



Standard Specification for Zinc-Coated Steel Chain-Link Fence Fabric¹

This standard is issued under the fixed designation A 392; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope

1.1 This specification covers zinc-coated steel chain-link fence fabric, zinc coated either before or after weaving.

1.2 The values stated in inch-pound units are to be regarded as the standard.

2. Referenced Documents

2.1 ASTM Standards:

A 90 Test Method for Weight of Coating on Zinc-Coated (Galvanized) Iron or Steel Articles²

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³

A 700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment⁴

A 817 Specification for Metallic-Coated Steel Wire for Chain Link Fence Fabric²

B 6 Specification for Zinc (Slab Zinc)⁵

2.2 Federal Standard:

Fed. Std. No. 123 Marking for Shipments (Civil Agencies)⁶

2.3 Military Standards:

MIL-STD-129 Marking for Shipment and Storage⁶

MIL-STD 163 Steel Mill Products, Preparation for Shipment and Storage⁶

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *chain-link fence fabric*—a fencing material made from steel wire helically wound and interwoven in such a manner as to provide a continuous mesh without knots or ties except in the form of knuckling or of twisting the ends of the wires to form the selvage of the fabric.

3.1.2 *diamond count*—the number of diamond openings from one edge of the fabric to the other. The diamond count of a given fabric shall begin at the first completed diamond at one

edge and continue to the unfinished ($\frac{1}{2}$) or full opening at the other edge.

3.1.3 *knuckling*—the type of selvage obtained by interlocking adjacent pairs of wire ends and then bending the wire ends back into a loop. The loop shall be closed or nearly closed to a measurement less than the diameter of the wire.

3.1.4 *twisting*—the type of selvage obtained by twisting adjacent pairs of wire ends together in a close helix of $1\frac{1}{2}$ machine turns, which is equivalent to 3 full twists, and cutting the wire ends at an angle. The wire ends beyond the twist shall be at least $\frac{1}{4}$ in. (6.4 mm) long. This type of selvage is not used on fabric with a mesh size of less than 2 in. (50.8 mm).

4. Ordering Information

4.1 Orders for chain-link fence fabric purchased to this specification shall include the following information:

4.1.1 Quantity (Section 14),

4.1.2 Zinc coated after weaving or before weaving (Section 5),

4.1.3 Size of mesh (Section 7),

4.1.4 Size of wire (Section 8),

4.1.5 Height of fabric (Section 9),

4.1.6 Diamond count, if specified (Section 6),

4.1.7 Type of selvage (Section 10),

4.1.8 Class of coating (Section 11),

4.1.9 ASTM designation and year of issue, and

4.1.10 Certification if required (Section 17).

4.2 All rolls of fencing accepted by the purchaser shall be billed on the basis of the original footage of the rolls before sampling, unless changed by contractual arrangement.

NOTE 1—A typical ordering description is as follows: 25 rolls, 50 ft each, chain-link fence fabric, zinc coated after weaving, 2-in. mesh, 0.148-in. wire, 60 in. high, knuckled both selvages, Class 2 coating to ASTM A—392–XX.

5. Materials

5.1 If zinc-coated before weaving, the wire from which the fabric is woven shall conform to all requirements of Specification A 817 for Type II coating, in the class of coating specified (Class 1 or Class 2).

5.2 If zinc-coated after weaving, the base metal shall be steel of such quality and purity that, when drawn to the size of wire specified and coated with zinc after fabrication, the

¹ This specification is under the jurisdiction of ASTM Committee F-14 on Fences and is the direct responsibility of Subcommittee F14.40 on Chain Link Fabric and Wire Accessories.

Current edition approved July 10, 1996. Published September 1996. Originally published as A 392 – 55 T. Last previous edition A 392 – 91b¹.

² Annual Book of ASTM Standards, Vol 01.06.

³ Annual Book of ASTM Standards, Vol 01.03.

⁴ Annual Book of ASTM Standards, Vol 01.05.

⁵ Annual Book of ASTM Standards, Vol 02.04.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

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finished fencing shall be of uniform quality and have the properties and characteristics as prescribed in this specification.

5.3 *Zinc for Coating*—The slab zinc, when used for the coating, shall be any grade of zinc conforming to Specification B 6.

6. Weave

6.1 The wire shall be woven throughout in the form of approximately uniform square mesh, having parallel sides and horizontal and vertical diagonals of approximately uniform dimensions. The top and bottom of the fabric shall be knuckled or twisted as specified in Section 10.

6.2 A typical diamond count for each standard height is shown in Table 1. Other diamond counts are permissible provided that they are consistent within a lot. The purchaser has the option to specify the diamond count (see 4.1.6).

7. Size of Mesh

7.1 The size of mesh shall be as indicated in Table 2.

7.2 The permissible variation from the specified size of mesh shall be $\pm 1/8$ in. (3.2 mm) for all mesh sizes except 1 in., and $\pm 1/16$ in. (± 1.6 mm) for 1 in. mesh size.

7.3 The size of mesh shall be determined by measuring the minimum clear distance between the wires forming the parallel sides of the mesh, and determined as the average of two readings taken at right angles to each other.

8. Size of Wire

8.1 Chain-link fabric shall be fabricated from wire diameters as listed in Specification A 817, with a permissible variation from the specified diameter of the coated wire of ± 0.005 in. (0.13 mm).

