

	Mar-Mac Industries, Inc. 229 Mar Mac Wire Rd. McBee, SC 29101 843-335-5000	<b>Title:</b> Premium Plastic Coated MC Specification	
		<b>MQS No.</b> 5543	<b>Rev. No.</b> 003 - 9/11/2023
		<b>Product Grouping:</b> Merchant Coils	
		<b>Date:</b> 7/23/20	<b>Page</b> 1 of 2
		<b>Responsible Person:</b>	Tracy Gooding

**Premium Plastic Coated Merchant Coil Specification**

**Standard Requirements:** Mar-Mac Industries, Inc. premium plastic coated merchant coils are produced from carbon steel wire that has been “dead-soft” annealed. The wire used to produce the premium plastic coated merchant coils will comply with the ASTM A853 specification unless otherwise stated in this specification. Premium plastic coated merchant coils are typically supplied in 100 and 50 pound catch weight coils. Additional weight increments may be available. Premium plastic coated merchant coils are coated with HDPE polyethylene and are supplied in the Mar-Mac gold color. Other colors may be available upon request. Mar-Mac premium plastic coated merchant coils are produced at our facility in McBee, SC and may be certified “Buy American” upon request. However, the request for “Buy American” certification must be made in advance of production and shipment.

**Chemical Requirements:** The chemical composition of Mar-Mac premium plastic coated merchant coils will comply with a C1006 or C1008 grade as specified in ASTM A510 and ASTM A1040.

**Physical Requirements:**

**Tensile:** The wire will be “dead-soft” annealed. The tensile after processing through the plastic coating process will be 40,000psi to 60,000psi for the core wire.

**Wire Size:** Typical core sizes for Mar-Mac premium plastic merchant coils are 18, 16, 12, 11, and 9 gauges. Core wire sizes are produced to a + or - .001” size tolerance from nominal. During the coating process, there is some size distortion on the core wire sizes due to processing stresses. The distortion is more pronounced on the larger wire gauges.

Below are size tolerances before and after processing:

<b>Gauge</b>	<b>Core Size</b>	<b>Core Range</b>	<b>Core Range after coating</b>	<b>Finish Range with coating</b>
18	.047	.046/.048	.045/.048	.059/.063
16	.063	.062/.064	.061/.064	.076/.079
12	.105	.104/.106	.101/.104	.117/.121
11	.120	.119/.121	.115/.119	.132/.136
9	.148	.147/.149	.141/.145	.161/.165

Note: Diameter and ranges are all listed in inches.

**Bonded HDPE Thickness:** For merchant coils with core gauges of 18, 16, 12, and 11, the bonded thickness is 7 mils, +/-2 mils. For merchant coils with a 9 gauge core, the bonded thickness will be 7mils, +3 / -2 mils.

	<p>Mar-Mac Industries, Inc. 229 Mar Mac Wire Rd. McBee, SC 29101 843-335-5000</p>	<b>Title:</b> Premium Plastic Coated MC Specification	
		<b>MQS No.</b> 5543	<b>Rev. No.</b> 003 - 9/11/2023
		<b>Product Grouping:</b> Merchant Coils	
		<b>Date:</b> 7/23/20	<b>Page 2</b> of 2
		<b>Responsible Person:</b>	Tracy Gooding

**Packaging Requirements:** Mar-Mac premium plastic coated merchant coils will generally be provided on tubular carriers. Each bundle will be secured with four (4) wire ties.

Any additional questions in regard to Mar-Mac premium plastic coated merchant coils can be directed to:

Tracy Gooding  
Director of Technical Operations  
Mar-Mac Industries, Inc.  
(843) 335-5000