



▲ GATE

General quality specifications:

Welding:

- Threat the material with care, scratches or indentations will remain visible for the client.
- Use a flat table to assure a flat surface of the gates.
- Use molds so distances are exact. All measures should have a tolerance of less then 2 mm. For the lock drillings and the hinges, tolerance is 1 mm.
- Clean and equal resemblance
- After welding : improve surface by grinding wheel, make welding spots smooth, so they become as invisible as possible after galvanization

Hot dip galvanization:

- According to EN ISO 1461 , everything should be galvanized from the outside and inside.
- It is necessary to drill holes in the frame so the galvanization can reach all parts from the inside. (Specified in drawings).
- Cleaning after galvanization : Must become flat surface so result after painting will be optimal.

Painting:

- According to NEN 5254



- RAL color , to be specified according to model
- Minimum 80 micrometer
- Must attain smooth surface
- Must have a good cohesion
- There may be no visible irregularities within 4 meters distance of the object in daylight

Locks:

- Locks must be for outdoor use (stainless steel) .

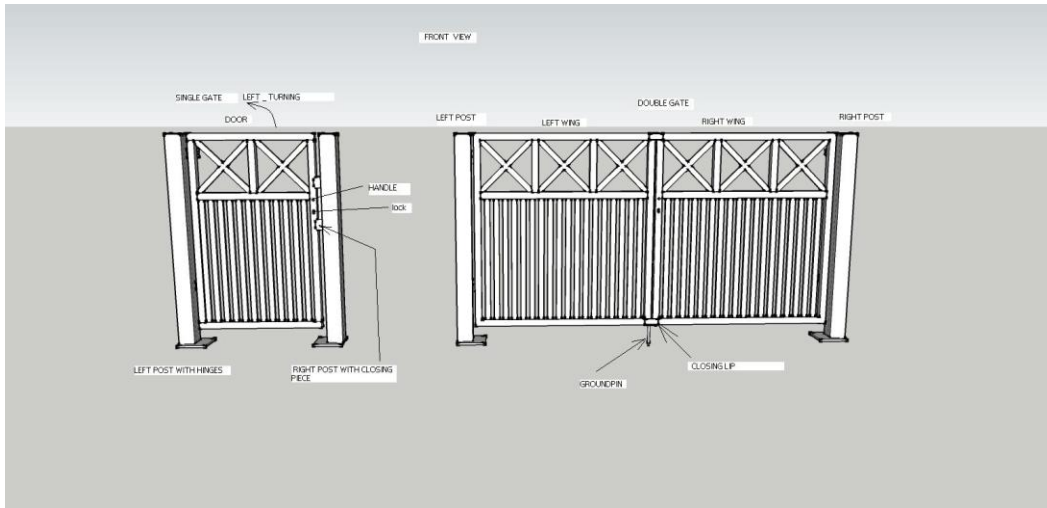
Packing:

- Every gate wing , post and other object should be packed so no scratches will occur on the paint during transport due to movements and trembling of the container.
- All parts must be packed on boxes so they can be loaden/unloaden by forklift. Every part in itself should be packed separately on the pallet with foam packing and plastic and wood so they can be transported without damage.

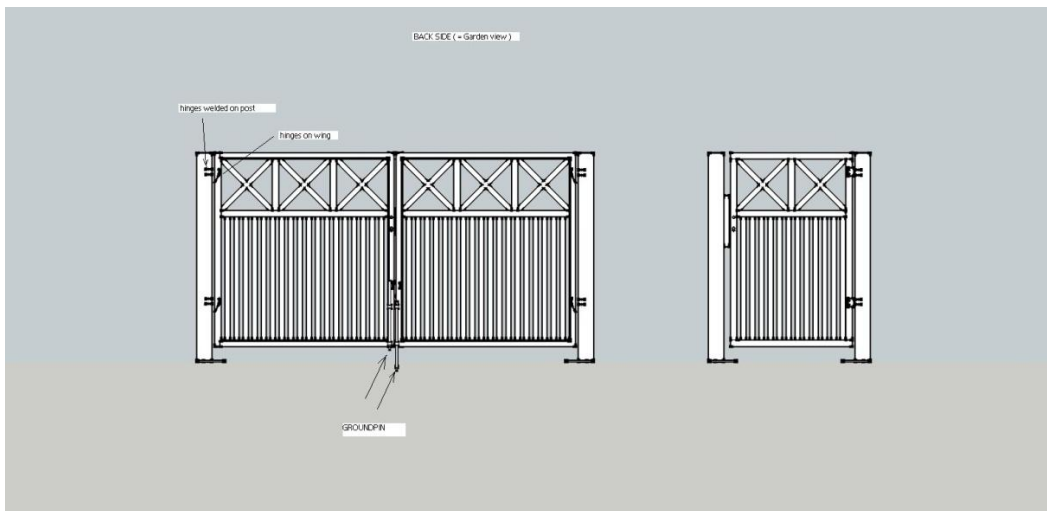


General specifications:

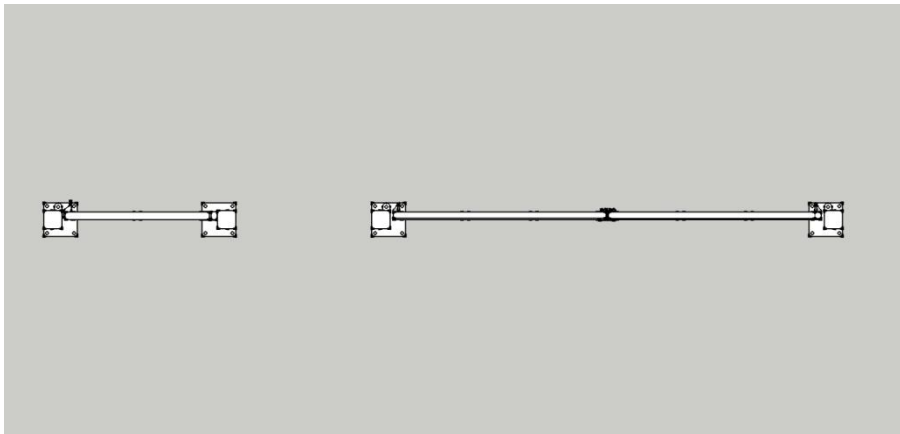
FRONT VIEW (view when standing on the street) - pict1



BACK VIEW (view when standing in the garden) - pict 2



TOP VIEW - pict 3



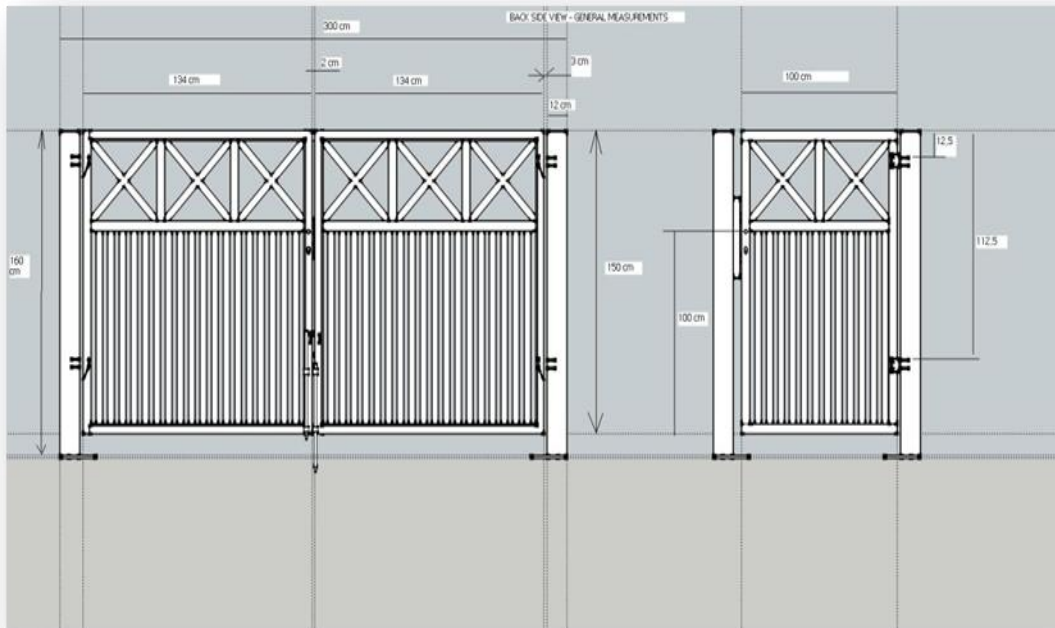
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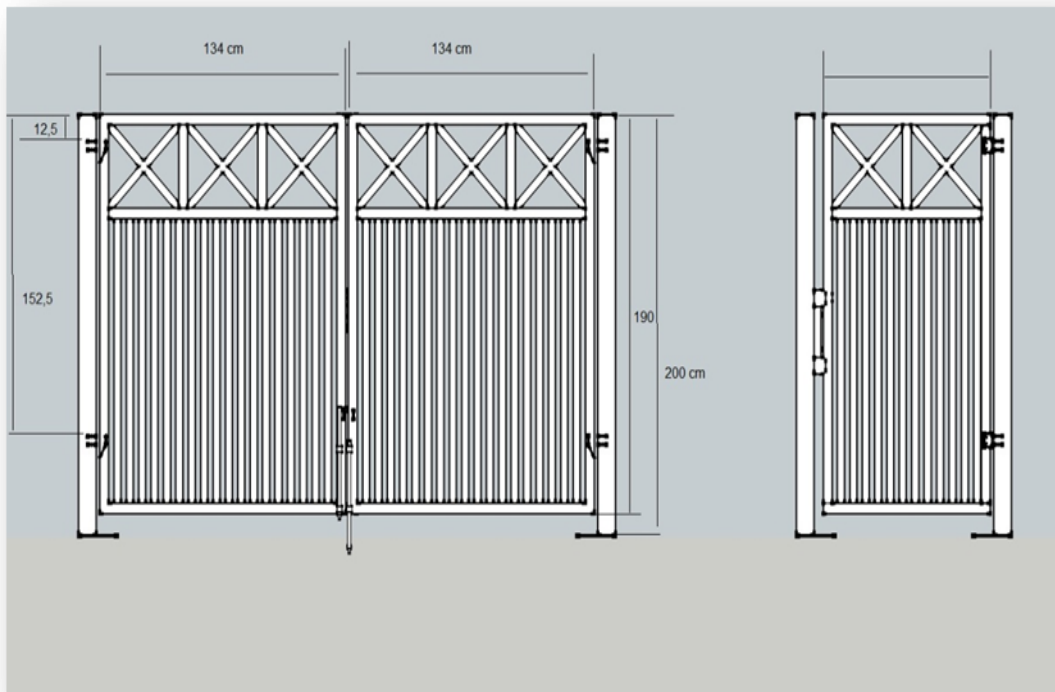


