



Standard Specification for Industrial and Commercial Horizontal Slide Gates¹

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1. Scope

1.1 This specification covers detailed requirements for cantilever and overhead slide chain link fence gates, gate posts, and accessories for industrial and commercial applications.

1.2 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 780 Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings²

F 567 Practice for Installation of Chain-Link Fence²

F 1043 Specification for Strength and Protective Coatings on Metal Industrial Chain Link Fence Framework²

F 1083 Specification for Pipe, Steel, Hot-Dipped Zinc-Coated (Galvanized) Welded, for Fence Structures²

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *polymer*—as used in this specification, describes poly(vinyl chloride) (PVC) or polyester.

4. Classification

4.1 Horizontal slide gates covered by this specification shall be of the types described in 4.1.1 and 4.1.2.

4.1.1 *Type I—Overhead Slide*—Any horizontal slide gate supported only from above.

4.1.2 *Type II—Cantilever Slide*—Any horizontal slide gate spanning an opening lacking a top or bottom support within that opening. Type II gates shall be supplied in one of two classes:

4.1.2.1 *Class 1*—Steel frame gates and aluminum frame gates using external rollers.

4.1.2.2 *Class 2*—Steel frame gates and aluminum frame gates using internal rollers.

5. Materials and Manufacture

5.1 *Materials*—The base materials of the gate frame shall be round or rectangular tubular members, welded at all corners. However, bolted or riveted, or both, field assemblies of modular panels are permitted.

5.1.1 The interior vertical or horizontal bracing, when needed, shall be the same metal tubular material and finish as the gate frame, but need not be the same size.

5.2 *Manufacture*—Gate frames shall be fabricated, and coated where necessary, as described in 5.2.1 through 5.2.3.

5.2.1 *Zinc-Coated Steel Frames* shall be in accordance with Specifications F 1043 or F 1083, or a combination thereof, and shall match that selected for any adjoining fence framework. Welded joints shall be coated in accordance with Practice A 780, employing a zinc-rich paint conforming to 4.2.2 of Practice A 780 and following only the procedures outlined in A 2.1.3 and A 2.1.4 of Practice A 780.

5.2.2 *Aluminum Alloy Gate Frames* shall be in accordance with Specification F 1043 and shall meet the performance criteria described in this specification.

5.2.3 *Polymer-Coated Steel or Polymer-Coated Aluminum Frames* shall be in accordance with Specification F 1043 and shall match that selected for any adjoining fence framework. Welded joints on steel gate frames shall be coated in accordance with Practice A 780, employing a zinc-rich paint conforming to 4.2.2 of Practice A 780 and following only the procedures outlined in A 2.1.3 and A 2.1.4 of Practice A 780. The painted areas shall then be top-coated to match the frame color.

5.2.4 *Chain Link Gate Fabric*—The fabric shall be as specified for the adjoining fence.

5.2.5 *Barbed Wire Top*—When specified, the barbed wire top shall have extensions to the gate frame to accommodate three strands of barbed wire uniformly spaced and positioned so that the top strand is approximately 1 ft [0.305 m] above the top horizontal member of the gate frame. Barbed wire shall be attached by suitable means to prevent wire from moving out of position and shall be supported by the gate frame extensions at maximum intervals of 10 ft [3.05 m].

¹ This specification is under the jurisdiction of ASTM Committee F14 on Fences and is the direct responsibility of Subcommittee F14.40 on Chain Link Fence and Wire Accessories.

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² *Annual Book of ASTM Standards*, Vol 01.06.

6. Dimensions

6.1 Width of gate opening shall be measured from one inside face to the other inside face of the gate posts.

6.2 Height of gate shall be measured from the finished grade line to the top edge of the gate frame, to match the height of the adjoining fence as measured from the finished grade line to the top edge of the top rail or fabric.

