
USACE / NAVFAC / AFCEA UFGS-11286A (August 2004)

Preparing Activity: USACE (CW) Superseding
UFGS-11286A (January 1994)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated 22 December 2004

SECTION TABLE OF CONTENTS

DIVISION 11 - EQUIPMENT

SECTION 11286

SECTOR GATES

08/04

PART 1 GENERAL

- 1.1 REFERENCES
- 1.2 UNIT PRICES
 - 1.2.1 Furnishing and Installing Sector Gates and Appurtenant Items
 - 1.2.1.1 Payment
 - 1.2.1.2 Unit of Measure
 - 1.2.2 Furnishing Sector Gates and Appurtenant Items
 - 1.2.2.1 Payment
 - 1.2.2.2 Unit of Measure
 - 1.2.3 Installing Sector Gates and Appurtenant Items
 - 1.2.3.1 Payment
 - 1.2.3.2 Unit of Measure
- 1.3 SUBMITTALS
- 1.4 QUALIFICATION OF WELDERS AND WELDING OPERATORS
- 1.5 DELIVERY, STORAGE, AND HANDLING
 - 1.5.1 Materials and Fabricated Items
 - 1.5.2 Rubber Seals

PART 2 PRODUCTS

- 2.1 MATERIALS
 - 2.1.1 Metals
 - 2.1.1.1 Structural Steel Shapes
 - 2.1.1.2 Structural Steel Plates
 - 2.1.1.3 Steel Pipe
 - 2.1.1.4 Steel Castings
 - 2.1.1.5 Steel Forgings
 - 2.1.1.6 High-Strength Steel Bar
 - 2.1.1.7 Stainless Steel Bars and Shapes
 - 2.1.1.8 Stainless Steel Plate, Sheet, and Strip
 - 2.1.1.9 Bronze Castings
 - 2.1.1.10 Aluminum-Bronze Castings
 - 2.1.2 Rubber Seals
 - 2.1.2.1 Physical Characteristics
 - 2.1.2.2 [Fabrication

- 2.1.3 Bumpers and Fenders
- 2.1.4 Asphalt Mastic
- 2.2 MANUFACTURED UNITS
 - 2.2.1 Bolts, Nuts and Washers
 - 2.2.2 Screws
- 2.3 FABRICATION
 - 2.3.1 Detail Drawings
 - 2.3.1.1 Fabrication Drawings
 - 2.3.1.2 Shop Assembly Drawings
 - 2.3.1.3 Delivery Drawings
 - 2.3.1.4 Field Installation Drawings
 - 2.3.2 Structural Fabrication
 - 2.3.3 Welding
 - 2.3.4 Bolted Connections
 - 2.3.5 Machine Work
 - 2.3.6 Miscellaneous Provisions
 - 2.3.7 Fabrications
 - 2.3.7.1 Gate Leaf
 - 2.3.7.2 Hinge Assembly
 - 2.3.7.3 Pintle Assembly
 - 2.3.7.4 Seal Assemblies
 - 2.3.7.5 Appurtenant Items
 - 2.3.8 Shop Assembly
- 2.4 TESTS, INSPECTIONS, AND VERIFICATIONS
 - 2.4.1 [Testing of Rubber Seals

PART 3 EXECUTION

- 3.1 INSTALLATION
 - 3.1.1 Embedded Metals
 - 3.1.2 Hinge Assembly Embedded Anchorages
 - 3.1.3 Pintle Base Anchor Frame and Pintle Base
 - 3.1.4 Pintle
 - 3.1.5 Gate Leaf
 - 3.1.6 Hinge Bracket and Hinge Pin
 - 3.1.7 Painting
 - 3.1.8 Seal Assemblies
- 3.2 CATHODIC PROTECTION SYSTEM
- 3.3 OPERATING MACHINERY
- 3.4 FIELD TESTS AND INSPECTIONS
 - 3.4.1 [Skinplate Watertightness Test
 - 3.4.2 Acceptance Trial Operation
- 3.5 PROTECTION OF FINISHED WORK

-- End of Section Table of Contents --

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SECTION 11286

SECTOR GATES 08/04

NOTE: This guide specification covers the requirements for the fabrication, assembly, delivery, and installation of sector gates and appurtenant items as specified and shown on the drawings.

Comments and suggestions on this guide specification are welcome and should be directed to the technical proponent of the specification. A listing of technical proponents, including their organization designation and telephone number, is on the Internet.

Recommended changes to a UFGS should be submitted as a Criteria Change Request (CCR).

Use of electronic communication is encouraged.

Brackets are used in the text to indicate designer choices or locations where text must be supplied by the designer.

PART 1 GENERAL

1.1 REFERENCES

NOTE: Issue (date) of references included in project specifications need not be more current than provided by the latest guide specification. Use of SpecsIntact automated reference checking is recommended for projects based on older guide specifications.