Measures of the objects that stay the same for all gates:

For gates of height 150 cm - pict 4



For gates of height 190 cm - pict 5



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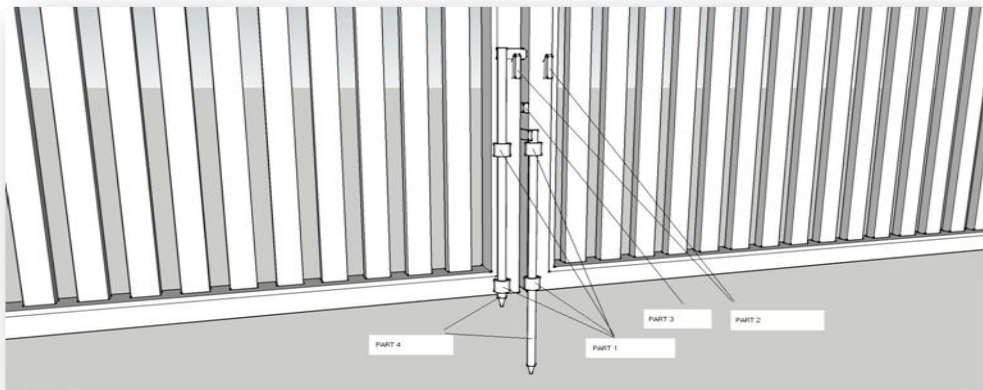


For all gates:

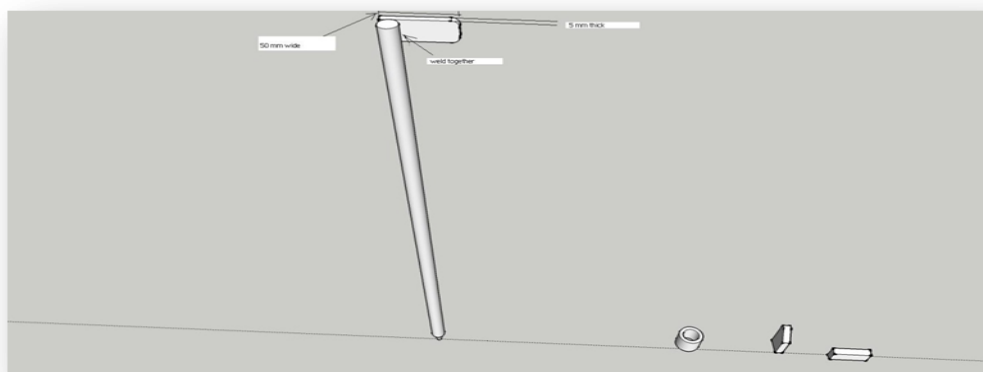
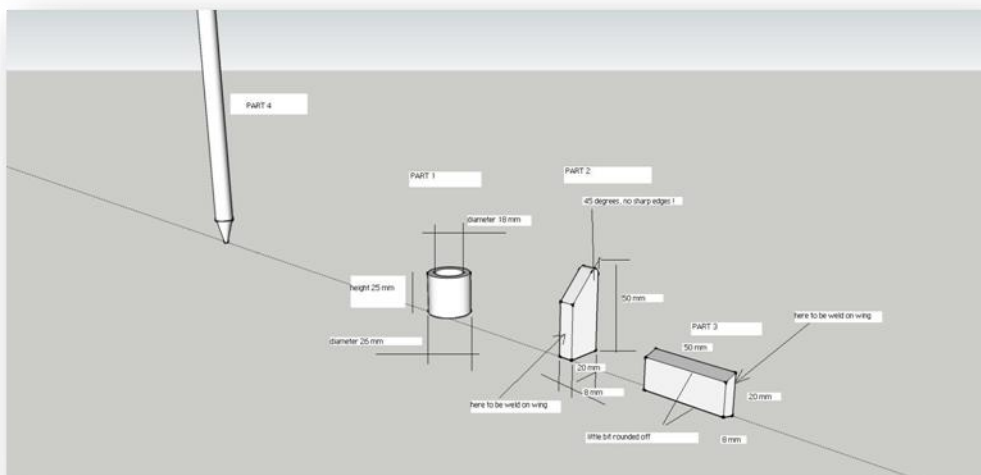
Door handle at 100 cm above bottom of the wing

Groundpin :

1) naming - pict 6



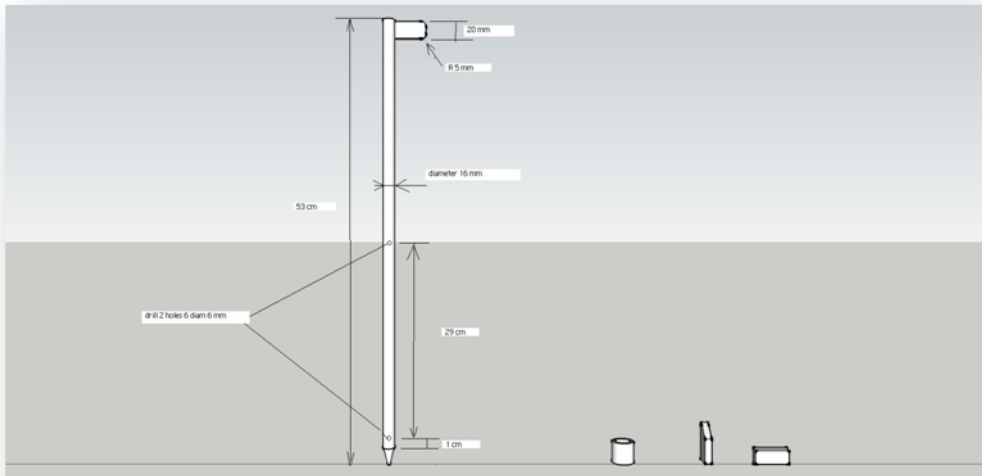
2) measures - pict 7



Pict 8

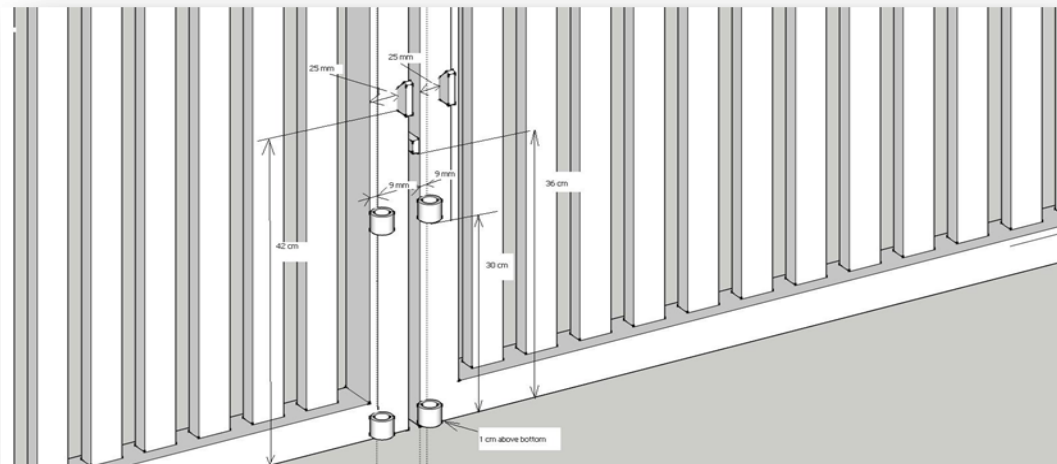
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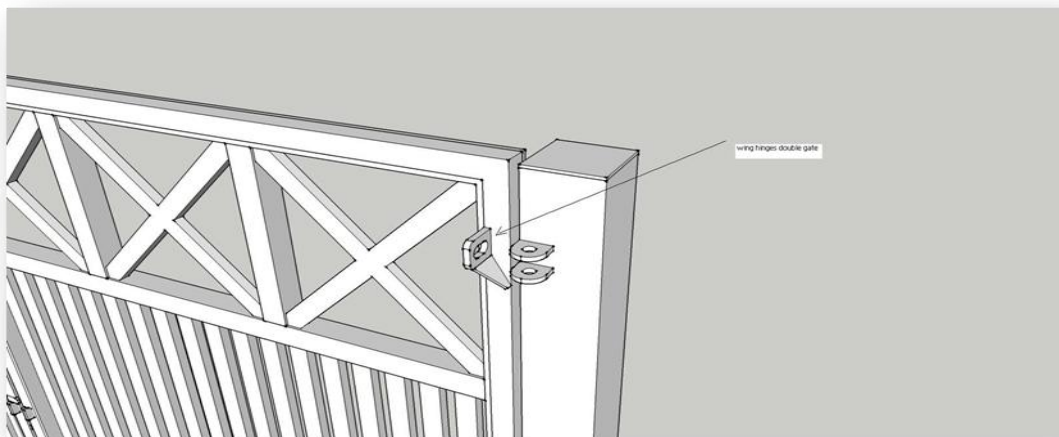
Pict 9

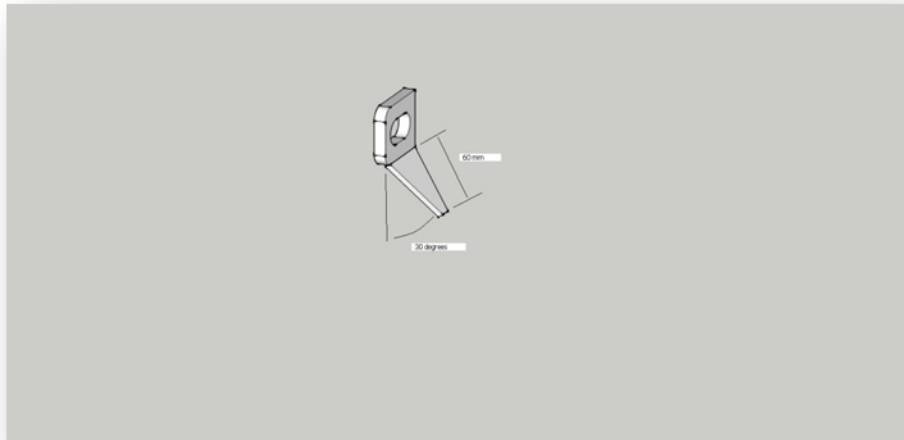
3) positioning – pict 10



For all Double gates :

