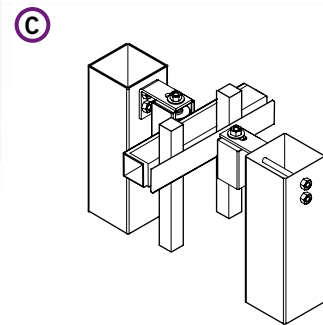
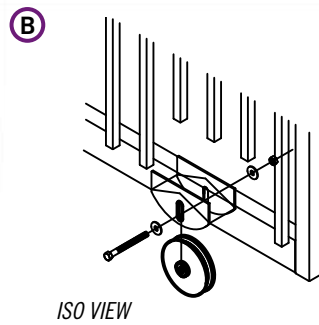
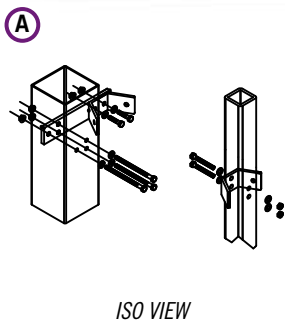
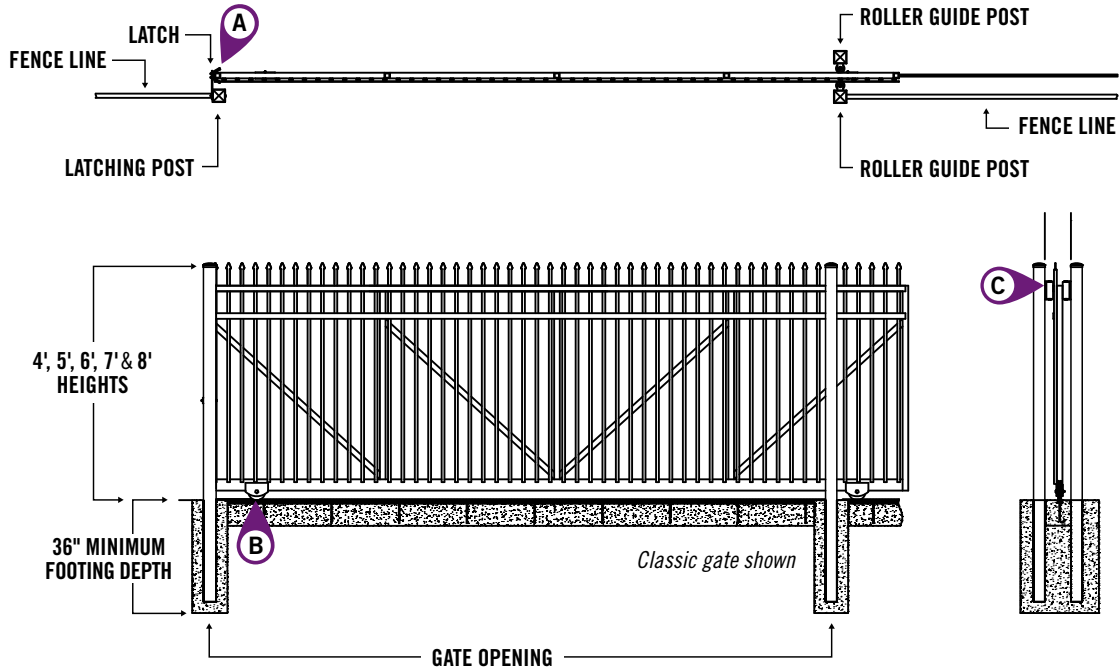


PASSPORT II®

2"sq x 12ga UPRIGHTS & DIAGONAL BRACES | 1"sq PICKETS | 2" x 4" x 11ga BOTTOM RAIL (notched & plated for v-track wheels)



ROLL GATE SAFETY WARNING

PassPort Roll Gates are supplied with 2" mesh safety screening in sufficient quantities to cover the entire gate and an equal portion of fence parallel to the gate in the open position up to a height of over 6 feet from ground elevation. ***This screening must be included when the PassPort Gate is installed at the jobsite. Additionally, all of the safety requirements of ASTM F2200 must be met during installation. Failure to incorporate the safety mesh or follow ASTM F2200 safety requirements during gate assembly and installation will cause rejection of the entire gate system any time an attempt is made to attach the gate to an automatic gate operator. Ameristar assumes no responsibility for gate installations that fail to utilize the materials provided or meet the applicable safety standards.***

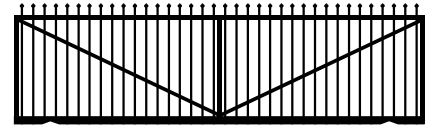
Refer to construction specification & tables within this section for more details.

