



CHAIN LINK FENCE MANUFACTURERS INSTITUTE

**GUIDE FOR SPECIFYING HIGH SECURITY
CHAIN LINK FENCE AND GATES**

32 31 13.53

(CLF-HSF 0518)

May, 2018

Chain Link Fence Manufacturers Institute

10015 Old Columbia Road Suite
B215 Columbia, MD 21046
Ph: 301-596-2583 Fax: 301-596-2594
Email: clfmihq@aol.com
www.chainlinkinfo.org

Copyright (c) 2018
All Rights Reserved



CLFMI Technical Support Team

To get answers to your questions regarding the content or usage of the information contained in this publication, contact one of these fence industry professionals for assistance.

BILL ULLRICH	email: bullrich.link@comcast.net	Ph: 443-562-7112
CHUCK NAEGELE	email: canaegele@aol.com	Ph: 570-430-1337
STEVE PETERS	email: smpeters@ldpeters.com	Ph: 914-576-5100
TED EYSENBACH	email: teysen@spsfence.com	Ph: 1-800-451-2612
TOM STANEK	email: tom.stanek@wheatland.com	Ph: 1-800-257-8182
BILL PETERSON	email: bill@richardsfence.com	Ph: 330-773-0423

CHAIN LINK FENCE MANUFACTURERS INSTITUTE GUIDE FOR SPECIFYING

HIGH SECURITY CHAIN LINK FENCE AND GATES (CLFS 2445.53)

May 2018

DEVELOPING A HIGHER SECURITY CHAIN LINK FENCE AND GATE SPECIFICATION 32 31 13.53

REVIEW THE FOLLOWING PRIOR TO DEVELOPING YOUR SPECIFICATION

**= available online at www.chainlinkinfo.org*

- 1. CLFMI Product Manual, CLF-PM 0610***, to become familiar chain link fabric gauges, coatings, and configurations, framework, fittings, terms and standard drawings.
- 2. Security Fencing Recommendations, CLF - SFR 0111***
- 3. Wind Load Guide for the Selection of Line Posts and Line Post Spacing, WLG -2445***
- 4. CLFMI Tested Proven Performance*** to review actual testing per ASTM F2781, Standard Testing Forced Entry, Ballistic, And Low Impact Resistance of Security Fence Systems.
- 5. SECURITY LEVELS (chain link fabric configurations for various security levels)**

3/8" 11 gauge...Deters climbing and very time consuming to cut thru, border fence, prisons, warehouse, chemical plants and refineries, interior partition secure areas, secure areas within a fenced in area, military and government secure areas interior and exterior, higher security electrical generating, transmission and substations. Provides level of impact resistance. Visually very intimidating. *Above average ASTM F2781 test results.

1/2" 9 gauge.....Deters climbing and very time consuming to cut thru, border fence, prisons, warehouse, chemical plants and refineries, interior partition secure areas, secure areas within a fenced in area, military and government secure areas interior and exterior, higher security electrical generating, transmission and substations. Provides level of impact resistance. Visually very intimidating. *Excellent ASTM F2781 test results

1/2" 11 gauge....Deters climbing and very time consuming to cut thru, border fence, prisons, warehouse, chemical plants and refinery interior partition secure areas, secure areas within a fenced in area, military and government secure areas interior and exterior, higher security electrical generating, transmission and substations. Visually intimidating.

5/8" 9 gauge.....Deters climbing and very time consuming to cut thru - border fence, prisons, warehouse, chemical plants and refinery interior partition secure areas, secure areas within a fenced in area, military and government, interior and exterior separate secure areas, higher security electrical generating, transmission and substations. Visually very intimidating.

5/8" 11 gauge.....Deters climbing and very time consuming to cut thru - border fence, prisons, warehouse, chemical plants and refineries, interior partition secure areas, secure areas within a fenced in area, military and government, higher security electrical generating, transmission and substations. Visually intimidating.

1" 9 gauge.....Smaller mesh size difficult to climb adds cutting delay time - prisons, interior partitions, electrical generating, transmission and substations, bridge and building parapet fence, rail road right of way, chemical plants, refineries, factories, interior partitions for secure areas within warehouses and plants, added security for selected areas within a fenced in area, military & government installations.

1 3/4" 6 gauge.... Smaller mesh size harder to climb adds cutting delay time - heavier 6 gauge requiring bolt cutters - prisons, higher security level for electrical generating, transmission and substations, chemical plants, refineries military & government installations. Visually intimidating.

