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USACE / NAVFAC / AFCEA UFGS-02397 (May 2003)  
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Preparing Activity: NAVFAC Superseding  
UFGS-02397N (September 1999)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated 22 December 2004

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### SECTION 02397

#### ARCH-TYPE RUBBER MARINE FENDERS 05/03

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NOTE: This guide specification covers the requirements for arch-type rubber marine fenders.

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.

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NOTE: On the project drawings, show location of fenders and size and spacing of fasteners.

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## PART 1 GENERAL

### 1.1 REFERENCES

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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.

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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.

ASME INTERNATIONAL (ASME)

ASME B18.22.1	(1965; R 2003) Plain Washers
ASME B18.22M	(1981; R 2000) Metric Plain Washers

ASTM INTERNATIONAL (ASTM)

ASTM A 479/A 479M	(2004) Stainless Steel Bars and Shapes for Use in Boilers and Other Pressure Vessels
ASTM D 1171	(1999) Rubber Deterioration - Surface Ozone Cracking Outdoors or Chamber (Triangular Specimens)
ASTM D 2000	(2003ae1) Rubber Products in Automotive Applications
ASTM D 395	(2003) Rubber Property - Compression Set
ASTM D 412	(1998a; R 2002e1) Vulcanized Rubber and Thermoplastic Elastomers - Tension
ASTM D 471	(1998e1) Rubber Property - Effect of Liquids
ASTM D 573	(2004) Rubber - Deterioration in an Air Oven
ASTM D 575	(1991; R 2001) Rubber Properties in Compression
ASTM D 624	(2000e1) Tear Strength of Conventional Vulcanized Rubber and Thermoplastic Elastomers
ASTM D 746	(2004) Brittleness Temperature of Plastics and Elastomers by Impact
ASTM F 593	(2002e2) Stainless Steel Bolts, Hex Cap Screws, and Studs
ASTM F 594	(2002) Stainless Steel Nuts

U.S. DEPARTMENT OF DEFENSE (DOD)

MIL-PRF-907	(Rev E; Am 2) Antiseize Thread Compound, High Temperature
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1.2 SUBMITTALS

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**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.

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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-03 Product Data

Fender

Hardware

SD-05 Design Data

Reaction--energy--percent compression curve

Dimension

Fender material specifications

Design calculations

SD-06 Test Reports

Minimum Tensile Strength

Shore Hardness (Durometer)

Modulus at 400 Percent Elongation

Maximum Compression Set

Tear Resistance  
Minimum Elongation  
Ozone Resistance  
Low Temperature Impact Resistance  
Water Absorption  
Heat Resistance  
Compression Deflection Resistance  
Fender Compression Test  
Angular Fender Compression Test

Tests shall have been performed on the specified fender within 5 years of submittal of the reports for approval. Test reports shall be accompanied by notarized certificates from the manufacturer certifying that the tested material is of the same type, quality, manufacture and make as that proposed to be supplied.

#### SD-08 Manufacturer's Instructions

##### Installation Instructions

### 1.3 DELIVERY HANDLING AND STORAGE

Fenders shall be undamaged when delivered and shall be handled and stored so as to prevent damage, such as bending or abrading end fittings, cutting of rubber, or damage to coating of hardware. Protect fenders from exposure to damaging liquids, oils, greases and extended exposure to sunlight.

## PART 2 PRODUCTS

### 2.1 CONFIGURATION

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**NOTE: Coordinate angle with angular compression  
test requirements.**  
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Fender shall be extruded and shall be continuous in the length indicated. The fenders shall have a truncated "A" cross section shape and be attached to the structure at the base, the widest dimension, of the arch. The connecting hardware shall be fully exposed. No encased hardware or molded fenders shall be allowed. The fender and hardware shall be designed and factory tested to the loads per linear meter foot of fender specified in paragraph entitled "PERFORMANCE," for angles of approach of 0 and 0.26 rad 0 and 15 degrees. Fender anchor bolts and method of anchorage shall be of the size and spacing required by the manufacturer's design and testing; however, the size and spacing of anchor bolts indicated on the drawings shall be construed to be the minimum required, unless exceeded by the requirements of the fender manufacturer's design.

## 2.2 ELASTOMER

The elastomer shall be the ethylene propylene dimonomer (EPDM), as specified in ASTM D 2000, with the following properties:

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NOTE: Coordinate values with calculated design requirements.  
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### ELASTOMER PROPERTY REQUIREMENTS

Minimum Tensile Strength (ASTM D 412)	[14 MPa] [_____]
Shore Hardness (Durometer) (ASTM D 412)	[70 $\pm$ 5] [_____]
Modulus at 400 Percent Elongation (ASTM D 412)	[6.2 MPa] [_____]
Maximum Compression Set (ASTM D 395 Method B, Maximum Percent 22 Hr. at 70 Degrees C	[25] [_____] Percent
Tear Resistance (ASTM D 624; DIE B Min. 150 lb/in)	[300] [_____] lb/in.
Minimum Elongation (ASTM D 412)	[500] [_____] Percent
Ozone Resistance (ASTM D 1171 Exposure Method B; 70h Bent Loop at 38 Degrees C; 50pphm)	[80] [_____] H $\pm$
Low Temperature Impact Resistance (ASTM D 746 Procedure B; Non-Brittle at -55 Degrees C)	[0] [_____] Degrees C
Water Absorption (ASTM D 471 Method B; 70h at 100 Degrees C.; Volume Change $\pm$ 5 Percent	[10.0] [_____] Percent
Heat Resistance (ASTM D 573; 70h at 100 Degrees C Ch Tensile, Elong. -25 Percent, Hardness +10	Shall exceed requirements
Compression Deflection Resistance (ASTM D 575 Method B; 3 S Dwell at 23 Degrees C	Shall exceed requirements

