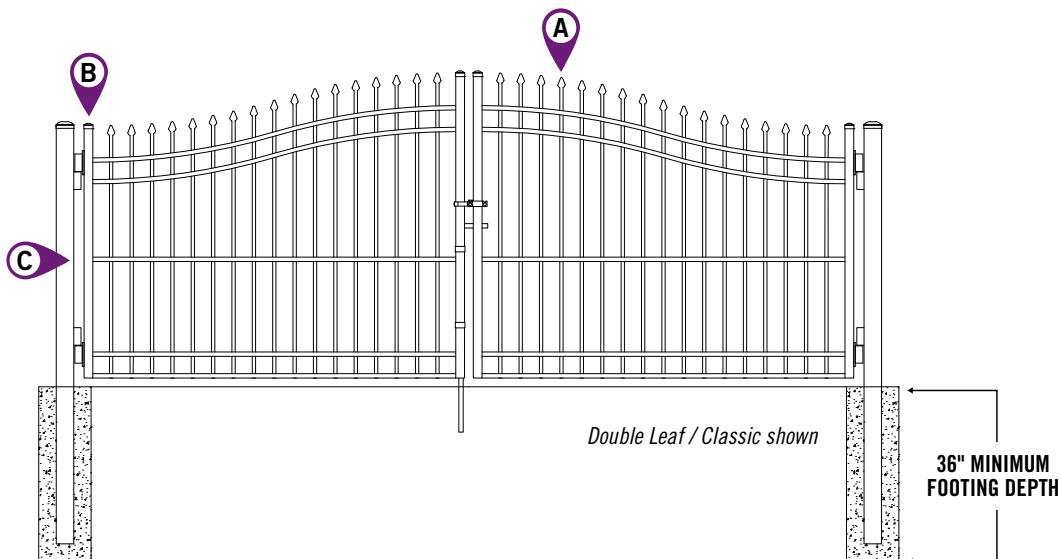


ESTATE®

FLUSH BOTTOM | SINGLE & DOUBLE SWING OPTIONS



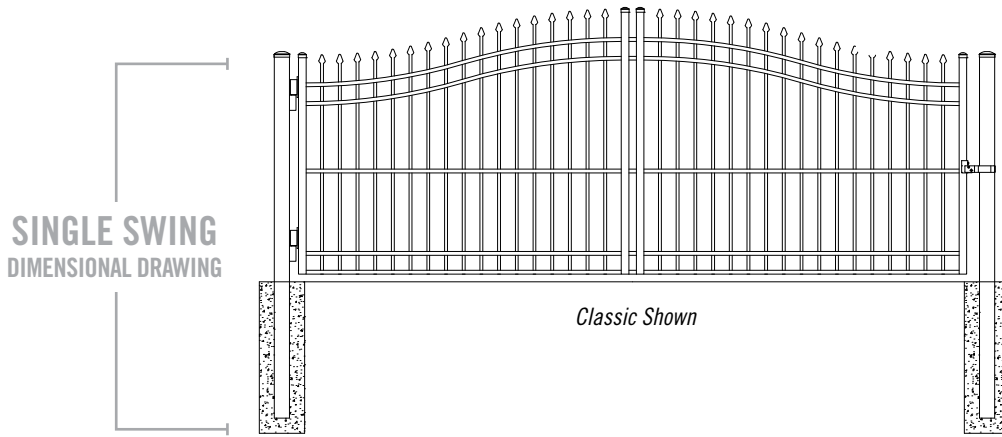
- Ⓐ .75"sq x .125" wall PICKETS
- Ⓑ 2"sq x .250" wall GATE ENDS
- Ⓒ 1" x 2" x .250" wall CHANNEL RAILS

*Refer to construction specification & tables
within this section for product details*

Effective: 01/01/18

ESTATE® | SINGLE SWING GATE SPECIFICATIONS

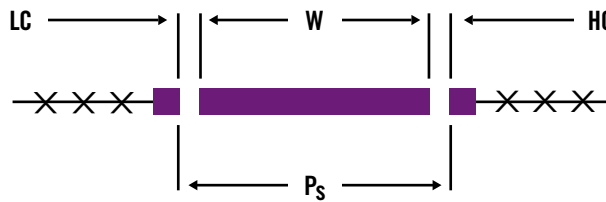
2"sq x .25" wall GATE ENDS | 1" x 2" x .25" wall CHANNEL RAILS | .75"sq x .125" PICKETS | 8' - 14' NOMINAL OPENINGS



