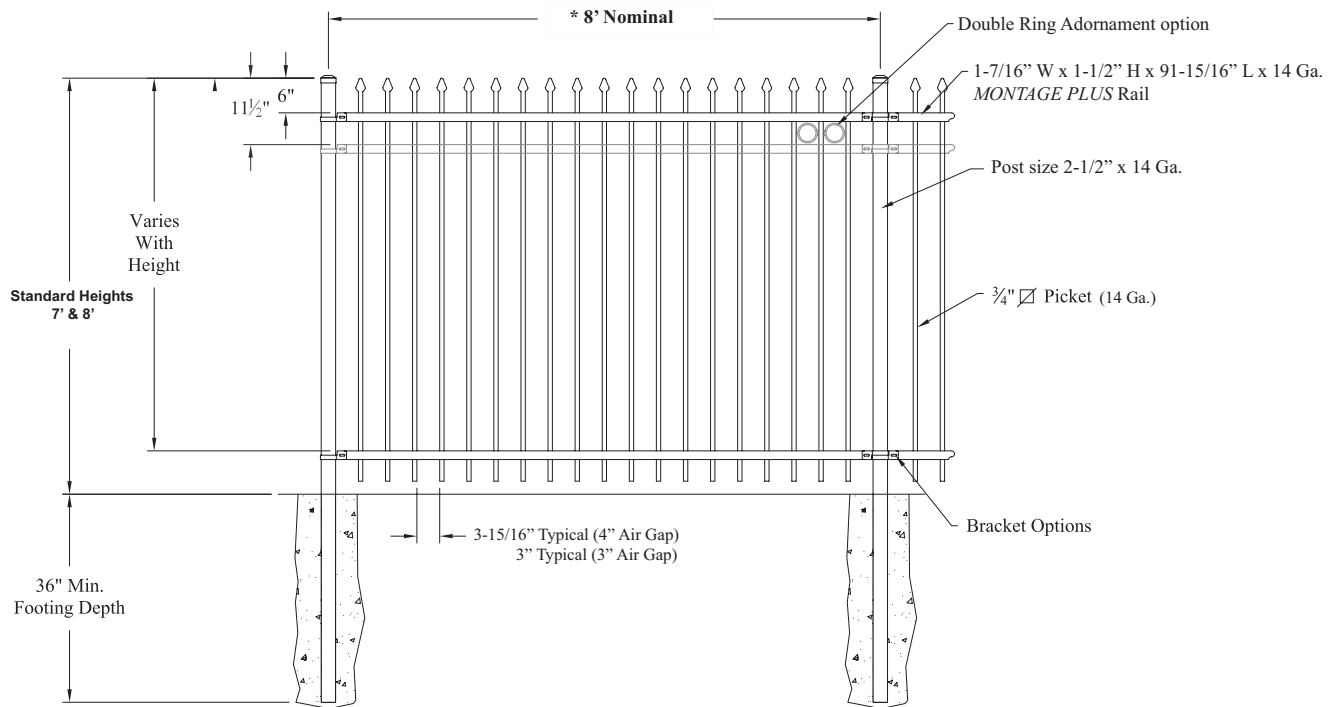


MONTAGE COMMERCIAL®

WELDED COMMERCIAL ORNAMENTAL FENCE

TYPICAL PANEL DRAWING (Classic Style shown; Genesis, Majestic and Invincible also available)



***Refer to Construction Specification
Table for recommended
(Post Spacing by Bracket Type)**

**E-COAT™
PROTECTION**

UNIQUE PROFUSION WELDING PROCESS
PATENT D466,620 6,811,145 7,071,439

**ATF™
RAKABLE DESIGN**
PATENT D466,621 7,071,439



- AUTOMATICALLY FUSION WELDED AT ALL INTERSECTIONS
- NO EXPOSED WELDS - VIRTUALLY SEAMLESS APPEARANCE
- GOOD NEIGHBOR PROFILE - SAME ON BOTH SIDES
- CONSISTENT HIGH QUALITY LEVEL - EVERY PANEL
- ZINC-PHOSPHATIZED GALVANIZED STEEL BASE MATERIAL



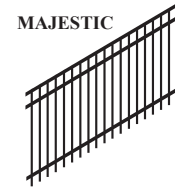
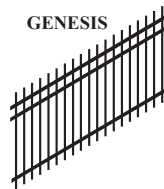
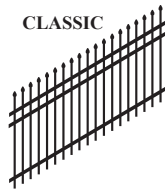
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MONTAGE COMMERCIAL® PANELS



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3-Rail (Standard) (4" Air Gap)

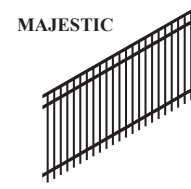
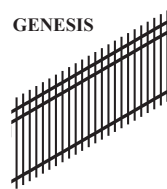
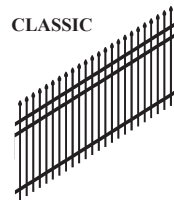


(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
7' H	1R * <u>X</u> 3828	114	25	MAJ, CLS/BLK
8' H	1R * <u>X</u> 3948	124	25	MAJ, CLS/BLK

STYLE SELECTION = * **X = COLOR SELECTION**
MAJESTIC = M B = BLACK
CLASSIC = C N = BRONZE
GENESIS = G

(8' Nominal) 92" Actual Panel Width
3/4" Sq x 14 Ga. Picket = (19 - Pickets per Panel)

(3" Air Gap)



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
7' H	1R * <u>X</u> 3828-3	135	25	N/A
8' H	1R * <u>X</u> 3948-3	148	25	N/A

STYLE SELECTION = * **X = COLOR SELECTION**
MAJESTIC = M B = BLACK
CLASSIC = C N = BRONZE
GENESIS = G

(8' Nominal) 92" Actual Panel Width
3/4" Sq x 14 Ga. Picket = (24 - Pickets per Panel)

* For Non-Stock Panels refer to Sales Policy.
* Genesis panels in both Black and Bronze are packaged with (Black) 3/4" Sq picket plugs.

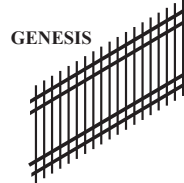
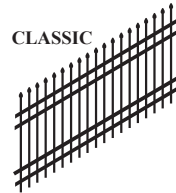
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MONTAGE COMMERCIAL® PANELS



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4-Rail (Standard) (4" Air Gap)

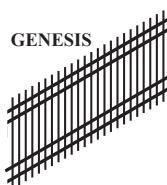
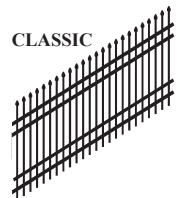


(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
7' H	1R * <u>X</u> 4828	121	25	N/A
8' H	1R * <u>X</u> 4948	132	25	N/A

STYLE SELECTION = * **X = COLOR SELECTION**
 MAJESTIC = M **B** = BLACK
 CLASSIC = C **N** = BRONZE
 GENESIS = G

(8' Nominal) 92" Actual Panel Width
 3/4" Sq x 14 Ga. Picket = (19 - Pickets per Panel)

(3" Air Gap)



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING STYLE/COLOR
7' H	1R * <u>X</u> 4828-3	143	25	N/A
8' H	1R * <u>X</u> 4948-3	156	25	N/A

STYLE SELECTION = * **X = COLOR SELECTION**
 MAJESTIC = M **B** = BLACK
 CLASSIC = C **N** = BRONZE
 GENESIS = G

(8' Nominal) 92" Actual Panel Width
 3/4" Sq x 14 Ga. Picket = (24 - Pickets per Panel)

* For Non-Stock Panels refer to Sales Policy.
 * Genesis panels in both Black and Bronze are packaged with (Black) 3/4" Sq picket plugs.

