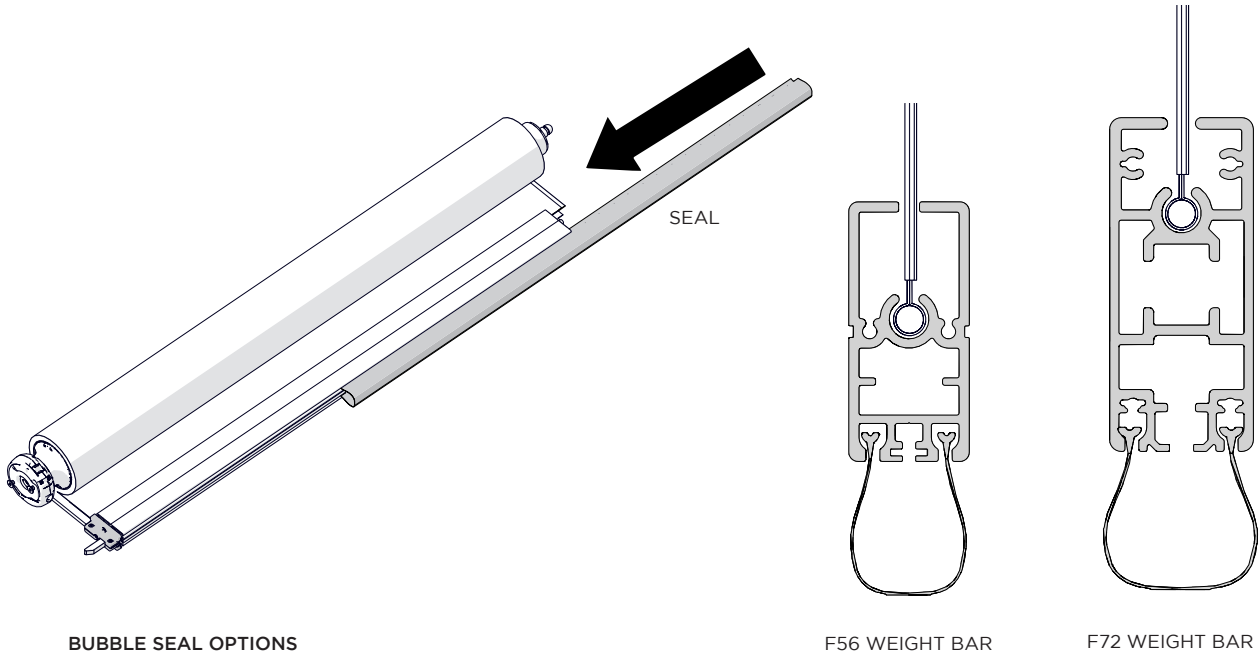


- 1. F56 BALLAST**
20x5mm (0.8"x0.2") Flat Bar Ballast
- 2. F72 BALLAST**
25x8mm (1x 0.3") Flat Bar Ballast

NOTE

- Ballast is recommended in all motorised and crank control shades, especially with the Ultra-Lock.
- If the ballast has been cut to size, use a Zinc-rich primer to protect the cut edges from corrosion.
- If using ballast on shades wider than 4m, only put the ballast on the outside edges.
- Max 2x lengths per ballast opening, total maximum of 4x lengths per weight bar.
- Extra ballast in the centre will create additional tube deflection.

