



















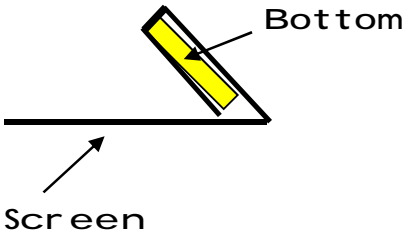
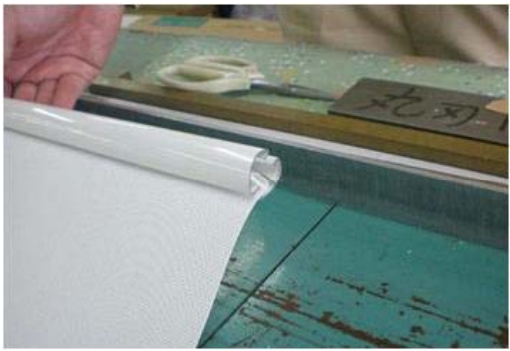



No.	Work photo	Procedure of the work
1		<p>Cut Roller Pipe to have a length equal to the product width (W) minus 36 mm (W - 36 mm).</p>
2		<p>Cut Weight Bar to have a length equal to the product width (W) minus 35 mm (W - 35 mm).</p>
3		<p>Remove any chips from Roller Pipe and Weight Bar with a compressed air blower, cloth, or other appropriate device or material.</p>
4		<p>Insert Spring Set (*1) into Roller Pipe.                      (The photo shows a Roller Pipe which for product width(W) ≤ 2,000 mm and the right operation type.)                       (*1) Refer to the Spring Chart for the appropriate spring set.                      *For left operation type, use Spring Set AL to FL.</p>
		<p>(The photo shows a Roller Pipe G which for product width(W) &gt; 2,000 mm and the right operation type.)</p>

No.	Work photo	Procedure of the work
5		Remove the tape attached to the joint of Spring Set.
6		Push Spring Set to the end and push into place.
7		<p>Insert Metal Chain Housing into the opposite end of Roller Pipe and push into place.</p> <p>(The photo shows a Roller Pipe which for product width(W) <math>\leq</math> 2,000 mm and the right operation type.)</p>
7		<p>(The photo shows a Roller Pipe G which for product width &gt; 2,000 mm and the right operation type.)</p>
8		<p>Cut the screen to the following dimensions:,  Width : product width (W) minus 36 mm (W - 36 mm)  Height : product height (H) plus 220 mm (H + 220 mm) (*2).</p> <p>(*2) Screen height is for reference only.</p> <p>TOSO sets the height of the screen based on the height that renders Roller Pipe invisible when the screen is lowered to the height of the product.</p>
9		<p>Prepare the processed Roller Pipe, Weight Bar, and Screen.</p> <p>For the right operation type, position Spring Set of the Roller Pipe to the right in front of you.</p>






No.	Work photo	Procedure of the work
10		Attach double-sided tape measuring 8 mm in width to the end part of the surface of the screen.
11		<p>Apply one side of double-sided tape measuring 20 mm in width to Roller Pipe.</p> <ul style="list-style-type: none"> <li>- For Roller Pipes for products width(W) <math>\leq 2,000</math> mm(photo) : attach by aligning the upper edge of the tape with the groove a quarter turn before the notch.</li> <li>- For Roller Pipes G for products width(W) &gt; 2,000mm : attach by aligning the upper edge of the tape to any of the grooves.</li> </ul>
12		<p>Set the end of the screen flush against the guide of nearest-side and set Magnet Spacer (*3) at two positions.</p> <p>(*3) The diameter of Magnet Spacer is 25 mm.</p>
13		<p>Remove the backing from the remaining side of the double-sided tape whose other side is already attached to Roller Pipe.</p> <p>Holding Roller Pipe with the exposed adhesive of the tape facing downward, press the tape and the pipe against the screen.</p> <p>Check to confirm that all parts are securely attached.</p>
14		Remove the backing from the double-sided tape whose other surface is already attached to the end part of the screen.
15		Attach the end part of the screen onto Roller Pipe.







No.	Work photo	Procedure of the work
16		Wind the screen around Roller Pipe.
17		When winding is complete, attach Bottom Inner Bar (*4) onto the end part of the rear surface of the screen.  (*4) Apply double-sided tape measuring 8 mm in width beforehand to Bottom Inner Bar.
18		Bend Bottom Inner Bar part toward the inside of the screen and insert into Weight bar.  
19		Insert Weight Bar all the way. Place caps at both ends of Weight Bar.
20		Insert the winder into Spring Set and rotate (*5) the screen in the correct screen-rolling direction.  (*5) Refer to the Spring Correspondence Table for the correct number of rotations.



