AMERISTAR FENCE PRODUCTS
PERMACOAT® PC-40™ Color Chain Link Framework – Industrial Weight
CONSTRUCTION SPECIFICATION – 32 31 13

PART 1 – GENERAL

1.01 WORK INCLUDED

The contractor shall provide all labor, materials and appurtenances necessary for installation of the color chain link fencing system defined herein at **(specify project site)**.

1.02 RELATED WORK

Section 02500 – Paving and Surfacing
Section 03300 – Case-In-Place Concrete
Section 04200 – Unit Masonry

1.03 SYSTEM DESCRIPTION

The contractor shall supply a total color chain link fencing system of the design, style and strength defined herein. The system shall include all components (i.e., framework, chain link fabric, gates and fittings) 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

A. American Society for Testing and Materials (ASTM) Standards: A90/A90M - Test Method for Weight (Mass) of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings. A653/A653M - Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process. A924/A924M - Specification for General Requirements for Steel Sheet, Metallic-Coated by the Hot-Dip Process. B6 - Specification for Zinc. B117 - Practice for Operating Salt Spray (Fog) Apparatus. D1499 - Practice for Operating Light- and Water-Exposure Apparatus (Carbon-Arc Type) for Exposure of Plastics. D3359 - Test Methods for Measuring Adhesion by Tape Test. E8/E8M - Test Methods for Tension Testing of Metallic Materials. F567 - Practice for Installation of Chain-Link Fence. F626 - Specification for Fence Fittings. F668 - Specification for Poly (Vinyl Chloride) (PVC)-Coated Steel Chain-Link Fence Fabric. F900 - Specification for Industrial and Commercial Swing Gates. F934 - Specification for Standard Colors for Polymer-Coated Chain Link Fence Materials. F969 - Practice for Construction of Chain-Link Tennis Court Fence. F1043 - Specification for Strength and Protective Coatings on Metal Industrial Chain Link Fence Framework. F1184 - Specification for Industrial and Commercial Horizontal Slide Gates.

B. American Association of State Highway and Transportation Officials (AASHTO) Standards: M181 - Standard Specification for Chain-Link Fence.

C. United States Federal Supply Service General Services Administration Specifications: RR-F-191/3 - Federal Specification Sheet for Fencing, Wire and Post, Metal (Chain-Link Fence Posts, Top Rails and Braces) - Detail Specification.

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 damages 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

Framework for color chain link fence systems shall conform to Ameristar® PermaCoat® PC-40™ (industrial weight), as manufactured by Ameristar® Fence Products in Tulsa, Oklahoma.

2.02 MATERIAL – STEEL FRAMEWORK

A. The steel material used to manufacture Ameristar® PermaCoat® PC-40™ shall be zinc-coated steel strip, galvanized by the hot-dip process conforming to the criteria of ASTM A653/A653M and the general requirements of ASTM A924/A924M.

B. The zinc used in the galvanizing process shall conform to ASTM B6. Weight of zinc shall be determined using the test method described in ASTM A90 and shall conform to the weight range (external and internal) of ASTM F1043, Type B.

C. The framework shall be manufactured in accordance with commercial standards to meet the strength (50,000 psi minimum yield strength) and coating requirements of the following standards: 1.) ASTM F1043, Group IC, Electrical Resistance Welded Round Steel Pipe, heavy industrial weight. 2.) M181, Type I, Grade 2, Electrical Resistance Welded Steel Pipe. 3.) RR-F-191/3, Class 1, Grade B, Electrical Resistance Welded Steel Pipe.

D. The exterior surface of the electrical resistance weld shall be recoated with the same type of material and thickness as the basic zinc coating.

E. The manufactured framework shall be subjected to the PermaCoat® process, a complete thermal stratification coating process (multi-stage, high-temperature, multi-layer) including, as a minimum, a six-stage pretreatment/wash (with zinc phosphate), an electrostatic spray application of an epoxy base, and a separate electrostatic spray application of a polyester finish.

F. The material used for the base coat shall be a (gray color) thermosetting epoxy; the minimum thickness of the base coat shall be two (2) mils. The material used for the finish coat shall be a thermosetting "no-mar" TGIC polyester powder; the minimum thickness of the finish coat shall be two (2) mils. The stratification coated pipe shall demonstrate the ability to endure a salt-spray resistance test in accordance with ASTM B117 without loss of adhesion for a minimum exposure time of 3,500 hours. Additionally, the coated pipe shall demonstrate the ability to withstand exposure in a weather-ometer apparatus for 1,000 hours without failure in accordance with ASTM D1499 and to show satisfactory adhesion when subjected to the cross-hatch test, Method B, in ASTM D3359. The polyester finish coat shall not crack, blister or split under normal use.

