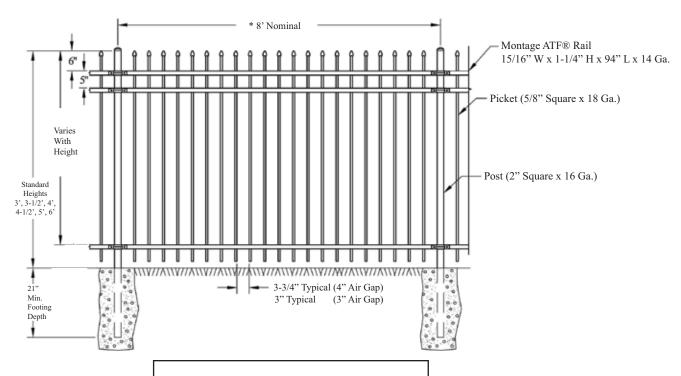
MONTAGE® WELDED RESIDENTIAL ORNAMENTAL FENCE

TYPICAL PANEL DRAWING

(Classic Style shown; Genesis, Majestic, Warrior, Crescent and Gemini also available)



* Refer to Construction Specification Table for recommended (Post Spacing by Bracket Type)

E-CoatTM PROTECTION

UNIQUE PROFUSION WELDING PROCESS

PATENT D466,620 6,811,145 7,071,439

ATF®
RACKABLE DESIGN
PATENT D466,621 7,071,439



- AUTOMATICALLY FUSION WELDED AT ALL INTERSECTIONS
- NO EXPOSED WELDS VIRTUALLY SEAMLESS APPEARANCE
- GOOD NEIGHBOR PROFILE SAME ON BOTH SIDES
- CONSISTENTLY HIGH QUALITY LEVEL EVERY PANEL
- ZINC-PHOSPHATIZED GALVANIZED STEEL BASE MATERIAL



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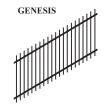
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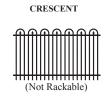
2-Rail (Standard) 4" Àir Gap











(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
3' H	R <u>*</u> <u>X</u> 234	30	40	MAJ/BLK
3-1/2° H	R <u>*</u> <u>X</u> 240	33	40	MAJ/BLK
4' H	R <u>*</u> <u>X</u> 246	36	40	MAJ, CLS, GEN/BLK & MAJ/BRZ
5' H	R <u>*</u> <u>X</u> 258	43	40	MAJ, CLS, GEN/BLK

 $\underline{*}$ $\underline{X} = \underline{COLOR\ SELECTION}$ STYLE SELECTION =

 $CLASSIC = \underline{\mathbf{C}} \quad \underline{\mathbf{B}} = BLACK$

GENESIS = \mathbf{G} \mathbf{N} = BRONZE

 $MAJESTIC = \underline{M}$ WARRIOR = $\underline{\mathbf{W}}$ CRESCENT =

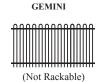
> N/A IN 4" AIR GAP GEMINI =

(8' Nominal) 94" Actual Panel Width

5/8" Sq x 18 Ga. Picket = (21 - Pickets per Panel)

3" Air Gap





(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
3'H	R <u>*</u> <u>X</u> 234-3	34	40	N/A
3-1/2° H	R <u>*</u> <u>X</u> 240-3	38	40	N/A
4' H	R <u>*</u> <u>X</u> 246-3	44	40	N/A

 $\underline{STYLE\ SELECTION} = \quad \underline{*} \quad \underline{X} = \underline{COLOR\ SELECTION}$

 $MAJESTIC = \underline{\mathbf{M}} \quad \underline{\mathbf{B}} = BLACK$

GEMINI = $\underline{\mathbf{H}}$ $\underline{\mathbf{N}}$ = BRONZE

CLASSIC = N/A IN 3" AIR GAP

GENESIS = N/A IN 3" AIR GAP

WARRIOR = N/A IN 3" AIR GAP

CRESCENT = N/A IN 3" AIR GAP

* Non-Stocking panel styles/colors must be purchased in full pallet quantities.
* Genesis panels in both Black and Bronze are packaged with (Black) 5/8" Sq picket plugs.

