

FENCELINE TO SUCCESS



Chainlink Fence Fabrication



Personal Protective Equipment

- ✓ Eyewear
- ✓ Gloves
- ✓ Footwear
- ✓ Hard Hat
- ✓ Hearing protection
- ✓ Safety vests
- ✓ Lifting belt/back bra



Welding Personal Protective Equipment

- ✓ Safety Glasses
- ✓ Welding Bandana
- ✓ Welding Jacket
- ✓ Welding Helmet
- ✓ Welding Gloves
- ✓ Leather Apron
- ✓ Leather Boots



Welding Personal Protective Equipment

- ✓ Welding Protective Screens



Gate Fabrication Tools Required



✓ Pipe Cutter



Gate Fabrication Tools Required

✓ Pipe
Notcher



Gate Fabrication Tools Required

- ✓ Pipe Notcher



Gate Fabrication Tools Required

- ✓ Pipe Notcher



Residential Gate Hardware

- ✓ Walk Gates
- ✓ Double Gates



Residential Gate Hardware

- ✓ Walk Gates
- ✓ Double Gates
- ✓ Roll Gates
- ✓ Cantilever Gates



Residential Single Gate Fabrication



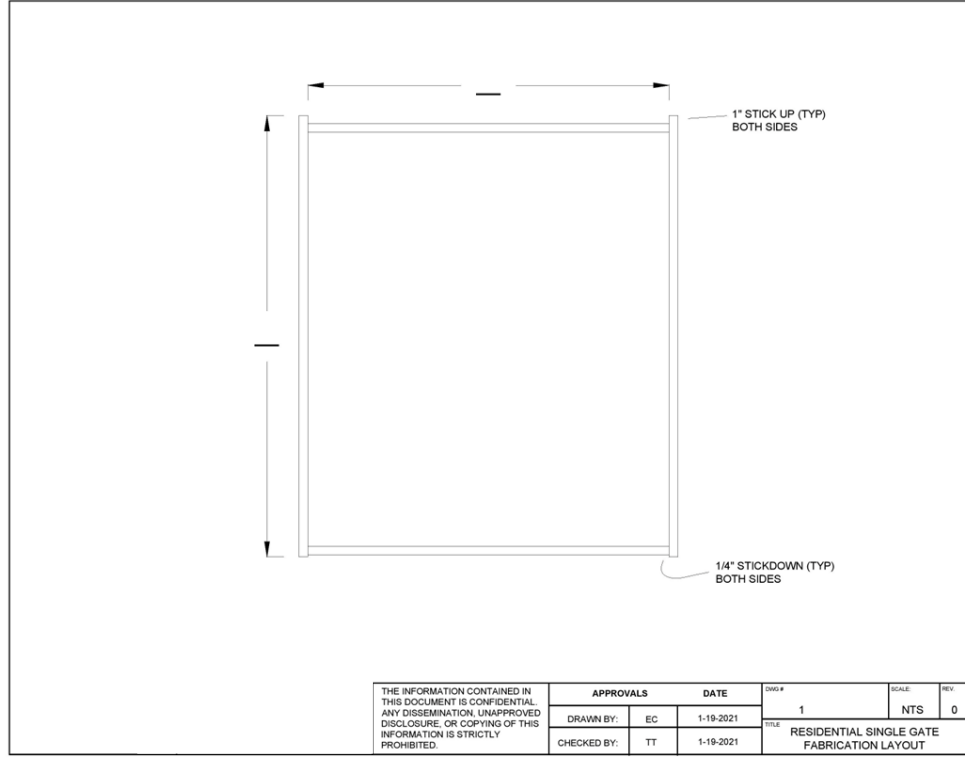
Residential Single Gate Fabrication



Residential Single Gate Fabrication

- **Residential Single Gates (1 3/8" tubing framework)**
- *Opening less 6" for cross piece cuts (2 required; NBE)*
 - *Place cross pieces 1" from top of uprights*
 - *Place bottom cross piece 1/4" from bottom of upright*
- *Height less 2 1/2" for upright piece cuts (2 required)*
- *Add horizontal (cross) brace for all gates over 4' height (1 required; NBE)*
- *Add 3/8" truss rods for all gate panels over 10' width*
- **EXAMPLE: 42" opening X 48" high // 36" cross piece cuts and 45 1/2" upright cuts**