1 3/4" 9 gauge... Smaller mesh size harder to climb adds cutting delay time - prisons, higher security level for electrical generating, transmission and substations, chemical plants, refineries, military & government installations, high use public tennis courts

2" 6 gauge.....Standard industrial/commercial added security, heavier 6 gauge deters cutting requiring bolt cutters - baseball backstops, areas more subjected to break in's, car lots, ports, distribution centers, electrical generating, transmission and substations, chemical plants, refineries, military & government installations as well as prisons and bridge parapet fence.

2" 9 gauge.....Standard industrial/commercial security - sports play fields, parks, schools, highway and rail road right of way fencing, factories, warehouses, distribution centers, ports, lumber yards, electrical generating, transmission and substations, refineries, chemical plants, airports, lower level military & government installations, interior partitions ...best value for everyday security

**CHAIN LINK FENCE MANUFACTURERS INSTITUTE GUIDE FOR
SPECIFYING HIGH SECURITY CHAIN LINK FENCE AND GATES
(CLFS 2445.53)**

May 2018

CONTRACT SECTION 32 31 13.53

PART 1 GENERAL

1. RELATED DOCUMENTS

- A. DIVISION 01 - GENERAL REQUIREMENTS: Drawings, quality, product and performance requirements, general and supplemental conditions apply as applicable to the project and project documents.

2. SUMMARY

- A. This Section includes materials applicable for high security chain link fence and gates. <Refer to CLFMI SFR 2445, "Security Fence Recommendations" , ASTM F2781 "Standard Practice for Testing Forced Entry, Ballistic, and Low Impact Resistance of Security Fence Systems" and CLFMI CLF- TPO211 "Tested and Proven Performance of Security Grade Chain Link Fence Systems" >

[delete products not applicable]

1. Galvanized steel coated chain link fabric
2. Aluminum coated steel chain link fabric
3. Polymer coated steel chain link fabric
4. Zinc 5% Aluminum alloy coated steel chain link fabric
5. Galvanized steel framework and fittings
6. Polymer coated galvanized steel framework and fittings
7. Gates: swing and cantilever slide
8. Barbed wire
9. Barbed tape
10. Installation

- B. Related Project Contract Sections: [delete sections not applicable]

1. 01 33 13 Certificates
2. 01 33 23 Shop Drawings, product data
3. 01 43 13 Manufacturers Qualifications
4. 01 43 23 Installer Qualifications
5. 01 45 00 Quality Control
6. 01 65 00 Product Delivery Requirements
7. 01 66 00 Product Storage and Handling Requirements
8. 03 30 53 Miscellaneous Cast in Place Concrete
9. 25 50 00 Integrated automation pertinent to gate operator access control
10. 26 01 02 Electrical distribution as it relates to gate operators and accessories
11. 31 22 19 Finish Grading

3. REFERENCES

[delete references not applicable]

- A. ASTM A121 Specification for Metallic-Coated Carbon Steel Barbed Wire
- B. ASTM A392 Specification for Zinc-Coated Steel Chain-Link Fence Fabric
- C. ASTM A491 Specification for Aluminum-Coated Steel Chain-Link Fabric
- D. ASTM A780 Standard Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings
- E. ASTM A824 Specification for Metallic-Coated Steel Marcellled Tension Wire for Use with Chain Link
- F. ASTM F552 Standard Terminology Relating to Chain Link Fencing
- G. ASTM F567 Standard Practice for Installation of Chain Link Fence
- H. ASTM F626 Specification for Fence Fittings
- I. ASTM F668 Specification for Polymer Coated Chain Link Fence Fabric
- J. ASTM F900 Specification for Industrial and Commercial Swing Gates
- K. ASTM F934 Specification for Standard Colors for Polymer-Coated Chain Link
- L. ASTM F1043 Specification for Strength and Protective Coatings of Metal Industrial Chain Link Fence Framework
- M. ASTM F1083 Specification for Pipe, Steel, Hot-Dipped Zinc-Coated (Galvanized) Welded, for Fence Structures
- N. ASTM F1184 Specification for Industrial and Commercial Horizontal Slide Gates
- O. ASTM F1345 Specification for Zinc-5% Aluminum-Mischmetal Alloy-Coated Steel Chain-Link Fence Fabric
- P. ASTM F1664 Specification for Poly (Vinyl Chloride) (PVC) and Other Conforming Organic Polymer-Coated Steel Tension Wire Used with Chain-Link Fence
- Q. ASTM F1665 Specification for Poly (Vinyl Chloride) (PVC) and Other Conforming Organic Polymer-Coated Steel Barbed Wire Used with Chain-Link Fence.
- R. ASTM F1910 Specification for Long Barbed Tape Obstacles
- S. ASTM F1911 Standard Practice for Installation of Barbed Tape
- T. ASTM F2200 Specification for Automated Vehicular Gate Construction