SINGLE SWING
HARDWARE KITS & POST
INTERSPACES

OPENING	LEAF WIDTH*	EGBSX25 / EGBSX3 FORK LATCH / BOX HINGE KITS			HGBS-25 HGBS-3 / HGBS-4 HEAVY COMMERCIAL HINGE KITS			IGBS-25 IGBS-3 / IGBS-4 INDUSTRIAL STRONG ARM HINGE KITS		
		HC	LC	P _s	HC	LC	P _s	HC	LC	P _s
8'	102"	2.375"	2"	106.375"	1.25"	3"	106.25"	1.5"	3"	106.5"
10'	120.5"	2.375"	2"	124.875"	1.25"	3"	124.75"	1.5"	3"	125"
12'	139.25"	2.375"	2"	143.625"	1.25"	3"	143.5"	1.5"	3"	143.75"
14'	176.75"	2.375"	2"	181.125"	1.25"	3"	181"	1.5"	3"	181.25"

W = width* | HC = hinge clearance | LC = latch clearance | P_s = gate post spacing**
* From outside to outside | ** From inside to inside



Effective: 01/01/18

ESTATE® | DOUBLE SWING GATE SPECIFICATIONS

2"sq x .25" wall GATE ENDS | 1" x 2" x .25" wall CHANNEL RAILS | .75"sq x .125" PICKETS | 8' - 28' NOMINAL OPENINGS

DOUBLE SWING
DIMENSIONAL DRAWING



EGBDX
FORK LATCH / BOX
HINGE KITS

HGBD
STRONG ARM
COMMERCIAL HINGE

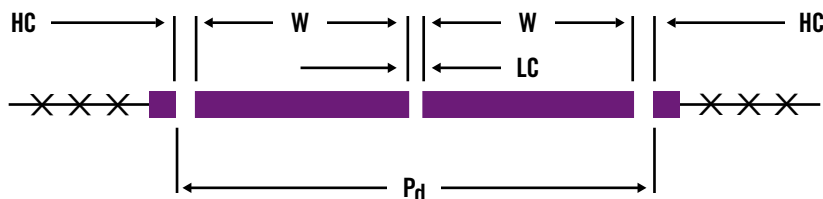
DOUBLE SWING
HARDWARE KITS & POST
INTERSPACES

OPENING	LEAF WIDTH*	HC	LC	P _d	HC	LC	P _d
8'	50"	2.375"	2"	106.75"	1.25"	2"	104.5"
10'	59.25"	2.375"	2"	125.25"	1.25"	2"	123"
12'	68.5"	2.375"	2"	143.75"	1.25"	2"	141.5"
14'	87.25"	2.375"	2"	181.25"	1.25"	2"	179"
16'	96.75"	2.375"	2"	200.25"	1.25"	2"	198"
18'	106"	2.375"	2"	218.75"	1.25"	2"	216.5"
20'	115.25"	2.375"	2"	237.25"	1.25"	2"	235"
22'	134"	2.375"	2"	274.75"	1.25"	2"	272.5"
24'	143.5"	2.375"	2"	293.75"	1.25"	2"	291.5"
26'	152.75"	2.375"	2"	312.25"	1.25"	2"	310"
28'	171.5"	2.375"	2"	349.75"	1.25"	2"	347.5"

W = width* | HC = hinge clearance (x2) | LC = latch clearance

P_d = gate post spacing**

* From outside to outside | ** From inside to inside



Effective: 01/01/18

ESTATE® | 5-RAIL SINGLE SWING GATES

GENESIS STYLE REQUIRES NO PICKET PLUGS

4'-5'
HEIGHTS

OPENING	LENGTH	ITEM NUMBER	PICKET QTY	WEIGHT	PICKET QTY
8'	102"	E☒Ⓞ548-96F	18	121 lbs	18
10'	120.5"	E☒Ⓞ548-120F	22	139 lbs	22
12'	139.25"	E☒Ⓞ548-144F	26	157 lbs	26
14'	176.75"	E☒Ⓞ548-168F	34	192 lbs	34

