Sudhai AirTech Pvt. Ltd.

Innovating Air Technology

STRIP DOORS

PRODUCTION PROCESS & INSTALLATION MANUAL

Sudhai

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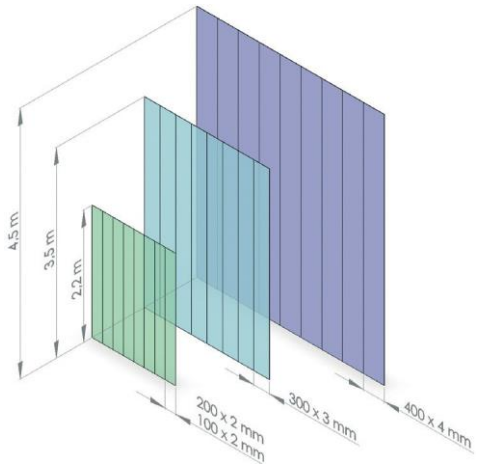
1 HOW TO DESIGN THE STRIP DOOR

• Strip quality

Choose from a wide range of PVC strips the right strips according to your application:

For normal application.....Standard clear
For cold rooms. ..... Polar & Super polar
For tropical regions. .....Anti-insect yellow
For welding screen..... Anti-UV strips
For identifying opening edges. ..... Signal red
For heavy traffic. .....Ribbed strips



Strips sizes

• Strip sizes

Depending on your opening size, choose a suitable width and thickness of strip.

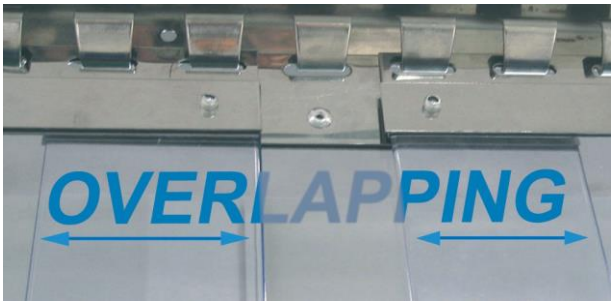
• Strip overlapping

In order to get a better performance from your doors, a certain percentages of strip overlapping is recommended depending on their use.

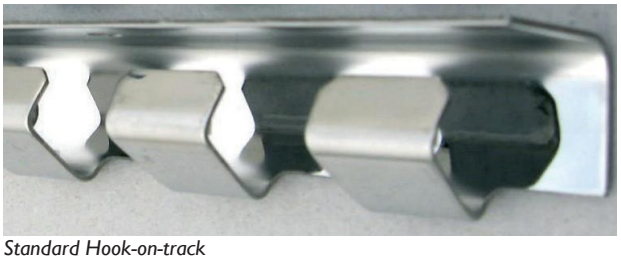
REQUIRED OVERLAPPING	STRIP WIDTH X THICKNESS (mm)	
Applications	200 x 2	300 x 3
Strong isolation / Outside opening	100%	100%
Medium isolation / Inside opening	50%	50%
Slight isolation / Inside opening without under or over pressure	33%	33%

• Hardware

- Use Heavy duty Hook-on-track with
  strips :300mm x 2 mm
  200mm x 2 mm for vehicle traffic
- Use standard 200 mm x 1mm
  Hook-on-track duty for all other applications.



Strips overlapping


Standard Hook-on-track

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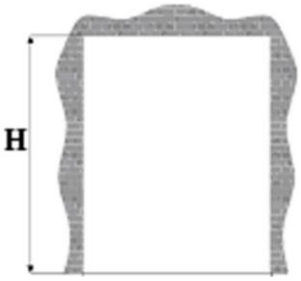
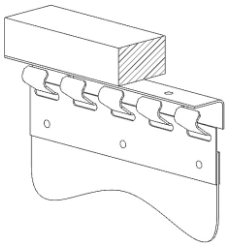
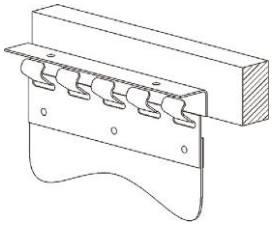
2 HOW TO CUT