7. Gate Accessories

7.1 All gate hardware shall be of sufficient strength and durability to support the gate and repeated open-close cycles.

7.2 In addition, latches shall have a provision for locking devices.

8. Additional Specifications for Type I Gates

8.1 The specifications given in 8.1.1 through 8.1.7 shall apply only to Type I (overhead slide) gates with opening widths up to 40 ft [12.2 m].

8.1.1 *Materials and Manufacture*—In addition to the welded construction specified in 5.1, the gate frame may be alternatively assembled with corner fittings. Gates assembled with corner fittings shall have adjustable truss rods of $\frac{5}{16}$ in. [7.9 mm] minimum diameter on panels 5 ft [1.52 m] wide or wider. Truss rods shall be of the same base metal and finish as the gate frame.

8.1.2 *Shape and Size*—Shape and size of the gate frame shall conform to procurement drawings or shall be of the shape and size as specified. The gate frame width shall be the width of the gate opening plus the diameter of one gate post.

8.1.3 *Dimension and Weight*—Gate frame members shall have dimensions and weights as described in Table 1.

8.1.4 *Gate Posts*—Gates having an opening width of up to 10 ft [3.05 m] and an overhead clearance of up to 14 ft [4.27 m] shall be supported by steel posts with a nominal outside diameter of 2.875 in. [73.02 mm] and a minimum weight of 4.64 lb/linear ft [6.91 kg/m]. Gates having an opening width larger than 10 ft [3.05 m] but up to 24 ft [7.32 m] with an overhead clearance of up to 22 ft [6.71 m] shall be supported

by steel posts with a nominal outside diameter of 4.00 in. [101.6 mm] and a minimum weight of 6.56 lb/linear ft [9.77 kg/m]. Gates having an opening width larger than 22 ft [6.7 m] but up to 40 ft [12.2 m] and an overhead clearance of up to 22 ft [6.71 m] shall be supported by a double set of steel posts with a nominal outside diameter of 4.00 in. [101.6 mm] and a minimum weight of 6.56 lb/linear ft [9.77 kg/m], or a single set of steel posts with a nominal outside diameter of 6.625 in. [168.3 mm] and a minimum weight of 18.97 lb/linear ft [28.27 kg/m]. For post lengths over 24 ft [7.32 m], a single weld butt joint reinforced by an internal sleeve at least 2 ft [0.61 m] in length will be permitted. Gate posts shall be installed in accordance with Practice F 567.

8.1.5 *Gate Support Member*—The overhead track support member shall be as indicated in the project specifications. The support member shall extend over the gate opening span and the adjacent span at the specified ground clearance. The support member shall be of adequate length to ensure a clear opening. The track and member shall have proper corrosion protection.

8.1.6 *Roller Assembly*—The gate shall be suspended from the overhead track member by means of suitable internal or external roller assemblies. These roller assemblies shall consist of at least two swivel type trucks having sealed lubricant ball bearing wheels, or roller bearing wheels with grease fittings, and include a means to assure that the trucks remain properly aligned in or on the track during all normal operations of the gate.

8.1.7 *Gate Extensions*—Gate extensions, which consist of vertical members which span the distance between the top of the gate and the overhead track, shall be attached to the gate frame by means of a threaded or bolted coupling, or a combination of both.

8.1.8 *Gate Extension Bracing*—Suitable diagonal or horizontal bracing, or both, shall be provided to ensure proper rigidity of the gate during normal operation.

9. Additional Specifications for Type II Gates

9.1 The specifications given in 9.1.1 through 9.1.8 shall apply only to Type II (cantilever slide) gates with opening widths up to 30 ft [9.1 m] and heights (see 5.2) up to 8 ft [2.4 m].

9.1.1 *Shape and Size*—Shape and size of the gate frame shall conform to procurement drawings or shall be of the shape and size as specified. The gate frame width shall be the width of the opening plus the diameter of one gate post, plus an overhang or counterbalance panel of at least 40 % of the width of the opening. Only the size of the opening need be filled with fabric or other specified material. Class 1 and Class 2 gates with tubular steel frames shall conform to the dimensions and weights in Table 2.

