

FENCE FITTINGS AND ACCESSORIES

ASTM F 626 FEDERAL SPECIFICATION RR-F-191/4 F AASHTO M-181

BASIC USE

Fence fittings and accessories include those items that are normally used in conjunction with metallic or color-coated chain link fabric and framework to complete a chain link fence installation.

COMPOSITION AND MATERIALS

Fence fittings and accessories as part of a chain link fence installation may be manufactured from steel or aluminum alloy. Steel items are galvanized after fabrication.

TECHNICAL DATA

All steel products are galvanized using zinc metal conforming to ASTM B6.

POST AND LINE CAPS

Post and line caps are fabricated from pressed steel or cast iron and galvanized with a minimum of 1.2 oz/ft² of zinc, or from aluminum alloy 360.0 conforming to ASTM B85. Post and line caps are to fit snugly over posts and exclude moisture from inside tubular posts.

RAIL AND BRACE ENDS

Rail and brace ends are fabricated from pressed steel or cast iron and galvanized with a minimum of 1.2 oz/ft² of zinc, or aluminum alloy 360.0 (ASTM B85), or alloy 356.0 or 713.0 (ASTM B26 or ASTM B108).

TOP RAIL SLEEVES

Top rail sleeves are fabricated from pressed steel or cast steel with a minimum of 1.2 oz/ft² of zinc, or aluminum alloy 6063-T6 (ASTM B221 or B429). The material thickness shall be a minimum of 0.051 in. of steel or 0.062 in. of aluminum alloy. Minimum length shall be 6 in.

TENSION AND BRACE BANDS

Tension and brace bands are fabricated from pressed steel and hot-dip galvanized with a minimum of 1.2 oz/ft² of zinc coating or from aluminum alloy 6063-T5, 6063-T6, or 8176-H19 (ASTM B211 or B221).

Tension bands have a minimum material thickness of 14 ga. (0.074 in.) and a minimum width of 3/4 in.

Brace bands have a minimum material thickness of 12 ga (0.105 in.) and a minimum width of 3/4 in.

TENSION BARS

Steel tension bars are fabricated from merchant quality steel and hot-dip galvanized with 1.2 oz/ft² min. zinc coating.

Steel tension bars used to connect 1-3/4 in. and 2 in. mesh fabric to terminal and gate posts shall be a minimum of 3/16 in. by 5/8 in. for fabric heights up to 5 ft and a minimum of 3/16 in. by 3/4 in. for fabric heights over 5 ft. Tension bars to connect 1 in. mesh fabric to terminal and gate posts are a minimum of 1/4 in. by 3/8 in.

Aluminum alloy tension bars shall be 6061-T6 or 6063-T6 alloy (ASTM B211M or B221M). Aluminum alloy tension bars used to connect 1-3/4 in. and 2 in. mesh fabric to terminal and gate posts shall be a minimum of 1/4 in. by 3/4 in.

Minimum lengths of tension bar shall be 2 in. less than the full height of chain link fabric.

TRUSS ROD ASSEMBLY

Steel truss rods are fabricated from 5/16 in. merchant quality rod. Truss rod and tighteners shall be galvanized after threading with a minimum of 1.2 oz/ft² of zinc coating. Truss rod and tightener shall withstand 2,000 lbs of tension.

BARBED WIRE ARMS

Barbed wire arms are fabricated from pressed steel or cast iron and hot-dip galvanized with a minimum of 1.2 oz/ft² of zinc. Barbed wire arms shall be of the following types:

- Type I - Single slanted arm, for 3 barbed wire strands
- Type II - Single vertical arm, for 3 barbed wire strands
- Type II - V-shaped arm, for 6 barbed wire strands
- Type IV - A-shaped arm, for 5 barbed wire strands

Each arm shall be able to support a vertical 250 lb. load placed at the point of the outer barbed wire strand.

TENSION WIRE

Tension wire, 7 ga. (0.177 ± 0.005 in.) shall be either zinc or aluminum-coated per ASTM A824.

Type I aluminum-coated, minimum average coating weight of 0.40 1.2 oz/ft².

Type II zinc-coated, class 4, minimum average coating weight of 1.2 oz/ft² of zinc.

Minimum breaking strength of 1,950 lbs.

TIE WIRES

Standard round wire ties shall have either a preformed hook or pig tail at one end and designed of sufficient length to engage one picket of the chain link fabric at the preformed end with two 360° turns, then wrap around the rail or post a minimum of 180°. The opposite end of the tie should be secured to the nearest chain link fabric picket with two 360° turns to draw up tightly around the post or rail.

Types and Sizes

Steel: 9 ga. (0.148 ± 0.005 in.), tensile strength 55-65 ksi.

Zinc-coated – 0.80 oz/ft², Class 3

Aluminum: Alloy 1350H19

11 ga. (0.120 ± 0.005 in.)

9 ga. (0.148 ± 0.005 in.)

6 ga. (0.192 ± 0.005 in.)

HOG RINGS

Round wire hog rings for attaching chain link fabric to horizontal tension wire shall be one of the following:

Steel – 12 ga. (0.106 ± 0.005), min. of 0.80 oz/ft² zinc

Steel – 9 ga. (0.148 ± 0.005), min. of 0.80 oz/ft² zinc.

Aluminum – 9 ga. (0.148 ± 0.005) alloy 1350-H19 wire

COLOR COATING OF FITTINGS

When specified, the fittings and accessories may be color-coated with a polymer coating to match the fabric. Standard colors are contained in ASTM F934. The thickness of the polymer coating shall be a minimum of 0.006 in., maximum 0.015 in. Pressed steel or cast fittings shall be hot-dip galvanized prior to application of color coating material.

STANDARDS

ASTM F 626 – Fence Fittings

RR-F-191/4 – Federal Specification, Fencing, Wire and Post, Metal (Chain Link Fence Accessories)

AASHTO M 181 – American Association of State Highway And Transportation Officials

FAA – Federal Aeronautics Administration, Item F-162

TECHNICAL SERVICES



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