9. Height of Fabric

9.1 Chain-link fabric shall be furnished in the standard heights shown in Table 2. Custom order fabric is available in heights to and including 20 ft. (6.56 m). The height of fabric shall be the overall dimension from ends of twists or knuckles. Permissible variation from the specified height shall be ± 1 in. (25 mm) for standard selvage.

10. Selvage

10.1 Unless otherwise specified by the purchaser, fabrics with 2 or $2\frac{1}{8}$ in. (50 or 54 mm) mesh, in heights 60 in. (1520

TABLE 2 Sizes of Wire and Mesh^A

Note 1— For fabrics heights over 144 in., see 9.1.

| Specified Diameter of Coated Wire, in. | Size, Coated Wire Gage | Size of Mesh, in. | Height of Fence Fabric, in. | | | | | | | | | |
|--|------------------------|-------------------|-----------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | | | 36 | 42 | 48 | 60 | 72 | 84 | 96 | 108 | 120 | 144 |
| 0.192 | 6 | 2 | 36 | 42 | 48 | 60 | 72 | 84 | 96 | 108 | 120 | 144 |
| 0.148 | 9 | 2 | 36 | 42 | 48 | 60 | 72 | 84 | 96 | 108 | 120 | 144 |
| 0.148 | 9 | 1 | 36 | 42 | 48 | 60 | 72 | 84 | 96 | 108 | 120 | 144 |
| 0.120 | 11 | 2 | 36 | 42 | 48 | 60 | 72 | 84 | ... | ... | ... | ... |
| 0.120 | 11 | 1 3/4 | ... | ... | ... | ... | ... | ... | 96 | 108 | 120 | 144 |
| 0.120 | 11 | 1 | 36 | 42 | 48 | 60 | 72 | 84 | 96 | 108 | 120 | 144 |
| 0.113 | 11 1/2 | 2 1/8 | 36 | 42 | 48 | 60 | 72 | ... | ... | ... | ... | ... |

^ASee Appendix X1 for metric equivalents.

mm) and under shall be knuckled at both selvages. Fabric 72 in. (1830 mm) high and over shall be knuckled at one selvage and twisted at the other.

10.2 The selvages of fabrics with meshes of less than 2 in. (50 mm) shall be knuckled.

10.3 **Caution:** Twisted selvages for fence fabric under 72 in. (1830 mm) in height are not recommended because of consumer safety considerations.

11. Weight of Zinc Coating

11.1 The weight of zinc coating on the fabric may be ordered in two coating weight classes as follows:

11.1.1 *Class 1*—The weight of zinc coating shall not be less than 1.2 oz/ft²(366 g/m²) of uncoated wire surface.

11.1.2 *Class 2*—The weight of zinc coating shall not be less than 2 oz/ft²(610 g/m²) of uncoated wire surface, on wire of fabric coated before weaving. On fabric coated after weaving, the weight of zinc coating shall be not less than 2.0 oz/ft²(610 g/m²) of uncoated wire surface as determined from the average of two or more specimens, and not less than 1.8 oz/ft² (500 g/m²) of uncoated wire surface for any individual specimen.

NOTE 2—Fabric galvanized after fabrication is normally not produced with a Class 2 coating on 0.120-in. (3.05-mm) or 0.113-in. (2.87-mm) wire.

11.2 On fabric galvanized after weaving, the weight of coating shall be determined on one or more pieces of wire removed from the fabric. These specimens may be of any length over 12 in. (300 mm) and shall include both bends and straight sections, but shall not include either twists or knuckles.

TABLE 1 Typical Diamond Count^A

Note 1—Other diamond counts are permitted (see 6.2.)

Note 2— For fabric heights over 144 in., see 6.2

| Nominal Diameter Coated Wire, in. | Size of Mesh, in. | Height of Fence Fabric, in. | | | | | | | | | |
|-----------------------------------|-------------------|-----------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| | | 36 | 42 | 48 | 60 | 72 | 84 | 96 | 108 | 120 | 144 |
| 0.192 | 2 | 10 1/2 | 12 1/2 | 13 1/2 | 17 1/2 | 20 1/2 | 24 1/2 | 27 1/2 | 31 1/2 | 34 1/2 | 41 1/2 |
| 0.148 | 2 | 10 1/2 | 12 1/2 | 13 1/2 | 17 1/2 | 20 1/2 | 24 1/2 | 27 1/2 | 31 1/2 | 34 1/2 | 41 1/2 |
| 0.148 | 1 | 20 | 23 | 27 | 33 | 39 | 45 | 53 | 61 | 67 | 79 |
| 0.120 | 2 | 10 1/2 | 12 1/2 | 14 1/2 | 17 1/2 | 20 1/2 | 24 1/2 | ... | ... | ... | ... |
| 0.120 | 1 3/4 | ... | ... | ... | ... | ... | ... | 31 1/2 | 35 1/2 | 39 1/2 | 47 1/2 |
| 0.120 | 1 | 20 | 23 | 27 | 33 | 39 | 45 | 53 | 61 | 67 | 79 |
| 0.113 | 2 1/8 | 9 1/2 | 11 1/2 | 13 1/2 | 16 1/2 | 19 1/2 | ... | ... | ... | ... | ... |

^ASee Appendix X1 for metric equivalents.