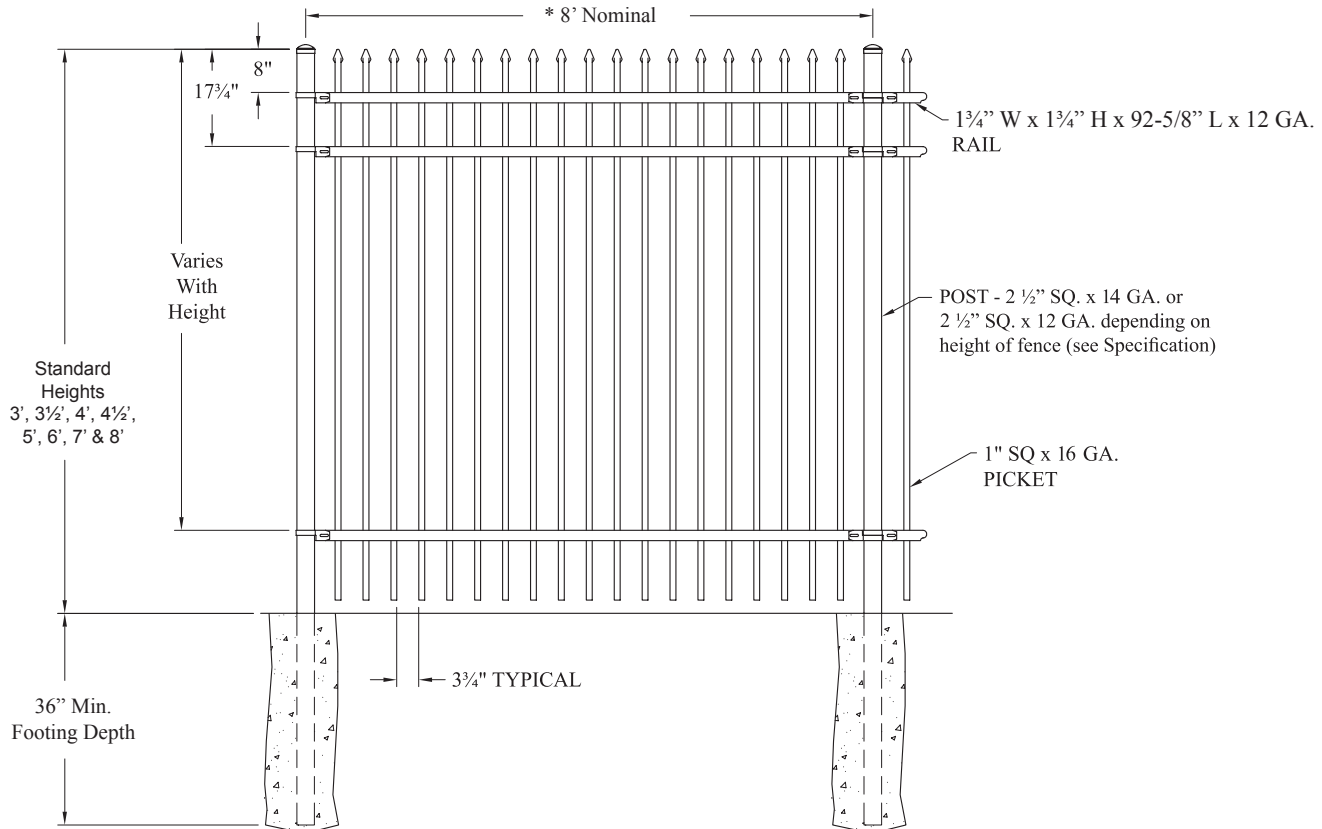


# MONTAGE INDUSTRIAL®

## WELDED INDUSTRIAL ORNAMENTAL FENCE

### TYPICAL PANEL DRAWING

(Classic Style shown; Genesis, Majestic & Invincible also available)



