

Zenturo® panel & Zenturo® Super panel**1 Scope**

This specification specifies requirements for galvanised steel wire welded and subsequently organically coated Zenturo® (Super) panels for fencing according to EN 10223-7. (See figure 1 & figure 2)

The panels are recommended as residential or professional fencing.

The vertical and horizontal wires will have no barb.

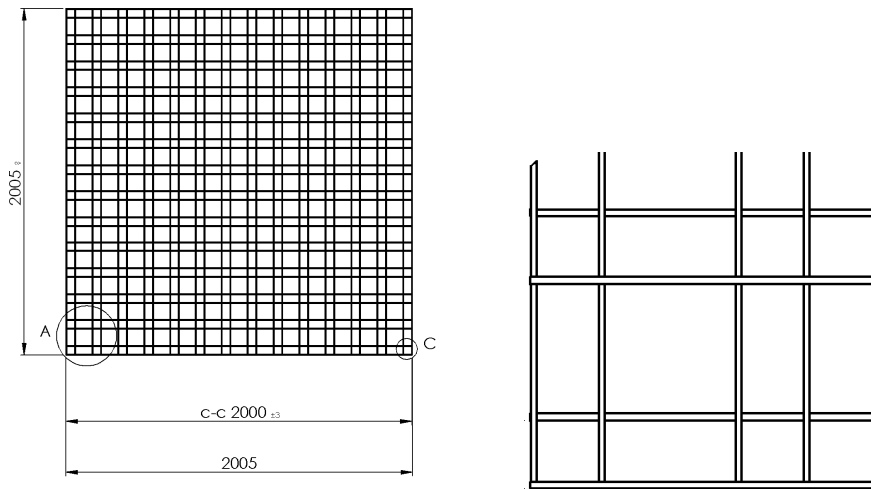


Figure 1: Zenturo® panel

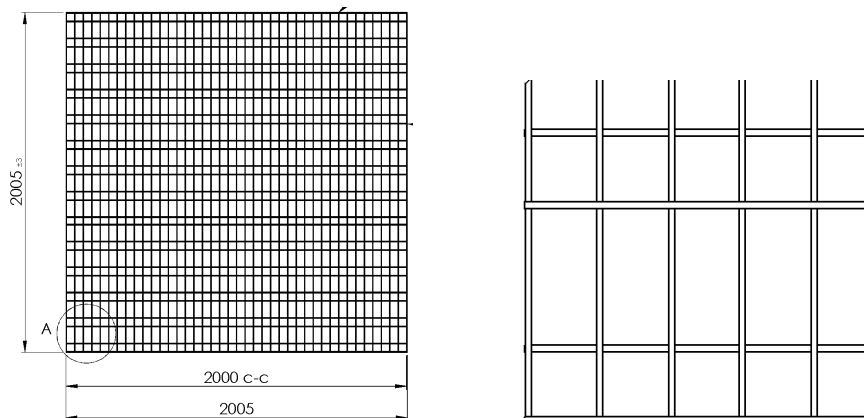


Figure 2: Zenturo® Super panel

Zenturo® panel & Zenturo® Super panel**1.1 Normative references**

- EN 10016-2: Non-alloy steel rod for drawing and/or for cold rolling, Part 2: Specific requirements for general purposes rod.
- EN 10218-2: Steel wire and wire products – General, Part 2: Wire dimensions and tolerances.
- EN 10223-7: Steel wire and wire products for fences, Part 7: Steel wire welded panels for fencing.
- EN 13438: Paints and varnishes: Powder organic coatings for galvanised or sherardised steel products for construction purposes.
- ISO 9227: Corrosion tests in artificial atmospheres; salt spray tests.

1.2 Definitions

- Nominal wire diameter (d): 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.

2 Raw material**2.1 Wire Rod**

In accordance with EN 10016-2 - C9D, see table 1.

Element	%
C	≤ 0,10
Si	≤ 0,30
Mn	≤ 0,60
P	≤ 0,035
S	≤ 0,035

2.2 Zinc

Minimum 99,95 % of pure zinc.

2.3 Polyester

Free of lead and Cadmium.

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3 Properties

Panels are fabricated by electrical resistance welding of zinc coated steel wires and are subsequently polyester coated.

3.1 Wire diameter and tolerances

See table 2

Table 2: wire diameters and tolerances				
	horizontal wire (mm)		vertical wire (mm)	
	core wire	polyester coated	core wire	polyester coated
Zenturo® (Super) panels	4,65 ± 0,06	5,00 ± 0,20	3,80 ± 0,06	4,15 ± 0,20

The tolerances are in accordance with EN 10218-2

3.2 Tensile strength of the wire

Vertical Wire: Min. 400 N/mm².

