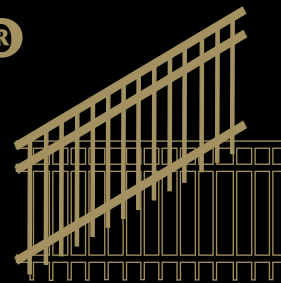


# MONTAGE®

by  **AMERISTAR®**

[www.MONTAGEFENCE.COM](http://www.MONTAGEFENCE.COM)



## MONTAGE II HEAVY INDUSTRIAL

---

## MONTAGE PLUS COMMERCIAL



**THE #1 ALTERNATIVE TO CHAIN LINK FENCING**  
**MONTAGE MAKEOVERS ARE SWEEPING THE NATION**



**SEE WHY . . . . INSIDE**

# The Changing of the Guard

## Forward-Thinking Architects Are Choosing the MONTAGE® Ornamental Option

For decades, the only product specified for commercial and industrial perimeter fencing was 6' tall chain-link with barbed wire.

### APPEARANCE

The look is unfriendly, oppressive and tiresome. The profile is broken by sharp exposed selva twists and unsightly tie wires. Standard framework and fabric finish is a layer of graying zinc.

### SECURITY

Chain-link fence fabric can be cut easily, allowing a breach large enough to gain access within 15 seconds.

**With a look that is less than attractive and a fabric that is less than secure . . . .**

**What exactly does that give you?**



WGRZ-TV, Channel 2, the Buffalo, New York NBC affiliate had previously erected a chain-link fence, citing the need to protect millions of dollars worth of satellite dishes, news vehicles and other broadcasting equipment. As reported in the Buffalo News, this led to three decades of barbed criticism from neighborhood business and civic leaders. "It was sending the absolute wrong message about safety and hospitality in the neighborhood," said Mike Croce, whose upscale Buffalo Chop House is next door. Buffalo Place, a coalition of downtown businesses, had been urging Channel 2 to get rid of the fence for several years.

After thorough evaluation, Channel 2 announced that it would be replacing its much-criticized, razor wire-topped chain-link fence with 'a safety fence with the appearance of wrought iron'.

Now, a fusion-welded steel ornamental fence is here, complete with a maintenance-free E-coat finish and a 20-Year warranty.

### APPEARANCE

The look is open and attractive, while conveying the assurance of strength to discourage potential trespassers. The smooth profile blends well with adjacent landscaping and architecture.

### SECURITY

Fusion-welded panel construction, one-way security fasteners on brackets, and high-tensile steel material prohibit easy cutting.

**With Montage, there is now a superior and affordable alternative to chain link . . . .**

**Montage adds value to the property.**



With the approval and endorsement from the city of Buffalo, the chain-link fence was removed and replaced by an 8' tall ornamental fence, Invincible (curved picket) style, from Ameristar. "We found an alternative that will provide the same, if not better level of security, without the intimidation factor," said WGRZ General Manager James W. Toellner. "We think the new look is more fitting with our '2 On Your Side' slogan."

"This is the neighborly thing for them to do," said restaurateur Croce. The new fence is also receiving positive comments from the Buffalo Place business group.

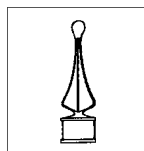
 **MONTAGE®** 

# MONTAGE® Ornamental Fences for Commercial & Industrial Specifiers

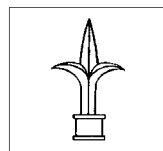
## COMPONENT SIZES

System	Height	Pickets	Rails	Posts
Montage Plus® Commercial	7' & 8'	3/4" x 14 GA.	1-7/16" x 0.072 Top 1-1/2" x 0.072" Sides	2-1/2" Sq. x 14 GA.
Montage II® Heavy Industrial	3' through 8'	1" x 14 GA.	1-3/4" x 0.105 Top 1-3/4" x 0.105" Sides	3" Sq. x 14 GA.