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

**E-COAT™  
PROTECTION**

**UNIQUE FUSION WELDING PROCESS**

PATENTS: #D466,620 #6,811,145 #7,071,439

**ATF®  
RAKABLE DESIGN**

PATENTS: #D466,620 #7,071,439



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



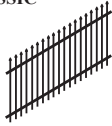
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PANELS**



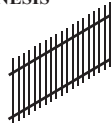
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**2-Rail (Standard)  
4" Air Gap**

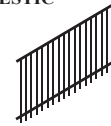
CLASSIC



GENESIS



MAJESTIC



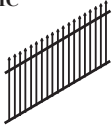
(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING STYLE/COLOR
3' H	2R <u>*</u> <u>X</u> 20348			71	N/A
3-1/2' H	2R <u>*</u> <u>X</u> 20408			77	N/A
4' H	2R <u>*</u> <u>X</u> 20468			85	N/A
5' H	2R <u>*</u> <u>X</u> 20588			99	N/A
6' H	2R <u>*</u> <u>X</u> 20708			113	N/A
7' H	2R <u>*</u> <u>X</u> 20828			127	N/A
8' H	2R <u>*</u> <u>X</u> 20948			141	N/A

**STYLE SELECTION =** \* **X = COLOR SELECTION**  
 MAJESTIC = M B = BLACK  
 CLASSIC = C N = BRONZE  
 GENESIS = G

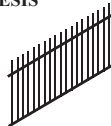
(8' Nominal) 92-5/8" Actual Panel Width  
1" Sq x 16 Ga. Picket = (19 - Pickets per Panel)

**2-Rail (Flush Bottom)  
4" Air Gap**

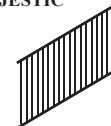
CLASSIC



GENESIS



MAJESTIC



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING STYLE/COLOR
3' H	2R <u>*</u> <u>X</u> 20348F			71	N/A
3-1/2' H	2R <u>*</u> <u>X</u> 20408F			77	N/A
4' H	2R <u>*</u> <u>X</u> 20468F			85	N/A
5' H	2R <u>*</u> <u>X</u> 20588F			99	N/A
6' H	2R <u>*</u> <u>X</u> 20708F			113	N/A
7' H	2R <u>*</u> <u>X</u> 20828F			127	N/A
8' H	2R <u>*</u> <u>X</u> 20948F			141	N/A

**STYLE SELECTION =** \* **X = COLOR SELECTION**  
 MAJESTIC = M B = BLACK  
 CLASSIC = C N = BRONZE  
 GENESIS = G

(8' Nominal) 92-5/8" Actual Panel Width  
1" Sq x 16 Ga. Picket = (19 - Pickets per Panel)

\* Genesis panels in both Black and Bronze are packaged with (Black) 1" Sq picket plugs.

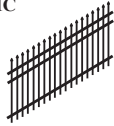
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PANELS**



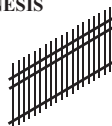
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**3-Rail (Standard)  
4" Air Gap**

CLASSIC



GENESIS



MAJESTIC



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING STYLE/COLOR
3-1/2' H	2R * <u>X</u> 30408			94	N/A
4' H	2R * <u>X</u> 30468			101	N/A
5' H	2R * <u>X</u> 30588			115	N/A
6' H	2R * <u>X</u> 30708			129	N/A
7' H	2R * <u>X</u> 30828			143	N/A
8' H	2R * <u>X</u> 30948			157	N/A

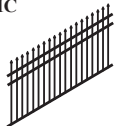
**STYLE SELECTION** = \* X = **COLOR SELECTION**

MAJESTIC = M B = BLACK  
CLASSIC = C N = BRONZE  
GENESIS = G

(8' Nominal) 92-5/8" Actual Panel Width  
1" Sq x 16 Ga. Picket = (19 - Pickets per Panel)

