



# Product Specification Sheet

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## Confidential

1. **PRODUCT TYPE**  
Mining Mesh - Sheets

<u>INLET SIZE</u>	<u>SHEET DIMENSIONS</u>	<u>MPA'S</u>	<u>APERTURE</u>	<u>COATING</u>	<u>ELONGATION</u>
5.60mm	Width 2.4m Max Length - As Per Customer Requirements	500 - 650 Mpa	100mm x 100mm	Lightly Galv	6 % Min

### Tolerances / Specifications

<u>INLET SIZE</u>	5.55mm - 5.70mm	<u>APERTURE</u>	Min 99mm / Max 101mm
<u>SHEET WIDTH</u>	(-5mm/+5mm) on the Width	<u>COATING</u>	Average 100g/m <sup>2</sup>
<u>SHEET LENGTH</u>	(-5mm/+5mm) on the Length	<u>WIRE ELONGATION</u>	Min 6%
<u>WIRE MPA'S</u>	Min 500 Mpa / Max 650 Mpa	<u>FLUSH CUT</u>	Must be flush all round
<u>FLATNESS</u>	Sheets may not lift more than 50mm at any point	<u>WELD SHEAR</u>	Min 9.3kN
<u>SQUARENESS</u>	Max 10mm between the two measurements	<u>WELD PENETRATION</u>	10.08mm Max

3. **PRODUCTION CONTROL**

- \* Each batch to be made using a identification number in the form of a job or contract number and is recorded on the pack labels, together with sequential pack numbers for identification purposes on the job.
- \* Pack sizes to be 50 sheets per pack, each having a label securely attached so it doesn't come off when being handled or transported.
- \* Each pack to be tied using a minimum of 4 ties. Ties to be positioned to ensure pack stability. Ties not to be used for lifting up of packs. Wire must be used as ties and must be well tensioned.
- \* There shall be 100 sheets per stack. Each stack to be strapped with 4 straps and must be well tensioned, "mesh must not be damaged".
- \* Sheets to be reverse stacked for stability when being transported and for ease of use inside mine tunnels.
- \* Color coded hawk rings to be attached to every sheet for traceability purposes. "Each shift will use a different color"

4. **QUALITY CONTROL**

#### Online Checks: Frequency of checks "1 sheet in 25"

- \* The sheet will be measured to ensure that the mesh is kept within all the dimensional tolerances as per specifications.
- \* a Non destructive test will be done with a 32mm Spanner on both sides of a cross wire to make sure the welds do not break. Where a weld/s are found to be deficient, the settings will be adjusted and re-tested until all welds stick together.
- \* Weld penetration checks will be done by gauging with a micrometer, Welds must have Min 10% penetration, "10.08mm" Max when measured.
- \* Flush cuts will be checked to ensure there's no overhangs, sharp corners and burrs. All sheets must be flush all round.
- \* All actual findings to be recorded on the quality checklist and handed to the machine operator to check and adjust any settings if needed.

#### Online Check: Frequency of check "1 sheet in 100"

- \* Random measurements will be made on the main and cross wires to determine if the block apertures are within the allowed tolerance.
- \* All actual findings to be recorded on the quality checklist and handed to the machine operator to check and adjust any settings if needed.

#### Calibrated Weld Shear Test: Frequency of test "1 sheet in 500"

- \* a Sample of the mesh must be taken to quality control with all the quality checklists for the shear test to be done.
- \* The sheet will have every weld on a single cross wire destructively tested to determine the weld shear force. Where a weld is found to be deficient, the relevant settings will be adjusted and another test performed on the respective weld until the minimum acceptable weld shear strength is achieved.

#### Labelling: "Every pack of 50 Sheets"

- \* Every pack will have a pre printed label securely attached and will include below mentioned information.

Manufacturer Name, Customer Name , Date  
Job number  
Order number  
Pack number  
Mesh description  
Amount of sheets per bundle

5. **RAW MATERIAL AND GALV PRODUCTION**

Rod - 6.50 mm SAE 1008/1010/1012  
Black Wire Sizes - 5.62 - 5.68mm  
Speed on line - various  
Temp @ annealing - 700 °C  
Temp @ Galvanising - 450 °C

