

Montage™ / Montage ATF™ Welded Ornamental Fence
CONSTRUCTION SPECIFICATION

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 the Montage™ / Montage ATF™ Welded Ornamental Steel (specify Classic™, Majestic™, Genesis™, or Warrior™) 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 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.

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™ / Montage ATF™ Welded Ornamental Steel (**specify Classic™, Majestic™, Genesis™ or Warrior™, Genesis™ with Quad-Flares, or Genesis™ with Triads**) design, (**specify extended picket or ?ush**) bottom rail treatment, (**specify rigid or all-terrain**) weld treatment, (**specify 2-Rail, 3-Rail or 3-Rail with Rings**) 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 50,000 psi (344 MPa) and a minimum zinc (hot-dip galvanized) coating weight of 0.90 oz/ft² (276 g/m²), Coating Designation G-60.
- B. Material for fence pickets shall be 5/8" square x 18 Ga. tubing. The rails shall be steel channel, (**specify rigid-Montage or all terrain - Montage ATF**) profile, 1.25" x 0.75" x 14 Ga. Picket holes in the rail shall be spaced 4.334" o.c. Posts shall be a minimum of 2" square x 16 Ga.

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 the AmeriCoat™ inline electrodeposition coating process consisting of a multi-stage pretreatment/wash (with zinc phosphate), followed by a duplex cathodic electrocoat application of an epoxy primer followed by 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, Bronze, White, or Desert Sand**). The coated panels and posts shall be capable of meeting the performance requirements for each quality characteristic shown in Table 1.
- D. 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 INSTALLATION

Fence posts shall be set with equal spacings of 96-3/4" o.c. , plus or minus 1/2". Fence panels shall be attached to posts with boulevard brackets supplied by the manufacturer. Gate posts shall be spaced according to the gate openings specified in the construction plans. The "Earthwork" and "Concrete" sections of this specification shall govern post base material requirements.

3.03 CLEANING

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

Table 1 – 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 & D1654	Corrosion Resistance over 3,500 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).



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