**3-Rail (Flush Bottom)  
4" Air Gap**

CLASSIC



GENESIS



MAJESTIC



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING STYLE/COLOR
3' H	2R * <u>X</u> 30348F			87	N/A
3-1/2' H	2R * <u>X</u> 30408F			94	N/A
4' H	2R * <u>X</u> 30468F			101	N/A
4-1/4' H	2R M <u>X</u> 30548F			109	N/A (ONLY AVAILABLE IN MAJ)
5' H	2R * <u>X</u> 30588F			115	N/A
6' H	2R * <u>X</u> 30708F			129	N/A
7' H	2R * <u>X</u> 30828F			143	N/A
8' H	2R * <u>X</u> 30948F			157	N/A

**STYLE SELECTION** = \* X = **COLOR SELECTION**

MAJESTIC = M B = BLACK  
CLASSIC = C N = BRONZE  
GENESIS = G

(8' Nominal) 92-5/8" Actual Panel Width  
1" Sq x 16 Ga. Picket = (19 - Pickets per Panel)

\* Genesis panels in both Black and Bronze are packaged with (Black) 1" Sq picket plugs.

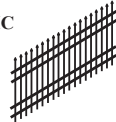
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PANELS**



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**4-Rail (Standard)  
4" Air Gap**

CLASSIC



GENESIS



MAJESTIC



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING STYLE/COLOR
6' H	2R * <u>X</u> 40708			144	N/A
7' H	2R * <u>X</u> 40828			158	N/A
8' H	2R * <u>X</u> 40948			172	N/A

**STYLE SELECTION = \* X = COLOR SELECTION**  
 MAJESTIC = M B = BLACK  
 CLASSIC = C N = BRONZE  
 GENESIS = G

(8' Nominal) 92-5/8" Actual Panel Width  
 1" Sq x 16 Ga. Picket = (19 - Pickets per Panel)

**4-Rail (Flush Bottom)  
4" Air Gap**

CLASSIC



GENESIS



MAJESTIC



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING STYLE/COLOR
6' H	2R * <u>X</u> 40708F			144	N/A
7' H	2R * <u>X</u> 40828F			158	N/A
8' H	2R * <u>X</u> 40948F			172	N/A

**STYLE SELECTION = \* X = COLOR SELECTION**  
 MAJESTIC = M B = BLACK  
 CLASSIC = C N = BRONZE  
 GENESIS = G

(8' Nominal) 92-5/8" Actual Panel Width  
 1" Sq x 16 Ga. Picket = (19 - Pickets per Panel)

\* Genesis panels in both Black and Bronze are packaged with (Black) 1" Sq picket plugs.

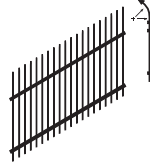
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**Invincible  
2-Rail (Standard)  
4" Air Gap**



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING COLOR
3' H	2R I <u>X</u> 20348			79	N/A
3-1/2' H	2R I <u>X</u> 20408			86	N/A
7' H	2R I <u>X</u> 20828			136	N/A
8' H	2R I <u>X</u> 20948			154	N/A

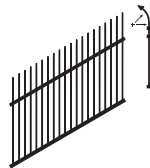
X = COLOR SELECTION

B = BLACK

N = BRONZE

(8' Nominal) 91-1/4" Actual Panel Width  
1" Sq x 16 Ga. Picket = (20 - Pickets per Panel)

**Invincible  
2-Rail (Flush Bottom)  
4" Air Gap**



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING COLOR
3' H	2R I <u>X</u> 20348F			79	N/A
3-1/2' H	2R I <u>X</u> 20408F			86	N/A
7' H	2R I <u>X</u> 20828F			136	N/A
8' H	2R I <u>X</u> 20948F			154	N/A

X = COLOR SELECTION

B = BLACK

N = BRONZE

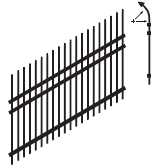
(8' Nominal) 91-1/4" Actual Panel Width  
1" Sq x 16 Ga. Picket = (20 - Pickets per Panel)

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**Invincible  
3-Rail (Standard)  
4" Air Gap**

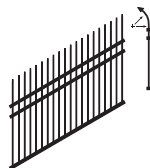


(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING COLOR
7' H	2R I <u>X</u> 30828			151	N/A
8' H	2R I <u>X</u> 30948			168	N/A

