

**Pantanet® Family****1. Scope :**

Pantanet® Family is the brand name for a spot-welded mesh made out of galvanized low carbon steel wires and subsequently PVC-coated.

The mesh is bounded by a double selvedge and the line wires are crimped in the middle of each mesh.

see fig. 1

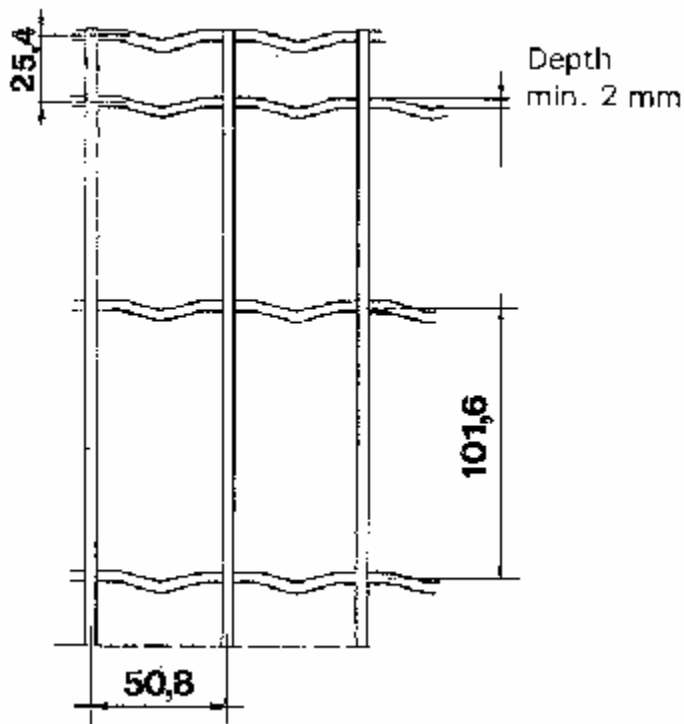


Fig 1

**1.1. Normative references**

- EN 10016-2: Non-alloy steel rod for drawing and/or for cold rolling
- EN 10218-2: Steel wire and wire products - General - Part 2: Wire dimensions and tolerances
- EN 10223-4: Steel wire and wire products for fences - Part 4: Steel wire welded mesh fencing
- EN 10244-2: Steel wire and wire products - Non-ferrous metallic coatings on steel wire - Part 2: Zinc or zinc-alloy coatings on steel wire

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### 1.2. Definitions

- nominal wire diameter: the diameter in mm to designate the wire
- real wire diameter: the average value of the minimal and the maximal diameter, measured in the same section of a straight piece of wire, by means of a micrometer to 0,01mm
- mesh sizes: see fig 1  
the meshes are measured from centre to centre of the wires.
- line wires: the wires running in the longitudinal direction of the mesh
- cross wires: the wires running in the traverse direction of the mesh

## 2. Raw material

### 2.1. Wire rod: see table 1

Element	%
C	≤ 0,10
Si	≤ 0,30
Mn	≤ 0,60
P	< 0,035
S	< 0,035

The chemical composition is in accordance with EN 10 016-2 .The designation of the wire rod is C9D

### 2.2. Zinc

Minimum 99,5% of pure zinc is used for galvanising

### 2.3. PVC

The PVC is free of cadmium,  
colour: Betafence green 6073

## 3. Requirements

### 3.1. Wire diameters and tolerances see table 2

Nominal wire diameter mm		application	Min. mass of Zinc g/m <sup>2</sup>	Tensile strength N/mm <sup>2</sup>
Core wire	PVC-coated wire			
2,00±0,09	2,50±0,15	Line wire	25	400 to 550
2,00±0,09	2,50±0,15	Cross wire	25	700 to 900

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### 3.2. Mesh sizes and tolerances

- spacing of the line wires: see fig 1 and table 3  
tolerance: +/- 3,0 mm

Table 3 spacing of the line wires		
height (mm)	number of line wires	Spacing (from bottom up) mm
610 mm	9	1x25,4 + 1x76,2 + 4x101,6 + 1x76,2 + 1x25,4
813	11	1x25,4 + 1x76,2 + 6x101,6 + 1x76,2 + 1x25,4
1016	13	1x25,4 + 1x76,2 + 8x101,6 + 1x76,2 + 1x25,4
1219	15	1x25,4 + 1x76,2 + 10x101,6 + 1x76,2 + 1x25,4
1524	18	1x25,4 + 1x76,2 + 13x101,6 + 1x76,2 + 1x25,4
1829	21	1x25,4 + 1x76,2 + 16x101,6 + 1x76,2 + 1x25,4
2032	23	1x25,4 + 1x76,2 + 18x101,6 + 1x76,2 + 1x25,4

- spacing of cross wires: 50,8mm  
tolerance: +/- 3,0 mm

### 3.3. Tensile strength of the wires

- line wire 400 to 550 N/mm<sup>2</sup>
- cross wire 700 to 900 N/mm<sup>2</sup>

### 3.4. Weld shear strength

The average shear strength of 4 welds selected at random in 1 roll shall be not less than 75% of the breaking load of the line wire.

### 3.5. PVC-coating

The PVC-coating is fused and adhered to a primer that is cured onto the galvanised core wire, thus achieving an excellent bond between wire and PVC

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#### **4. Form of delivery**

##### 4.1. Roll length

10 and 25m, see also table 4

##### 4.2. Height of the mesh

see table 3, tolerance  $\pm 5$ mm

##### 4.3. Inside diameter of the roll

About 150 mm

##### 4.4. Outside diameter of the roll

- 25m rolls: about 36,5mm
- 10m rolls: about 26mm

##### 4.5. Packing

Roll, packed in either shrink-or stretchfoil, are forwarded on either one-way pallets of 1200 x 1000 x 145mm, 1000 x 1000 x 145mm (only for the Italian market) or on Euro-pallets of 1200 x 800 x 145mm. The pallets and bundles are stretch wrapped to form a firm unit.

Number of rolls per pallet:

- One-way pallets:
  - 25m rolls: 9 rolls
  - 10m rolls: 23 rolls
- Euro pallets
  - 25m rolls: 9 rolls
  - 10m rolls: not available

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