Effective: 08/14/18

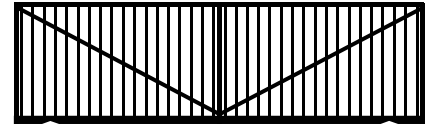
PASSPORT II® | 2-RAIL ROLL GATES

RAIL SPACINGS MATCH MONTAGE II PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

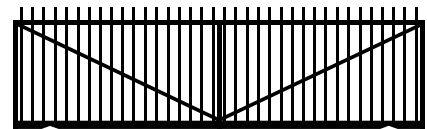
OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4' HEIGHT	4' - 6'	2☒Ⓞ204606R*	200 lbs	20
	6' - 8'	2☒Ⓞ204608R*	243 lbs	26
	8' - 10'	2☒Ⓞ204610R*	273 lbs	29
	10' - 12'	2☒Ⓞ204612R*	317 lbs	36
	12' - 14'	2☒Ⓞ204614R**	386 lbs	40
	14' - 16'	2☒Ⓞ204616R**	444 lbs	48
	16' - 18'	2☒Ⓞ204618R**	473 lbs	52
	18' - 20'	2☒Ⓞ204620R**	532 lbs	60
	20' - 22'	2☒Ⓞ204622R**	561 lbs	64
	22' - 24'	2☒Ⓞ204624R**	591 lbs	68
	24' - 26'	2☒Ⓞ204626R**	621 lbs	72
	26' - 28'	2☒Ⓞ204628R***	703 lbs	78
28' - 31'	2☒Ⓞ204631R***	791 lbs	90	
5' HEIGHT	4' - 6'	2☒Ⓞ205806R*	230 lbs	20
	6' - 8'	2☒Ⓞ205808R*	278 lbs	26
	8' - 10'	2☒Ⓞ205810R*	310 lbs	29
	10' - 12'	2☒Ⓞ205812R*	359 lbs	36
	12' - 14'	2☒Ⓞ205814R**	443 lbs	40
	14' - 16'	2☒Ⓞ205816R**	507 lbs	48
	16' - 18'	2☒Ⓞ205818R**	539 lbs	52
	18' - 20'	2☒Ⓞ205820R**	604 lbs	60
	20' - 22'	2☒Ⓞ205822R**	636 lbs	64
	22' - 24'	2☒Ⓞ205824R**	669 lbs	68
	24' - 26'	2☒Ⓞ205826R**	701 lbs	72
	26' - 28'	2☒Ⓞ205828R***	800 lbs	78
28' - 31'	2☒Ⓞ205831R***	897 lbs	90	
6' HEIGHT	4' - 6'	2☒Ⓞ207006R*	260 lbs	20
	6' - 8'	2☒Ⓞ207008R*	313 lbs	26
	8' - 10'	2☒Ⓞ207010R*	348 lbs	29
	10' - 12'	2☒Ⓞ207012R*	401 lbs	36
	12' - 14'	2☒Ⓞ207014R**	501 lbs	40
	14' - 16'	2☒Ⓞ207016R**	571 lbs	48
16' - 18'	2☒Ⓞ207018R**	606 lbs	52	