- Cut strips according to the opening height and the hook-on-track configuration as follow :

	STANDARD HOOK-ON-TRACK	
	 Under lintel	 Face fix
Strip length	Type 1	Type 2

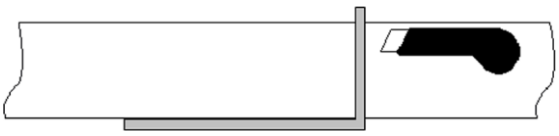
Note: The length of strips is cut to the height of the opening. It is recommended that you cut the strips in the workshop10mm longer and trim them when fitted.

Note 2: It is recommended that the Standard Hook-on-track is face fixed as it is easier to install and is stronger.

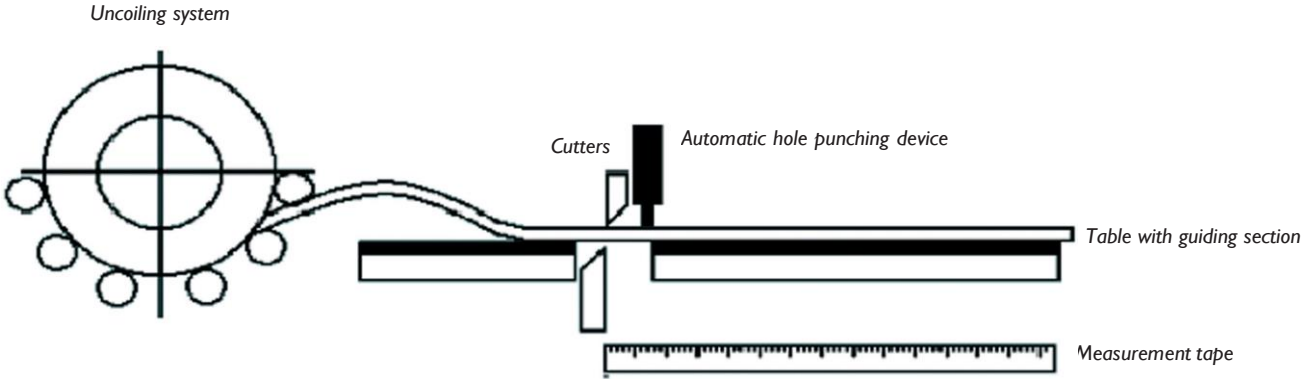
- When cutting use a work surface at least 4500x450mm that does not adhere to the PVC (cardboard, carpet)

- **Manually cutting**

- Use a long square to determine the centerline of the strip whenpressed against one of the edges.
- For thick strips, cut several times with the cutter without pressing too hard, maintaining the square pressed firmly on the working surface so that it does not slide.
- It is recommended that a steel glove is worn when cutting.



- **Automatic or semi-automatic: cutting table (Recommended)****



3 HOW TO PACK TO DELIVER TO THE JOB SITE

- Never roll the strips into small diameters. (ø 150 mm minimum)
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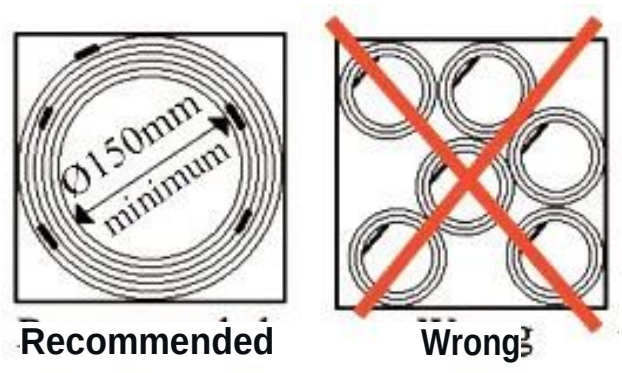
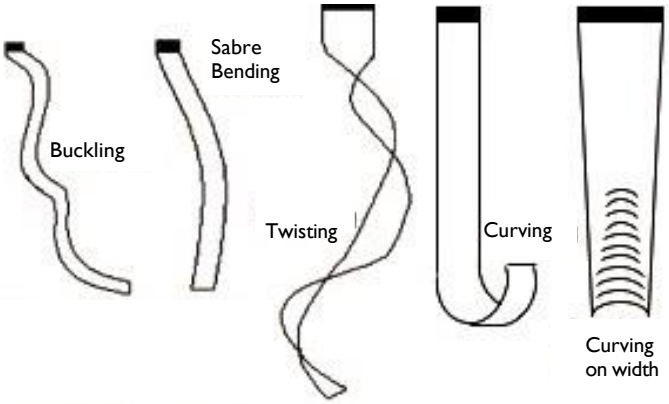
- Pack the strips in the box using packing paper, foam or bubble wrap.