Residential Single Gate Fabrication



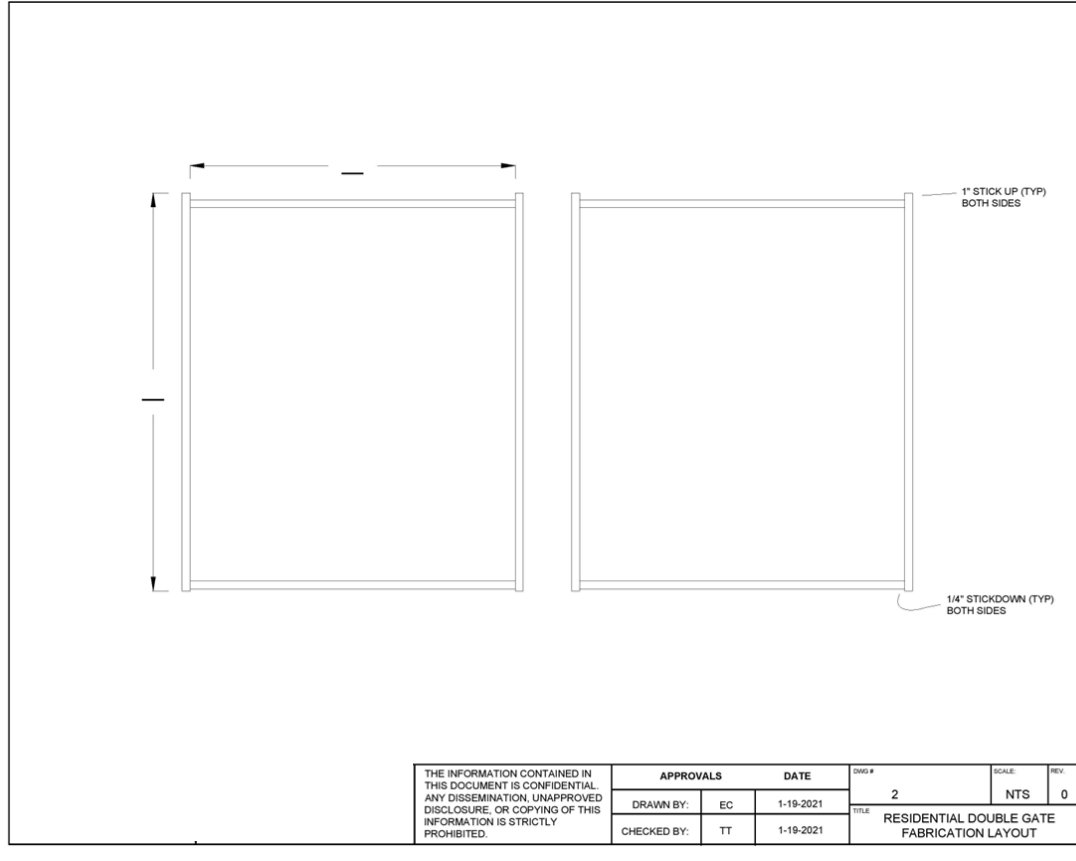
Residential Double Gate Fabrication



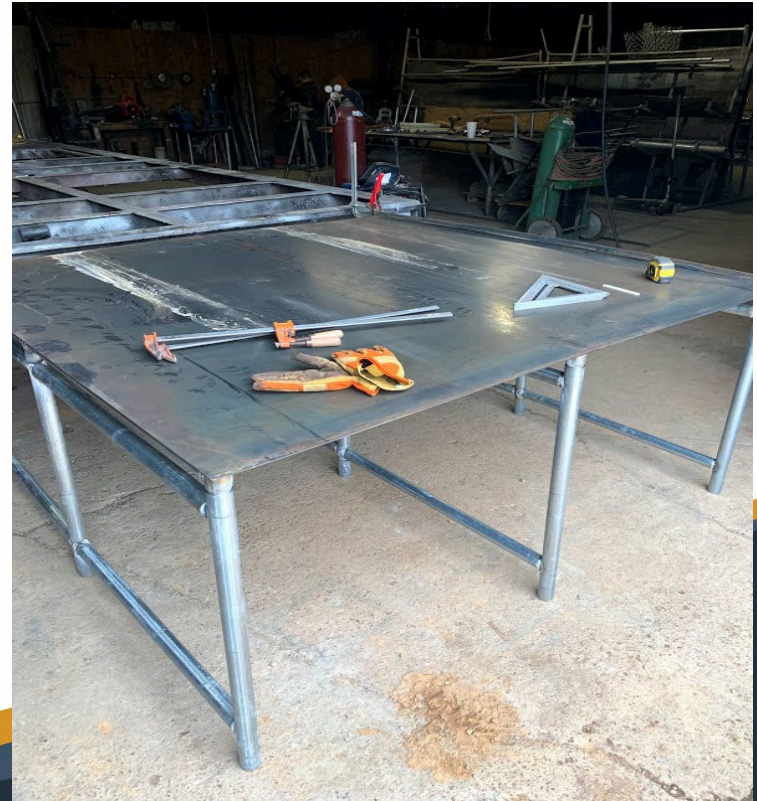
Residential Double Gate Fabrication

- *Residential Double Gates (1 3/8" tubing framework)*
- *Opening less 10", divided by 2 for cross piece cuts (4 required; NBE)*
 - *Place top cross piece 1" from top of uprights*
 - *Place bottom cross piece 1/4" from bottom of upright*
- *Height less 2 1/2" for upright piece cuts (4 required)*
- *Add horizontal (cross) brace for all gates over 4' height (2 required; NBE)*
- *Add 3/8" truss rods for all gate panels over 10' width*
- ***EXAMPLE: 10' opening X 48" high // 55" cross piece cuts and 45 1/2" upright cuts***

Residential Double Gate Fabrication



Residential Gate Fabrication Table



Commercial Single Gate Fabrication



Commercial Single Gate Fabrication

Commercial Single Gates (1 5/8" framework any weight)

Opening less 6 1/2" for cross piece cuts (2 required; NBE)

Height less 3" for latch side upright piece cuts (1 required)

Height less 1" for hinge side upright piece cuts (1 required)

Add horizontal (cross) brace for all gates over 4' height (1 required; NBE)

Add 3/8" truss rods for all single gates over 10' width

Add 13" to upright cuts for bard wire

EXAMPLE: 42" opening X 72" high // 35 1/2" cross piece cuts and 71" hinge upright cut, 69" latch upright cut

Commercial Single Gate Fabrication



Commercial Single Gate Fabrication

Commercial Single Gates (2" framework any weight)

Opening less 7 1/2" for cross piece cuts (2 required; NBE)

