

**AMERISTAR FENCE PRODUCTS**  
**Montage Industrial® - Steel Ornamental Fence System – Fusion Welded and Rackable**  
**CONSTRUCTION SPECIFICATION - SECTION 32 31 00**

**PART 1 - GENERAL**

**1.01 WORK INCLUDED**

The contractor shall provide all labor, materials and appurtenances necessary for installation of the welded ornamental steel fence system defined herein at (specify project site).

**1.02 RELATED WORK**

Section \_\_\_\_\_ - Earthwork

Section \_\_\_\_\_ - Concrete

**1.03 SYSTEM DESCRIPTION**

The manufacturer shall supply a total fence system of Montage Industrial® *Welded and Rackable* (ATF – All Terrain Flexibility) Ornamental Steel (specify Invincible®, Classic™, Majestic™, or Genesis™) design. The system shall include all components (i.e., panels, posts, gates and hardware) required.

**1.04 QUALITY ASSURANCE**

The contractor shall provide laborers and supervisors who are thoroughly familiar with the type of construction involved and materials and techniques specified.

**1.05 REFERENCES**

- ASTM A653/A653M - Standard Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy Coated (Galvannealed) by the Hot-Dip Process.
- ASTM B117 - Practice for Operating Salt-Spray (Fog) Apparatus.
- ASTM D523 - Test Method for Specular Gloss.
- ASTM D714 - Test Method for Evaluating Degree of Blistering in Paint.
- ASTM D822 - Practice for Conducting Tests on Paint and Related Coatings and Materials using Filtered Open-Flame Carbon-Arc Light and Water Exposure Apparatus.
- ASTM D1654 - Test Method for Evaluation of Painted or Coated Specimens Subjected to Corrosive Environments.
- ASTM D2244 - Test Method for Calculation of Color Differences from Instrumentally Measured Color Coordinates.
- ASTM D2794 - Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation (Impact).
- ASTM D3359 - Test Method for Measuring Adhesion by Tape Test.
- ASTM F2408 – Ornamental Fences Employing Galvanized Steel Tubular Pickets.

**1.06 SUBMITTAL**

The manufacturer's literature shall be submitted prior to installation.

**1.07 PRODUCT HANDLING AND STORAGE**

Upon receipt at the job site, all materials shall be checked to ensure that no damage occurred during shipping or handling. Materials shall be stored in such a manner to ensure proper ventilation and drainage, and to protect against damage, weather, vandalism and theft.

**PART 2 - MATERIALS**

**2.01 MANUFACTURER**

The fence system shall conform to Montage Industrial® *Welded and Rackable* (ATF – All Terrain Flexibility) Ornamental Steel, (specify Invincible®, Classic™, Majestic™, or Genesis™) design, (specify extended picket or flush) bottom rail treatment, (specify 2-Rail, 3-Rail or 4-Rail) style manufactured by Ameristar Fence Products, Inc., in Tulsa, Oklahoma.

**2.02 MATERIAL**

**A.** Steel material for fence panels and posts shall conform to the requirements of ASTM A653/A653M, with a minimum yield strength of 45,000 psi (344 MPa) and a minimum zinc (hot-dip galvanized) coating weight of 0.60 oz/ft<sup>2</sup> (184 g/m<sup>2</sup>), Coating Designation G-60. A minimum of 62% of the steel material shall be derived from recycled scrap metal.

**B.** Material for pickets shall be 1" square x 16 Ga. tubing. The rails shall be steel channel, 1.75" x 1.75" x .105". Picket holes in the rail shall be spaced 4.715" o.c. For fence systems up to and including 6 feet tall, posts shall be a minimum of 2-1/2" square x 14 Ga. For fence systems 7 feet tall and 8' tall, posts shall be a minimum of 2-1/2" square x 12 Ga. Gate posts shall meet the minimum requirements of Table 1.

## **2.03 FABRICATION**

**A.** Pickets, rails and posts shall be pre-cut to specified lengths. Rails shall be pre-punched to accept pickets.

**B.** Pickets shall be inserted into the pre-punched holes in the rails and shall be aligned to standard spacing using a specially calibrated alignment fixture. The aligned pickets and rails shall be joined at each picket-to-rail intersection by Ameristar's proprietary fusion welding process, thus completing the rigid panel assembly (Note: The process produces a virtually seamless, spatter-free good-neighbor appearance, equally attractive from either side of the panel).

**C.** The manufactured panels and posts shall be subjected to an inline electrodeposition coating (E-Coat) process consisting of a multi-stage pretreatment/wash (with zinc phosphate), followed by a duplex application of an epoxy primer and an acrylic topcoat. The minimum cumulative coating thickness of epoxy and acrylic shall be 2 mils (0.058 mm). The color shall be (specify Black or Bronze). The coated panels and posts shall be capable of meeting the performance requirements for each quality characteristic shown in Table 2 (Note: The requirements in Table 2 meet or exceed the coating performance criteria of ASTM F2408).

**D.** The manufactured fence system shall be capable of meeting the vertical load, horizontal load, and infill performance requirements for Industrial weight fences under ASTM F2408.