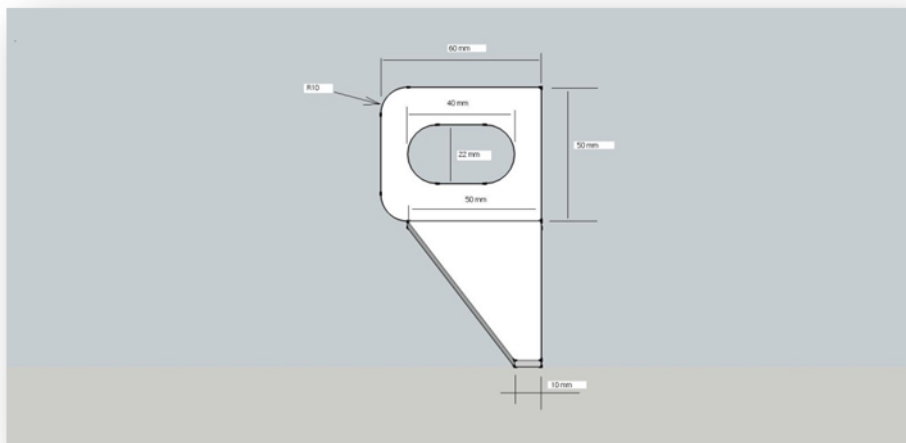
- Hinges – pict 11



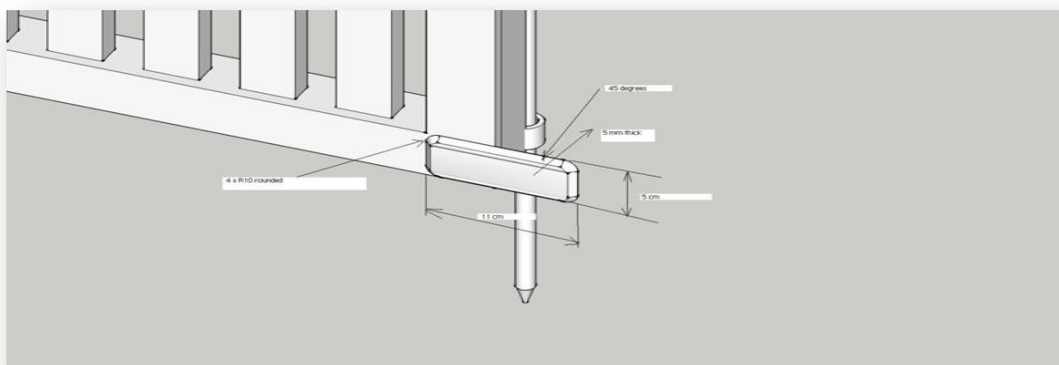


Measures: pict12

Pict 13



Closing lip : (2 times, on top and on bottom of the LEFT wing)



-pict14

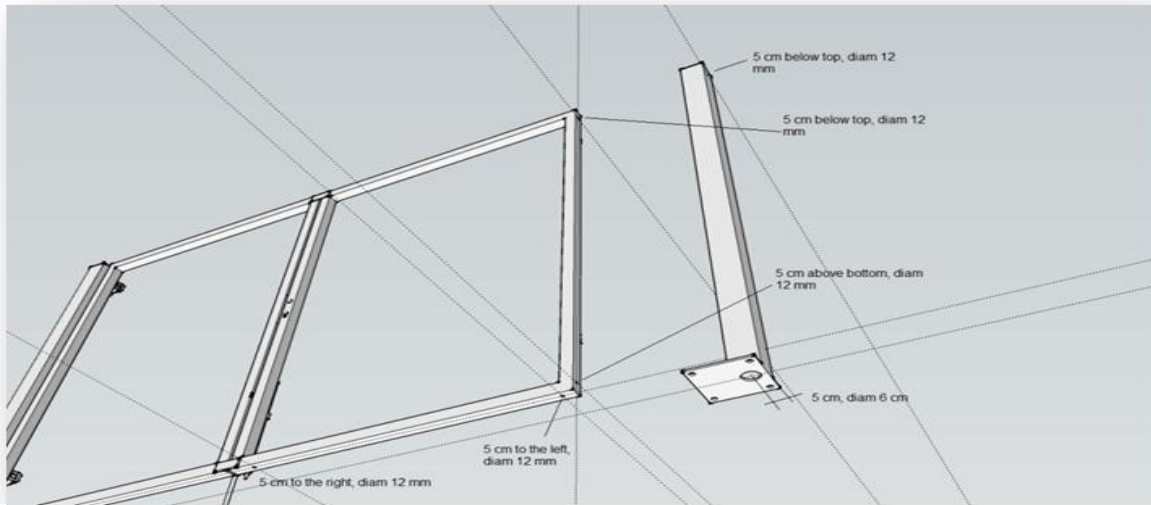
Minimum galvanisation holes for all gates:

- 4 holes in the wing diam 12 mm, 2 on the side , 2 on the bottom

- 2 holes in all poles, 1 on the extreme side diam 12mm ,5 cm below top and 1 in base plate diam 6 cm

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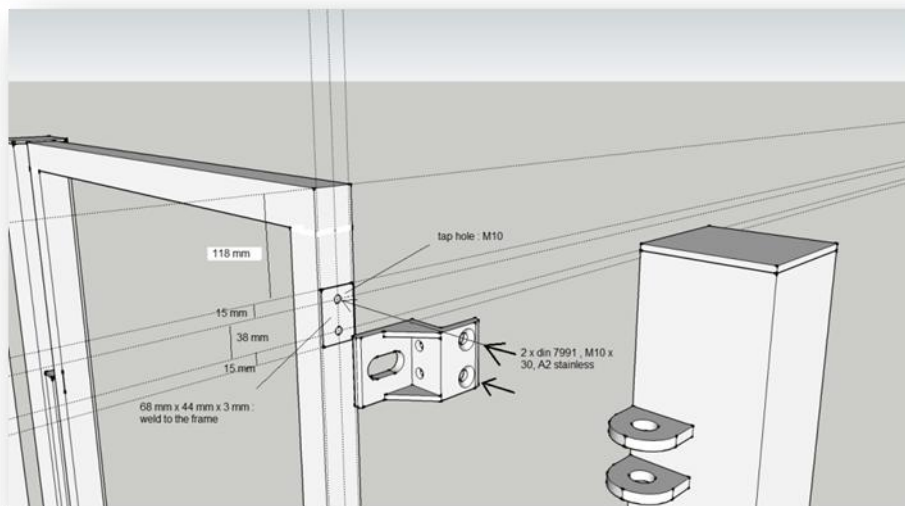


For all Single gates :

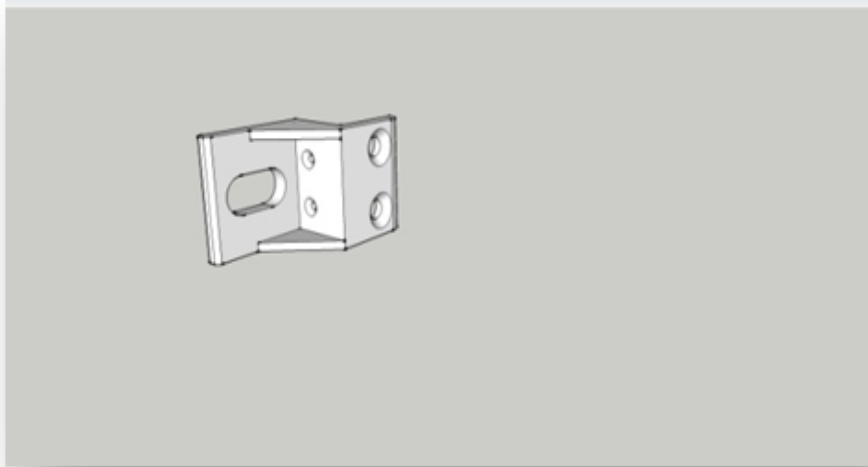
2 plates 68 x 44 x 8 mm will be welded on the frame of the single gate . This is to strengthen the profile when we draw screw wire in the frame for attaching the hinges.

Attention

According to picture 17 : 2 holes must be drilled through the 50x50x2mm profile to attach the single gate hinges. The hinges will be attached with 2 x M10 screw din 7991 . These measures must be very correct. If not the hinges will not work properly.

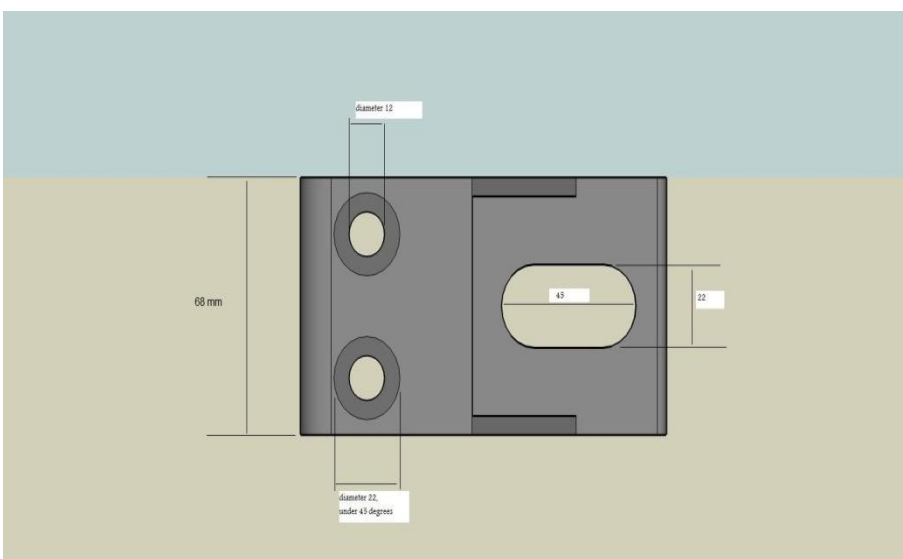
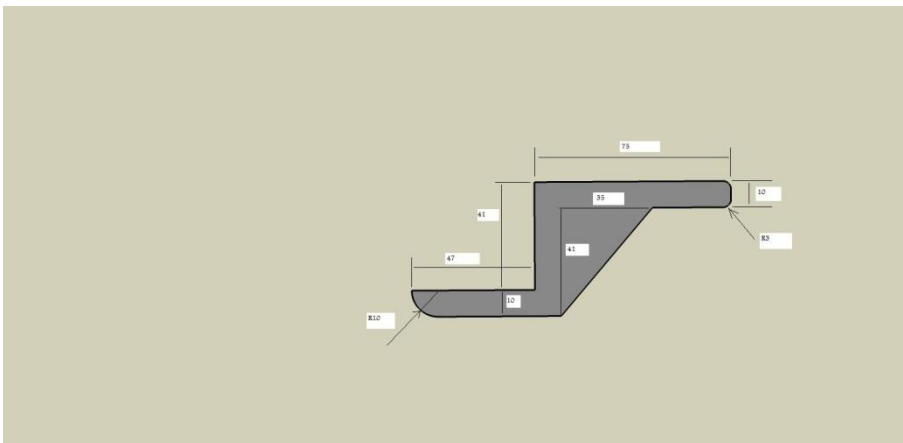


