Perfect for the Commercial / Industrial Fencing Marketplace

Stronger than Schedule 40

Outperforms Schedule 40 in ASTM B 117 Salt Spray Tests

Domestically Manufactured

SS 30™ benefits from three decades of advancement in coating technology pioneered by SS 40®. Allied Tube’s innovative application process provides the same level of galvanization and zinc-rich interior in the same quality controlled manner. The result is a triple external coating consisting of 1.0 oz/ft² ± .1 oz/ft² of zinc, a conversion coating of 30 micrograms/in² ± 15 micrograms/in², and a clear organic coating of .5 mils ± .2 mils. The internal coating has a minimum of 90% by weight zinc powder loading capable of providing galvanic protection.

SS 30’s strength and coatings exceed the provisions of ASTM F 1043, Standard Specifications for Strength and Protective Coatings on Steel Industrial Chain Link Fence Framework.

SS 30, manufactured in the United States, has greater strength and outperforms standard weight pipe in independent salt spray testing.

SS 30 continues the Allied Tube tradition of providing quality, service, and performance to the fence industry. Inspired by the high-strength performance of SS 40 and with the identical triple layer of corrosion protection, SS 30 has a bending moment exceeding that of Schedule 40 and meets the coating requirements of all major federal and state agencies.

Allied Tube’s SS 30 fence pipe is ready to fulfill its role as the quality domestic alternative to standard pipe.
PART 1 – GENERAL

1.01 WORK INCLUDED
A. Fence framework, fabric and accessories.
B. Gates and related hardware.
C. Installation.

1.02 SCOPE OF WORK
A. Summary: This section covers the work necessary to complete the chain link fence and gate installation.
B. General: Like items of materials provided hereafter shall be the end-products of one manufacturer in order to achieve standardization for appearance, maintenance, and replacement. Major components including, but not limited to, Fence Framework and Chain-link Fabric shall be manufactured in the United States.
C. Delivery, Storage and Handling: Deliver material to the site in an undamaged condition. Carefully store material off the ground to provide proper protection against oxidation caused by ground moisture.

1.03 SUBMITTALS AND CERTIFICATION
A. Shop Drawings: Include complete details of fence and gate construction, fence height, post spacing, dimensions, and unit weights of framework and concrete footing details.
B. Product Data: Provide manufacturer's catalog cuts and shop drawings.
C. Include complete details of fence, including details of fence framework, fabric, accessories, gates, and post setting. If required, option details shall be provided.
D. Fasteners: Include complete details of fence and gate construction, fence height, post spacing, dimensions, and unit weights of framework and concrete footing details.
E. Bracing: Brace gate and terminal posts back to adjacent line posts with horizontal brace rails and diagonal truss rods.
F. Bottom Rail: Install between loops connecting sections with sleeves to form a continuous rail between terminal posts.
G. Bottom/Middle Rail: Install between posts with line rail clamps or rail ends and bands.
H. Fabric: Pull fabric taut with bottom selvage 2” above grade. Fasten to terminal posts with tension bars threaded through mesh and secured with tension bands at maximum 15” intervals. Tie to line posts and top rails with tie wires spaced at maximum 12” on posts and 24” on rails. Attach to bottom/top tension wire with hog rings at maximum 24” intervals.
I. Barbed Wire: Anchor to terminal extension arms, pull taut, and firmly install in slots of line post extension arms.
J. Gates: Install gates plum and secure for full opening without interference. Anchor center stops and keepers in concrete.
K. Fasteners: Install nuts for fittings, bands, and barbed wire to line posts.
L. Barbed Tape: Install in accordance with ASTM F 1911. Consult with manufacturer for unique applications.

PART 2 – PRODUCTS

2.01 MATERIAL
A. Framework: SS 30” manufactured by Allied Tube & Conduit, or an approved equal, conforming to Standard Specification ASTM F 1043, Group IV. High-strength steel pipe triple coated per ASTM F 1043: external coating, Type B; internal coating, Type D.
B. Fabric Options: Fabric to be 9-gauge wire, woven in a 2” diamond mesh. Top selvage to be twisted and barbed. Bottom selvage to be knuckled unless otherwise specified.
C. Aluminized fabric shall be manufactured in accordance with ASTM A 491 and coated before weaving with a minimum .40 ounces of aluminum per square foot of surface area. The steel wire and coating shall conform to ASTM A 817.
D. Zinc-coated fabric shall be galvanized after weaving in accordance with ASTM A 392, Class 1 or Class 2.

