Pantanet® Protect

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

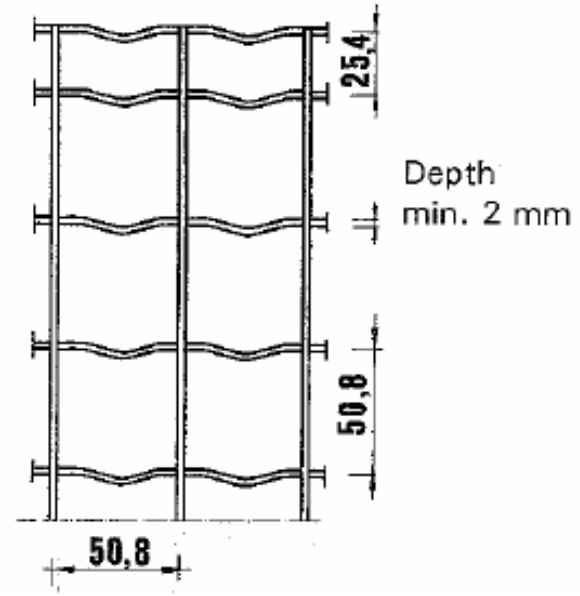

Fig 1

1.1. Normative references

- EN 10016-2:Non-alloy steel rod for drawing and/or for cod 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

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

Table 1: Chemical composition	
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

Table 2 : Wire properties				
Nominal wire diameter mm		application	Min. mass of Zinc g/m²	Tensile strength N/mm²
Core wire	PVC-coated wire			
2,00±0,09 1,80±0,09	2,50±0,15 2,20±0,15	Line wire Cross wire	25 25	400 to 550 700 to 900

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
1016	22	1x25,4 + 19x50,8 + 1x25,4
1219	26	1x25,4 + 23x50,8 + 1x25,4
1524	32	1x25,4 + 29x50,8 + 1x25,4
1829	38	1x25,4 + 35x50,8 + 1x25,4
2032	42	1x25,4 + 39x50,8 + 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/mm²
- cross wire 700 to 900 N/mm²

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

4. Form of delivery

4.1. Roll length

25m, see also table 4

4.2. Height of the mesh

see table 3, tolerance ± 5mm

4.3. Inside diameter of the roll

About 150 mm

4.4. Outside diameter of the roll

25m rolls: about 36,5mm

4.5. Packing

Roll, packed in either shrink-or strechfoil, are forwarded on either one-way pallets of 1200 x 1000 x 145mm. The pallets and rolls are stretch wrapped to firm a firm unit.
Number of rolls per pallet: 9 rolls
Under the last layer of each roll a coloured paper label is positioned, stating:

- height (m),
- length (m),
- mesh sizes (mm),
- bar code