Height less 3" for latch side upright piece cuts (1 required)

Height less 1" for hinge side upright piece cuts (1 required)

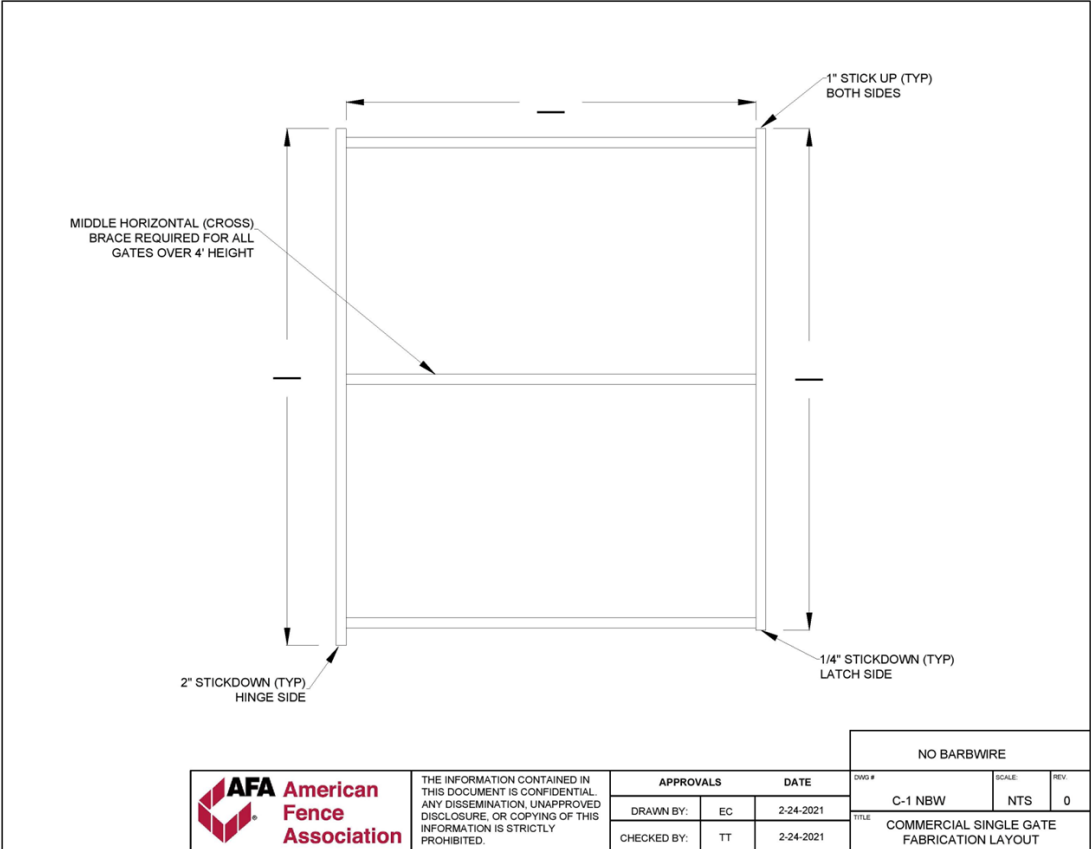
Add horizontal (cross) brace for all gates over 4' height (1 required; NBE)