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GENESIS™

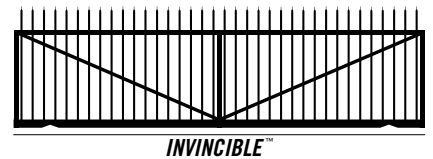
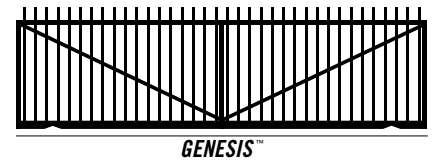
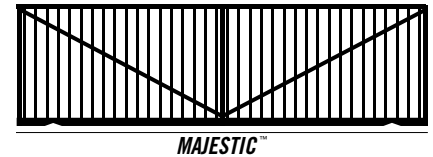
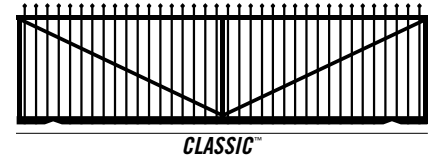
6', 7' & 8' HEIGHTS CONTINUED ON NEXT PAGE

Effective: 08/14/18

PASSPORT II® | 2-RAIL ROLL GATES

RAIL SPACINGS MATCH MONTAGE II PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

	OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
6' HEIGHT	18' - 20'	287"	2☒⊗207020R**	676 lbs	60
	20' - 22'	306"	2☒⊗207022R**	712 lbs	64
	22' - 24'	325"	2☒⊗207024R**	748 lbs	68
	24' - 26'	344"	2☒⊗207026R**	783 lbs	72
	26' - 28'	372.5"	2☒⊗207028R***	899 lbs	78
	28' - 31'	429.5"	2☒⊗207031R***	1005 lbs	90
7' HEIGHT	4' - 6'	97"	2☒⊗208206R*	291 / 294†	20
	6' - 8'	125.5"	2☒⊗208208R*	348 / 352†	26
	8' - 10'	144.5"	2☒⊗208210R*	386 / 391†	29
	10' - 12'	173"	2☒⊗208212R*	444 / 450†	36
	12' - 14'	192"	2☒⊗208214R*	559 / 566†	40
	14' - 16'	230"	2☒⊗208216R**	635 / 643†	48
	16' - 18'	249"	2☒⊗208218R**	673 / 682†	52
	18' - 20'	287"	2☒⊗208220R**	750 / 760†	60
	20' - 22'	306"	2☒⊗208222R**	789 / 799†	64
	22' - 24'	325"	2☒⊗208224R**	827 / 838†	68
8' HEIGHT	24' - 26'	344"	2☒⊗208226R**	866 / 981†	72
	26' - 28'	372.5"	2☒⊗208228R***	999 / 1011†	78
	28' - 31'	429.5"	2☒⊗208231R***	1114 / 1142†	90
	4' - 6'	97"	2☒⊗209406R*	322 / 325†	20
	6' - 8'	125.5"	2☒⊗209408R*	384 / 388†	26
	8' - 10'	144.5"	2☒⊗209410R*	425 / 430†	29
	10' - 12'	173"	2☒⊗209412R*	487 / 493†	36
	12' - 14'	192"	2☒⊗209414R**	618 / 625†	40
	14' - 16'	230"	2☒⊗209416R**	700 / 708†	48
	16' - 18'	249"	2☒⊗209418R**	741 / 750†	52
18' - 20'	287"	2☒⊗209420R**	824 / 834†	60	
20' - 22'	306"	2☒⊗209422R**	866 / 876†	64	
22' - 24'	325"	2☒⊗209424R**	907 / 918†	68	
24' - 26'	344"	2☒⊗209426R**	949 / 923†	72	
26' - 28'	372.5"	2☒⊗209428R***	1099 / 1112†	78	
28' - 31'	429.5"	2☒⊗209431R***	1223 / 1232†	90	



☒ = FENCE STYLES AVAILABLE | C = Classic
 M = Majestic G = Genesis I = Invincible†
 ⊗ = COLOR OPTIONS AVAILABLE | B = Black
 N = Bronze W = White S = Sand

* 2-Bays | ** 4-Bays | *** 6-Bays

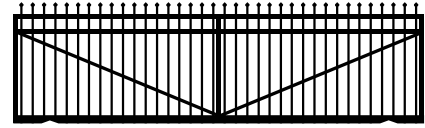
Note: All gates that exceed 192" in length for Invincible and all 8' gates that exceed 192" in length for Classic, Genesis & Majestic will have bolt-on panels with face-welded pales.

