

**AMERISTAR PERIMETER SECURITY**  
**Montage® Residential - Steel Ornamental Fence System – Fusion Welded**  
**CONSTRUCTION SPECIFICATION - SECTION 32 31 19**

**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 Rackable** (ATF – All Terrain Flexibility) Ornamental Steel, (for standard picket space, specify Classic™, Majestic™, Genesis™, Warrior™, Crescent™; for 3” air-space specify Classic™, Majestic™, Genesis™, or Gemini™) 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.

**1.08 PRODUCT WARRANTY**

**A.** All structural fence components (i.e. rails, pickets, and posts) shall be warranted within specified limitations, by the manufacturer as stated in the Montage product warranty. Warranty shall cover any defects in material finish, including cracking, peeling, chipping, blistering or corroding.

**B.** Reimbursement for labor necessary to restore or replace components that have been found to be defective under the terms of manufactures warranty shall be guaranteed for five (5) years from date of original purchase.

## 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 Rackable** (ATF – All Terrain Flexibility) Ornamental Steel, (for standard picket space, specify Classic™, Majestic™, Genesis™, Warrior™, Crescent™; for 3" air-space specify Classic™, Majestic™, Genesis™, or Gemini™) design, (specify extended picket or flush) bottom rail treatment, (specify 2-Rail or 3-Rail) style manufactured by Ameristar Perimeter Security USA 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/ft<sup>2</sup> (184 g/m<sup>2</sup>), Coating Designation G-60.
- B. Material for pickets shall be 5/8" square x 18 Ga. tubing. The rails shall be steel channel, 1.25" x 0.92" 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, 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 Residential 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 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. 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.

Table 1 – Minimum Sizes for Montage Gate Post

Gate Leaf	Gate Height	
	Up To & Including 4'	Over 4', Up To & Including 6'
Up To & Including 4'	2" x 16 Ga.	2" x 16 Ga.
Over 4'1", Up To & Including 6'	2" x 16 Ga.	2-1/2" x 16 Ga.
Over 6'1", Up To & Including 8'	2-1/2" x 16 Ga.	2-1/2" x 16 Ga.

Table 2 – Coating Performance Requirements

Quality Characteristics	ASTM Test Method	Performance Requirements
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 1,000 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).

Table 3 – Montage - Post Spacing By Bracket Type

Span	For CLASSIC, GENESIS, MAJESTIC, WARRIOR, CRESCENT, GEMINI 8' Nominal (94" Rail)			
	2"	2"	2"	2"
Post Size	2"	2"	2"	2"
Bracket Type	Montage Universal (BB102)	Montage Line Boulevard (BB104)	Montage Flat Mount (BB105)	Montage Swivel (BB106)
Post Settings ± 1/2" O.C.	96-3/4"	96-3/4"	96-3/4"	96-3/4"

\* Note: When using BB106 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.