



16100 South Lathrop Avenue  
Harvey, Illinois 60426  
(708) 339-1610  
Telex: 28-0172

Installation instructions for barbed tape affixed to a chain link fence:

1. Barbed wire Arms - pressed steel, cast iron or cast aluminum alloy fitted with clips or slots for attaching three strands of barbed wire. Arms shall be set outward on a 45 degree angle and be capable of supporting a 250 pound load at outer barbed wire connecting point without causing permanent deflection. One strand of barbed wire at top for barbed tape placement, arm to point away from secured side, or in lieu of barbed wire:
2. Tension Wire: Marcellled 7 gauge steel wire with minimum coating of 0.80 ounces of zinc or 0.40 ounces of aluminum square foot of wire surface and conforming to ASTM A-824.
3. Tie Wires: stainless steel 18 gauge or 9 gauge galvanized hog rings.
4. Barb Wire: 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.
5. Ground Stakes: #3 rebar, galvanized, 18" long, 12" in ground with candy cane type hook to secure the barrier in place.
6. For fence tops and fence/fabric barriers of 24" barbed tape or larger attach at 2 points about their circumference. On barb wire arms attach to barb wire between barbs and fence fabric, maintaining appropriate spacing. For top wire extend line posts every 50' to support wire. See illustration
7. For use with tension wire attach to tension wire and fence fabric.
8. Procedure for barbed tape installation: Provide labor and equipment necessary to attach the required number of rolls of barbed tape obstacle to the fences and ground along the specified perimeter length. Placement of security wire to be as shown on the drawings,



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- A. Extend barbed tape rolls to full length. The spacing between coils of extended rolls shall be 12 inches or as recommended, When installed, the rolls shall be the manufacturers recommended length.
- B. Attach successive rolls of barbed tape to each other to form one continuous obstacle. Ends of each roll are to be connected to the beginning of the next roll so the attachments of the second roll match those at the end of the first roll. The rolls are to be connected together with wire ties or hog rings at the points where the coils would have been attached if one continuous unit had been fabricated. Attachments should be placed between 2 barb clusters to prevent slippage.
- C. Where barbed tape rolls are placed on the ground, anchor each roll to the ground at intervals using 2 ground stakes per 25 ft., of 18" galvanized ground anchors as recommended by the barbed tape manufacturer.
- D. Secure rolls of barbed tape to the side of the fences by preparing the rolls as described for ground installation. Attach each coil loop to the fence fabric with stainless steel wire ties or galvanized hog rings. Attachment shall be made at the points where the coils intersect the fence fabric.



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## Double Coil Concertina Installation Instructions

### Recruired Equipment and Material

1. Bolt Cutters
2. Tin Snips
3. Twister Tool
4. Gloves - Leather or Rubberized
5. Tape Measure
6. Wire Ties
7. Double Coil Concertina

### Instructions - use Caution at all times

1. Remove one coil at a time from cardboard box.
2. Place coil in upright position on the ground.
3. Cut and remove wire ties holding the coil tightly together.
4. Have one person hold the coil while a second individual stretches the coil to its proper length with the approximate spacings required.
5. If barbs become entangled, a third person will be used to disengage the barbs from each other.

NOTE: The coils may have a tendency to spring out when the barbs are released.

### Top of Fence

6. With the coil stretched to its appropriate displaced length, and using a single strand of wire or barbed wire as a support, tie each end loop of the outer coil to the wire strand with a wire tie.
  - A. Hook one barb of a barb cluster to the wire strand.
  - B. Bend wire tie around the neck of the barbed tape.
  - C. Twist wire tie around barbed tape and wire strand.
7. Attach the First and last loop of outer diameter coil to the chain link fabric using above procedure.
8. Hook the barb loops of the remaining loops at the designated spacings.



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9. From the other side of the fence away from the barbed tape, go back and tie each outer diameter coil loop to the wire strand and to the fence at the required spacings utilizing how the barbed tape is positioned.
10. If required, tie inner coil loops to the chain link fabric also or to the wire strand.

