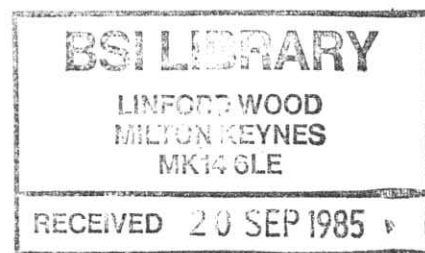


JIS

JAPANESE INDUSTRIAL STANDARD

Chain Link Wire Netting

JIS G 3552—1984



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by

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JAPANESE INDUSTRIAL STANDARD

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G 3552-1984

1. Scope

This Japanese Industrial Standard specifies the galvanized low carbon steel wire chain link netting, precoated colour low carbon steel wire chain link netting and vinyl coated low carbon steel wire chain link netting to be used mainly for fence. However, regarding the galvanized low carbon steel wire chain link netting, those which are post-plated are excluded.

2. Types and Symbols

The types and symbols of the chain link wire nettings shall be as given in Table 1.

Applicable Standards:

JIS G 3532-Low Carbon Steel Wires

JIS G 3542-Precoated Color Steel Wires

JIS G 3543-Polyvinyl Chloride Coated Color Steel Wires

JIS H 0401-Methods of Test for Hot-Dip Galvanized Coatings

Reference Standards:

JIS A 1415-Recommended Practice for Accelerated Artificial Exposure of
Plastics Building Materials

JIS K 6720-Polyvinyl Chloride Resins

JIS Z 2371-Methods of Salt Spray Testing

Table 1. Types and Symbols

Type	Symbol	Remark
Galvanized low carbon steel wire chain link nettings (Class Z)	Z-G 1	Those using SWM-G 1 of JIS G 3532. Furthermore, those conforming to 3. (1).
	Z-G 3	Those using SWM-G 3 of JIS G 3532. Furthermore, those conforming to 3. (1).
	Z-G 4	Those using SWM-G 4 of JIS G 3532. Furthermore, those conforming to 3. (1).
Precoated colour low carbon steel wire chain link nettings (Class C)	C-G 1	Those using SWMC-G 1 of JIS G 3542.
	C-G 3	Those using SWMC-G 3 of JIS G 3542.
	C-G 4	Those using SWMC-G 4 of JIS G 3542.
	C-A	Those using SWMC-A of JIS G 3542.
	C-B	Those using SWMC-B of JIS G 3542.
Vinyl coated low carbon steel wire chain link nettings (Class V)	V-G 1	Those using SWMV-G 1 of JIS G 3543.
	V-G 3	Those using SWMV-G 3 of JIS G 3543.
	V-A	Those using SWMV-A of JIS G 3543.
	V-B	Those using SWMV-B of JIS G 3543.

3. Materials

The materials shall be as given in the following:

- (1) The materials to be used for the galvanized low carbon steel wire chain link nettings shall be those conforming to SWM-G 1, SWM-G 3 or SWM-G 4 specified in JIS G 3532. However, the cylinder to be used for wrapping test shall be two times the wire diameter for SWM-G 1 and SWM-G 3, and be four times the wire diameter for SWM-G 4.
- (2) The materials to be used for the precoated colour low carbon steel wire chain link nettings shall be those conforming to JIS G 3542.
- (3) The materials to be used for the vinyl coated low carbon steel wire chain link nettings shall be those conforming to JIS G 3543.

4. Manufacturing Method

The chain link wire nettings shall be manufactured continuously entangling each other row wires, which have been bent in angle shape with a constant pitch by jig.

5. Shapes, Dimensions and Tolerances Thereof

5.1 Wire Diameters The wire diameters shall be as given in Table 2.

Table 2. Wire Diameters

Unit: mm

Class Z and Class C	Class V		
Wire diameter	Wire diameter	Core wire diameter	Minimum coating thickness of vinyl (Reference)
2.00	2.60	1.80	0.30
2.60	3.20	2.30	0.30
3.20	3.20	2.60	0.20
4.00	4.00	3.20	0.30
5.00	5.00	4.00	0.38

Remark: Those of 3.20 mm in wire diameter and 2.60 mm in core wire diameter of Class V shall be as designated by the purchaser.