(8' Nominal) 94" Actual Panel Width

5/8" Sq x 18 Ga. Picket = (26 - Pickets per Panel)

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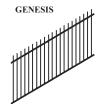
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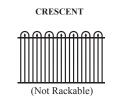
2-Rail (Flush Bottom) 4" Air Gap











(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
3'H	R <u>*</u> <u>X</u> 234F	30	40	MAJ/BLK
3-1/2° H	R <u>*</u> <u>X</u> 240F	33	40	MAJ/BLK
4' H	R <u>*</u> <u>X</u> 246F	36	40	MAJ/BLK
5' H	R <u>*</u> <u>X</u> 258F	43	40	MAJ/BLK

 $\underline{STYLE\ SELECTION} = \quad \underline{*} \quad \underline{X} = \underline{COLOR\ SELECTION}$

 $CLASSIC = \underline{\mathbf{C}} \quad \underline{\mathbf{B}} = BLACK$

GENESIS = \mathbf{G} \mathbf{N} = BRONZE

 $\begin{aligned} \text{MAJESTIC} &= & \underline{\mathbf{M}} \\ \text{WARRIOR} &= & \underline{\mathbf{W}} \\ \text{CRESCENT} &= & \underline{\mathbf{L}} \end{aligned}$

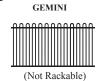
GEMINI = N/A IN 4" AIR GAP

(8' Nominal) 94" Actual Panel Width

5/8" Sq x 18 Ga. Picket = (21 - Pickets per Panel)

3" Air Gap





(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
3'H	R <u>*</u> <u>X</u> 234F-3	34	40	N/A
3-1/2° H	R <u>*</u> <u>X</u> 240F-3	38	40	N/A
4' H	R <u>*</u> <u>X</u> 246F-3	44	40	MAJ/BLK

 $\underline{STYLE \ SELECTION} = \quad \underline{*} \quad \underline{X} = \underline{COLOR \ SELECTION}$

 $MAJESTIC = \underline{\mathbf{M}} \quad \underline{\mathbf{B}} = BLACK$

GEMINI = $\underline{\mathbf{H}}$ $\underline{\mathbf{N}}$ = BRONZE

CLASSIC = N/A IN 3" AIR GAP

GENESIS = N/A IN 3" AIR GAP

WARRIOR = N/A IN 3" AIR GAP CRESCENT = N/A IN 3" AIR GAP

* Non-Stocking panel styles/colors must be purchased in full pallet quantities.

* Genesis panels in both Black and Bronze are packaged with (Black) 5/8" Sq picket plugs.

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(8' Nominal) 94" Actual Panel Width

5/8" Sq x 18 Ga. Picket = (26 - Pickets per Panel)

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(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
3' H	R <u>*</u> <u>X</u> 334	35	40	MAJ, CLS, GEN/BLK
3-1/2° H	R <u>*</u> <u>X</u> 340	39	40	MAJ, CLS, GEN/BLK
4' H	R <u>*</u> <u>X</u> 346	42	40	MAJ, CLS, GEN, WAR, CRE/BLK & MAJ, GEN/BRZ
5' H	R <u>*</u> <u>X</u> 358	49	40	MAJ, CLS, GEN, WAR/BLK & MAJ, CLS/BRZ
6' H	R <u>*</u> <u>X</u> 370	55	40	MAJ, CLS, GEN, WAR/BLK & CLS, GEN/BRZ

 $\underline{\textbf{STYLE SELECTION}} =$ $\underline{\mathbf{X}} = \underline{\mathbf{COLOR}} \ \underline{\mathbf{SELECTION}}$

> CLASSIC = $\underline{\mathbf{C}}$ $\underline{\mathbf{B}}$ = BLACK

GENESIS = $\underline{\mathbf{G}}$ $\underline{\mathbf{N}}$ = BRONZE

MAJESTIC = WARRIOR = CRESCENT =

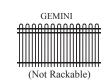
> GEMINI = N/A IN 4" AIR GAP

(8' Nominal) 94" Actual Panel Width 5/8" Sq x 18 Ga. Picket = (21 - Pickets per Panel)









(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
3'H	R <u>*</u> <u>X</u> 334-3	40	40	N/A
3-1/2° H	R <u>*</u> <u>X</u> 340-3	44	40	N/A
4' H	R <u>*</u> <u>X</u> 346-3	50	40	MAJ, CLS, GEN/BLK
5' H	R <u>*</u> <u>X</u> 358-3	55	40	MAJ, CLS/BLK
6' H	R <u>*</u> <u>X</u> 370-3	62	40	MAJ, CLS/BLK

STYLE SELECTION = $\underline{*}$ $\underline{X} = \underline{COLOR\ SELECTION}$

 $CLASSIC = \underline{C} \underline{B} = BLACK$

GENESIS = $\mathbf{\underline{G}}$ $\mathbf{\underline{N}}$ = BRONZE

 $MAJESTIC = \underline{M}$ GEMINI = \mathbf{H}

WARRIOR = N/A IN 3" AIR GAP CRESCENT = N/A IN 3" AIR GAP

- Non-Stocking panel styles/colors must be purchased in full pallet quantities.
 Genesis panels in both Black and Bronze are packaged with (Black) 5/8" Sq picket plugs.

