



Designation: F1184 – 05

Standard Specification for Industrial and Commercial Horizontal Slide Gates¹

This standard is issued under the fixed designation F1184; 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 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 standard. The values given in brackets are for information only.

2. Referenced Documents

2.1 *ASTM Standards*:²

[A780 Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings](#)

[F567 Practice for Installation of Chain-Link Fence](#)

[F1043 Specification for Strength and Protective Coatings on Steel Industrial Chain Link Fence Framework](#)

[F1083 Specification for Pipe, Steel, Hot-Dipped Zinc-Coated \(Galvanized\) Welded, for Fence Structures](#)

[F2200 Specification for Automated Vehicular Gate Construction](#)

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 5.2.6. For gates intended to be automated, manufacture shall conform to the applicable provisions of Specification F2200.

5.2.1 *Zinc-Coated Steel Frames* shall be in accordance with Specifications F1043 or F1083, or a combination thereof, and shall match that selected for any adjoining fence framework. Welded joints shall be coated in accordance with Practice A780, employing a zinc-rich paint conforming to 4.2.2 of Practice A780 and following only the procedures outlined in A 2.1.3 and A 2.1.4 of Practice A780.

5.2.2 *Aluminum Alloy Gate Frames* shall be in accordance with Specification F1043 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 F1043 and shall match that selected for any adjoining fence framework. Welded joints on steel gate frames shall be coated in accordance with Practice A780, employing a zinc-rich paint conforming to 4.2.2 of Practice A780 and following only the procedures outlined in A 2.1.3 and A 2.1.4 of Practice A780. 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, except that the

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.

Current edition approved July 1, 2005. Published August 2005. Originally approved in 1988. Last previous edition approved in 2003 as F1184 - 03. DOI: 10.1520/F1184-05.

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.

minimum height for barbed wire installed at the top of gates intended to be automated shall be in accordance with Specification **F2200**. 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].

5.2.6 *Barbed Tape*—The minimum height for barbed tape installed at the top of gates intended to be automated shall be in accordance with Specification **F2200**.

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

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.

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 **F567**.

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