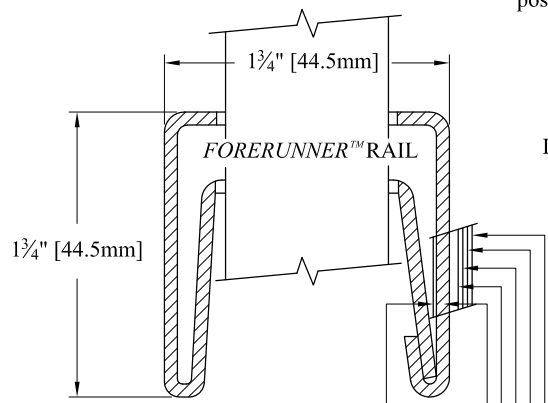
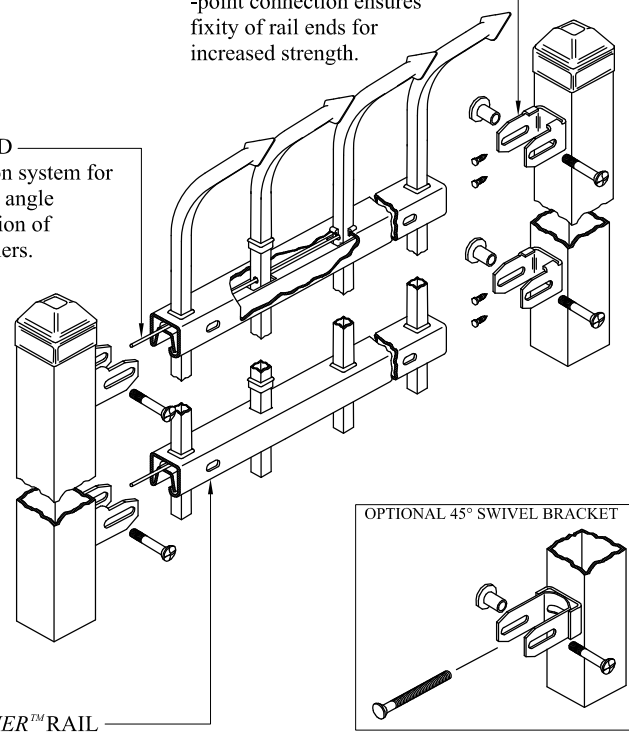
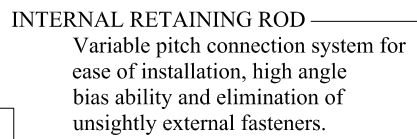
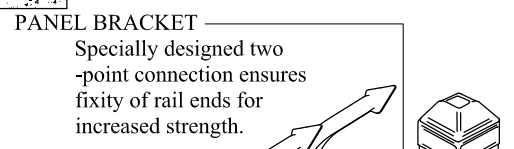


- NOTES:**
- 1.) Post size depends on fence height and wind loads. See *AEGIS II* post sizing chart.
 - 2.) Additional heights available on request.
 - 3.) Third rail optional.
 - 4.) Panels also available for 6' on center post spacing.



- Uniform Zinc Coating (Hot Dip Galvanized)
- Base Material
- Uniform Zinc Coating (Hot Dip Galvanized)
- Zinc Phosphate & Conversion Coating
- Epoxy base coat
- "No-Mar" Polyester Powder finish coat