X = COLOR SELECTION  
B = BLACK  
N = BRONZE

(8' Nominal) 91-1/4" Actual Panel Width  
1" Sq x 16 Ga. Picket = (20 - Pickets per Panel)

**Invincible  
3-Rail (Flush Bottom)  
4" Air Gap**



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING COLOR
3-1/2' H	2R I <u>X</u> 30408F			101	N/A
7' H	2R I <u>X</u> 30828F			151	N/A
8' H	2R I <u>X</u> 30948F			168	N/A

X = COLOR SELECTION  
B = BLACK  
N = BRONZE

(8' Nominal) 91-1/4" Actual Panel Width  
1" Sq x 16 Ga. Picket = (20 - Pickets per Panel)

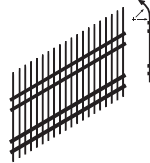
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**Invincible  
4-Rail (Standard)  
4" Air Gap**

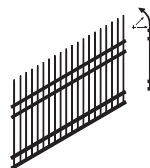


(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING COLOR
7' H	2R I <u>X</u> 40828			166	N/A
8' H	2R I <u>X</u> 40948			183	N/A

X = **COLOR SELECTION**  
B = BLACK  
N = BRONZE

(8' Nominal) 91-1/4" Actual Panel Width  
1" Sq x 16 Ga. Picket = (20 - Pickets per Panel)

**Invincible  
4-Rail (Flush Bottom)  
4" Air Gap**










(NOMINAL) PANEL HEIGHT	ITEM NUMBER	CATALOG PRICE (BLACK)	CATALOG PRICE (BRONZE)	PANEL WEIGHT	STOCKING COLOR
7' H	2R I <u>X</u> 40828F			166	N/A
8' H	2R I <u>X</u> 40948F			183	N/A

X = **COLOR SELECTION**  
B = BLACK  
N = BRONZE







(8' Nominal) 91-1/4" Actual Panel Width  
1" Sq x 16 Ga. Picket = (20 - Pickets per Panel)

## GATES





- \* All gates will be Montage II.  
Consult MONTAGE II  
Section for details.**

ITEM DESCRIPTION	BLACK		BRONZE		SIZE	BAG QTY	BOX QTY	WT EA.
	PART NO.	PRICE	PART NO.	PRICE				
<b>Industrial Universal Boulevard Bracket (Not For Invincible)</b>    BB302 fits 2-1/2" BB303 fits 3"	BB302		BN302		2-1/2"	2	80	.46
	BB303		BN303		3"	2	60	.53
Made from high strength stainless steel. Packaged in polybag with #14 x 3/4" stainless steel self-drilling screws, 1/4" x 2" stainless steel one-way security bolts and 1/4" stainless steel tee nuts. <b>MUST BE ORDERED IN BAG QUANTITIES.</b> Mounts on 2-1/2" and 3" square post. Works universally for lines, ends and corners. <div style="display: flex; justify-content: space-around; align-items: center; margin-top: 10px;"> <span>LINE </span> <span>END </span> <span>CORNER </span> </div>								
<b>Industrial Line Bracket (For Invincible only)</b>    BB319 fits 2-1/2" BB320 fits 3"	BB319		BN319		2-1/2"	2	24	1.2
	BB320		BN320		3"	2	24	1.2
Used as boulevard bracket around a post to join two adjacent panels in line. Packaged 2 per bag with stainless steel #14 x 3/4" self-drilling screws, stainless steel 1/4" x 1-3/4" one-way bolts and stainless steel 1/4" tee nuts. <b>MUST BE ORDERED IN BAG QUANTITIES.</b>								
<b>Industrial Flat Mount Bracket</b>  	BB301		BN301		----	2	100	.42
	Packaged 2 pieces per polybag with #14 x 3/4" self-drilling screws, 1/4" x 2" one-way security bolts, 1/4" tee nuts. Fasteners and brackets are stainless steel. <b>MUST BE ORDERED IN BAG QUANTITIES.</b> NOTE: If used with Invincible style panels, will require drilling thru rail and end picket.							
<b>Industrial Swivel Bracket</b>  	BB304		BN304		----	2	80	1.00
	Made from high strength stainless steel. Packaged 2 sets per polybag with 2 ea. 5/16" x 3-1/2" carriage bolts, (for 2-1/2" posts) 2 ea. 5/16" x 4" carriage bolts (for 3" posts), 2 ea. 5/16" flange nuts, 2 ea. 1/4" x 2" one-one security bolts, and 2 ea. 1/4" tee nuts. All fasteners are stainless steel. <b>MUST BE ORDERED IN BAG QUANTITIES. * (NOTE: CAUTION THIS BRACKET INCREASES POST SPACING).</b>							