5'-6'
HEIGHTS

8'	102"	E☒Ⓞ560-96F	18	139 lbs	18
10'	120.5"	E☒Ⓞ560-120F	22	159 lbs	22
12'	139.25"	E☒Ⓞ560-144F	26	178 lbs	26
14'	176.75"	E☒Ⓞ560-168F	34	218 lbs	34

6'-7'
HEIGHTS

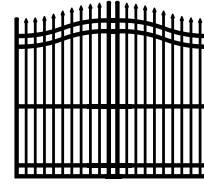
8'	102"	E☒Ⓞ572-96F	18	156 lbs	18
10'	120.5"	E☒Ⓞ572-120F	22	178 lbs	22
12'	139.25"	E☒Ⓞ572-144F	26	200 lbs	26
14'	176.75"	E☒Ⓞ572-168F	34	244 lbs	34

7'-8'
HEIGHTS

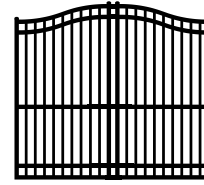
8'	102"	E☒Ⓞ584-96F	18	173 lbs	18
10'	120.5"	E☒Ⓞ584-120F	22	197 lbs	22
12'	139.25"	E☒Ⓞ584-144F	26	222 lbs	26
14'	176.75"	E☒Ⓞ584-168F	34	269 lbs	34

☒ = FENCE STYLES AVAILABLE | C = Classic M = Majestic G = Genesis W = Warrior

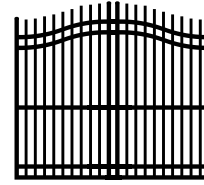
Ⓞ = COLOR OPTIONS AVAILABLE | B = Black N = Bronze W = White S = Sand



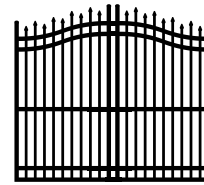
CLASSIC™



MAJESTIC™



GENESIS™



WARRIOR™

Effective: 01/01/18

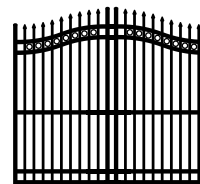
ESTATE® | 5-RAIL SINGLE SWING GATES WITH RINGS

GENESIS STYLE REQUIRES NO PICKET PLUGS

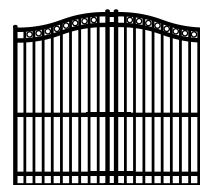
	OPENING	LENGTH	ITEM NUMBER	PICKET QTY	WEIGHT	PICKET QTY
4'-5' HEIGHTS	8'	102"	E☒☉548-96FR	18	131 lbs	18
	10'	120.5"	E☒☉548-120FR	22	151 lbs	22
	12'	139.25"	E☒☉548-144FR	26	171 lbs	26
5'-6' HEIGHTS	14'	176.75"	E☒☉548-168FR	34	210 lbs	34
	8'	102"	E☒☉560-96FR	18	149 lbs	18
	10'	120.5"	E☒☉560-120FR	22	171 lbs	22
6'-7' HEIGHTS	12'	139.25"	E☒☉560-144FR	26	192 lbs	26
	14'	176.75"	E☒☉560-168FR	34	236 lbs	34
	8'	102"	E☒☉572-96FR	18	166 lbs	18
7'-8' HEIGHTS	10'	120.5"	E☒☉572-120FR	22	190 lbs	22
	12'	139.25"	E☒☉572-144FR	26	214 lbs	26
	14'	176.75"	E☒☉572-168FR	34	264 lbs	34
	8'	102"	E☒☉584-96FR	18	183 lbs	18
	10'	120.5"	E☒☉584-120FR	22	209 lbs	22
	12'	139.25"	E☒☉584-144FR	26	239 lbs	26
	14'	176.75"	E☒☉584-168FR	34	289 lbs	34

☒ = FENCE STYLES AVAILABLE | C = Classic M = Majestic G = Genesis W = Warrior

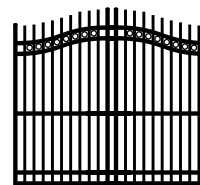
☉ = COLOR OPTIONS AVAILABLE | B = Black N = Bronze W = White S = Sand