### ELASTOMER PROPERTY REQUIREMENTS

Minimum Tensile Strength (ASTM D 412)	[2000 psi] [_____]
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#### ELASTOMER PROPERTY REQUIREMENTS

Shore Hardness (Durometer) (ASTM D 412)	[70 $\pm$ 5] [_____]
Modulus at 400 Percent Elongation (ASTM D 412)	[900 psi] [_____]
Maximum Compression Set (ASTM D 395 Method B, Maximum Percent 22 Hr. at 158 Degrees F)	[25] [_____] Percent
Tear Resistance (ASTM D 624; DIE B Min. 150 lb/in)	[300] [_____] lb/in.
Minimum Elongation (ASTM D 412)	[500] [_____] Percent
Ozone Resistance (ASTM D 1171 Exposure Method B; 70h Bent Loop at 100 Degrees F; 50pphm)	[80] [_____] H $\pm$
Low Temperature Impact Resistance (ASTM D 746 Procedure B; Non-Brittle at -67 Degrees F)	[-40] [_____] Degrees F
Water Absorption (ASTM D 471 Method B; 70h at 212 Degrees F.; Volume Change $\pm$ 5 Percent	[10.0] [_____] Percent
Heat Resistance (ASTM D 573; 70h at 212 Degrees F Ch Tensile, Elong. -25 Percent, Hardness +10	Shall exceed requirements
Compression Deflection Resistance (ASTM D 575 Method B; 3 S Dwell at 73 Degrees F	Shall exceed requirements

### 2.3 HARDWARE

#### 2.3.1 Plates and Angles

ASTM A 479/A 479M, Type 316L stainless steel for plates, angles, and miscellaneous hardware required to attach the fenders to the structure.

#### 2.3.2 Nuts, Bolts, and Washers

ASTM F 593 or ASTM F 594, Group 2 (316 alloy) stainless steel for nuts and bolts. ASME B18.22M ASME B18.22.1 for washers, except fabricate washers of 316 alloy stainless steel.

#### 2.3.3 Antiseize Compound

MIL-PRF-907.

## 2.4 PERFORMANCE

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**NOTE: Coordinate values with calculated design requirements.**  
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When vertically compressed by a plate extending the full length and width of a 0.30 m one foot section of the fender, the fender shall absorb [8950] [\_\_\_\_\_] joules [6,600] [\_\_\_\_\_] foot pounds of energy  $\pm 10$  percent when [48] [\_\_\_\_\_] percent compressed (i.e., to a dimension of [52] [\_\_\_\_\_] percent of its original height) with a corresponding load of not more than [85,402] [\_\_\_\_\_] N [19,200] [\_\_\_\_\_] pounds  $\pm 10$  percent.

### 2.4.1 FENDER COMPRESSION TEST

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**NOTE: Coordinate values with calculated design requirements.**  
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Compress fender along its longitudinal axis between two parallel flat plate surfaces to a compressed dimension of [48] [\_\_\_\_\_] percent of its original height. Record load and the corresponding deflection at 6 mm 1/4 inch increments and plot as a graph of load versus deflection. The Load-Deflection curve shall then be integrated to generate an Energy-Deflection curve for the fender. After compression of the fender to [48] [\_\_\_\_\_] percent of its original height, the fender shall be rebound to 98 percent of its original height within [ten] [\_\_\_\_\_] minutes after the load is removed.

### 2.4.2 ANGULAR FENDER COMPRESSION TEST

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**NOTE: Coordinate values with calculated design requirements.**  
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Compress fender along its longitudinal axis between two flat plate surfaces, at an angle of [0.26] [\_\_\_\_\_] rad [15] [\_\_\_\_\_] degrees to each other, to a compressed dimension of [48] [\_\_\_\_\_] percent of its original height. Record load and the corresponding deflection at 6 mm 1/4 inch increments and plot as a graph of load versus deflection. The Load-Deflection curve shall then be integrated to generate an Energy-Deflection curve for the fender. After compression of the fender to [48] [\_\_\_\_\_] percent of its original height, the fender shall rebound to 98 percent of its original height within [10] [\_\_\_\_\_] minutes after the load is removed.

## PART 3 EXECUTION

### 3.1 INSTALLATION

Install fenders with the fender longitudinal axis vertical. Install the fenders in the position and at the spacing indicated on the drawings.

#### 3.1.1 Antiseize Compound

Coat threads of bolts prior to applying washers and nuts. Recoat bolt



thread projection beyond nut after tightening.  
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