Effective: 08/14/18

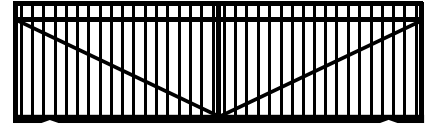
PASSPORT II® | 3-RAIL ROLL GATES

RAIL SPACINGS MATCH MONTAGE II PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

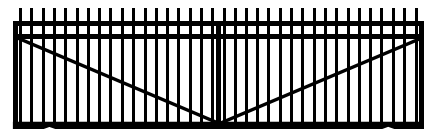
OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4' HEIGHT	4' - 6'	2☒Ⓞ304606R*	224 lbs	20
	6' - 8'	2☒Ⓞ304608R*	275 lbs	26
	8' - 10'	2☒Ⓞ304610R*	309 lbs	29
	10' - 12'	2☒Ⓞ304612R*	361 lbs	36
	12' - 14'	2☒Ⓞ304614R**	435 lbs	40
	14' - 16'	2☒Ⓞ304616R**	502 lbs	48
	16' - 18'	2☒Ⓞ304618R**	536 lbs	52
	18' - 20'	2☒Ⓞ304620R**	605 lbs	60
	20' - 22'	2☒Ⓞ304622R**	639 lbs	64
	22' - 24'	2☒Ⓞ304624R**	674 lbs	68
	24' - 26'	2☒Ⓞ304626R**	708 lbs	72
	26' - 28'	2☒Ⓞ304628R***	797 lbs	78
28' - 31'	2☒Ⓞ304631R***	900 lbs	90	
5' HEIGHT	4' - 6'	2☒Ⓞ305806R*	254 lbs	20
	6' - 8'	2☒Ⓞ305808R*	310 lbs	26
	8' - 10'	2☒Ⓞ305810R*	347 lbs	29
	10' - 12'	2☒Ⓞ305812R*	403 lbs	36
	12' - 14'	2☒Ⓞ305814R**	492 lbs	40
	14' - 16'	2☒Ⓞ305816R**	565 lbs	48
	16' - 18'	2☒Ⓞ305818R**	602 lbs	52
	18' - 20'	2☒Ⓞ305820R**	677 lbs	60
	20' - 22'	2☒Ⓞ305822R**	714 lbs	64
	22' - 24'	2☒Ⓞ305824R**	751 lbs	68
	24' - 26'	2☒Ⓞ305826R**	789 lbs	72
	26' - 28'	2☒Ⓞ305828R***	895 lbs	78
28' - 31'	2☒Ⓞ305831R***	1006 lbs	90	
6' HEIGHT	4' - 6'	2☒Ⓞ307006R*	285 lbs	20
	6' - 8'	2☒Ⓞ307008R*	345 lbs	26
	8' - 10'	2☒Ⓞ307010R*	385 lbs	29
	10' - 12'	2☒Ⓞ307012R*	445 lbs	36
	12' - 14'	2☒Ⓞ307014R**	550 lbs	40
	14' - 16'	2☒Ⓞ307016R**	629 lbs	48
	16' - 18'	2☒Ⓞ307018R**	669 lbs	52



CLASSIC™



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GENESIS™

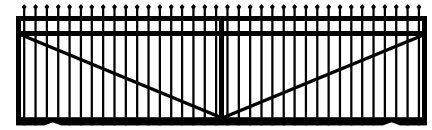
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Effective: 08/14/18

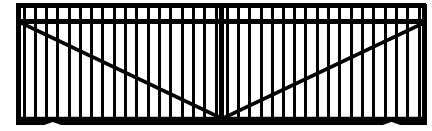
PASSPORT II® | 3-RAIL ROLL GATES

RAIL SPACINGS MATCH MONTAGE II PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