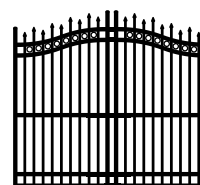
CLASSIC™



MAJESTIC™



GENESIS™



WARRIOR™

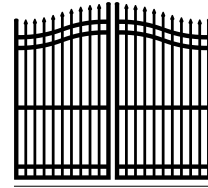
Effective: 01/01/18

ESTATE® | 5-RAIL DOUBLE SWING GATES

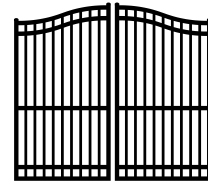
GENESIS STYLE REQUIRES NO PICKET PLUGS

	OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4'-5' HEIGHTS	8'	50"	Eⓧⓧ548-96FHD	126 lbs	18
	10'	59.25"	Eⓧⓧ548-120FHD	144 lbs	22
	12'	68.5"	Eⓧⓧ548-144FHD	162 lbs	26
	14'	87.25"	Eⓧⓧ548-168FHD	198 lbs	34
	16'	96.75"	Eⓧⓧ548-192FHD	216 lbs	38
	18'	106"	Eⓧⓧ548-216FHD	234 lbs	42
	20'	115.25"	Eⓧⓧ548-240FHD	252 lbs	46
	22'	134"	Eⓧⓧ548-264FHD	288 lbs	54
	24'	143.5"	Eⓧⓧ548-288FHD	306 lbs	58
	26'	152.75"	Eⓧⓧ548-312FHD	324 lbs	62
5'-6' HEIGHTS	28'	171.5"	Eⓧⓧ548-336FHD	344 lbs	70
	8'	50"	Eⓧⓧ560-96FHD	142 lbs	18
	10'	59.25"	Eⓧⓧ560-120FHD	162 lbs	22
	12'	68.5"	Eⓧⓧ560-144FHD	184 lbs	26
	14'	87.25"	Eⓧⓧ560-168FHD	224 lbs	34
	16'	96.75"	Eⓧⓧ560-192FHD	244 lbs	38
	18'	106"	Eⓧⓧ560-216FHD	264 lbs	42
	20'	115.25"	Eⓧⓧ560-240FHD	284 lbs	46
	22'	134"	Eⓧⓧ560-264FHD	324 lbs	54
	24'	143.5"	Eⓧⓧ560-288FHD	344 lbs	58
6'-7' HEIGHTS	26'	152.75"	Eⓧⓧ560-312FHD	364 lbs	62
	28'	171.5"	Eⓧⓧ560-336FHD	386 lbs	70
	8'	50"	Eⓧⓧ572-96FHD	160 lbs	18
	10'	59.25"	Eⓧⓧ572-120FHD	182 lbs	22
	12'	68.5"	Eⓧⓧ572-144FHD	204 lbs	26
	14'	87.25"	Eⓧⓧ572-168FHD	250 lbs	34
	16'	96.75"	Eⓧⓧ572-192FHD	272 lbs	38
	18'	106"	Eⓧⓧ572-216FHD	294 lbs	42
	20'	115.25"	Eⓧⓧ572-240FHD	316 lbs	46
	22'	134"	Eⓧⓧ572-264FHD	360 lbs	54
24'	143.5"	Eⓧⓧ572-288FHD	382 lbs	58	
26'	152.75"	Eⓧⓧ572-312FHD	404 lbs	62	
28'	171.5"	Eⓧⓧ572-336FHD	428 lbs	70	