**FASTENERS**

ITEM DESCRIPTION	PART NUMBER		PRICE	SIZE	BAG QTY	WT
	BLACK	BRONZE				
<b>One-Way Bolts</b>  	7150BP-20	7150NP-20		1/4" x 2"	20	.8
Stainless steel washered one-way bolts for industrial brackets.						
<b>Tee Nuts</b>  	7157BP-20	7157NP-20		1/4"	20	.3
Stainless steel tee nuts for industrial brackets.						
<b>Self-Drilling Screws</b>  	HB524P-50	HN524P-50		#14 x 3/4"	50	.6
Stainless steel hex head self-drilling screws for industrial brackets.						
<b>Drive Rivets</b>  	HB558P	HN558P		1/4"	1	.002
Drive rivets for flat mount bracket.						
<b>Flange Nuts</b>  	HB300P	HN300P		5/16"	1	.013
Stainless steel flange nuts for industrial swivel bracket.						
<b>Carriage Bolts</b>  	HB302P	HN302P		5/16" x 3-1/2"	1	.082
	HB303P	HN303P		5/16" x 4"	1	.090
Stainless steel carriage bolts for industrial swivel bracket.						





**ADORNMENTS**

ITEM DESCRIPTION	BLACK		BRONZE		SIZE	BOX QTY	WT EA.
	PART NO.	PRICE	PART NO.	PRICE			
<b>Quad-Flares</b>    Narrow Side      Wide Side Top View	AB512		AN512		1"	19	.5
Fits atop 1" square pickets. Heavy-duty cast aluminum (6" tall). The four sided flare design adds the popular traditional look to the "Genesis™" fence style.							
<b>Triads</b>  	AB514		AN514		1"	19	.5
Fits atop 1" square pickets. Heavy-duty cast aluminum (6" tall). These distinct tips reflect the strong look of a barbed spear.							
<b>Picket Plug</b>  	8450P-20		---		1"	20/Bag	.06

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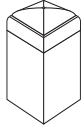
ITEM DESCRIPTION	BLACK		BRONZE		WT EA.
	PART NO.	PRICE	PART NO.	PRICE	
<b>Paint Pen</b> 	<b>PB100</b>		<b>PN100</b>		<b>.5</b>
Custom finishes in both Montage Industrial fencing colors.					
<b>Zinc-Rich Paint Pen</b> 					<b>.5</b>
Priming required for cut steel edges prior to application of Ameristar Custom Finishes. <b>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.</b>					
<b>Spray Paint</b> 	<b>FB100</b>		<b>FN100</b>		<b>1.1</b>
Custom finishes in both Montage Industrial fencing colors.					
<b>Zinc-Rich Spray Primer</b> 		<b>FZ100</b>			<b>1.1</b>
Priming required for cut steel edges prior to application of Ameristar Custom Finishes. <b>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.</b>					

**SCREW REMOVER**

ITEM DESCRIPTION	PART NUMBER	PRICE EA.	BOX QTY.	WT. EA.
<b>One-Way Screw Remover</b>	<b>88246P</b>		<b>1</b>	<b>.10</b>
Removes security fastener.				