G. The color of all framework shall be **(specify Black, Green or Brown)** in accordance with ASTM F934.

H. The strength of Ameristar® PermaCoat® PC-40™ shall conform to the requirements of ASTM F1043; the minimum weight shall not be less than 90% of the nominal weight (see Table 1). The strength of line, end, corner and pull posts shall be determined by the use of 4' or 6' cantilevered beam test. The top rail shall be determined by a 10' free-supported beam test (see Table 1). An alternative method of determining pipe strength is by the calculation of bending moment (see Table 1). Conformance with this specification can be demonstrated by measuring the yield strength of a randomly selected piece of pipe from each lot and calculating the section modulus. The yield strength shall be determined according to the methods described in ASTM E8. For materials under this specification, the 0.2 offset method shall be used in determining yield strength. Terminal posts, line posts and top/bottom rails shall be precut to specified lengths.

2.03MATERIAL – FENCE FABRIC

A. The material for chain link fence fabric shall be manufactured from galvanized steel wire. The weight of zinc shall meet the requirements of ASTM F668, Table 4. Galvanized wire shall be PVC-coated to meet the requirements of ASTM F668. The class of the fence fabric shall be **(specify Class 1 - Extruded, Class 2A - Extruded and Bonded or Class 2B - Fused and Bonded)**.

B. Selvage: Top edge **(specify knuckled or twisted)** and bottom edge **(specify knuckled or twisted)**.

C. Color: The coating color for the fence fabric shall be **(specify Black, Green or Brown)**. Reference ASTM F668 and ASTM F934.

D. Wire Size: The size of the steel wire core shall be **(specify gauge)** gauge. (See Table 2); the finished size of the coated wire shall be **(specify gauge)** gauge (See Table 2).

E. Height and Mesh Size: The fabric height shall be **(specify height)** feet high with a mesh size of **(specify mesh size)** inches. (See Table 2).

2.04 MATERIAL – FENCE FITTINGS

The material for fence fittings shall be manufactured to meet the requirements of ASTM F626. The color of all fittings and fasteners shall be **(specify Black, Green or Brown)** in accordance with ASTM F934. All fasteners shall be stainless steel.

2.05 MATERIAL – GATES

Swing gates shall be manufactured and coated to meet the requirements of ASTM F900. Slide gates shall be manufactured to meet the requirements of ASTM F1184. The color of all gates shall be **(specify Black, Green or Brown)** in accordance with ASTM F934.

PART 3 – EXECUTION

3.01 PREPARATION

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

3.02 INSTALLATION

Install chain link fence in accordance with ASTM F567. For chain link tennis court fences, install in accordance with ASTM F969. Fence posts shall be set at spacings of a maximum of 10' o.c. Gate posts shall be spaced according to the gate openings specified in the construction plans. The "Paving and Surfacing," "Cast-In-Place Concrete" and "Unit Masonry" sections of this specification shall govern post base placement and material requirements. Install fabric on security side and attach with wire ties or clip to line posts at 15 inches o.c. and to rails, braces and tension wire at 24 inches o.c.

3.03 CLEANING

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

TABLE 1

Fence Industry	Decimal O.D. Equivalent		Pipe Wall Thickness		Weight		Section Modulus Inches	x	Min. Yield Strength psi	=	Max. Bending Moment lb. in.	Calculated Load (lbs.)		
												10' Free Supported	Cantilever	
O.D.	Inches	(mm)	Inches	(mm)	lb./ft.	(kg/m)							4'	6'
1-5/8"	1.660	42.16	.111	2.82	1.84	2.74	.1961	x	50,000	=	9,805	327	204	136
2"	1.900	48.26	.120	3.05	2.28	3.39	.2810	x	50,000	=	14,050	468	293	195
2-1/2"	2.375	60.33	.130	3.30	3.12	4.64	.4881	x	50,000	=	24,405	814	508	339
3"	2.875	73.03	.160	4.06	4.64	6.90	.8778	x	50,000	=	43,890	1,463	914	610
4"	4.000	101.60	.160	4.06	6.56	9.76	1.7819	x	50,000	=	89,095	2,970	1,856	1,237

TABLE 2

Finished Gauge	Finished OD (NOM)	Core Diameter (NOM)	PVC Coating Thickness	Mesh Sizes Available	Fabric Extrusion Type	Minimum Breaking Strength
6	.192 (4.88 mm)	.148 (3.76 mm)	.015 - .025 (0.38 - 0.64 mm)	2 (50 mm); 1-3/4 (44 mm)	CLASS 2A	1290#
8	.162 (4.11 mm)	.120 (3.05 mm)	.015 - .025 (0.38 - 0.64 mm)	2 (50 mm); 1-3/4 (44 mm); 1 (25 mm)	CLASS 1, 2A	850#
9	.148 (3.76 mm)	.120 (3.05 mm)	.015 - .025 (0.38 - 0.64 mm)	2 (50 mm); 1-3/4 (44 mm); 1 (25 mm)	CLASS 1, 2A	850#