



**Stephens Pipe and Steel, LLC *OnGuard* Aluminum Square Frame Cantilever Gate Construction Specifications**  
Section 02830

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### **OnGuard Aluminum Slide Specification**

Slide gates shall be "OnGuard Aluminum Cantilever style as manufactured by Stephens Pipe and Steel, LLC in Russell Springs, Kentucky (270) 866 3331 Gate sizes shall be as shown on the drawings and shall conform to the following specifications:

- 1. Gate Frames:** Fabricated in accordance with ASTM F 1184, Class 2, using 2" square x .125 wall aluminum members weighing 1.71 lb./ft, a one-piece aluminum top track/frame member weighing a minimum of 5.16 lb./ft, with a wall thickness of .250, and a bottom track weighing a minimum of 2.69 lb/ft with a .210 wall thickness. Both tracks shall be extruded with a defined channel whose purpose is to capture the chain link fabric at the top and bottom selvage. Each section shall be diagonally braced with a 1-1/4" x .125 wall aluminum square weighing .66 lb/ft. Aluminum alloy used shall be **6061-T6** only. For reasons of strength, **no other alloy will be permitted.** Internal uprights shall be 2" square x .125 wall aluminum square spaced equally at no more than 8'-0" O.C. subdividing the gate frame into panels. All members shall be welded to form a ridged one-piece gate frame unit. No bolt on type tracks will be allowed. Any splicing of the gate frames that may be required shall be performed in the factory by welding. **No bolt type splices will be allowed.**
- 2. Truss Rods:** (Optional) Internal truss rods shall be 3/8" diameter and equipped with adjustable turnbuckles as recommended by the manufacturer. They shall be attached to 2" x 2" x 3/8" corner gussets that have been securely welded to the frame at each corner and drilled for truss rod attachment. **No drilling through frame and no cables of any kind will be allowed.**
- 3. Truck Assemblies:** shall be swivel type, zinc die cast, with 8 factory sealed and lubricated ball bearing rollers. Rollers shall be 2" diameter by 9/16" in width equipped with two ball bearing side rollers to prevent lateral movement. Truck assemblies shall be mounted on post brackets using 1/2" dia U-bolts.
- 4 Bottom Guide Wheel Assemblies:** Two 2" dia x 3-3/8" tall rubber rollers (one set) straddling the bottom horizontal gate rail shall be installed, one set on the gate post and one on the overhang post.
- 5. Hardware:** Gate Hangers, latches brackets, guide assemblies and stops shall be aluminum, malleable iron or steel galvanized after fabrication. Positive latch device shall be provided with provisions for padlocking.
- 6. Posts:** Gate posts, latch posts and overhang posts shall be 4" OD schedule 40 galvanized pipe set in 12" x 36" deep footings or as recommended by the manufacturer. Concrete shall be troweled and sloped to shed water away from the posts.

7. **Style:** Style of gate frame shall be dictated by size of opening as follows:

Single Gates	Double Gates
Up to 30' wide	up to 60' wide

Shall be of single frame construction as recommended by the manufacturer.

Single Gates	Double Gates
31' to 40' wide	62' to 80' wide

Shall be a one piece double track extrusion with welding allowed.

Single Gates	Double Gates
41' to 50' wide	82' to 100' wide

Shall be of box-frame construction with dual frames welded together to form 24" box, as recommended by the manufacturer.

**(For larger gate openings contact manufacturer for special design).**

8. **Certification:** Mill certificates verifying that the **6061-T6 alloy** has been used and that all other components of this specification have been met are required.