- Hinges with measures : pict 15



Pict 16

Pict 17

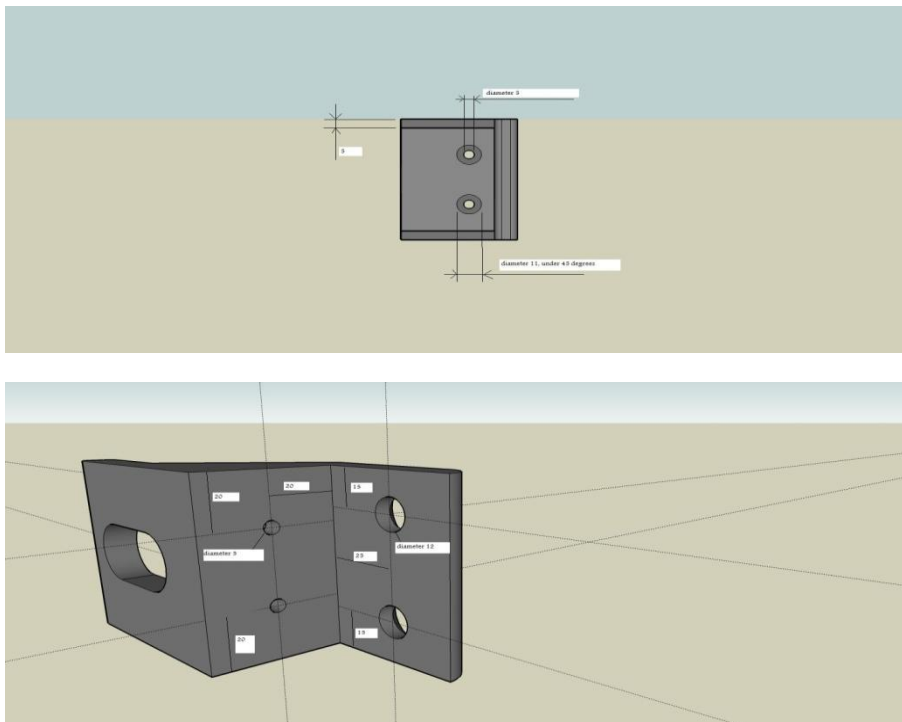


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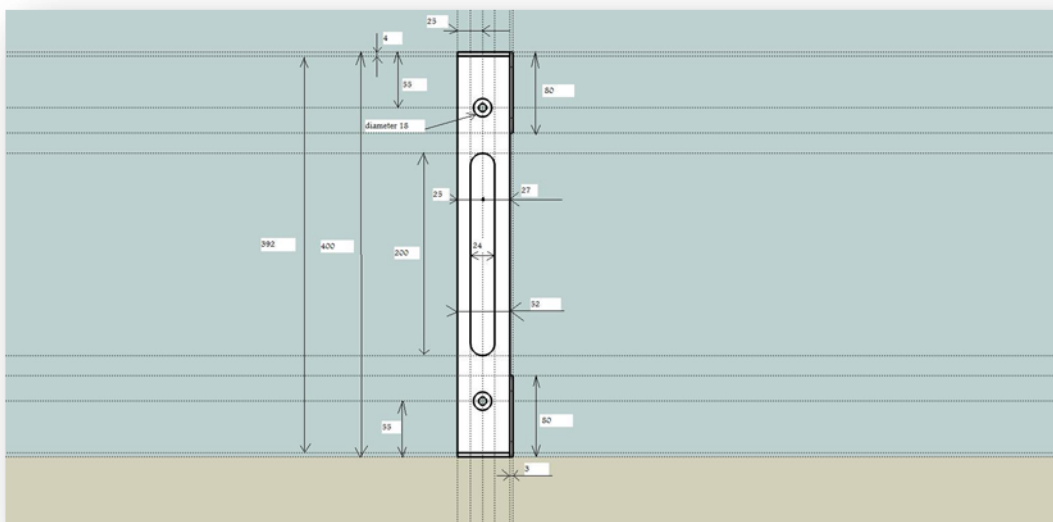


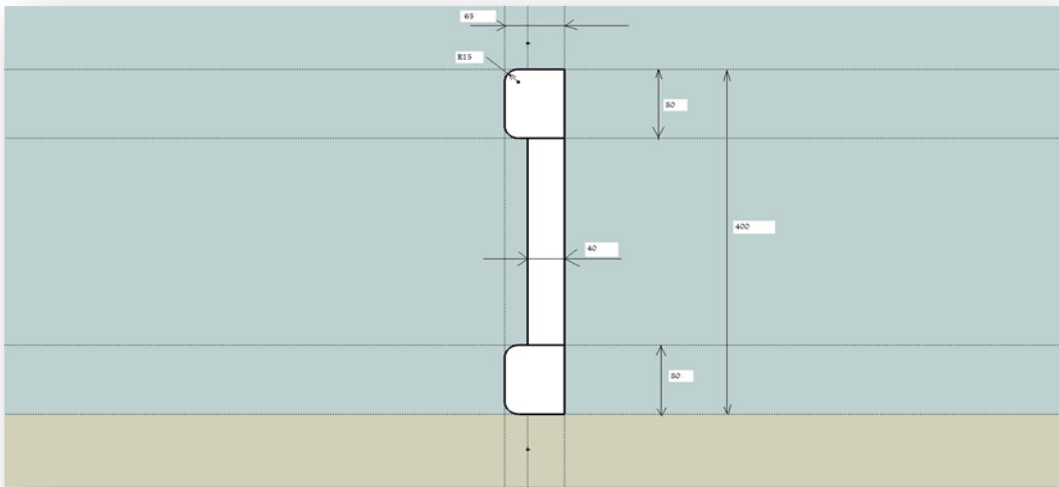
Pict 18



- Lock piece

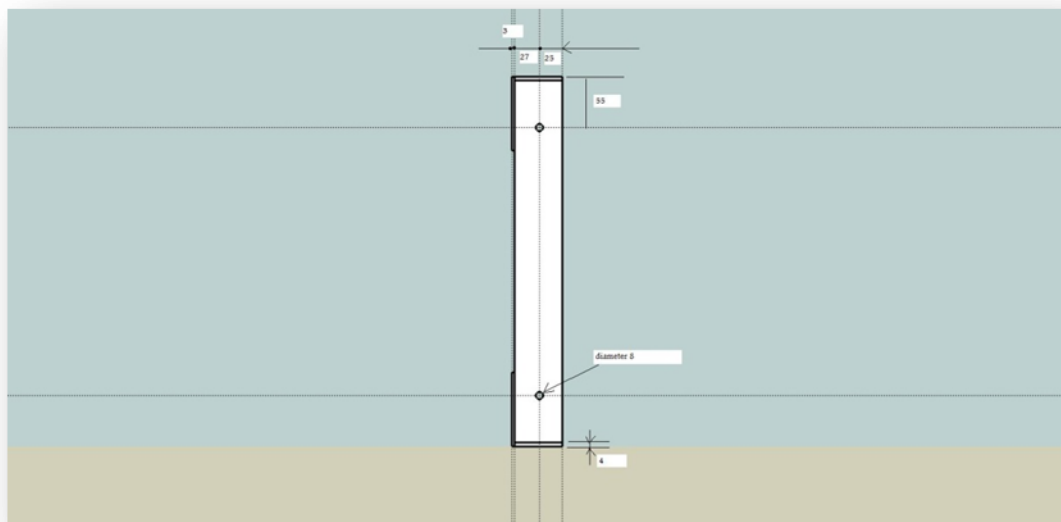
-pict19





Pict20

Pict 21

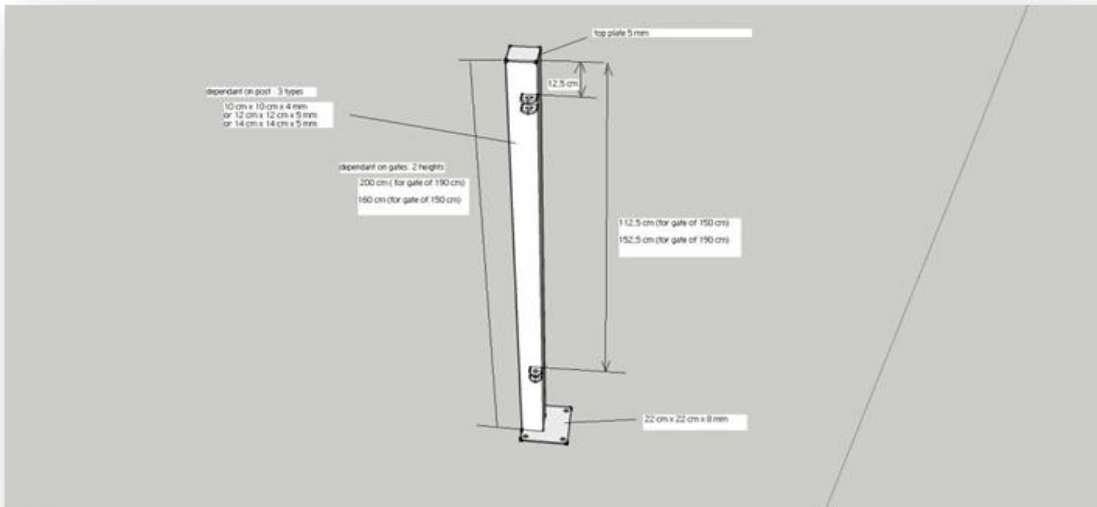


Posts :

