

Nylofor® Swing Gate**1 Scope**

This specification specifies requirements for swing gates with Nylofor® infill.

The gate consists of different components:

- Gate posts with square fixation strip (hinge post and latch post)
- Wing (with or without dental strip)
- Accessories (hinges, lock-system, ground bolt)

There are 2 types; single Nylofor® swing gates (figure 1) and double Nylofor® swing gates (figure 2). Nylofor® swing gates are CE labelled, in accordance with EN 13241-1.

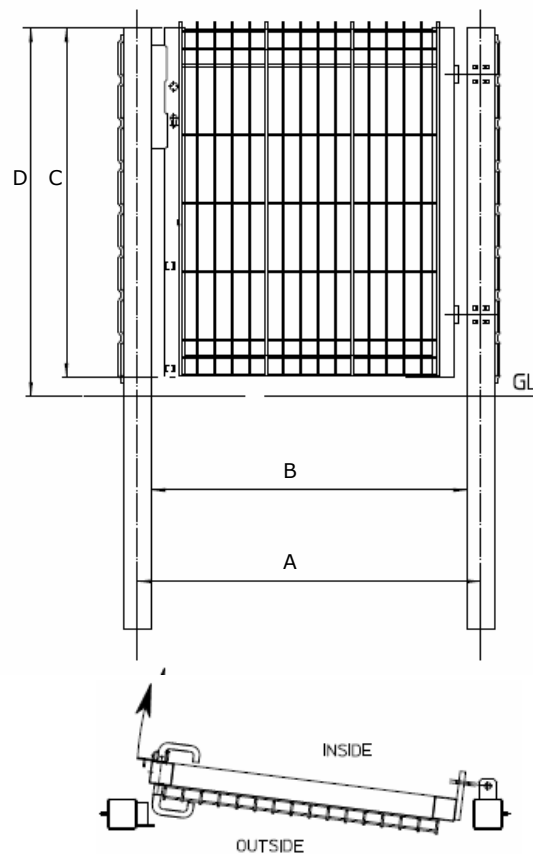


Figure 1: Single Nylofor® Swing Gate

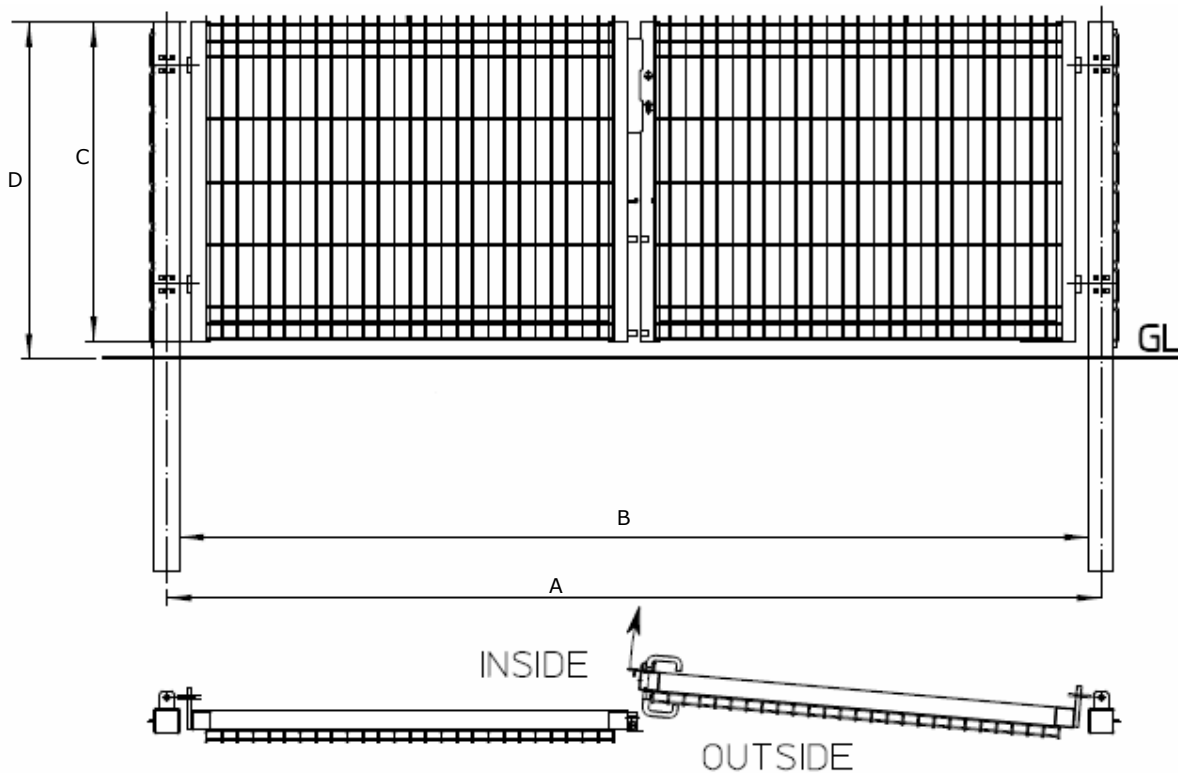
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Figure 2: Double Robusta® Swing Gate

1.1 Normative References

- EN 10027-1: Designation system for steel - Part 1: Steelnames.
- EN 10088-1: Stainless steels: Part1: List of stainless steels
- EN 13241-1: Industrial, commercial and garage doors and gates - Product standard - Part 1: Products without fire resistance or smoke control characteristics
- EN 13438: Powder organic coatings for galvanized steel products for construction purposes
- ISO 1461: Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods
- ISO 9227: Corrosion tests in artificial atmospheres; salt spray tests.

