

CONSTRUCTION SPECIFICATION
SECTION 02825 - ORNAMENTAL METAL FENCE SYSTEM
Echelon II™ - Industrial Aluminum

PART 1 - GENERAL

1.01 WORK INCLUDED

The contractor shall provide all labor, materials and appurtenances necessary for installation of the industrial ornamental aluminum 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 industrial ornamental aluminum fence system of the Ameristar® Echelon II™ (specify Classic™, Majestic™, Genesis™ or Invincible™) design. The system shall include all components (i.e., pickets, rails, 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 B117 - Practice for Operating Salt-Spray (Fog) Apparatus.

ASTM B221 - Standard Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles and Tubes.

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.

The industrial ornamental aluminum fence system shall conform to Ameristar® Echelon II™, (specify Classic™, Majestic™, Genesis™ or Invincible™) (specify 2-Rail, 3-Rail or 3-Rail with Rings) style manufactured by Ameristar® Fence Products, Inc., in Tulsa, Oklahoma.

PART 2 – MATERIALS

2.01 MANUFACTURER

The industrial ornamental aluminum fence system shall conform to Ameristar® Echelon II™, (specify Classic™, Majestic™, Genesis™ or Invincible™) (specify 2-Rail, 3-Rail or 3-Rail with Rings) style manufactured by Ameristar® Fence Products, Inc., in Tulsa, Oklahoma.

2.02 MATERIAL

A. Aluminum material for fence framework (i.e., tubular pickets, rails and posts) shall conform to the requirements of ASTM B221. The aluminum extrusions for posts and rails (outer channel) shall be Alloy and Temper Designation 6005-T5. The aluminum extrusions for pickets and rail inner slide channels shall be Alloy and Temper Designation 6063-T5.

B. The manufactured framework shall be subjected to the Ameristar® thermal stratification coating process (high-temperature, in-line, multi-stage, 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 or white). The stratification-coated framework shall be capable of meeting the performance requirements for each quality characteristic shown in Table 1.

C. Material for fence pickets shall be 1" square x 0.065" thick extruded tubing. The cross-sectional shape of the rails shall conform to the manufacturer's ForeRunner™ design with outside cross-section dimensions of 1.75" square. The top wall of the outer channel of the rail shall be 0.100" thick; the side walls shall be 0.120" thick for superior vertical load strength. The inner slide channel of the rail shall be 0.080" thick. Picket holes in the ForeRunner™ rail shall be spaced 4.98" o.c. Picket retaining rods shall be 0.125" diameter galvanized steel. Posts shall be a minimum of 2-1/2" square with a perimeter wall thickness of 0.080" and an interior reinforcing web thickness of 0.080". High quality PVC grommets shall be supplied to seal all picket-to-rail intersections.

D. All fasteners shall be stainless steel. Bracket to rail attachments shall be made using specially designed one-way tamperproof security bolts with inverted “t-nuts”. Bracket to post connections shall be made using self-drilling hex-head screws.

E. Aluminum castings shall be used for all rings, post caps, finials, and miscellaneous adornments.

2.03 FABRICATION

A. Pickets, rails and posts shall be pre-cut to specified lengths. ForeRunner™ rails shall be pre-punched to accept pickets.

B. The rail inner slide shall be fully inserted into the rail outer channel to form the raceway for the internal retaining rod. Grommets shall be inserted into the pre-punched holes in the rails, and pickets shall be inserted through the grommets so that pre-drilled picket holes align with the internal raceway of the two-part ForeRunner™ rails. (Note: This can best be accomplished by using an alignment template). Retaining rods shall be inserted into each ForeRunner™ rail so that they pass through the pre-drilled holes in each picket, thus completing the panel assembly.

C. Completed panels shall be capable of supporting a 300 lb. load (applied at midspan) without permanent deformation. Panels shall be biasable to a 25% change in grade.

D. Gates shall be fabricated using ForeRunner™ rail material and gate ends having the same outside cross-section (1.75" Square) as the rail. Gate ends shall be 0.125" thick; gate pickets shall be 0.080" thick. All rail and upright intersections shall be joined by welding. All picket and rail intersections shall also be joined either by welding or by the same retaining rod process used for panel assembly.

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 in accordance with the spacings shown in Table 2, plus or minus 1/2", depending on the nominal span specified. 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. Echelon II™ panels shall be attached to posts using mechanically fastened panel brackets supplied by the manufacturer.

3.03 CLEANING

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

Table 1 - Coating Performance Requirements

Quality Characteristics	ASTM Test Method	Performance Requirements
Adhesion	D3359 - Method B	Adhesion (Retention of Coating) over 90% of test area (Tape and knife test).
Corrosion Resistance	B117 & D1654	Corrosion Resistance over 3,000 hours (Scribed per D1654; failure mode is 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 2 - Post Spacing Requirements

Span	6' Nominal (67-3/4" Rail)				8' Nominal (92-5/8" Rail)			
	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"
Bracket	Rigid		Swivel		Rigid		Swivel	
Straight Picket Post Settings ± 1/2" O.C.	71-1/2"	72"	73"	73-1/2"	96"	96-1/2"	97-1/2"	98"
Curved Picket Post Settings ± 1/2" O.C.	75"	75-1/2"	76-1/2"	77"	94-1/2"	95"	96"	96-1/2"