- U. ASTM F2611 Standard Guide for the Design and Construction of Chain Link Security Fencing
- V. ASTM F2781 Standard Practice for Testing Forced Entry, Ballistic, and Low Impact Resistance of Security Fence Systems
- W. CLFMI SFR 2445 Security Fence Recommendations
- X. CLFMI CLF TPO211 Tested and Proven Performance of Security Grade Chain Link Fence Systems
- Y. CLFMI WLG2445 Chain Link Fence Wind Load Guide for the Selection of Line Post and Line Post Spacing
- Z. UL 325 Door, Drapery, Gate, Louver and Window Operators

4. SUBMITTALS

- A. Shop drawings: Site plan showing layout of fence location with dimensions, location of gates and opening size, cleared area, elevation of fence and gates, details of attachments and footings.
- B. Certifications: Manufacturers material certifications in compliance with current ASTM specifications.
- C. Domestic certifications: Material certifications, Made in U.S.A., Buy American Act or Buy America when required.
- D. Specification Changes: May not be made after the date of bid.

5. QUALITY ASSURANCE

- A. Manufacturer: Company operating in the United States having U.S. manufacturing facility/facilities specializing in manufacturing chain link fence products with at least 5 years' experience.
- B. Fence contractor: Company with demonstrated successful experience installing similar projects in accordance with ASTM F567 at least 5 years' experience.
- C. Tolerances: Current published edition of ASTM specifications tolerances apply. ASTM specification tolerances supersede any conflicting tolerance.

6. DELIVERY, STORAGE AND HANDLING

- A. Delivery: Deliver products to site per contract requirements.
- B. Storage: Store and protect products off the ground when required.

PART 2 – PRODUCTS

1. MANUFACTURERS

A. Framework, posts, rails, pipe for gates: [list selected CLFMI manufacturers]

B. Fabric, fittings, gates and accessories: [list selected CLFMI manufacturers]

2. CHAIN LINK FABRIC

A. Steel Chain Link Fabric: ___ in. mesh, gauge__ high per ASTM____, top sel-
vage____bottom selvage _____

[Refer to CLFMI security chain link fabric listing when selecting security fabric mesh and gauge size configuration] [List height or heights] [select ASTM coating specification designation and Class, mesh size and wire gauge (see Table 1), top/bottom selvage and color when applicable] [delete fabric specifications not selected] <Steel chain link mesh sizes and gauges are produced in one-piece widths 3 feet (910 mm) to 12 feet (3660 mm). Custom order fabric is available in heights up to and including 20 ft. (6.1m).>

1. Zinc-Coated Steel Fabric: ASTM A392 hot dipped galvanized before or after weaving.

a. Class 1 - 1.2 oz/ft² (366 g/m²)

b. Class 2 - 2.0 oz/ft² (610 g/m²) [available 9 and 6 gauge]

2. Aluminum-Coated Steel Fabric (Aluminized): ASTM A491

3. Zinc-5% Aluminum-Mischmetal Alloy Coated Steel Fabric: ASTM F1345

a. Class 1 – 0.6 oz/ft² (183 g/m²)

b. Class 2 – 1.0 oz/ft² (305 g/m²)

4. Polymer Coated Steel Fabric: ASTM F668, the wire gauge specified for polymer-coated wire is that of the metallic coated steel core wire

a. Class 1 extruded

b. Class 2a extruded and adhered

c. Class 2b fused and adhered

d. Color: [dark green] [olive green] [brown] [black] per ASTM F934

5. Fabric selvage:

Standard fabric selvage for 2 in (50 mm) mesh 72 in. (1.8 m) high and over is knuckle finish at one end, twist at the other, K&T. Fabric less than 72 in (1.8 m), and mesh size less than 2 in. (50 mm), knuckle finish top and bottom, K&K. T&T available for 2" (50 mm) mesh.

3. STEEL FENCE FRAMEWORK

A. Round steel pipe and rail: ASTM F1043 Group IA Heavy Industrial Fence Framework, schedule 40 galvanized pipe per ASTM F1083. Exterior hot dipped zinc coating minimum average 1.8 oz/ft², interior hot dipped zinc coating minimum average 1.8 oz/ft². <specify 2.0 oz/ft² zinc coating when applicable> <Select and specify steel yield strength Grade> Regular Grade, 30,000 psi or High Strength Grade, 50,000 psi.>

1. Line post: [Refer to Table 2] <Insert outside diameter and weight>

2. End, Corner, Pull post: [Refer to Table 2] <Insert outside diameter and

- weight>
- Top, brace, bottom and intermediate rails, 1.660 in. (42.2 mm) OD, 2.27 lb/ft [3.38 kg/m]

B. Round steel pipe and rail: ASTM F1043 Group IC Heavy Industrial Fence Framework. <Select and specify galvanized after forming or galvanized before forming>

Galvanized after forming: Exterior zinc coating minimum average 0.90 oz/ft² and an interior 81% nominal zinc pigmented 0.30 mil coating.