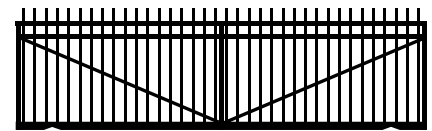
	OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
6' HEIGHT	18' - 20'	287"	2☒⊗307020R**	749 lbs	60
	20' - 22'	306"	2☒⊗307022R**	790 lbs	64
	22' - 24'	325"	2☒⊗307024R**	830 lbs	68
	24' - 26'	344"	2☒⊗307026R**	871 lbs	72
	26' - 28'	372.5"	2☒⊗307028R***	994 lbs	78
	28' - 31'	429.5"	2☒⊗307031R***	1114 lbs	90
7' HEIGHT	4' - 6'	97"	2☒⊗308206R*	316 / 319†	20
	6' - 8'	125.5"	2☒⊗308208R*	380 / 384†	26
	8' - 10'	144.5"	2☒⊗308210R*	423 / 428†	29
	10' - 12'	173"	2☒⊗308212R*	488 / 494†	36
	12' - 14'	192"	2☒⊗308214R*	608 / 615†	40
	14' - 16'	230"	2☒⊗308216R**	694 / 701†	48
	16' - 18'	249"	2☒⊗308218R**	737 / 745†	52
	18' - 20'	287"	2☒⊗308220R**	823 / 833†	60
	20' - 22'	306"	2☒⊗308222R**	866 / 877†	64
	22' - 24'	325"	2☒⊗308224R**	910 / 921†	68
8' HEIGHT	24' - 26'	344"	2☒⊗308226R**	953 / 965†	72
	26' - 28'	372.5"	2☒⊗308228R***	1093 / 1106†	78
	28' - 31'	429.5"	2☒⊗308231R***	1223 / 1225†	90
	4' - 6'	97"	2☒⊗309406R*	347 / 350†	20
	6' - 8'	125.5"	2☒⊗309408R*	415 / 420†	26
	8' - 10'	144.5"	2☒⊗309410R*	462 / 466†	29
	10' - 12'	173"	2☒⊗309412R*	531 / 537†	36
	12' - 14'	192"	2☒⊗309414R**	667 / 674†	40
	14' - 16'	230"	2☒⊗309416R**	759 / 766†	48
	16' - 18'	249"	2☒⊗309418R**	805 / 813†	52
18' - 20'	287"	2☒⊗309420R**	897 / 907†	60	
20' - 22'	306"	2☒⊗309422R**	943 / 954†	64	
22' - 24'	325"	2☒⊗309424R**	990 / 1001†	68	
24' - 26'	344"	2☒⊗309426R**	1036 / 1048†	72	
26' - 28'	372.5"	2☒⊗309428R***	1194 / 1207†	78	
28' - 31'	429.5"	2☒⊗309431R***	1332 / 1337†	90	



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GENESIS™



INVINCIBLE™



☒ = FENCE STYLES AVAILABLE | C = Classic
 M = Majestic G = Genesis I = Invincible†

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

* 2-Bays | ** 4-Bays | *** 6-Bays

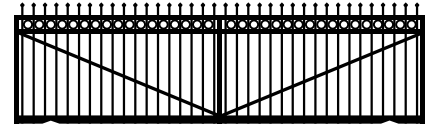
Note: All gates that exceed 192" in length for Invincible and all 8' gates that exceed 192" in length for Classic, Genesis & Majestic will have bolt-on panels with face-welded pales.

Effective: 08/14/18

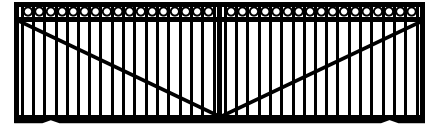
PASSPORT II® | 3-RAIL ROLL GATES WITH RINGS

RAIL SPACINGS MATCH AEGIS II PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

