



**MASTER
HALCO®**

SPECTRA POLY (VINYL CHLORIDE) (PVC) COATED STEEL CHAIN LINK FENCE FABRIC

Class 1 - Extruded

ASTM F668, Federal Specification RR-F-191/1E Type IV, AASHTO M-181 Type IV, Class A

Product Name: Extruded Poly(Vinyl Chloride) PVC Coated Steel Chain Link Fence Fabric.

Basic Use: Extruded PVC coated fabric is a PVC coated, high strength galvanized steel chain link fence fabric for industrial, commercial and institutional applications. Extruded Fabric is contained in local, state and federal government specifications for use in prison, road, dock, airport, housing, forestry, and military use.

Composition and Material: The galvanized steel core wire for producing extruded PVC coated steel chain link fence fabric is produced by cold-drawing good commercial grade steel rod into wire of the appropriate diameter. The steel rod from which the wire is drawn is produced by the open hearth, electric furnace or basic oxygen process. The galvanized coating is produced by passing the cleaned wire through a bath of molten zinc which conforms to ASTM B6. The extruded PVC coating is produced by extruding PVC at a coating thickness of 0.015" (.38mm) - 0.025" (0.64 mm) over a galvanized core wire.

Standards:

ASTM B6 – Slab Zinc

ASTM F567 – Installation of Chain Link Fence

ASTM F668 – Poly(Vinyl Chloride) (PVC) and Other Organic Polymer-Coated Steel Chain Link Fence Fabric, Class 1
Federal Specification RR-F-191K/1E – Fencing, Wire, and Post Metal (Chain Link Fence Fabric), Type IV

AASHTO M-181 – Chain Link Fence, Type IV, Class A

Technical Data:

General: The manufacturer, if requested, will supply samples and certification that all materials furnished comply with the appropriate specifications.

Chain Link Fence Fabric: The base metal of the chain link fence fabric is composed of commercial quality, medium carbon galvanized (zinc coated) steel wire. The vinyl coating is continuously applied over the galvanized wire by the extrusion process. The extrusion process ensures a dense and impervious coating free of voids, as well as a smooth and lustrous surface appearance. Vinyl coating thickness, galvanized coating weight, and wire tensile strength conform to ASTM F668, Class 1, Federal Specification RR-F-191/1E Type IV, and AASHTO M-181 Type IV, Class A, as shown in table 1. The wire is PVC coated before weaving and is free and flexible at all joints. Unless otherwise specified, fabric woven in 2" (50 mm) mesh, under 72" (1,830 mm) in height, is knuckled at both selvages; fabric 72" (1,830 mm) high and over is knuckled at one end and twisted at the other. All fabrics woven into meshes under 2" (50 mm) have both selvages knuckled. See Table II.

Wire Coating: Only plasticized poly(vinyl chloride) (PVC) with a low temperature (-20 C ; -4 C) plasticizer and no extenders or extraneous matter other than the necessary stabilizers and pigments, is used. The PVC coatings resists attack from prolonged exposure to dilute solutions most common mineral acids, seawater, and dilute solutions of most salts and alkali. See Table II.

Installation: Install fence in accordance with ASTM Practice 567. Handle all PVC coated material with care. If PVC coating is damaged during installation, contractor must replace or repair the material at own expense.

Maintenance: Periodic inspection is recommended but no routine maintenance is required.

SPECTRA POLY (VINYL CHLORIDE) (PVC) COATED STEEL CHAIN LINK FENCE FABRIC

EXTRUDED

ASTM F668 Class 1, Federal Specification RR-F-191/1E Type IV, AASHTO M-181 Type IV, Class A

Table 1 - PVC Coated Steel Wire Characteristics

Zinc Coated Core Wire Size			PVC Coated Finished Wire Size	PVC Coated Wire Allowable Variance		Core Wire Zinc Coating Weight, min.		PVC Coating Thickness		Breaking Strength, minimum		Tensile Strength, min	
Gage	Inch	mm	Gage	Inch	mm	Oz/ft ²	g/m ²	Inch	mm	lbf	Newtons	ksi	MPa
9	0.148	3.76	6	±0.005	±0.13	0.30	92	0.015 to 0.025	0.38 to 0.64	1,290	5,740	75	515
11	0.120	3.05	8	±0.005	±0.13	0.30	92			850	3,780	75	515
14	0.080	2.03	11	±0.005	±0.13	0.25	76			380	1,690	75	515

Table 2 - PVC Coated Chain Link Fabric Recommended Uses

Mesh Sizes Available	Nominal Core Wire Size	Nominal Finish Wire Size	Selvage**	Recommended Use	Standard Heights of Fence Fabric
inch	gauge	gauge			inch
2"	13	9	KK, KT, TT	Residential	36" - 144"
2"	11	8	KK, KT, TT	Heavy Residential/Light Commercial	36" - 144"
2"	9	6	KK, KT, TT	Commercial, Industrial	36" - 144"
1-3/4"	13	9	KK, KT, TT	Residential	36" - 144"
1-3/4"	11	8	KK	Tennis Court	120" - 144"
1-3/4"	9	6	KK	Heavy Commercial, Industrial	120" - 144"
1-1/4"	14	11	KK	Residential, Swimming Pool	36" - 144"
1-1/4"	13	9	KK	Residential, Swimming Pool	36" - 144"
1-1/4"	9	6	KK	Heavy Commercial, Industrial	36" - 144"
1"	14	11	KK	Heavy Industrial, Security	36" - 144"
1"	13	9	KK	Heavy Industrial, Security	36" - 144"
1"	11	8	KK	Heavy Industrial, Security	36" - 144"
1"	9	6	KK	Security	36" - 144"
3/4"	14, 13, 11	11, 9, 8	KK	Heavy Security, Anti-Climb	36" - 144"
5/8"	14, 11	11, 8	KK		36" - 144"
1/2"	14, 13, 11	11, 9, 8	KK		36" - 144"
3/8"	13, 11	9, 8	KK		36" - 144"

**Selvage KK - Knuckle top and bottom
 TT - Twist top and bottom
 KT - Twist top and Knuckle bottom

Table 3 - Typical Vinyl Properties

Test	Test Method	Value
Specific Gravity	ASTM D 792	1.30 ± 0.03
Hardness, Durometer	ASTM D 2240	A90 ± 5
Tensile Strength	ASTM D 412	2,600 ± 5%
Ultimate Elongation	ASTM D 412	275% ± 5%
Mandrel Bend Test, 10X mandrel	ASTM D 668	-20° F (-29° C)
Dielectric Strength, volt/mil	ASTM D 149	750
Compression cut-through, lbs	BELL LABS	1,500
Accelerated Aging Test	ASTM D 1499	1,500 hrs @ 145° F