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

AMERICAN WELDING SOCIETY (AWS)

AWS D1.1/D1.1M	(2004) Structural Welding Code - Steel
AWS D1.2	(2003) Structural Welding Code - Aluminum

AMERICAN WOOD-PRESERVERS' ASSOCIATION (AWPA)

AWPA C2	(2001) Lumber, Timber, Bridge Ties and Mine Ties - Preservative Treatment by Pressure Processes
AWPA P3	(2001) Standard for Creosote - Petroleum Oil Solution

ASTM INTERNATIONAL (ASTM)

ASTM A 148/A 148M	(2003) Steel Castings, High Strength, for Structural Purposes
ASTM A 167	(2004) Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip
ASTM A 176	(1999; R 2004) Stainless and Heat-Resisting Chromium Steel Plate, Sheet, and Strip
ASTM A 240/A 240M	(2004ae1) Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels for General Applications
ASTM A 27/A 27M	(2003) Steel Castings, Carbon, for General Application
ASTM A 276	(2004) Stainless Steel Bars and Shapes
ASTM A 307	(2004) Carbon Steel Bolts and Studs, 60 000 PSI Tensile Strength
ASTM A 320/A 320M	(2004) Alloy/Steel Bolting Materials for Low-Temperature Service
ASTM A 325	(2004b) Structural Bolts, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength
ASTM A 325M	(2004b) Structural Bolts, Steel, Heat Treated, 830 Mpa Minimum Tensile Strength (Metric)
ASTM A 36/A 36M	(2004) Carbon Structural Steel
ASTM A 490	(2004a) Structural Bolts, Alloy Steel, Heat Treated, 150 ksi Minimum Tensile Strength
ASTM A 490M	(2004a) High-Strength Steel Bolts, Classes

	10.9 and 10.9.3, for Structural Steel Joints (Metric)
ASTM A 501	(2001) Hot-Formed Welded and Seamless Carbon Steel Structural Tubing
ASTM A 53/A 53M	(2004a) Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless
ASTM A 564/A 564M	(2004) Hot-Rolled and Cold-Finished Age-Hardening Stainless Steel Bars and Shapes
ASTM A 572/A 572M	(2004) High-Strength Low-Alloy Columbium-Vanadium Structural Steel
ASTM A 588/A 588M	(2004) High-Strength Low-Alloy Structural Steel with 50 ksi (345 MPa) Minimum Yield Point to 4 in. (100 mm) Thick
ASTM A 668/A 668M	(2004) Steel Forgings, Carbon and Alloy, for General Industrial Use
ASTM A 722/A 722M	(1998; R 2003) Uncoated High-Strength Steel Bar for Prestressing Concrete
ASTM B 148	(1997; R 2003) Aluminum-Bronze Sand Castings
ASTM B 22	(2002) Bronze Castings for Bridges and Turntables
ASTM D 2240	(2004) Rubber Property - Durometer Hardness
ASTM D 395	(2003) Rubber Property - Compression Set
ASTM D 412	(1998a; R 2002e1) Vulcanized Rubber and Thermoplastic Elastomers - Tension
ASTM D 413	(1998; R 2002e1) Rubber Property - Adhesion to Flexible Substrate
ASTM D 471	(1998e1) Rubber Property - Effect of Liquids
ASTM D 572	(2004) Rubber Deterioration by Heat and Oxygen

THE SOCIETY FOR PROTECTIVE COATINGS (SSPC)

SSPC Paint 12	(1982; R 2000) Cold-Applied Asphalt Mastic (Extra Thick Film)
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1.2 UNIT PRICES

NOTE: If Section 01270 MEASUREMENT AND PAYMENT is included in the project specifications, this paragraph title (UNIT PRICES) should be deleted from

this section and the remaining appropriately edited subparagraphs below should be inserted into Section 01270.

Select Alternate 1 (one pay item) or Alternate 2 (two pay items). Delete all paragraphs of Alternate not selected.

1.2.1 Furnishing and Installing Sector Gates and Appurtenant Items

NOTE: Alternate 1.

1.2.1.1 Payment

Payment will be made for costs associated with furnishing and installing sector gates and appurtenant items, which includes full compensation for the materials, fabrication, delivery, installation, and testing of sector gates and appurtenant items including gate leaves, pintle assemblies, hinge assemblies, seal assemblies, [walkways,] [bridgeways,] bumpers, fenders, and other items necessary for complete installation.

1.2.1.2 Unit of Measure

Unit of measure: lump sum.

1.2.2 Furnishing Sector Gates and Appurtenant Items

NOTE: Alternate 2.