Packaging requirement

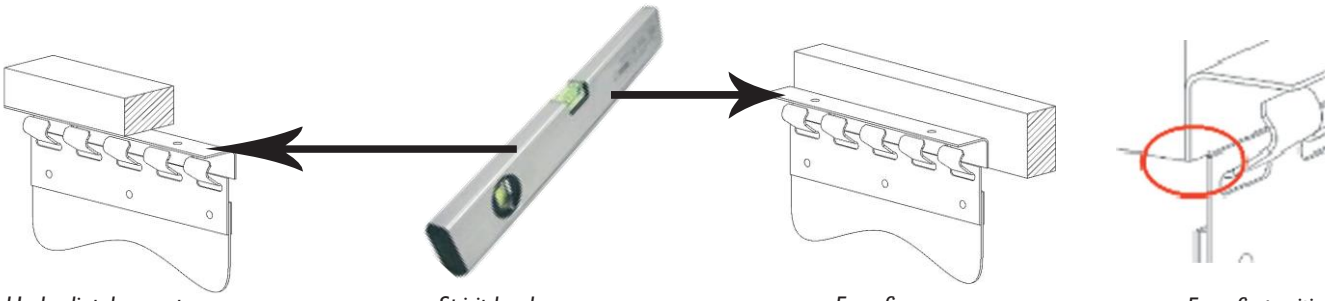


Defects caused by wrong packing

4 HOW TO INSTALL

- Make sure that support is in good condition.
- The hook-on-track must be secured firmly and in a level position:

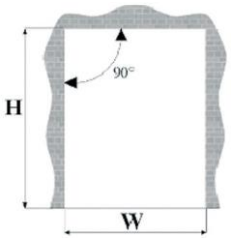
1) Position the hook-on-track to the opening (face fix or under lintel)
Note that for the face fix beginning of the hook needs to match the opening.
For under lintel mount configuration make sure that the edge of the end strips will be able to swing freely.



Under lintel mount *Spirit level* *Face fix* *Face fix position*

2) Fix the Hook-on-track with a first screw in its middle.
3) Use a spirit level to position and mark fixing holes.
(For under lintel mount use wedges to correct the position)
4) Then install. (For the heavy-duty hook-on-track fixation process refer to the following page)

- For under lintel, the hook-on-track has to be cut to fit the opening and the strips width.



- For face fix, the curtains have to be wider than the opening to cover the gap between the door edge and the wall in order to provide a better sealing. Longer edges can be used to stock strips if the door is removed during hot periods.

- Place the first PVC strips on the hook-on-track with the required number of free hooks between the strips according to the overlap. Then place remaining strips.
- Front plates have to be placed in the middle of the curtain between the back plates to avoid any unnecessary gap
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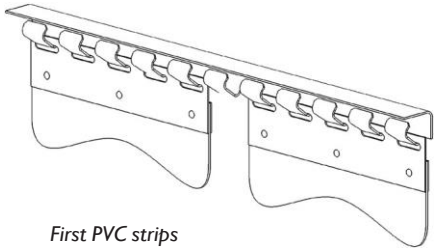
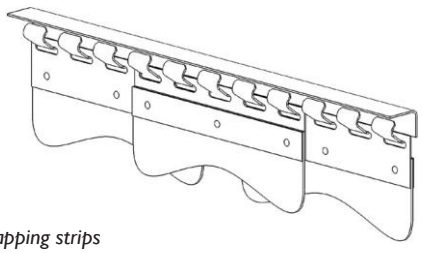


First PVC strips



Overlapping strips

5 CLEANING AND MAINTENANCE

- Wash with soapy water or alcohol solution.
- Avoid any contact with solvents.
- No particular maintenance is required except for periodic checking (twice annually) to ensure the attachment systems are secure (strips/hooks, hook-on-track/lintel) and to replace any worn strips that no longer offer the necessary transparency.