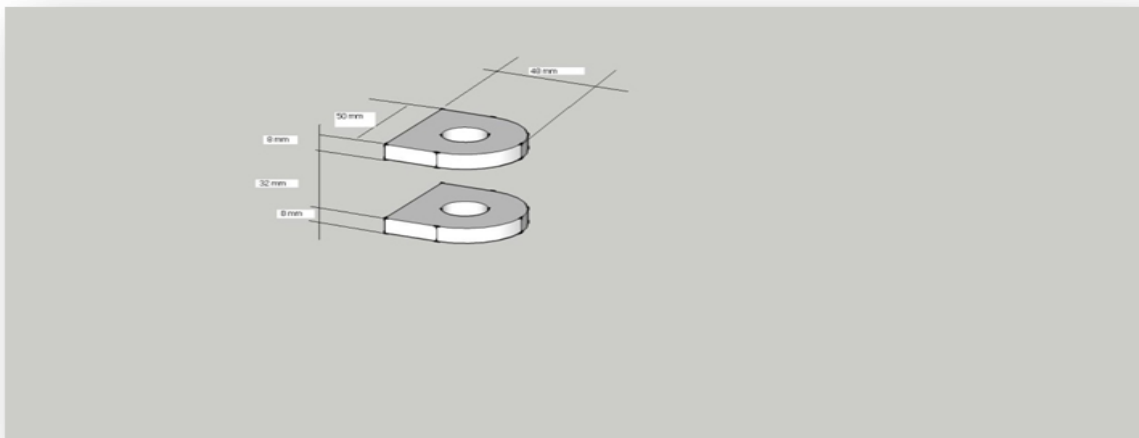
- possible profiles: 100x100x4 mm / 120x120x5mm / 140x140x5 mm depending on model.
- Possible height :160 cm above baseplate or 200 cm above baseplate depending on model.
- Baseplate : 220 x 220 x 10 mm , with 4 holes diam 20 mm , and 1 hole diam 60 mm for electric wiring and galvanization
- For double gates : 2 posts with hinges
- For single gates : 1 post with hinges (can be left or right) , 1 post without hinges
- 12,5 cm for the hinges is always measured from the top of the post , including the top plate
- pict 22

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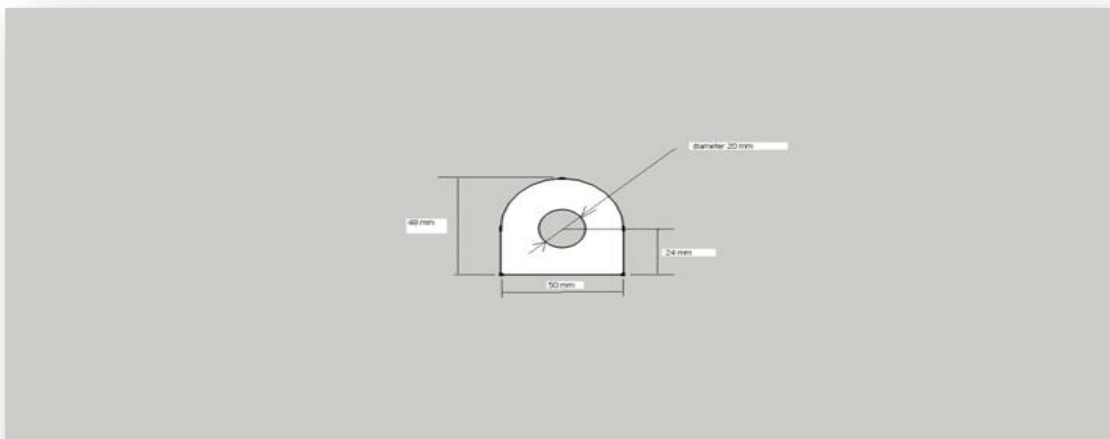
URL: <http://www.yexiangwiremesh.com>



Pict 23

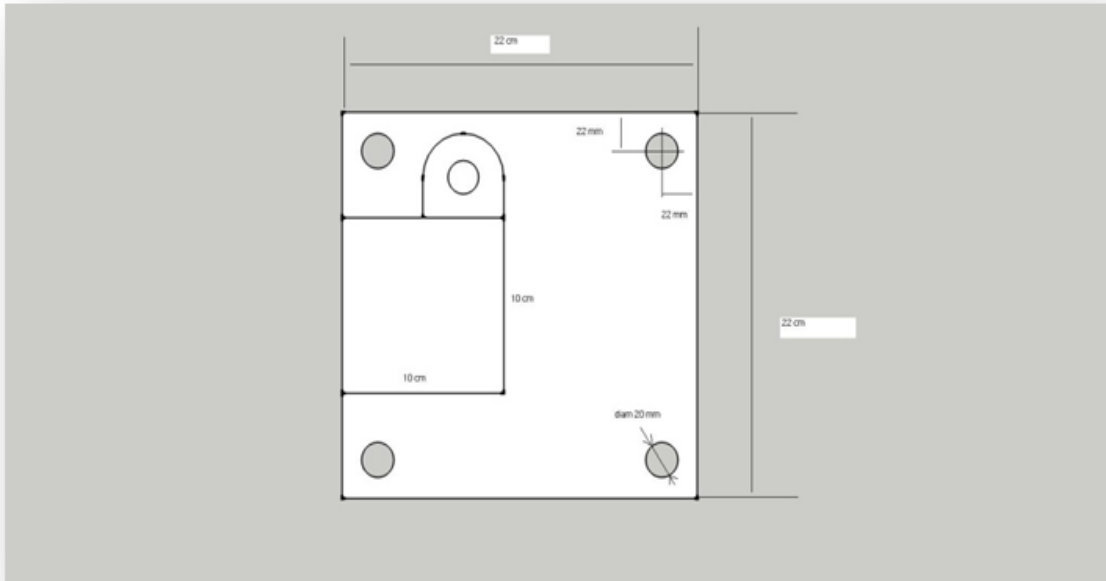


Pict 24





Pict 25

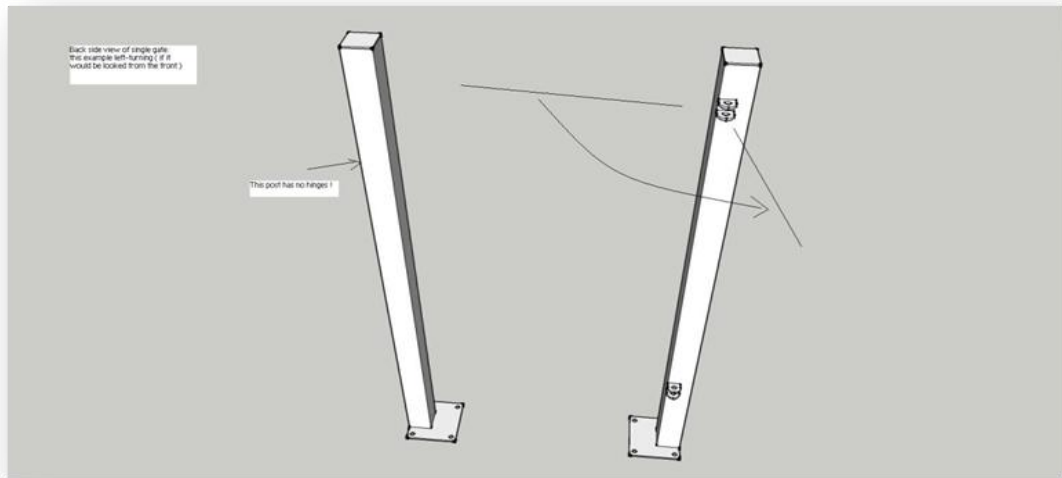


Pict 26



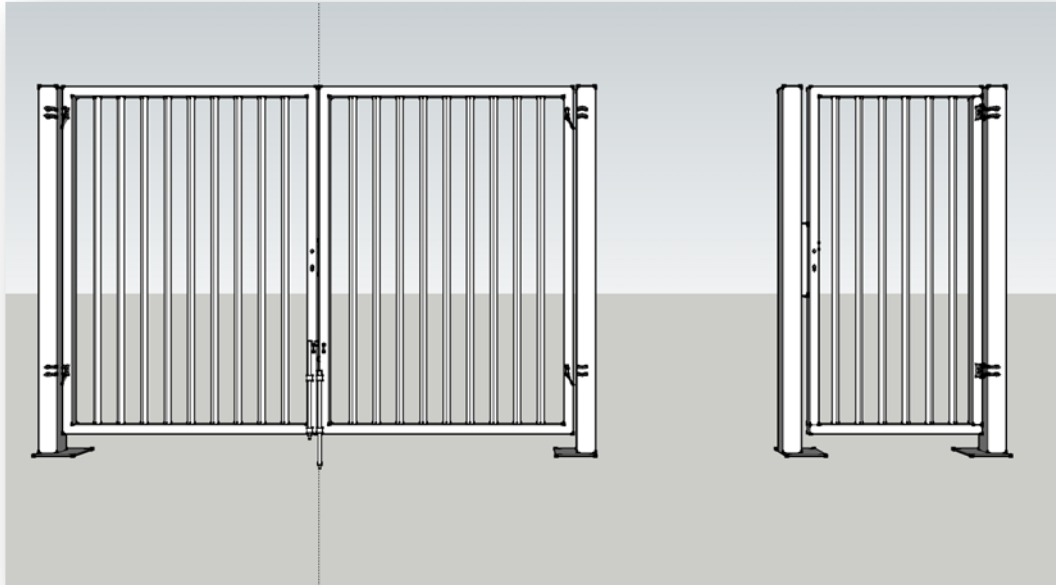


Posts for single gates – pict 27





Model 1: gate with vertical bars (square)

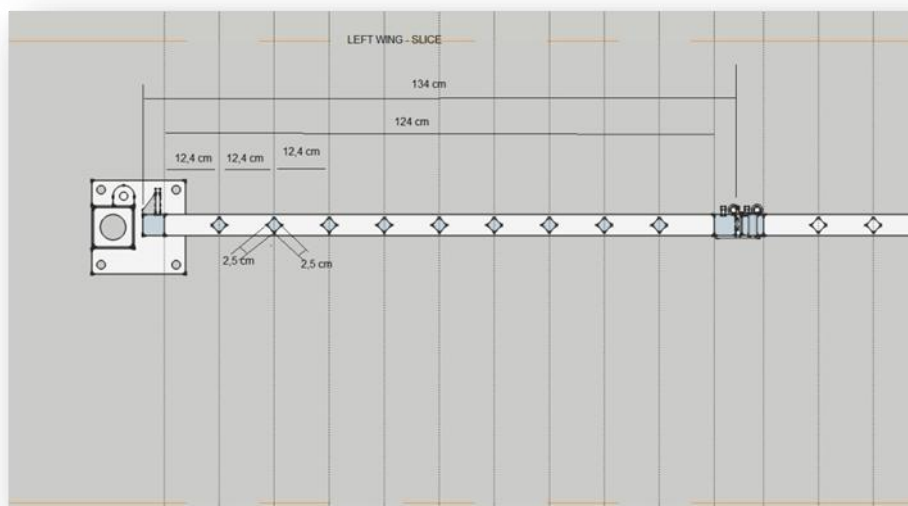


2 posts 100x100x4 mm with length 2000 mm with base plate (see pictures 22,23,24,25,26,27)