Galvanized before forming: Exterior zinc coating minimum average 0.90 oz/ft² and an interior zinc coating minimum average 0.90 oz/ft².

- Line post: [Refer to Table 2] <Insert, outside diameter and weight>
- End, Corner, Pull post: [Refer Table 2] <Insert outside diameter and weight>
- Top, brace, bottom and intermediate rails, 1.660 in. (42.2 mm) OD, 1.84 lb/ft [2.74 kg/m]

C. Rolled-Formed line posts and rail: ASTM F1043 Group II Heavy Industrial Fence Framework. Zinc coating minimum average 2.0 oz/ft².

- Line post dimensions: [Refer to Table 2] <insert size dimensions and weight>
- Top, brace, bottom and intermediate rails: 1.625 x 1.25 in. (41.2 x 31.7 mm), 1.35 lb/ft (2.01kg/m).
[1.660 in (42.2 mm) OD round pipe rail can be used with the rolled formed post] < select ASTM F1043 Group IA or IC rail >

TABLE 2 Line post selection guideline

Minimum post size based on 2” 9 gauge mesh, 105 mph wind speed, Category B, no icing.

Consult the CLFMI “Chain Link Fence Wind Load Guide for the Selection of Line Post and Line Post Spacing (WLG 2445)”

Group IA F1083, schedule 40 pipe reflects Regular Grade 30,000 psi yield steel, High Strength Grade, 50,000 psi yield steel not listed.

Pipe terminal posts are generally one size larger in outside diameter than the line posts.

<i>Fence Fabric</i>	<i>Group IA ASTM F1083 Sch. 40 Pipe Minimum</i>	<i>Group IC Elec. Resistance Welded Pipe Minimum</i>	<i>Group II Rolled Formed C-Section Minimum</i>
<i>up to 6' 0"</i>	<i>1.900"</i>	<i>1.900"</i>	<i>1.875x1.625"</i>
<i>over 6' 0" to 8' 0"</i>	<i>2.375"</i>	<i>2.375"</i>	<i>1.875x1.625"</i>
<i>over 8' 0" to 10' 0"</i>	<i>2.875"</i>	<i>2.875"</i>	<i>2.250x1.700"</i>
<i>over 10' 0" to 12' 0"</i>	<i>3.500"</i>	<i>2.875"</i>	<i>3.250x2.500"</i>
<i>over 12' 0" to 14' 0"</i>	<i>3.500"</i>	<i>3.500"</i>	<i>N/A</i>
<i>over 14' 0" to 16' 0"</i>	<i>4.000"</i>	<i>4.000"</i>	<i>N/A</i>

D. Polymer Coated Framework: Polymer coated framework shall have a [PVC] [Polyolefin] [Polyester] coating fused and adhered to the exterior zinc coating of the post or rail. PVC and polyolefin coatings shall have minimum thickness 10-mils (0.254 mm), polyester coating minimum thickness 3 mils (0.0076 mm) per ASTM F1043. Color to match fabric [dark green] [olive green] [brown] [black] per ASTM F934.

4. TENSION WIRE

A. Metallic Coated Steel Tension Wire: 7 gauge (0.177 in.) (4.50 mm) marcelled wire complying with ASTM A824 [Match coating type to that of the chain link fabric] <Insert metallic coating Type and class when applicable>

1. Type I Aluminum-Coated (Aluminized) 0.40 oz/ft² (122 g/m²)
2. Type II Zinc-Coated Class 4 - 1.2 oz/ft² (366 g/m²)
3. Type II Zinc-Coated Class 5 - 2.0 oz/ft² (610 g/m²)
4. Type III Zinc-5% Aluminum-Mischmetal Alloy Coated Steel Fabric Class 1 – 0.6 oz/ft² (183 g/m²) Class 2 - 1.0 oz/ft² (305 g/m²)

B. Polymer Coated Steel Tension Wire: 7 gauge (0.177 in.) (4.50 mm) wire complying with ASTM F1664. Wire gauge specified is the core wire gauge. [Match coating class and color to that of the chain link fabric] <Insert material coating class and color>

1. Class 1, extruded
2. Class 2a, extruded and adhered
3. Class 2b, fused and adhered,

5. BARBED WIRE

A. Metallic Coated Steel Barbed Wire: Comply with ASTM A121, Design Number 12-4-5-14R, double 12-½ gauge (0.099 in.) (2.51 mm) twisted strand wire, with 4 point 14 gauge (0.080 in.) (2.03 mm) round barbs spaced 5 inches (127 mm) on