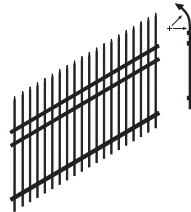
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MONTAGE COMMERCIAL® PANELS



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Invincible (3-Rail Standard) (4" Air Gap)



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING COLOR
7' H	1RI <u>X</u> 3828	116	25	BLK
8' H	1RI <u>X</u> 3948	129	25	BLK

X = COLOR SELECTION

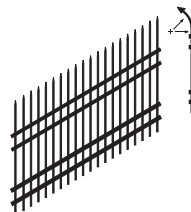
B = BLACK

N = BRONZE

(8' Nominal) 90-1/2" Actual Panel Width

3/4" Sq x 14 Ga. Picket = (20 - Pickets per Panel)

Invincible (4-Rail Standard) (4" Air Gap)



(NOMINAL) PANEL HEIGHT	ITEM NUMBER	PANEL WEIGHT	PALLET QUANTITY	STOCKING COLOR
7' H	1RI <u>X</u> 4828	124	25	N/A
8' H	1RI <u>X</u> 4948	137	25	N/A

X = COLOR SELECTION

B = BLACK

N = BRONZE

(8' Nominal) 90-1/2" Actual Panel Width

3/4" Sq x 14 Ga. Picket = (20 - Pickets per Panel)

* For Non-Stock Panels refer to Sales Policy.

Effective: 04/16/13

MONTAGE COMMERCIAL®

AMERISTAR®
FENCE PRODUCTS
WIND LOADING

1-888-333-3422
FAX: 1-877-926-3747

Montage Commercial Wind Load Capacity

Height	Rail Length	Post Size	Pickets With 3.925" Air Space		Pickets With 2.990" Air Space	
			Wind Load Capacity Factor (PSF)	Typical Wind Load Capacity (MPH)	Wind Load Capacity Factor (PSF)	Typical Wind Load Capacity (MPH)
7'	8'	2-½" Square x 14 Ga.	30	121	25	110
8'	8'	2-½" Square x 14 Ga.	24	107	20	98

Note: Mph calculated using ANSI/ASCE 7-02, "American Society of Civil Engineers Minimum Design Loads for Buildings and Other Structures", Exposure Category B (Urban and suburban areas, wooded areas, or other terrain with numerous closely spaced obstructions having the size of single family dwellings or larger). For wind loading applicable to a particular specification, consult the applicable Building Code.

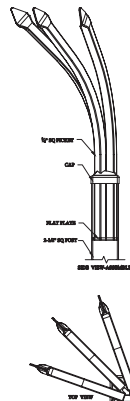
Note: Mph values shown are provided for information only. They are calculated according to ANSI/ASCE 7-05, "American Society for Civil Engineers Minimum Design Loads for Buildings and Other Structures", Exposure Category C (open terrain with scattered obstructions having lengths, generally less than 30 feet), based on post setting in 36" deep concrete footer in soil assumed to be of mid-range strength and compaction. Since specified project conditions such as jurisdictional building codes, elevation of installation, post base/footer design, soil strength, etc., may change from project to project, a structural engineering evaluation, unique to applicable requirements and conditions, should be performed. Consult with your Ameristar Service Representative for an estimate on Engineering Analysis and P.E. Certification.

MONTAGE COMMERCIAL®

POST ACCESSORIES



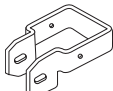
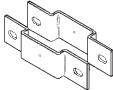
ITEM DESCRIPTION	PART NUMBER	PRICE EA	SIZE	BOX QTY	BOX WT
Post Cap Assembly for Invincible Outside Corners - Commercial	1RIB100		See Below	1	6
	Assembled kit fits over 2-1/2" square post. Three curved pickets radiate at equal angles to cover the space above the corner post.				



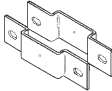
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BRACKETS

ITEM DESCRIPTION	BLACK		COLOR		SIZE	BAG QTY	BOX QTY	WT. EA.
	BLACK PART NO.	DEALER PRICE	BRONZE PART NO.	DEALER PRICE				
Montage Plus Universal Boulevard Bracket (Not for Invincible) 	BB112		BN112		2-1/2"	2	80	.15
Made from high strength steel. Works universally for lines, ends, and corners. Packaged 2 per bag with #14 x 3/4" self-drilling screws, 1/4" x 1-3/4" one-way bolts and 1/4" tee nuts. MUST BE ORDERED IN BAG QUANTITIES.  LINE  END  CORNER								
Montage Plus Line Bracket (Not for Invincible) 	BB114		BN114		2-1/2"	2	80	.84
Used as boulevard bracket around a post to join two adjacent panels in line. Packaged 2 per bag with #14 x 3/4" self-drilling screws, 1/4" x 1-3/4" one-way bolts and 1/4" tee nuts. MUST BE ORDERED IN BAG QUANTITIES.								
Montage Plus Swivel Bracket (Not for Invincible) 	BB113		BN113 (N/S)		-	2	80	.20
For oblique angles. Packaged 2 per bag with #10 x 3/4" self-drilling screws and #10 x 5/8" flat head phillips screws. MUST BE ORDERED IN BAG QUANTITIES.								
Montage Plus Flat Mount Bracket (Not for Invincible) 	BB111		BN111		-	2	204	.27
Can be used to attach panels to walls, wood posts, etc. Packaged 2 per bag with #14 x 3/4" self-drilling screws, 1/4" x 1-3/4" one-way bolts, 1/4" tee nuts and 1/4" drive rivets. MUST BE ORDERED IN BAG QUANTITIES.								

INVINCIBLE STYLE BRACKETS

Montage Plus Invincible Flat Mount Bracket 	BB118		BN118 (N/S)		-	2	100	.30
This bracket to be used for Montage Invincible style. Packaged 2 per bag with #14 x 3/4" self-drilling screws, 1/4" x 1-3/4" one-way bolts, 1/4" tee nuts and 1/4" drive rivets. MUST BE ORDERED IN BAG QUANTITIES.								
Montage Plus Invincible Line Bracket 	BB119		BN119 (N/S)		2-1/2"	2	48	.95
	BB120		BN120 (N/S)		3"	2	48	1.05
Used as boulevard bracket around a post to join two adjacent panels in line. Packaged 2 per bag with #14 x 3/4" self-drilling screws, 1/4" x 1-3/4" one-way bolts and 1/4" tee nuts. MUST BE ORDERED IN BAG QUANTITIES.								

N/S = Non Stock

Effective: 04/16/13

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ADORNMENTS

ITEM DESCRIPTION	BLACK		COLOR		SIZE	BOX QTY	WT. EA.
	BLACK PART NO.	DEALER PRICE	BRONZE PART NO.	DEALER PRICE			
Royalty 	AB525		AN525		3/4"	19	.21
Fits atop 3/4" square pickets (press-fit). Die cast aluminum. (19 required per panel on standard (4") picket spacing; 24 required per panel on condensed (3") picket spacing).							

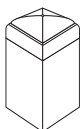
FASTENERS

ITEM DESCRIPTION	BLACK		COLOR		SIZE	BOX QTY	WT. EA.
	BLACK PART NO.	DEALER PRICE	BRONZE PART NO.	DEALER PRICE			
One-Way Bolts 	3HB300P-20		3HN300P		1/4" x 1-3/4"	20/Bag	.8
Steel washered one-way bolt for commercial brackets.							
Tee Nuts 	7157BP-20		7157NP		1/4"	20/Bag	.3
Steel tee nuts for commercial brackets.							
Self-Drilling Screws 	HB524P-50		HN524P		#14 x 3/4"	50/Bag	.6
	HB539P-50		HN539P		#10 x 3/4"	50/Bag	.35
Steel hex head self-drilling screws for commercial brackets.							
Flat Head Phillips Screws 	H519P		-----		#10 x 5/8"	1	.005
Steel flat head screw for setting angle on Montage Plus swivel brackets.							
Drive Rivets 	HB558P		HN558P		1/4"	1	.001
Drive rivets for flat mount brackets.							

CUSTOM FINISHES

ITEM DESCRIPTION	BLACK		COLOR		WT. EA.
	BLACK PART NO.	DEALER PRICE	BRONZE PART NO.	DEALER PRICE	
Paint Pen 	PB100		PN100		.5
Custom finishes in the two standard Montage Plus Commercial Fence colors.					
Zinc-Rich Paint Pen 	PZ100				.5
Priming required for cut steel edges prior to application of Ameristar Custom Finishes. NOTE: All cut rail ends must be seal coated with Zinc Rich Primer and Ameristar’s custom touch-up paint or the warranty is void.					
Spray Paint 	FB100		FN100		1.1
Custom finishes in the two standard Montage Plus Commercial Fence colors.					
Zinc-Rich Primer 	FZ100				1.1
Ideal for priming cut steel edges of Montage Plus Commercial Fence components prior to applying the appropriate custom finish color. NOTE: All cut rail ends must be seal coated with Zinc Rich Primer and Ameristar’s custom touch-up paint or the warranty is void.					

