



Standard Specification for Cleats, Welded Horn Type¹

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1. Scope

1.1 This specification covers hollow cleats and pads for marine use.

1.2 The cleats shall be used where securing of boat handling lines are required onboard commercial and navy boats and crafts.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 ASTM Standards:

A 36/A 36M Specification for Carbon Structural Steel²

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³

A 385 Practice for Providing High-Quality Zinc Coatings (Hot-Dip)⁴

3. Ordering Information

3.1 Orders for material under this specification shall include the following:

3.1.1 Title, number, and date of this specification,

3.1.2 Quantity,

3.1.3 Size of cleats, and

3.1.4 Packaging, packing, or marking requirements.

4. Materials and Manufacture

4.1 Material:

4.1.1 The horn cleats shall be of galvanized steel, grade 1023W, in accordance with Practice A 385.

4.1.2 The base plate shall be of steel, (carbon 0.35 maximum), in accordance with Specification A 36/A 36M.

4.1.3 All chafing surfaces shall have a 125 μ finish.

4.2 *Manufacture*—The cleats' horns shall be of cast steel, round in shape, and free of burrs or sharp edges. The horns shall be welded to a base plate as shown in Fig. 1 (see Table 1). The weld is to be ground smooth to prevent chafing of ropes. The base plate shall be oval shaped with smooth rounded edges. The dimensions shall be in accordance with Table 1.

5. Packaging

5.1 The packing shall afford protection against deterioration and physical damage during shipment from the manufacturer to the using activity for immediate use.

6. Product Marking

6.1 Containers shall be stenciled with the ASTM standard designation, in black paint with approximately 1 in. (25.4 mm) high letters and numbers with the following information:

6.1.1 Address,

6.1.2 purchase order number, and

6.1.3 Manufacturer's name.

7. Keywords

7.1 base plates; boat handling lines; cleats; hollow cleats; horn cleats; marine; marine cleats; ship; welded cleats

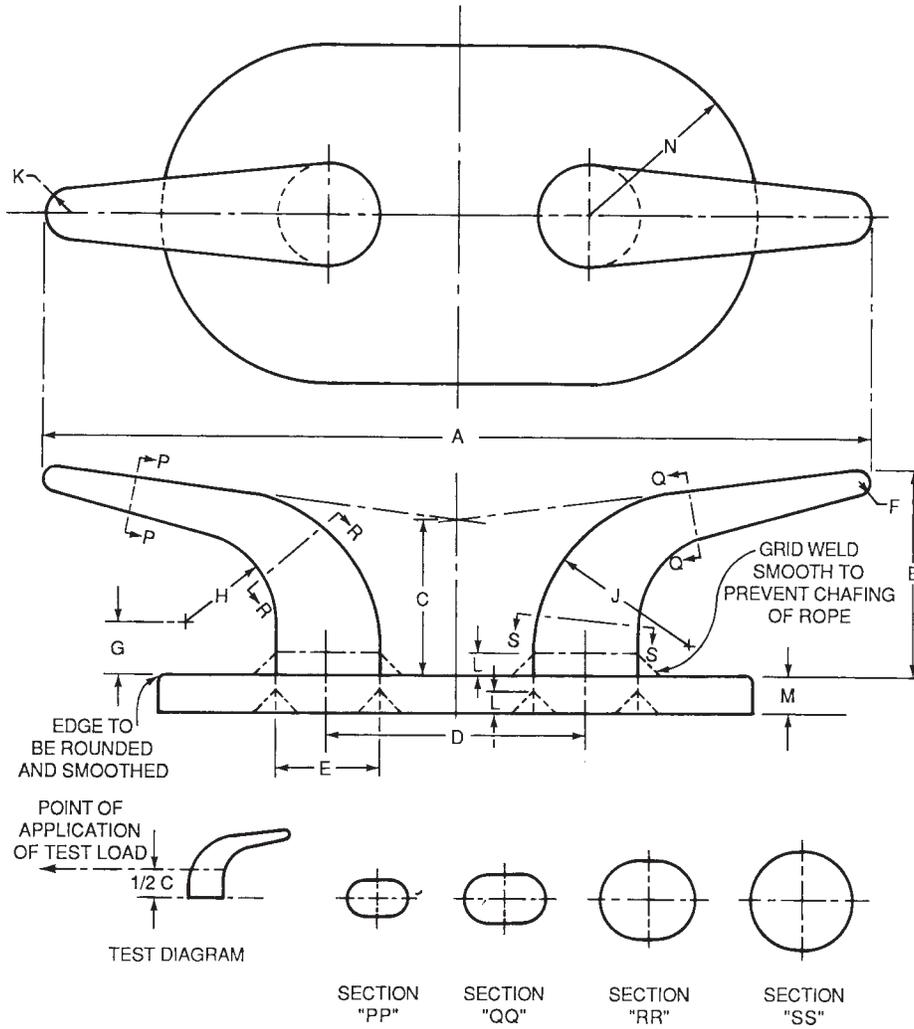
¹ This specification is under the jurisdiction of ASTM Committee F25 on Ships and Marine Technology and is the direct responsibility of Subcommittee F25.03 on Outfitting.

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² *Annual Book of ASTM Standards*, Vol 01.04.

³ *Annual Book of ASTM Standards*, Vol 01.03.

⁴ *Annual Book of ASTM Standards*, Vol 01.06.



NOTE—See Table 1 for dimensions.
FIG. 1 Welded Horn Type Cleat (16 in.)

TABLE 1 Welded Horn-Type Cleat Dimensions

NOTE 1—Table 1 is to be used with Fig. 1.

NOTE 2—1 in. = 25.4 mm.

NOTE 3—1 lb = 0.45 kg.

Cleat													Rope Circumference (in.)				Rope Di- ameter (in.)	Cleats Test Load (lb)	
Dimensions (in.)													Calcu- lated Weight (lb)	Manila	Nylon	Dacron	Polypro- pylene		6 × 37 Fi- ber Core Wire Rope
A	B	C	D	E	F	G	H	J	K	L	M	N							
10	2½	1⅞	3⅞	1¼	⅝	⅝	1⅜	1⅞	⅝	¼	⅞	2	5.3	1¼	1	1	1½		4100
16	4	3	5	2	¼	1	1¾	3	½	⅞	¾	¾	21.7	3	2	2	2½	⅝	9000
24	6	4½	7½	3	⅜	1½	2⅝	4½	¾	¾	1⅞	4½	75	5	3	3	4	½	23 000
30	7½	5⅞	9⅞	3¾	1⅝	1⅞	3⅝	5⅞	1⅝	⅞	1⅝	5½	137	6	3½	4	5	⅝	36 000

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirement shall apply only when specified by the purchaser in the contract or order.

S1. Quality Assurance Provisions

S1.1 Responsibility for Inspection—The purchaser reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirements.

S1.2 Source Inspection—The purchaser reserves the right to inspect the manufacturing process and end product in the supplier’s plant.

S1.3 Tests—The cleats shall meet the test load requirements of Table 1, as tested in accordance with Test Methods and Definitions A 370.

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