#### Middle of Fence

11. With the coil stretched to its appropriate displaced length, tie each end loop of the outer coil to the fence.
12. Hook the barb loops of the remaining loops at the designated spacings.
13. From the other side of the fence away from the barbed tape, go back and tie each outer diameter coil loop to the fence at the required spacings utilizing how the barbed tape is positioned.
14. If required, tie inner coil loops to the chain link fabric also.

#### Ground Barrier

15. Use 12-18" stakes every 10 feet.
16. Use the same procedure tying barbed tape to the fence as shown in steps 11-14.

#### Splicing

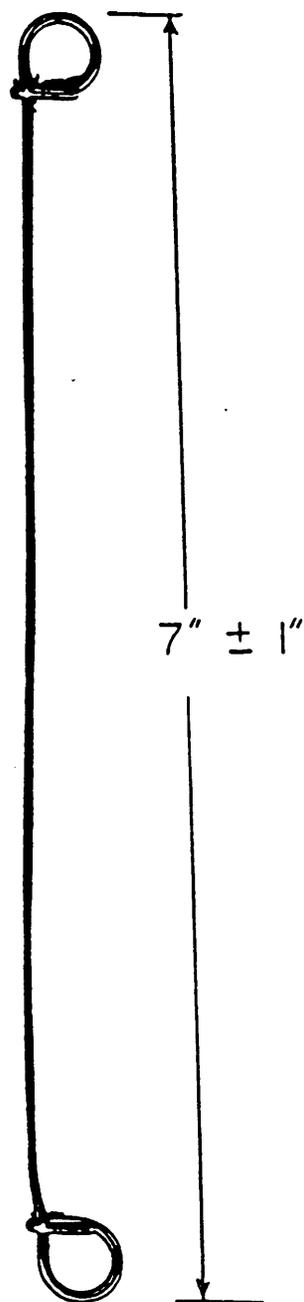
To splice two coils together, wire tie the tail of the first coil to the first loop of second coil and wire tie the tail of the second coil to the last loop of the first coil.

\* Registered



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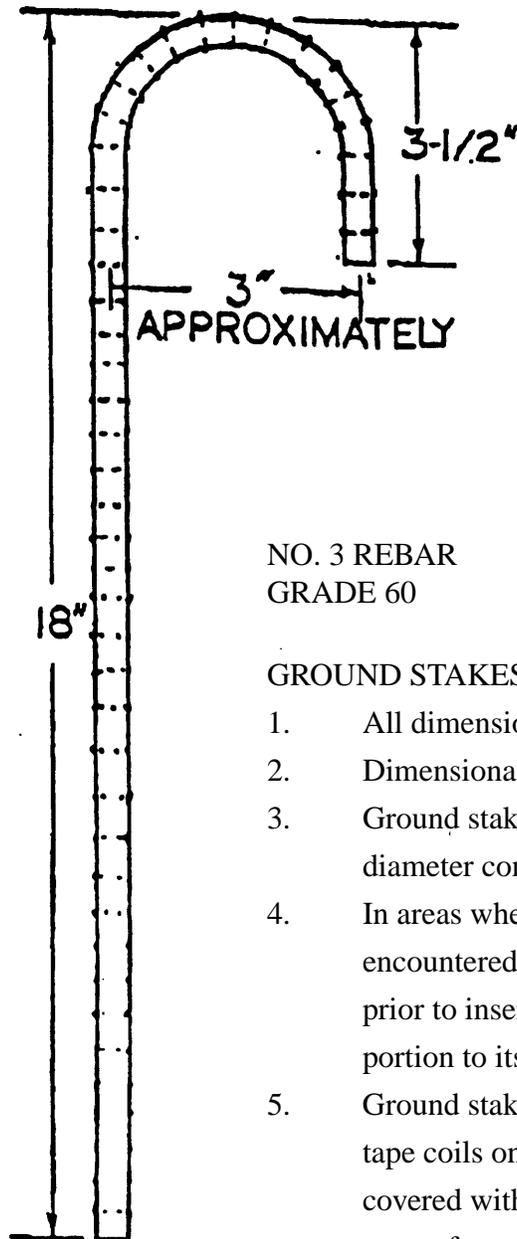
STAINLESS STEEL TIES  
18 GAUGE  
LOOPEd ON EACH END  
TO RECEIVE TWIST TOOL.