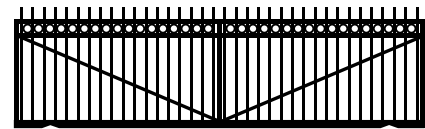
OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4' HEIGHT	4' - 6'	2☒Ⓞ304606RR*	231 lbs	20
	6' - 8'	2☒Ⓞ304608RR*	284 lbs	26
	8' - 10'	2☒Ⓞ304610RR*	320 lbs	29
	10' - 12'	2☒Ⓞ304612RR*	374 lbs	36
	12' - 14'	2☒Ⓞ304614RR**	449 lbs	40
	14' - 16'	2☒Ⓞ304616RR**	519 lbs	48
	16' - 18'	2☒Ⓞ304618RR**	555 lbs	52
	18' - 20'	2☒Ⓞ304620RR**	626 lbs	60
	20' - 22'	2☒Ⓞ304622RR**	662 lbs	64
	22' - 24'	2☒Ⓞ304624RR**	697 lbs	68
	24' - 26'	2☒Ⓞ304626RR**	733 lbs	72
	26' - 28'	2☒Ⓞ304628RR***	825 lbs	78
28' - 31'	2☒Ⓞ304631RR***	932 lbs	90	
5' HEIGHT	4' - 6'	2☒Ⓞ305806RR*	261 lbs	20
	6' - 8'	2☒Ⓞ305808RR*	319 lbs	26
	8' - 10'	2☒Ⓞ305810RR*	357 lbs	29
	10' - 12'	2☒Ⓞ305812RR*	416 lbs	36
	12' - 14'	2☒Ⓞ305814RR**	506 lbs	40
	14' - 16'	2☒Ⓞ305816RR**	582 lbs	48
	16' - 18'	2☒Ⓞ305818RR**	620 lbs	52
	18' - 20'	2☒Ⓞ305820RR**	698 lbs	60
	20' - 22'	2☒Ⓞ305822RR**	736 lbs	64
	22' - 24'	2☒Ⓞ305824RR**	775 lbs	68
	24' - 26'	2☒Ⓞ305826RR**	814 lbs	72
	26' - 28'	2☒Ⓞ305828RR***	922 lbs	78
28' - 31'	2☒Ⓞ305831RR***	1038 lbs	90	
6' HEIGHT	4' - 6'	2☒Ⓞ307006RR*	292 lbs	20
	6' - 8'	2☒Ⓞ307008RR*	354 lbs	26
	8' - 10'	2☒Ⓞ307010RR*	395 lbs	29
	10' - 12'	2☒Ⓞ307012RR*	458 lbs	36
	12' - 14'	2☒Ⓞ307014RR**	564 lbs	40
	14' - 16'	2☒Ⓞ307016RR**	646 lbs	48
	16' - 18'	2☒Ⓞ307018RR**	687 lbs	52



CLASSIC™



MAJESTIC™



GENESIS™

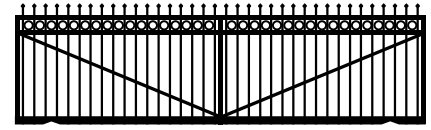
6', 7' & 8' HEIGHTS CONTINUED ON NEXT PAGE

Effective: 08/14/18

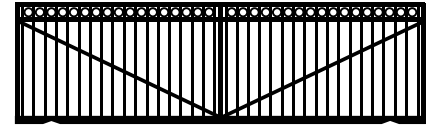
PASSPORT II® | 3-RAIL ROLL GATES WITH RINGS

RAIL SPACINGS MATCH AEGIS II PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

	OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
6' HEIGHT	18' - 20'	287"	2☒⊗307020RR**	770 lbs	60
	20' - 22'	306"	2☒⊗307022RR**	812 lbs	64
	22' - 24'	325"	2☒⊗307024RR**	854 lbs	68
	24' - 26'	344"	2☒⊗307026RR**	896 lbs	72
	26' - 28'	372.5"	2☒⊗307028RR***	1021 lbs	78
	28' - 31'	429.5"	2☒⊗307031RR***	1146 lbs	90
7' HEIGHT	4' - 6'	97"	2☒⊗308206RR*	323 / 326†	20
	6' - 8'	125.5"	2☒⊗308208RR*	389 / 393†	26
	8' - 10'	144.5"	2☒⊗308210RR*	434 / 438†	29
	10' - 12'	173"	2☒⊗308212RR*	501 / 507†	36
	12' - 14'	192"	2☒⊗308214RR*	622 / 629†	40
	14' - 16'	230"	2☒⊗308216RR**	710 / 718†	48
	16' - 18'	249"	2☒⊗308218RR**	755 / 763†	52
	18' - 20'	287"	2☒⊗308220RR**	844 / 854†	60
	20' - 22'	306"	2☒⊗308222RR**	889 / 899†	64
	22' - 24'	325"	2☒⊗308224RR**	934 / 945†	68
8' HEIGHT	24' - 26'	344"	2☒⊗308226RR**	978 / 990†	72
	26' - 28'	372.5"	2☒⊗308228RR***	1121 / 1133†	78
	28' - 31'	429.5"	2☒⊗308231RR***	1254 / 1255†	90
	4' - 6'	97"	2☒⊗309406RR*	354 / 357†	20
	6' - 8'	125.5"	2☒⊗309408RR*	425 / 429†	26
	8' - 10'	144.5"	2☒⊗309410RR*	472 / 477†	29
	10' - 12'	173"	2☒⊗309412RR*	544 / 550†	36
	12' - 14'	192"	2☒⊗309414RR**	681 / 688†	40
	14' - 16'	230"	2☒⊗309416RR**	775 / 783†	48
	16' - 18'	249"	2☒⊗309418RR**	823 / 831†	52
18' - 20'	287"	2☒⊗309420RR**	918 / 928†	60	
20' - 22'	306"	2☒⊗309422RR**	966 / 976†	64	
22' - 24'	325"	2☒⊗309424RR**	1014 / 1025†	68	
24' - 26'	344"	2☒⊗309426RR**	1062 / 1073†	72	
26' - 28'	372.5"	2☒⊗309428RR***	1221 / 1234†	78	
28' - 31'	429.5"	2☒⊗309431RR***	1364 / 1367†	90	