1.2.2.1 Payment

Payment will be made for all costs associated with furnishing sector gates and appurtenant items, which includes full compensation for the materials, fabrication, and delivery of sector gates and appurtenant items including gate leaves, pintle assemblies, hinge assemblies, seal assemblies, [walkways,] [bridgeways,] bumpers, fenders, and other items necessary for complete installation.

1.2.2.2 Unit of Measure

Unit of Measure: lump sum.

1.2.3 Installing Sector Gates and Appurtenant Items

NOTE: Alternate 2.

1.2.3.1 Payment

Payment will be made for costs associated with the installation of sector gates and appurtenant items, which includes full compensation for the complete installation and testing of sector gates and appurtenant items.

1.2.3.2 Unit of Measure

Unit of measure: lump sum.

1.3 SUBMITTALS

NOTE: Submittals must be limited to those necessary for adequate quality control. The importance of an item in the project should be one of the primary factors in determining if a submittal for the item should be required.

A "G" following a submittal item indicates that the submittal requires Government approval. Some submittals are already marked with a "G". Only delete an existing "G" if the submittal item is not complex and can be reviewed through the Contractor's Quality Control system. Only add a "G" if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy projects.

Submittal items not designated with a "G" are considered as being for information only for Army projects and for Contractor Quality Control approval for Navy projects.

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control approval.] [for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES:

SD-02 Shop Drawings

Detail Drawings[; G][; G, [_____]]

Detail drawings shall be submitted as specified and in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

SD-03 Product Data

Materials

System of identification which shows the disposition of specific lots of approved materials and fabricated items in the work shall be submitted before completion of the contract.

Materials orders, materials lists and materials shipping bills shall be submitted as specified in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

[Pintle Base Anchor Frame
Pintle Base

Record of the prestressing of the pintle base anchors shall be submitted immediately after the prestressing operations are completed.]

Hinge Assembly Embedded Anchorages

Record of the prestressing of hinge bracket anchors shall be submitted immediately after completion of the prestressing operations.

Welding[; G][; G, [_____]]

Schedules of welding procedures for structural steel shall be submitted as specified in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

SD-04 Samples

Materials[; G][; G, [_____]]
Manufactured Units[; G][; G, [_____]]
Fabrications[; G][; G, [_____]]

Samples shall be submitted and approved prior to use of the represented materials or items in the work. Samples of standard and shop fabricated items shall be full size and complete as required for installation in the work. Approved samples may be installed in the work provided each sample is clearly identified and its location recorded.

SD-06 Test Reports

Tests, Inspections, and Verifications

Certified test reports for material tests shall be submitted with all materials delivered to the site.

1.4 QUALIFICATION OF WELDERS AND WELDING OPERATORS

Qualification of welders and welding operators shall conform to the requirements of Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

1.5 DELIVERY, STORAGE, AND HANDLING

Delivery, handling, and storage of materials and fabricated items shall be as described below.

1.5.1 Materials and Fabricated Items

Delivery, handling, and storage of materials and fabricated items shall conform to the requirements specified [and] in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS. [Materials and equipment delivered to the site by the Contracting Officer shall be unloaded by the Contractor. The Contractor shall verify the condition and quantity of the items delivered by the Contracting Officer and acknowledge receipt and condition thereof in writing to the Contracting Officer. If delivered items are damaged or a shortage is determined, the Contractor shall notify the Contracting Officer of such in writing within 24 hours after delivery.]

1.5.2 Rubber Seals

Rubber seals shall be stored in a place which permits free circulation of air, maintains a temperature of 20 degrees C 70 degrees F or less, and prevents the rubber from being exposed to the direct rays of the sun. Rubber seals shall be kept free of oils, grease, and other materials which would deteriorate the rubber. Rubber seals shall not be distorted during handling.

PART 2 PRODUCTS

2.1 MATERIALS

Materials orders, materials lists, and materials shipping bills shall conform with the requirements of Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

2.1.1 Metals

Structural steel, steel forgings, steel castings, stainless steel, bronze, aluminum-bronze, and other metal materials used for fabrication shall conform to the requirements shown and specified herein and in Section 05502A METALS: MISCELLANEOUS, STANDARD ARTICLES, SHOP FABRICATED ITEMS.

2.1.1.1 Structural Steel Shapes

ASTM A 36/A 36M.

2.1.1.2 Structural Steel Plates

[ASTM A 36/A 36M,] [ASTM A 572/A 572M, Grade 50,] [or] [ASTM A 588/A 588M, Grade 50].

2.1.1.3 Steel Pipe

[ASTM A 53/A 53M, Type S, Grade B, seamless, black, normal size and weight class or outside diameter and nominal wall thickness as shown, [plain] [threaded] [threaded and coupled] ends.] [ASTM A 501, seamless, outside diameter and nominal wall thickness as shown.]