B. Polymer Coated Barbed Wire: Comply with ASTM F1665, 0.80 in (2.03 mm) double twisted strand wire; zinc coated or aluminum alloy four point, 14 gauge (0.080 in.) (2.03 mm) barbs spaced 5 inches (127 mm) on center **[Match strand wire coating class and color to the chain link fabric]** **[Barbs are not polymer coated]** <Insert strand wire Class coating and color>

1. Class 1, extruded
2. Class 2a, extruded and adhered
3. Class 2b fused and adhered

6. BARBED TAPE

Stainless Steel Long Barbed Tape: Comply with ASTM F1910. **[Based on the security level required select the design configuration from the table listed in ASTM F1910]** **[Insert description, barbed tape material, coil diameter, core wire gauge and material when applicable, barb clusters per loop, coil loops, coil loop spacing, coil length, attachment points]**

7. FITTINGS

- A. **Brace Bands and Line Rail Clamps:** Galvanized pressed steel complying with ASTM F626, steel thickness 1/8 in. (3.18 mm), band width 1 in. (25 mm), zinc coated 1.20 oz/ft² (366 g/m²). Secure with 3/8 in. (9.53 mm) galvanized steel carriage bolts.
- B. **Terminal Post Caps, Line Post Loop Tops, Rail and Brace Ends, Boulevard Clamps, Rail Sleeves:** In compliance to ASTM F626, pressed steel galvanized after fabrication having a minimum zinc coating of 1.20 oz/ft² (366 g/m²).
- C. **Truss Rod Assembly:** In compliance with ASTM F626, 3/8 in. (9.53 mm) diameter steel truss rod with a pressed steel tightener, minimum zinc coating of 1.2 oz/ft² (366 g/m²), assembly capable of withstanding a tension of 2,000 lbs. (970 kg).
- D. **Tension Bars:** In compliance with ASTM F626. Galvanized steel one-piece length 2 in. (50 mm) less than the fabric height. Minimum zinc coating 1.2 oz. /ft² (366 g/m²). **[select bar size]**
1. Bars for 2 in. (50 mm) and 1 ¾ in. (44 mm) mesh shall have a minimum cross section of 3/16 in. (4.8 mm) by 3/4 in. (19 mm).
 2. Bars for 1 in. (25 mm) mesh shall have a cross section of 1/4 in. (6.4 mm) by 3/8 in. (9.5 mm).
 3. Bars for small mesh 3/8 in. (10 mm), 1/2 in. (13 mm) and 5/8 in. (16 mm) shall

be attached (sandwiched) to the terminal post using a galvanized steel strap having a minimum cross section of 2 in. (51 mm) by 3/16 in. (4.8 mm) with holes spaced 12 in. (304.8 mm) on center to accommodate 3/8 in. (10 mm) carriage bolts which are to be thru bolted - thru the strap the mesh and thru the terminal post.

E. Barbed Wire Arms: In compliance with ASTM F626, pressed steel galvanized after fabrication, minimum zinc coating of 1.20 oz. /ft² (366 g/m²), capable of supporting a vertical 250 lb (113 kg) load. [Type I – three strand 45 degree (0.785 rad) arm] [Type II– three strand vertical arm] [Type III -V shaped six strand arm]

F. Polymer Coated Color Fittings: In compliance with ASTM F626. Polymer coating minimum thickness 0.006 in. (0.152 mm) fused and adhered to zinc coated fittings

8. TIE WIRE and HOG RINGS

Tie wire and hogs rings per ASTM F626. 9 gauge (0.148 in.) (3.76 mm) galvanized steel preformed power-fastened wire ties, 9 gauge (0.148 in.) (3.76 mm) galvanized steel hog rings. Minimum zinc coating 1.20 oz/ft² (366 g/m²) for ties and hog rings.

[polymer coated; match the coating, class and color to the chain link fabric]

9. SWING GATES [Consult manufacturer for added security gate designs]

A. Swing Gates: [single] [double] ___ opening ___ by ___ ft. high. Galvanized steel welded fabrication in compliance with ASTM F900. Gate frame members 1.900 in. OD (48.3 mm) <insert pipe specification> [ASTM F1043 Group IA F1083 schedule 40 pipe] [ASTM F1043 Group IC pipe] Frame members spaced no greater than 8 ft. (2440 mm) apart vertically and horizontally. Welded joints protected by applying zinc-rich paint in accordance with ASTM Practice A780. Positive locking gate latch fabricated of 5/16 in. (7.9 mm) thick by 1 3/4" (44.45 mm) pressed steel galvanized after fabrication. Galvanized malleable iron or heavy gauge pressed steel post and frame hinges. Match gate fabric to that of the fence system. Gateposts ___ OD, ___ lb/ft [ASTM F1043 Group IA ASTM F1083 schedule 40 pipe] [ASTM F1043 Group IC pipe] <Insert outside diameter, specification reference and weight> [Select the gatepost outside diameter from table 2.9 B] [Polymer coated gate frames and gateposts; match the coating type and color to that specified for the fence framework. Moveable parts such as hinges, latches and drop rods may be field coated using a liquid polymer touch up] [electrically operated gates must comply with ASTM F2200 and UL325]