CLASSIC™



MAJESTIC™



GENESIS™



INVINCIBLE™



☒ = FENCE STYLES AVAILABLE | C = Classic
 M = Majestic G = Genesis I = Invincible†
 ⊗ = COLOR OPTIONS AVAILABLE | B = Black
 N = Bronze W = White S = Sand

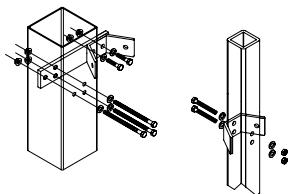
* 2-Bays | ** 4-Bays | *** 6-Bays

Note: All gates that exceed 192" in length for Invincible and all 8' gates that exceed 192" in length for Classic, Genesis & Majestic will have bolt-on panels with face-welded pales.

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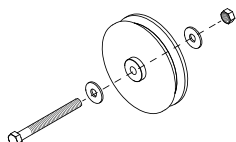
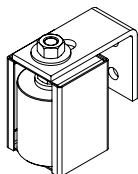
PASSPORT II® | HARDWARE

V-TRACK NOT INCLUDED



DESCRIPTION	ITEM NUMBER	WHEEL QTY	BOX QTY	WEIGHT
PassPort Gate Kit	PGKODN	2	1	35

Kits include: (2 or 3) 6" Wheel Kits / includes wheels, bearings, spacer bushings, washers, bolts & lock nuts | (2 or 3) Safety Guide Rollers | (1) Gate Latch



PASSPORT II® | ORNAMENTAL SQUARE POST

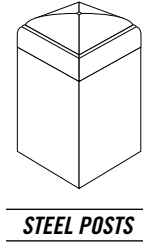
DESCRIPTION	POST LENGTH	ITEM NUMBER	POST WEIGHT
4" sq. x 11ga. STEEL	6'	P⊗ 40072	39 lbs
	7'	P⊗ 40084	47 lbs
	8'	P⊗ 40096	54 lbs
	9'	P⊗ 40108	61 lbs
	10'	P⊗ 40120	67 lbs
	11'	P⊗ 40132	74 lbs
	12'	P⊗ 40144	81 lbs
	13'	P⊗ 40156	87 lbs
	14'	P⊗ 40168	94 lbs
	15'	P⊗ 40180	101 lbs
	16'	P⊗ 40192	108 lbs

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

Effective: 08/14/18

PASSPORT II® | STEEL PLATED ORNAMENTAL SQUARE POSTS

PLATED POSTS USED WITH MAJESTIC PANELS REQUIRE 1" DEPENDING ON GRADE ELEVATION

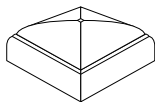


4"sq. x 11ga.

