

DEPARTMENT OF COMMERCE

BUREAU OF STANDARDS

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CIRCULAR OF THE BUREAU OF STANDARDS, No 368

[Issued July 27, 1928]

UNITED STATES GOVERNMENT MASTER SPECIFICATION
FOR SHADES, WINDOW; ROLLERS; SLATS; CORDS; AND
ACCESSORIES

FEDERAL SPECIFICATIONS BOARD SPECIFICATION No. 367b

[Revised May 22, 1928. Supersedes Part of F. S. B. No. 367a]

This specification was officially promulgated by the Federal Specifications Board on December 24, 1925, for the use of the departments and independent establishments of the Government in the purchase of window shades, rollers, slats, cords, and accessories.

[The technical requirements of this revision of this specification shall become mandatory for all departments and independent establishments of the Government not later than August 22, 1928. They may be put into effect, however, at any earlier date after promulgation]

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I. GENERAL SPECIFICATIONS

United States Government general specification for textile materials (methods of physical and chemical tests), Federal Specifications Board specification No. 345, in effect on date of invitation for bids, shall form part of this specification.

II. TYPES

The following types of materials are covered by this specification:

1. Rollers shall be furnished in two types, as follows: A, wooden rollers; B, metal rollers.
2. The cords shall be of one type only.
3. The slats shall be of one type only.
4. Window shades, complete.

III. MATERIAL AND WORKMANSHIP

1. WINDOW SHADES.—(a) The window shades shall be delivered mounted on the specified rollers and shall be complete with bottom hem, slat inserted, and cord with rustproof eyelet. The necessary bracket and screws shall also be supplied unless otherwise specified.

(b) *Mounting.*—Shades shall be made in a thoroughly workmanlike manner, cut square and true, and mounted on the roller in the same manner, using suitable substantial fasteners.

(c) *Construction of hem.*—The hem shall have ample width to include free inclosure of the slat. The hem shall be turned, sewed, and the edge backstitched or thread tied.

(d) *Construction of brackets, roller ferrules, and ends.*—The brackets, roller ferrules, and ends shall be of a grade known as standard of any one of the following: Malleable iron, coppered finish; stamped steel, nickered finish, or aluminum.

2. ROLLERS.—(a) The wooden roller, type A, shall be made of seasoned, straight-grained wood, and finished to a straight, smooth roller.

(b) The metal roller, type B, shall be of tinned metal of sufficient thickness and strength to minimize bending and damage.

3. CORD.—The cord shall be firmly and evenly braided and shall be free from an excessive number of imperfections of manufacture.

4. SLATS.—The slats shall be straight and of seasoned, straight-grained wood and of a smooth finish. They shall be free from knots, splits, shakes, and other imperfections.

IV. GENERAL REQUIREMENTS

See Detail requirements, Section V.

V. DETAIL REQUIREMENTS

1. ROLLERS.—(a) The necessary bracket and screws shall be included with the rollers, unless otherwise specified. The diameter of roller for the width and length of shade specified shall be as given in Table 1.

TABLE 1.—Roller diameter for width and length of shade cloth

Length of shade (feet)	Width of shade (Inches)				
	28 to 41	41 to 46	46 to 61	61 to 73	73 and over
	<i>Inches</i>	<i>Inches</i>	<i>Inches</i>	<i>Inches</i>	<i>Inches</i>
4 to 7, inclusive.....	1 1	1 1 ¹ / ₂	1 1 ¹ / ₂	2 1 ¹ / ₂	2 1 ³ / ₄
8 to 10, inclusive.....	1 1 ¹ / ₄	1 1 ¹ / ₄	2 1 ¹ / ₄	2 1 ¹ / ₂	2 1 ³ / ₄
11 to 12.....	1 1 ¹ / ₂	2 1 ¹ / ₂	2 1 ¹ / ₂	2 1 ¹ / ₂	2 1 ³ / ₄

¹ Mounted on wood roller.

² Mounted on metal roller.

(b) *Spring*.—The spring of the roller shall be adjustable for the tension required and shall catch readily at every turn of the roller, and shall release readily when properly handled. The spring length shown below shall be determined by the length when mounted on dowel. The minimum length of spring for the diameter of roller shall be as given in Table 2.

TABLE 2.—Minimum lengths of spring for diameter of rollers

Diameter of rollers (in inches)	Minimum length of spring	Minimum cross-sectional area of wire	Minimum number of pounds of wire per gross of springs
	<i>Inches</i>	<i>Square inch</i>	
1.....	9½	0.001430	13½
1½.....	12½	.001600	19½
1½ ¹	12½	.001890	23
1½ ²	13½	.002220	31
1½.....	13½	.002220	31
1¾.....	26	.003900	92

¹ Widths up to and including 49 inches.
² Widths above 49 inches.

2. **CORDS**.—The color of the cord shall be as specified. The minimum breaking strength shall be 30 pounds. The cord shall be approximately one-eighth inch in diameter and put up in hanks of approximately 48 feet to the hank.