**STEEL ORNAMENTAL SQUARE POST**



**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.

**X** = COLOR SELECTION  
 B = BLACK  
 N = BRONZE  
 W = WHITE  
 S = SAND

Post Diameter	Ga. / Wall Thickness	Post Length	Item Number	Catalog Price (Black)	Catalog Price (Color)	Post Weight	
2-1/2" SQ. (STEEL)	14 GA. (COMMERCIAL)	8'	WP <u>X</u> 25096-14			20	
		9'	WP <u>X</u> 25108-14			23	
		10'	WP <u>X</u> 25120-14			25	
		11'	WP <u>X</u> 25132-14			27	
	12 GA. (INDUSTRIAL)	5'	P <u>X</u> 25060			16	
		6'	P <u>X</u> 25072			19	
		7'	P <u>X</u> 25084			22	
		8'	P <u>X</u> 25096			26	
		9'	P <u>X</u> 25108			28	
		10'	P <u>X</u> 25120			31	
		11'	P <u>X</u> 25132			35	
		12'	P <u>X</u> 25144			36	
	3" SQ. (STEEL)	12 GA. (INDUSTRIAL)	5'	P <u>X</u> 30060			20
			6'	P <u>X</u> 30072			24
7'			P <u>X</u> 30084			30	
8'			P <u>X</u> 30096			34	
9'			P <u>X</u> 30108			39	
10'			P <u>X</u> 30120			43	
11'			P <u>X</u> 30132			47	
12'			P <u>X</u> 30144			51	



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**STEEL PLATED ORNAMENTAL SQUARE POST**

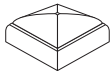

Note: Plated posts used with Majestic & Conqueror styles may require a post length 1" longer than the panel/gate height dependent on the grade elevation.

**X** = COLOR SELECTION  
B = BLACK  
N = BRONZE  
W = WHITE  
S = SAND

Post Diameter	GA. / Plate Size	Post Length	Item Number	Catalog Price (Black)	Catalog Price (Color)	Post Weight
2-1/2" SQ. (STEEL)	12 GA. 5" x 5" SQ. 1/4" Thick with 9/16" Holes (8833G)	4'	P <u>X</u> 25048P			16
		5'	P <u>X</u> 25060P			19
		6'	P <u>X</u> 25072P			22
		7'	P <u>X</u> 25084P			26
		8'	P <u>X</u> 25096P			28
3" SQ. (STEEL)	12 GA. 6" x 6" SQ. 1/4" Thick with 9/16" Holes (5003G)	4'	P <u>X</u> 30048P			20
		5'	P <u>X</u> 30060P			24
		6'	P <u>X</u> 30072P			30
		7'	P <u>X</u> 30084P			34
		8'	P <u>X</u> 30096P			39

**POST CAPS**

**X** = COLOR SELECTION  
B = BLACK  
N = BRONZE  
W = WHITE  
S = SAND

Cap Type	Cap Style	Size	Item Number	Catalog Price (Black)	Catalog Price (Color)	Cap Weight
STEEL 	STANDARD FLAT CAP	2-1/2" SQ.	A <u>X</u> 507			0.3
		3" SQ.	A <u>X</u> 508			0.3
ALUMINUM 	BALL CAP	2-1/2" SQ.	A <u>X</u> 513			0.7
		3" SQ.	A <u>X</u> 516			0.8

**AMERISTAR FENCE PRODUCTS**

**Montage Industrial® - Steel Ornamental Fence System - Fusion Welded and Rakable  
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 Rakeable (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 Rakeable (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 manufacturer's 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.

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

Table 1 – Minimum Sizes for Montage Industrial Posts			
Fence Posts		Panel Height	
2-1/2" x 14 Ga.		Up to & Including 6' Height	
2-1/2" x 12 Ga.		Over 6' Up to & Including 8' Height	
Gate Leaf	Gate Height		
	Up to & Including 4'	Over 4' Up to & Including 6'	Over 6' Up to & Including 8'
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"

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 Industrial – Post Spacing By Bracket Type										
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.										