POST LENGTH	PLATE SIZE	ITEM NUMBER	WEIGHT
4'	8" sq. x .375" / .5625" holes (8876G)	P⊗40048P	33 lbs
5'	8" sq. x .375" / .5625" holes (8876G)	P⊗40060P	39 lbs
6'	8" sq. x .375" / .5625" holes (8876G)	P⊗40072P	47 lbs
7'	8" sq. x .375" / .5625" holes (8876G)	P⊗40084P	54 lbs
8'	8" sq. x .375" / .5625" holes (8876G)	P⊗40096P	61 lbs
9'	8" sq. x .375" / .5625" holes (8876G)	P⊗40108P	67 lbs
10'	8" sq. x .375" / .5625" holes (8876G)	P⊗40120P	74 lbs

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

PASSPORT II® | POST CAPS



STANDARD FLAT CAP
Steel

CAP SIZE	ITEM NUMBER	WEIGHT
4"sq.	A⊗509	.4 lbs

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

Effective: 08/14/18

PASSPORT II® | CONSTRUCTION SPECIFICATION 32 31 00

STEEL ROLL GATE SYSTEM

PART 1 - GENERAL

1.01 WORK INCLUDED

The contractor shall provide all labor, materials and appurtenances necessary for installation of the steel roll gate system defined herein at (*specify project site*).

1.02 RELATED WORK

Section 022__ - Earthwork

Section 030__ - Concrete

1.03 SYSTEM DESCRIPTION

The manufacturer shall supply a total roll gate system of Ameristar® PassPort II® Industrial Ornamental design series and (*specify Classic™, Majestic™, Genesis™, or Invincible™*) style. The system shall include all components (*i.e., pickets, rails, gate uprights, wheels 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 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 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 steel roll gate system shall conform to Ameristar PassPort II Industrial Ornamental design series, (*specify Classic, Majestic, Genesis, or Invincible*) style and (*specify 2-rail or 3-rail*) frame configuration manufactured by Ameristar Fence Products, Inc. in Tulsa, Oklahoma.

2.02 MATERIAL

- A. Steel material for roll gate components (*i.e. pickets, rails, diagonals and uprights*), shall be commercial steel with a minimum yield strength of 45,000 psi (344 MPa).
- B. Ornamental picket material shall be 1" square x 14 Ga. Tubing. Picket spacing shall be 4-3/4". Material for top rails, uprights and diagonals rails shall be 2" square x 12ga. Material for the bottom rail shall be 2" x 4" x 11ga. Posts shall be a minimum of 4" square x 11ga.

2.03 FABRICATION

- A. Pickets/pales, rails, uprights and posts shall be pre-cut to specified lengths. Diagonals shall be pre-cut to specified lengths and angles. Frame materials shall be joined by welding. Pickets/pales shall be face welded to roll gate frame, except for Invincible or Gauntlet style gates over 18' long. Invincible or Gauntlet™ style gates over 18' long shall have pickets face-welded to 2" x 2" angle iron to form panels equal in length to the gate frame bay width.
- B. The manufactured roll gates and bolt-on panels (*if applicable*) shall be subjected to the PermaCoat® thermal stratification coating process (*high-temperature, in-line, multi-stage, multi-layer*) including, as a minimum, a six-stage pre-treatment/wash, an electrostatic spray application of an epoxy base, and a separate electrostatic spray application of a polyester finish. The base coat shall be a thermosetting epoxy powder coating (gray in color) with a minimum thickness of 2 mils (0.0508mm). 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**.
- C. Completed gates shall be capable of supporting a 200 lb. load applied at midspan without permanent deformation.

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PASSPORT II® | CONSTRUCTION SPECIFICATION 32 31 00

ORNAMENTAL STEEL ROLL GATES

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

Gate posts shall be set in accordance with the spacings shown in the construction plans. The "Earthwork" and "Concrete" sections of this specification shall govern post base material requirements. 6" wheels shall be bolted to the gate (*between the wheel plates welded near the ends of the gate bottom rail*). The gate shall be set upright with the V-grooved wheels positioned over the pre-installed steel V-track that traverses the gate opening. Roller guides shall be affixed to the gate posts at a height even with the gate toprail to hold the gate in a vertical position. Gate stops shall be welded to the end of the gate or track so gate cannot pass rollers in either direction.

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 (<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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