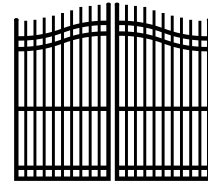
7' - 8' HEIGHTS ON NEXT PAGE



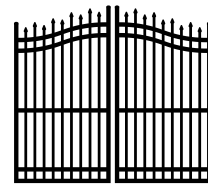
CLASSIC™



MAJESTIC™



GENESIS™



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Effective: 01/01/18

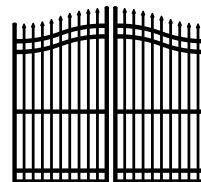
ESTATE® | 5-RAIL DOUBLE SWING GATES

GENESIS STYLE REQUIRES NO PICKET PLUGS

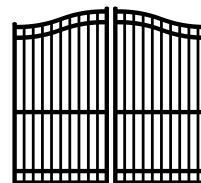
OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
8'	50"	E☒ⓧ584-96FHD	178 lbs	18
10'	59.25"	E☒ⓧ584-120FHD	202 lbs	22
12'	68.5"	E☒ⓧ584-144FHD	226 lbs	26
14'	87.25"	E☒ⓧ584-168FHD	276 lbs	34
16'	96.75"	E☒ⓧ584-192FHD	300 lbs	38
18'	106"	E☒ⓧ584-216FHD	324 lbs	42
20'	115.25"	E☒ⓧ584-240FHD	348 lbs	46
22'	134"	E☒ⓧ584-264FHD	396 lbs	54
24'	143.5"	E☒ⓧ584-288FHD	422 lbs	58
26'	152.75"	E☒ⓧ584-312FHD	446 lbs	62
28'	171.5"	E☒ⓧ584-336FHD	472 lbs	70

7'-8'
HEIGHTS

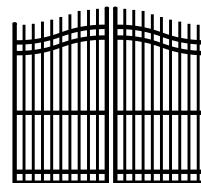
☒ = FENCE STYLES AVAILABLE | C = Classic M = Majestic G = Genesis W = Warrior
 ⓧ = COLOR OPTIONS AVAILABLE | B = Black N = Bronze W = White S = Sand



CLASSIC™



MAJESTIC™



GENESIS™



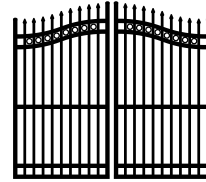
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Effective: 01/01/18

ESTATE® | 5-RAIL DOUBLE SWING GATES WITH RINGS

GENESIS STYLE REQUIRES NO PICKET PLUGS

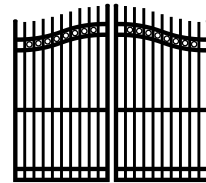
	OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4'-5' HEIGHTS	8'	50"	Eⓧⓧ548-96FHRD	136 lbs	18
	10'	59.25"	Eⓧⓧ548-120FHRD	156 lbs	22
	12'	68.5"	Eⓧⓧ548-144FHRD	176 lbs	26
	14'	87.25"	Eⓧⓧ548-168FHRD	216 lbs	34
	16'	96.75"	Eⓧⓧ548-192FHRD	236 lbs	38
	18'	106"	Eⓧⓧ548-216FHRD	256 lbs	42
	20'	115.25"	Eⓧⓧ548-240FHRD	276 lbs	46
	22'	134"	Eⓧⓧ548-264FHRD	316 lbs	54
	24'	143.5"	Eⓧⓧ548-288FHRD	336 lbs	58
	26'	152.75"	Eⓧⓧ548-312FHRD	356 lbs	62
5'-6' HEIGHTS	28'	171.5"	Eⓧⓧ548-336FHRD	378 lbs	70
	8'	50"	Eⓧⓧ560-96FHRD	152 lbs	18
	10'	59.25"	Eⓧⓧ560-120FHRD	174 lbs	22
	12'	68.5"	Eⓧⓧ560-144FHRD	198 lbs	26
	14'	87.25"	Eⓧⓧ560-168FHRD	242 lbs	34
	16'	96.75"	Eⓧⓧ560-192FHRD	264 lbs	38
	18'	106"	Eⓧⓧ560-216FHRD	286 lbs	42
	20'	115.25"	Eⓧⓧ560-240FHRD	308 lbs	46
	22'	134"	Eⓧⓧ560-264FHRD	352 lbs	54
	24'	143.5"	Eⓧⓧ560-288FHRD	374 lbs	58
6'-7' HEIGHTS	26'	152.75"	Eⓧⓧ560-312FHRD	396 lbs	62
	28'	171.5"	Eⓧⓧ560-336FHRD	420 lbs	70
	8'	50"	Eⓧⓧ572-96FHRD	172 lbs	18
	10'	59.25"	Eⓧⓧ572-120FHRD	184 lbs	22
	12'	68.5"	Eⓧⓧ572-144FHRD	218 lbs	26
	14'	87.25"	Eⓧⓧ572-168FHRD	268 lbs	34
	16'	96.75"	Eⓧⓧ572-192FHRD	292 lbs	38
	18'	106"	Eⓧⓧ572-216FHRD	316 lbs	42
	20'	115.25"	Eⓧⓧ572-240FHRD	340 lbs	46
	22'	134"	Eⓧⓧ572-264FHRD	388 lbs	54
24'	143.5"	Eⓧⓧ572-288FHRD	412 lbs	58	
26'	152.75"	Eⓧⓧ572-312FHRD	436 lbs	62	
28'	171.5"	Eⓧⓧ572-336FHRD	462 lbs	70	