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2 Raw materials

2.1 Steel

A regular construction steel is used. Yield strength: minimum 235 N/mm².

2.2 Polyester

Free from Lead and Cadmium. The colour of the polyester is green Ral 6005. Other colours on request.

3 Properties

3.1 Standard Types

See tables below.

SINGLE SWING GATES			
Dimensions of the gates in mm	Drawing N°	Dimensions of pallets in cm	Weight/ piece (kg)
1000 x 1030	IPC 4031	185 x 100 x 35	75,1
1000 x 1230	IPC 4032	203 x 100 x 35	81,3
1000 x 1530	IPC 4033	235 x 100 x 35	90,4
1000 x 1730	IPC 4034	250 x 100 x 35	96,6
1000 x 2030	IPC 4035	280 x 100 x 35	104,7
1000 x 2430	IPC 4036	325 x 100 x 35	113,4
1500 x 1530	IPC 4039	235 x 150 x 35	103,3
1500 x 1730	IPC 4040	250 x 150 x 35	110,4
1500 x 2030	IPC 4041	280 x 150 x 35	119,7
2000 x 1530	IPC 4045	235 x 200 x 35	118,1
2000 x 2030	IPC 4047	280 x 200 x 35	136,8
3000 x 2030	IPC 4059	280 x 300 x 35	178,8

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DOUBLE SWING GATES									
Dimensions of the gates in mm		Drawing N°	Dimensions of pallets in cm				Weight/ piece (kg)		
3000	x	1030	IPC 4097	185	x	105	x	40	108,8
3000	x	1230	IPC 4098		x		x		118,3
3000	x	1530	IPC 4099	200	x	144	x	40	131,8
3000	x	1730	IPC 4100	250	x	150	x	40	140,8
3000	x	2030	IPC 4101	275	x	160	x	40	153,7
3000	x	2430	IPC 4102		x		x		167,1
4000	x	1030	IPC 4103		x		x		128,3
4000	x	1230	IPC 4104		x		x		139,5
4000	x	1530	IPC 4105	230	x	163	x	40	155,3
4000	x	1730	IPC 4106		x		x		165,8
4000	x	2030	IPC 4107	280	x	210	x	40	181,0
4000	x	2430	IPC 4108		x		x		196,7
5000	x	1030	IPC 4109		x		x		140,9
5000	x	1230	IPC 4110		x		x		152,9
5000	x	1530	IPC 4111	250	x	160	x	40	170,0
5000	x	1730	IPC 4112		x		x		182,0
5000	x	2030	IPC 4113	280	x	210	x	40	197,9
5000	x	2430	IPC 4114		x		x		214,8
6000	x	1030	IPC 4115		x		x		160,6
6000	x	1230	IPC 4116		x		x		175,1
6000	x	1530	IPC 4117		x		x		195,7
6000	x	1730	IPC 4118		x		x		210,0
6000	x	2030	IPC 4119	300	x	210	x	40	229,3
6000	x	2430	IPC 4120		x		x		250,0
8000	x	1530	IPC 4123		x		x		246,6
8000	x	1730	IPC 4124		x		x		266,1
8000	x	2030	IPC 4125		x		x		290,5
8000	x	2430	IPC 4126		x		x		316,8
10000	x	1530	IPC 4129		x		x		312,4
10000	x	1730	IPC 4130		x		x		337,1
10000	x	2030	IPC 4131		x		x		368,0
10000	x	2430	IPC 4132		x		x		401,4

All other dimensions are specified in the corresponding technical drawings, available on request.

A dental strip which is welded on the wing(s), is standard for all gates with height \geq 2000 mm.

Technical Data Sheet
TDS-07-31

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3.2 Coating

Posts and wing are coated with zinc and polyester, resulting in an excellent corrosion resistance.

3.2.1 Metallic coating

Wing and posts are hot dip galvanized in accordance with ISO 1461.

3.2.2 Organic coating

Posts and wings are coated with a Polyester coating system. The layer-thickness is minimum 60 µm. Standard colour Green Ral 6005, other colours on request.

Adhesion: make two scratches by means of a hard metal pointed graving tool, penetrating through the metal and intersecting at an angle of $30^\circ \pm 5^\circ$. Lift a 30° peak with the point of a knife. The coating shall not be able to be lifted from the metal by more than 5 mm.

Resistance of the polyester to salt spray: make a rectangular diagonal cross by means of a hard metal pointed graving tool, penetrating through the metal. Test in accordance with ISO 9227 (neutral salt spray). After 1000 h there shall be no corrosion beneath the polyester or loss of adhesion in excess of 10 mm from the diagonals and no signs of blistering, cracking or crazing on any part of the specimen.

3.3 Accessories

- Hinges: are adjustable and are made out of hot dip galvanized steel to assure a good corrosion resistance.
- Ground bolt: made out of stainless steel. The analysis is in accordance with AISI 302/304 and the quality X5CrNi18-10 as specified in the European Standard EN 10088-1.
- Lock System: all metal parts of the lock system are made out of stainless steel or coated steel to assure good corrosion resistance.

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