

RR-F-191/2D
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SUPERSEDING
RR-F-191/2C
July 22, 1981

FEDERAL SPECIFICATION SHEET

FENCING, WIRE AND POST, METAL (CHAIN-LINK FENCE GATES)
(DETAIL SPECIFICATION)

This Federal Specification is approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

(This specification forms a part of the latest issue of Federal Specification RR-F-191K/GEN).

1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers detail requirements for chain-link fence gates, and accessories.

1.2 Classification. Chain-link fence gates will be of the following types, as specified (see 6.1):

- Type I - Single swing.
- Type II - Double swing.
- Type III - Single cantilever sliding, wheel sliding gate.
- Type IV - Double cantilever sliding.
- Type V - Single overhead sliding.
- Type VI - Double overhead sliding.
- Type VII - Vertical lift.
- Type VIII - Special.

2. APPLICABLE DOCUMENTS (Not applicable).

Beneficial comments (recommendations, additions, deletions) and any pertinent
 *data which may be of use in improving this document should be addressed to: *
 *Commanding Officer (Code 156), Naval Construction Battalion Center, Port *
 *Hueneme, CA 93043-5000, by using the self-addressed Standardization *
 *Document Improvement Proposal (DD Form 1426) appearing at the end of this *
 *document or by letter. *

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3. REQUIREMENTS

3.1 Design. Detailed construction requirements for all gates shall be as specified (see 6.1), and shall meet the applicable requirements of this specification. Gate frames shall be of welded construction or shall be assembled using fittings. When fittings are used as the construction method for gate frames, the frames shall be fitted with 5/16-inch minimum diameter truss rods. All gates shall be constructed so that they may be operated by one person.

3.1.1 Color coating and material. When color coating is required the color shall be as specified (see 6.1), and shall match the color specified for chain-link fabric as cited in RR-F-191/1D. Steel frames shall be zinc-coated prior to application of color coating. Unless otherwise specified (see 6.1), color coating material shall be at the option of the manufacturer.

3.2 Frames. Gate frames shall be constructed from applicable class, size, and grade members selected from RR-F-191/3D as specified (see 6.1).

3.2.1 Welded zinc-coated frames. When specified (see 6.1), the frames shall be zinc-coated by the hot dip or metal spray method after fabrication. When frames are not zinc coated after fabrication the welds shall be coated with a zinc rich paint or cold zinc spray.

3.2.2 Color coated frames. When color coated frames are required and the frames are of welded construction, all weld areas shall be finished with a suitable rust preventative coating and a matching color final coating.

3.3 Fabric. Gate fabric shall be selected from RR-F-191/1D and shall be of the type, size of mesh, gage size of wire, color, and selvage as specified (see 6.1).

3.4 Barbed wire top. When barbed wire top is specified (see 6.1), the end members of gate frames shall extend 1 foot above the top horizontal section of the gate frame. Three strands of barbed wire, uniformly spaced, shall be attached by bands, clips or eyebolts.

3.5 Latches, hinges, stops, and keepers. Latches, hinges, stops and keepers shall be zinc-coated steel or color coated over zinc-coated steel, or aluminum coated steel as specified (see 6.1). When zinc coating is required, the weight of zinc coating shall be 1.2 ounces per square foot unless otherwise specified (see 6.1). When aluminum coating is required, the weight of aluminum coating shall be not less than 0.4 ounces per square foot.

3.5.1 Single gate latches. Single gate latches shall be fork type, gravity drop bar type with positive locking features, or plunger bar type of full gate height as specified (see 6.1).

3.5.2 Double gate latches. Latches for double gates shall be fork type latch with center drop rod, or plunger bar type of full gate height arranged to engage the gate stop, or a positive locking gravity device as specified (see 6.1). Locking devices shall be constructed so that the center drop rod or plunger bar cannot be raised when locked.

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3.5.3 Stops. Center gate stop shall be provided for all double gates and shall be suitable for setting in concrete or with anchors for the center drop rod or plunger.

3.5.4 Keepers. Keepers shall be provided for each gate leaf over 5 feet wide. Gate keepers shall consist of a mechanical device for securing the free end of the gate when in full open position.

3.5.5 Gate hinges. Gate hinges shall be of adequate strength for the gate, and shall have large bearing surfaces for clamping or bolting in position. Hinge action shall be such that gates may be easily opened and closed by one person. Hinges shall provide for full 180 degree swing of gate leaf.

3.6 Rollers. Rollers shall be equipped with bearings. Non-sealed type bearings shall be provided with a grease fitting for periodic maintenance. Rollers shall be secured to the gate post or gate frame without welding. Unless otherwise specified (see 6.1), rollers shall be enclosed.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. (See RR-F-191K/GEN)

4.2 Sampling. (See RR-F-191K/GEN, section 6)

4.4 Examination. Examine gates for defects listed in table I.

TABLE I. Classification of defects gates.

-----	* Defects	Major	Minor	*-----*
*	*Type of gate not as specified.	X		*
*	*Materials not as specified.	X		*
*	*Color not as specified.	X		*
*	*Truss rods missing or less than 5/16-inch diameter.	X		*
*	*Dimensions not within tolerance.	X		*
*	*Welds not painted or protected against corrosion		X	*
*	*Gate construction not as specified.	X		*
*	*Damage or defects affecting function or serviceability.	X		*
*	*Damage or defects not affecting function or serviceability.		X	*

5. PREPARATION FOR DELIVERY (See RR-F-191K/GEN)

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

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6.1 Ordering data. Purchasers should select the preferred options permitted herein and include the following information in acquisition documents:

- a. Title, number, and date of this specification.
- b. Type of gate required (see 1.2).
- c. Design and construction of gate required (see 3.1).
- d. When color coating is required and color (see 3.1.1).
- e. When color coating material is other than specified (see 3.1.1).
- f. Class, grade, and size of wire, color, and selvage for fabric required (see 3.3).
- g. When barbed wire top on gate is required (see 3.4).
- h. Coating required on latches, hinges, stops, and keepers, and weights of coatings if other than that specified (see 3.5).
- i. Type latch required (see 3.5.1 and 3.5.2).
- j. When rollers are other than specified (see 3.6).

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