9.1.2 *Gate Posts*—Gates having an opening width of up to 12 ft [3.7 m] shall be supported by steel posts with a nominal outside diameter of 2.875 in. [73.03 mm] and a minimum weight of 4.64 lb/linear ft [6.91 kg/m]. Gates having an opening width larger than 12 ft [3.7 m] shall be supported by steel posts with a nominal outside diameter of 4.00 in. [101.6 mm] and a minimum weight of 6.56 lb/linear ft [9.77 kg/m]. Gate posts shall be installed in accordance with Practice F 567.

TABLE 1 Type I Gates—Gate Frame Members, Dimensions and Weights

Gate Fabric Weight	Outside Dimensions		Nominal Weight ^A	
	in.	[mm]	lb/ft	[kg/m]
6 ft [1.8 m] or less				
Round tubular (steel)	1.66	[42.2]	1.83	[2.72]
Rectangular tubular (steel)	1.50	[38.1]	1.84	[2.74]
Round tubular (aluminum)	1.90	[48.3]	0.91	[1.35]
Rectangular tubular (aluminum)	2.00	[50.8]	0.91	[1.35]
Over 6 ft [1.8 m]				
Round tubular (steel)	1.90	[48.3]	2.28	[3.39]
Rectangular tubular (steel)	2.00	[50.8]	2.52	[3.75]
Round tubular (aluminum)	1.90	[48.3]	0.91	[1.35]
Rectangular tubular (aluminum)	2.00	[50.8]	0.91	[1.35]
Interior bracing ^B				
Round pipe (steel)	1.66	[42.2]	1.83	[3.39]
Rectangular pipe (steel)	1.50	[38.1]	1.84	[2.74]
Round tubular (aluminum)	1.90	[48.3]	0.91	[1.35]
Rectangular tubular (aluminum)	2.00	[50.8]	0.91	[1.35]

^AWeight tolerance, $\pm 5\%$.

^BThe gate shall have vertical interior bracing at maximum intervals of 8 ft [2.4 m], and shall have a horizontal interior member if fabric height is 8 ft [2.4 m] or more.

TABLE 2 Gate Frame Members, Dimensions and Weights Type II, Class 1 or Class 2 Gates with Tubular Steel Frames

Gate Opening Width and Height	Outside Diameter of Pipe		Nominal Minimum Weight of Pipe	
	in.	[mm]	lb/ft	[kg/m]
Frame Size				
4 ft [1.2 m] width or less	1.90	[48.26]	2.28	[3.40 kg/m]
6 ft [1.8 m] height or less				
Over 4 ft [1.2 m] width	2.375	[60.325]	3.11	[4.63 kg/m]
All heights				
Interior bracing				
All gates	1.90	[48.26]	2.28	[3.40 kg/m]
Diagonal bracing				
All gates	1.90	[48.26]	2.28	[3.40 kg/m]

9.1.3 *Guide Posts (for Class 1 Gates Only)*—Guide posts for all Class 1 gates equal to the height of the gate shall be installed adjacent to each gate support post (see Fig. 1). The gate shall slide between the gate support posts and the guide posts. Guide posts shall be the same as, or one pipe diameter smaller than, the gate support posts and shall have a minimum weight of 3.11 lb/ft [4.63 kg/m].

9.1.4 *Roller Assembly:*

9.1.4.1 External rollers for Class 1 gates shall be galvanized, malleable iron riding on a caged cylindrical roller or needle bearing. The bearing shall extend a minimum of 90 % of the width of the inside of the roller wheel, turn on a steel axle shaft and be housed within a steel bearing race or sleeve. The bearing shall not ride on any surface of the iron casting. The roller shall be drilled, tapped and equipped with a grease fitting. Roller assemblies shall be secured to the gate posts with a minimum of two 5/8 in. [15.9 mm] diameter “U” bolts, nuts, and lock washers for each assembly.