Effective: 04/16/13

**MONTAGE
COMMERCIAL®**1-888-333-3422
FAX: 1-877-926-3747**STEEL ORNAMENTAL SQUARE POST**

NOTE: In location subject to freezing, where posts are grouted into core-drilled holes, a 1/4" diameter hole should be drilled in the post approximately 1/2" above elevation to allow for drainage of built-up ground water. The drilled hole must be wiped clean and dry before applying Ameristar zinc primer and color finish.

X = COLOR SELECTIONB = BLACK
N = BRONZE
W = WHITE
S = SAND

Post Diameter	Ga. / Wall Thickness	Post Length	Item Number	Catalog Price (Black)	Catalog Price (Color)	Post Weight
2-1/2" SQ. (STEEL)	14 GA. (COMMERCIAL)	8'	WP <u>X</u> 25096-14			20
		9'	WP <u>X</u> 25108-14			23
		10'	WP <u>X</u> 25120-14			25
		11'	WP <u>X</u> 25132-14			27
	12 GA. (INDUSTRIAL)	7'	P <u>X</u> 25084			22
		8'	P <u>X</u> 25096			26
		9'	P <u>X</u> 25108			28
		10'	P <u>X</u> 25120			31
		11'	P <u>X</u> 25132			35
		12'	P <u>X</u> 25144			36
3" SQ. (STEEL)	12 GA. (INDUSTRIAL)	7'	P <u>X</u> 30084			30
		8'	P <u>X</u> 30096			34
		9'	P <u>X</u> 30108			39
		10'	P <u>X</u> 30120			43
		11'	P <u>X</u> 30132			47
		12'	P <u>X</u> 30144			51
4" SQ. (STEEL)	11 GA. (INDUSTRIAL)	7'	P <u>X</u> 40084			47
		8'	P <u>X</u> 40096			54
		9'	P <u>X</u> 40108			61
		10'	P <u>X</u> 40120			67
		11'	P <u>X</u> 40132			74
		12'	P <u>X</u> 40144			81
6" SQ. (STEEL)	3/16" WALL (INDUSTRIAL)	7'	P <u>X</u> 60084			102
		8'	P <u>X</u> 60096			116
		9'	P <u>X</u> 60108			131
		10'	P <u>X</u> 60120			145
		11'	P <u>X</u> 60132			160
		12'	P <u>X</u> 60144			174
8" SQ. (STEEL)	1/4" WALL (INDUSTRIAL)	9'	P <u>X</u> 80108			233
		10'	P <u>X</u> 80120			259
		11'	P <u>X</u> 80132			285
		12'	P <u>X</u> 80144			311

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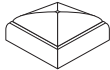
**MONTAGE
COMMERCIAL®**1-888-333-3422
FAX: 1-877-926-3747**STEEL PLATED ORNAMENTAL SQUARE POST**

Note: Plated posts used with Majestic & Conqueror styles may require a post length 1" longer than the panel/gate height dependent on the grade elevation.

X = COLOR SELECTIONB = BLACK
N = BRONZE
W = WHITE
S = SAND

Post Diameter	GA. / Plate Size	Post Length	Item Number	Catalog Price (Black)	Catalog Price (Color)	Post Weight
2-1/2" SQ. (STEEL)	12 GA. 5" x 5" SQ. 1/4" Thick with 9/16" Holes (8833G)	7'	P <u>X</u> 25084P			26
		8'	P <u>X</u> 25096P			28
		9'	P <u>X</u> 25108P			31
3" SQ. (STEEL)	12 GA. 6" x 6" SQ. 1/4" Thick with 9/16" Holes (5003G)	7'	P <u>X</u> 30084P			34
		8'	P <u>X</u> 30096P			39
		9'	P <u>X</u> 30108P			43
4" SQ. (STEEL)	11 GA. 8" x 8" SQ. 3/8" Thick with 9/16" Holes (8876G)	7'	P <u>X</u> 40084P			54
		8'	P <u>X</u> 40096P			61
		9'	P <u>X</u> 40108P			67

POST CAPS

X = COLOR SELECTION B = BLACK N = BRONZE W = WHITE S = SAND						
Cap Type	Cap Style	Size	Item Number	Catalog Price (Black)	Catalog Price (Color)	Cap Weight
STEEL 	STANDARD FLAT CAP	2-1/2" SQ.	A <u>X</u> 507			0.3
		3" SQ.	A <u>X</u> 508			0.3
		4" SQ.	A <u>X</u> 509			0.4
		6" SQ.	A <u>X</u> 515			0.8
		8" SQ.	A <u>X</u> 801			2
ALUMINUM 	BALL CAP	2-1/2" SQ.	A <u>X</u> 513			0.7
		3" SQ.	A <u>X</u> 516			0.8
		4" SQ.	A <u>X</u> 517			2
		6" SQ.	A <u>X</u> 521			8

Effective: 04/16/13

AMERISTAR FENCE PRODUCTS®

Montage Commercial® – Commercial 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 Commercial® standard picket space or Montage Commercial® Pool, Pet & Play® 3" air space) Welded and Rackable (ATF – All Terrain Flexibility) Ornamental Steel (for standard picket space, specify Classic™, Majestic™, Genesis™, or Invincible™; for 3" air space, specify Classic™, Majestic™, or Genesis™) design. The ornamental fence system shall be (specify 7' height or 8' height) from grade. 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. 0020
- 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 Commercial standard picket space or Montage Commercial Pool, Pet & Play 3" air space) Welded and Rackable (ATF – All Terrain Flexibility) Ornamental Steel, (for standard picket space, specify Classic, Majestic, Genesis, or Invincible; for 3" air space, specify Classic, Majestic, or Genesis) design, (specify extended picket or flush) bottom rail treatment, (specify 3-Rail, 4-Rail, or 3-Rail with Double Rings, 4-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 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). 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 Industrial weight fences under ASTM F2408.

E. Gates shall be fabricated using fusion welded ornamental panel material 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.

Effective: 04/16/13

AMERISTAR FENCE PRODUCTS®

Montage Commercial® – Commercial Steel Ornamental Fence System – Fusion Welded and Rackable
CONSTRUCTION SPECIFICATION - SECTION 32 31 19

Table 1 – Minimum Sizes for Montage Commercial Posts

Fence Posts	Panel Height
2-1/2" x 14 Ga.	7' & 8' Heights
Gate Leaf	Gate Height
	7' & 8' Heights
Up to 4'	3" x 12 Ga.
4'1" to 6'	4" x 12 Ga.
6'1" to 16'	6" x 12 Ga.

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 Commercial – Post Spacing By Bracket Type

Span	For INVINCIBLE® 8' Nominal (90.445" Rail)				For CLASSIC, GENESIS, & MAJESTIC 8' Nominal (91.95" Rail)					
Post Size	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"
Bracket Type	Montage Commercial Invincible Flat Mount (BB118)		Montage Commercial Invincible Line 2-1/2" (BB119) 3" (BB120)		Montage Commercial Universal (BB112)	Montage Commercial Line Blvd. (BB114)	Montage Commercial Flat Mount (BB111)		Montage Commercial Swivel (BB113)*	
Post Settings ± 1/4" O.C.	94"	94-1/2"	94"	94-1/2"	95"	95"	95"	95-1/2"	*95"	*95-1/2"

*Note: When using BB304 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.

MONTAGE COMMERCIAL® / WARRANTY WELDED ORNAMENTAL FENCE

Ameristar's Montage Commercial® welded ornamental fences are manufactured from the highest quality materials by skilled craftsmen to meet the highest standards of workmanship in the industry. Galvanized steel framework is subjected to a multi-stage pretreatment/wash (with zinc phosphate), followed by a duplex cathodic electro-coat system consisting of an epoxy primer, which significantly increases corrosion protection, and an acrylic liquid topcoat, which provides the protection necessary to withstand adverse weathering effects.