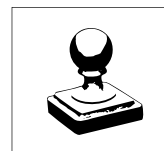
## ADORNMENTS



Quad Flare



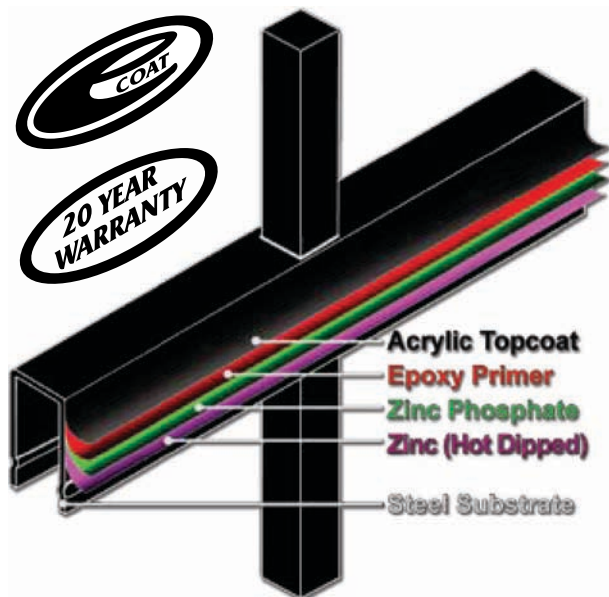
Triad



Ball Cap

## Fusion Welded Steel Construction

Montage Plus® and Montage II® are crafted with an inherent beauty that adds a decorative touch to any landscape. The fusion welded steel construction makes it applicable for all types of heavy industrial applications as well as for commercial installations such as retail businesses, storage facilities, schools, health care facilities, golf courses and recreational parks. The maintenance-free electro-deposition coating (E-Coat) makes Montage Plus® Commercial and Montage II® Heavy Industrial suitable for any climate, hot or cold, wet or dry; Ameristar® uses the same cyclic testing technology used in the automotive industry to ensure that the coating will withstand repeated shifts in temperature and humidity. The All Terrain Flexibility, 'ATF' design enables fence installation that follows significant grade changes.



## COATING & WARRANTY

The E-Coat combination of galvanized steel, zinc phosphate pre-treatment, and epoxy and acrylic double coating provide the protection necessary to withstand adverse weathering effects and justify the 'best-in-the-business' 20 Year Warranty.

## COLORS, AVAILABILITY & MAINTENANCE

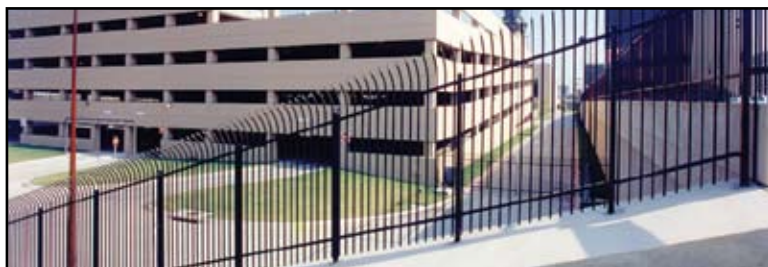
Montage Plus® Commercial and Montage II® Heavy Industrial are available in Black and Bronze. Color chip samples can be requested for actual color. Little or no maintenance is required as the E-coated components will remain corrosion-free for years to come. If coating is damaged by accidental impact, the affected components can be readily repaired with Ameristar's matching custom finishes (either spray or paint pen application). Montage Plus® Commercial and Montage II® Heavy Industrial fence components are packaged as necessary to ensure damage-free shipping.

To order, simply specify the fence or gate design series, color and height desired. Then figure and provide the quantities needed. Contact Ameristar® for the nearest distributor.

## UNIQUE DESIGN FEATURES

### • All Terrain Flexibility (ATF)

Unlike conventional welded panels that require stair-stepping along grades (leaving gaps and open areas below the fence), the all-terrain flexibility (ATF) of eight-foot long Montage Plus® Commercial and Montage II® Heavy Industrial panels allows them to rack up to 48" on Classic, Majestic and Genesis styles; up to 18" on Invincible® curved picket style.



### • Flush Bottom Rail Option

For some applications, a flush bottom rail may be necessary to meet local building codes or simply to meet an aesthetic preference.



# Montage II®

## Welded Steel Ornamental Fence

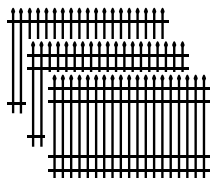
### COMPONENT SIZES

System	Pickets	Rails	Posts
Montage II® Heavy Industrial	1" x 14 Ga.	1-3/4" x 1-3/4" x 0.105"	2-1/2" Sq. x 12 Ga. min. for fences up to & including 6' tall; 3" Sq. x 12 Ga. min. for 7' & 8' tall fences

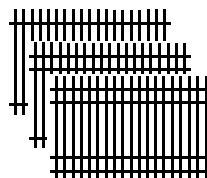
### 20 YEAR WARRANTY

The E-Coat combination of galvanized steel, zinc phosphate pre-treatment, and epoxy and acrylic double coating provide the protection necessary to withstand adverse weathering effects and justify the 'best-in-the-business' 20 Year Warranty.

