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## **BARBED TAPE SPECIFICATION**

### **MAZE® REINFORCED CONCERTINA**

#### **1. GENERAL**

- 1.01. This section covers the furnishing and installation of barbed tape. Together with chain link fence, the completed installation comprises a security barrier.
- 1.02. Applicable Documents:
  - ASTM A-176 Specification for Stainless and Heat-Resisting Chromium Steel Plate, Sheet, and Strip.
  - ASTM A-580 Specification for Stainless and Heat-Resisting Steel Wire.
  - ASTM A-764 Specification for Steel Wire, Carbon, Drawn, Galvanized and Galvanized at Size for Mechanical Springs.

#### **2. PRODUCTS**

- 2.01. Acceptable manufacturer is Allied Tube & Conduit, (708) 339-1610, Maze.
- 2.02. Barbed tape shall be [18", 24", 30"] plus or minus 1" diameter concertina style coil consisting of 31 loops. Each loop shall contain [13, 19, 23] plus or minus 1 barb clusters per loop. Adjacent coil loops shall be alternately clipped together at 3 points about the circumference to produce the concertina effect upon deployment. Spacing between attachment points when deployed shall be [12", 16"] plus or minus 2".
- 2.03. Barbed tape shall be fabricated from Type 430 stainless steel conforming to ASTM A-176. Stainless steel shall be 1" wide before fabrication by .025" thick, and shall be hardened to Rockwell (30N) 35-40. The stainless steel strip shall have clusters of four (4) barbs, each a minimum of 1.2" long, punched at 4" centers.
- 2.04. Fabricated (punched) barbed tape shall be reinforced by permanently cold clenching it around a reinforcing wire. Reinforcing wire shall be .098" diameter galvanized wire per ASTM A 764, Finish 2, Class II, Type 3, with a minimum tensile strength of 220,000 psi. (Core wire also available in 301 austenitic stainless steel conforming to ASTM A 580, with a minimum tensile strength of 130,000 psi). The stainless steel barbed tape shall be permanently roll formed about the core wire with a minimum wrap of 230 degrees. The finished reinforced barbed tape shall be a minimum of 0.325" wide in the throat area and shall exhibit two cut-resistant flanges. These flanges shall taper off in the immediate vicinity of the barb clusters to allow maximum barb penetration.
- 2.05. Reinforced barbed tape shall be converted to concertina by clipping alternate adjacent loops at three places about the circumference, continuous along the entire length of the roll. Stainless steel clips shall be .375" by .065" and mechanically closed to withstand a minimum pull load of 200 pounds.

#### **3. EXECUTION**

- 3.01. Concertina barbed tape shall be securely attached to the chain link fence using 18 gauge galvanized or stainless steel ties. Attachments shall be approximately [12", 16"] on center along both the top of the chain link fabric and the top single strand of barbed wire.
- 3.02. Each coil of barbed tape shall be extended a maximum of [15, 20] ± 1 foot.
- 3.03. Adjacent coils shall be permanently spliced together by overlapping one cluster each adjacent coil, and splicing with two new steel tie wires placed around the shanks of the two coils between the barb clusters.