[Swing gate post size per ASTM F900]

Gate fabric height up to and including 6 ft. (1.2m)	
Gate leaf width	Post Outside Diameter
up to 4 ft. (1.2 m)	2.375 in. (60.3 mm)
over 4 ft. to 10 ft. (1.2 to 3.05 m)	2.875 in. (73.0 mm)
over 10 ft. to 18 ft. (3.05 to 5.5 m)	4.000 in. (101.6 mm)
Gate fabric height over 6 ft. to 12 ft. (1.2 to 2.4m)	
Gate leaf width	
up to 6 ft. (1.8 m)	2.875 in. (73.0 mm)
over 6 ft. to 12 ft. (1.8 to 3.7 m)	4.000 in. (101.6 mm)
over 12 ft. to 18 ft. (2.4 to 5.5 m)	6.625 in. (168.3 mm)
over 18 ft. to 24 ft. (5.5 to 7.3 m)	8.625 in. (219.1 mm)

10. HORIZONTAL SLIDE GATES [Consult manufacture for added security designs or crash rated systems]

A. Overhead Slide Gates: In compliance with ASTM F1184 Type I.

Gate framing to be of welded construction, minimum 1.900 in. OD (48.3 mm) pipe members. **<Insert pipe specifications> [ASTM F1043 Group IA ASTM F 1083 sch 40 pipe] [ASTM F1043 Group IC pipe]** Framing members to be spaced no more than 8 ft. (2440 mm) apart horizontally and vertically. Welded joints are to be protected by applying zinc-rich paint in accordance with ASTM Practice A780.

Positive locking latch, 5/16 in. (7.9 mm) thick by 1 3/4 in. (44.45 mm) pressed steel, galvanized after fabrication. Galvanized steel drop bars to be provided with double gates. Chain link fabric to match the fence system. Manufacturer's standard overhead beam/structure, track, rollers and accessories designed to support the load of the gate panel taking into consideration wind load and possible icing. The support beam/structure to be galvanized or receive proper corrosion protection.

Gateposts to be ___OD ___lb/ft

<Insert post size & weight per ft>

Post size for gate openings up to and including 10 ft. (3.05 m) shall be 2.875 in OD (73 mm)

Openings greater than 10 ft. (3.05 m) up to 24 ft. (7.3 m) shall be 4.000 in. OD (101.6 mm)

Openings greater than 24 ft. (7.3 m) up to 40 ft. (12.2 m) shall be double 4.000 in. OD (101.6 mm)

in compliance with **<Insert pipe specification> [ASTM F1043 Group IA F 1083 schedule 40 pipe] [ASTM F1043 Group IC pipe].**

B. Cantilever Slide Gates: In compliance with ASTM F1184 Type II

1. Class 1-External Roller Design: Horizontal top and bottom steel pipe “track” members to be 2.375 in. OD (60.3 mm), vertical and internal members 1.900 in. O.D. in compliance with **<Inset gate pipe frame specification> [ASTM F1043 Group IA 1083 sch 40 pipe] [ASTM F1043 Group IC pipe.]** Gate frame to be fabricated by welding, vertical and horizontal members located no greater than 8 ft. (2440 mm) apart. The length of back frame support section shall be a minimum of 40% of the opening. Welded joints are to be protected by applying zinc-rich paint in accordance with ASTM Practice A780. Gates designed to open or close by applying an initial pull force no greater 40 lbs. (18.14 kg). Match chain link fabric to that of the fence system. Positive locking latch fabricated galvanized pressed steel. Gateposts, 4.000 in. OD (101.6 mm) _____ lb/ft **<Insert post specification & weight per ft.> [ASTM F1043 Group IA ASTM F1083 sch 40 pipe] [ASTM F1043 Group IC pipe].** Provide safety protective guards for the top and bottom external rollers.

