

Expanded Metal

REGULAR

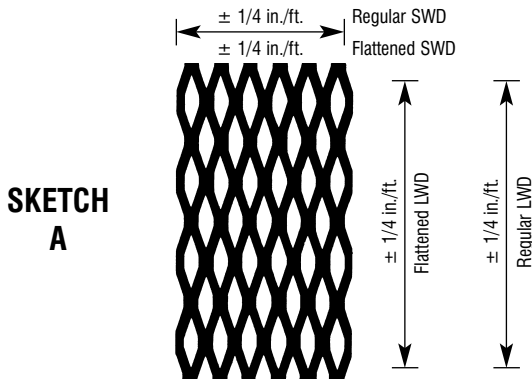
SWD – Shall not vary greater than $\pm 1/4$ inches per foot of SWD dimension, to a maximum of 1 inch overall.

LWD – Shall not vary greater than $\pm 1/4$ inch per foot of length.

FLATTENED

SWD – After flattening – shall not vary from the nominal dimension more than $\pm 1/4$ inch per foot of dimension to a maximum of 1 inch overall.

LWD – After flattening – shall not vary from the nominal dimension more than $\pm 1/4$ inch per foot of dimension.



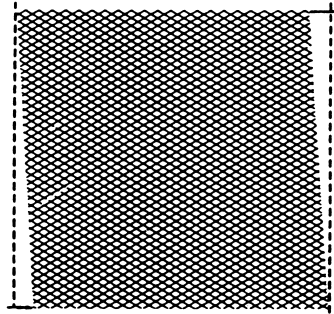
CLOSED DIAMONDS ALL FOUR SIDES

Flatness (Levelness) – Sheets shall be free from waves or buckles that are in excess of 3/4 in. from a plane surface.

Sketch A typifies the edge conditions of a normal standard size sheet as it emerges from the expanding press. It is simply expanded to size and is characterized by closed diamonds on all four sides.

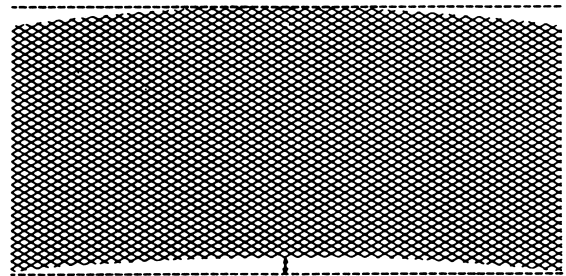
Squareness – Edges shall be such that any intersecting sides shall not be out of square in excess of 1/8 in. per foot either direction, to a maximum of 1/2 in. overall regular.

Squareness After Flattening – Ends shall not be more than 1/8 in. per foot out of square or 3/8 in. overall in relation to the side of the sheet used to gauge the shearing.



Camber – The greatest deviation of a side edge from a straight line shall not exceed 1/16 in. per foot of dimension, SWD and LWD. Regular.

Camber After Flattening – The greatest deviation of a side edge from a straight line after flattening shall not exceed 3/32 in. per foot of dimension.



RANDOM SHEARED TOLERANCE

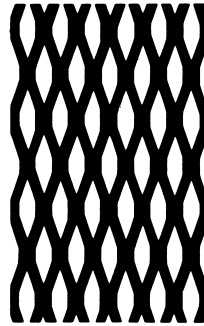
SKETCH B



Random sheared one side and one end $\pm 1/4$ ", causing open diamond one side SWD and one side LWD.

Expanded Metal Grating $\pm 1/2$ ".

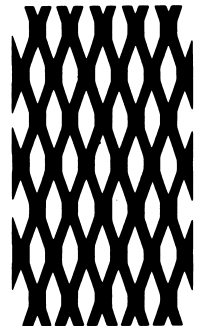
SKETCH C



Random sheared LWD ends $\pm 1/8$ ", causing open diamonds on LWD.

Expanded Metal Grating $\pm 1/4$ ".

SKETCH D



Random sheared SWD and LWD $\pm 1/8$ ". Open diamonds all four sides. This process will resquare the sheet and eliminates the out of square and camber tolerance found in stock size sheets.

Note: Random sheared on Expanded Metal Grating $\pm 1/4$ ".