Add 3/8" truss rods for all single gates over 10' width

Add 13" to upright cuts for bard wire

**EXAMPLE: 48" opening X 72" high // 40 1/2" cross piece cuts
and 71" hinge upright cut, 69" latch upright cut**

Commercial Single Gate Fabrication



NO BARBWIRE

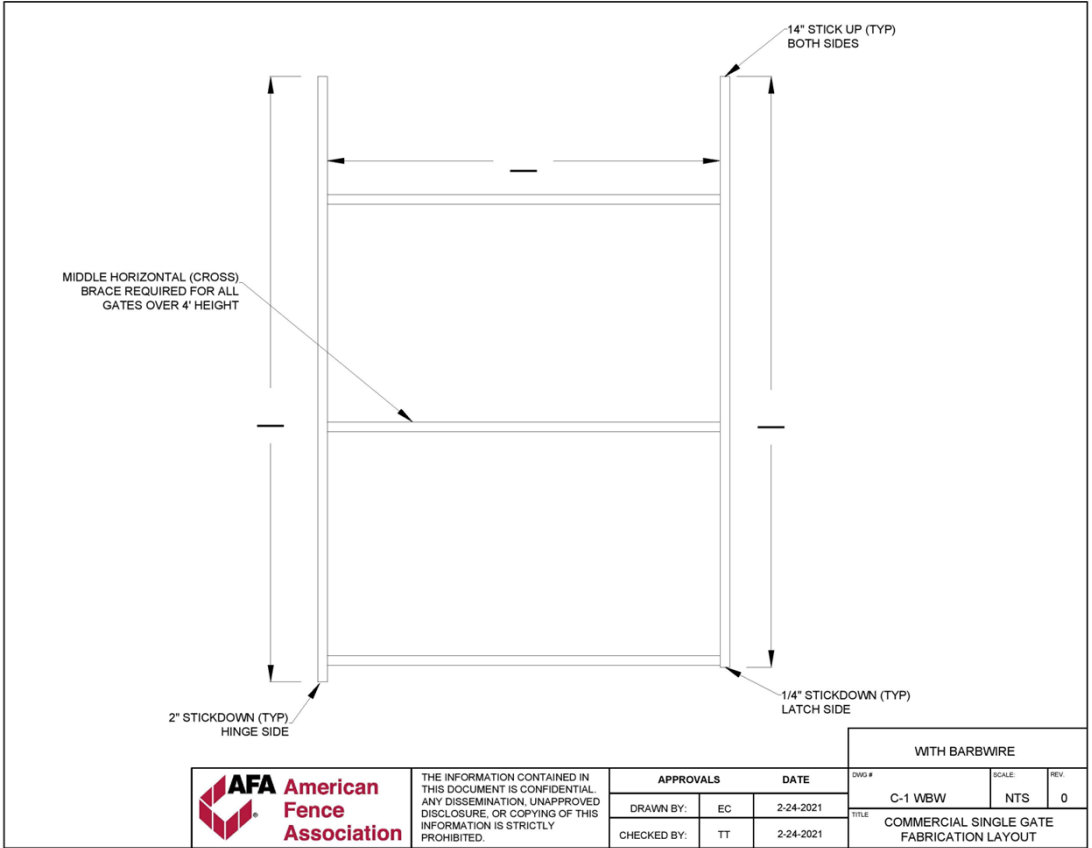


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APPROVALS		DATE
DRAWN BY:	EC	2-24-2021
CHECKED BY:	TT	2-24-2021

DWG #	SCALE	REV.
C-1 NBW	NTS	0
TITLE: COMMERCIAL SINGLE GATE FABRICATION LAYOUT		

Commercial Single Gate Fabrication



Commercial Double Gate Fabrication



Commercial Double Gate Fabrication

Commercial Double Gates (1 5/8" framework any weight)

Opening less 13", divided by 2 for cross piece cuts (4 required;
NBE)

Height less 3" for latch side upright piece cuts (2 required)

Height less 1" for hinge side upright piece cut (2 required)

Add horizontal (cross) brace for all gates over 4' height (2 required;
NBE)

Add 3/8" truss rods for all single gates over 10' width

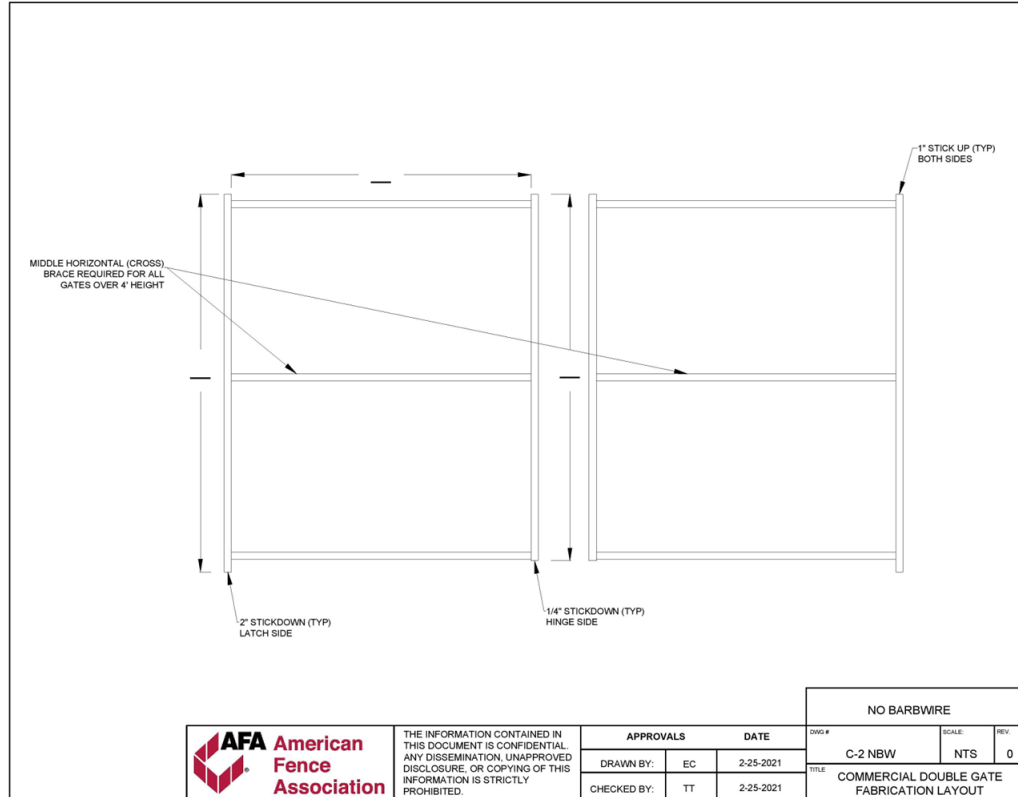
Add 13" to upright cuts for bard wire

**EXAMPLE: 10' opening X 72" high // 53 1/2" cross piece cuts and
71" hinge upright cut, 69" latch upright cut**

Commercial Double Gate Fabrication

- **Commercial Double Gates (2" framework any weight)**
- Opening less 14", divided by 2 for cross piece cuts (4 required; NBE)
- Height less 3" for latch side upright piece cuts (2 required)
- Height less 1" for hinge side upright piece cuts (2 required)
- Add horizontal (cross) brace for all gates over 4' height (2 required; NBE)
- Add 3/8" truss rods for all single gates over 10' width
- Add 13" to upright cuts for bard wire
- **EXAMPLE: 10' opening X 72" high // 53" cross piece cuts and 71" hinge upright cut, 69" latch upright cut**

