

MONTAGE PLUS®



ORNAMENTAL STEEL FENCE

Montage Plus ornamental steel fence has the *versatility to fit many different project applications*. With its ability to *traverse varying grades*, variety of *distinct product styles* and unmatched coating performance, Montage Plus is the *preferred choice for ornamental fence*.



PRIMARY APPLICATIONS

- **Commercial Developments**
- **Self Storage**
- **Apartments (Multi-Family)**
- **Parks & Recreation**
- **Schools & Universities**



FENCE PRODUCTS

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ASSA ABLOY, the global leader in door opening solutions

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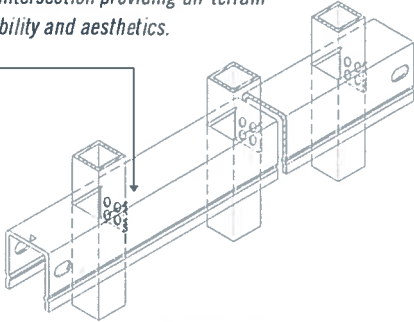
FIGURE 5

MONTAGE PLUS®

ORNAMENTAL STEEL FENCE

.75"sq x 18ga PICKETS | 1.4375" x 1.5" x 14ga RAILS | 2.5"sq x 16ga POSTS

Each picket is precisely welded at each rail intersection providing all-terrain flexibility and aesthetics.



STYLE OPTIONS



Also available in Pool, Pet & Play (3" air spacing) – styles vary

PROFUSION WELDED STEEL



All Montage fence panels are fabricated using Ameristar's ProFusion welding process. This technique combines laser and fusion technology to create a virtually invisible structural connection at every picket to rail intersection. Unlike typical aluminum fence systems that are held together with unsightly screws, the ProFusion weld used with Montage promotes a "good neighbor" profile with sleek lines and no exposed picket to rail fasteners. When compared to aluminum fencing, Montage's welded steel construction is unmatched in strength and durability.



E-COAT™ PROTECTIVE FINISH

Montage galvanized steel framework is subjected to a multi-stage pre-treatment/wash (with zinc phosphate), followed by a duplex cathodic electrocoat system consisting of an epoxy primer, which significantly increases corrosion protection, and an acrylic topcoat, which provides the protection necessary to withstand adverse weathering effects. This process results in years of maintenance-free ownership.



20 YEAR LIMITED WARRANTY

The Montage families of fencing products are manufactured from superior quality materials by skilled craftsmen with the highest standards of workmanship in the industry. Ameristar is confident in offering Montage with a 20 year limited warranty.



DOMESTIC MANUFACTURING

Ameristar is committed to providing products that are manufactured in the USA. We have made significant investments in technology, process improvement, and employee training in an effort to secure American jobs and combat inferior import products.

#DMP | REVISED 05/2014



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FIGURE 5

PASSPORT®



STEEL V-TRACK ROLL GATE DESIGN

Passport is an *innovative roll gate system* with a robust fabricated design. Its rigid framework enables the gate system to *glide effortlessly across its on-grade track*, and its *V-Track design provides the least amount of space required for a slide gate system*.



PRIMARY APPLICATIONS

- Water Treatment & Storage
- Municipal Facilities
- Government Facilities
- Airports
- Manufacturing Plants
- Petro & Chemical Facilities
- Power Plants & Substations
- Schools & Universities
- Stadiums & Event Centers



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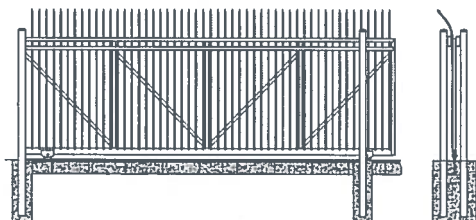
ASSA ABLOY