The electro-coated surface on all Montage Commercial welded ornamental panels and posts, are guaranteed under normal and intended usage, against cracking, peeling, chipping, blistering or corroding commencing with the original purchase date and extending according to the applications defined in the table below. Normal and intended usage does not include physical damage, abrasion, or heavy salt spray exposure to the protective coating.

The following acts and/or omissions will void the subject warranty:

- Damage to the product caused by the property owner by use of landscape, gardening equipment, chemicals that may cause damage, and/or water sprinklers with high mineral content;
- Damage caused by adhesion of chicken wire, chain link mesh, welded wire, or other similar substance to the product;
- Damage caused by allowing plant life of any sort to grow directly upon or in contact with any portion of the product or sap from trees;
- Any alteration to the product itself by the property owner including any on-site cutting or welding; and/or, failure to follow any and all maintenance instructions provided by Ameristar® at the time of sale to the original purchaser even if these instructions are not forwarded to the ultimate claimant under this warranty.
- When cutting Montage Commercial immediately seal the exposed surfaces by 1) Removing all metal shavings from the cut area 2) Applying zinc-rich primer to thoroughly cover cut edge and drilled hole and, after letting dry 3) Applying two (2) coats of custom finish spray paint matching fence color. Failure to seal exposed surfaces per steps 1-3 above will negate warranty.
- If contractor uses non-Ameristar parts/components this will negate the warranty.

Ameristar Montage Commercial welded ornamental fences are also guaranteed for the same period of time against defects in workmanship or materials. Should any Montage Commercial welded ornamental panel or post manufactured by Ameristar fail in accordance with any of the above conditions, Ameristar warrants to the original purchaser their redemption through replacement, renewal or issuance of a pro-rated credit. The choice of redemption method is solely at the discretion of Ameristar. If the pro-rated alternative is chosen, the amount will be based on the original cost of materials at the date of purchase multiplied by the appropriate time and exposure factor from the table below:

<u>Application</u>	<u>Length of Warranty</u>
Fence Installations 0 to 1 Mile from Salt Water Coast Line	5 Years
Fence Installations 1 Mile to 10 Miles from Salt Water Coast Line	10 Years
Fence Installations Over 10 Miles from Salt Water Coast Line	20 Years

Note: Regardless of location and years in service, evidence of historical salt spray exposure shall be considered as grounds to void any warranty obligations.

Notice of failure under the conditions of this warranty shall be sent to Ameristar or its authorized representative, in writing, together with proof of purchase and shall specify the nature of the defect and when it was first observed as well as photographs of current site conditions. Should the fence be improperly installed, Ameristar shall not be responsible for guaranteed performance or appearance of the material. Neither does this guarantee apply when failure or damage is due to improper use or application, abuse or misuse, salt spray exposure (see Table and Note above), vandalism, or acts of God. Ameristar reserves the right to inspect the material to determine validity of the claim.

Upon acceptance of the claim by Ameristar or its authorized representative, redemption by replacement, renewal or issuance of a pro-rated credit shall be made by Ameristar. Reimbursement for labor necessary to restore and/or replace components that have been found defective under the terms of this warranty is guaranteed to the original purchaser for a period of five (5) years from the original purchase date. Ameristar reserves the right to select the qualified company or individual to perform the labor to repair or replace the components that are deemed to be defective under the terms of this warranty.

The above constitutes the complete warranty by the manufacturer. No other agreement, written or implied, is valid. Ameristar Fence Products does not authorize any other person or agent to make any other express warranties. Ameristar neither assumes nor authorizes any other person or agent to assume any other liability in connection with the Montage Commercial welded ornamental fence system.



AMERISTAR®
FENCE PRODUCTS

1555 N. MINGO RD., TULSA, OK 74116
WWW.AMERISTARFENCE.COM

MONTAGE COMMERCIAL® SWING GATES



1-888-333-3422
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GATE SPECIFICATIONS

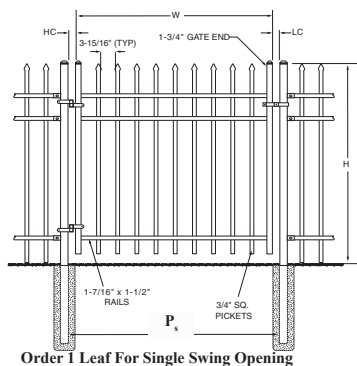
Construction Components for Nominal Gate
Openings of 3-1/2' thru 8':

Gate Ends: 1-3/4" Sq. (14 Ga.) Steel
Rails: 1-7/16" W x 1-1/2" H (14 Ga.) Steel
Pickets: 3/4" Sq. (14 Ga.)

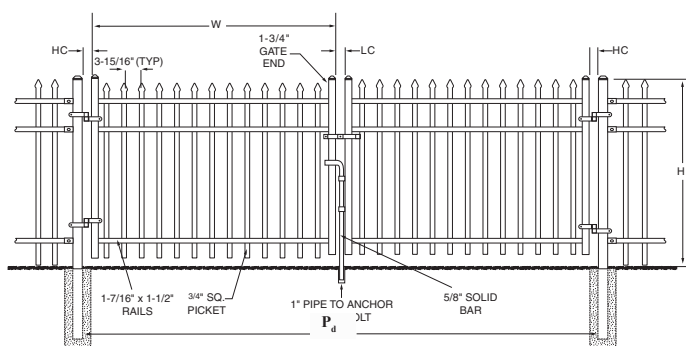
Construction Components for Nominal Gate
Openings of 9' thru 16':

Gate Ends: 1-3/4" Sq. (14 Ga.) Steel
Rails: 1-1/2" W x 1-1/2" H (14 Ga.) Steel
Pickets: 3/4" Sq. (14 Ga.)
(With gusset plates and cable kit)

GATE DRAWING DIMENSIONAL FORMAT



Order 1 Leaf For Single Swing Opening



Order 2 Leaves For Double Swing Opening

W = Outside To Outside Width of Finished Gate Leaf

H = Height; HC = Hinge Clearance; LC = Latch Clearance;

P_s = Gate Post Spacing (Inside-To-Inside) for Single Gate; P_d = Gate Post Spacing (Inside-To-Inside) for Double Gate

See Montage Commercial Specification for Montage Commercial Gate Post Recommendation

HARDWARE KITS & POST INTERSPACES FOR MONTAGE PLUS SINGLE SWING WELDED STEEL GATES						
NOMINAL GATE OPENING	3-1/2'	4'	5'	6'	7'	8'
W = LEAF WIDTH	40"	49-1/2"	58-3/4"	68"	86-3/4"	95-1/2"
FORK LATCH/BOX HINGE KITS #SGBSX25 OR #SGBSX3	HC	2"				
	LC	2"				
	P _s	44"	53-1/2"	62-3/4"	72"	90-3/4"
AMERISTAR LOCK/BOX HINGE KIT #SGBSXA	HC	2"				
	LC	5/8"				
	P _s	42-5/8"	52-1/8"	61-3/8"	70-5/8"	89-3/8"
LOKKLATCH WITH TRU-CLOSE HINGE KIT #TCSGK	HC	3/4"				
	LC	3/4"				
	P _s	41-1/2"	51"	60-1/4"	69-1/2"	88-1/4"
TOP PULL LATCH WITH TRU-CLOSE HINGE KIT #TCPGK	HC	3/4"				
	LC	3/4"				
	P _s	41-1/2"	51"	60-1/4"	69-1/2"	88-1/4"
COMMERCIAL HINGE WITH STRONGARM KIT #CGBS-25, #CGBS-3 OR #CGBS-4	HC	1"				
	LC	3"				
	P _s	44"	53-1/2"	62-3/4"	72"	90-3/4"
HEAVY COMMERCIAL HINGE KIT #HGBS-25, #HGBS-3 OR #HGBS-4	HC	1-1/4"				
	LC	3"				
	P _s	44-1/4"	53-3/4"	63"	72-1/4"	91"
P _s (Gate Post Spacing (Inside-To-Inside) for Single Gate = HC (Hinge Clearance) + W (Out-To-Out Gate Width) + LC (Latch Clearance))						