### STYLES



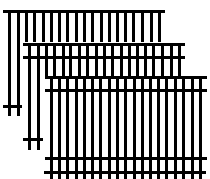
**CLASSIC™**  
Style C2 (2-Rail)  
Style C3 (3-Rail)  
Style C4 (4-Rail)



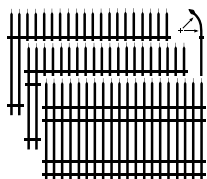
**GENESIS™**  
Style G2 (2-Rail)  
Style G3 (3-Rail)  
Style G4 (4-Rail)

The extended spear top of the Classic™ style gives the secure structure an added touch of elegance. Classic™ is available in 2-rail, 3-rail and 4-rail designs.

The Genesis™ acts as a foundation for creation of multiple custom looks by the addition of decorative finials. Genesis™ is available in 2-rail, 3-rail and 4-rail designs.



**MAJESTIC™**  
Style M2 (2-Rail)  
Style M3 (3-Rail)  
Style M4 (4-Rail)



**INVINCIBLE®**  
Style I2 (2-Rail)  
Style I3 (3-Rail)  
Style I4 (4-Rail)

Majestic™ is a simple, yet elegant style with a smooth top rail, available in 2-rail, 3-rail and 4-rail designs. It is ideally suited for public pools, recreational areas, schools and other institutions.

Invincible® means 'incapable of being overcome'. The gradual outward curve of the pickets makes this style a superior alternative to the chain link and barbed wire fences of the past. 2-rail, 3-rail and 4-rail profiles are available in 7' and 8' heights.

### DESIGN ADVANTAGES

#### Maintenance-Free

Montage II® panels are subjected to a thorough cleaning and zinc phosphate pretreatment and then, in Ameristar's state-of-the-art E-Coat system, are completely submerged twice, first in a moisture-resistant epoxy and secondly in a weather-resistant acrylic, to ensure protection over all exposed surfaces. Ameristar® uses the same cyclic testing technology, developed in the automotive industry, to ensure that Montage II® fences will endure harsh environments.

#### Fusion-Welded

Montage II® fence panels are fabricated using Ameristar's revolutionary ProFusion process that combines fusion and laser technology to automatically weld strong, virtually invisible, structural connections without unsightly or insecure fasteners. This rigid welded construction not only suits Montage II® for rigorous environments, but also makes it a popular choice for commercial applications like businesses, schools, and public parks and playgrounds.

U.S. Patent  
No. 6,811,145



### ADORNMENTS



Quad  
Flare



Triad



Ball  
Cap

### COLORS, AVAILABILITY & MAINTENANCE

Montage II® is available in Black and Bronze; color chip samples can be requested for actual color. Availability and maintenance information are the same as for the Aegis II® and Aegis Plus® steel fence systems.

## • All Terrain Flexibility (ATF)

Unlike conventional welded panels that require stair-stepping along grades (leaving gaps and open areas below the fence), the all-terrain flexibility (ATF) of eight-foot long Montage II® Heavy Industrial panels allows racking up to 48" on Classic, Majestic and Genesis styles; up to 18" on Invincible® curved picket style.



## • Flush Bottom Rail Option

For some applications, a flush bottom rail may be necessary to meet local building codes or simply to meet an aesthetic preference.



# CONSTRUCTION SPECIFICATION

## SECTION 32 31 00 - ORNAMENTAL WELDED FENCING SYSTEM

### Montage II® - Heavy Industrial Weight

#### 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 II ATF® Welded 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.

##### 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 II ATF® Welded 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 (310 MPa) and a minimum zinc (hot-dip galvanized) coating weight of 0.90 oz/ft<sup>2</sup> (276 g/m<sup>2</sup>). Coating Designation G-90.

B. Material for pickets shall be 1" square x 14 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 12 Ga. For fence systems 7 feet tall and 8' tall, posts shall be a minimum of 3" 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 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 shall be capable of meeting the performance requirements for each quality characteristic shown in Table 2.