2.1.1.4 Steel Castings

ASTM A 27/A 27M, Grade [____], Class [____]; or ASTM A 148/A 148M, Grade [____].

2.1.1.5 Steel Forgings

ASTM A 668/A 668M, Class [____], carbon content not exceeding 0.35 percent, and chemical composition which results in satisfactory weldability.

2.1.1.6 High-Strength Steel Bar

ASTM A 722/A 722M, Type [____], and complying with all supplementary requirements.

2.1.1.7 Stainless Steel Bars and Shapes

ASTM A 276, UNS [S 20910,] [S 30400,] [S 40500,] Condition A, hot-finished or cold-finished, Class C; or ASTM A 564/A 564M, UNS [S 17400,] [S 45000,] Condition A, age-hardened heat treatment, hot-finished or cold-finished, Class C.

2.1.1.8 Stainless Steel Plate, Sheet, and Strip

ASTM A 167, UNS S 30400; ASTM A 176, UNS S 40500 or UNS S 41008; and ASTM A 240/A 240M, UNS [S 20910,] [S 30400,] [S 40500,]. Plate finish shall be hot-rolled, annealed or heat-treated, and blast-cleaned or pickled. Sheet and strip finish shall be No. 1.

2.1.1.9 Bronze Castings

ASTM B 22, Copper Alloy UNS No. C91300.

2.1.1.10 Aluminum-Bronze Castings

ASTM A 148/A 148M, Copper Alloy UNS No. [____].

2.1.2 Rubber Seals

NOTE: If fluorocarbon (Teflon) clad seals are not used, delete paragraph FABRICATION.

Rubber seals shall be [fluorocarbon (Teflon) clad rubber seals of the mold type only, shall be] compounded of natural rubber, synthetic polyisoprene, or a blend of both, and shall contain reinforcing carbon black, zinc oxide, accelerators, antioxidants, vulcanizing agents, and plasticizers.

2.1.2.1 Physical Characteristics

Physical characteristics of the seals shall meet the following requirements:

PHYSICAL TEST	TEST VALUE	TEST METHOD SPECIFICATION
Tensile Strength	17.2 MPa (min.)	ASTM D 412
Elongation at Break	450 percent (min.)	ASTM D 412
300 percent Modulus	6.2 MPa (min.)	ASTM D 412
Durometer Hardness (Shore Type A)	60 to 70	ASTM D 2240

PHYSICAL TEST	TEST VALUE	TEST METHOD SPECIFICATION
*Water Absorption	5% by weight (max.)	ASTM D 471
Compression Set	30% (max.)	ASTM D 395
Tensile Strength (after aging 48 hrs)	80% tensile strength (min.)	ASTM D 572
PHYSICAL TEST	TEST VALUE	TEST METHOD SPECIFICATION
Tensile Strength	2500 psi (min.)	ASTM D 412
Elongation at Break	450 percent (min.)	ASTM D 412
300 percent Modulus	900 psi (min.)	ASTM D 412
Durometer Hardness (Shore Type A)	60 to 70	ASTM D 2240
*Water Absorption	5% by weight (max.)	ASTM D 471
Compression Set	30% (max.)	ASTM D 395
Tensile Strength (after aging 48 hrs)	80% tensile strength (min.)	ASTM D 572

* The "Water Absorption" test shall be performed with distilled water. The washed specimen shall be blotted dry with filter paper or other absorbent material and suspended by means of small glass rods in the oven at a temperature of 70 degrees C plus or minus 2 degrees for 22 plus or minus 1/4 hour. The specimen shall be removed, allowed to cool to room temperature in air, and weighed. The weight shall be recorded to the nearest 1 mg as M subscript 1 (M subscript 1 is defined in ASTM D 471). The immersion temperature shall be 70 degrees C plus or minus one (1) degree and the duration of immersion shall be 166 hours.

2.1.2.2 [Fabrication]

Rubber seals shall have a fluorocarbon film vulcanized and bonded to the sealing surface of the bulb. The film shall be [0.762] [1.524] mm[0.030] [0.060] inch thick Huntington Abrasion Resistant Fluorocarbon Film No. 4508, or equal, and shall have the following physical properties:

Tensile strength 13.8 MPa (min.)
Elongation..... 250 percent (min.)
Tensile strength 2,000 psi (min.)
Elongation..... 250 percent (min.)

The outside surface of the bonded film shall be flush with the surface of the rubber seal and shall be free of adhering or bonded rubber. Strips and corner seals shall be molded in lengths suitable for obtaining the finish lengths shown and with sufficient excess length to provide test specimens

for testing the adequacy of the adhesion bond between the film and bulb of the seal. At one end of each strip or corner seal to be tested, the fluorocarbon film shall be masked during bonding to prevent a bond for a length sufficient to hold the film securely during testing.]

