



APRIL 2004

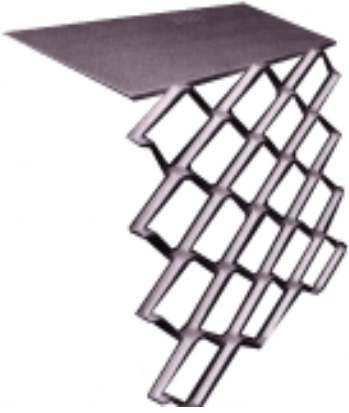
D R A M E X[®]
S P E C I F I C A T I O N S

CARBON STEEL REGULAR & FLATTENED

METRIC VERSION

W W W . D R A M E X . C O M

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 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.

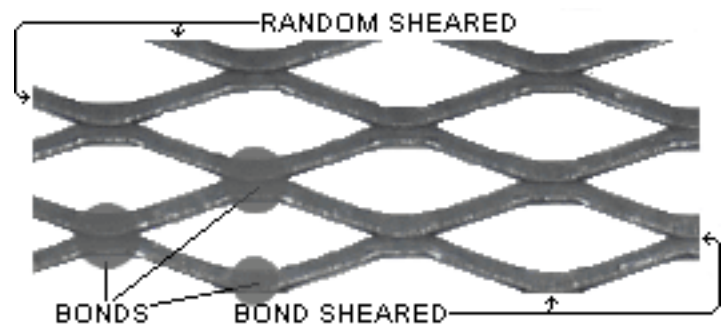
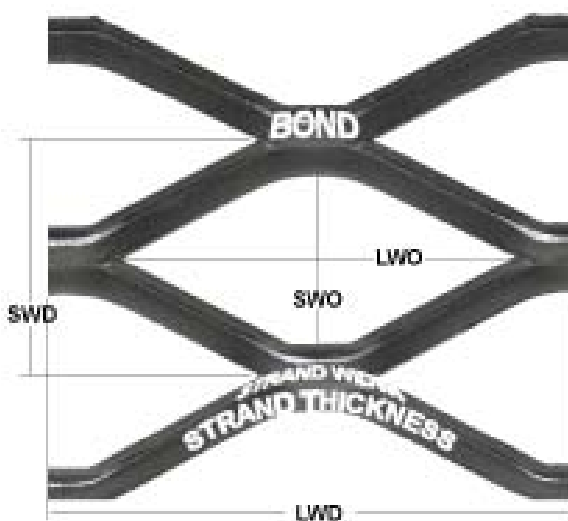
SWO: Short Way of Opening.

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 12.7mm the design size, either SWD or LWD. Special bond tolerances on meshes of 6.35mm and under.

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

Tolerances: ± 1.59 mm on grating ± 3.18 mm.

STOCK SHEET SIZES

Standard

SWD- Plus 15.62mm minus 0mm per meter of width.

LWD- Plus 19.05mm minus 0mm per sheet size.

Flattened

SWD- Plus 15.62mm minus 0mm per meter of width.

LWD- Plus 25.40mm minus 0mm 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- 5.21mm per meter of width.

LWD- Standard expanded metal minus 5.21mm per meter of length.

Flattened expanded metal minus 7.81mm per meter of length.

OUT OF SQUARE

Measured using a 90 degree angle.

SWD- 5.21mm per meter of width.

LWD- 5.21mm per meter of length.

FLATTENING

Flattening is limited to 1.83m maximum size one dimension. Flattened sheet thickness shall be plus or minus 10% of the published thickness.

DRAMEX STANDARD METAL - CARBON STEEL

SMALL DIAMOND DESIGNS 3/32" - 5/16"

STYLE	Kg per square meter	Standard Sheet Size (m)		Design Size (mm)		Opening Size (mm)		Strand Size (mm)		Overall Thick.	Open Area %
		SWD	LWD	SWD	LWD	SWO	LWO	Width	Thick.		
3/32" - #24L	2.05	1.22	2.44	3.962	6.350	2.388	3.962	0.762	0.610	1.143	58
3/32" - #24H	3.08	1.22	2.44	3.962	6.350	1.600	3.962	1.143	0.610	1.397	37
3/16" - #22	2.73	1.22	2.44	5.156	12.700	2.794	7.950	1.194	0.762	1.778	55
3/16" - #20	4.39	1.22	2.44	5.156	12.700	2.032	7.950	1.600	0.914	2.032	40
1/4" - #20	4.20	1.22	2.44	6.350	25.400	3.175	18.237	1.829	0.914	3.429	45
1/4" - #18	5.57	1.22	2.44	6.350	25.400	2.794	18.237	1.829	1.219	3.734	43
5/16" - #20	2.78	1.22	2.44	8.458	25.400	6.350	19.050	1.600	0.914	3.175	60
5/16" - #18	5.08	1.22	2.44	8.458	25.400	4.775	17.475	2.368	1.219	4.318	48