FIGURE 5

PASSPORT®

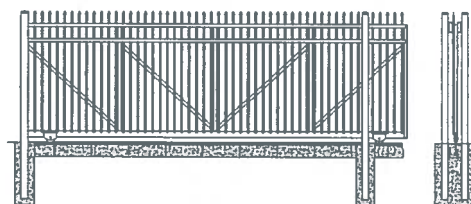
STEEL V-TRACK ROLL GATE DESIGN

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



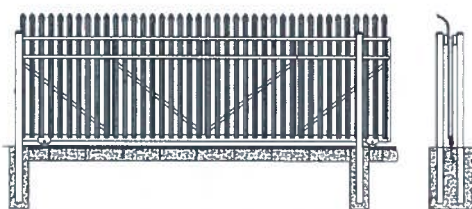
PASSPORT COMMERCIAL®

.75" Ornamental Picket Design | * Montage Commercial Invincible shown
Matches: Montage Plus | Montage Commercial



PASSPORT II®

1" Ornamental Picket Design | * Classic shown
Matches: Montage II

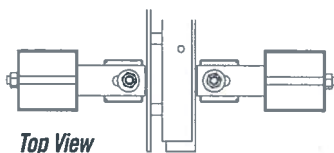


PASSPORT IS®

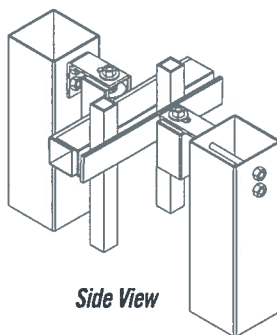
2.75" Ornamental Pale Design | * Gauntlet shown
Matches: Impasse II

GATE HARDWARE

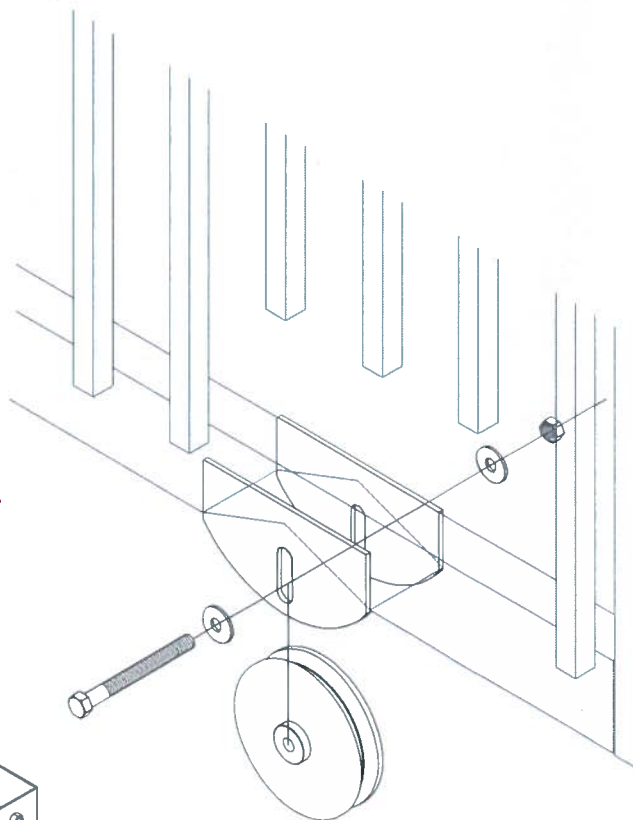
The Passport roll gate design has been matched with equally superior hardware. The v-track rollers are designed to support more than the recommended load, and provide an effortless balance that glides smoothly across its gate opening.



Top View



Side View



#9797 | REVISED 05/2014



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FIGURE 5

The Ameristar Family of Companies



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Automatic Gate Systems

Gate Solutions for Swing Gates and Slide Gates

Ameristar's team is a resource in providing information on automated gate systems that combine automatic gate operators and access controls from the industries' leading manufacturers to provide project specific solutions. These components coupled with an Ameristar gate help raise the bar in the industry by providing complete gate entry systems that meet ASTM F2200 and UL325 safety standards for automated gates.

For years, the fence and gate industry has been a separate trade from the operator and access control industry. This separation has made it difficult for specifiers and end users to make an informed decision about what products work best for a specific entry application. Ameristar's goal is to provide its customers with support in combining gate, operator & access controls. That is why we have invested in training our employees on best practices for safety and product selection. Ameristar's knowledgeable staff will be able to assist architects and engineers who are seeking assistance in gate entry layout and design, as well as direct specifiers to the appropriate products that best fit the required application.



