



Standard Specification for Expanded-Metal Doors¹

This standard is issued under the fixed designation F1072; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers steel expanded-metal doors suitable for installation in expanded-metal bulkheads, structural bulkheads, and structural arches.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

A36/A36M Specification for Carbon Structural Steel

A167 Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip (Withdrawn 2014)³

D3951 Practice for Commercial Packaging

F783 Specification for Staple, Handgrab, Handle, and Stirrup Rung

2.2 *Other Documents:*

ABS Rules for Building and Classing Steel Vessels⁴

AWS D1.1 Structural Welding Code⁵

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 and Deck Machinery.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from American Bureau of Shipping (ABS), ABS Plaza, 16855 Northchase Dr., Houston, TX 77060, <http://www.eagle.org>.

⁵ Available from American Welding Society (AWS), 8669 NW 36 St., #130, Miami, FL 33166-6672, <http://www.aws.org>.

3. Classification

3.1 Expanded-metal doors are furnished in four types (see Detail “J”) as follows:

3.1.1 *Type I*—Right hand (RH).

3.1.2 *Type II*—Left hand (LH).

3.1.3 *Type III*—Right hand reverse (RHR).

3.1.4 *Type IV*—Left hand reverse (LHR).

4. Ordering Information

4.1 Orders for doors under this specification shall include this specification number and type.

5. Materials and Manufacture

5.1 *Materials*—See Table 1.

5.2 *Manufacture:*

5.2.1 Doors shall be furnished with the vertical support channels and top angle in place. A temporary brace shall be included at the frame bottom to prevent racking.

5.2.2 Welding shall be in accordance with AWS D1.1 Structural Welding Code or ABS Rules for Building and Classing Steel Vessels.

6. Installation Requirements

6.1 Doors shall be fitted with rubber-tipped bumpers and a manually operated catch for holding doors in an open position. These shall be furnished and installed by others.

6.2 Provision shall be made for the installation of a rim latch set operated by knobs on both sides. This hardware shall be furnished and installed by others.

6.3 Padlocks shall be furnished by others.

6.4 Any holes needed in the frame for installation in expanded-metal or other types of bulkheads shall be made at installation by others.

7. Dimensions and Tolerances

7.1 Dimensions are as indicated in Figs. 1-8 and Table 1.

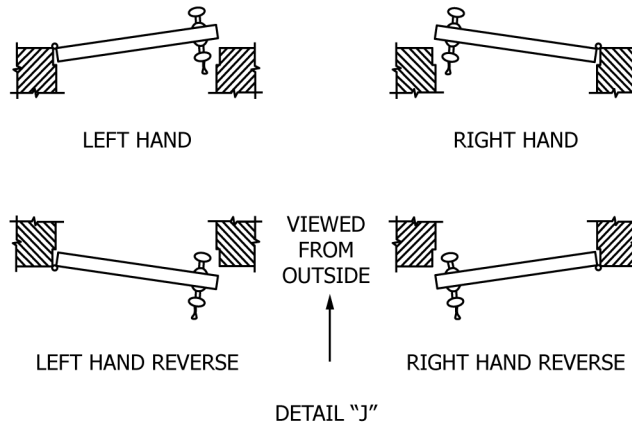
7.2 *Tolerance*— $\pm 1/16$ in. (1.5 mm).

8. Workmanship, Finish, and Appearance

8.1 Doors and frames shall be free from all cracks, burrs, sharp edges, and other defects.

TABLE 1 Expanded-Metal Door Materials

NOTE 1—1 in. = 25.4 mm.



Item Number	Description
1	Frame Top—Angle, 6 × 3½ × 5/16 in., Specification A36/A36M.
2	Frame Side—Channel, C3 × 5.0, Specification A36/A36M.
3	Staple—Round bar, Specification F783.
4	Door Frame—Angle, 1¼ × 1¼ × ¼ in., Specification A36/A36M.
5	Brace—Flat bar, 2 × ¼ in., Specification A36/A36M.
6	Cross Brace—Flat bar, 2 × ¼ in., Specification A36/A36M.
7	Stop—Flat bar, 4 × ¼ in., Specification A36/A36M.
8	Pad—Flat bar, 4 × ¼ in., Specification A36/A36M.
9	Hinge—Swaged butt, plain, fixed pin, 3- × 2½-in. Type 316 stainless steel, Specification A167.
10	Expanded Metal—13-gage × ½-in. flat pattern, Specification A36/A36M.
11	Temporary Brace—Angle 1¼ × 1¼ × ¼ in., Specification A36/A36M. (See 5.2.1.)