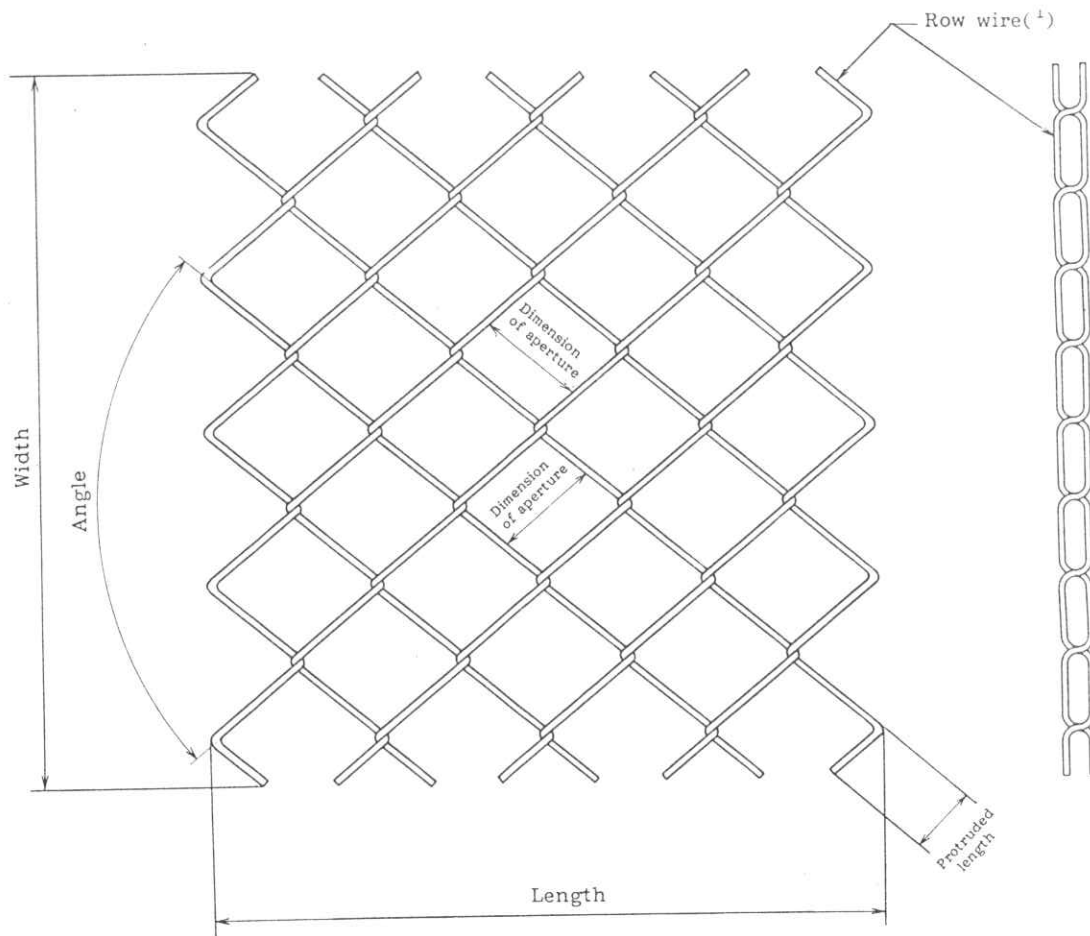
5.2 Dimensions of Apertures The dimensions of apertures shall be the length of one side of open quadrangle enclosed with row wires as given in Figure, and the dimensions and the tolerances thereof shall be as given in Table 3.

Table 3. Dimensions of Apertures and Tolerances Thereof

Dimensions mm	Tolerances %
20, 25, 32, 40, 50, 56, 63, 75	± 3

Remark: In the case of the end twisting process, the tolerances for the aperture of the processed part are not specified.

Figure



Note ⁽¹⁾ One piece of wire which has been processed is called a row wire.

Remark: This Figure is only for indicating names, and does not indicate the reference of shapes and construction.

5.3 Width The width shall be expressed by a distance from the end to end of the row wire as given in Figure, and its tolerances shall be the length equivalent to plus one aperture and minus $1/8$ of the aperture.

5.4 Length The length shall be expressed by a distance from the end to end of the row wires as given in Figure, and its tolerances shall be 0 in minus side and no tolerance is specified in plus side.

5.5 Dimension of Protruded Length The dimension of the protruded length shall be the length from the bent part of the extreme end of row wire to the end as given in Figure, and the dimension shall be $1/3$ or more of the aperture. However, as designated by the purchaser, other dimension may be applicable.

5.6 Angle The angle shall be measured as given in Figure, extending so that intersections of row wires are not be separated, and its angle shall be 85°.

Furthermore, its tolerances shall be $\pm 5^\circ$.

5.7 Combination of Wire Diameter and Aperture The combination of the wire diameter and aperture shall be as given in Table 4.

Table 4. Combination of Wire Diameter and Aperture

Unit: mm

Aperture Wire diameter	20	25	32	40	50	56	63	75
2.00	●	●	●	●	●	●		
2.60		○	○	○	●	●	●	
3.20		○	○	○	○	●	●	●
4.00			○	○	○	○	●	●
5.00					○	○	●	●

Remark: Mark ○ applies to Class Z, Class C and Class V.
However, mark ● applies to Class Z and Class C only, and is not applicable to Class V.

6. Appearance

The appearance shall be as given in the following:

- (1) The row wire shall not have flaw, cracking, peeling and other harmful defect in use and irregular colour on the surface.
- (2) The row wire shall be correct in shape and be free from dislocation of braiding.
- (3) The row wire shall have no joint on intermediate part.

7. Masses of Zinc Coating

The masses of zinc coating of row wire of Class Z shall be as given in Table 5.

Table 5. Masses of Zinc Coating

Wire diameter mm	Mass of zinc coating g/m ²		
	G 1	G 3	G 4
2.00	23 min.	85 min.	147 min.
2.60	23 min.	114 min.	175 min.
3.20	28 min.	128 min.	218 min.
4.00	33 min.	147 min.	232 min.
5.00	42 min.	147 min.	232 min.

8. Testing Method

8.1 Sampling Method of Test Piece In sampling the test piece, an arbitrary length shall be taken from the row wire.

8.2 Testing Method on Mass of Zinc Coating The test on mass of zinc coating shall be in accordance with 3.2 specified in JIS H 0401.

9. Inspection

The inspection on the mass of zinc coating shall be carried out in accordance with 8.2, and the results shall conform to the requirements of 7. The inspection on the shape, dimensions and appearance shall be carried out in accordance with appropriate methods, and the results shall conform to the requirements of 5. and 6.

10. Marking

The nettings which have passed the inspection shall be marked with the following information on respective bundles.

- (1) Symbol of type
- (2) Wire diameter
- (3) Dimension of aperture
- (4) Width and length
- (5) Year and month of manufacture or its abbreviation
- (6) Manufacturer's name or its abbreviation

11. Report

On the request of the purchaser, the manufacturer shall submit the results table of the specified items.

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