HARDWARE KITS & POST INTERSPACES FOR MONTAGE PLUS DOUBLE SWING WELDED STEEL GATES						
NOMINAL GATE OPENING	7'	8'	10'	12'	14'	16'
W = LEAF WIDTH	40"	49-1/2"	58-3/4"	68"	86-3/4"	95-1/2"
FORK LATCH / BOX HINGE KIT #SGBDX	HC	2"				
	LC	2"				
	P _s	86"	105"	123-1/2"	142"	179-1/2"
COMMERCIAL HINGE WITH STRONG ARM KIT #CGBD	HC	1"				
	LC	2"				
	P _s	84"	103"	121-1/2"	140"	177-1/2"
HEAVY COMMERCIAL HINGE KIT #HGBD	HC	1-1/4"				
	LC	2"				
	P _s	84-1/2"	103-1/2"	122"	140-1/2"	178"
P _d (Gate Post Spacing (Inside-To-Inside) for Double Gate = 2 x HC (Hinge Clearance) + 2 x W (Out-To-Out Gate Width) + LC (Latch Clearance))						

Effective: 04/16/13

MONTAGE COMMERCIAL® SWING GATES



1-888-333-3422
FAX: 1-877-926-3747

3-Rail (Standard) (4" Air Gap)						
CLASSIC GENESIS MAJESTIC						
(NOMINAL) GATE HEIGHT	(NOMINAL) GATE OPENING	(ACTUAL) GATE LEAF WIDTH	ITEM NUMBER	GATE WEIGHT	PICKET QTY	STOCKING STYLE/COLOR
7' H	3-1/2'	40"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-42	65	7	N/A
	4'	49-1/2"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-48	77	9	N/A
	5'	58-3/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-60	88	11	N/A
	6'	68"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-72	100	13	N/A
	7'	86-3/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-84	118	17	N/A
	8'	95-1/2"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-96	130	19	N/A
	9'	105-1/2"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-108	177	21	N/A
	10'	114-3/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-120	200	23	N/A
	11'	133-1/2"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-132	236	27	N/A
	12'	143"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-144	272	29	N/A
	13'	152-1/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-156	282	31	N/A
	14'	171"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-168	292	35	N/A
8' H	15'	180-1/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-180	309	37	N/A
	16'	189-3/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 382-192	325	39	N/A
	3-1/2'	40"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-42	73	7	N/A
	4'	49-1/2"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-48	86	9	N/A
	5'	58-3/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-60	99	11	N/A
	6'	68"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-72	112	13	N/A
	7'	86-3/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-84	132	17	N/A
	8'	95-1/2"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-96	145	19	N/A
	9'	105-1/2"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-108	193	21	N/A
	10'	114-3/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-120	220	23	N/A
	11'	133-1/2"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-132	266	27	N/A
	12'	143"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-144	288	29	N/A
	13'	152-1/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-156	302	31	N/A
	14'	171"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-168	320	35	N/A
	15'	180-1/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-180	338	37	N/A
	16'	189-3/4"	1W $\frac{*}{-}$ $\frac{X}{-}$ 394-192	356	39	N/A

STYLE SELECTION =

MAJESTIC = $\frac{M}{-}$

CLASSIC = $\frac{C}{-}$

GENESIS = $\frac{G}{-}$

= COLOR SELECTION

$\frac{B}{-}$ = BLACK

$\frac{N}{-}$ = BRONZE

For additional strength; all gate leaves greater than 6 feet in width will have an intermediate center upright, gusset plates will be welded in all four corners, and the appropriate quantity of turnbuckle and cable kits will be included.
Custom gate dimensions are available upon request, but incur a 10% engineering charge based on the nearest larger standard gate leaf.

Effective: 04/16/13

MONTAGE COMMERCIAL® SWING GATES



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MONTAGE
COMMERCIAL

3-Rail (Standard) (3" Air Gap)

CLASSIC



GENESIS



MAJESTIC



(NOMINAL) GATE HEIGHT	(NOMINAL) GATE OPENING	(ACTUAL) GATE LEAF WIDTH	ITEM NUMBER	GATE WEIGHT	PICKET QTY	STOCKING STYLE/COLOR
7' H	3-1/2'	40"	1R <u> </u> <u> </u> 382-42	74	9	N/A
	4'	49-1/2"	1R <u> </u> <u> </u> 382-48	86	12	N/A
	5'	58-3/4"	1R <u> </u> <u> </u> 382-60	100	14	N/A
	6'	68"	1R <u> </u> <u> </u> 382-72	117	17	N/A
	7'	86-3/4"	1R <u> </u> <u> </u> 382-84	136	22	N/A
	8'	95-1/2"	1R <u> </u> <u> </u> 382-96	152	24	N/A
8' H	3-1/2'	40"	1R <u> </u> <u> </u> 394-42	83	9	N/A
	4'	49-1/2"	1R <u> </u> <u> </u> 394-48	96	12	N/A
	5'	58-3/4"	1R <u> </u> <u> </u> 394-60	112	14	N/A
	6'	68"	1R <u> </u> <u> </u> 394-72	132	17	N/A
	7'	86-3/4"	1R <u> </u> <u> </u> 394-84	152	22	N/A
	8'	95-1/2"	1R <u> </u> <u> </u> 394-96	170	24	N/A

STYLE SELECTION = = COLOR SELECTION
MAJESTIC = M B = BLACK
CLASSIC = C N = BRONZE
GENESIS = G

For additional strength; all gate leaves greater than 6 feet in width will have an intermediate center upright, gusset plates will be welded in all four corners, and the appropriate quantity of turnbuckle and cable kits will be included.
Custom gate dimensions are available upon request, but incur a 10% engineering charge based on the nearest larger standard gate leaf.

Effective: 04/16/13

MONTAGE COMMERCIAL® SWING GATES



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4-Rail (Standard) (4" Air Gap)						
CLASSIC		GENESIS		MAJESTIC		
(NOMINAL) GATE HEIGHT	(NOMINAL) GATE OPENING	(ACTUAL) GATE LEAF WIDTH	ITEM NUMBER	GATE WEIGHT	PICKET QTY	STOCKING STYLE/COLOR
7' H	3-1/2'	40"	1W $\frac{1}{2}$ X 482-42	69	7	N/A
	4'	49-1/2"	1W $\frac{1}{2}$ X 482-48	81	9	N/A
	5'	58-3/4"	1W $\frac{1}{2}$ X 482-60	93	11	N/A
	6'	68"	1W $\frac{1}{2}$ X 482-72	106	13	N/A
	7'	86-3/4"	1W $\frac{1}{2}$ X 482-84	126	17	N/A
	8'	95-1/2"	1W $\frac{1}{2}$ X 482-96	138	19	N/A
	9'	105-1/2"	1W $\frac{1}{2}$ X 482-108	194	21	N/A
	10'	114-3/4"	1W $\frac{1}{2}$ X 482-120	222	23	N/A
	11'	133-1/2"	1W $\frac{1}{2}$ X 482-132	260	27	N/A
	12'	143"	1W $\frac{1}{2}$ X 482-144	299	29	N/A
	13'	152-1/4"	1W $\frac{1}{2}$ X 482-156	310	31	N/A
	14'	171"	1W $\frac{1}{2}$ X 482-168	322	35	N/A
8' H	15'	180-1/4"	1W $\frac{1}{2}$ X 482-180	342	37	N/A
	16'	189-3/4"	1W $\frac{1}{2}$ X 482-192	361	39	N/A
	3-1/2'	40"	1W $\frac{1}{2}$ X 494-42	77	7	N/A
	4'	49-1/2"	1W $\frac{1}{2}$ X 494-48	90	9	N/A
	5'	58-3/4"	1W $\frac{1}{2}$ X 494-60	104	11	N/A
	6'	68"	1W $\frac{1}{2}$ X 494-72	118	13	N/A
	7'	86-3/4"	1W $\frac{1}{2}$ X 494-84	140	17	N/A
	8'	95-1/2"	1W $\frac{1}{2}$ X 494-96	153	19	N/A
	9'	105-1/2"	1W $\frac{1}{2}$ X 494-108	210	21	N/A
	10'	114-3/4"	1W $\frac{1}{2}$ X 494-120	242	23	N/A
	11'	133-1/2"	1W $\frac{1}{2}$ X 494-132	290	27	N/A
	12'	143"	1W $\frac{1}{2}$ X 494-144	315	29	N/A
	13'	152-1/4"	1W $\frac{1}{2}$ X 494-156	330	31	N/A
	14'	171"	1W $\frac{1}{2}$ X 494-168	350	35	N/A
	15'	180-1/4"	1W $\frac{1}{2}$ X 494-180	371	37	N/A
	16'	189-3/4"	1W $\frac{1}{2}$ X 494-192	392	39	N/A
STYLE SELECTION = $\frac{1}{2}$ X = COLOR SELECTION MAJESTIC = M B = BLACK CLASSIC = C N = BRONZE GENESIS = G For additional strength; all gate leaves greater than 6 feet in width will have an intermediate center upright, gusset plates will be welded in all four corners, and the appropriate quantity of turnbuckle and cable kits will be included. Custom gate dimensions are available upon request, but incur a 10% engineering charge based on the nearest larger standard gate leaf.						