-Frame

Profiles: 50 mm x 50 mm x 2mm

Filling : square profiles 25 mm x 25 mm x 2 mm



Hot dip galvanized 100 micrometer and powder coated ral 6005 or 9005

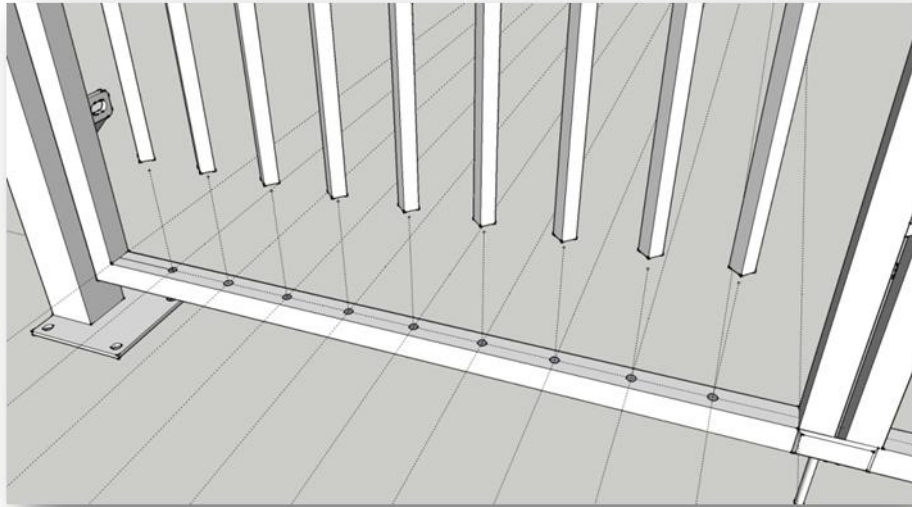
Including industrial hinges and lock

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Special attention for the galvanization – position of the holes for galvanization



As indicated in the picture: drill holes into the bottom and top frame of the 2 wings with diameter 1,6 cm and positioned at the centers where the square tubes will be welded. This to allow the flow of zinc inside the tubes during galvanization.

Dimensions of the gates -width of the wings

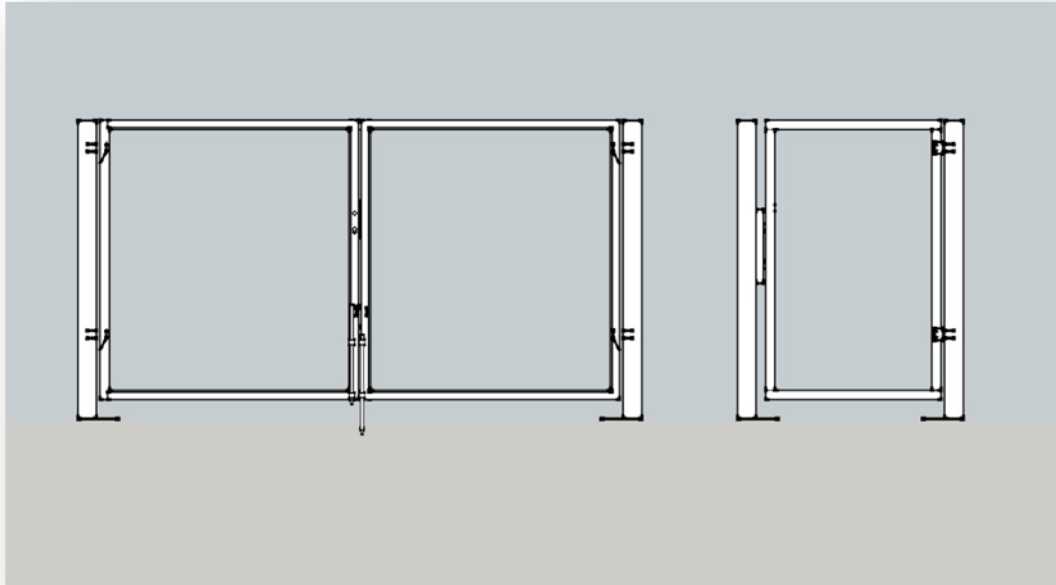
Single gate : height 190 cm , width 100 cm :
See pict 15,16,17,18,19,20,21,22,23,24,25,26

Double gate : height 190 cm, width 2 x 134 cm :
See pict 6,7,8,9,10,11,12,13,14,22,23,24,25,26,27



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Model 2: gate with double wired mesh panel – see pict 4 for frame measures (double wired mesh not drawn in picture. It must be placed symmetric in the frame. Same cut off distance on left and right and same distance on top and bottom). Take special care of the quality of the wired mesh panel. Only straight wires must be used (not the beginning or end of a roll). It must be well point welded and welding in the frame must be done precise and clean.



2 posts 100x100x4 mm with length 1600 mm with base plate (see pictures 22,23,24,25,26,27)

-Frame

Profiles: 50 mm x 50 mm x 2mm

Filling : double wired mesh 8-6-8 mm

Hot dip galvanized 100 micrometer and powder coated ral 6005 or 9005

Including hinges and lock

Dimensions of the gates -width of the wings

Single gate : height 150 cm , width 100 cm :

See pict 15,16,17,18,19,20,21,22,23,24,25,26

Double gate : height 150 cm, width 2 x 134 cm :

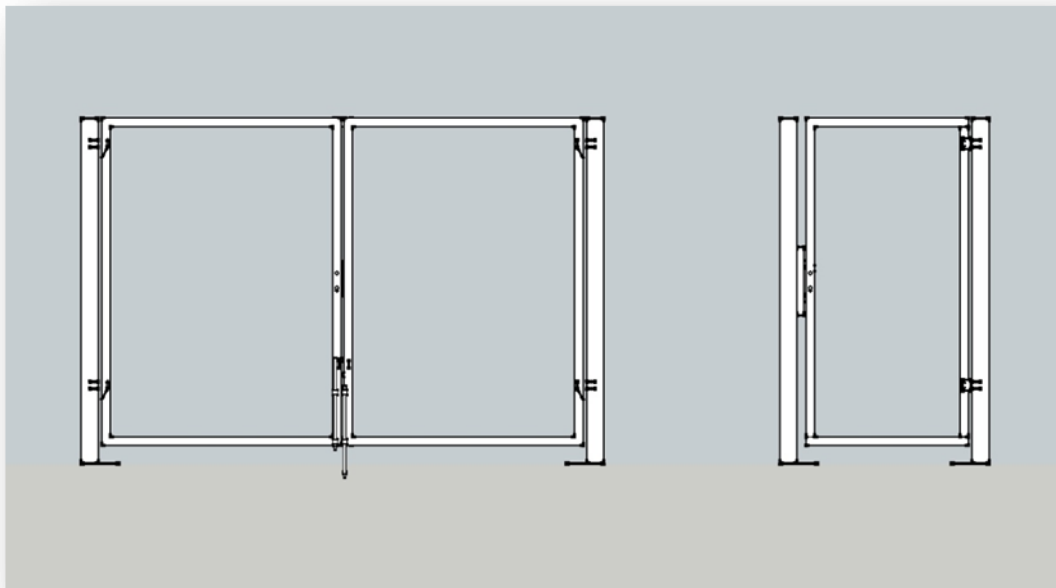
See pict 6,7,8,9,10,11,12,13,14,22,23,24,25,26,27

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Model 3: gate with double wired mesh panel - see pict 5 for frame measures (double wired mesh not drawn in picture. It must be placed symmetric in the frame. Same cut off distance on left and right and same distance on top and bottom) .Take special care of the quality of the wired mesh panel. Only straight wires must be used (not the beginning or end of a roll). It must be well point welded and welding in the frame must be done precise and clean.



2 posts 100x100x4 mm with length 2000 mm with base plate: (see pictures 22,23,24,25,26,27)

-Frame

Profiles: 50 mm x 50 mm x 2mm

Filling : double wired mesh 8-6-8 mm

Hot dip galvanized 100 micrometer and powder coated ral 6005 or 9005

Including hinges and lock

Dimensions of the gates -width of the wings

Single gate : height 190 cm , width 100 cm :

See pict 15,16,17,18,19,20,21,22,23,24,25,26

Double gate : height 190 cm, width 2 x 134 cm :

See pict 6,7,8,9,10,11,12,13,14,22,23,24,25,26,27

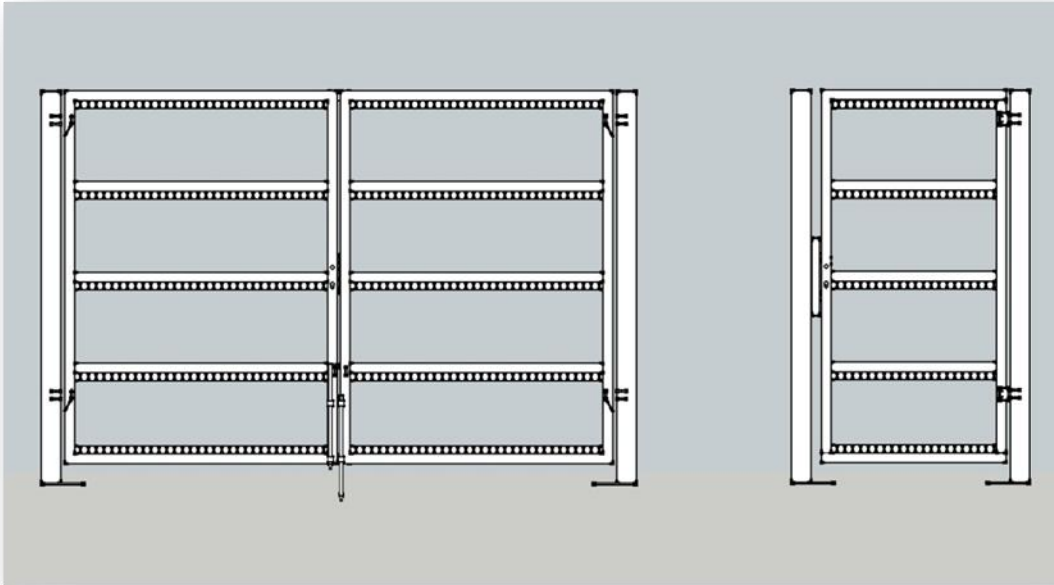
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Model 4: gate for wooden planks – see pict 5 for frame measures