Commercial Double Gate Fabrication

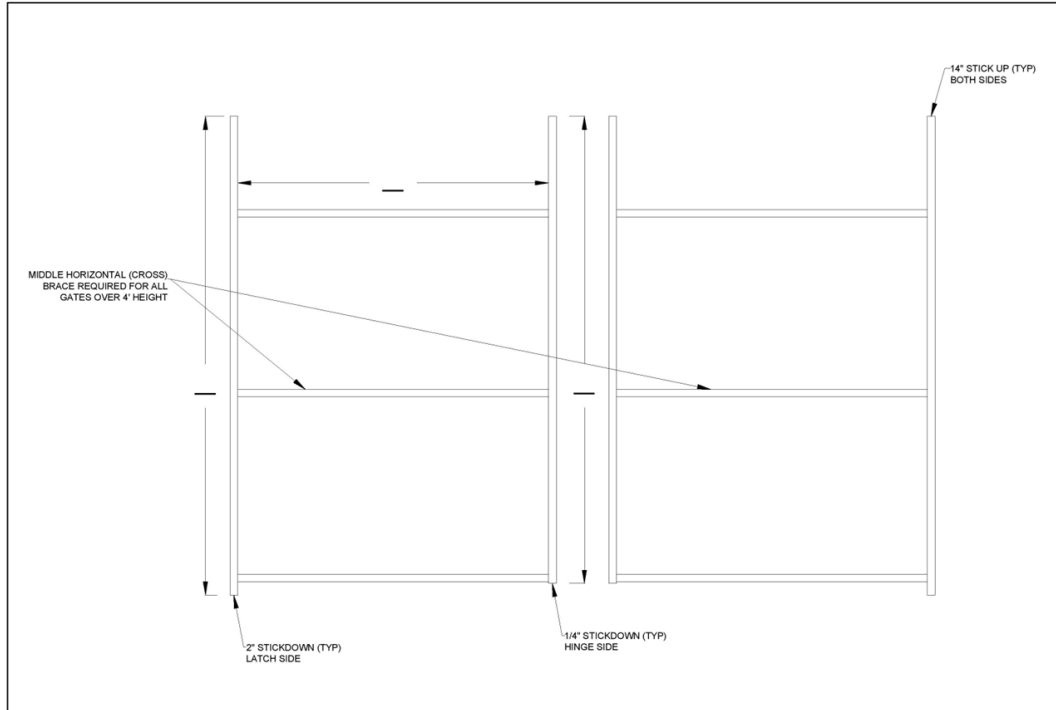


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APPROVALS		DATE
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NO BARBWIRE		
DWG #	SCALE	REV
C-2 NBW	NTS	0
TITLE COMMERCIAL DOUBLE GATE FABRICATION LAYOUT		

Commercial Double Gate Fabrication



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WITH BARBWIRE		
DWG #	SCALE	REV
C-2 WBW	NTS	0
TITLE COMMERCIAL DOUBLE GATE FABRICATION LAYOUT		

Commercial Roll Gate Fabrication



Commercial Roll Gate Fabrication



Commercial Double Gate Fabrication

Roll Gate (1 5/8" framework any weight)

- Cross pieces = Gate Opening + 1' + uprights for overall gate length
- Height less 4" for end uprights (2 required)
- Height less 8" for middle uprights (Quantity as required, NBE)
- Add horizontal (cross) brace for all gates over 4' height as required between uprights (NTF)
- 3/8" Truss rods welded per section cut to fit as required
- Add 12" to upright cuts for bard wire
- NOTE:
 - 1) Uprights will not exceed 5' spacing
 - 2) Fabric will cover full length of gate
 - 3) Fabric will be attached to top/bottom cross pieces with tie wire

Commercial Double Gate Fabrication

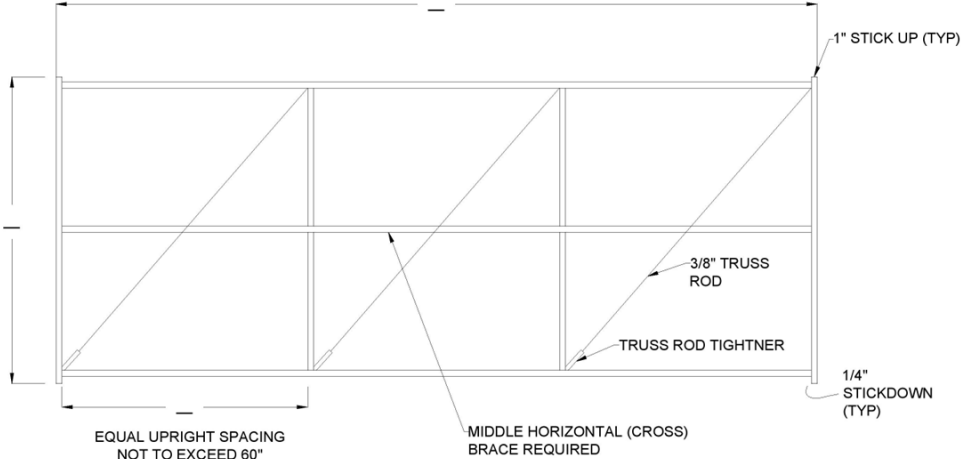
Roll Gates

Example: 20' opening x 72" high

(20' + 1' + uprights = 21'- 3 ¼" o/a length)

- Gate End Upright cuts = 68" (2 required)
- Middle uprights = 64" (3 required, NBE)
- 3/8" Truss Rods welded between uprights (4 required)