## MONTAGE INDUSTRIAL® / WARRANTY WELDED ORNAMENTAL FENCE

Ameristar's Montage Industrial® welded ornamental fences are manufactured from the highest quality materials by skilled craftsmen to meet the highest standards of workmanship in the industry. Galvanized steel framework is subjected to a multi-stage pretreatment/wash (with zinc phosphate), followed by a duplex cathodic electro-coat system consisting of an epoxy primer, which significantly increases corrosion protection, and an acrylic liquid topcoat, which provides the protection necessary to withstand adverse weathering effects.

The electro-coated surface on all Montage Industrial welded ornamental panels and posts, are guaranteed under normal and intended usage, against cracking, peeling, chipping, blistering or corroding commencing with the original purchase date and extending according to the applications defined in the table below. Normal and intended usage does not include physical damage, abrasion, or heavy salt spray exposure to the protective coating.

The following acts and/or omissions will void the subject warranty:

- Damage to the product caused by the property owner by use of landscape, gardening equipment, chemicals that may cause damage, and/or water sprinklers with high mineral content;
- Damage caused by adhesion of chicken wire, chain link mesh, welded wire, or other similar substance to the product;
- Damage caused by allowing plant life of any sort to grow directly upon or in contact with any portion of the product or sap from trees;
- Any alteration to the product itself by the property owner including any on-site cutting or welding; and/or, failure to follow any and all maintenance instructions provided by Ameristar at the time of sale to the original purchaser even if these instructions are not forwarded to the ultimate claimant under this warranty.
- When cutting Montage Industrial immediately seal the exposed surfaces by 1) Removing all metal shavings from the cut area 2) Applying zinc-rich primer to thoroughly cover cut edge and drilled hole and, after letting dry 3) Applying two (2) coats of custom finish spray paint matching fence color. Failure to seal exposed surfaces per steps 1-3 above will negate warranty.
- If contractor uses non-Ameristar parts/components this will negate the warranty.

Ameristar Montage Industrial welded ornamental fences are also guaranteed for the same period of time against defects in workmanship or materials. Should any Montage Industrial welded ornamental panel or post manufactured by Ameristar fail in accordance with any of the above conditions, Ameristar warrants to the original purchaser their redemption through replacement, renewal or issuance of a pro-rated credit. The choice of redemption method is solely at the discretion of Ameristar. If the pro-rated alternative is chosen, the amount will be based on the original cost of materials at the date of purchase multiplied by the appropriate time and exposure factor from the table below:

<u>Application</u>	<u>Length of Warranty</u>
Fence Installations 0 to 1 Mile from Salt Water Coast Line	5 Years
Fence Installations 1 Mile to 10 Miles from Salt Water Coast Line	10 Years
Fence Installations Over 10 Miles from Salt Water Coast Line	20 Years

Note: Regardless of location and years in service, evidence of historical salt spray exposure shall be considered as grounds to void any warranty obligations.

Notice of failure under the conditions of this warranty shall be sent to Ameristar or its authorized representative, in writing, together with proof of purchase and shall specify the nature of the defect and when it was first observed as well as photographs of current site conditions. Should the fence be improperly installed, Ameristar shall not be responsible for guaranteed performance or appearance of the material. Neither does this guarantee apply when failure or damage is due to improper use or application, abuse or misuse, salt spray exposure (see Table and Note above), vandalism, or acts of God. Ameristar reserves the right to inspect the material to determine validity of the claim.

Upon acceptance of the claim by Ameristar or its authorized representative, redemption by replacement, renewal or issuance of a pro-rated credit shall be made by Ameristar. Reimbursement for the cost of removal of existing material and the freight and installation of replacement material is not included in the guarantee, nor will Ameristar provide those services.

The above constitutes the complete warranty by the manufacturer. No other agreement, written or implied, is valid. Ameristar Fence Products does not authorize any other person or agent to make any other express warranties. Ameristar neither assumes nor authorizes any other person or agent to assume any other liability in connection with the Montage Industrial welded ornamental fence system.



**AMERISTAR®  
FENCE PRODUCTS**

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