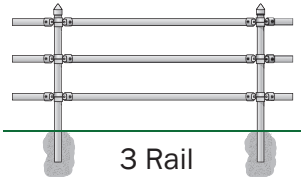
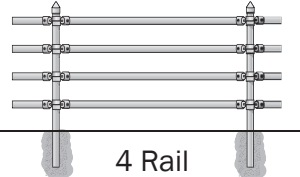


440® Ranch Fence

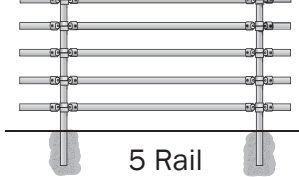
440 PIPE FENCE



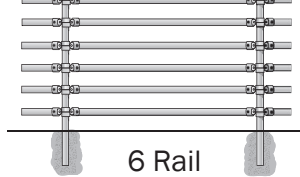
3 Rail
(10' OC)
(8' OC)
+ 1 Extra Post Per Line



4 Rail
(10' OC)
(8' OC)
+ 1 Extra Post Per Line

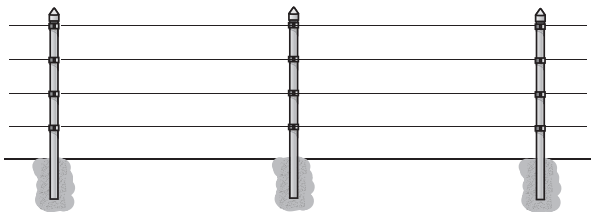


5 Rail
(10' OC)
(8' OC)
+ 1 Extra Post Per Line



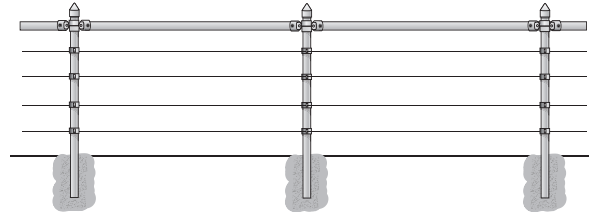
6 Rail
(10' OC)
(8' OC)
+ 1 Extra Post Per Line

BACK 40 WIRE ROPE CABLE FENCE



+ Pull Kits At Start & Every 500 Ft.
+ 1 Extra Post Per Line

BACK 40 PLUS PIPE & ROPE FENCE



+ Pull Kits At Start & Every 500 Ft.
+ 1 Extra Post Per Line

Use Pipe Fence Gates.

440 CORRALS & BREAKING PENS



60' Ø 4 Rail (200' Circumference)
(10' OC)/(8' OC)



60' Ø 5 Rail (200' Circumference)
(10' OC)/(8' OC)



60' Ø 6 Rail (200' Circumference)
(10' OC)/(8' OC)

10' OC Kits Include 10' Hingeless Gate; 8' OC Kits Include 8' Hingeless Gate

Effective: 06/20/13

440®

Ranch Fence

440Fence.com
PIPE FENCE FILLER SETS

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FAX: 1-918-879-5708

3 RAIL

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4P X 310		79
8' WIDTH	4P X 308		66



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each 10' Wide 440 Pipe Fence Filler Set Includes:

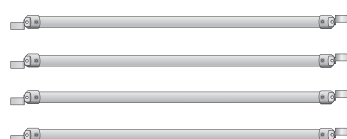
- 3 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 6 Universal Pipe Connector Brackets

Each 8' Wide 440 Pipe Fence Filler Set Includes:

- 3 Pieces 2-3/8" Dia. x 13 Ga. x 7'-6" Round Pipe
- 6 Universal Pipe Connector Brackets

4 RAIL

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4P X 410		106
8' WIDTH	4P X 408		88



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each 10' Wide 440 Pipe Fence Filler Set Includes:

- 4 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 8 Universal Pipe Connector Brackets

Each 8' Wide 440 Pipe Fence Filler Set Includes:

- 4 Pieces 2-3/8" Dia. x 13 Ga. x 7'-6" Round Pipe
- 8 Universal Pipe Connector Brackets

5 RAIL

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4P X 510		132
8' WIDTH	4P X 508		110