D. Material for gate pickets shall be 1" square x 14 Ga. tubing. Rails for gates shall be 1.75" square ForeRunner® double-walled u-channel. Uprights shall be 2" square x 11 GA. Gates shall be fabricated with all intersections 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 according to Table 3, plus or minus 1/2". Fence panels shall be attached to posts with 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 – Minimum Sizes for Montage II Gate Posts

Gate Opening	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.	4" x 11 Ga.
4'-1" To 6'	3" x 12 Ga.	3" x 12 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'	3" x 12 Ga.	4" x 11 Ga.	6" x 3/16"
10'-1" To 12'	3" x 12 Ga.	4" x 11 Ga.	6" x 3/16"
12'-1" To 14'	3" x 12 Ga.	4" x 11 Ga.	6" x 3/16"
14'-1" To 16'	3" x 12 Ga.	4" x 11 Ga.	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 1,500 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).

Table 3 – Montage II - Post Spacing

Span	For INVINCIBLE® 8" Nominal (91-1/4" Rail)		For CLASSIC™ 8" Nominal (91-1/4" Rail)	
Post Size	2-1/2"	3"	2-1/2"	3"
Bracket Type	Industrial Flat Mount (BB301)		Industrial Universal (BB302)	
Post Settings ± 1/2" O.C.	94-1/2"	95"	96"	96"

\* Note: When using BB304 swivel brackets on either or both ends of a panel, the spacing between post and adjoining pickets meets applicable codes. This v

# Montage Plus®

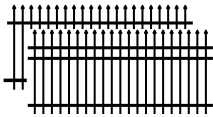
## Fusion Welded Steel Construction

Montage Plus® is crafted with an inherent beauty that adds a decorative touch to any landscape. The fusion welded steel construction makes it applicable for all types of commercial installations such as retail businesses, storage facilities, schools, health care facilities, golf courses and recreational parks. The curved pickets of the Invincible® style provide a superior look to chain link and barbed wire. The maintenance-free electro-deposition coating (E-Coat) makes Montage Plus® suitable for any climate, hot or cold, wet or dry; Ameristar® uses the same cyclic testing technology used in the automotive industry to ensure that the coating will withstand repeated shifts in temperature and humidity.

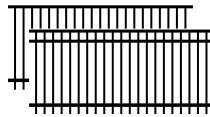
### COMPONENT SIZES

System	Pickets	Rails	Posts
Montage Plus® Commercial	3/4" x 17 Ga. for fences up to & including 6' tall; 3/4" x 14 Ga. for 7' & 8' tall fences	1-7/16" x 0.072 Top 1-1/2" x 0.072" Sides	2-1/2" Sq. x 16 Ga. min. for fences up to & including 6' tall; 2-1/2" Sq. x 14 Ga. min. for 7' & 8' tall fences

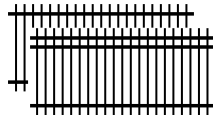
### STYLES



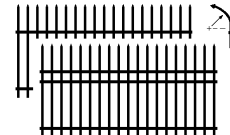
CLASSIC™  
Style C2 (2-Rail)  
Style C3 (3-Rail)



MAJESTIC™  
Style M2 (2-Rail)  
Style M3 (3-Rail)

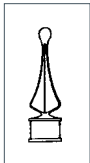


GENESIS™  
Style G2 (2-Rail)  
Style G3 (3-Rail)



INVINCIBLE™  
Style I2 (2-Rail)  
Style I3 (3-Rail)

### ADORNMENTS



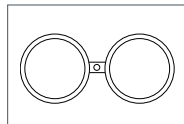
Quad  
Flare



Triad



Ball  
Cap



Ring



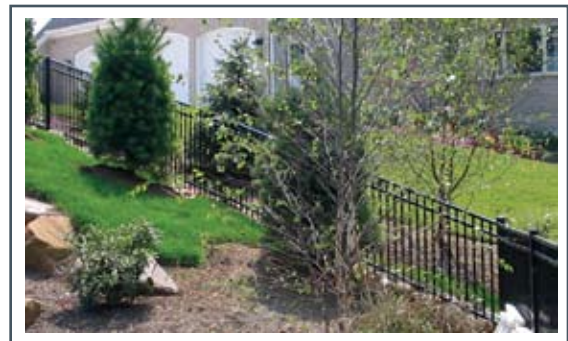
### GATES

Gates are fabricated by welding Montage Plus® panel material to 1-3/4" square gate ends.

### DESIGN ADVANTAGES

#### • All Terrain Fence (ATF)™ Panel Design

Architectural design and construction technology have progressed to enable new facility construction on rough and uneven terrain that was previously considered unfeasible for permanent structures. Montage Plus® ATF maintains its rigid strength, while adapting to slopes as severe as a 30 inch rise in an 8 foot run.