Commercial Roll Gate Fabrication

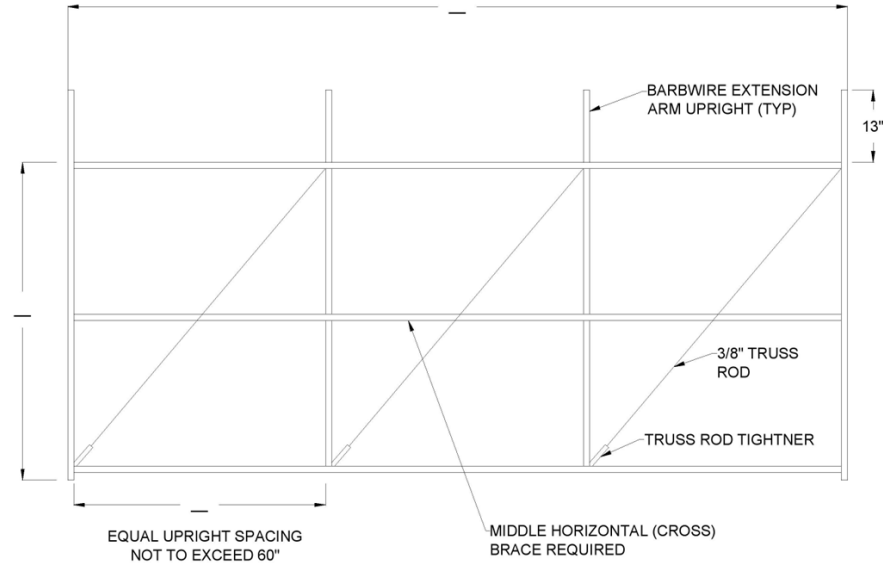


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APPROVALS		DATE
DRAWN BY:	EC	5-11-2021
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NO BARBWIRE		
DWG #	SCALE	REV
C-5-NBW	NTS	0
TITLE COMMERCIAL ROLL GATE FABRICATION LAYOUT		

Commercial Roll Gate Fabrication



EQUAL UPRIGHT SPACING
NOT TO EXCEED 60"

MIDDLE HORIZONTAL (CROSS)
BRACE REQUIRED



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WITH BARBWIRE		
DWG #	SCALE	REV
C-5-WBW	NTS	0
TITLE COMMERCIAL ROLL GATE GATE FABRICATION LAYOUT		

Commercial Cantilever Gate Fabrication



Commercial Cantilever Gate Fabrication

Cantilever Gates

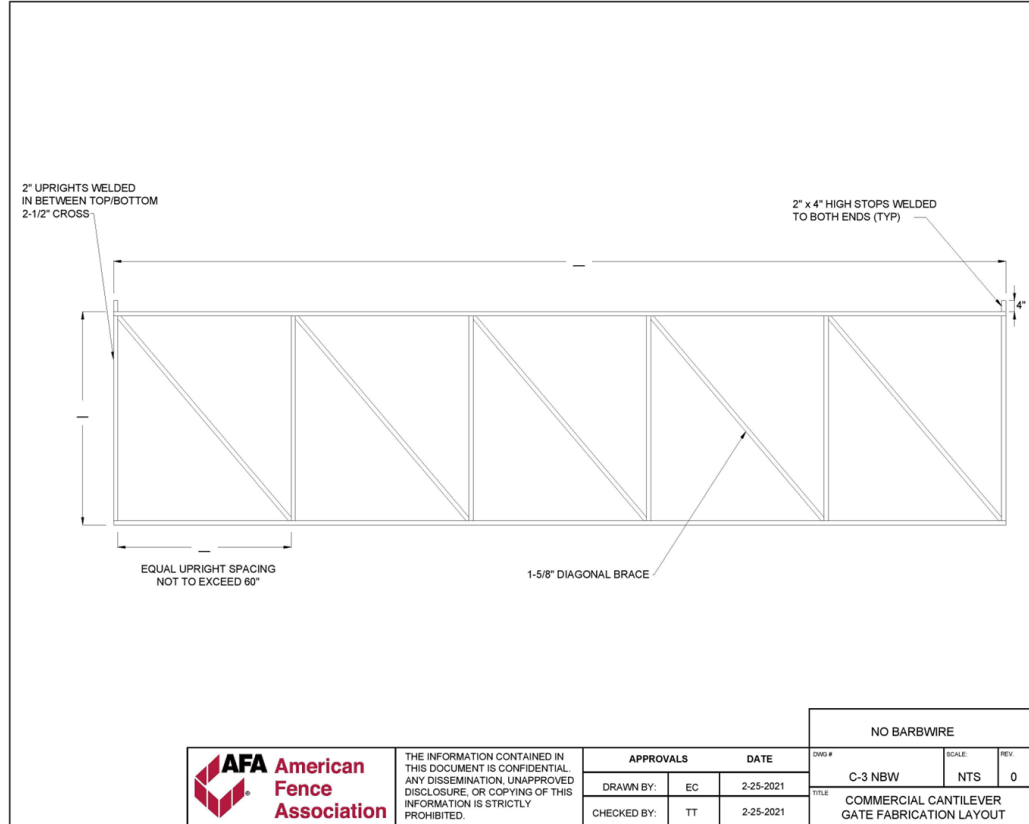
Example: 20' opening x 72" high

(20' + 10' + 1' = 31' o/a length) Cross pieces 2 ½' SCH 40 x 31' (2 required)

- Upright cut 61 ½" x 2" SCH 40 (7 required, NBE)
- Diagonal Brace (6 required, NTF)