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7' - 8' HEIGHTS ON NEXT PAGE

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ESTATE® | 5-RAIL DOUBLE SWING GATES WITH RINGS

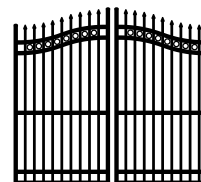
GENESIS STYLE REQUIRES NO PICKET PLUGS

OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
8'	50"	E ☒ ⊗ 584-96FHRD	188 lbs	18
10'	59.25"	E ☒ ⊗ 584-120FHRD	204 lbs	22
12'	68.5"	E ☒ ⊗ 584-144FHRD	244 lbs	26
14'	87.25"	E ☒ ⊗ 584-168FHRD	294 lbs	34
16'	96.75"	E ☒ ⊗ 584-192FHRD	320 lbs	38
18'	106"	E ☒ ⊗ 584-216FHRD	346 lbs	42
20'	115.25"	E ☒ ⊗ 584-240FHRD	372 lbs	46
22'	134"	E ☒ ⊗ 584-264FHRD	424 lbs	54
24'	143.5"	E ☒ ⊗ 584-288FHRD	452 lbs	58
26'	152.75"	E ☒ ⊗ 584-312FHRD	478 lbs	62
28'	171.5"	E ☒ ⊗ 584-336FHRD	506 lbs	70

7'-8'
HEIGHTS

☒ = FENCE STYLES AVAILABLE | **C** = Classic **M** = Majestic **G** = Genesis **W** = Warrior

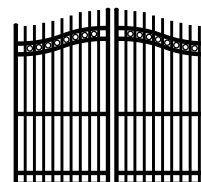
⊗ = COLOR OPTIONS AVAILABLE | **B** = Black **N** = Bronze **W** = White **S** = Sand



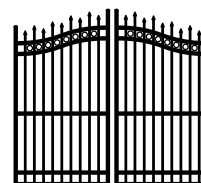
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WARRIOR™

Effective: 01/01/18

ESTATE® | FINIALS & ADORNMENTS

FINIALS FOR GENESIS PANELS ONLY



QUAD FLARE

.75" / 8 oz
A⊗ 920



TRIAD

.75" / 8 oz
A⊗ 900



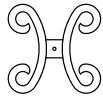
ROYALTY

.75" / .14 lbs
A⊗ 921



FLORENTINE SCROLL

14 oz / H⊗ 507



BUTTERFLY SCROLL

4 oz / H⊗ 506

.75" PRESS FIT PICKET FINIALS

⊗ = COLOR OPTIONS AVAILABLE | **B** = Black **N** = Bronze
W = White **S** = Sand

ESTATE GATE ADORNMENTS

» #10 x .75" self-drilling screws included

⊗ = COLOR OPTIONS AVAILABLE | **B** = Black **N** = Bronze
W = White **S** = Sand



BLOCK LETTERING

4 lbs / 8613



OLD ENGLISH LETTERING

4 lbs / 8614

ESTATE GATE LETTERING

» Complete alphabet available in each style

» Letters are 10" in height

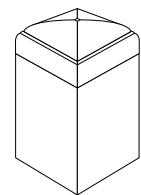
⊗ = COLOR OPTIONS AVAILABLE | **B** = Black **N** = Bronze
W = White **S** = Sand