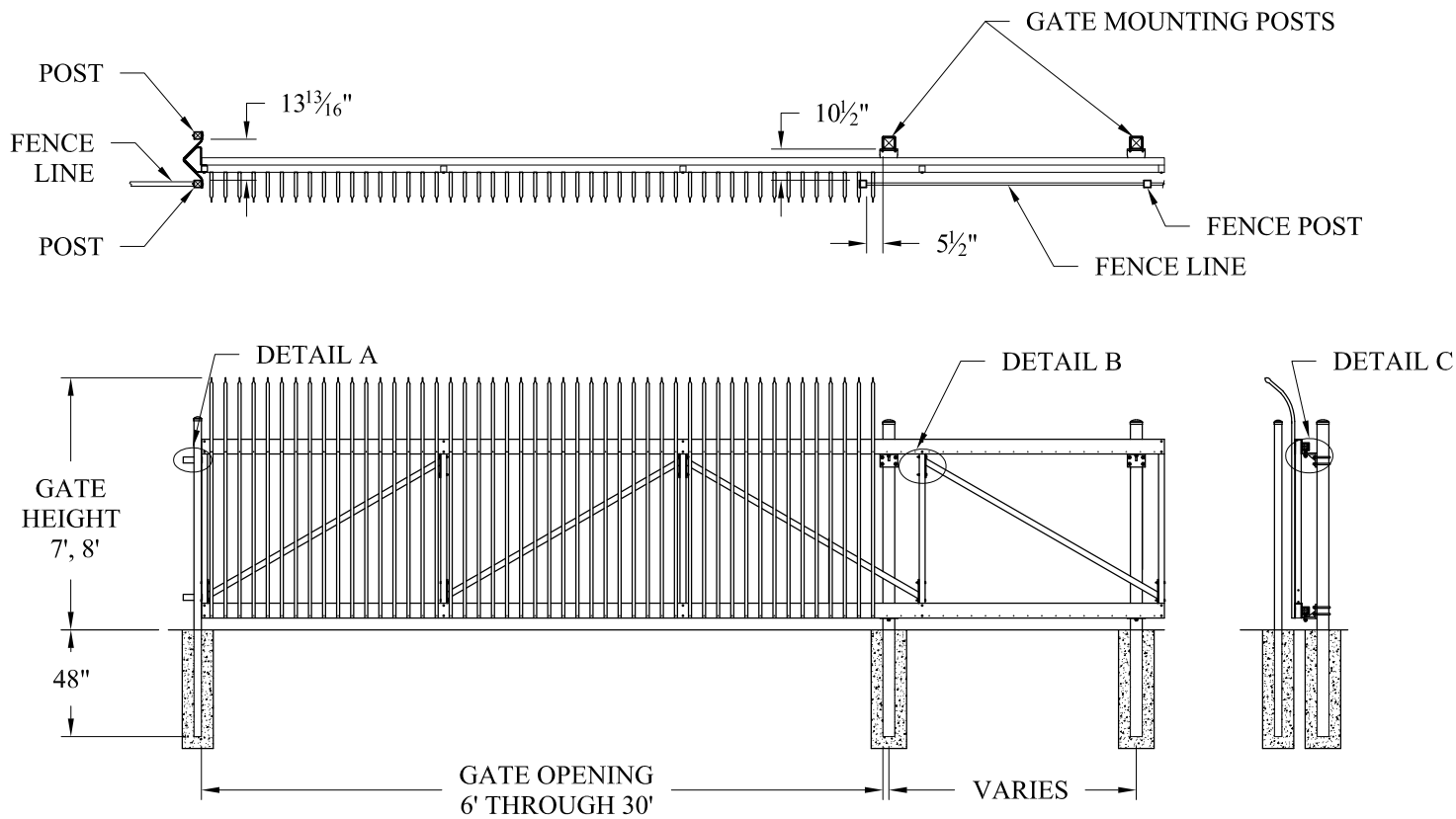
Values shown are nominal and not to be used for installation purposes. See product specification for installation requirements.

INDUSTRIAL STRENGTH STEEL

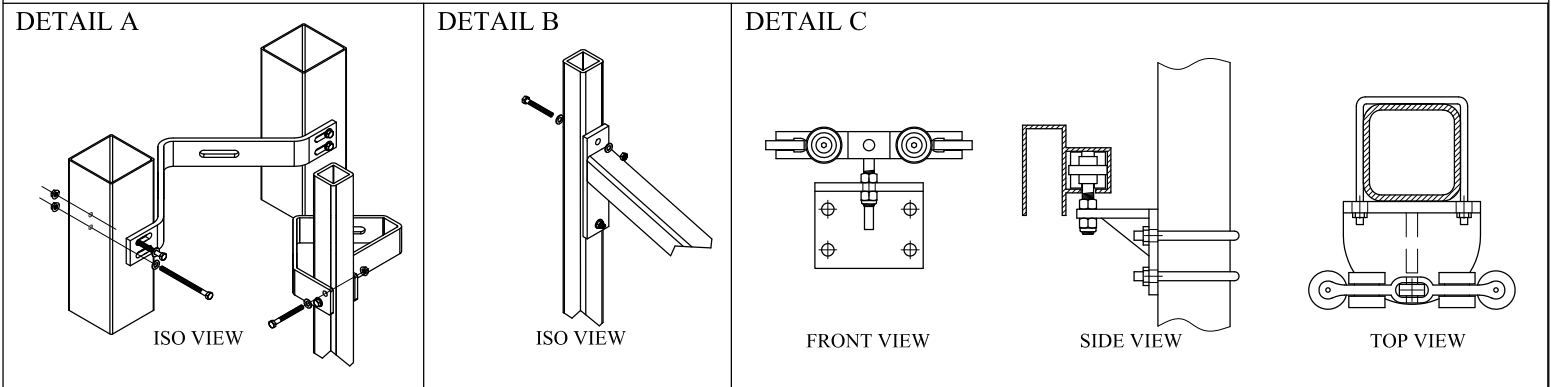
Title: AEGIS II INVINCIBLE 2/3-RAIL			
DR: KMc	SH . 1 of 1	SCALE: DO NOT SCALE	
CK:	Date 04/17/2015	REV: D	