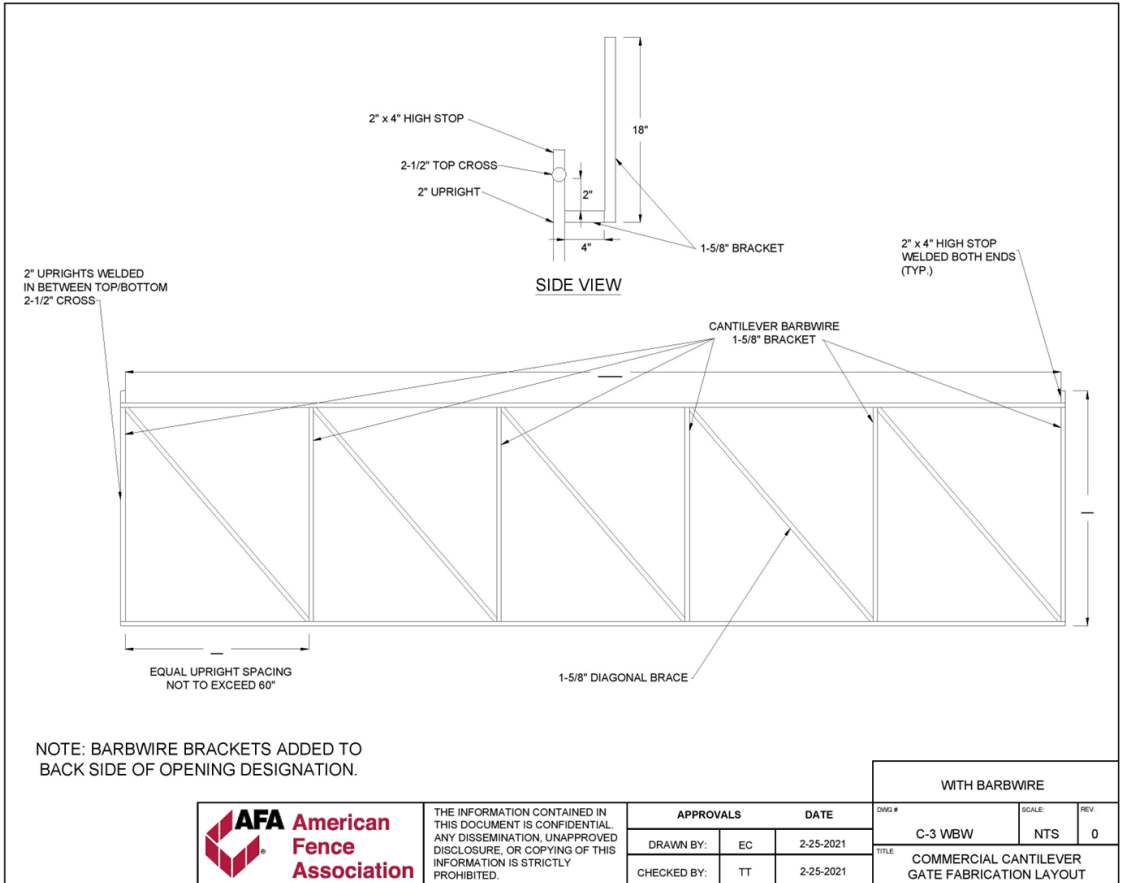
Commercial Roll Gate Fabrication

No
Barbed Wire



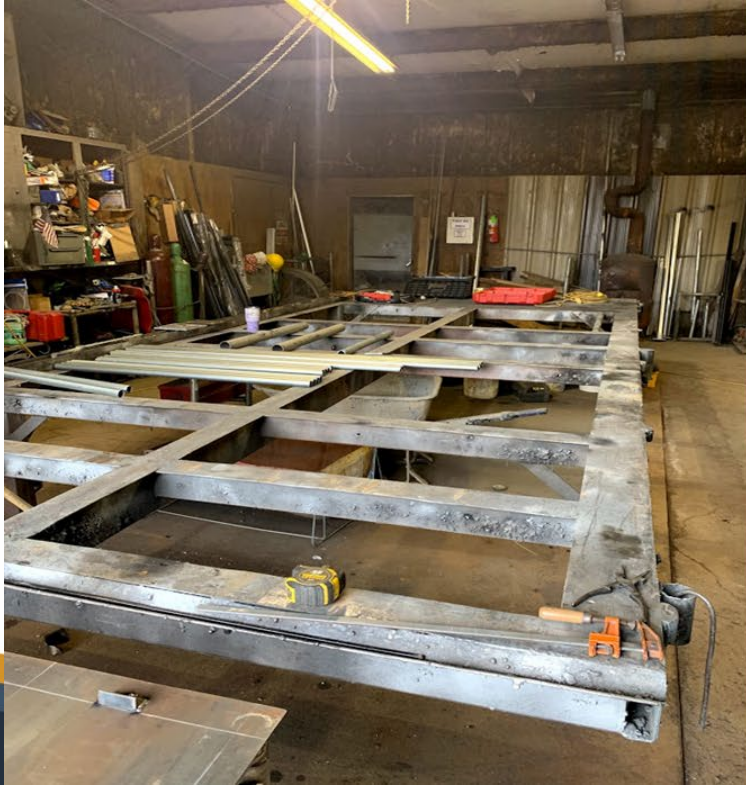
Commercial Roll Gate Fabrication

With
Barbed Wire



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Commercial Gate Fabrication Table