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each 10' Wide 440 Pipe Fence Filler Set Includes:

- 5 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 10 Universal Pipe Connector Brackets

Each 8' Wide 440 Pipe Fence Filler Set Includes:

- 5 Pieces 2-3/8" Dia. x 13 Ga. x 7'-6" Round Pipe
- 10 Universal Pipe Connector Brackets

6 RAIL

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4P X 610		158
8' WIDTH	4P X 608		132



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each 10' Wide 440 Pipe Fence Filler Set Includes:

- 6 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 12 Universal Pipe Connector Brackets

Each 8' Wide 440 Pipe Fence Filler Set Includes:

- 6 Pieces 2-3/8" Dia. x 13 Ga. x 7'-6" Round Pipe
- 12 Universal Pipe Connector Brackets

Effective: 06/20/13

440®
Ranch Fence

440Fence.com
BACK 40 WIRE ROPE FILLER SETS

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FAX: 1-918-879-5708

CABLE

ITEM	ITEM NUMBER	CATALOG PRICE	WEIGHT
Sleeved Cable	440CAB		.197/FT



Cable is 5/16" diameter with clear plastic sleeve.

CABLE BRACKET SET

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4W X 410		4

X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each 10' Back 40 Wire Rope Filler Set Includes:

- 4 Universal Single Eye Cable Brackets

IN-LINE PULL PANEL KITS

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4PL X 410		96



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each In-Line Pull Panel Kit Includes:

- 4 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 8 Universal Pipe Connector Brackets
- 8 Universal Single Eye Cable Brackets (Not Shown)
- 16 Cable Clamps (Not Shown)

Pull panel required at start and then every 500' or next terminal (end, gate or corner), whichever is less.

CORNER PULL PANEL KITS

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4PC X 410		191



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each In-Line Pull Panel Kit Includes:

- 8 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 16 Universal Pipe Connector Brackets
- 16 Universal Single Eye Cable Brackets (Not Shown)
- 16 Cable Clamps (Not Shown)

Corner panel required at every 90 degree turn in the fence line and at every significant change in direction and/or change of grade in fence line.

Effective: 06/20/13

440®
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440Fence.com
BACK 40 PLUS PIPE & ROPE FILLER SETS

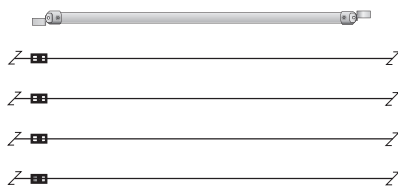
1-800-440-5889
FAX: 1-918-879-5708

CABLE

ITEM	ITEM NUMBER	CATALOG PRICE	WEIGHT
Sleeved Cable	440CAB		.197/FT

PIPE & CABLE BRACKET SET

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4B X 510		8.5



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each 10' Back 40 Wire Rope Filler Set Includes:

- 1 Piece 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 2 Universal Pipe Connector Brackets
- 4 Universal Single Eye Cable Brackets

Note: Minimum order is 10 Pipe & Cable Filler Sets (sufficient for 120' fence line that includes two 10' Pull Panels).

IN-LINE PULL PANEL KITS

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4PL X 510		118



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

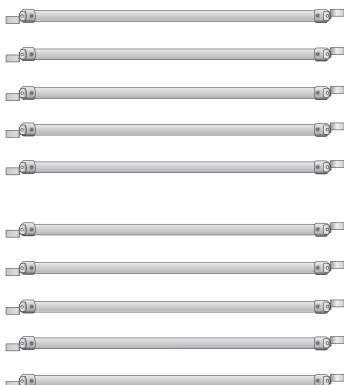
Each In-Line Pull Panel Kit Includes:

- 5 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 10 Universal Pipe Connector Brackets
- 8 Universal Single Eye Cable Brackets (Not Shown)
- 20 Cable Clamps (Not Shown)

Pull panel required at start and then every 500' or next terminal (end, gate or corner), whichever is less.