ESTATE® | GATE POST SIZE RECOMMENDATIONS

MINIMUM SIZES FOR ESTATE GATEPOSTS		
GATE OPENING	GATE HEIGHT UP TO 6'	GATE HEIGHT OVER 6' UP TO 8'
up to 4'	3" STEEL	3" STEEL
4'-1" to 6'	3" STEEL	3" STEEL
6'-1" to 8'	4" STEEL	4" STEEL
8'-1" to 10'	4" STEEL	6" STEEL
10'-1" to 12'	6" STEEL	6" STEEL
12'-1" to 14'	6" STEEL	6" STEEL

Effective: 01/01/18

ESTATE® | STEEL ORNAMENTAL SQUARE GATE POSTS



STEEL POSTS

	POST LENGTH	ITEM NUMBER	WEIGHT
3"sq. x 12ga.	5'	P⊗30060	20 lbs
	6'	P⊗30072	24 lbs
	7'	P⊗30084	30 lbs
	8'	P⊗30096	34 lbs
	9'	P⊗30108	39 lbs
	10'	P⊗30120	43 lbs
	11'	P⊗30132	47 lbs
	12'	P⊗30144	51 lbs
	13'	P⊗30156	56 lbs
	14'	P⊗30168	60 lbs
	15'	P⊗30180	64 lbs
4"sq. x 11ga.	6'	P⊗40072	39 lbs
	7'	P⊗40084	47 lbs
	8'	P⊗40096	54 lbs
	9'	P⊗40108	61 lbs
	10'	P⊗40120	67 lbs
	11'	P⊗40132	74 lbs
	12'	P⊗40144	81 lbs
	13'	P⊗40156	87 lbs
	14'	P⊗40168	94 lbs
	15'	P⊗40180	101 lbs
	16'	P⊗40192	108 lbs
6"sq. x .1875" wall	7'	P⊗60084	102 lbs
	8'	P⊗60096	116 lbs
	9'	P⊗60108	131 lbs
	10'	P⊗60120	145 lbs
	11'	P⊗60132	160 lbs
	12'	P⊗60144	174 lbs
	13'	P⊗60156	189 lbs
	14'	P⊗60168	203 lbs
	15'	P⊗60180	218 lbs
	16'	P⊗60192	232 lbs

⊗ = COLOR OPTIONS AVAILABLE | **B** = Black | **N** = Bronze | **W** = White | **S** = Sand

NOTE: When installed in a location subject to freezing, where posts are grouted into core-drilled holes, a .25" diameter hole should be drilled in the post approximately .5" 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.

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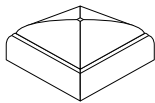
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ESTATE® | GATE POST CAPS



STANDARD FLAT CAP
Steel

CAP SIZE	ITEM NUMBER	WEIGHT
2" sq	Aⓧ506	0.3 lbs
2.5" sq	Aⓧ507	0.3 lbs
3" sq	Aⓧ508	0.3 lbs
4" sq	Aⓧ509	0.4 lbs
6" sq	Aⓧ515	0.8 lbs
8" sq	Aⓧ801	2 lbs



BALL CAP
Aluminum

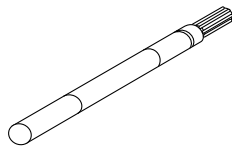
CAP SIZE	ITEM NUMBER	WEIGHT
3"sq.	Aⓧ516	.8 lbs
4"sq.	Aⓧ517	2 lbs
6"sq.	Aⓧ521	8 lbs

ⓧ = COLOR OPTIONS AVAILABLE | **B** = Black **N** = Bronze **W** = White
S = Sand

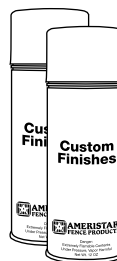
ESTATE® | CUSTOM FINISHES

WARRANTY ON CUT COMPONENTS VOID WITHOUT PROPER TOUCH-UP APPLICATION*

*For details & the guidelines for the proper 3-step process, see Ameristar's Sales Policy in the catalog guide



PAINT PEN
.5 lbs / Pⓧ100



SPRAY PAINT
1.1 lbs / Fⓧ100

ⓧ = COLOR OPTIONS AVAILABLE | **B** = Black **N** = Bronze **W** = White **S** = Sand