Above material conforms to ASTM specification F1267-01

DRAMEX STANDARD METAL - CARBON STEEL

DESIGNS 1/2" - 1 1/2"

Style	Kg per square meter		Standard Sheet Size (m)		Design Size (mm)		Opening Size (mm)		Strand Size (mm)		Overall Thick.	Open Area %
	Plain	Galv.	SWD	LWD	SWD	LWD	SWO	LWO	Width	Thick.		
1/2" - #20	2.10	2.49	1.22	2.44	12.700	30.480	11.125	23.825	1.829	0.914	3.556	80
1/2" - #18	3.42	4.30	1.22	2.44	12.700	30.480	11.125	23.825	2.235	1.219	4.369	72
1/2" - #16	4.20	5.08	1.22, 1.83	2.44, 3.05	12.700	30.480	9.525	23.825	2.210	1.524	4.445	65
1/2" - #13	7.18	8.50	1.22, 1.83	2.44, 3.05	12.700	30.480	7.925	23.825	2.438	2.286	5.182	57
1/2" - #13(.188)	13.77	15.14	1.22, 1.83	2.44, 3.05	12.700	30.480	6.350	20.320	4.775	2.286	6.985	25
3/4" - #16	2.64	2.98	1.22, 1.83	2.44, 3.05	23.444	50.800	20.650	44.450	2.565	1.524	5.334	78
3/4" - #13	3.91	4.59	1.22, 1.83	2.44, 3.05	23.444	50.800	19.050	42.875	2.438	2.286	5.207	76
3/4" - #10(13)	5.86	6.54	1.22, 1.83	2.44, 3.05	23.444	50.800	19.050	41.275	3.658	2.286	7.366	72
3/4" - #9(10)	8.79	9.67	1.22, 1.83	2.44, 3.05	23.444	50.800	17.475	39.675	3.810	3.429	7.925	68
1" - #16	2.29	2.64	1.22, 1.83	2.44, 3.05	25.400	57.150	23.825	50.800	2.210	1.524	4.877	82
1" - #14	3.81	4.39	1.22, 1.83	2.44, 3.05	25.400	57.150	22.225	39.700	3.175	1.880	5.715	75
1" - #12	4.69	5.37	1.22, 1.83	2.44, 3.05	25.400	57.150	23.038	39.700	2.769	2.667	5.715	78
1" - #10(170)	8.30	9.13	1.22, 1.83	2.44, 3.05	25.400	57.150	19.050	39.700	3.937	3.429	9.525	62
1" - #10H	9.76	10.79	1.22, 1.83	2.44, 3.05	25.400	57.150	19.050	39.700	4.572	3.429	9.906	60
1" - #7	20.12	22.12	1.22, 1.83	2.44, 3.05	25.400	57.150	14.630	39.700	6.985	4.648	13.970	45
1 1/2" - #16	1.95	2.34	1.22, 1.83	2.44, 3.05	33.782	76.200	31.750	66.675	2.743	1.524	5.842	85
1 1/2" - #13	2.93	3.32	1.22, 1.83	2.44, 3.05	33.782	76.200	30.175	63.500	2.667	2.286	6.147	85
1 1/2" - #10(13)	3.86	4.39	1.22, 1.83	2.44, 3.05	33.782	76.200	30.175	63.500	3.505	2.286	7.214	80
1 1/2" - #12	3.61	4.15	1.22, 1.83	2.44, 3.05	33.782	76.200	28.245	60.325	2.769	2.667	5.715	83
1 1/2" - #9(10)	5.86	7.03	1.22, 1.83	2.44, 3.05	33.782	76.200	28.575	60.325	3.658	3.429	7.925	76
1 1/2" - #10(170)	8.30	9.13	1.22, 1.83	2.44, 3.05	33.782	76.200	25.400	60.325	5.080	3.429	9.652	74
1 1/2" - #10H	9.76	10.74	1.22, 1.83	2.44, 3.05	33.782	76.200	21.082	60.325	6.096	3.429	11.684	72
1 1/2" - #6	12.21	13.43	1.22, 1.83	2.44, 3.05	33.782	76.200	28.194	58.750	5.156	5.029	10.998	69