2.1.3 Bumpers and Fenders

[Bumpers and fenders shall be "Rubbumper," a product of Missouri Dry Dock & Repair Co., or an approved equal.] [Timber bumpers and fenders shall conform to [west coast fir] [or] [southern yellow pine], structural grade, dressed surfacing, pressure treated with creosote conforming to [AWPA P3] in accordance with AWPA C2. Bumpers and fenders shall be cut, beveled, or bored as required before being pressure treated.]

2.1.4 Asphalt Mastic

SSPC Paint 12.

2.2 MANUFACTURED UNITS

Bolts, nuts, washers, screws and other manufactured units shall conform with the requirements shown and specified and in Section 05502A METALS: MISCELLANEOUS, STANDARD ARTICLES, SHOP FABRICATED ITEMS.

2.2.1 Bolts, Nuts and Washers

High-strength bolts, nuts, and washers shall conform to ASTM A 325M ASTM A 325, Type [____], [hot-dip galvanized] or ASTM A 490M ASTM A 490, Type [____]. Bolts, nuts, studs, stud bolts and bolting materials other than high-strength shall conform to ASTM A 307, Grade A, [hot-dip galvanized] or ASTM A 320/A 320M, [Ferritic Steel, Grade [____]] [Austenitic Steel, Grade [____], Class [____]]. Bolts M16 1/2 inch and larger shall have hexagon heads. The finished shank of bolts shall be long enough to provide full bearing. Washers for use with bolts shall conform to the requirements specified in the applicable specification for bolts.

2.2.2 Screws

Screws shall be of the type indicated on the drawings.

2.3 FABRICATION

2.3.1 Detail Drawings

Detail drawings, including fabrication drawings, shop assembly drawings, delivery drawings, and field installation drawings, shall conform to the requirements specified and in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

2.3.1.1 Fabrication Drawings

Fabrication drawings shall show complete details of materials, tolerances, connections, and proposed welding sequences which clearly differentiate shop welds and field welds.

2.3.1.2 Shop Assembly Drawings

Shop assembly drawings shall provide details for connecting the adjoining fabricated components in the shop to assure satisfactory field installation.

2.3.1.3 Delivery Drawings

Delivery drawings shall provide descriptions of methods of delivering components to the site, including details for supporting fabricated components during shipping to prevent distortion or other damages.

2.3.1.4 Field Installation Drawings

Field installation drawings shall provide a detailed description of the field installation procedures. The description shall include the location and method of support of installation and handling equipment; provisions to be taken to protect concrete and other work during installation; method of maintaining components in correct alignment; plan for prestressing hinge bracket anchors, which shall include descriptions of connections, riggings, anchorages, and measuring equipment; methods for installing pintle and hinge assemblies, including checking and maintaining alignments during concreting; and methods for installing other appurtenant items.

2.3.2 Structural Fabrication

Structural fabrication shall conform with the requirements shown and specified herein and in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS. Components shall be shop-fabricated of the materials specified and shown. Dimensional tolerances shall be as specified and shown. Splices shall occur only where shown or approved. Pin holes shall be bored in components after welding, straightening, stress-relieving, and threading operations are completed. Brackets, eye bar sections, and other components requiring straightening shall be straightened by methods which will not damage the material. Bronze bushings shall be press-fitted with supporting components. Bolt connections, lugs, clips, or other pick-up assembly devices shall be provided for components as shown and required for proper assembly and installation. Provisions shall be made for the installation of appurtenances as required.

2.3.3 Welding

NOTE: List applicable welds requiring radiographic examination.

Welding shall conform with [AWS D1.1/D1.1M, AWS D1.2,] the requirements specified, and in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS. Welds shall be of the type shown on the contract drawings and approved detail drawings. Radiographic examination is required on the major shop and field welds of the type and location indicated on the drawings and as follows: [____]. Welds which have been designated to receive radiographic examination and are found to be inaccessible to a radiation source or film, or are otherwise so situated that radiographic examination is not feasible may be examined, with written approval of the Contracting Officer, by dye penetrant, magnetic particle tests, or ultrasonic tests. [Components shall be stress-relief heat treated after welding where shown. Stress-relieving of components shall be performed prior to the attachment of miscellaneous appurtenances.]

2.3.4 Bolted Connections

Bolted connections shall conform with the requirements specified in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

2.3.5 Machine Work

Machine work shall conform with the requirements specified in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

2.3.6 Miscellaneous Provisions

Miscellaneous provisions for fabrication shall conform with the requirements specified and in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

2.3.7 Fabrications

Fabrications shall conform to the following requirements.

