



Designation: F654 – 07 (Reapproved 2012)

Standard Specification for Residential Chain Link Fence Gates¹

This standard is issued under the fixed designation F654; 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 detail requirements for residential chain link fence gates, gate posts, and accessories.

2. Referenced Documents

2.1 *ASTM Standards*:²

A780 Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings

F1043 Specification for Strength and Protective Coatings on Steel Industrial Fence Framework

F626 Specification for Fence Fittings

3. Classification

3.1 Residential chain link fence gates are classified as follows:

3.1.1 *Type I*—Single Swing

3.1.2 *Type II*—Double Swing

3.2 No gate leaf over 6 ft (1.829 m) in height or over 6 ft (1.829 m) in width shall be classified as residential, regardless of use or location.

4. Manufacture

4.1 Zinc-coated steel frames shall be zinc-coated in accordance with the zinc coating specified for the fence framework. Welded joints shall have suitable rust preventive coating applied to the welds.

4.2 Aluminum gate frame shall be the same base material and alloy as specified for the fence framework. Aluminum gate frames may be assembled with corner fittings.

4.3 Polymer-coated steel or aluminum frame shall be polymer coated as specified for framework. Polymer-coated steel frames may be assembled with corner fittings. Welded joints shall have suitable preventive coating applied to the welds.

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, 2012. Published October 2012. Originally approved in 1980. Last previous edition approved in 2007 as F654 - 07. DOI: 10.1520/F0654-07R12.

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.

NOTE 1—The word polymer is used to describe all types of heat set organic exterior coatings and is not applicable to metallic coatings, such as zinc or aluminum.

5. Gate Frames, Fabric, Attachment, and Finish

5.1 *Gate Frames* shall be of aluminum or steel tubing, round or square, and assembled by means of corner fittings or welded, or formed by bending. The bend should be smooth and continuous.

5.1.1 *Corner Fitted and Welded Gates* shall have vertical and horizontal interior members spaced so that no horizontal dimension between outside members shall be greater than 5 ft (1.524 m), and no vertical dimension between members shall be greater than 5 ft (1.524 m).

5.2 *Fabric* shall match that of the line fabric adjacent to the gate opening or as required by specifications or drawings, or both. However, fabric having a breaking strength equivalent to or greater than the fabric used in the line of fence may be used.

5.3 *Attachment of Fabric to Gate Frame*—Stretch the fabric so it is taut and fastened to frames by one of the following methods:

5.3.1 Place a round rod or flat bar through the fabric and fasten with clips or bands, at a maximum spacing of 12 in. (305 mm) on center, of sufficient strength to hold fabric taut between the vertical frame members. Clips or bands shall conform to the profile of the frame members.

5.3.2 Place a round rod or flat bar through the fabric and fasten with a J-bolt through the holes in the frame.

5.3.3 Fasten all fabric to horizontal frame members and to any interior frame members by means of clips, tie wires, or bands suitable to retain the fabric to the frame members. Spacing should be at a maximum of 18 in. (450 mm) apart.

6. Dimensions and Weights (of Gate Frames and Gate Posts)

6.1 *Dimension (Height)*:

6.1.1 The vertical dimension (height) of the gate should be 2 in. (60 mm) less than the specified height of the adjacent fence.