Effective: 04/16/13

MONTAGE COMMERCIAL®
SWING GATES

AMERISTAR®
FENCE PRODUCTS

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4-Rail (Standard) (3" Air Gap)						
CLASSIC GENESIS MAJESTIC						
(NOMINAL) GATE HEIGHT	(NOMINAL) GATE OPENING	(ACTUAL) GATE LEAF WIDTH	ITEM NUMBER	GATE WEIGHT	PICKET QTY	STOCKING STYLE/COLOR
7' H	3-1/2'	40"	1R $\frac{*}{X}$ 482-42	78	9	N/A
	4'	49-1/2"	1R $\frac{*}{X}$ 482-48	90	12	N/A
	5'	58-3/4"	1R $\frac{*}{X}$ 482-60	107	14	N/A
	6'	68"	1R $\frac{*}{X}$ 482-72	123	17	N/A
	7'	86-3/4"	1R $\frac{*}{X}$ 482-84	144	22	N/A
	8'	95-1/2"	1R $\frac{*}{X}$ 482-96	160	24	N/A
8' H	3-1/2'	40"	1R $\frac{*}{X}$ 494-42	87	9	N/A
	4'	49-1/2"	1R $\frac{*}{X}$ 494-48	101	12	N/A
	5'	58-3/4"	1R $\frac{*}{X}$ 494-60	119	14	N/A
	6'	68"	1R $\frac{*}{X}$ 494-72	138	17	N/A
	7'	86-3/4"	1R $\frac{*}{X}$ 494-84	160	22	N/A
	8'	95-1/2"	1R $\frac{*}{X}$ 494-96	179	24	N/A
STYLE SELECTION = $\frac{*}{X}$ = COLOR SELECTION MAJESTIC = $\frac{M}{B}$ = BLACK CLASSIC = $\frac{C}{N}$ = BRONZE GENESIS = $\frac{G}{G}$ For additional strength; all gate leaves greater than 6 feet in width will have an intermediate center upright, gusset plates will be welded in all four corners, and the appropriate quantity of turnbuckle and cable kits will be included. Custom gate dimensions are available upon request, but incur a 10% engineering charge based on the nearest larger standard gate leaf.						

Effective: 04/16/13

MONTAGE COMMERCIAL® SWING GATES



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FAX: 1-877-926-3747

Invincible 3-Rail (Standard) (4" Air Gap)



(NOMINAL) GATE HEIGHT	(NOMINAL) GATE OPENING	(ACTUAL) GATE LEAF WIDTH	ITEM NUMBER	GATE WEIGHT	PICKET QTY	STOCKING COLOR
7' H	3-1/2'	40"	1WI X 382-42	68	8	N/A
	4'	49-1/2"	1WI X 382-48	80	10	N/A
	5'	58-3/4"	1WI X 382-60	92	12	N/A
	6'	68"	1WI X 382-72	108	14	N/A
	7'	86-3/4"	1WI X 382-84	123	18	N/A
	8'	95-1/2"	1WI X 382-96	139	20	N/A
	9'	105-1/2"	1WI X 382-108	181	22	N/A
	10'	114-3/4"	1WI X 382-120	203	24	N/A
	11'	133-1/2"	1WI X 382-132	240	28	N/A
	12'	143"	1WI X 382-144	276	30	N/A
	13'	152-1/4"	1WI X 382-156	286	32	N/A
	14'	171"	1WI X 382-168	295	36	N/A
	15'	180-1/4"	1WI X 382-180	314	38	N/A
8' H	3-1/2'	40"	1WI X 394-42	76	8	N/A
	4'	49-1/2"	1WI X 394-48	90	10	N/A
	5'	58-3/4"	1WI X 394-60	103	12	N/A
	6'	68"	1WI X 394-72	121	14	N/A
	7'	86-3/4"	1WI X 394-84	137	18	N/A
	8'	95-1/2"	1WI X 394-96	155	20	N/A
	9'	105-1/2"	1WI X 394-108	197	22	N/A
	10'	114-3/4"	1WI X 394-120	224	24	N/A
	11'	133-1/2"	1WI X 394-132	271	28	N/A
	12'	143"	1WI X 394-144	292	30	N/A
	13'	152-1/4"	1WI X 394-156	307	32	N/A
	14'	171"	1WI X 394-168	326	36	N/A
	15'	180-1/4"	1WI X 394-180	345	38	N/A
	16'	189-3/4"	1WI X 394-192	362	40	N/A

X = COLOR SELECTION
B = BLACK
N = BRONZE

For additional strength; all gate leaves greater than 6 feet in width will have an intermediate center upright, gusset plates will be welded in all four corners, and the appropriate quantity of turnbuckle and cable kits will be included.
Custom gate dimensions are available upon request, but incur a 10% engineering charge based on the nearest larger standard gate leaf.

Effective: 04/16/13

MONTAGE COMMERCIAL® SWING GATES



1-888-333-3422
FAX: 1-877-926-3747

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Invincible 4-Rail (Standard) (4" Air Gap)



(NOMINAL) GATE HEIGHT	(NOMINAL) GATE OPENING	(ACTUAL) GATE LEAF WIDTH	ITEM NUMBER	GATE WEIGHT	PICKET QTY	STOCKING COLOR
7' H	3-1/2'	40"	1WI <u>X</u> 482-42	71	8	N/A
	4'	49-1/2"	1WI <u>X</u> 482-48	84	10	N/A
	5'	58-3/4"	1WI <u>X</u> 482-60	97	12	N/A
	6'	68"	1WI <u>X</u> 482-72	114	14	N/A
	7'	86-3/4"	1WI <u>X</u> 482-84	131	18	N/A
	8'	95-1/2"	1WI <u>X</u> 482-96	148	20	N/A
	9'	105-1/2"	1WI <u>X</u> 482-108	200	22	N/A
	10'	114-3/4"	1WI <u>X</u> 482-120	227	24	N/A
	11'	133-1/2"	1WI <u>X</u> 482-132	265	28	N/A
	12'	143"	1WI <u>X</u> 482-144	306	30	N/A
	13'	152-1/4"	1WI <u>X</u> 482-156	316	32	N/A
	14'	171"	1WI <u>X</u> 482-168	328	36	N/A
8' H	15'	180-1/4"	1WI <u>X</u> 482-180	348	38	N/A
	16'	189-3/4"	1WI <u>X</u> 482-192	367	40	N/A
	3-1/2'	40"	1WI <u>X</u> 494-42	80	8	N/A
	4'	49-1/2"	1WI <u>X</u> 494-48	94	10	N/A
	5'	58-3/4"	1WI <u>X</u> 494-60	108	12	N/A
	6'	68"	1WI <u>X</u> 494-72	127	14	N/A
	7'	86-3/4"	1WI <u>X</u> 494-84	145	18	N/A
	8'	95-1/2"	1WI <u>X</u> 494-96	164	20	N/A
	9'	105-1/2"	1WI <u>X</u> 494-108	214	22	N/A
	10'	114-3/4"	1WI <u>X</u> 494-120	248	24	N/A
	11'	133-1/2"	1WI <u>X</u> 494-132	296	28	N/A
	12'	143"	1WI <u>X</u> 494-144	322	30	N/A
	13'	152-1/4"	1WI <u>X</u> 494-156	337	32	N/A
	14'	171"	1WI <u>X</u> 494-168	357	36	N/A
	15'	180-1/4"	1WI <u>X</u> 494-180	377	38	N/A
	16'	189-3/4"	1WI <u>X</u> 494-192	398	40	N/A

X = COLOR SELECTION
B = BLACK
N = BRONZE

For additional strength; all gate leaves greater than 6 feet in width will have an intermediate center upright, gusset plates will be welded in all four corners, and the appropriate quantity of turnbuckle and cable kits will be included. Custom gate dimensions are available upon request, but incur a 10% engineering charge based on the nearest larger standard gate leaf.