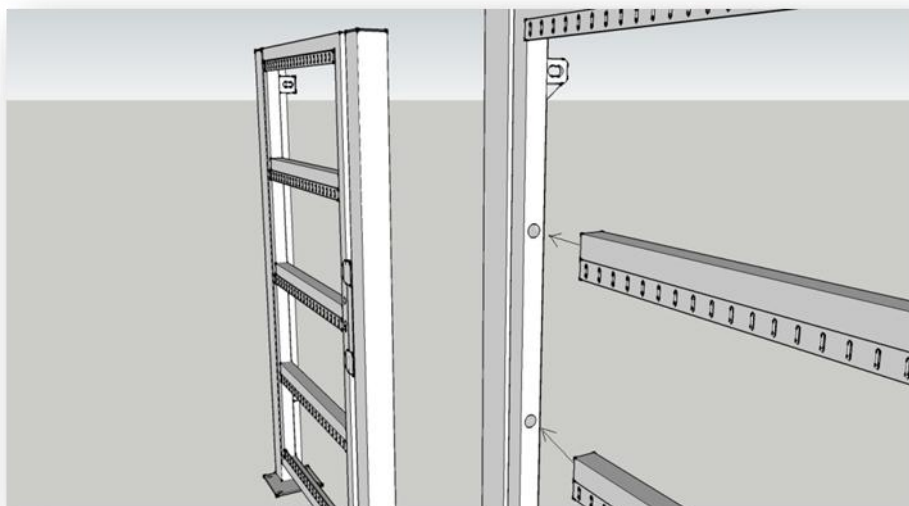


posts 100x100x4 mm with length 2000 mm with base plate: (see pictures 22,23,24,25,26,27)

-Frame

Profiles: 50 mm x 50 mm x 2mm

Filling : no filling, will be done manually by costumer Hot dip galvanized100micrometer



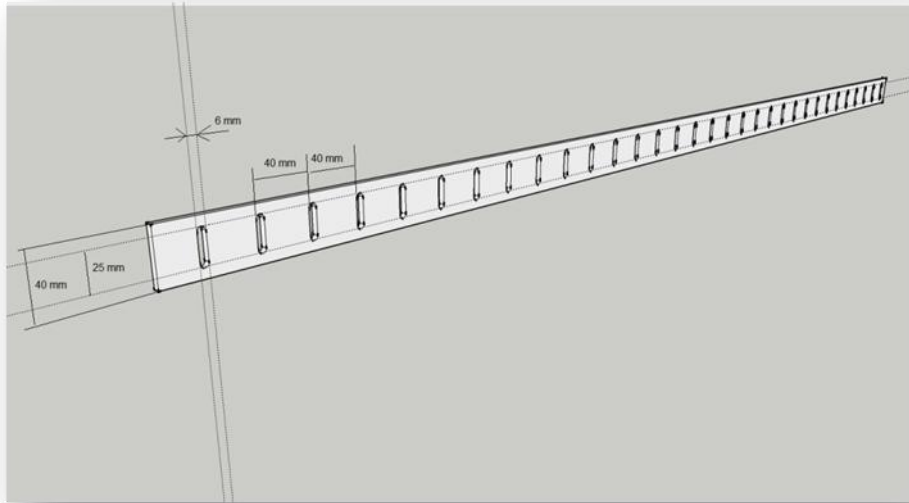
As indicated in the picture , on the place where the horizontal profiles

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will be welded, first there must be drilled holes diameter 30 mm , for a flow of zinc inside the frame profiles during galvanization



To the frame is welded iron profile 40 mm x 5 mm, and in this profile are cut vertical holes (diam 6 mm and height 25 mm). These are dilatation holes (for the wood to contract/extract in changing weather conditions)

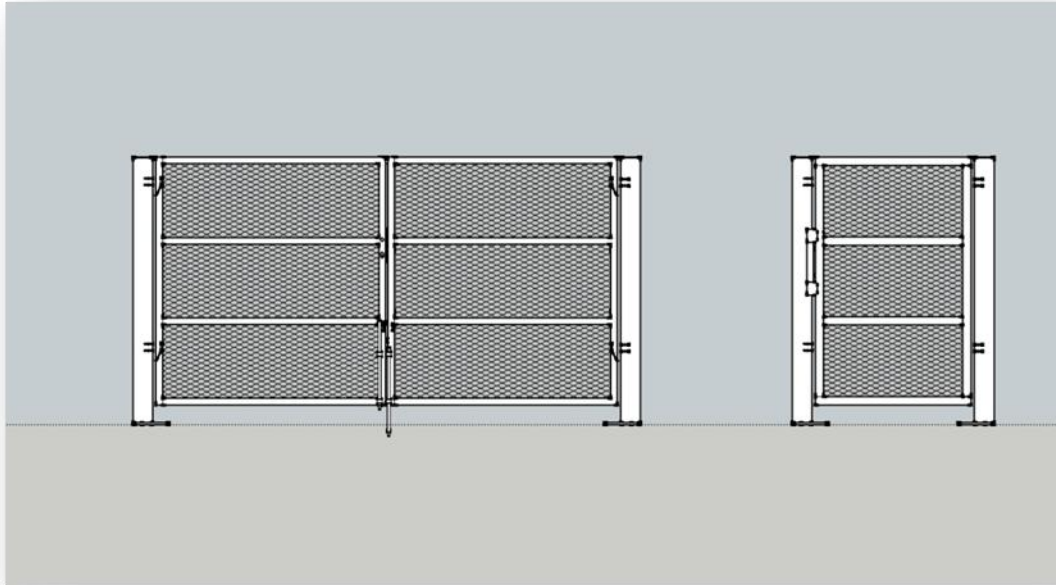
Dimensions of the gates -width of the wings

Single gate : height 190 cm , width 100 cm :
See pict 15,16,17,18,19,20,21,22,23,24,25,26

Double gate : height 190 cm, width 2 x 134 cm :
See pict 6,7,8,9,10,11,12,13,14,22,23,24,25,26,27



Model 5: "Kwai" : - see pict 4 for frame measures



2 posts 120x120x4 mm with length 1600 mm with base plate (see pictures 22,23,24,25,26,27)

-Frame

Profiles: 50 mm x 50 mm x 2mm

Filling : perforated plate : diameter of the holes 6 mm, distance between holes 9 mm.

Electrolytic galvanized and powder coated ral ... Including hinges and lock : !!! attention: the perforated plate can not be galvanized hot dip. This will fill the holes and destroy the result.

! Special attention for the galvanization - position of the holes for galvanization :

Similar as to model 4, on the place where the horizontal profiles will be welded, first there must be drilled holes diameter 30 mm , for a flow of zinc inside the frame profiles during galvanization

! Order of galvanization: Make frame with profiles and hinges and ground bars and lock preparations (without perforated plate)-> hot dip galvanization -> perforated plate electrical galvanized place perforated plate in the frame with blind rivets

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Dimensions of the gates -width of the wings

Single gate : height 150 cm , width 100 cm :

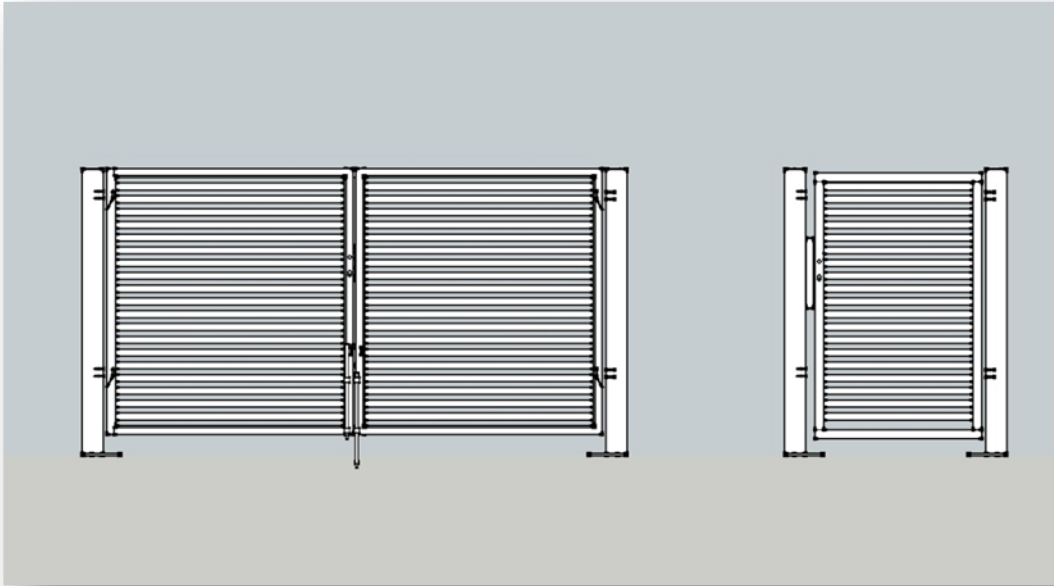
See pict 15,16,17,18,19,20,21,22,23,24,25,26

Double gate : height 150 cm, width 2 x 134 cm :

See pict 6,7,8,9,10,11,12,13,14,22,23,24,25,26,27



Model 6: "Nova Scotia" : - see pict 5 for frame measures



2 posts 120x120x4 mm with length 1600 mm with base plate (see pictures 22,23,24,25,26,27)

-Frame

Profiles: 50 mm x 50 mm x 2mm

Filling : 17 rectangular profiles 60 x 20 x1,5 mm

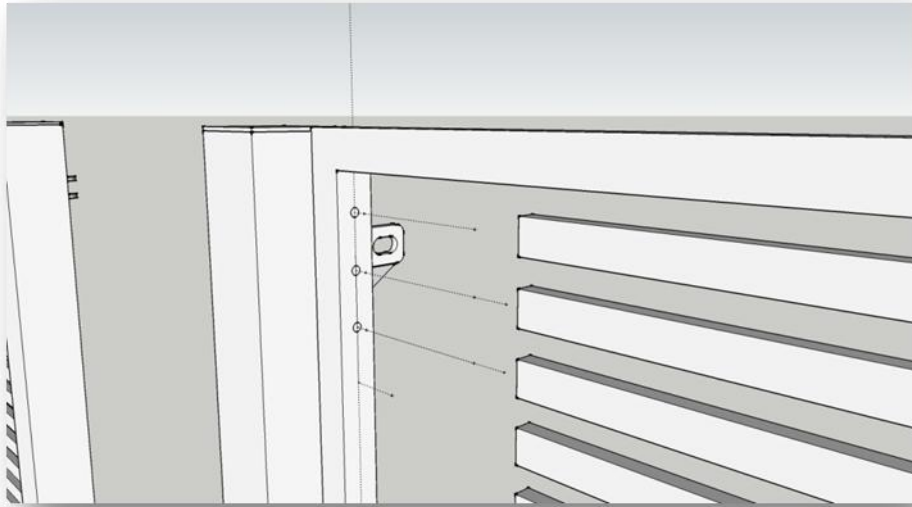
Hot dip galvanized 100 micrometer

Including hinges and lock

! Special attention for the galvanization - position of the holes for galvanization