TWISTABLE WIRE TIE



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NO. 3 REBAR  
GRADE 60

#### GROUND STAKES

1. All dimensions are in inches.
2. Dimensional tolerances are +/- 1.0 inches.
3. Ground stakes are fabricated from 3/8" diameter concrete reinforcing bar, grade 60.
4. In areas where hard clay or rock is encountered, pilot the hole at least 12" deep prior to inserting stake. Drive the remaining portion to its full depth.
5. Ground stake hooks will encompass barbed tape coils on the ground. Stakes should be covered with gravel, crushed stone, or dirt to camouflage their location.

*ALLIED TUBE & CONDUIT  
BARBED TAPE SPECIFICATIONS  
& ATTACHMENTS*

**NON-REINFORCED - (NO CORE WIRE)**

- STRIP - 301 austenitic stainless steel per ASTM A 666. Rockwell (30N) 50-55.  
Instabarrier & GPBTO Type II.
- WELDS - 400# pull load
- CABLES - One - 7 x 7 stainless steel cable, 3/64" x 5/64" (has coating) min. diameter.  
Instabarrier only.
- CABLES - Four - 7 x 7 stainless steel cables, 3/63" (no coating) min. Diameter.  
GPBTO Type II
- OFFSET BARB - Alternately offset .15" - .45" from the plane of the Flange. (Instabarrier only).

**REINFORCED - (WITH CORE WIRE)**

- STRIP - AISI 430 stainless steel per ASTM A 176. Rockwell (30N) 35-40 min.  
Ferritic Stainless Steel = magnetic, ductile, easily formed, not easily welded
- STRIP - Galvanized per ASTM A 653 with a G60-G90 coating. Rockwell (15T) 80-85.
- CORE WIRE - 300 series austenitic stainless steel per ASTM A 580 or A 478.  
130,000 psi (130 ksi) min. Austenitic Stainless Steel = nonmagnetic, high  
tensile strength core wire, forming limitations
- CORE WIRE - Galvanized per ASTM A 764, Finish 2, Class II, Type 3 (.8 oz/ft<sup>2</sup> zinc)  
220,000 psi (220 ksi) min.
- CLIPS - 200# pull load. Stainless Steel
- CABLES - (Double Coil Only) Four - 7 x 7 stainless steel cables, attached at ends only,  
3/64" (no coating) minimum. Diameter, crimped with aluminum  
compression sleeves.
- HOOK BARB - Barb is angled approx. 24° above the center line of the tape, with a retainer  
barb located 0.70" +/- 0.05" from the barb tip. Retaining barb shall be 0.10"  
nominal length.
- OFFSET BARB - Alternately offset 15" - .45" from the plane of the flange. (Does not apply to  
Detainer Hook Barb).
- FLANGES - Cut away at each barb root to permit maximum barb penetration.

**NOTES ON ROCKWELL HARDNESS:** Some specs show 40-45 rather than 35-40. At hardness greater than 40, difficult to accomplish the 230° wrap around core wire, particularly as hardness approaches 45. Cracks not visible to the naked eye on strip can be present.

**ATTACHMENTS**

- HOG RINGS - 12 1/2 gauge galvanized (or stainless) steel
- TIE WIRES - 18 gauge galvanized (or stainless) steel.
- TIE WIRES - 16 gauge galvanized (or stainless) steel.
- GROUND STAKES - Galvanized 3/8" rebar x 18" long
- BARBED WIRE - Galvanized per ASTM A 121, Class 3. 12.5 gauge wire. 14 gauge barb.