1555 N. Mingo
Tulsa, OK 74116
1-888-333-3422
www.ameristarfence.com



Values shown are nominal and not to be used for installation purposes. See product specification for installation requirements.



TRANSPORT II CANTILEVER GATE SPECIFICATION SUMMARY

U.S.A. PATENT NO. 5,136,813
 Material: Aluminum (ASTM B221 - 6005-T5)
 Track: Proprietary Fast-Trak Extruded Shape



Uprights and Diagonal Braces: 2" Square x 1/4"
 Ornamental Pickets: 1" Square x 1/8"
 Cantilever Gate Hardware: Kit # TGKOD

Ameristar's TransPort Ornamental Cantilever Gates are designed to be mounted on posts that are off-set from the fence line. By off-setting the gate posts, the gate will pass between the fence and the mounting posts, keeping it from falling in the event of a track or hardware failure (a requirement of ASTM F2200).

2TCISO

Title: TRANSPORT II INVINCIBLE GATE		
DR: CI	SH . 1 of 1	SCALE: DO NOT SCALE
CK: PB	Date 6/28/10	REV: b



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AMERISTAR® PERIMETER SECURITY USA INC.
AEGIS II® - Heavy Industrial Steel Ornamental Fence System – Internally Secured
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 industrial 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 industrial ornamental steel fence system of the Ameristar® Aegis II Invincible™ design. The system shall include all components (i.e., pickets, rails, posts, gates and hardware) required.

1.04 QUALITY ASSURANCE

The contractor shall provide laborers and supervisors who are thoroughly familiar with the type of construction involved and materials and techniques specified.

1.05 REFERENCES

- ASTM 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 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.

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 10 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 Ameristar Aegis II, Invincible design, 3-Rail style manufactured by Ameristar Fence Products, Inc. in Tulsa, Oklahoma.

2.02 MATERIAL

A. Steel material for fence framework (i.e. tubular pickets, rails and posts), shall be galvanized prior to forming in accordance with the requirements of ASTM A653/A653M, with minimum yield strength of 45,000 psi (310 MPa). The steel shall be hot-dip galvanized to meet the requirements of ASTM A653/A653M with a minimum zinc coating weight of 0.90 oz/ft² (276 g/m²), Coating Designation G-90.

B. Material for pickets shall be 1" square x 14 Ga. tubing. The cross-sectional shape of the rails shall conform to the manufacturer's ForeRunner™ double wall design with outside cross-section dimensions of 1.75" square and a minimum thickness of 14 Ga. Picket holes in the ForeRunner rail shall be spaced 4.715" o.c., except for Invincible style 6' long, which shall be, spaced 4.98" o.c. Picket retaining rods shall be 0.125" diameter galvanized steel. High quality PVC grommets shall be supplied to seal all picket-to-rail intersections. Fence posts and gateposts shall meet the minimum size requirements of Table 1.

2.03 FABRICATION

A. Pickets, rails and posts shall be precut to specified lengths. ForeRunner rails shall be prepunched to accept pickets. Pickets shall be predrilled to accept retaining rods.

B. Grommets shall be inserted into the prepunched holes in the rails and pickets shall be inserted through the grommets so that predrilled picket holes align with the internal upper raceway of the ForeRunner rails (Note: This can best be accomplished by making an alignment jig). Retaining rods shall be inserted into each ForeRunner rail so that they pass through the predrilled holes in each picket.

C. The manufactured galvanized framework shall be subjected to the PermaCoat® thermal stratification coating process (high-temperature, in-line, multi-stage, multi-layer) including, as a minimum, a six-stage pretreatment/wash, 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, Bronze, White, or Desert Sand). The stratification-coated framework shall be capable of meeting the performance requirements for each quality characteristic shown in Table 2.

D. Completed sections (i.e., panels) shall be capable of supporting a 600 lb. load applied at midspan without permanent deformation. Panels shall be biasable to a 25% change in grade.

