



APRIL 2004

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S P E C I F I C A T I O N S

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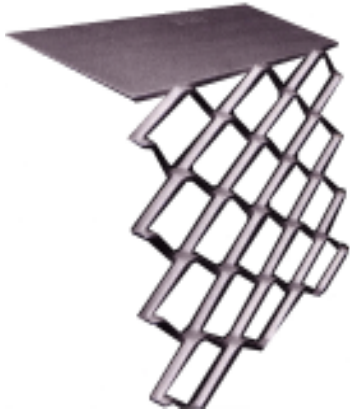
ALUMINUM & STAINLESS STEEL

IMPERIAL VERSION

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# TERMINOLOGY



## **Standard Expanded Metal**

Expanded metal as it comes off the machine. Standard expanded metal is abbreviated “XM”.

## **Flattened Expanded Metal**

Expanded metal which has been passed through flattening rolls (cold rolled), turning the strands and bonds down to provide a flat surface. The flattening operation reduces the thickness (gauge) of the metal and stretches the pattern or piece. Flattened expanded metal is abbreviated “FXM”.

## **Designating Style**

Expanded metal products are designated by a series of numbers which identify any given style. The first number designates nominal pitch short way of design. The second number is used in conjunction with the first number and may specify the gauge of metal, weight per 100 square feet, or may have some other significance. Therefore, the word “gauge” should never be added to the style designation.

**Style Dimension:** Nominal dimension Short Way of Design (SWD).

**Design Size:** Actual dimension SWD and LWD. Measured from a point to a corresponding point on the following design.

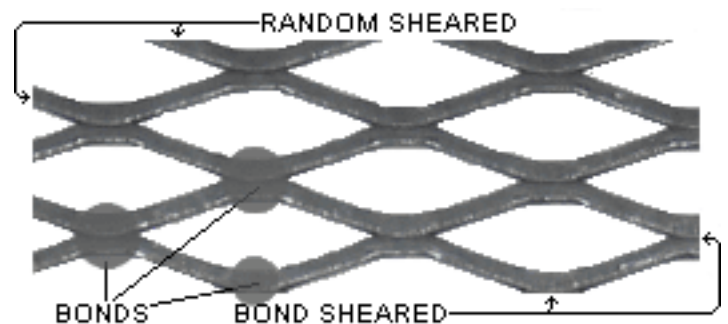
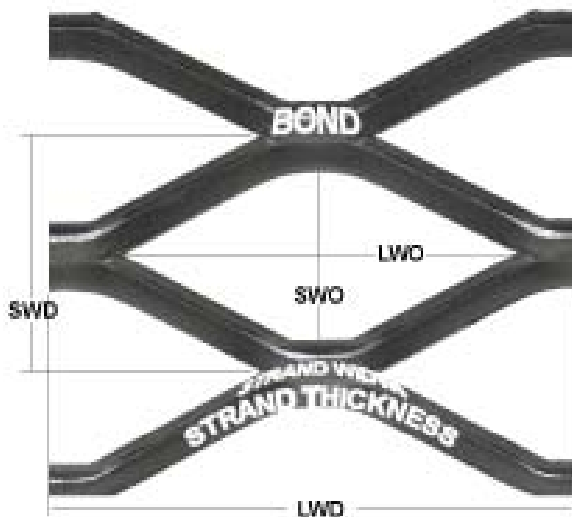
**SWO** Short Way of Opening.

**LWO** Long Way of Opening.

**Strands:** The sides of the expanded metal design.

**Strand Thickness:** Gauge thickness of metal expanded.

**Strand Width:** Amount of metal fed under dies to produce one strand.



## TOLERANCES

### **SHEARING TOLERANCES**

**Bond:** Where two strands intersect. Eliminates prongs or jagged edges.

Tolerance: Minus 0 plus 1/2" the design size, either SWD or LWD. Special bond tolerances on meshes of 1/4" and under.

**Random:** This type of shearing leaves prongs or jagged edges.

Tolerances:  $\pm 1/16$ " on grating  $\pm 1/8$ ".

### **STOCK SHEET SIZES**

#### **Standard**

SWD- Plus 3/16" minus 0" per foot of width.

LWD- Plus 1/4" minus 0" per sheet size.

#### **Flattened**

SWD- Plus 3/16" minus 0" per foot of width.

LWD- Plus 1" minus 0" per sheet size.

### **CAMBER**

Measured by placing a straight edge along the concave side of the sheet parallel to the LWD, touching both ends.

The maximum distance from the edge of the expanded metal to the straight edge is the camber.

SWD- 1/16" per foot of width.

LWD- Standard expanded metal 1/16" per foot of length.

Flattened expanded metal 3/32" per foot of length.