2.02 CONCRETE MIX
A. Concrete: Conforming to ASTM C 94, having a minimum compressive strength of 3,000 PSI at 28 days.

2.03 COMPONENTS
A. Rails and Braces: 1-5/8” O.D.
B. Gates: Per ASTM F 900
C. Fittings, Tie Wires, and Hog Rings: Per ASTM F 626
D. Tension Wire: Per ASTM A 824 (if required)
E. Barbed Wire: If required, commercial quality steel, 12-1/2 gauge, two strand twisted line wire with 4 point barbs at 5 inch spacing. Coating shall consist of a minimum of 0.80 ounces of zinc per square foot of wire surface conforming to ASTM A 121 or a minimum of 0.30 ounces of aluminum per square foot of wire surface conforming to ASTM A 585.
F. Barbed Tape: If required, options are available in ASTM F 1910: Table 1 and 2.

PART 3 – EXECUTION

3.01 INSTALLATION
A. General: Installation to conform to ASTM F 567.
B. Height: Provide height as indicated on contract drawings.
C. Post Spacing: Space line posts at intervals not exceeding ten feet.
D. Post Setting: Set terminal, gate and line posts plum in concrete footings. The top of footing to be 2” above grade and sloped to direct water away from posts.
E. Bracing: Brace gate and terminal posts back to adjacent line posts with horizontal brace rails and diagonal truss rods.
F. Top Rail: Install through line loop caps connecting sections with sleeves to form a continuous rail between terminal posts.
G. Bottom/Middle Rail: Install between posts with line rail clamps or rail ends and bands.
H. Fabric: Pull fabric taut with bottom selvage 2” above grade. Fasten to terminal posts with tension bars threaded through mesh and secured with tension bands at maximum 15” intervals. Tie to line posts and top rails with tie wires spaced at maximum 12” on posts and 24” on rails. Attach to bottom/top tension wire with hog rings at maximum 24” intervals.
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3.02 COMPLETION
A. The area of installation shall be left free of debris caused by the installation of the fence.
### SS 30 vs. SCHEDULE 40 COMPARISON CHART

<table>
<thead>
<tr>
<th>Outside Dimensions</th>
<th>Pipe Wall Thickness</th>
<th>Weight (lbs/ft)</th>
<th>Section Modulus (inches³)</th>
<th>Yield Strength (lbs)</th>
<th>Bending Moment (lb. in.)</th>
<th>Bending Strength (lbs)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-5/8&quot; O.D.</td>
<td>SS 30</td>
<td>1.660&quot;</td>
<td>.095&quot;</td>
<td>1.59</td>
<td>2.36</td>
<td>0.1730</td>
</tr>
<tr>
<td>1-7/8&quot; O.D.</td>
<td>Sch 40</td>
<td>1.900&quot;</td>
<td>.145&quot;</td>
<td>2.72</td>
<td>3.71</td>
<td>0.2562</td>
</tr>
<tr>
<td>2-1/2&quot; O.D.</td>
<td>SS 30</td>
<td>2.375&quot;</td>
<td>.115&quot;</td>
<td>2.78</td>
<td>4.40</td>
<td>0.4402</td>
</tr>
<tr>
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<td>Sch 40</td>
<td>2.375&quot;</td>
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<td>2-7/8&quot; O.D.</td>
<td>SS 30</td>
<td>2.875&quot;</td>
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<td>9.09</td>
<td>1.6338</td>
</tr>
</tbody>
</table>

**MANUFACTURING LOCATIONS:**
- Harvey, IL Pine Bluff, ARPhiladelphia, PA Phoenix, AZ

SS 30 is available with POLYKOTE color finish. Allied Tube’s patented Flo-Coat® process with polyester coating conforming to ASTM F 1043. Contact your distributor for details.

SS 30 is available in long and extra long lengths and in cut posts.

For information on Razor Ribbon® brand barbed tape products, please visit www.razorribbon.com

### SS 30 PHYSICAL DIMENSIONS & STRENGTH CALCULATIONS

#### STRENGTH COMPARISON

<table>
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<tr>
<th>Line Posts Under 6’ Cantilever Load</th>
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<tr>
<td>Bending Strength (lbs)</td>
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<tr>
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<tr>
<td>1.660&quot;</td>
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<tr>
<td>1.2310</td>
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#### SS 30 SCHEDULE 40 PHYSICAL DIMENSIONS & STRENGTH CALCULATIONS

<table>
<thead>
<tr>
<th>O.D.</th>
<th>Outside Diameter (inches)</th>
<th>Pipe Wall Thickness (inches)</th>
<th>Weight (lbs/ft)</th>
<th>Section Modulus (inches³)</th>
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<td>9.09</td>
<td>1.6338</td>
<td>50,000</td>
<td>81,690</td>
</tr>
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