HOW IT ALL WORKS



Gate Fabrication Weld Shop Worksheet

Gate Fabrication Weld Shop Worksheet

Date _____ Date Required _____ Customer/Project Name _____ Work Order # _____

Gate Description _____ Frame Size/Weight _____ Fabric Height ____ Gauge ____ Oz ____ Knuckle Twist

Upright Hinge Side Cut _____ Quantity ____ Upright Latch Side Cut _____ Quantity ____ Cross Piece Cuts _____ Quantity ____

RH LH Single Gate Double Gate Roll Gate Cantilever Gate Drop Rod Frame ONLY Truss Barb Wire Brace

Fabrication Completion Date _____ Welder Initials _____ Cover Completion Date _____ Cover Initials _____

SPECIAL INSTRUCTIONS:



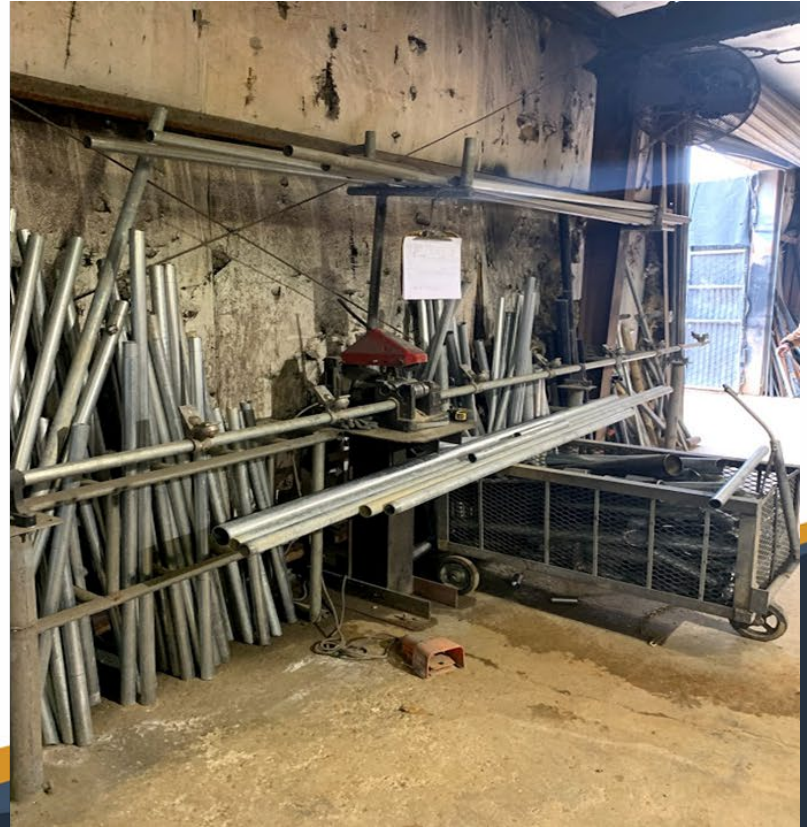
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APPROVALS		DATE
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Fence Company Shop Pictures



Fence Company Shop Pictures



Fence Company Shop Pictures



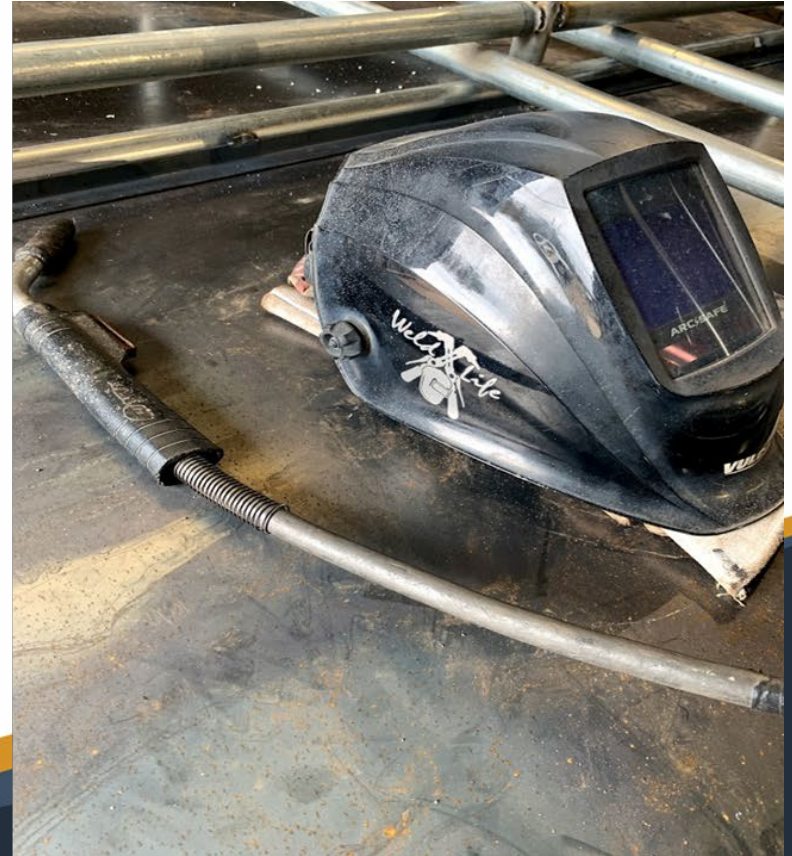
Fence Company Shop Pictures



Fence Company Shop Pictures



Fence Company Shop Pictures



Fence Company Shop Pictures



Chainlink Gate Fabrication

QUESTIONS