8.2 The door manufacturer shall apply a nonhazardous corrosion-inhibiting primer coating to all door assemblies.

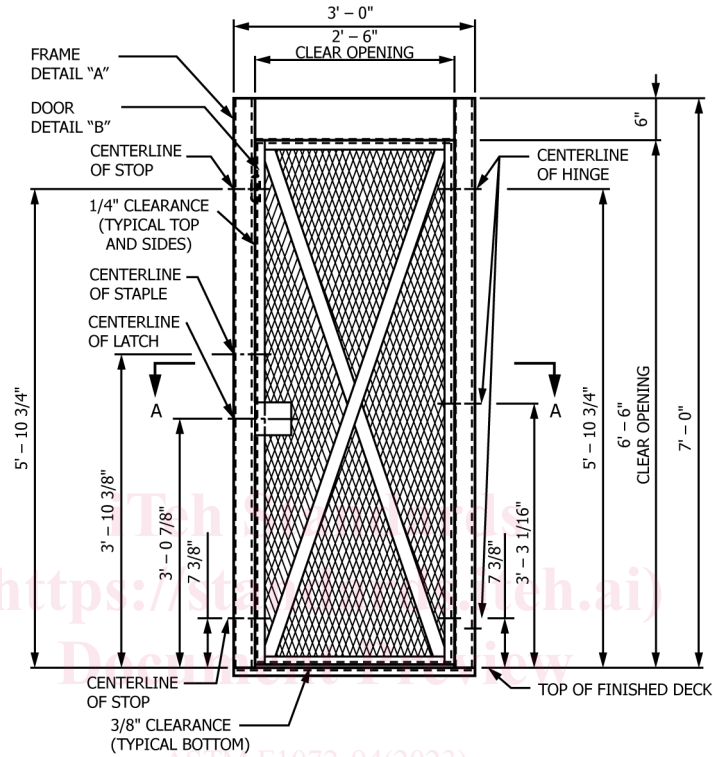
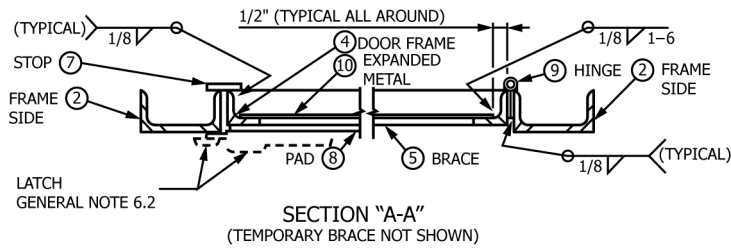
9. Packaging and Package Marking

9.1 Each expanded-metal door shall be individually packed for shipment and storage in accordance with Practice D3951.

9.2 In addition to any special marking required by the contract or purchase order, each expanded-metal door shall be marked in accordance with Practice D3951.

10. Keywords

10.1 expanded-metal bulkheads; expanded-metal doors; metal doors; structural arches; structural bulkheads



NOTE 1—1 in. = 25.4 mm.

FIG. 1 Right-Hand Door and Frame Assembly—Type I (Left Hand, Type II Not Shown) - f1072-942023

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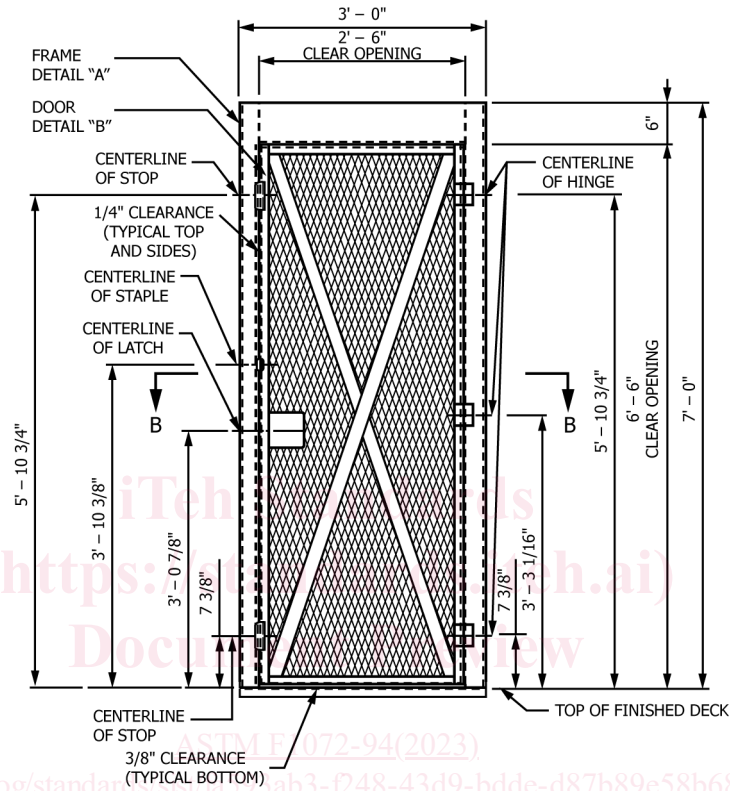
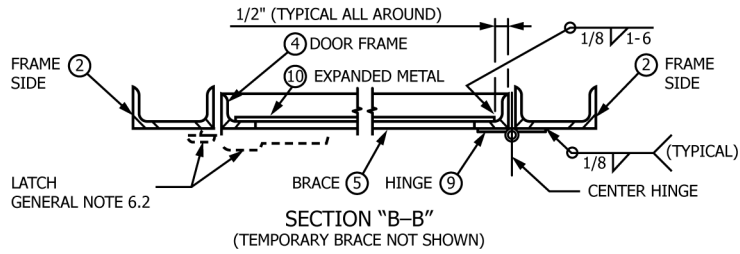


FIG. 2 Right-Hand Reverse Door and Frame Assembly—Type III (Left Hand, Type IV Not Shown)