**E.** Swing gates shall be fabricated using 1.75" x 14ga Forerunner double channel rail, 2" sq. x 11ga. gate ends, and 1" sq. x 14ga. pickets. Gates that exceed 6' in width will have a 1.75" sq. x 14ga. intermediate upright. All rail and upright intersections shall be joined by welding. All picket and rail intersections shall also be joined by welding. Gusset plates will be welded at each upright to rail intersection. Cable kits will be provided for additional trussing for all gates leaves over 6'.

## **PART 3 - EXECUTION**

### **3.01 PREPARATION**

All new installation shall be laid out by the contractor in accordance with the construction plans.

### **3.02 FENCE INSTALLATION**

Fence post shall be spaced according to Table 3, plus or minus 1/2". For installations that must be raked to follow sloping grades, the post spacing dimension must be measured along the grade. Fence panels shall be attached to posts with brackets supplied by the manufacturer. Posts shall be set in concrete footers having a minimum depth of 36" (Note: In some cases, local restrictions of freezing weather conditions may require a greater depth). The "Earthwork" and "Concrete" sections of this specification shall govern material requirements for the concrete footer. Posts setting by other methods such as plated posts or grouted core-drilled footers are permissible only if shown by engineering analysis to be sufficient in strength for the intended application.

### **3.03 FENCE INSTALLATION MAINTENANCE**

When cutting/drilling rails or posts adhere to the following steps to seal the exposed steel surfaces; 1) Remove all metal shavings from cut area. 2) Apply zinc-rich primer to thoroughly cover cut edge and/or drilled hole; let dry. 3) Apply 2 coats of custom finish paint matching fence color. Failure to seal exposed surfaces per steps 1-3 above will negate warranty. Ameristar spray cans or paint pens shall be used to prime and finish exposed surfaces; it is recommended that paint pens be used to prevent overspray. Use of non-Ameristar parts or components will negate the manufactures' warranty.

### **3.04 GATE INSTALLATION**

Gate posts shall be spaced according to the manufacturers' gate drawings, dependent on standard out-to-out gate leaf dimensions and gate hardware selected. Type and quantity of gate hinges shall be based on the application; weight, height, and number of gate cycles. The manufacturers' gate drawings shall identify the necessary gate hardware required for the application. Gate hardware shall be provided by the manufacturer of the gate and shall be installed per manufacturer's recommendations.

### **3.05 CLEANING**

The contractor shall clean the jobsite of excess materials; post-hole excavations shall be scattered uniformly away from posts.

<b>Table 1 – Minimum Sizes for Montage Industrial Posts</b>			
<u>Fence Posts</u>		<u>Panel Height</u>	
2-1/2" x 14 Ga.		Up to & Including 6' Height	
2-1/2" x 12 Ga.		Over 6' Up to & Including 8' Height	
<u>Gate Leaf</u>	<u>Gate Height</u>		
	<u>Up to &amp; Including 4'</u>	<u>Over 4' Up to &amp; Including 6'</u>	<u>Over 6' Up to &amp; Including 8'</u>
Up to 4'	2-1/2" x 12 Ga.	3" x 12 Ga.	3" x 12 Ga.
4'1" to 6'	3" x 12Ga.	4" x 11 Ga.	4" x 11 Ga.
6'1" to 8'	3" x 12 Ga.	4" x 11 Ga.	6" x 3/16"
8'1" to 10'	4" x 11 Ga.	6" x 3/16"	6" x 3/16"
10'1" to 12'	4" x 11 Ga.	6" x 3/16"	6" x 3/16"
12'1" to 14'	4" x 11 Ga.	6" x 3/16"	6" x 3/16"
14'1" to 16'	6" x 3/16"	6" x 3/16"	6" x 3/16"

<b>Table 2 – Coating Performance Requirements</b>		
<u>Quality Characteristics</u>	<u>ASTM Test Method</u>	<u>Performance Requirements</u>
Adhesion	D3359 – Method B	Adhesion (Retention of Coating) over 90% of test area (Tape and knife test).
Corrosion Resistance	B117, D714 & D1654	Corrosion Resistance over 1,500 hours (Scribed per D1654; failure mode is accumulation of 1/8" coating loss from scribe or medium #8 blisters).
Impact Resistance	D2794	Impact Resistance over 60 inch lb. (Forward impact using 0.625" ball).
Weathering Resistance	D822 D2244, D523 (60° Method)	Weathering Resistance over 1,000 hours (Failure mode is 60% loss of gloss or color variance of more than 3 delta-E color units).

<b>Table 3 – Montage Industrial – Post Spacing By Bracket Type</b>										
Span	For INVINCIBLE® 8' Nominal (91-1/2" Rail)				For CLASSIC, GENESIS, & MAJESTIC 8' Nominal (92-5/8" Rail)					
	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"
Bracket Type	Industrial Flat Mount (BB301)*		Industrial Line 2-1/2" (BB319) 3" (BB320)		Industrial Universal 2.5" (BB302) 3" (BB303)		Industrial Flat Mount (BB301)		Industrial Swivel (BB304)*	
Post Settings ± 1/2" O.C.	94-1/2"	95"	94-1/2"	95"	96"	96-1/2"	96"	96-1/2"	*96"	*96-1/2"

\*Note: When using BB304 swivel brackets on either or both ends of a panel installation, care must be taken to ensure the spacing between post and adjoining pickets meets applicable codes. This will require trimming one or both ends of the panel. When using the BB301 flat mount bracket for Invincible style, rail may need to be drilled to accommodate rail to bracket attachment.