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ESTATE® | CONSTRUCTION SPECIFICATION 32 31 00

ALUMINUM ENTRY GATE SYSTEM

PART 1 - GENERAL

1.01 WORK INCLUDED

The contractor shall provide all labor, materials and apparatuses necessary for installation of the industrial 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 ornamental gate system of the Ameristar® Estate Gate® (*specify Classic™, Majestic™, Genesis™ or Warrior™*) design. The gate system shall include all components (*i.e., gate modules, hardware, accessories and posts*) 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 B221** – Aluminum and Aluminum Alloy Extruded Bars, Shapes and Tubes
- **ASTM D523** – Test Method for Specular Gloss
- **ASTM D714** – Test Method for Evaluating Degree of Blistering in Paint
- **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 D6695** – Standard Practice for Xenon-Arc Exposures of Paint and Related Coatings

1.06 SUBMITTAL

The manufacturer's submittal package shall be provided 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

The modular gate system shall conform to Ameristar Estate (*specify Classic, Majestic, Genesis, or Warrior*) style, (*specify 5-Rail or 5-Rail with Rings*) design, (*specify Single Swing or Double Swing*) entry configuration, (*specify standard catalog dimension*) opening, (*specify standard catalog*) height, manufactured by Ameristar Fence Products Inc. in Tulsa, Oklahoma.

2.02 MATERIAL

- A. The materials used for gate (*pickets, rails & gate ends*) shall be manufactured from **ASTM B221** aluminum (*designation 6063-T-6*) with yield strength of 25,000 PSI, a tensile strength of 30,000 PSI and a standard mill finish.
- B. Steel material for gateposts, shall be galvanized prior to forming in accordance with the requirements of **ASTM A653/A653M**, with minimum yield strength of 45,000 psi (310 MPa). The steel shall be hot-dip galvanized to meet the requirements of **ASTM A653/A653M** with a minimum zinc coating weight of 0.90 oz/ft² (276 g/m²), Coating Designation G-90.
- C. Material for pickets shall be 3/4" square x .125 wall aluminum; rails shall be 1" x 2" x .250" wall aluminum, gate ends and intermediates shall be 2" square x .250" wall aluminum. Gate posts shall be per manufactures recommendation.

2.03 FABRICATION

- A. Pickets, rails and gate ends shall be precut to specified lengths, and then joined via welding at each picket to rail connection and rail to gate end connection.
- B. The manufactured framework shall be subjected to the Ameristar thermal stratification coating process (*high-temperature, in-line, multi-stage, and multi-layer*) including, as a minimum, a six-stage pretreatment/wash and an electrostatic spray application of a polyester finish. The topcoat shall be a "no-mar" TGIC polyester powder coat finish with a minimum thickness of 2 mils (0.0508mm). The color shall be (*specify Black, Bronze, White, or Desert Sand*). The stratification-coated framework shall be capable of meeting the performance requirements for each quality characteristic shown in **Table 1**.

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ALUMINUM ENTRY GATE SYSTEM

PART 3 - EXECUTION

3.01 PREPARATION

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

3.02 GATE INSTALLATION

Gateposts 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. Gateposts 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 GATE INSTALLATION MAINTENANCE

When cutting/drilling gate adhere to the following steps to seal the exposed surfaces; 1) Remove all metal shavings from cut area. 2) Apply 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 manufacture 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

COATING PERFORMANCE REQUIREMENTS		
QUALITY CHARACTERISTICS	ASTM TEST METHOD	PERFORMANCE REQUIREMENTS
ADHESION	D3359 – METHOD B	Adhesion (<i>retention of coating</i>) over 90% of test area (<i>tape and knife kit test</i>).
CORROSION RESISTANCE	B117, D714, D1654	Corrosion resistance over 1,000 hours (<i>scribed per D1654; failure mode is accumulation of 1/8" coating loss from scribe or medium #8 blisters</i>)
IMPACT RESISTANCE	D2794	Impact resistance over 60" lb. (<i>forward impact using 0.625" ball</i>).
WEATHERING RESISTANCE	D822 D2244, D523 (60° method)	Weathering resistance over 1,000 hours (<i>failure mode is 60% loss of gloss or color variance of more than 3 delta-E color units</i>).

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