Remember : Strips are not costly don't hesitate to change them.

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FLEXIBLE VINYL & NON-PHTHALATE PLASTICIZERS

Soft Vinyl is a complex material. Softness or flexibility is given by plasticizers' incorporation in basic formulas. Phthalates have been used for many years and are still in use today.
In order to be proactive in the protection of our customers and our environment **Sudhai** is proposing a complete new non-phthalate soft vinyl range.
Already used in toys, children articles, food contact material and medical devices, this new **NON-PHTHALATE** plasticizer will guarantee to the end-users the safest soft vinyl strips and sheets. Our "**NON-PHTHALATE**" grade will give you the assurance that our soft vinyl is no longer using phthalates and will offer you the best choice for human health and environment protection.

RISK ASSESSMENT Conclusion of the assessment on the risks to		PHTHALATE		NON PHTHALATE
		DEHP	DINP	
HUMAN HEALTH	WORKERS	✗	✓	✓
	CONSUMERS*	✗	✓	
	HUMANS EXPOSED VIA THE ENVIRONMENT	✗	✓	✓
	HUMAN HEALTH (physico-chemical properties)	✓	✓	✓
	FOOD CONTACT – Aqueous preparation*	✗	✓	✓
	FOOD CONTACT – Acidic liquid*	✗	✓	✓
	FOOD CONTACT – Alcohol beverage*	✗	✓	✓
	FOOD CONTACT – Fatty food*	✗	✗	✓
	TOYS AND CHILDCARE ARTICLE		✗	✓
ENVIRONMENT	ATMOSPHERE	✓	✓	✓
	AQUATIC ECOSYSTEM	✗	✓	✓
	TERRESTRIAL ECOSYSTEM	✗	✓	✓
	MICRO-ORGANISMS IN THE SEWAGE TREATMENT PLANT	✓	✓	✓
Conclusion			Restricted use	SAFE

*migration of the plasticizer shall not exceed the maximum level authorized by regulation DINP cannot be used in toys and childcare articles which can be placed in mouth. Use of DEHP is unauthorized in all toys and childcare articles.

✓ : SAFE ✗ : RISK FOR HUMAN HEALTH

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TECHNICAL SPECIFICATIONS

FLEXIBLE VINYL

PROPERTY	CLASSIC	Unit	CLASSIC
Light transmittance	ASTM D1003	%	85
Shore A hardness	EN ISO 868	Sh A	80
Tearing resistance	DIN 53515	N/mm	50
Tensile strength at break	ASTM D638 EN ISO 527-2	N/mm2	16
Elongation at break		%	340
Residual elong. (after break)		%	68
Thermal conductivity	ASTM C 177	W/m.K	0,16
Cold bend brittle temp.	ISO 8570	°C	-35
Min. usage temp.	EN 1876	°C	5
Max. usage temp.		°C	50
Vicat softening temp.	EN ISO 306	°C	50
Specific heat capacity	ISO 11357	kJ/kg.K	1,6
Sound reduction	DIN 52210	dB	>35
Fire retardance	NF P 92-507 AS/NZS 3837 DIN 4102	Grade	Grp4 B2
UV/IR filter	EN 1598	Filter	-
UV resistance	ISO4892	-	Yes
Charge buildup	IEC 61087	Sparks	Yes
Surface resistivity	IEC 60093	/	4.1013
Water absorption	EN ISO 62	%	-0,2
Anti-insect	-	-	No
Density	ASTM D792	g/cm3	1,22

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