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Similar as to model 4, on the place where the horizontal profiles will be welded, first there must be drilled holes diameter 12 mm , for a flow of zinc inside the profiles during galvanization

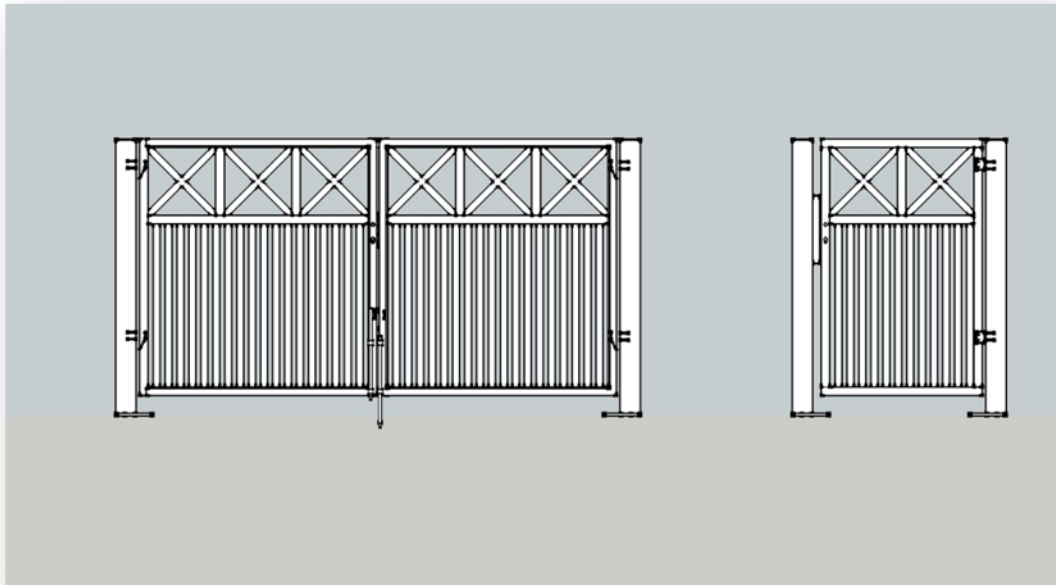
Dimensions of the gates -width of the wings

Single gate : height 150 cm , width 100 cm :
See pict 15,16,17,18,19,20,21,22,23,24,25,26

Double gate : height 150 cm, width 2 x 134 cm :
See pict 6,7,8,9,10,11,12,13,14,22,23,24,25,26,27



Model 7: "Cottage" : - see pict 4 for frame measures



2 posts 120x120x4 mm with length 1600 mm with base plate (see pictures 22,23,24,25,26,27)

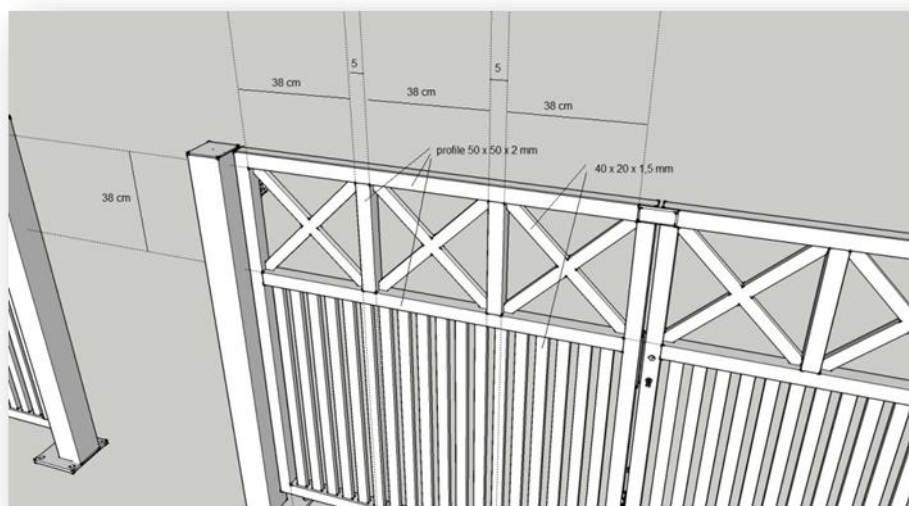
-Frame

Profiles: 50 mm x 50 mm x 2mm

Filling : rectangular profiles 60 x 20 x 1,5 mm

Hot dip galvanized 100 micrometer

Including hinges and



Dimensions of the cross :

For double gate : 134 cm - 4x5cm = 114 cm -> 114 / 3 = 38 cm

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choose also height = 38 cm

For single gate : $2 \times 38 \text{ cm} + 3 \times 5 = 91 \text{ cm}$ (1), choose height 38 cm.

Similar as to model 4 and model 6, on the place where the horizontal/vertical and cross profiles will be welded, first there must be drilled holes diameter 30 mm for the profiles 50x50x2 and there must be drilled holes diameter 12 mm for the profiles 60 x 20 x 1,5 mm, for a flow of zinc inside the profiles during galvanization

Dimensions of the gates -width of the wings

Single gate : height 150 cm , width 91 cm : Attention : the width of the gate is smaller to make exact the same cross as in double gate. See above (1)

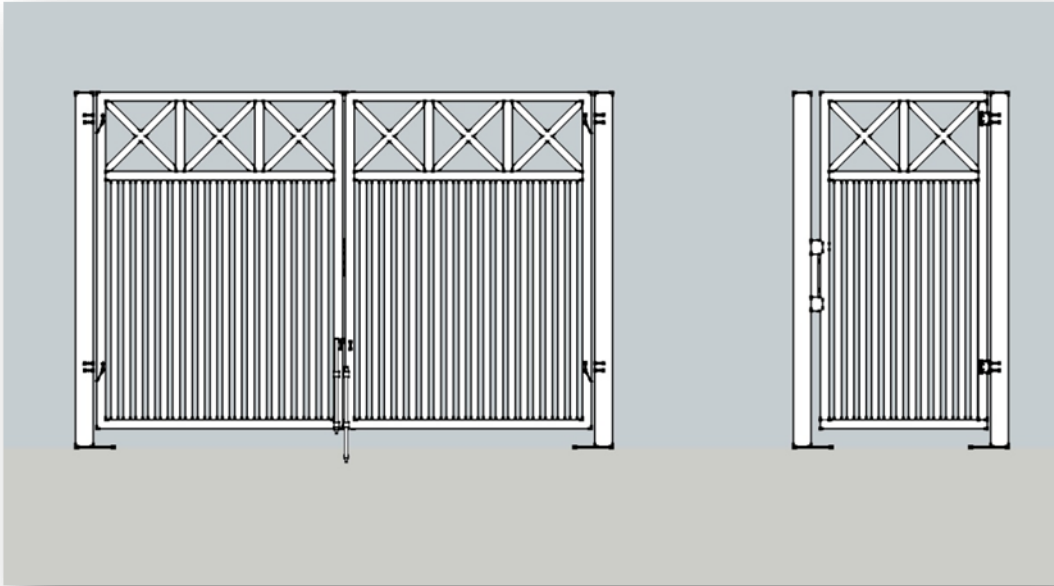
See pict 15,16,17,18,19,20,21,22,23,24,25,26

Double gate : height 150 cm, width $2 \times 134 \text{ cm}$:

See pict 6,7,8,9,10,11,12,13,14,22,23,24,25,26,27



Model 8: "Cottage" : - see pict 5 for frame measures



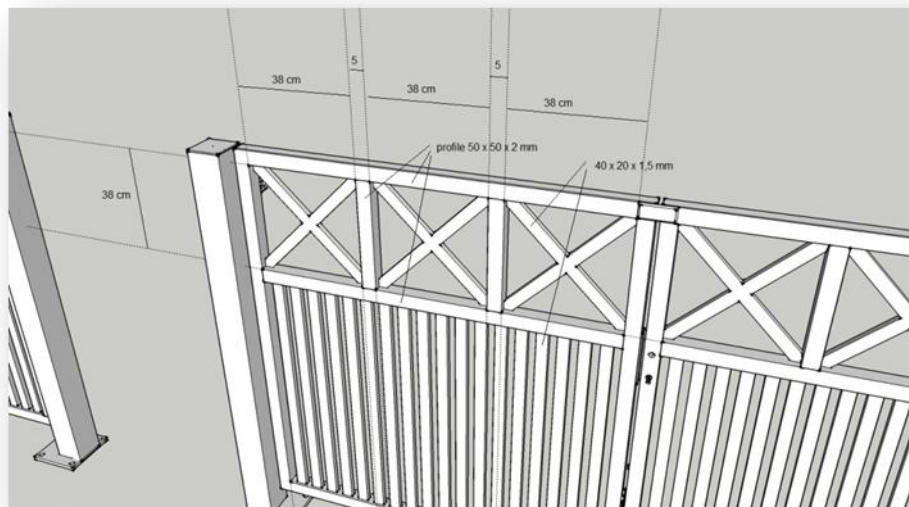
2 posts 120x120x4 mm with length 1600 mm with base plate (see pictures 22,23,24,25,26,27)

-Frame

Profiles: 50 mm x 50 mm x 2mm

Filling : rectangular profiles 60 x 20 x 1,5 mm

Hot dip galvanized 100 micrometer



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Dimensions of the cross :

For double gate : $134 \text{ cm} - 4 \times 5 \text{ cm} = 114 \text{ cm} \rightarrow 114 / 3 = 38 \text{ cm}$

choose also height = 38 cm

For single gate : $2 \times 38 \text{ cm} + 3 \times 5 = 91 \text{ cm} (1)$, choose height 38 cm.

Dimensions of the gates -width of the wings

Single gate : height 190 cm , width 91 cm :

See pict 15,16,17,18,19,20,21,22,23,24,25,26

Double gate : height 190 cm, width $2 \times 134 \text{ cm}$:

See pict 6,7,8,9,10,11,12,13,14,22,23,24,25,26,27

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