2.3.7.1 Gate Leaf

Gate leaf shall be of welded fabrication except for bolted appurtenances. Gate leaf shall consist of a pintle socket, pipe column, and hinge pin housing integrally framed with horizontal and vertical trusses supporting vertical ribs faced with a continuous skin plate. Pintle socket shall be of cast steel conforming to ASTM A 27/A 27M. Pintle socket shall be press-fitted with bronze bushing conforming ASTM B 22. Bearing surfaces of the bronze bushing shall have a truly hemispherical 0.4 micrometer 16 microinch finish. Pipe column shall conform to [ASTM A 53/A 53M] [ASTM A 501]. Hinge pin housing shall be of [cast steel conforming to ASTM A 27/A 27M] [structural steel conforming to ASTM A 36/A 36M]. Trusses and vertical ribs shall be of structural steel conforming to ASTM A 36/A 36M. Skin plate shall conform to [ASTM A 36/A 36M] [ASTM A 572/A 572M, Grade 50,] [ASTM A 588/A 588M, Grade 50]. Gate leaf shall be shop-fabricated. Contractor proposed shop-fabrication of gate leaf in separate segments to facilitate handling and shipping must be approved and shall be as shown on approved detail drawings. Such segments shall permit easy field-assembly and shall be as few as practicable to minimize the number of joints to be field-welded. The overall height of the gate leaf shall not vary from the nominal dimension or differ from the mating gate leaf by more than 6 mm 1/4 inch. The surfaces of the vertical ribs to which skin plates are to be welded shall not vary from a true plane by more than 5 mm 3/16 inch. The outside surfaces of skin plates welded to the vertical ribs shall not vary from a true plane by more than 5 mm 3/16 inch. Splices in skin plates shall be located only where shown or approved. [In addition to welds specifically indicated on the drawings for nondestructive testing, [_____] percent of the welds in the [hinge pin housing] [joints between trusses and pintle socket] [joints between trusses and hinge pin housing] [joints between vertical webs and skin plate] [and] skin plate shall receive nondestructive testing. The location of these additional welds for testing shall be as directed by the Contracting Officer.] Gate leaf shall be provided complete with pintle assembly, hinge assembly, seal assembly, and other appurtenant components as required for complete installation as specified and shown.

2.3.7.2 Hinge Assembly

Hinge assembly shall consist of hinge bracket support anchor frame, hinge

bracket support, hinge bracket, and hinge pin. Hinge bracket support anchor frame shall be a welded structural steel frame with high strength anchor bolts conforming to ASTM A 722/A 722M for prestressed anchorage of the hinge bracket support. Hinge bracket support and hinge bracket shall be of [cast steel conforming to ASTM A 27/A 27M] [structural steel conforming to ASTM A 36/A 36M]. The hinge pin barrel section of the hinge bracket shall be fitted with [a stainless steel collar conforming to ASTM A 564/A 564M and] [a bronze bushing conforming with ASTM B 22] [an aluminum bronze bushing conforming to ASTM B 148]. Hinge pin shall be of [forged steel conforming to ASTM A 668/A 668M] [stainless steel conforming to [ASTM A 276] [ASTM A 564/A 564M]]. [In addition to welds specifically indicated on the drawings for nondestructive testing, [_____] percent of the welds in the hinge assembly components shall receive nondestructive testing. The location of these additional welds for testing shall be directed by the Contracting Officer.] [Welded hinge assembly components shall be stress-relieved by heat-treating after all welding is completed. Stress-relieving shall be performed prior to machining.]

2.3.7.3 Pintle Assembly

Pintle assembly shall consist of pintle base anchor frame, pintle base, pintle socket seal retainer ring assembly, pintle, and pintle socket which shall be an integral component of the gate leaf. Pintle base anchor frame shall be a welded structural steel frame [with high strength anchor bolts conforming to ASTM A 722/A 722M for prestressed anchorage of the pintle base]. Pintle base shall be of [cast steel conforming to ASTM A 27/A 27M] [structural steel conforming to ASTM A 36/A 36M]. Pintle shall be of [cast alloy steel] [forged alloy steel with bearing surfaces of corrosion-resisting steel deposited in weld passes to a thickness of not less than 3 mm 1/8 inch and machined the required shape]. The pintle ball pintle shall receive a 0.4 micrometer 16 microinch finish and shall be fitted into the bushing of the pintle socket by scraping the bushing until uniform contact is attained over the entire bearing surface as determined by testing with carbon paper or other approved coloring. The pintle ball shall be match-marked with the bushing when fitted and so erected in the field.

2.3.7.4 Seal Assemblies

Seal assemblies shall consist of rubber seals, stainless steel retainer and spacer bars, and fasteners. Rubber seals shall be continuous over the full length. Seals shall be accurately fitted and drilled for proper installation. Bolt holes shall be drilled in the rubber seals by using prepared templates or the retainer bars as templates. Splices in seals shall be fully molded, develop a minimum tensile strength of 50 percent of the unspliced seal, and occur only at locations shown. All vulcanizing of splices shall be done in the shop. The vulcanized splices between molded corners and straight lengths shall be located as close to the corners as practicable. Splices shall be on a 45 degree bevel related to the "thickness" of the seal. The surfaces of finished splices shall be smooth and free of irregularities. Stainless steel retainer bars shall be field-spliced only where shown and shall be machine-finished after splicing.