Effective: 04/16/13

MONTAGE COMMERCIAL® STEEL ARCHED GATES



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FAX: 1-877-926-3747

GATE SPECIFICATIONS

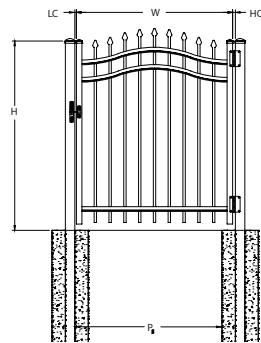
Construction Components for Nominal Gate
Openings of 3-1/2' thru 6':

Gate Ends: 1-3/4" Sq. (14 Ga.) Steel
Rails: 1-7/16" W x 1-1/2" H (14 Ga.) Steel
Pickets: 3/4" Sq. (14 Ga.)

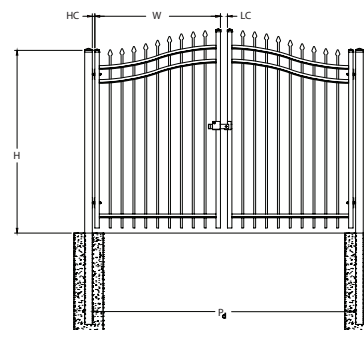
Construction Components for Nominal Gate
Openings of 7' thru 14':

Gate Ends: 1-3/4" Sq. (14 Ga.) Steel
Rails: 1-7/16" W x 1-1/2" H (14 Ga.) Steel
Pickets: 3/4" Sq. (14 Ga.)

GATE DRAWING DIMENSIONAL FORMAT



Order 1 Leaf For Single Swing Opening



Order 2 Leaves For Double Swing Opening

W = Outside To Outside Width of Finished Gate Leaf

H = Height; HC = Hinge Clearance; LC = Latch Clearance;

P_s = Gate Post Spacing (Inside-To-Inside) for Single Gate; P_d = Gate Post Spacing (Inside-To-Inside) for Double Gate

See Montage Commercial Specification for Montage Commercial Gate Post Recommendation

HARDWARE KITS & POST INTERSPACES FOR MONTAGE COMMERCIAL SINGLE SWING WELDED STEEL GATES				
NOMINAL GATE OPENING	3-1/2'	4'	5'	6'
W = LEAF WIDTH	40"	49-1/2"	58-3/4"	68"
FORK LATCH/BOX HINGE KITS #SGBSX25 OR #SGBSX3	HC	2"		
	LC	2"		
	P _s	44"	53-1/2"	62-3/4"
AMERISTAR LOCK/BOX HINGE KIT #SGBSXA	HC	2"		
	LC	5/8"		
	P _s	42-5/8"	52-1/8"	61-3/8"
LOKKLATCH WITH TRU-CLOSE HINGE KIT #TCSGK	HC	3/4"		
	LC	3/4"		
	P _s	41-1/2"	51"	60-1/4"
TOP PULL LATCH WITH TRU-CLOSE HINGE KIT #TCPGK	HC	3/4"		
	LC	3/4"		
	P _s	41-1/2"	51"	60-1/4"
COMMERCIAL HINGE WITH STRONGARM KIT #CGBS-25, #CGBS-3 OR #CGBS-4	HC	1"		
	LC	3"		
	P _s	44"	53-1/2"	62-3/4"
HEAVY COMMERCIAL HINGE KIT #HGBS-25, #HGBS-3 OR #HGBS-4	HC	1-1/4"		
	LC	3"		
	P _s	44-1/4"	53-3/4"	63"
P _s (Gate Post Spacing (Inside-To-Inside) for Single Gate = HC (Hinge Clearance) + W (Out-To-Out Gate Width) + LC (Latch Clearance)				

HARDWARE KITS & POST INTERSPACES FOR MONTAGE COMMERCIAL DOUBLE SWING WELDED STEEL GATES					
NOMINAL GATE OPENING	7'	8'	10'	12'	14'
W = LEAF WIDTH	40"	49-1/2"	58-3/4"	68"	86-3/4"
FORK LATCH / BOX HINGE KIT #SGBDX	HC	2"			
	LC	2"			
	P _s	86"	105"	123-1/2"	142"
COMMERCIAL HINGE WITH STRONG ARM KIT #CGBD	HC	1"			
	LC	2"			
	P _s	84"	103"	121-1/2"	140"
HEAVY COMMERCIAL HINGE KIT #HGBD	HC	1-1/4"			
	LC	2"			
	P _s	84-1/2"	103-1/2"	122"	140-1/2"
P _d (Gate Post Spacing (Inside-To-Inside) for Double Gate = 2 x HC (Hinge Clearance) + 2 x W (Out-To-Out Gate Width) + LC (Latch Clearance)					

Warning: Steel Arched Gates with extended picket bottom exposure are not to be automated. This would cause a safety hazard and violate safety regulations.

Effective: 04/16/13

MONTAGE COMMERCIAL®
STEEL ARCHED GATES

AMERISTAR®
FENCE PRODUCTS

1-888-333-3422
FAX: 1-877-926-3747

SINGLE SWING

3-Rail (Standard) (4” Air Gap)				4-Rail (Standard) 4” Air Gap)			
Classic							
Majestic							
Genesis							
NOMINAL GATE HEIGHT	RAIL QUANTITY	NOMINAL GATE OPENING	ACTUAL GATE LEAF WIDTH	ITEM NUMBER		PICKET QUANTITY	GATE WEIGHT
7' H	3-RAIL	3-1/2'	40”	1W	* X 382-42A	7	70
		4'	49-1/2”	1W	* X 382-48A	9	83
		5'	58-3/4”	1W	* X 382-60A	11	95
		6'	68”	1W	* X 382-72A	13	108
	4-RAIL	3-1/2'	40”	1W	* X 482-42A	7	75
		4'	49-1/2”	1W	* X 482-48A	9	87
		5'	58-3/4”	1W	* X 482-60A	11	100
		6'	68”	1W	* X 482-72A	13	114
STYLE SELECTION = * X = COLOR SELECTION MAJESTIC = M B = BLACK CLASSIC = C N = BRONZE GENESIS = G							
Warning: Steel Arched Gates with extended picket bottom exposure are not to be automated. This would cause a safety hazard and violate safety regulations.							

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Effective: 04/16/13

MONTAGE COMMERCIAL® STEEL ARCHED GATES



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DOUBLE SWING

All Double Swing Gates
include two (2) Gate Leafs

3-Rail (Double)
(4" Air Gap)

4-Rail (Double)
4" Air Gap)

Classic



Majestic



Genesis



NOMINAL GATE HEIGHT	RAIL QUANTITY	NOMINAL GATE OPENING	ACTUAL GATE LEAF WIDTH	ITEM NUMBER	PICKET QUANTITY	GATE WEIGHT PER LEAF
7' H	3-RAIL	7'	40"	1W [±] <u>X</u> 382-84HD	14	134
		8'	49-1/2"	1W [±] <u>X</u> 382-96HD	18	160
		10'	58-3/4"	1W [±] <u>X</u> 382-120HD	22	182
		12'	68"	1W [±] <u>X</u> 382-144HD	26	210
		14'	86-3/4"	1W [±] <u>X</u> 382-168HD	34	246
	4-RAIL	7'	40"	1W [±] <u>X</u> 482-84HD	14	142
		8'	49-1/2"	1W [±] <u>X</u> 482-96HD	18	168
		10'	58-3/4"	1W [±] <u>X</u> 482-120HD	22	192
		12'	68"	1W [±] <u>X</u> 482-144HD	26	222
		14'	86-3/4"	1W [±] <u>X</u> 482-168HD	34	262

STYLE SELECTION = [±] X = COLOR SELECTION
MAJESTIC = ^M B = BLACK
CLASSIC = ^C N = BRONZE
GENESIS = ^G

Warning: Steel Arched Gates with extended picket bottom exposure are not to be automated. This would cause a safety hazard and violate safety regulations.

Effective: 04/16/13

MONTAGE COMMERCIAL® STEEL ESTATE ENTRY GATES



1-888-333-3422
FAX: 1-877-926-3747

GATE SPECIFICATIONS

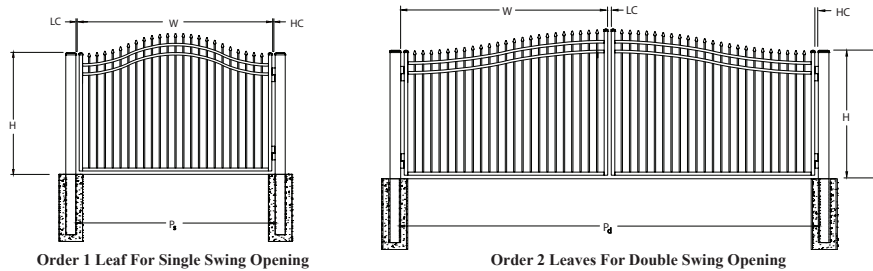
Construction Components for Nominal Gate
Openings of 8' thru 10':

Gate Ends: 2" Square Steel
Rails: 1-7/16" W x 1-1/2" H (14 Ga.) Steel
Pickets: 3/4" Sq. (14 Ga.)

Construction Components for Nominal Gate
Openings of 16' thru 24':

Gate Ends: 2" Square Steel
Rails: 1-7/16" W x 1-1/2" H (14 Ga.) Steel
Pickets: 3/4" Sq. (14 Ga.)

GATE DRAWING DIMENSIONAL FORMAT



W = Outside To Outside Width of Finished Gate Leaf
H = Height; HC = Hinge Clearance; LC = Latch Clearance;

P_s = Gate Post Spacing (Inside-To-Inside) for Single Gate; P_d = Gate Post Spacing (Inside-To-Inside) for Double Gate

See Montage Commercial Specification for Montage Commercial Gate Post Recommendation

HARDWARE KITS & POST INTERSPACES FOR MONTAGE COMMERCIAL SINGLE SWING STEEL ESTATE ENTRY GATES				
NOMINAL GATE OPENING	8'	10'	12'	
W = LEAF WIDTH	95-1/2"	114-3/4"	143"	
FORK LATCH/BOX HINGE KITS #SGBSX25 OR #SGBSX3	HC	2"		
	LC	2"		
	P _s	99-1/2"	118-3/4"	147"
AMERISTAR LOCK/BOX HINGE KIT #SGBSXA	HC	2"		
	LC	5/8"		
	P _s	98-1/8"	117-3/8"	145-5/8"
LOKKLATCH WITH TRU-CLOSE HINGE KIT #TCSGK	HC	3/4"		
	LC	3/4"		
	P _s	97"	116-1/4"	144-1/2"
TOP PULL LATCH WITH TRU-CLOSE HINGE KIT #TCPGK	HC	3/4"		
	LC	3/4"		
	P _s	97"	116-1/4"	144-1/2"
COMMERCIAL HINGE WITH STRONGARM KIT #CGBS-25, #CGBS-3 OR #CGBS-4	HC	1"		
	LC	3"		
	P _s	99-1/2"	118-3/4"	147"
HEAVY COMMERCIAL HINGE KIT #HGBS-25, #HGBS-3 OR #HGBS-4	HC	1-1/4"		
	LC	3"		
	P _s	99-3/4"	119"	147-1/4"
P _s (Gate Post Spacing (Inside-To-Inside) for Single Gate = HC (Hinge Clearance) + W (Out-To-Out Gate Width) + LC (Latch Clearance)				

HARDWARE KITS & POST INTERSPACES FOR MONTAGE COMMERCIAL DOUBLE SWING STEEL ESTATE ENTRY GATES					
NOMINAL GATE OPENING	16'	18'	20'	22'	24'
W = LEAF WIDTH	95-1/2"	105-1/2"	114-3/4"	133-1/2"	143"
FORK LATCH / BOX HINGE KIT #SGBDX	HC	2"			
	LC	2"			
	P _s	197"	217"	235-1/2"	273"
COMMERCIAL HINGE WITH STRONG ARM KIT #CGBD	HC	1"			
	LC	2"			
	P _s	195"	215"	233-1/2"	271"
HEAVY COMMERCIAL HINGE KIT #HGBD	HC	1-1/4"			
	LC	2"			
	P _s	195-1/2"	215-1/2"	234"	271-1/2"
P _d (Gate Post Spacing (Inside-To-Inside) for Double Gate = 2 x HC (Hinge Clearance) + 2 x W (Out-To-Out Gate Width) + LC (Latch Clearance)					

Effective: 04/16/13

MONTAGE COMMERCIAL®
STEEL ESTATE ENTRY GATES



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3-Rail (Standard) (4" Air Gap)				4-Rail (Standard) 4" Air Gap)			
Classic							
Majestic							
Genesis							
NOMINAL GATE HEIGHT	RAIL QUANTITY	NOMINAL GATE OPENING	ACTUAL GATE LEAF WIDTH	ITEM NUMBER		PICKET QUANTITY PER LEAF	GATE WEIGHT PER LEAF
7' H	3-RAIL	8'	95-1/2"	1W	* X 382F-96A	19	
		10'	114-3/4"	1W	* X 382F-120A	23	
		12'	143"	1W	* X 382F-144A	29	
	4-RAIL	8'	95-1/2"	1W	* X 482F-96A	19	
		10'	114-3/4"	1W	* X 482F-120A	23	
		12'	143"	1W	* X 482F-144A	29	
STYLE SELECTION = * X = COLOR SELECTION MAJESTIC = M B = BLACK CLASSIC = C N = BRONZE GENESIS = G							
3rd rail from the top on all 4-rail gates match Montage Commercial 3-rail extended picket fence panels. Steel Estate Entry Gates are designed to comply with industry standards for automatic gates under UL325 & ASTM F2200.							

Effective: 04/16/13

MONTAGE COMMERCIAL® STEEL ESTATE ENTRY GATES



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MONTAGE
COMMERCIAL

All Double Swing Gates
include two (2) Gate Leafs

3-Rail (Double)
(4" Air Gap)

4-Rail (Double)
4" Air Gap)

Classic



Majestic



Genesis



NOMINAL GATE HEIGHT	RAIL QUANTITY	NOMINAL GATE OPENING	ACTUAL GATE LEAF WIDTH	ITEM NUMBER	PICKET QUANTITY	GATE WEIGHT PER LEAF
7' H	3-RAIL	16'	95-1/2"	1W * X 382F-192HD	38	
		18'	105-1/2"	1W * X 382F-216HD	42	
		20	114-3/4"	1W * X 382F-240HD	46	
		22	133-1/2"	1W * X 382F-264HD	54	
		24	143"	1W * X 382F-288HD	58	
	4-RAIL	16'	95-1/2"	1W * X 482F-192HD	38	
		18'	105-1/2"	1W * X 482F-216HD	42	
		20	114-3/4"	1W * X 482F-240HD	46	
		22	133-1/2"	1W * X 482F-264HD	54	
		24	143"	1W * X 482F-288HD	58	

STYLE SELECTION = * X = COLOR SELECTION
MAJESTIC = M B = BLACK
CLASSIC = C N = BRONZE
GENESIS = G

3rd rail from the top on all 4-rail gates match Montage Commercial 3-rail extended picket fence panels.

Steel Estate Entry Gates are designed to comply with industry standards for automatic gates under UL325 & ASTM F2200.

Effective: 04/16/13

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ITEM DESCRIPTION	PART NUMBER / COLOR		LENGTH	BOX QTY	WT. EA.
	BLACK	BRONZE			
1-3/4" Sq. x 14 Ga. Steel Gate End 	1HB282	1HN282	82"	8	12.25
	1HB294	1HN294	94"	8	14.00
	NOTE: Gate Ends are supplied with 1-3/4" Sq. Pressed Steel caps. NOTE: Gates fabricated by welding of gate ends to panel remnants are excluded from the Montage/Montage Plus warranty.				

MONTAGE COMMERCIAL®

GATE HARDWARE KITS



Gate Hardware Kits are located in the Ornamental Gate Hardware Section.

Effective: 04/16/13