#### • Pool, Pet & Play (PPP)™ Picket Space Option

In many cases related to child care, public swimming pools, and containment, a narrower space may be desired or required for added safety or security. Montage Plus® offers the optional 3" space.



#### • Flush Bottom Rail Option

For some applications, a flush bottom rail may be necessary to meet local building codes or simply to meet an aesthetic preference.

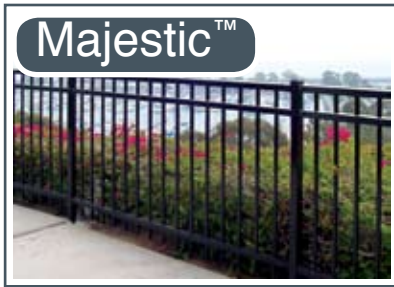
### WARRANTY

The E-Coat combination of galvanized steel, zinc phosphate pre-treatment, and epoxy and acrylic double coating provide the protection necessary to withstand adverse weathering effects and justify the 'best-in-the-business' 20 Year Warranty.

### COLORS, AVAILABILITY & MAINTENANCE

Montage Plus® color chip samples can be requested for actual color. Availability and maintenance information are the same as for the Aegis II® and Aegis Plus® steel fence systems.

Montage Plus® offers elegant style at an affordable price. Montage Plus® is the best choice for commercial projects that require perimeter fences.



## CONSTRUCTION SPECIFICATION

### SECTION 32 31 00 - ORNAMENTAL WELDED FENCING SYSTEM

#### Montage Plus® - Commercial Weight

#### 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 (specify Montage Plus ATF® standard picket space or Montage Plus® Pool, Pet & Play® 3" air space) Welded Ornamental Steel (for standard picket space, specify Invincible®, Classic™, Majestic™, or Genesis™, for 3" air space, specify 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 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 (specify Montage Plus ATF® standard picket space or Montage Plus® Pool, Pet & Play® 3" air space) Welded Ornamental Steel, (for standard picket space, specify Invincible®, Classic™, Majestic™, or Genesis™, for 3" air space, specify Classic™, Majestic™, or Genesis™) design, (specify extended picket or flush) bottom rail treatment, (specify 2-Rail, 3-Rail or 4-Rail or 3-Rail or 4-Rail with Coronas) style manufactured by Ameristar Fence Products, Inc., in Tulsa, Oklahoma.

Table 1 - Minimum Sizes for Montage Plus Gate Posts

Gate Opening	Gate Height		
	Up To & Including 4'	Over 4', Up To & Including 6'	Over 6', Up To & Including 8'
Up to & Including 4'	2-1/2" x 14 Ga.	3" x 12 Ga.	3" x 12 Ga.
Over 4', Up To & Including 6'	3" x 12 Ga.	3" x 12 Ga.	4" x 12 Ga.
Over 6', Up To & Including 8'	3" x 12 Ga.	4" x 12 Ga.	6" x 12 Ga.

#### 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 (310 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.

B. For fence systems up to and including 6' tall, material for pickets shall be 3/4" square x 17 Ga. tubing. For fence systems 7' and 8' tall, material for pickets shall be 3/4" square x 14 Ga. tubing. The rails shall be steel channel, 1.5" x 1.4375" x 14 Ga. Picket holes in the rail shall be spaced (specify 4.675" o.c. for standard picket space or 3.500" o.c. for 3" air space). For fence systems up to and including 6' tall, posts shall be a minimum of 2-1/2" square x 16 Ga. For fence systems 7' and 8' tall, posts shall be a minimum of 2-1/2" square x 14 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.

D. Gates shall be fabricated using welded ornamental panel material and gate ends having a 1-3/4" 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 according to Table 3, plus or minus 1/2". Fence panels shall be attached to posts with 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 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 1,500 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).

# AFFORDABLE PERIMETER SECURITY WITH GOOD LOOKS



American  
Made

## MONTAGE®

by



AMERISTAR®

[www.MONTAGEFENCE.COM](http://www.MONTAGEFENCE.COM)



American  
Owned

1555 N. Mingo Road  
Phone 1-888-333-3422

Tulsa, OK 74116  
Fax 1-877-926-3747

[www.ameristarfence.com](http://www.ameristarfence.com)

Email: [mktg@ameristarfence.com](mailto:mktg@ameristarfence.com)

Printed in USA Revised 08/08