### **OUT OF SQUARE**

Measured using a 90 degree angle.

SWD- 1/16" per foot of width.

LWD- 1/16" per foot of length.

### **FLATTENING**

Flattening is limited to 72" maximum size one dimension. Flattened sheet thickness shall be plus or minus 10% of the published thickness.

## DRAMEX STANDARD ALUMINUM

Style	Lbs. per 100 S.F.	Standard Sheet Size		Design Size (In.)		Opening Size (In.)		Strand Size (In.)		Overall Thick.	Open Area %
	Plain	SWD	LWD	SWD	LWD	SWO	LWO	Width	Thick.		
<b>3/16" - #.032</b>	28	4	8	0.203	0.500	0.080	3.130	0.060	0.032	0.080	40
<b>5/16" - #.032</b>	22	4	8	0.330	1.000	0.219	0.690	0.080	0.032	0.125	62
<b>5/16" - #.051</b>	35	4	8	0.330	1.000	0.188	0.920	0.080	0.051	0.170	55
<b>1/2" - #.051</b>	25	4	8	0.500	1.200	0.375	0.937	0.080	0.051	0.158	65
<b>1/2" - #.081</b>	41	4	8	0.500	1.200	0.375	0.937	0.080	0.081	0.186	60
<b>3/4" - #.051</b>	17	4	8	0.923	2.000	0.812	1.750	0.109	0.051	0.200	78
<b>3/4" - #.081LT</b>	27	4	8	0.923	2.000	0.750	1.680	0.110	0.081	0.200	76
<b>3/4" - #.081HVY</b>	41	4	8	0.923	2.000	0.750	1.680	0.165	0.081	0.300	69
<b>3/4" - #.125</b>	65	4	8	0.923	2.000	0.687	1.680	0.169	0.125	0.305	68
<b>3/4" - #.188</b>	127	4	8	0.923	2.000	0.600	1.680	0.221	0.188	0.400	60
<b>1 1/2" - #.081</b>	22	4	8	1.330	3.000	1.187	2.500	0.129	0.081	0.240	85
<b>1 1/2" - #.125</b>	43	4	8	1.330	3.000	1.187	2.500	0.162	0.125	0.300	79
<b>1 1/2" - #.188</b>	79	4	8	1.330	3.000	1.000	2.500	0.200	0.188	0.380	70

**Above material conforms to military specification MIL-M-17999C (MR) Class 1.**

## DRAMEX FLATTENED ALUMINUM

Style	Lbs. per 100 S.F.	Standard Sheet Size		Design Size (In.)		Opening Size (In.)		Strand Size (In.)		Overall Thick.	Open Area %
	Plain	SWD	LWD	SWD	LWD	SWO	LWO	Width	Thick.		
<b>3/16" - #.032F</b>	20	4	8	0.218	0.500	0.094	0.343	0.060	0.028	0.028	43
<b>5/16" - #.032F</b>	20	4	8	0.333	1.020	0.188	0.813	0.082	0.030	0.030	43
<b>5/16" - #.051F</b>	34	4	8	0.333	1.020	0.156	0.780	0.082	0.045	0.045	51
<b>1/2" - #.051F</b>	24	4	8	0.500	1.270	0.312	1.000	0.091	0.040	0.040	61
<b>1/2" - #.081F</b>	39	4	8	0.500	1.270	0.312	1.000	0.091	0.060	0.060	58
<b>3/4" - #.051F</b>	16	4	8	0.923	2.125	0.750	1.812	0.122	0.040	0.040	72
<b>3/4" - #.081LTF</b>	25	4	8	0.923	2.125	0.687	1.750	0.134	0.070	0.070	70
<b>3/4" - #.081HF</b>	39	4	8	0.923	2.125	0.687	1.750	0.181	0.070	0.070	63
<b>3/4" - #.125F</b>	62	4	8	0.923	2.125	0.625	1.750	0.187	0.095	0.095	62
<b>1" - #.188F</b>	115	4	8	1.000	2.000	0.540	1.400	0.280	0.165	0.165	60
<b>1 1/2" - #.188F</b>	72	4	8	0.923	2.125	0.575	1.600	0.200	0.170	0.170	58
<b>1 1/2" - #.081F</b>	21	4	8	1.330	3.150	1.062	2.750	0.143	0.055	0.055	77
<b>1 1/2" - #.125F</b>	41	4	8	1.330	3.150	1.000	2.750	0.181	0.095	0.095	70

**Above material conforms to military specification MIL-M-17999C (MR) Class 2.**

Styles 3/32" - 3/16" - 1/4" - 5/16" - 5/8" - 1" and hex styles please enquire for availability.

For aluminum grating see grating specifications booklet.