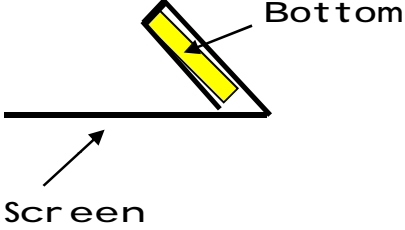


### Other note on the procedure

- Select the S or L type of Side Holder from the Side Holder Chart.

No.	Work photo	Procedure of the work
1		<p>Cut Roller Pipe to have a length equal to the product width (W) minus 31 mm (W - 31 mm).</p> <p>Cut Weight Bar to have a length equal to the product width (W) minus 30 mm (W - 30 mm).</p>
2		<p>Remove any chips from Roller Pipe, Weight Bar and Set Bar with a compressed air blower, cloth, or other appropriate device or material.</p>
3		<p>Prepare Spring Set (*1), Clutch and Speed Controller to assemble Spring Clutch Set.</p> <p>(*1) Refer to the Spring Chart for the appropriate spring set.</p>
4		<p>Insert Speed Controller into Clutch.</p>
5		<p>Connect Spring Set to Clutch with Speed Controller by Connect Pin.</p>
6		<p>Insert the Spring Clutch Set into Roller Pipe.</p>

No.	Work photo	Procedure of the work
7		Remove the tape attached to the joint of Spring Set.
8		Push Spring Set to the end and push into place.
9		Insert Pipe End into Roller Pipe.
10		<p>Cut the screen to the following dimensions:,  Width : product width (W) minus 31 mm (W - 31 mm)  Height : product height (H) plus 220 mm (H + 220 mm) (*2).</p> <p>(*2) Screen height is for reference only.</p> <p>TOSO sets the height of the screen based on the height that renders Roller Pipe invisible when the screen is lowered to the height of the product.</p>
11		<p>Prepare the processed Roller Pipe, Weight Bar, and Screen.</p> <p>For the right operation type, position Spring Set of the Roller Pipe to the right in front of you.</p>
12		Attach double-sided tape measuring 8 mm in width to the end part of the surface of the screen.

No.	Work photo	Procedure of the work
13		<p>Apply one side of double-sided tape measuring 20 mm in width to Roller Pipe.</p> <ul style="list-style-type: none"> <li>- For Roller Pipes for products width(W) <math>\leq</math> 2,000 mm(photo) : attach by aligning the upper edge of the tape with the groove a quarter turn before the notch.</li> <li>- For Roller Pipes G for products width(W) &gt; 2,000mm : attach by aligning the upper edge of the tape to any of the grooves.</li> </ul>
14		<p>Set the end of the screen flush against the guide of nearest-side and set Magnet Spacer (*3) at two positions.</p> <p>(*3) The diameter of Magnet Spacer is 25 mm.</p>
15		<p>Remove the backing from the remaining side of the double-sided tape whose other side is already attached to Roller Pipe.</p> <p>Holding Roller Pipe with the exposed adhesive of the tape facing downward, press the tape and the pipe against the screen.</p> <p>Check to confirm that all parts are securely attached.</p>
16		<p>Remove the backing from the double-sided tape whose other surface is already attached to the end part of the screen.</p>
17		<p>Attach the end part of the screen onto Roller Pipe.</p>
18		<p>Wind the screen around Roller Pipe.</p>

No.	Work photo	Procedure of the work
19		<p>When winding is complete, attach Bottom Inner Bar (*4) onto the end part of the rear surface of the screen.</p> <p>(*4) Apply double-sided tape measuring 8 mm in width beforehand to Bottom Inner Bar.</p>
20		<p>Bend Bottom Inner Bar part toward the inside of the screen and insert into Weight bar.</p> 
21		<p>Insert Weight Bar all the way. Place caps at both ends of Weight Bar.</p>
22		<p>Insert the winder into Spring Set and rotate (*5) the screen in the correct screen-rolling direction.</p> <p>(*5) Refer to the Spring Chart for the correct number of rotations.</p>

#### Other note on the procedure

- Select the S or L type of Side Holder from the Side Holder Chart.