3. **SLATS**.—The width shall be either seven-eighths inch (approximately), or 1¼ inches (approximately), as specified in the invitation for bids, for slats up to and including 54 inches; for slat lengths from 54 to 72 inches the width shall be 1¼ inches (approximately); above 72 inches the width shall be 1¾ inches (approximately). The cross section shall be that of commercial practice, and the length shall be as specified within a tolerance of plus or minus one-eighth inch.

4. **WINDOW SHADES, COMPLETE**.—(a) *Length of shade*.—The length of the shade shall be the 6-inch step between 3 feet and 12 feet, as specified, and shall be the finished length after hemming.

(b) *Width of shade*.—The width specified shall be considered the average width and shall come within the tolerance specified in Table 4. Table 3 shows commercial standard widths (see notes, Section VIII, 2).

TABLE 3.—Commercial standard widths for window shades

Type	Width (in inches)															
	28	30	32	36	38	40	42	44	45	48	54	58	63	72	82	
Translucent cambric.....				36	38		42		45	48	54	58		63	72	82
Opaque cambric.....					38		42		45	48	54	58		63	72	82
Holland.....	28	30	32	36	38	40	42	44		48	54		60		72	82
Pyroxylin.....				36	38		42		45	48	54			63	72	

TABLE 4.—*Tolerance for width*

Width (in inches)	Tolerance	
	Plus	Minus
To 38 inclusive.....	$\frac{3}{8}$	$\frac{3}{8}$
38 to and including 60.....	$\frac{1}{2}$	$\frac{1}{2}$
Over 60.....	1	1

(c) *Cord with shade*.—Unless otherwise specified, the cord shall be furnished with each shade at least equal to the length of the shade. The color of the cord shall match the shade. The cord shall conform in other respects with the requirements of Section V, 2. Stop or catch pulley shall be furnished if specified.

(d) *Slat with shade*.—Unless otherwise specified, the width of the slat shall be approximately seven-eighths inch for shades up to and including 45 inches and approximately $1\frac{1}{4}$ inches for shades over 45 inches. The slat shall conform in other respects with Section V, 3.

(e) *Roller with shade*.—The roller shall conform to requirements given in Section VI, 1.

(f) The supplier shall cut cloth for the shades on the following basis: The shade cloth shall cover practically the entire barrel of the roller when shades are hung between the jambs with inside fixtures; and when for hanging on the face of window casing a margin of not over three-eighths of an inch shall be allowed on each end of the roller.

5. The completed shade shall be individually wrapped with a protective covering which can be utilized as an aid to keep the shade clean during installation. There shall be printed instructions on each cover telling how the installation shall be made.

6. Each shade shall be marked to designate its size and bear a label to show the brand and name of the original manufacturer.

7. Each roller shall be marked to designate its size and bear a label to show the brand and name of the original manufacturer.

VI. METHODS OF SAMPLING AND TEST

1. **SLATS AND ROLLERS**.—At least one or two samples of slats and of rollers shall be taken from each shipment for inspection.

2. **CORD**.—At least 2 yards of cord shall be taken from each shipment for test purposes.

3. **WINDOW SHADES**.—At least one complete window shade from each shipment shall be taken for test purposes. Checks on dimensions may be made throughout the shipment, as necessary.

VII. PACKING AND MARKING OF SHIPMENTS

Shall be in accordance with the best commercial practice unless otherwise specified.

VIII. NOTES

1. The invitation for bids and order should state for:

(a) *Rollers*.—The type, diameter, and length, and whether or not inside or outside brackets are required.

(b) *Cords*.—The color and length.

(c) *Slats*.—The width and length.

(d) *Window shades*.—State type, color, width, length, whether or not inside, outside brackets, or other types of brackets are required; and whether cords or pulls are desired. Also over-all measurements between brackets shall be stated. When outside brackets are specified, width of cloth desired should be stated. When inside brackets are specified, manufacturers will make the necessary one-fourth inch deduction from the over-all dimensions furnished to allow for free play of the shade between brackets. All shades should be ordered 12 inches longer than the window opening.

2. It is customary trade practice when an intermediate width is specified to charge at the rate of the next larger width, for example, if a 46 inch width is specified, the rate is on the basis of the 48 inch width.

3. To avoid any misunderstanding, it should be noted by the purchaser that the colors do not correspond for translucent cambric, opaque cambric, holland cloth, and pyroxylin; for example, dark green cambric cloth is different from dark green holland cloth.

4. Window shades of greater width and length than that given in the tables should be purchased with such fixtures as rollers, slats, etc., of larger dimensions to insure maximum service.

5. Opaque cambric shade cloth should not be confused with opaque shade cloth which has a lower thread count and which is not included in this specification.

6. SHADE CLOTH MATERIAL.—United States Government master specification for shade cloth is covered by Federal Specifications board specification No. 555b, or latest revision thereof.

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