E. Swing gates shall be fabricated using 1.75" x 14ga Forerunner double channel rail, 2" sq. x 12ga. gate ends, and 1" sq. x 14ga. pickets. Gates that exceed 6' in width will have a 1.75" sq. x 14ga. intermediate upright. All rail and upright intersections shall be joined by welding. All picket and rail intersections shall also be joined by welding. Gusset plates will be welded at each upright to rail intersection. Cable kits will be provided for additional trussing for all gates leaves over 6'.

F. Pedestrian swing gates shall be self-closing, having a gate leaf no larger than 48" width. Integrated hinge-closer set (2 qty) shall be ADA compliant that shall include a variable speed and final snap adjustment with compact design (no greater than 5" x 6" footprint). Hinge-closer set (2 qty) shall be tested to a minimum of 500,000 cycles and capable of self-closing gates up to a maximum gate weight of 260 lbs. and maximum weight load capacity of 1,500 lbs. Hinge-closer device shall be externally mounted with tamper-resistant security fasteners, with full range of adjustability, horizontal (.5" - 1.375") and vertical (0 - .5"). Maintenance free hinge-closer set shall be tested to operate in temperatures of negative 20 F to 200 F degrees, and swings to negative 2 degrees to ensure reliable final lock engagement.

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 Table 3, plus or minus ½". 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 Aegis II Posts

Fence Posts	Panel Height			
2-1/2" x 12 Ga.	Up to & Including 6' Height			
3" x 12 Ga.	Over 6' Up to & Including 10' Height			
4" x 11 Ga.	Over 10' Height			
Gate Leaf	Gate Height			
	Up to & Including 6'	Over 6' Up to & Including 8'	Over 8' Up to & Including 10'	Over 12'
Up to 4'	3" x 12Ga.	3" x 12 Ga.	4" x 11 Ga.	4" x 11 Ga.
4'1" to 6'	3" x 12Ga.	3" x 12 Ga.	4" x 11 Ga.	4" x 11 Ga.
6'1" to 8'	4" x 11 Ga.	6" x 3/16"	6" x 3/16"	6" x 3/16"
8'1" to 10'	4" x 11 Ga.	6" x 3/16"	6" x 3/16"	6" x 3/16"
10'1" to 12'	6" x 3/16"	6" x 3/16"	6" x 3/16"	8" x 1/4"
12'1" to 16'	6" x 3/16"	6" x 3/16"	8" x 1/4"	8" x 1/4"

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 3,500 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 – Aegis II – Post Spacing By Bracket Type

Span	For INVINCIBLE® 8' Nominal (91.25" Rail)		For CLASSIC, GENESIS, & MAJESTIC 8' Nominal (92.625" Rail)					
	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"
Bracket Type	Industrial Flat Mount (BB301)		Industrial Universal (BB302)	Industrial Universal (BB303)	Industrial Flat Mount (BB301)		Industrial Swivel (BB304)*	
Post Settings ± 1/2" O.C.	94-1/2"	95"	96"	96.5"	96"	96-1/2"	*97-1/2"	*98"
Span	For INVINCIBLE® 6' Nominal (67.75" Rail)		For CLASSIC, GENESIS, & MAJESTIC 6' Nominal (71.375" Rail)					
	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"	2-1/2"	3"
Bracket Type	Industrial Flat Mount (BB301)		Industrial Universal (BB302)	Industrial Universal (BB303)	Industrial Flat Mount (BB301)		Industrial Swivel (BB304)*	
Post Settings ± 1/2" O.C.	75"	75.5"	71.5"	72"	71.5"	72"	*73"	*73.5"
*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.								

AMERISTAR FENCE PRODUCTS
TRANSPORT II – Enclosed Track Industrial Aluminum Cantilever Gate System
Construction Specification – SECTION 32 31 00

PART 1 - GENERAL

1.01 WORK INCLUDED

The contractor shall provide all labor, materials, and appurtenances necessary for installation of the industrial cantilever gate system defined herein at (specify project site).

1.02 RELATED WORK

Section _____ - Earthwork

Section _____ - Concrete

1.03 SYSTEM DESCRIPTION

The manufacturer shall supply a total industrial ornamental aluminum cantilever gate system of the Ameristar® TransPort II design, (specify Classic, Majestic, Genesis, or Invincible) style. The system shall include all components (i.e., tracks, uprights, bracing, pickets, hardware, fittings and fasteners) required.

1.04 QUALITY ASSURANCE

The contractor shall provide laborers and supervisors who are thoroughly familiar with the type of construction involved and materials and techniques specified.

