



Standard Specification for Doors, Non-Tight, for Marine Use¹

This standard is issued under the fixed designation F 1070; 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 to be used in conjunction with Specification F 1073, covers the principal dimensions and the mechanical requirements for manufacturing steel, aluminum, and glass-reinforced plastic non-tight, personnel doors and dutch doors, with the exception of joiner, joiner dutch doors, and expanded metal doors, for marine use.

1.2 The doors will be used in non-tight bulkheads.

1.3 When fire protection requirements are applicable to the location of these doors, then the use of aluminum and glass-reinforced plastic doors shall be unacceptable.

1.4 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 131/A 131M Specification for Structural Steel for Ships²

B 209 Specification for Aluminum and Aluminum-Alloy Sheet and Plate³

F 1073 Specification for Door Fittings, for Watertight/Gastight/Airtight, Weathertight, and Non-Tight Doors, for Marine Use⁴

2.2 ABS Standard:

Rules for Building and Classing Steel Vessels⁵

2.3 Military Standards:

MIL-P-17549 Plastic Laminates, Fibrous Glass Reinforced, Marine Structural⁶

MIL-R-21607 Resins, Polyester Low-Pressure Laminating, Fire Retardant⁶

MIL-P-24441 Epoxy-Polyamide Paint⁶

MIL-C-81706 Coating, Aluminum and Aluminum Alloys⁶

TT-E-490 Enamel, Silicone Alkyd Copolymer, Semi-gloss, Exterior⁶

DoD-STD-2138 Metal Sprayed Coating Systems for Corrosion Protection⁶

3. Ordering Information

3.1 Ordering for doors under this specification shall include the following:

3.1.1 Type of door and material (see Table 1 and Figs. 1-3),

3.1.2 Nominal and ASTM designations,

3.1.3 Quantity, hand of door (right hand or left hand, or both), and

3.1.4 Optional items, such as fixed lights, door locks, to be indicated.

3.2 Inspection and acceptance of doors shall be agreed upon between the purchaser and the supplier.

4. Materials and Manufacture

4.1 The materials and specifications shall be as given in Table 1.

4.2 Glass-reinforced plastic (GRP) material of doors shall meet the requirements of MIL-P-17549, Grade 1. In addition, laminate must have the flammability limits equal to the requirements for Grade 2, Class A of MIL-R-21607.

5. Construction, Shape, and Dimensions

5.1 The construction, shape, and clear opening dimensions shall be as shown in Tables 1 and 2 and Figs. 1-3 and conform to the following requirements:

5.1.1 A right-hand opening door shall be construed as one that opens towards you with hinges located on right side of door. A left-hand opening is similar but with hinges on the left.

5.1.2 The size of the door opening and shape shall be as given in Table 2.

5.1.3 Figs. 1 and 2 show the right-hand opening, and in the case of left-hand opening, the arrangement of fittings shall be reversed.

5.1.4 The position of the grab handles shall be located on the center of the height of both sides of the door; in the case of dutch doors, the location of the grab handles shall be suitably positioned in the top panel.