9.1.4.2 Internal rollers for Class 2 gates shall consist of two swivel type trucks having sealed lubricant ball bearing wheels and a means to assure that the trucks remain properly aligned in the track during all normal operations of the gate.

9.1.4.3 *Top Roller Guards*—Top external rollers for Class 1 gates shall be covered by top roller guards (see Fig. 2). Top roller guards shall be designed to help lessen pinch points, thereby helping eliminate possible injuries from top external rollers. The top roller guards shall be installed to help provide a safe opening from the bottom edge of the guard to the top edge of the gate frame. The maximum opening between the gate frame and the guard shall be 0.25 in. [6.4 mm].

9.1.4.4 *Bottom Protective Plates*—Bottom external rollers for Class 1 gates shall have a bottom roller protective plate attached (see Fig. 2). The bottom protective plate shall be

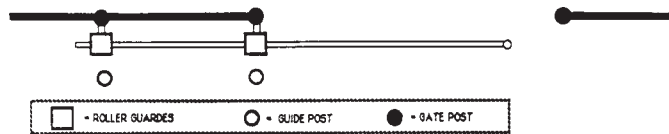
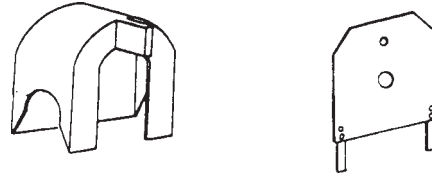


FIG. 1 Post Configuration and Roller Guards



TOP ROLLER GUARD BOTTOM PROTECTIVE PLATE
FIG. 2 Top Roller Guard and Bottom Protective Plate

secured behind the cotter pin (or behind the nut and cotter pin, if used) on the roller axle.

9.1.5 *Performance Criteria*—All Class 2 gates shall perform to the minimum criteria outlined in Table 3 and shall be installed to manufacturer’s specifications. All minimum performance criteria for the fabric or other filler material and other accessories installed shall be met, including a gate operator where specified.

9.1.6 *Field Adjustment*—All gates shall be designed with a means to adjust the vertical alignment of the gate in the field.

9.1.7 *Latching*—All gates shall be designed with sufficient lateral stability to assure that the gate will enter a catcher which has a 12 in. [305 mm] width (6 in. [152 mm] on each side from center) under wind loads as indicated and using the particular means of operation as indicated in the project specifications.

9.1.8 Assembly and installation instructions which clearly outline the proper procedure for all required assembly and proper installation and tuning of the gate shall be included with all gate shipments.

10. Keywords

10.1 cantilever slide; external rollers; gate posts; internal rollers; overhead slide; roller assembly

TABLE 3 Minimum Performance Criteria, Type II, Class 2 Gates

Performance Factor	Maximum Allowable Distances	
	Opening Width Up to 21 ft [6.4 m]	Opening Widths , 21 ft to 30 ft [6.4 m to 9.1 m]
	in. [mm]	in. [mm]
Downward deflection (unloaded) ^A	1/2 [12.7]	1 [25.4]
Downward deflection (loaded) ^A	2 [50.8]	3 [76.2]
Vertical chord ^B	1/2 [12.7]	1 [25.4]
Lateral chord (camber) ^C	1/2 [12.7]	1 [25.4]

^A*Downward deflection, unloaded and loaded*—Measure the gate within 6 in. [152.4 mm] of being fully closed, and without support by devices at the latch end. The measurement is made twice, once with the gate totally unencumbered by any foreign weight, and once with a 200-lb [907-kg] dead weight attached to the front of the gate. The critical measurement is made at the maximum vertical distance between the extension of a straight line drawn at the top of the gate between the two internal truck assemblies, at the point of the two center bolts and the top of the gate at the outermost point of the latch end of the gate.

^B*Vertical chord*—Measure the maximum vertical distance between a straight line drawn between the two top ends of the gate and any point on the top of the gate.

^C*Lateral chord (camber)*—Measure the maximum lateral distance between a straight line drawn between the two top or the two bottom outside points of the vertical members of the gate and the corresponding lateral member.

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