2.3.7.5 Appurtenant Items

Seal plates, seal shapes, pintle socket seal retainer ring assembly, bumpers, fenders, [walkways,] [bridgeways,] and other appurtenant items shall conform to details specified and shown.

2.3.8 Shop Assembly

Shop assembly requirements for sector gates and appurtenant items shall be as shown and specified herein and in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS. Sector gates and appurtenant items shall be assembled completely in the shop, unless otherwise approved, to assure satisfactory field installation. Adjoining components shall be fitted and bolted together to facilitate field connections. The matchmarking of unassembled items shall be carefully preserved until the items are assembled. Mating surfaces and machined surfaces shall be covered with a rust preventive until assembly. Assembled components shall be shop-welded in their final positions as much as delivery and field installation conditions will permit. Rubber seals shall be fitted and drilled to match the seal retainers, match-marked, and removed for shipment. Shop assembly and disassembly work shall be performed in the presence of the Contracting Officer unless otherwise approved. The presence of the Contracting Officer will not relieve the Contractor of any responsibility under this contract.

2.4 TESTS, INSPECTIONS, AND VERIFICATIONS

Tests, inspections, and verifications for materials shall conform to the requirements specified and in Section 05055A METALWORK FABRICATION, MACHINE WORK, AND MISCELLANEOUS PROVISIONS.

2.4.1 [Testing of Rubber Seals

NOTE: If fluorocarbon (Teflon) clad seals are not used, delete this paragraph.

The fluorocarbon film of rubber seals shall be tested for adhesion bond in accordance with ASTM D 413 using either the machine method or the deadweight method. A 25 mm 1 inch long piece of seal shall be cut from the end of the seal which has been masked and subjected to tension at an angle approximately 90 degrees to the rubber surface. There shall be no separation between the fluorocarbon film and the rubber when subjected to the following loads:

THICKNESS OF FLUOROCARBON FILM	MACHINE METHOD AT 50 MM PER MINUTE	DEADWEIGHT METHOD
[1.524 mm	13.6 kg per 25 mm width	13.6 kg per 25 mm width]
[0.726 mm	13.6 kg per 25 mm width	13.6 kg per 25 mm width]
THICKNESS OF FLUOROCARBON FILM	MACHINE METHOD AT 2 INCHES PER MINUTE	DEADWEIGHT METHOD
[0.030 inch	30 pounds per inch width	30 pounds per inch width]
[0.060 inch	30 pounds per inch width	30 pounds per inch width]]

PART 3 EXECUTION

3.1 INSTALLATION

Installation shall conform with the requirements specified herein and in Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS. Sector gates and appurtenant items shall be assembled for installation in strict accordance with the contract drawings, approved installation drawings, and shop match-markings. Bearing surfaces requiring lubrication shall be thoroughly cleaned and lubricated with an approved lubricant before assembly and installation. Components to be field-welded shall be in correct alignment before welding is commenced.

3.1.1 Embedded Metals

Seal shapes, seal plates, frames, bases and other embedded metal items required for proper and complete installation shall be accurately installed to the alignment and grade required to ensure accurate fitting and matching of components. Embedded metals shall be given a primer coat of the required paint on all surfaces prior to installation in concrete forms. Anchors for embedded metals shall be installed as shown. Items requiring two concrete pours for installation shall be attached to the embedded anchors after the initial pour, adjusted to the proper alignment, and concreted in place with the second pour. Welded field splices in sealing surfaces of embedded items shall be ground smooth.

3.1.2 Hinge Assembly Embedded Anchorages

The hinge assembly embedded anchorages consisting of the hinge bracket support anchor frame and attached hinge bracket support anchor bolts shall be aligned accurately, leveled, and blocked rigidly in place to prevent displacement before concrete is placed. Hinge bracket support anchor bolts shall be coated with asphalt mastic prior to the placement of first-pour concrete. Hinge bracket support shall be connected to anchor bolts and embedded in second-pour concrete. Anchor bolts shall be prestressed as shown on contract drawings and approved field installation drawings after the concrete has attained the specified strength. A record of the prestressing operations shall be compiled and submitted.

3.1.3 Pintle Base Anchor Frame and Pintle Base

NOTE: Design options provided in this paragraph consist of the pintle base bearing directly on an anchor frame embedded in second-pour concrete and anchored with bolts embedded in first-pour concrete, the pintle base bearing directly on second-pour concrete and anchored with bolts attached to an anchor frame embedded in first-pour concrete, and the prestressing of pintle base anchor bolts when attached to an anchor frame embedded in first-pour concrete.