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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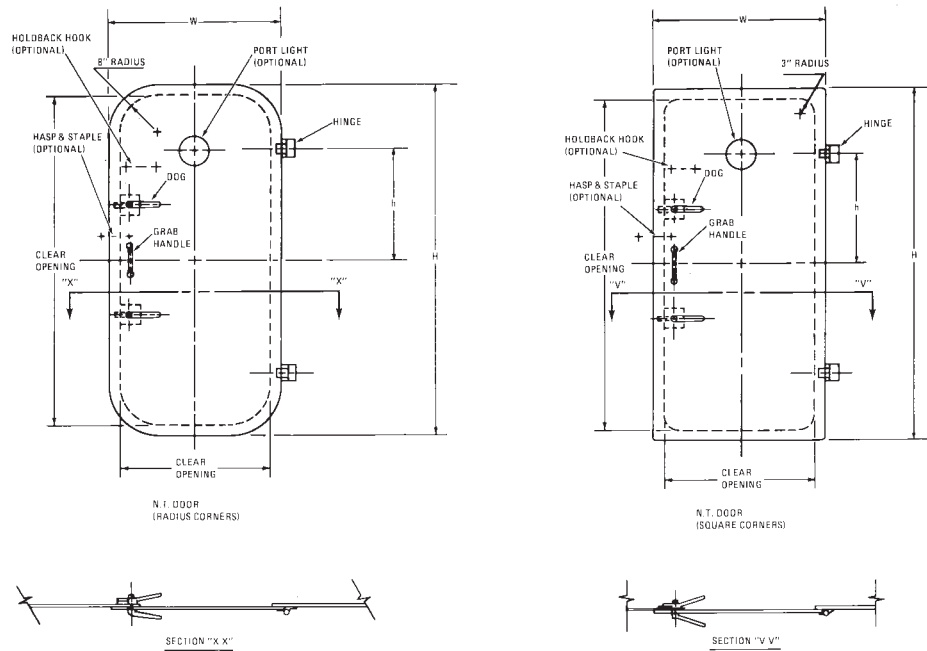
² Annual Book of ASTM Standards, Vol 01.04.

³ Annual Book of ASTM Standards, Vol 02.02.

⁴ Annual Book of ASTM Standards, Vol 01.07.

⁵ Available from American Bureau of Shipping, ABS Plaza, 16855 Northchase Dr., Houston, TX 77060.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.



NOTE 1—1 in. = 25.4 mm.

FIG. 1 Non-Tight Doors (Square Corners)

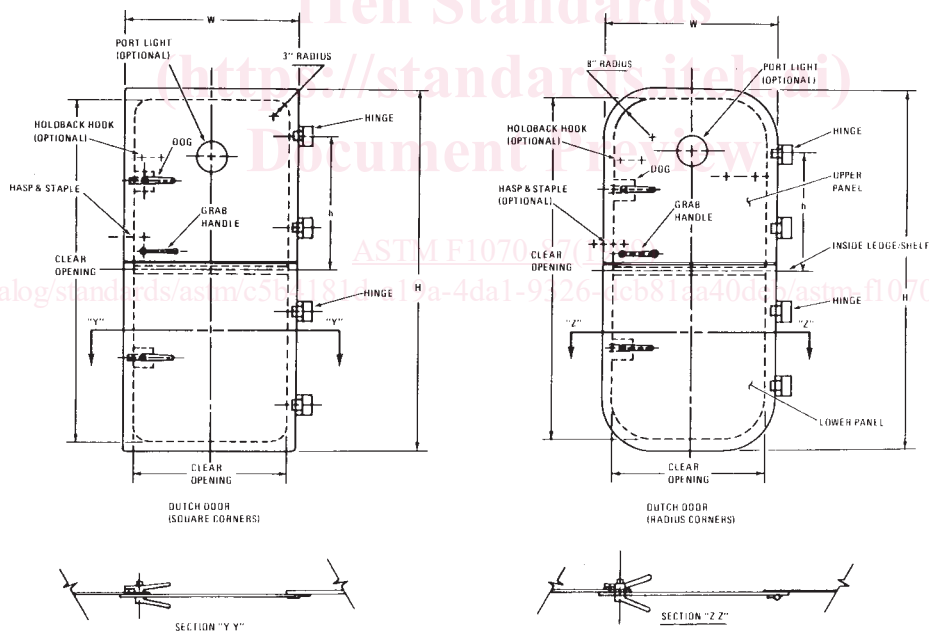


FIG. 2 Non-Tight Doors (Radius Corners)

5.1.5 The material of the standard door components shall be as shown in Table 1.

5.1.6 Doors shall be fitted with dogs, hinges, hasp and staple assemblies, grab handles, label plates, and hook assemblies; for details, see Specification F 1073.

5.1.7 Welding shall be done in accordance with the Rules of American Bureau of Shipping.

6. Workmanship, Finish, and Appearance

6.1 All sharp and ragged edges shall be ground flush and removed for personnel protection.

6.2 Pretreatment and priming of door components shall be as follows: