



## **SPECIFICATION: STAINLESS STEEL GATES**

### **PART 1 GENERAL**

#### **1.01 SCOPE OF WORK**

A. The CONTRACTOR shall furnish all labor, materials, equipment and incidentals required to install, ready for operation and field test stainless steel gates and appurtenances as shown on the Contract Drawings and as specified herein.

B. The gates and appurtenances shall be supplied in accordance with the latest edition of AWWA C561 Standard for Fabricated Stainless Steel Slide Gates as modified herein. The allowable leakage rate for the stainless steel gates in this specification shall be 1/2 the allowable leakage listed in the latest revision of AWWA C561.

#### **1.02 SUBMITTALS**

A. Provide the following information to confirm compliance with the specification in addition to the submittal requirements specified in Section \_\_\_\_\_.

1. Complete description of all materials including the material thickness of all structural components of the frame and slide.
2. General assembly drawings showing all details of construction, details required for installation, dimensions, and anchor bolt locations. General assembly drawings must be provided in 3D format.
3. Maximum bending stress and deflection of the slide under the maximum design head.
4. The location of the company headquarters and the location of the principle manufacturing facility. Provide the name of the company that manufactures the equipment if the supplier utilizes an outside source.



## QUALITY ASSURANCE

### A. Qualifications

1. All of the equipment specified under this Section shall be furnished by a single manufacturer with a minimum of 20 years experience designing and manufacturing water control gates. The manufacturer shall have manufactured water control gates for a minimum of 100 projects.
2. The principle manufacturer must have an ASTM A380 compliant in house pickle and passivation facility.
3. The specification is based on the Stainless Steel Gate as manufactured by Rodney Hunt, Inc of Orange, MA.

### B. Contamination Prevention

1. In order to avoid contamination and maintain surface purity, the principle manufacturing facility must have a dedicated stainless steel facility segregated and isolated from the facility where products of other materials such as carbon steel or cast iron are manufactured. The stainless steel material must be kept separated from other materials beginning from acquisition and storage through handling, fabrication, assembly, and dispatch.
2. Mechanical removal of free iron particle, oil, dirt, paint, welding flux, slag, heat tint and scales of oxides must be supplemented with a submerged pickle and passivation bath process. Mechanical blasting alone is not an acceptable method of contamination prevention.
3. The pickling and passivation procedure must be compliant per ASTM A380 standards and utilize a Nitric and Hydrofluoric acid combination pickling solution followed immediately by demineralized water passivation. To ensure an environmentally safe discharge, the pickling facility must be equipped with fume extraction and acid scrubbing systems.

### C. Corrosion Prevention

1. To prevent crevice corrosion and advocate long life of stainless steel fabricated products, the principle manufacturer must only use continuous welding practices performed in house by the principle manufacturer.
2. To limit the possibility of changing the corrosion resistance properties and also restrict surface distortion, all stainless steel must be cut utilizing a heatless CNC water jet.

### D. Factory Leakage Testing

1. All stainless steel gates must pass a leakage test under full specified head at the principle manufacturer's facility prior to shipment to site.



## **PART 2      EQUIPMENT**

### **2.01    GENERAL**

- A. Gates shall be as specified herein and have the characteristics and dimensions shown on the Contract Drawings.
- B. Leakage shall not exceed 0.05 gpm/ft of wetted seal perimeter in seating head and unseating head conditions.
- C. The gate shall utilize self-adjusting seals. Due to the difficulty of accessing gates when they are in service - gates that utilize adjustable wedges, wedging devices or pressure pads are not acceptable.
- D. All structural components of the frame and slide shall be fabricated of stainless steel having a minimum thickness of 1/4-inch and shall have adequate strength to prevent distortion during normal handling, during installation and while in service.
- E. All welds shall be full and continuous performed by welders with AWS certification for all material grades such as 304, 304L, 316, 316L, duplex, and super duplex.
- F. Finish: Mill finish on stainless steel. Welds shall be sandblasted to remove weld burn and scale accompanied by pickle & passivation. All iron and steel components shall be properly prepared and shop coated with a primer.

### **2.02    FRAME**

- A. The frame assembly, including the guide members, invert member and yoke members, shall be constructed of stainless steel plate with a minimum thickness of 1/4-inch.
  - 1. Frame design shall allow for embedded mounting, mounting directly to a wall with stainless steel anchor bolts and grout or mounting to a wall thimble with stainless steel mounting studs and a mastic gasket material. Mounting style shall be as shown on the Contract Drawings.
  - 2. All wall mounted or wall thimble mounted gates shall have a flange frame. Flat frame gates are not acceptable.
  - 3. Gussets shall be provided as necessary to support the guide members in an unseating head condition.
  - 4. The frame shall extend to accommodate the entire height of the slide when the slide is in the fully opened position on upward opening gates or downward opening weir gates.
  - 5. On self-contained gates, a yoke shall be provided across the top of the frame. The yoke shall be formed by a structural members affixed to the top of the side frame members to provide a one-piece rigid assembly. The yoke shall be designed to allow removal of the slide.



6. A rigid stainless steel invert member shall be provided across the bottom of the opening. The invert member shall be of the flush bottom type on upward opening gates.
7. A rigid stainless steel top seal member shall be provided across the top of the opening on gates designed to cover submerged openings.
8. A rigid stainless steel member shall be provided across the invert of the opening on downward opening weir gates.

## 2.03 SLIDE

A. The slide and reinforcing stiffeners shall be constructed of stainless steel plate. All structural components shall have a minimum thickness of 1/4-inch.

1. The slide shall not deflect more than 1/360 of the span or 1/16 inch, whichever is smaller, under the maximum design head.
2. Reinforcing stiffeners shall be continuously welded (stitch welding will not be acceptable) to the slide and mounted horizontally. Vertical stiffeners shall be continuously welded on the outside of the horizontal stiffeners for additional reinforcement.
3. The stem connector shall be constructed of two angles or plates. The stem connector shall be continuously welded to the slide. A minimum of two bolts shall connect the stem to the stem connector.

## 2.04 SEALS

A. All gates shall be provided with a self-adjusting seal system to restrict leakage in accordance with the requirements listed in this specification.

1. All gates shall be equipped with UHMW polyethylene seat/seals to restrict leakage and to prevent metal to metal contact between the frame and slide.
2. The seat/seals shall extend to accommodate the 1-1/2 x the height of the slide when the slide is in the fully closed or fully opened position.
3. All upward opening gates shall be provided with a resilient seal to seal the bottom portion of the gate. The seal shall be attached to the invert member or the bottom of the slide and it shall be held in place with stainless steel attachment hardware.
4. All downward opening weir gates shall be provided with UHMW polyethylene seat/seals across the invert member.
5. The seal system shall be durable and shall be designed to accommodate high velocities and frequent cycling without loosening or suffering damage.
6. All seals must be bolted or otherwise mechanically fastened to the frame or slide.



7. The seals shall be mounted so as not to obstruct the water way opening.
8. Gates that utilize rubber “J” seals or “P” seals are not acceptable.
9. The seal system shall have been factory tested to confirm negligible wear (less than 0.01”) and proper sealing. The factory testing shall consist of an accelerated wear test comprised of a minimum of 25,000 open-close cycles using a well-agitated sand/water mixture to simulate fluidized grit.

## 2.05 STEM

- A. A threaded operating stem shall be utilized to connect the operating mechanism to the slide.
- B. On rising stem gates, the threaded portion shall engage the operating nut in the manual operator or motor actuator. On non-rising stem gates; the threaded portion shall engage the nut on the slide.
  1. The threaded portion of the stem shall have a minimum outside diameter of 1-1/2 inches. Stem extension pipes are not acceptable.
  2. The stem shall be constructed of solid stainless steel bar for the entire length, the metal having a tensile strength of not less than 90,000 psi for stems that are 3 inches or less in diameter. Stems that are in excess of 3 inches in diameter shall have a tensile strength of 85,000 psi.
  3. The stem shall be threaded to allow full travel of the slide unless the travel distance is otherwise shown on the Contract Drawings.
  4. Maximum L/R ratio for the unsupported part of the stem shall not exceed 200.
  5. In compression, the stem shall be designed for a critical buckling load caused by a 40 lb. effort on the crank or handwheel with a safety factor of 2, using the Euler column formula.
  6. The stem shall be designed to withstand the tension load caused by the application of a 40 lb. effort on the crank or handwheel without exceeding 1/5 of the ultimate tensile strength of the stem material.
  7. The threaded portion of the stem shall have threads of Acme type with a 16 micro inch finish or better.
  8. Stems of more than one section shall be joined by stainless steel or bronze couplings. The coupling shall be threaded and bolted to the stems.
  9. Stems shall be provided with adjustable stop collars to prevent over closing of the slide.



## STEM GUIDES

- A. Stem guide shall be provided when necessary to ensure that the maximum L/R ratio for the unsupported part of the stem is 200 or less.
1. Stem guide brackets shall be fabricated of stainless steel and shall be outfitted with UHMW or bronze bushings.
  2. Adjustable in two directions.

## 2.02 WALL THIMBLES

- A. Wall thimbles shall be provided when shown on the Contract Drawings.
1. The wall thimble depth shall be equal to the thickness of the concrete wall in which the thimble is to be mounted.
  2. Wall thimbles shall be fabricated stainless steel construction of adequate section to withstand all operational and reasonable installation stresses.
  3. Wall thimbles shall be constructed of 1/4-inch minimum thickness stainless steel and the front face shall have a minimum thickness of 1/4-inch.
  4. The fabrication process shall ensure that the wall thimble is square and plumb and the front face is sufficiently flat to provide a proper mounting surface for the gate frame.
  5. The face of the wall thimble shall only be machined if recommended by the gate manufacturer. If the wall thimble is to be machined, the front face shall have a minimum thickness of 1/4-inch after machining.
  6. A water stop shall be welded around the periphery of the thimble. Wall thimbles shall be designed to allow thorough and uniform concrete placement during installation.
  7. Studs and nuts shall be stainless steel. Water stop may be stitch welded.
  8. A suitable gasket or mastic shall be provided to seal between the gate frame and the wall thimble.



## 2.03 MATERIAL OF CONSTRUCTION

Frame Assembly and Retainers:	Stainless Steel, Type 304L, ASTM A240
Slide and Stiffeners:	Stainless Steel, Type 304L, ASTM A240
Stem:	Stainless Steel, Type 304, ASTM A276
Fasteners, Nuts and Bolts:	Stainless Steel, Type 304, ASTM A276
Invert Seal (Upward Opening Gates Only):	Neoprene ASTM D-2000 or EPDM
Seat/Seals and Facing:	Ultra-High Molecular Weight Polyethylene ASTM D4020
Lift Nuts:	Bronze ASTM B584
Pedestals and Wall Brackets:	Stainless Steel, Type 304L, ASTM A276
Operator Housing:	Cast Aluminum or Ductile Iron

## 2.04 MANUAL OPERATORS

A. Unless otherwise shown on the Drawings, gates shall be operated by a manual handwheel or a manual crank-operated gearbox. The operator shall be mounted on the yoke of self-contained gates or on the pedestal of non-self-contained gates.

1. The gate manufacturer shall select the proper gear ratio to ensure that the gate can be operated with no more than a 40 lb. effort when the gate is in the closed position and experiencing the maximum operating head.
2. An arrow with the word "OPEN" shall be permanently attached or cast onto the operator to indicate the direction or rotation to open the gate.
3. Handwheel operators shall be fully enclosed and shall have a cast aluminum housing.
  - a. Handwheel operators shall be provided with a threaded cast bronze lift nut to engage the operating stem.
  - b. Handwheel operators shall be equipped with roller bearings above and below the operating nut.



- c. Positive mechanical seals shall be provided above and below the operating nut to exclude moisture and dirt and prevent leakage of lubricant out of the hoist.
  - d. The handwheel shall be removable and shall have a minimum diameter of 15 inches.
4. Crank-operated gearboxes shall be fully enclosed and shall have cast aluminum or ductile iron housing.
- a. Gearboxes shall have either single or double gear reduction depending upon the lifting capacity required.
  - b. Gearboxes shall be provided with a threaded cast bronze lift nut to engage the operating stem.
  - c. Bearings shall be provided above and below the flange on the operating nut to support both opening and closing thrusts.
  - d. Gears shall be steel with machined cut teeth designed for smooth operation.
  - e. The pinion shaft shall be stainless steel and shall be supported on ball or tapered roller bearings.
  - f. Positive mechanical seals shall be provided on the operating nut and the pinion shafts to exclude moisture and dirt and prevent leakage of lubricant out of the hoist.
  - g. The crank shall be cast aluminum or cast iron with a revolving nylon grip.
  - h. The crank shall be removable.
5. All gates having widths in excess of 72 inches and widths greater than twice their height shall be provided with two gearboxes connected by an interconnecting shaft for simultaneous operation.
- a. Interconnecting shafting shall be constructed of aluminum or stainless steel.
  - b. Flexible couplings shall be provided at each end of the interconnecting shaft.
  - c. One crank shall be provided to mount on the pinion shaft of one of the gearboxes.
6. An extended operator system utilizing chain and sprockets shall be furnished by the manufacturer when the centerline of the crank or handwheel, on a non-gear operator, is located over 48 in above the operating floor. Chain wheels are not acceptable.
- a. A removable stainless steel or aluminum cover shall be provided to enclose chain and sprockets.
  - b. The extended operator system shall lower the centerline of the pinion shaft to 36 in above the operating floor.





- c. A handwheel may be utilized in conjunction with a gearbox in lieu of the extended operator system if the centerline of the pinion shaft is 60 in or less above the operating floor.
7. Pedestals shall be constructed of stainless steel. Aluminum pedestals are not acceptable.
- a. The pedestal height shall be such that the handwheel or pinion shaft on the crank-operated gearbox is located approximately 36 in above the operating floor.
  - b. Wall brackets shall be used to support floor stands where shown on the Drawings and shall be constructed of stainless steel.
  - c. Wall brackets shall be reinforced to withstand in compression at least two times the rated output of the operator with a 40 lb. effort on the crank or handwheel.
  - d. The design and detail of the brackets and anchor bolts shall be provided by the gate manufacturer and shall be approved by the ENGINEER. The gate manufacturer shall supply the bracket, anchor bolts and accessories as part of the gate assembly.
8. Operators shall be equipped with polycarbonate plastic stem covers.
- a. The top of the stem cover shall be closed.
  - b. The bottom end of the stem cover shall be mounted in a housing or adapter for easy field mounting.
  - c. Stem covers shall be complete with indicator markings to indicate gate position.
  - d. When shown on the Contract Drawings, provide 2-inch square nut, mounted in a floor box, with a non-rising stem.
  - e. The square nut shall be constructed of stainless steel.
  - f. The floor box shall be constructed of stainless steel or cast iron and shall be set in the concrete floor above the gate as shown.
  - g. Provide one aluminum or stainless steel T-handle wrench for operation.

## 2.10 ELECTRIC MOTOR ACTUATORS

- A. See Section\_\_.



## 2.11 ANCHOR BOLTS

A. Anchor bolts shall be provided by the gate manufacturer for mounting the gates and appurtenances.

1. Quantity and location shall be determined by the gate manufacturer.
2. If epoxy type anchor bolts are provided, the gate manufacturer shall provide the studs and nuts.
3. Anchor bolts shall have a minimum diameter of 1/2-inch.

## PART 3 EXECUTIONS

### 3.01 INSTALLATION

A. Installation of the gates and appurtenances shall be done in a workmanlike manner. It shall be the responsibility of the CONTRACTOR to handle, store and install the equipment specified in this Section in strict accordance with the manufacturer's recommendations.

B. The CONTRACTOR shall review the installation drawings and installation instruction prior to installing the gates.

C. The gate assemblies shall be installed in a true vertical plane, square and plumb.

D. The CONTRACTOR shall fill the void in between the gate frame and the wall with non-shrink grout as shown on the installation drawing and in accordance with the manufacturer's recommendations.

E. The CONTRACTOR shall add a mastic gasket between the gate frame and wall thimble (when applicable) in accordance with the manufacturer's recommendations.

### 3.02 FIELD TESTING

A. After installation, all gates shall be field tested in the presence of the ENGINEER and OWNER to ensure that all items of equipment are in full compliance with this Section. Each gate shall be cycled to confirm that they operate without binding, scraping, or distorting. The effort to open and close manual operators shall be measured and shall not exceed the maximum operating effort specified above. Electric motor actuators shall function smoothly and without interruption. Each gate shall be water tested by the CONTRACTOR, at the discretion of the ENGINEER and OWNER, to confirm that leakage does not exceed the specified allowable leakage.