(8' Nominal) 94" Actual Panel Width

5/8" Sq x 18 Ga. Picket = (26 - Pickets per Panel)

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MONTAGE® PANELS

CLASSIC

5' H

6' H



3-Rail (Flush Bottom) 4" Air Gap

WARRIOR

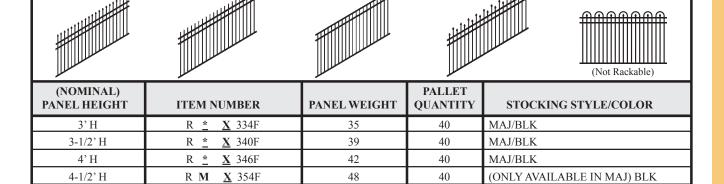
40

40

MAJESTIC

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CRESCENT



49

55

 $\underline{STYLE\ SELECTION} = \quad \underline{*} \quad \underline{X} = \underline{COLOR\ SELECTION}$

X 358F

X 370F

CLASSIC = $\underline{\mathbf{C}}$ $\underline{\mathbf{B}}$ = BLACK

R *

R *

GENESIS

GENESIS = $\underline{\mathbf{G}}$ $\underline{\mathbf{N}}$ = BRONZE

 $\begin{array}{ll} \text{MAJESTIC} = & \underline{\mathbf{M}} \\ \text{WARRIOR} = & \underline{\mathbf{W}} \\ \text{CRESCENT} = & \underline{\mathbf{L}} \end{array}$

GEMINI = N/A IN 4" AIR GAP

(8' Nominal) 94" Actual Panel Width

MAJ, CLS, GEN/BLK

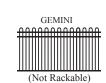
MAJ, CLS/BLK

5/8" Sq x 18 Ga. Picket = (21 - Pickets per Panel)









(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
3' H	R <u>*</u> <u>X</u> 334F-3	40	40	N/A
3-1/2° H	R <u>*</u> <u>X</u> 340F-3	44	40	N/A
4' H	R <u>*</u> <u>X</u> 346F-3	50	40	MAJ/BLK
4-1/2° H	R M <u>X</u> 354F-3	55	40	(ONLY AVAILABLE IN MAJ) N/A
5' H	R <u>*</u> <u>X</u> 358F-3	56	40	N/A
6' H	R <u>*</u> <u>X</u> 370F-3	63	40	N/A

 $\underline{STYLE\ SELECTION} = \quad \underline{*} \quad \underline{X} = \underline{COLOR\ SELECTION}$

CLASSIC = $\underline{\mathbf{C}}$ $\underline{\mathbf{B}}$ = BLACK

GENESIS = $\underline{\mathbf{G}}$ $\underline{\mathbf{N}}$ = BRONZE

 $MAJESTIC = \underline{\mathbf{M}}$ $GEMINI = \underline{\mathbf{H}}$

WARRIOR = N/A IN 3" AIR GAP

CRESCENT = N/A IN 3" AIR GAP

* Non-Stocking panel styles/colors must be purchased in full pallet quantities.

* Genesis panels in both Black and Bronze are packaged with (Black) 5/8" Sq picket plugs.

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(8' Nominal) 94" Actual Panel Width

5/8" Sq x 18 Ga. Picket = (26 - Pickets per Panel)