5 Insert seal (if required). Silicone spray can assist with smooth insertion.



BUBBLE SEAL OPTIONS



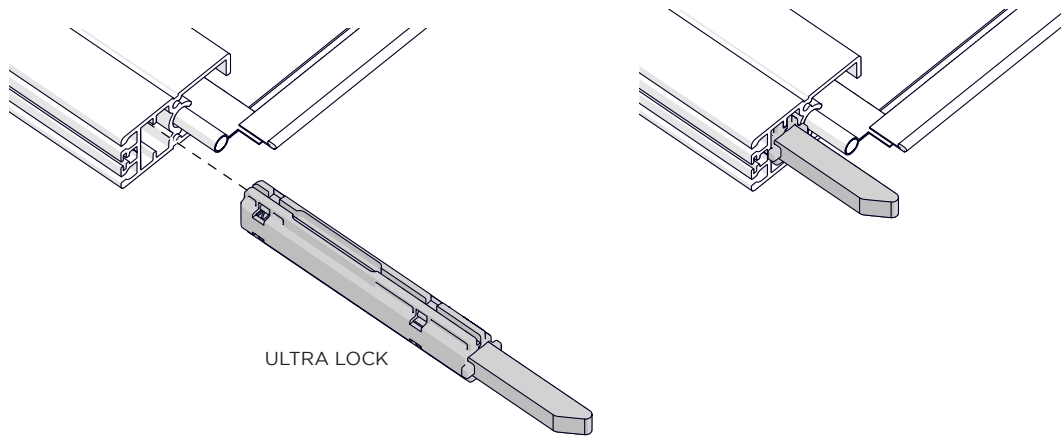
SCAN HERE

NOTE

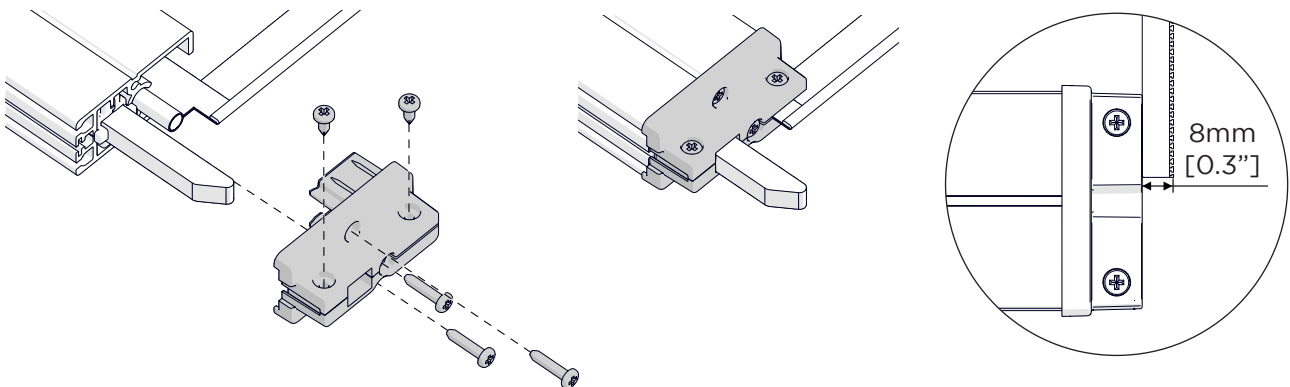
Ultra-Lock Seal must be used for installations with the Ultra-Lock.

WEIGHT BAR ASSEMBLY

- 6 Insert components at the other end

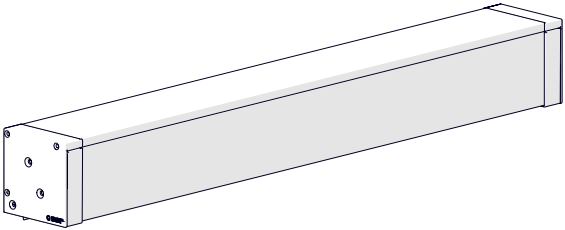
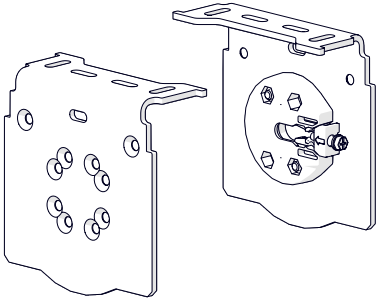


- 7 Attach end caps

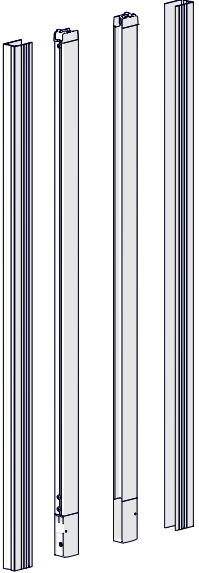


PREPARE & PACK FOR TRANSPORTATION

Note: Images shown below are indicative only and will vary with system requirements.

<p>Box 120 Box 190</p> 	<p>Open Brackets</p>  <p>OR</p> <div style="border: 1px solid black; padding: 5px; text-align: center;"> <p>NOTE</p> <p>Store idler/spring adapter retaining clip until required (can be left in adaptor as shown)</p> </div>
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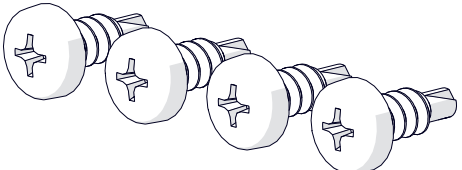
Side Guide



Blind



Screws (quantity as required)



SECTION F | DOCUMENT CHANGE NOTES

REVISION	CHANGES
v4.0 September 2023	Updated codes and items for Top Hardware Upgrade changes. Combined Zipscreen & Zipscreen Extreme Assembly Manuals. 78mm Tube deduction changed to W-118mm (+2mm, was W-116mm).
v4.1 February 2024	Updated RE01 gear codes