

Rectangular wire for zip fasteners



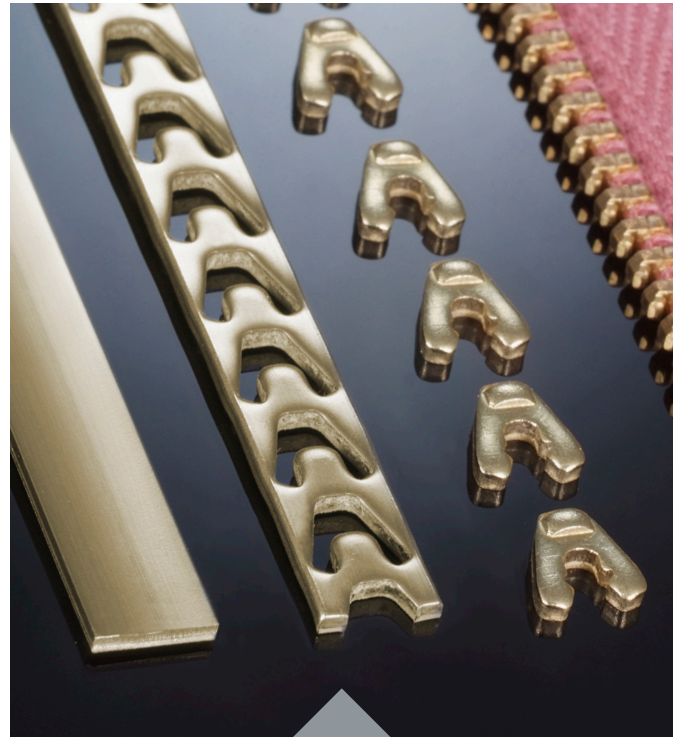
Rectangular wire for zip fasteners

Rectangular wire from Wieland has excellent processing properties and is used for zippers in clothing and bags of global brands.

The pre-material for the flat wire is hot worked, so that the cast structure is completely transformed into a homogeneous wrought structure. This ensures consistently good cold working properties as required for the correct form of the stamped teeth.

The rectangular wire has a metallic bright surface resulting in long stamping tool life. The bright material is characterized by excellent polishing and electroplating properties.

Wieland is constantly adapting its alloys to existing and new standards and directives. The entire range of the below mentioned materials meets the requirements of the U.S. CPSIA. The materials most commonly used in the textile industry fulfill the requirements of the OEKO-TEX® Standard 100, which, on request, is explicitly certified in the certificate of conformance. Corresponding OEKO-TEX® certificates are available.



This picture shows the rectangular wire produced by Wieland, the teeth stamped from it and the remaining stamping residue.

The zipper is created by fixing those teeth to a textile ribbon.

Materials

Material	Wieland designation	Standard designation	Colour	Compliance with the standard	Pb content [ppm]	Cd content [ppm]
Brass	M16	CuZn15	golden red	OEKO-TEX® Standard 100 product class I	< 90	< 40
	M34	CuZn30	golden	OEKO-TEX® Standard 100 product class I*	< 90	< 40
Nickel silver	N22	CuNi12Zn24	silvery	CPSIA	< 100	< 100
	N29	CuNi18Zn20	silvery	CPSIA	< 100	< 100
Bronze	B09	CuSn8	red brown antique			

1 ppm = 0.0001 %

* Oeko-TEX® certificate can be created on request..

Available dimensions and mechanical parameters

Material	Width [mm]	Thickness [mm]	¼ hard temper		A10 [%]	HV10
			R _m [N/mm ²]	R _{p0.2} [N/mm ²] Reference value		
M16	2-9	0.4-1.5	400-500	420	> 2	120-150
M34			410-510	430	> 2	130-160
N22		0.4-2.5	480-580	460	> 5	140-170
N29			500-600	480	> 5	150-190
B09		0.4-2.5	400-500	300	> 35	110-140

Other dimensions and tempers as well as combination width/thickness > 10:1 on request.

Reel types and dimensions

Type of reel	Coil outside diameter [mm]	Coil inside diameter [mm]	Coil width [mm]	Coil weight [kg]
Without core	400-600	300	80-200	25-250
Wooden reel S40A with bore 124 mm	560	320	440	250
	630	320	480	500
	800	400	535	1,000
Small plastic reel S35A	560	355	380	200-250
Big plastic reel S35B	630	400	380	350-400



Reel without core



Wooden reel on pallet



Plastic reel

wieland

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