CORNER PULL PANEL KITS

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4PC X 510		235



X = COLOR SELECTION

B = BLACK

G = GREEN

N = BROWN

W = WHITE

Each In-Line Pull Panel Kit Includes:

- 10 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 20 Universal Pipe Connector Brackets
- 16 Universal Single Eye Cable Brackets (Not Shown)
- 20 Cable Clamps (Not Shown)

Corner panel required at every 90 degree turn in the fence line and at every significant change in direction and/or change of grade in fence line.

Effective: 06/20/13

440®
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CORRAL & BREAKING PEN KITS

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FAX: 1-918-879-5708

4 RAIL 60' CORRAL KIT

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4C X 46010-601		2599
8' WIDTH	4C X 46008-601		2752



X = COLOR SELECTION

B = BLACK
G = GREEN
N = BROWN
W = WHITE

Each 4 Rail 60' Corral Kit (10' O.C.) Includes:

- 20 Pieces 2-3/8" Dia. x 13 Ga. x 7'-6" Round Pipe
- 76 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 152 Universal Pipe Connector Brackets
- 20 Each 2-3/8" Dome Caps
- 1 Each 4-Rail Gate x 10' Opening • 1 Each Gate Latch
- 1 Each 2-7/8" Gate Post

Each 4 Rail 60' Corral Kit (8' O.C.) Includes:

- 121 Pieces 2-3/8" Dia. x 13 Ga. x 7'-6" Round Pipe
- 192 Universal Pipe Connector Brackets
- 25 Each 2-3/8" Dome Caps
- 1 Each 4-Rail Gate x 8' Opening • 1 Each Gate Latch
- 1 Each 2-7/8" Gate Post

5 RAIL 60' CORRAL KIT

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4C X 57210-601		3238
8' WIDTH	4C X 57208-601		3429



X = COLOR SELECTION

B = BLACK
G = GREEN
N = BROWN
W = WHITE

Each 5 Rail 60' Corral Kit (10' O.C.) Includes:

- 115 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 190 Universal Pipe Connector Brackets
- 20 Each 2-3/8" Dome Caps
- 1 Each 5-Rail Gate x 10' Opening • 1 Each Gate Latch
- 1 Each 2-7/8" Gate Post

Each 5 Rail 60' Corral Kit (8' O.C.) Includes:

- 120 Pieces 2-3/8" Dia. x 13 Ga. x 7'-6" Round Pipe
- 25 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 240 Universal Pipe Connector Brackets
- 25 Each 2-3/8" Dome Caps
- 1 Each 5-Rail Gate x 8' Opening • 1 Each Gate Latch
- 1 Each 2-7/8" Gate Post

6 RAIL 60' BREAKING PEN KIT

SECTION WIDTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
10' WIDTH	4C X 67210-601		3758
8' WIDTH	4C X 67208-601		3967



X = COLOR SELECTION

B = BLACK
G = GREEN
N = BROWN
W = WHITE

Each 6 Rail 60' Breaking Pen Kit (10' O.C.) Includes:

- 134 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 228 Universal Pipe Connector Brackets
- 20 Each 2-3/8" Dome Caps
- 1 Each 6-Rail Gate x 10' Opening • 1 Each Gate Latch
- 1 Each 2-7/8" Gate Post

Each 6 Rail 60' Breaking Pen Kit (8' O.C.) Includes:

- 144 Pieces 2-3/8" Dia. x 13 Ga. x 7'-6" Round Pipe
- 25 Pieces 2-3/8" Dia. x 13 Ga. x 9'-6" Round Pipe
- 288 Universal Pipe Connector Brackets
- 25 Each 2-3/8" Dome Caps
- 1 Each 6-Rail Gate x 8' Opening • 1 Each Gate Latch
- 1 Each 2-7/8" Gate Post

Effective: 06/20/13

440®
Ranch Fence

440Fence.com
440 ROUND POST KITS

1-800-440-5889
FAX: 1-918-879-5708

2-3/8" DIAMETER ROUND POSTS WITH DOME CAPS

POST LENGTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
7'-6"	4P X 090D		17.5
9'-6"	4P X 114D		22