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	BLAC	CK	COLOR		BAG	nov		
ITEM DESCRIPTION	BLACK PART NO.	DEALER PRICE	BRONZE DEALER PART NO. PRICE		QTY	BOX QTY	WT EA.	
Montage Universal Boulevard Bracket	BB102	iah atranati	BN102 1 stainless steel. Packaged in polybag with	#10 v 2/4	2	150	.27	
	bolts and 1/4	" flange nu	is stainless steet. Packaged in polybag will ts. Works universally for lines, ends, and color IN BAG QUANTITIES.				ŭ	
Montage Line	BB104		BN104		2	120	.47	
Bracket	Made from high strength stainless steel. Used as boulevard bracket around a 2" post to join two adjacent panels in line. Packaged in polybag with #10 x 3/4" self-drilling screws, 1/4" x 1-1/2" carriage bolts and 1/4" flange nuts. Packaged 2 per bag. MUST BE ORDERED IN BAG QUANTITIES.							
Montage Flat Mount	BB105		BN105		2	300	.15	
Bracket	Made from high strength stainless steel. Can be used to attach panels to walls, wood posts, etc. Packaged in polybag with #14 x 3/4" self-drilling screws, 1/4" x 1-1/2" carriage bolts and 1/4" flange nuts. Packaged 2 per bag. MUST BE ORDERED IN BAG QUANTITIES.							
Montage Swivel	BB106		BN106		2	120	.20	
Bracket	Heavy-duty cast aluminum. For oblique angles. Packaged in polybag with #10 x 3/4" self-drilling screws and #10 x 5/8" flat head phillips screw. Packaged 2 per bag. MUST BE ORDERED IN BAG QUANTITIES.							

$\mathbf{ADORNMENTS^{TM}}$

ITEM DESCRIPTION			PART NUMBER					
HEM DESCRIPTION	BLACK PART NO.	DEALER PRICE	BRONZE PART NO.	DEALER PRICE	SIZE	UNIT OF MEASURE	WT EA.	
Quad-Flare 🕡	AB301		AN301		5/8"	Ea.	.2	
		to "Genesis™" style p	Heavy-duty cast aluminum. The four annels (21 required per panel on standa					
Triad	AB302		AN302		5/8"	Ea.	.2	
		to "Genesis™" style	Heavy-duty cast aluminum. Three di panels (21 required per panel on standa				on	
Serpentine Scroll	HB059		HN059			Ea.	.75	
69:00			s. Die cast aluminum. Can be mounted shed with #10 x 3/4" self-drilling screv					
Butterfly Scroll	HB058		HN058			Ea.	.2	
	Fits onto the face of 5/8" square pickets. Die cast aluminum. Can be mounted in a line between the top rails of 3-rail panels or grouped in Arched Swing Gates. Furnished with #10 x 3/4" self-drilling screws. (11 required per panel). Not available for 3" Air Gap spacing.							
Double Ring	AB102		AN102 (N/S)			Ea.	.7	
			s. Die cast aluminum. Can be mounte nished with #14 x 3/4" self-drilling scr				ls to	
Corona	AB103		AN103 (N/S)			Ea.	.35	
			ressed steel ring. Can be mounted in a red per panel). Includes two (2) #10 x					
Picket Plug	AB502				5/8"	21/Bag	.06	
	5/8" plug for flat	top pickets. SOLD IN	N BAG QUANTITY ONLY.					

N/S = Non Stock

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ITEM DESCRIPTION		PART NUMBER / COLOR							
	BLACK PART NO.				UNIT OF MEASURE	WT EA.			
Self-Drilling Screws	HB524P-50	HN524P-50		#14 X 3/4"	50/Bag	.6			
(Jun=	Stainless steel he	ex head self-drilling screws for brackets and adornments.							
Self-Drilling Screws	HB539P-50	HN539P-50		#10 x 3/4"	50/Bag	.6			
(Dun=	Stainless steel hex head self-drilling screws for brackets and adornments.								
Phillips Head Screws	H519P			#10 x 5/8"	Ea.	.005			
()	Stainless steel flat head screw for setting angle on Montage swivel bracket.								
Carriage Bolts	HB511P-20	HN511P-20		1/4" x 1-1/2"	20/Bag	.5			
	Stainless steel carriage bolts for brackets.								
Flange Nuts	HB541P-20	HN541P-20		1/4"	20/Bag	.2			
	1/4" Stainless steel flange nuts for brackets.								

CUSTOM FINISHES

ITEM DESCRIPTION	BLA	CK	COLOR		WEIGHT	
HEW DESCRIPTION	BLACK PART NO.	DEALER PRICE	BRONZE PART NO.	DEALER PRICE	WEIGHT EACH	
Paint Pen	PB100		PN100		.5	
	Custom fi	nishes in the	ne two standard Montage Fence colors.			
Zinc-Rich Paint Pen			PZ100		.5	
	Priming required for cut steel edges prior to application of Ameristar Custom Finishes NOTE: All cut rail ends must be seal coated with Zinc Rich Primer and Ameristar's custom touch-up paint or the warranty is void.					
Spray Paint	FB100		FN100		1.1	
200 - 200 -	Custom finishes in the two standard Montage Fence colors.					
Zinc-Rich Primer			FZ100		1.1	
	Ideal for priming cut steel edges of Montage Fence components prior to applying the appropriate custom finish color. NOTE: All cut rail ends must be seal coated with Zinc Rich Primer and Ameristar's custom touch-up paint or the warranty is void.					