Above material conforms to ASTM specification F1267-01

DRAMEX FLATTENED METAL - CARBON STEEL

SMALL DIAMOND DESIGNS 3/16" - 5/16"

STYLE	Kg per square meter	Standard Sheet Size (m)		Design Size (mm)		Opening Size (mm)		Strand Size (mm)		Overall Thick.	Open Area %
		SWD	LWD	SWD	LWD	SWO	LWO	Width	Thick.		
3/16" - #22F	3.52	1.22	2.44	5.537	12.700	2.388	8.712	1.600	0.686	0.686	43
3/16" - #20F	4.20	1.22	2.44	5.537	12.700	2.388	8.712	1.600	0.813	0.813	43
1/4" - #20F	4.30	1.22	2.44	6.350	26.670	2.134	18.161	2.007	0.762	0.762	35
1/4" - #18F	5.27	1.22	2.44	6.350	26.670	1.905	18.161	2.032	1.016	1.016	35
5/16" - #20F	2.64	1.22	2.44	8.458	26.162	5.156	20.650	1.905	0.813	0.813	60
5/16" - #18F	4.64	1.22	2.44	8.458	26.162	4.369	20.650	2.515	1.016	1.016	45

Above materials conforms to ASTM specification F1267-01

DRAMEX FLATTENED METAL - CARBON STEEL

DESIGNS 1/2" - 1 1/2"

Style	Kg per square meter		Standard Sheet Size (m)		Design Size (mm)		Opening Size (mm)		Strand Size (mm)		Overall Thick.	Open Area %
	Plain	Galv.	SWD	LWD	SWD	LWD	SWO	LWO	Width	Thick.		
1/2" - #20F	1.95	2.49	1.22	2.44	12.700	31.750	9.525	25.400	2.007	0.737	0.737	65
1/2" - #18F	3.22	4.05	1.22	2.44	12.700	31.750	7.925	25.400	2.464	0.991	0.991	60
1/2" - #16F	4.00	4.78	1.22, 1.83	2.44, 3.05	12.700	31.750	7.925	25.400	2.436	1.422	1.422	63
1/2" - #13F	6.84	7.86	1.22, 1.83	2.44, 3.05	12.700	31.750	7.925	25.400	2.718	1.778	1.778	52
1/2" - #13(.188)F	13.43	14.60	1.22, 1.83	2.44, 3.05	12.700	31.750	6.350	25.400	4.775	1.778	1.778	25
3/4" - #16F	2.49	2.78	1.22, 1.83	2.44, 3.05	23.444	53.340	19.050	44.450	2.819	1.219	1.219	74
3/4" - #13F	3.66	4.30	1.22, 1.83	2.44, 3.05	23.444	53.340	17.475	45.237	2.692	1.778	1.778	74
3/4" - #10(13)F	5.57	6.25	1.22, 1.83	2.44, 3.05	23.444	53.340	16.180	44.577	4.064	1.778	1.778	68
3/4" - #9(10)F	8.35	9.18	1.22, 1.83	2.44, 3.05	23.444	53.340	14.300	42.875	4.191	3.048	3.048	63
1" - #16F	2.15	2.44	1.22, 1.83	2.44, 3.05	25.400	58.420	20.650	53.340	2.489	1.270	1.270	78
1" - #14F	3.08	3.52	1.22, 1.83	2.44, 3.05	25.400	58.420	20.650	50.800	3.175	1.778	1.778	80
1" - #12F	4.78	5.52	1.22, 1.83	2.44, 3.05	25.400	58.420	20.650	50.800	3.962	2.159	2.159	74
1" - #10F	8.06	8.74	1.22, 1.83	2.44, 3.05	25.400	58.420	19.050	48.260	4.064	2.794	2.794	58
1 1/2" - #16F	1.86	2.15	1.22, 1.83	2.44, 3.05	33.782	81.280	26.975	69.850	3.023	1.219	1.219	83
1 1/2" - #13F	2.78	3.22	1.22, 1.83	2.44, 3.05	33.782	81.280	26.975	69.850	2.946	1.778	1.778	80
1 1/2" - #12F	3.22	3.71	1.22, 1.83	2.44, 3.05	35.814	81.280	32.918	66.675	2.946	2.159	2.159	85
1 1/2" - #9F	5.57	6.10	1.22, 1.83	2.44, 3.05	33.782	81.280	25.400	65.100	4.013	2.794	2.794	75
1 1/2" - #10F	8.06	8.74	1.22, 1.83	2.44, 3.05	33.782	81.280	22.860	65.100	4.775	2.794	2.794	63

Above materials conforms to ASTM specification F1267-01



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