Horizontal wire: Min 500 N/mm².

3.3 Mesh sizes and tolerances

See table 3 and 4:

Table 3 mesh sizes Zenturo® panel			
Mesh sizes mm	Mesh size 100x100mm	Mesh size 100x50mm	Mesh size 50x50mm
Distance between the horizontal wires	100 ± 3,0mm	100 ± 3,0mm	50 ± 3,0mm
Distance between the vertical wires	100 ± 3,0mm	50 ± 3,0mm	50 ± 3,0mm

Table 4 mesh sizes Zenturo® Super panel		
Mesh sizes mm	Mesh size 100x50mm	Mesh size 50x50mm
Distance between the horizontal wires	100 ± 3,0mm	50 ± 3,0mm
Distance between the vertical wires	50 ± 3,0mm	50 ± 3,0mm

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

3.4 Overhang

The overhang of the horizontal wires shall be not more than 3 mm, burrs shall be avoided.

Zenturo® panel & Zenturo® Super panel**3.5 Weld shear strength**

Four welds selected at random from the panel shall be tested on weld shear strength. The average of these measurements shall be not less 50% of the min. breaking load of the wire, in accordance with EN 10223-7.

3.6 Barbs

The panel shall have no barbs.

3.7 Dimensions of the Panels

Height of the panel: see table 5 and 6, form of delivery - tolerance on the height: ± 3 mm.
Width of the panel: 2000 mm ± 3 mm, measured from centre to centre,

3.8 Coating**3.8.1 Metallic coating**

The wires are galvanised and the min. zinc weight for the horizontal and vertical wires is 30 g/m².

3.8.2 Organic coating**Thickness polyester coating:**

The panels are after welding subsequently polyester coated.

The total layer is minimum 100 μ m thick. The minimum is the average of 10 measurements done on 1 panel.

Colour:

Zenturo® panels are standard available from stock in Green Ral 6005 and Metallic Anthracite BF7016M.

Zenturo® Super panels are standard available from stock in Metallic Anthracite BF7016M.

For both panel types, other RAL, metallic & structured coatings are available on request.

Adhesion of the polyester:

Make a scratch in the longitudinal direction of the wire, by means of a hard metal pointed graving tool, penetrating through the metal. The length of the scratch will be about 50mm. The coating shall not be able to be lifted from the metal by more than 5 mm.

Resistance of the polyester to salt spray:

Make a scratch in the longitudinal direction of the wire, by means of a hard metal pointed graving tool, penetrating through the metal. The length of the scribe will be about 50mm. Test in accordance with ISO 9227.

There shall be, after 1000 h salt spray, no corrosion beneath the polyester or loss of adhesion in excess of 10 mm from the scratch and no signs of blistering, cracking or crazing on any part of the specimen

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4 Form of delivery

Panels are delivered on a four-way pallet, protected by water resistant shrink foil.

Number of panels per pallet, weight and Sapcode: See table 5 and 6.

A label is stuck on each panel stating mesh size, width, height of the panel & Ean code.

Four wooden beams are used to give more stability to the pallet and to avoid gliding of the panels.

Table 5 : Form of delivery and packing (Zenturo® panel)

Overall height of the panel mm	Width of the panel mm	number of panels per pallet	Palet dimensions L x W X H	Technical drawing	Sapcode RAL 6005	Sapcode BF7016 M
655	2000	100 (2x50)	210 x 106 x 58	BFO50P000001	7040762	7040768
955	2000	50	210 x 106 x 58	BFO50P000002	7040763	7040769
1255	2000	50	210 x 130 x 58	BFO50P000003	7040764	7040770
1555	2000	50	206 x 158 x 58	BFO50P000004	7040765	7040771
1705	2000	50	206 x 180 x 58	BFO50P000005	7040766	7040772
2005	2000	50	210 x 210 x 58	BFO50P000006	7040767	7040773

Table 6 : Form of delivery and packing (Zenturo® Super panel)

Overall height of the panel mm	Width of the panel mm	number of panels per pallet	Palet dimensions L x W X H	Technical drawing	Sapcode BF7016M
955	2000	50	210 x 106 x 58	BFO50P002002	7054201
1255	2000	50	210 x 130 x 58	BFO50P002003	7054202
1555	2000	50	206 x 158 x 58	BFO50P002004	7054203
1705	2000	50	206 x 180 x 58	BFO50P002005	7045816
2005	2000	50	210 x 210 x 58	BFO50P002006	7045817