1.05 REFERENCES

- ASTM B117 - Practice for Operating Salt-Spray (Fog) Apparatus.
- ASTM B221 - Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles and Tubes.
- ASTM D523 - Test Method for Specular Gloss.
- ASTM D822 - Practice for Conducting Tests on Paint and Related Coatings and Materials using Filtered Open-Flame Carbon-Arc Light and Water Exposure Apparatus.
- ASTM D1654 - Test Method for Evaluation of Painted or Coated Specimens Subjected to Corrosive Environments.
- ASTM D2244 - Test Method for Calculation of Color Differences from Instrumentally Measured Color Coordinates.
- ASTM D2794 - Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation (Impact).
- ASTM D3359 - Test Method for Measuring Adhesion by Tape Test.
- ASTM F1184 – Industrial & Commercial Horizontal Slide Gates

1.06 SUBMITTAL

The manufacturer's submittal package consisting of gate elevations, hardware details, and installation details, shall be submitted prior to installation.

1.07 PRODUCT HANDLING AND STORAGE

Upon receipt at the job site, all materials shall be checked to ensure that no damage occurred during shipping or handling. Materials shall be stored in such a manner to ensure proper ventilation and drainage, and to protect against damage, weather, vandalism, and theft.

PART 2 - MATERIALS

2.01 MANUFACTURER

All industrial ornamental aluminum cantilever gates shall conform to the Ameristar® TransPort II gate system, (specify Classic, Majestic, Genesis, or Invincible) style, manufactured by Ameristar Fence Products, Inc., in Tulsa, Oklahoma. The project gate schedule shall include the following additional information for each cantilever gate included in the project scope: (specify nominal opening size range in feet) opening, and (specify size and shape of posts) gate posts.

2.02 MATERIAL

A. The materials used for cantilever gate framing (i.e., uprights, diagonal braces and pickets or pales) shall be manufactured from ASTM B221 aluminum (designation 6063-T-6) with a yield strength of 25,000 PSI, a tensile strength of 30,000 PSI and a standard mill finish. The TransPort® Fast-Trak™ rails shall be manufactured from ASTM B221 aluminum (designation 6063-T-6) with minimum yield strength of 25,000 PSI, a tensile strength of 30,000 PSI and a standard mill finish.

B. Material for diagonal bracing and uprights shall be 2" sq. x 1/4" aluminum. The design of the top and bottom enclosed track shall conform to the manufacturers 5" x 2" Fast-Trak system. Material for pickets shall be 1" x 1/8" wall aluminum.

C. Internal roller truck assembly shall be self-aligning swivel ball-and-socket type running on four bearing wheels. Internal roller truck assembly shall be affixed to the hanger bracket by means of a 5/8” diameter industrial-grade rod end/center bolt, with a minimum static load rating of 10,000 pounds. Attachment of the center bolt to the truck body shall be by means of a swivel joint to ensure equivalent and consistent loading on all bearing wheels and internal track surfaces throughout the travel of the gate.

2.03 FABRICATION

A. Pickets, enclosed track, uprights and diagonal bracing shall be pre-drilled and labeled for easy assembly. All components shall be pre-cut to specified lengths.

B. Top and bottom rail extrusions shall be mechanically fastened to vertical uprights and reinforced with diagonal braces, as required by drawing.

C. The manufactured components shall be subjected to the Ameristar thermal stratification coating process (high-temperature, in-line, multi-stage, and multi-layer) including, as a minimum, a six-stage pretreatment/wash and an electrostatic spray application of a polyester finish. The topcoat shall be a “no-mar” TGIC polyester powder coat finish with a minimum thickness of 2 mils (0.0508mm). The color shall be (specify Black, Bronze, White, or Desert Sand). The stratification-coated framework shall be capable of meeting the performance requirements for each quality characteristic shown in Table 1.

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 3,500 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).

PART 3 - EXECUTION

3.01 PREPARATION

A. All new gate installations shall be laid out by the contractor in accordance with the construction plans.

B. All hardware shall be installed in accordance with the Transport installation instructions. Transport cantilever gates shall be installed so they comply with current ASTM F2200 & UL325 standards.

C. Gate stops shall be installed on each track in a way that conforms to current ASTM F2200 standards.

3.02 GATE INSTALLATION

Gate post shall be spaced according to specified gate elevation. Posts shall be set in concrete footers having a minimum depth of 48” with a minimum diameter of 12” (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 CLEANING

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