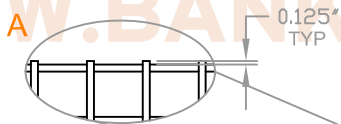


# WELDED MESH PANELS: MEASUREMENTS & TOLERANCES

WELDED MESH IS A HEAT INDUCED PRODUCT. THE HEAT REQUIRED TO PRODUCE THIS MESH AFFECTS MEASURABLE QUANTITIES SUCH AS LENGTH, FLATNESS, AND TAIL LENGTHS. DUE TO A LACK OF ASTM STANDARDS FOR WELDED MESH, THE FOLLOWING TOLERANCES HAVE BEEN DEVELOPED AT BANKER WIRE FROM TESTING AND FROM HISTORICAL PRODUCT. BANKER WIRE IS CONTINUALLY DEVELOPING AND IMPROVING THESE STANDARD TOLERANCES.

- TAILS (SEE "A"):**
- TYPICAL TOLERANCE FOR TAIL LENGTH IS +/- .125"
  - FOR UNTRIMMED MATERIAL, TAILS WILL BE BALANCED WITHIN +/- .125"
  - FOR TRIMMED MATERIAL, THERE WILL TYPICALLY BE .125" TAILS/NUBS ON SIDES 1, 2, AND 3
  - CROSS WIRE TAILS (TAILS ON SIDES 1 AND 3) WILL BE EVEN WITHIN +/- .125"



- BOWING (SEE "B"):**
- ON TIGHTER MESH (TYPICALLY 2" MESH OR LESS), AND LARGER DIAMETER MESH, THE FIRST SEVERAL CROSS WIRES FROM SIDE 2 MAY BE BOWED SLIGHTLY
  - THIS IS BECAUSE OF THE HEAT REQUIRED TO MAKE THIS WELDED PRODUCT

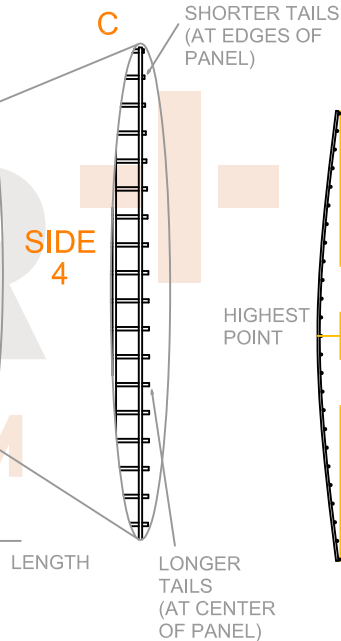


BOWING ON THE CW'S AT THE BEGINNING OF THE MESH ON SIDE 2 OF THE PANEL

(THE CW'S SLOWLY TRANSITION FROM BOWED TO STRAIGHT GOING FROM SIDE 2 TO SIDE 4 OF THE MESH

**SIDE 3**

WIDTH



**SIDE 4**

LENGTH

LONGER TAILS (AT CENTER OF PANEL)

SHORTER TAILS (AT EDGES OF PANEL)

**D**

HIGHEST POINT

- FLATNESS (SEE "D"):**
- FLATNESS IS DETERMINED BY MEASURING THE HIGHEST POINT ON THE MESH WHEN IT IS PLACED ON THE GROUND
  - DUE TO HEAT, SOME MATERIAL MAY BE BOWED
  - THIS RARELY HAPPENS FOR MORE OPEN MESH, BUT GETS WORSE FOR TIGHTER MESH (2" MESH OR LESS)
  - MOST BOWED MESH CAN BE FLATTENED BY APPLYING PRESSURE (MESH IS FLEXIBLE)

**"THUMBNAILING" (SEE "C"):**

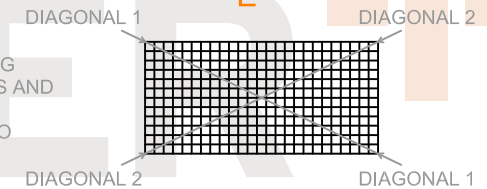
- THUMBNAILING MEANS THAT ON SIDE 4 OF THE MESH, THE SIDE COMING OFF OF THE WELDER LAST, THE TAILS WILL BE SHORT ON THE EDGES BUT LONGER IN THE MIDDLE
- THE TAILS ON THE EDGES OF SIDE 4 ARE TYPICALLY THE SAME LENGTH AS THE TAILS ON THE OTHER 3 SIDES OF THE MESH
- THE TAILS IN THE MIDDLE OF SIDE 4 MAY BE UP TO .5" LONGER THAN THE REST OF THE TAILS
- THIS IS DUE TO THE HEAT REQUIRED TO MAKE THIS WELDED PRODUCT
- THUMBNAILING IS MORE APPARENT AS THE MESH GETS TIGHTER AND THE DIAMETER GETS LARGER

**SIDE 1**

- WIDTH:**
- THE WIDTH OF THE FINISHED PANEL IS ACCURATE TO WITHIN +/- .125"
- LENGTH:**
- THE LENGTH OF EACH OF THE LONG WIRES IS ACCURATE TO WITHIN +/- .125"
  - HOWEVER, DUE TO THUMBNAILING, THE OVERALL LENGTH OF A TIGHTER MESH PANEL (TYPICALLY 2" MESH OR LESS) MAY BE UP TO .625" GREATER THAN NOMINAL BECAUSE THE MIDDLE LW'S SHIFT AS THE PANEL COOLS (CAUSING THE BOWED CW'S AND LONGER LW TAILS IN THE MIDDLE OF THE PANEL)

**SQUARENESS (SEE "E"):**

- SQUARENESS OF A PANEL IS DETERMINED BY MEASURING THE CORNER-TO-CORNER DISTANCE IN BOTH DIRECTIONS AND FINDING THE DIFFERENCE BETWEEN THE TWO LENGTHS
- THE SQUARENESS OF A FINISHED PANEL IS ACCURATE TO WITHIN +/- .25"



- PITCH/SPACING:**
- THE SPACING TOLERANCE ON THE PLACEMENT OF EACH WIRE WILL BE +/- .063" OF THE NOMINAL PITCH
  - THIS APPLIES IN BOTH DIRECTIONS (LENGTH AND WIDTH)
  - EDGE WIRE SPACING MAY VARY FROM PANEL SPACING TO ACCOMMODATE THE OVERALL SIZE, DEPENDING ON TRIMMED/UNTRIMMED CONDITION