[Anchor bolts for the pintle base anchor frame shall be embedded in first-pour concrete. Pintle base anchor frame shall be attached to the anchor bolts, aligned, leveled, blocked rigidly to prevent displacement, and embedded in second-pour concrete. Pintle base shall be bolted to the pintle base anchor frame.] [Pintle base anchor frame shall be embedded in

first-pour concrete. Pintle base shall be attached to the pintle base anchor bolts extending from the embedded anchor frame, aligned, leveled, blocked rigidly to prevent displacement, and embedded in second-pour concrete.] [Pintle base anchor bolts shall be prestressed as shown on contract drawings and approved field installation drawings. A record of the prestressing operations shall be compiled and submitted.] Concrete pours shall be allowed to set for 72 hours and must attain the specified before any loading is applied.

3.1.4 Pintle

Surfaces of the pintle base shall be cleaned thoroughly prior to installing the pintle. The pintle shaft shall be set in the pintle base and secured by lock-bolting.

3.1.5 Gate Leaf

Gate leaf components not assembled in the shop shall be assembled in the field as required for installation. Pintle socket seal retainer ring assembly shall be attached to the pintle socket and the pintle ball shall be coated with grease prior to setting the gate leaf in place. Pintle grease pipes shall be tapped into pintle bushing in correct register with bushing grease grooves. Grease pipes shall be flushed prior to connecting to bearings. All necessary precautions shall be taken to avoid distortion of the gate leaf or any component parts. Special care shall be exercised during installation to prevent any sag of the sector gate leaf due to compression of blocking or other causes.

3.1.6 Hinge Bracket and Hinge Pin

Hinge bracket shall be attached to the hinge bracket support after the gate leaf has been set in place. Hinge pin shall be inserted to connect the hinge pin barrel of the hinge bracket to the hinge pin housing of the gate leaf. Hinge bracket shall be adjusted so that the center of the hinge pin is in vertical alignment with the center of the pintle and each gate leaf swings without interference and any point on the moving gate leaf remain in a plane throughout the range of movement.

3.1.7 Painting

Exposed parts of gates and appurtenances, except machined surfaces, corrosion-resistant surfaces, surfaces of anchorages embedded in concrete, [cathodic protection system anodes,] and other specified surfaces shall be painted as specified in Section 09964 PAINTING: HYDRAULIC STRUCTURES.

3.1.8 Seal Assemblies

Rubber seal assemblies shall be installed after the embedded metal components have been concreted in place and the gate installation, including painting, completed. Rubber seals shall be fastened securely to metal retainers. Before operating the gates, a suitable lubricant shall be applied to the rubber seal rubbing plates to protect the rubber.

3.2 CATHODIC PROTECTION SYSTEM

The cathodic protection system shall conform to Section [[_____] [CATHODIC PROTECTION SYSTEMS FOR SECTOR GATES]] [[_____] [CATHODIC PROTECTION FOR LOCK MITER GATE]].

3.3 OPERATING MACHINERY

Operating machinery shall conform to Section [_____] [SECTOR GATE OPERATING MACHINERY].

3.4 FIELD TESTS AND INSPECTIONS

3.4.1 [Skinplate Watertightness Test

**NOTE: Skinplate watertightness tests should be
deleted when complete or spot radiographic or
ultrasonic examination of the skinplate is required
by the specifications.**

After the gate leaves are installed but prior to painting and mounting of seals, skinplate welds shall be tested for watertightness by applying air pressure with a hose, using a minimum air pressure of 400 kPa 60 psi at the nozzle, to one face of the skinplate with a light coating of soapsuds on the opposite face. Disclosed leaks shall be sealed with light welds.]

3.4.2 Acceptance Trial Operation

After completion of the gate installation, the Contracting Officer will examine the gates for final acceptance. The gates will be examined first to determine whether or not the workmanship conforms to the specification requirements. The Contractor will then be required to operate the gates from the fully-opened to the fully-closed position a sufficient number of times to demonstrate to the Contracting Officer's satisfaction that all parts are functioning properly. The workmanship in the fabrication and installation of gates shall be such that the gates in the closed position will form a watertight barrier across the opening. Required repairs or replacements to correct defects, as determined by the Contracting Officer, shall be made at no cost to the Government. The trial operation shall be repeated after defects are corrected. Prior to final acceptance of the gates, the Contractor shall provide temporary restraints to prevent unauthorized operation of the gates.

3.5 PROTECTION OF FINISHED WORK

Protection of finished work shall conform to the requirements of Section 05055A METALWORK FABRICATION, MACHINE WORK, MISCELLANEOUS PROVISIONS.

-- End of Section --