2. Class 2-Internal Roller Design: **Select material: [aluminum alloy extrusion] [ASTM F 1043 Group IA, ASTM F 1083 schedule 40 pipe] [ASTM F 1043 Group IC pipe]** Gate frame fabricated by welding, vertical and horizontal members located no greater than 8 ft. (2440 mm) apart. The length of back frame support section shall be a minimum of 40% of the opening. Class 2 cantilever slide gates to comply with the performance deflection criteria listed in ASTM F1184. Gates designed to open or close by applying an initial pull force no greater than 40 lbs. (18.14 kg). Internal truck assemblies designed to handle the forces required for gate size opening and height. Match chain link fabric to that of the fence system. Positive locking latch fabricated galvanized pressed steel. Gateposts, 4.00 in. O.D. (106.1 mm) _____ lb/ft **<Insert post specification & weight per ft> [ASTM F1043 Group IA ASTM F1083 schedule 40 pipe] [ASTM F1043 Group IC pipe].**

[Internal roller cantilever designs vary by manufacturer and material]

a.[Steel Pipe Frame Design: Match the specification of Class 1 cantilever slide gate. Securely bolt an extruded aluminum enclosed track designed to accommodate internal roller assemblies to the top horizontal member]

b.[Aluminum Frame Design: Aluminum rectangular members of various shapes and wall thickness per manufacturers design based on gate opening and height. Top horizontal member to be one-piece extruded section having an integral internal track to accommodate truck assemblies.]

C. [Polymer coated horizontal slide gates and posts shall match the coating type and color as that specified for the fence framework.] <Insert coating requirement and color>

D. [Electrically operated gates and accessories must be manufactured and installed to comply with the safety requirements of ASTM F2200 and UL325]

11. CONCRETE

Concrete for post footings shall have a 28-day compressive strength of 2,500 psi. (17.2 MPa).

PART 3 EXECUTION

1. CLEARING FENCE LINE

Clearing: Surveying, clearing, grubbing, grading and removal of debris for the fence line or any required clear areas adjacent to the fence <Insert project requirement> [Surveying, clearing, grubbing, grading and removal of debris for the fence line or any required clear areas adjacent to the fence is included in the earthwork contractor's contract under the provisions of Division 31 - Earthwork.] [Surveying, clearing, grubbing, grading and removal of debris for the fence line or any required clear areas adjacent to the fence is not included in the earthwork contractor's contract and is the responsibility of the fence contractor in accordance with the provisions of Division 31 - Earthwork.] The contract drawings indicate the extent of the area to be cleared and grubbed.

2. FRAMEWORK INSTALLATION

- A. Posts: Posts shall be set plumb in concrete footings in accordance with ASTM F567. Minimum footing depth, 24 in. (609.6 mm) plus an additional 3 in. (76.2 mm) for each 1 ft. (305 mm) increase in the fence height over 4 ft. (1220 mm). Minimum footing diameter four times the largest cross section of the post up to 4.00" (101.6mm) O.D. and three times the largest cross section of post greater than 4.00" (101.6mm). O.D. Gate posts require larger footings; minimum requirements are listed in ASTM F567. <Insert footing depth and diameter> [Site soil conditions, local frost depth, fence height and wind load may require larger diameter or deeper footings, consult CLFMI Wind Load document for footing design] Top of post concrete footing to be crowned to shed water away from the post. Line posts installed at intervals not exceeding 10 ft. (3.05 m) on center.
- B. Top and bottom rail: When specified, install 21 ft. (6.4 m) lengths of rail continuous thru the line post or barb arm loop top. Splice rail using top rail sleeves minimum 6 in. (152 mm) long. The rail shall be secured to the terminal post by a brace band and rail end. [Based on the height of the fence, deleting the top rail may be considered

as the rail can provide a handhold for an intruder. For added security for fences using a top rail, install the rail 12 in. (305 mm) below the top of the mesh.] Bottom rail or intermediate rail shall be field cut and secured to the line posts using boulevard bands or rail ends and brace bands. For added security drill and thru bolt rail to rail ends and boulevard bands using 3/8 in. (9.53 mm) carriage bolts.

- C. Terminal posts: End, corner, pull and gate posts shall be braced and trussed for fence 6 ft. (1.8 m) and higher and for fences 5 ft. (1.5 m) in height not having a top rail. The horizontal brace rail and diagonal truss rod shall be installed in accordance with ASTM F567.
- D. Tension wire: Shall be installed 4 in. (101.6 mm) up from the bottom of the fabric. Fences without top rail shall have a tension wire installed 4 in. (101.6 mm) down from the top of the fabric. Tension wire to be stretched taut, independently and prior to the fabric, between the terminal posts and secured to the terminal post using a brace band. Secure the tension wire to the chain link fabric with a 9 gauge hog rings 12 in. (304.8 mm) on center and to each line post with a tie wire. **[Install the top tension wire through the barb arm loop for fences having barbed wire and no top rail.]**

3. CHAIN LINK FABRIC INSTALLATION

Chain Link Fabric: Install fabric to **[outside]** **[inside]** of the framework. Attach fabric to the terminal post by threading the tension bar through the fabric; secure the tension bar to the terminal post with tension bands and 5/16 in. (7.94 mm) carriage bolts spaced no greater than 12 inches (304.8mm) on center. Small mesh fabric less than 1 in. (25 mm), attach to terminal post by sandwiching the mesh between the post and a vertical 2 in. wide (50mm) by 3/16 in. (4.76 mm) galvanized steel bar using 3/8 in. (10 mm) carriage bolts, thru bolted - thru the bar, mesh and post spaced 15 in. (381 mm) on center.