X = **COLOR SELECTION**

B = BLACK

G = GREEN

N = BROWN

W = WHITE



Dome cap included with post

2-3/8" DIAMETER ROUND POSTS WITH BULLET CAPS

POST LENGTH	ITEM NUMBER	CATALOG PRICE	WEIGHT
7'-6"	4P X 090B		17.5
9'-6"	4P X 114B		22

X = **COLOR SELECTION**

B = BLACK

G = GREEN

N = BROWN

W = WHITE



Bullet cap included with post

POST CAPS*

ITEM	ITEM NUMBER	SIZE	CATALOG PRICE	WEIGHT
Dome Cap 	DC X 01	2-3/8" DIA		0.1
	DC X 04	4" DIA		0.25
Bullet Cap 	BC X 01	2-3/8" DIA		0.15

* Note: It is not necessary to buy caps, except for spares or replacements; caps are provided with fence posts (above) and with gate post.

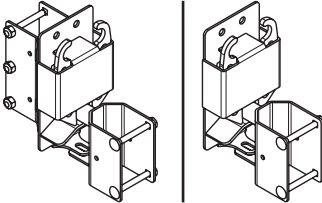
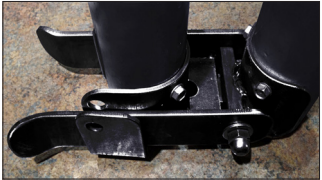
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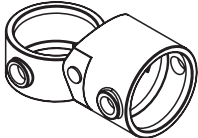
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440 HARDWARE & ACCESSORIES

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FAX: 1-918-879-5708

HARDWARE

ITEM	ITEM NUMBER	CATALOG PRICE	WEIGHT
Two-Way Drop Latch 440 Hingeless Gates  FLUSH MOUNT (L X 7000)	L X 470		7
	L X 7000		6.7
	X = COLOR SELECTION B = BLACK G = GREEN N = BROWN W = WHITE 2-way locking latch body and striker both fit over 2-3/8" diameter pipe. Available in all 4 colors.		
Double Gate Latch 440 Hingeless Gates 	L X 471		6
	X = COLOR SELECTION B = BLACK G = GREEN N = BROWN W = WHITE Double Gate latch yoke & receiver fit over 2-3/8" diameter pipe. Available in all 4 colors.		

BRACKETS & CONNECTORS

ITEM	ITEM NUMBER	CATALOG PRICE	WEIGHT
Universal Single Pipe Connector Bracket 	B X 441		2.2
	Universal pipe bracket connects 2-3/8" uprights to 2-3/8" rails. Rotates to any angle from post; pivots up to 45° up or down to follow grades.		
Universal Single Cable Connector Bracket 	B X 445		1
	Universal cable eye bracket fits over 2-3/8" uprights.		

CABLE & CABLE ACCESSORIES

ITEM	ITEM NUMBER	CATALOG PRICE	WEIGHT
Sleeved Cable 	440CAB		.197/FT
	Cable is 5/16" diameter with clear plastic sleeve.		
Cable Clamps 	4CC1		.21
	Clamp for 5/16" sleeved cable.		

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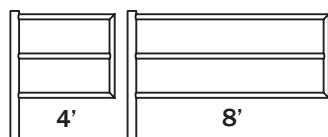
440®
Ranch Fence

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440 PIPE FENCE GATES

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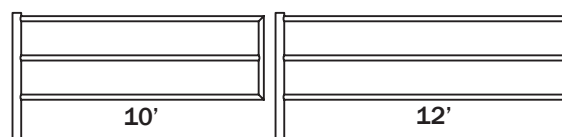
3 RAIL GATES (INCLUDES GATE POST)

NOMINAL OPENING	ITEM NUMBER	CATALOG PRICE	WEIGHT
4'	4P X 360-481		120
8'	4P X 360-961		144
10'	4P X 360-1201		158
12'	4P X 360-1441		172



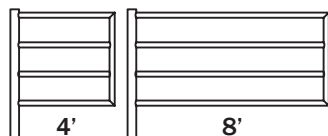
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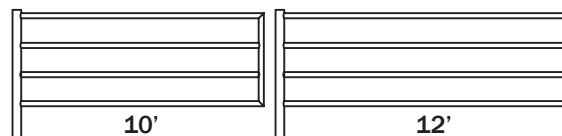
4 RAIL GATES (INCLUDES GATE POST)

NOMINAL OPENING	ITEM NUMBER	CATALOG PRICE	WEIGHT
4'	4P X 460-481		129
8'	4P X 460-961		161
10'	4P X 460-1201		180
12'	4P X 460-1441		198



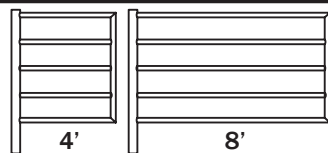
X = COLOR SELECTION

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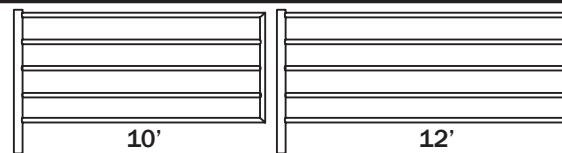
5 RAIL GATES (INCLUDES GATE POST)

NOMINAL OPENING	ITEM NUMBER	CATALOG PRICE	WEIGHT
4'	4P X 572-481		161
8'	4P X 572-961		202
10'	4P X 572-1201		225
12'	4P X 572-1441		248



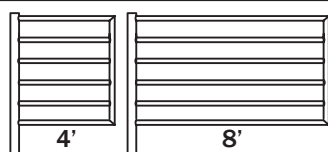
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W = WHITE



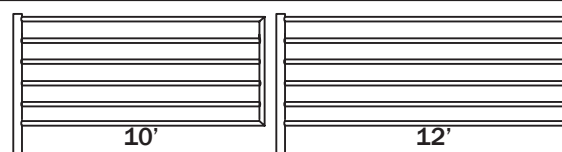
6 RAIL GATES (INCLUDES GATE POST)

NOMINAL OPENING	ITEM NUMBER	CATALOG PRICE	WEIGHT
4'	4P X 672-481		170
8'	4P X 672-961		219
10'	4P X 672-1201		246
12'	4P X 672-1441		274



X = COLOR SELECTION

B = BLACK
G = GREEN
N = BROWN
W = WHITE



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CONSTRUCTION SPECIFICATION

SECTION 32 31 00

440® Pipe Fence System

PART 1 - GENERAL

1.01 WORK INCLUDED

The contractor shall provide all labor, materials and appurtenances necessary for installation of the steel pipe 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 the Ameristar® 440® Pipe Fence (specify 3-rail, 4-rail, 5-rail, or 6-rail) design. The system shall include all components (i.e., panels, brackets, 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 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 fence system shall conform to Ameristar 440 Pipe Fence design, (specify 3-rail, 4-rail, 5-rail, or 6-rail) style manufactured by Ameristar Fence Products, Inc. in Tulsa, Oklahoma.

2.02 MATERIAL

A. Steel material for fence panels and posts shall be galvanized prior to forming in accordance with the requirements of ASTM A653/A653M.

B. Material for rails shall round steel pipe 2.375" diameter x 13 Ga. Posts shall be round steel pipe, 2.375" diameter x 13ga. Gate posts shall be round steel pipe 2.875" diameter x GBR40.

C. Post to rail connector bracket shall be zinc plated cast steel. Connector bracket shall swivel 45 degrees allowing rails to traverse inconsistent grade changes. Connector bracket should provide secure attachment to post and rail with an internal socket set screws.

2.03 FABRICATION

A. The manufactured rails, brackets, and posts shall be subjected to the Perma-Coat® thermal stratification coating process (high-temperature, in-line, multi-stage, multi-layer) including, as a minimum, a six-stage pretreatment/wash (with zinc phosphate), 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, Brown, White, or Green). The stratification-coated framework shall be capable of meeting the performance requirements for each quality characteristic shown in Table 1.

B. Posts shall be pre-cut to specified lengths. Rails shall be pre-cut to specified lengths, (specify 8' or 10') on center spacing.

E. Swing gates shall be fabricated using round steel pipe 2.375" diameter x 13ga. and 4" x 8ga. hingeless gate post. All intersections shall 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 FENCE INSTALLATION

Fence post shall be spaced according to manufacturer's installation details. 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 28" (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 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 manufacturer's 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 (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).

Effective: 06/20/13