Aluminum styles are made from 1100H14, 3003H14 and utility sheet alloys. 1100H14 is normally stocked for other alloys, please enquire.

## DRAMEX STANDARD STAINLESS STEEL

Style	Lbs. per 100 S.F.	Standard Sheet Size		Design Size (In.)		Opening Size (In.)		Strand Size (In.)		Overall Thick.	Open Area %
	Plain	SWD	LWD	SWD	LWD	SWO	LWO	Width	Thick.		
1/2" - #20	50	4	8	0.500	1.200	0.437	0.937	0.080	0.037	0.164	70
1/2" - #18	67	4	8	0.500	1.200	0.437	0.937	0.080	0.050	0.164	70
1/2" - #16	84	4	8	0.500	1.200	0.437	0.937	0.080	0.062	0.164	70
1/2" - #13	187	4	8	0.500	1.200	0.325	0.875	0.119	0.093	0.225	65
3/4" - #16	60	4	8	0.923	2.000	0.812	1.750	0.106	0.062	0.202	83
3/4" - #13	91	4	8	0.923	2.000	0.750	1.687	0.107	0.093	0.202	80
3/4" - #9(10)	193	4	8	0.923	2.000	0.687	1.562	0.150	0.140	0.308	67
1 1/2" - #16	41	4	8	1.330	3.000	1.250	2.750	0.106	0.062	0.222	85
1 1/2" - #13	62	4	8	1.330	3.000	1.250	2.625	0.106	0.093	0.222	83
1 1/2" - #9 (10)	137	4	8	1.330	3.000	1.125	2.500	0.155	0.140	0.280	77

## DRAMEX FLATTENED STAINLESS STEEL

Style	Lbs. per 100 S.F.	Standard Sheet Size		Design Size (In.)		Opening Size (In.)		Strand Size (In.)		Overall Thick.	Open Area %
	Plain	SWD	LWD	SWD	LWD	SWO	LWO	Width	Thick.		
1/2" - #20F	48	4	8	0.500	1.260	0.312	1.000	0.091	0.033	0.033	60
1/2" - #18F	65	4	8	0.500	1.260	0.312	1.000	0.091	0.040	0.040	60
1/2" - #16F	81	4	8	0.500	1.260	0.312	1.000	0.091	0.050	0.050	60
1/2" - #13F	178	4	8	0.500	1.260	0.240	0.915	0.132	0.080	0.080	57
3/4" - #16F	57	4	8	0.923	2.100	0.750	1.812	0.118	0.050	0.050	75
3/4" - #13F	86	4	8	0.923	2.100	0.625	1.750	0.120	0.070	0.070	75
3/4" - #9(10)F	183	4	8	0.923	2.100	0.562	1.687	0.155	0.119	0.119	61
1 1/2" - #16F	39	4	8	1.330	3.150	1.062	2.750	0.119	0.050	0.050	80
1 1/2" - #13F	59	4	8	1.330	3.150	1.000	2.625	0.121	0.079	0.079	80
1 1/2" - #9 (10)F	131	4	8	1.330	3.150	0.937	2.625	0.165	0.119	0.119	75

### Meshes

Stainless Steel Styles also available in - 3/16" - 5/16" - 5/8" - 1".

Styles are normally stocked in type 304, however some may be stocked in type 316.

For any other grades please enquire.

For stainless grating refer to grating specifications booklet.



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## **Dramex International Inc.**

8110 Southern Boulevard  
Youngstown, Ohio 44512  
Tel: (330) 758-2535  
Fax: (330) 758-1942  
1-800-225-1705  
E-mail: [sales@dramex.com](mailto:sales@dramex.com)

7345 Julie Francis Road  
Shreveport, Louisiana 71149  
Tel: (318) 688-1900  
Fax: (318) 688-1903  
1-800-533-1858  
E-mail: [dramexla@dramex.com](mailto:dramexla@dramex.com)

125 Business Drive  
Lilburn, Georgia 30247  
Tel: (770) 925-2898  
Fax: (770) 381-9716

1550 Babbitt Avenue  
Anaheim, California 92805  
Tel: (714) 634-1882  
Fax: (714) 634-8635  
1-800-654-9640

## **Corporation Métal Déployé**

62 Kelly Road  
St-Jean-sur-Richelieu, Québec J2X 4J5  
Tel: (450) 347-6350  
Fax: (450) 347-0541  
1-800-463-3255  
E-mail: [deploye@dramex.com](mailto:deploye@dramex.com)

## **Expanded Metal Corporation**

20 Fasken Drive  
Rexdale, Ontario M9W 1K5  
Tel: (416) 675-6311  
Fax: (416) 675-4310  
1-800-461-2991  
E-mail: [dramex@dramex.com](mailto:dramex@dramex.com)

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