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NOTE: In location subject to freezing, where posts are grouted into core-drilled holes, a 1/4" diameter hole should be drilled in the post approximately 1/2" above elevation to allow for drainage of built-up ground water. The drilled hole must be wiped clean and dry before applying Ameristar zinc primer and color finish.

$$\begin{split} \underline{X} &= \text{COLOR SELECTION} \\ B &= B \text{LACK} \\ N &= B \text{RONZE} \\ W &= W \text{HITE} \\ S &= S \text{AND} \end{split}$$

Post Diameter	Ga. / Wall Thickness	Post Length	Item Number	Catalog Price (Black)	Catalog Price (Color)	Post Weight
		4'-9"	WP <u>X</u> 20057			8
		5'-3"	WP <u>X</u> 20063			9
27, 50		5'-9"	WP <u>X</u> 20069			10
2" SQ. (STEEL)	16 GA. (RESIDENTIAL)	6'-9"	WP <u>X</u> 20081			11
		7'-9"	WP <u>X</u> 20093			13
		8'-9"	WP <u>X</u> 20105			14
		6'	WP <u>X</u> 25072			12
	16 GA.	7'	WP <u>X</u> 25084			14
2-1/2" SQ. (STEEL)	(RES/COM)	8'	WP <u>X</u> 25096			16
(SIEEL)		9'	WP <u>X</u> 25108			18

POST BASES

X = COLOR SELECTION B = BLACK N = BRONZE W = WHITE S = SAND									
Post Size	Base Size	Drill Holes	Item Number	Catalog Price (Black)	Catalog Price (Color)	Base Weight			
Fits 2" SQ. Steel Post	5" x 5"	9/16"	B <u>X</u> 205			3			

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$\underline{\mathbf{X}}$ = COLOR SELECTION

B = BLACK N = BRONZE W = WHITE S = SAND

Сар Туре	Cap Style	Size	Item Number	Catalog Price (Black)	Catalog Price (Color)	Cap Weight
STEEL		1-3/4" SQ.	A <u>X</u> 505			0.1
	STANDARD FLAT CAP	2" SQ.	A <u>X</u> 506			0.2
		2-1/2" SQ.	A <u>X</u> 507			0.3
ALUMINUM		2" SQ.	H <u>X</u> 508R			0.7
	BALL CAP	2-1/2" SQ.	A <u>X</u> 513			0.7

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Montage® Residential - 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 (specify Montage® standard picket space or Montage Pool, Pet & Play® 3" air space) Welded and Rakeable (ATF – All Terrain Flexibility) Ornamental Steel, (for standard picket space, specify ClassicTM, MajesticTM, GenesisTM, WarriorTM, CrescentTM; for 3" air-space specify ClassicTM, MajesticTM, GenesisTM, or GeminiTM) 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 (specify Montage® standard picket space or Montage Pool, Pet & Play® 3" air space) Welded and Rakeable (ATF – All Terrain Flexibility) Ornamental Steel, (for standard picket space, specify ClassicTM, MajesticTM, GenesisTM, WarriorTM, CrescentTM; for 3" air-space specify ClassicTM, MajesticTM, GenesisTM, or GeminiTM) design, (specify extended picket or flush) bottom rail treatment, (specify 2-Rail or 3-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 (310 MPa) and a minimum zinc (hot-dip galvanized) coating weight of 0.60 oz/ft2 (184 g/m2), Coating Designation G-60. A minimum of 62% of the steel material shall be derived from scrap metal.

B. Material for pickets shall be 5/8" square x 18 Ga. tubing. The rails shall be steel channel, 1.25" x 0.925" x 14 Ga. Picket holes in the rail shall be spaced (specify 4.334" o.c. for standard picket space or 3.500" o.c. for 3" air space). Fence posts shall be a minimum of 2" square x 16 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 electrode position 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. Gates shall be fabricated using welded ornamental panel material and gate ends having a 1-1/4" square cross-sectional size. All rail and upright intersections shall be joined by welding. All picket and rail intersections shall also be joined by welding.

PART 3 - EXECUTION

3.01 P REPARATION

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 ½". 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. The "Earthwork" and "Concrete" sections of this specification shall govern material requirements for the concrete footer.

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.

Effective: 04-25-12