The Ameristar Story

Ameristar®, based in Tulsa, Okla., is the largest ornamental fence manufacturer in the world. From its beginnings over a quarter-century ago Ameristar®...
Read more »

Our Mission

is to enhance the aesthetic appearance of modern fence products, promote ease of installation, while increasing strength & durability.

SAFETY Act Certification



Our Impasse and Stalwart lines are the only fence and barrier products in the world to be certified under the SAFETY Act by the US Department of Homeland Security... Read more »

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AMERISTAR FENCE PRODUCTS®
Montage Plus® - Steel Ornamental Fence System – Fusion Welded and Rackable
CONSTRUCTION SPECIFICATION - SECTION 32 31 19

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® standard picket space or Montage Plus® Pool, Pet & Play® 3" air space) **Welded and Rackable** (ATF – All Terrain Flexibility) Ornamental Steel (for standard picket space, specify Classic™, Majestic™, Genesis™, or Warrior™; 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 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.

1.08 PRODUCT WARRANTY

A. All structural fence components (i.e. rails, pickets, and posts) shall be warranted within specified limitations, by the manufacturer for a period of 20 years from date of original purchase. Warranty shall cover any defects in material finish, including cracking, peeling, chipping, blistering or corroding.

B. Reimbursement for labor necessary to restore or replace components that have been found to be defective under the terms of manufactures warranty shall be guaranteed for five (5) years from date of original purchase.

PART 2 - MATERIALS

2.01 MANUFACTURER

The fence system shall conform to (specify Montage Plus standard picket space or Montage Plus Pool, Pet & Play 3" air space) *Welded and Rackable* (ATF – All Terrain Flexibility) Ornamental Steel, (for standard picket space, specify Classic, Majestic, Genesis or Warrior; for 3" air space, specify Classic, Majestic, or Genesis) design, (specify extended picket or flush) bottom rail treatment, (specify 2-Rail, 3-Rail or 3-Rail with Double Rings) 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 0.60 oz/ft² (184 g/m²), Coating Designation G-60.

B. Material for pickets shall be 3/4" square x 18 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). Fence posts and gate posts shall meet the minimum size 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 electrode position 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 Commercial weight fences under ASTM F2408.

E. Gates with an out to out leaf dimension less than and including 72 inches shall be fabricated using Montage Plus ornamental panel material and 1-3/4" sq. x 14ga. gate ends. Gate leafs greater than 72 inches shall be fabricated using ForeRunner rails, 17 gauge pickets, intermediate uprights, gussets and 1-3/4" sq. x 14ga. gate ends. 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 post shall be spaced according to Table 3, plus or minus 1/4". 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 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 – Minimum Sizes for Montage Plus Posts

<u>Fence Posts</u>	<u>Panel Height</u>	
2-1/2" x 16 Ga.	Up to & Including 6' Height	
<u>Gate Leaf</u>	<u>Gate Height</u>	
	<u>Up to & Including 4'</u>	<u>Over 4' Up to & Including 6'</u>
Up to 4'	2-1/2" x 14 Ga.	3" x 12 Ga.
4'1" to 6'	3" x 12 Ga.	3" x 12 Ga.
6'1" to 8'	3" x 12 Ga.	4" x 12 Ga.

Table 2 – Coating Performance Requirements

<u>Quality Characteristics</u>	<u>ASTM Test Method</u>	<u>Performance Requirements</u>
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 Plus – Post Spacing By Bracket Type

Span	For CLASSIC, GENESIS, MAJESTIC, & WARRIOR 8' Nominal (91.95" Rail)					
Post Size	2-1/2"	2-1/2"	2-1/2"	3"	2-1/2"	3"
Bracket Type	Montage Plus Universal (BB112)	Montage Plus Line Blvd. (BB114)	Montage Plus Flat Mount (BB111)		Montage Plus Swivel (BB113)*	
Post Settings ± 1/4" O.C.	95"	95"	95"	95-1/2"	*95"	*95-1/2"

*Note: When using BB113 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.