

Technical Data Sheet
TDS-04-23

Nylofor[®] 2D and Nylofor[®] 2D Super (Hot Dip Galvanized)

1 Scope

This technical data sheet specifies requirements for steel wire welded and subsequently hot dip galvanized mesh panels for fencing.

The panel is reinforced by means of a horizontal double round wire at both sides of the vertical one. (See Picture 1)



Picture 1

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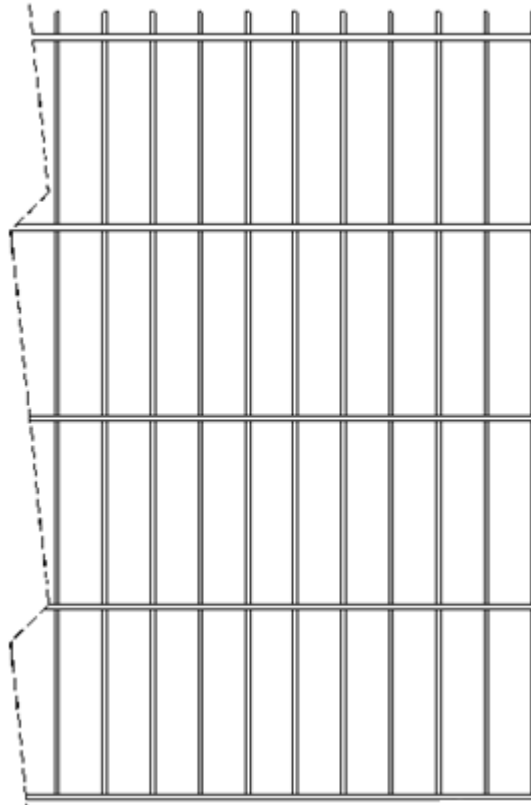


Figure 1

1.1 Normative references

- ISO 16120-2: Non-alloy steel wire rod for conversion to wire - Part 2: Specific requirements for general purpose wire rod.
- ISO 22034-2: Steel wire and wire products - Part 2: Tolerances on wire dimensions.
- EN 10223-7: Steel wire and wire products for fences, Part 7: Steel wire welded panels for fencing.
- ISO 1461: Hot dip galvanized coatings on fabricated iron and steel articles – Specifications and test methods.

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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 accurate to 0,01 mm.
- Mesh sizes: The distance measured between the centres of two neighbouring 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	≤ 0,70
P	< 0,035
S	< 0,035

The designation of the wire rod is based on grade C9D or C7D – ISO 16120-2.

2.2 Zinc used for hot dip galvanizing bath

The ingots are in accordance with ISO 1461.

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3 Properties

3.1 Wire diameter and tolerances (before hot dip galvanizing)

See table 2:

Table 2: Wire diameters and tolerances (Before galvanizing)		
	Horizontal wire (mm)	Vertical wire (mm)
Nylofor [®] 2D HDG	5,50 ± 0,05	4,50 ± 0,05
Nylofor [®] 2D Super HDG	7,50 ± 0,06	5,50 ± 0,05

The tolerances in accordance with ISO 22034-2, T3.

3.2 Tensile strength of the wire

Vertical and horizontal wires: Min. 500 N/mm².

3.3 Mesh sizes and tolerances

See table 3:

Table 3 : Mesh sizes and tolerances		
Mesh sizes (mm)	Nylofor [®] 2D	Nylofor [®] 2D Super
Distance between the horizontal wires	200 ± 4,0 mm	200 ± 4,0 mm
Distance between the vertical wires	50 ± 3,0 mm	50 ± 3,0 mm

The tolerances are in accordance with the European standard EN 10223-7.

3.4 Weld shear strength

Weld shear strength is tested on four welds selected at random from one transverse wire of the panel.

The minimum average weld shear strength value meets the required 50% of the breaking strength of the wire as per EN 10223-7.

3.5 Barbs

Nylofor[®] 2D and 2D super panels have a barb of 30 mm ± 2 mm at the topside of the panel.
(See figure 1.)

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3.6 Overhangs

The overhang of the horizontal wires shall be not more than 3 mm.
The short overhang of the vertical wires is max. 2 mm.

3.7 Dimensions of the Panels

Overall height of the panels: See table 4 and 5.

Tolerance on the height: ± 2 mm.

Width of the panel: 2500 mm ± 3 mm.

4 Coating

4.1 Metallic Coating

After welding the Nylofor[®] 2D and 2D super panels are hot dip galvanized.

The mean zinc coating thickness shall be: Min 70 μm (505 g/m²), average of 10 measurements done on 1 panel.

5 Form of delivery

Panels are delivered on a wooden pallet, protected by shrink foil.

Number of panels per pallet: See table 4 and 5.

A label is stuck on the pallet stating mesh size, width and height of the panel.

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Table 4 : Form of delivery Nylofor® 2D

Mesh size: 200 x 50

Overall height of the panel with barb (mm)	Height of the panel without barb (Measured C-C) (mm)	Number of panels per pallet	Sapcode HDG
630	600	30	4012540
830	800	30	4012541
1030	1000	30	4011961
1230	1200	30	4011962
1430	1400	30	4011963
1630	1600	30	4011964
1830	1800	30	4011965
2030	2000	30	4011966
2230	2200	30	4012542
2430	2400	30	4012543

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(Hot Dip Galvanized)**Table 5 : Form of delivery Nylofor® 2D Super****Mesh size: 200 x 50**

Overall height of the panel with barb (mm)	Height of the panel without barb (Measured C-C) (mm)	Number of panels per pallet	Sapcode HDG
630	600	25	4000019
830	800	25	4000012
1030	1000	25	4000013
1230	1200	25	4000014
1430	1400	25	4000015
1630	1600	25	4000016
1830	1800	25	4000017
2030	2000	25	4000018
2230	2200	25	4001863
2430	2400	25	4000020

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