Chain link fabric to be sufficiently stretched taut so as not to deflect more than 3 in. (76 mm) in the center of two line post at mid height subjected to a 30 lb. (133N) horizontal force. Fabric to be secured to the line post with tie wires spaced no greater than 12 inches (304.8 mm) on center and to rail spaced no greater than 12 inches (304.8 mm) on center using pre-formed 9 gauge galvanized steel power-fastened tie wire wrapped 360 degrees around the post or rail and fabric picket, twist the two wire ends together three full turns per ASTM F567. Excess wire shall be cut off and bent over to prevent injury. Secure fabric to the tension wire with hog rings spaced no greater than 18 inches (457.2 mm) apart.

The installed fabric shall have a ground clearance on no more than 2 inches (50 mm). **[Additional security can be obtained by burying a separate section of polymer coated chain link fabric of the same gauge and mesh as the adjacent fabric a minimum of 24 in. (610 mm) below grade. Overlap the buried fabric with the fence fabric a minimum of 6 in. (153 mm). It is recommended not to hog ring the two fabrics together in areas of heavy frost leaving the buried fabric free to adjust to possible movement due to frost.]**

4. BARBED WIRE INSTALLATION

Barbed Wire: Stretched taut between terminal posts and secured in the slots provided on the line post barb arms. Attach each strand of barbed wire to the terminal post using a brace band. Barb arms to be riveted or bolted to post. **[Indicate type of barb arm, Type I, II or III and direction [inward] [outward] for installation of Type I arm.]**

5. GATE INSTALLATION

- A. Swing Gates: Installation of swing gates and gateposts in compliance with ASTM F567. Direction of swing shall be **[inward] [outward]**. Gates shall be plumb in the closed position having a bottom clearance of 3 in. (76 mm) grade permitting. Hinge and latch offset opening space from the gate frame to the post shall be no greater than 3 in. (76 mm) in the closed position. Double gate drop bar receivers shall be set in a concrete footing minimum 6 in. (152 mm) diameter 24 in. (609.6 mm) deep. Gate leaf holdbacks shall be installed for all double gates. **[Electrically operated gates and accessories must be manufactured and installed in compliance with ASTM F2200 and UL 325.]**
- B. Horizontal Slide Gates: Installation varies by design and manufacturer, install according to manufacturer's instructions and in accordance with ASTM F567. Gates shall be plum in the closed position, installed to slide with an initial pull force no greater than 40 lbs. (18.14 kg). Double gate drop bar receivers to be installed in a concrete footing minimum 6 in. (152 mm) diameter, 24 in. (609.6 mm) deep. Roller guards and guide posts must be installed on Type I external roller cantilever slide gate in compliance with ASTM F1184. Ground clearance shall be 3 in. (76 mm), grade permitting. **[Electrically operated gates and accessories must be manufactured and installed in compliance with ASTM F2200 and UL 325]**

6. BARBED TAPE INSTALLATION

Barbed Tape: Barbed tape when specified shall be installed in accordance with ASTM F1911, installation of barbed tape.

7. NUTS AND BOLTS

Bolts: Carriage bolts used for fittings shall be installed with the head on the secure side of the fence. All bolts shall be peened over to prevent removal of the nut

8. ELECTRICAL GROUNDING

Grounding: Grounding of the fence and gates is not the responsibility of the fence contractor and not included in the fencing scope of work for this contract.

Grounding, when required, shall be specified and included in Contract Section 33 79 00. A licensed electrical contractor shall install grounding.

9. CLEAN UP

Clean Up: The area of the fence line shall be left neat and free of any debris caused by the installation of the fence.

END OF SECTION

Disclaimer: The Chain Link Fence Manufacturers Institute (CLFMI) is a not-for-profit organization and has provided all information in this publication as a public service. While every effort has been made to provide accurate information, neither the CLFMI nor its members make any warranties, express or implied, as to the adequacy or accuracy or fitness for a particular purpose of the instructions, diagrams and other information in this publication. The CLFMI bears no responsibility for any errors or omissions in this publication. Users shall bear all risks from using the information in this publication.