



CLASSIC WELDED ORNAMENTAL FENCE COMMERCIAL

PART 1 GENERAL

1.01 SECTION INCLUDES:

Ornamental welded steel fence system

1.02 RELATED SECTIONS:

Section 0503___ Metal Finishes
Section 0330___ Cast in Place Concrete.
Section 0420___ Unit Masonry.
Section 3130___ Earthwork.
Section 3231___ Paving and surface improvements.

1.04 REFERENCES:

ASTM-F593-02e2_ Stainless Steel Fasteners
ASTM A500___ Seamless Grade A metal tubing
ASTM A123___ Hot dip electroplating
ASTM E935___ Cone Penetration test (Method D)
In-fill Load Test (Method C)
Vertical Concentrated Load Test (Method B)
Horizontal Load Test (Method A)
ASTM B117-97___ Salt Spray Corrosion test
AC174-Section 4.2.2 In-Fill Load Test
Section 4.2.3 Uniform Load Test
Section 4.2.4 Concentrated Load Test
ICBO UBC-97___ Quality standards
BOCA___ National Building Codes

1.05 WARRANTY

Fortress Fence Products CLASSIC products include a 10-year limited warranty, from the date of purchase, for defects in material and workmanship, including protection against cracking, peeling, blistering and corrosion (rusting). Refer to 10 Year Warranty Sheet.

PART 2 PRODUCTS

2.01 MANUFACTURER

Fortress Fence Products
1720 North 1st ST
Garland, Texas 75040
Phone: 844-909-1999 Fax: 972-644-3720
Web site: www.fortressfence.com
E-Mail: specifications@fortressfence.com

2.02 MATERIALS

Rails and Pickets are Grade A cold rolled steel formed and welded tubing conforming to ASTM A500 with G 60 zinc coating (0.60 oz/ft² or 0.18 kg/M²) on both inside and outside surfaces in accordance with the ASTM A123 hot dipped electroplating process. Materials also conform to ASTM E935 testing (Methods A, B, C and D) and load testing in accordance with AC174 (Sections 4.2.2, 4.2.3 and 4.2.4).

2.03 COMPONENTS

Rails: 16-gauge ASTM 500 galvanized welded steel tubing, 1.5-inch square.

Pickets: 18-gauge ASTM A500 galvanized welded and formed steel tubing, 3/4-inch square.

Posts: 16-gauge 2.5-inch square or 14gauge 3-inch square ASTM A500 galvanized formed and welded steel tubing with powder coated factory finish. Post caps can be nylon.

Fasteners: All nuts, bolts, sheet metal and wood screws are stainless steel conforming to ASTM F593-02e2 standard.

Fittings: Fabricated tees, elbows, splice connections, wall returns, wall ends and other similar components are of the same material, specification and finish as fence panels.

2.04 STYLE

Fortress Iron's CLASSIC Fence is made in: Plain Iron Panel (PIP), Spear Point (SP), and Extended Picket (EXT)

2.05 FABRICATION

A. Fence panels are fabricated in standard length of 90.5" and standard heights of 46", 58" and 70" and comply with all requirements indicated for materials, thickness, design and details of construction.

B. All welded connections comply with AWS standards for recommended practice in shop welding.

C. All components are accurately cut and drilled to receive hardware, fasteners and accessories.

2.06 FINISH

A. Metal parts are assembled and finished individually prior to shipment.

B. Galvanized steel fence components are cleaned with a non-petroleum solvent followed by the application of a sealing zinc phosphate coating.

C. Immediately after sealing, a two-step powder finish coating is applied by the electrostatic spray process. This consists of a thermosetting carboxyl polyester resin top coat with a minimum dry film thickness of 60 to 70 microns.

PART 3 EXECUTION

3.01 PREPARATION

Stake layout showing locations of all gates and posts. Contact "CALL BEFORE YOU DIG" prior to beginning any excavation work.

3.02 INSTALLATION

- A. Install fences in accordance with written instructions and in accordance with authorities having jurisdiction.
- B. Concrete Set Posts: Drill hole in firm soil. Posts holes will be a minimum of 24 inches deep with a minimal diameter of 10 inches. Fence post (2.5") shall be spaced 93.25" on-center to accommodate installation of brackets on 2.5" post.
- C. Installation is to conform to the specifications referenced in Section 1.02 of this specification.
- D. Install Fortress brackets onto fence section and posts as indicated in printed instructions for specific fence style. Attach fence sections to brackets with approved fasteners and techniques to ensure that fence sections are parallel to grade within ¼-inch in 12 feet.
- E. Gate Installation: Install in accordance with printed instructions. Do not mount gate from wall of a structure. Provide gate post on both sides of a gate. For double drive gate installation, provide concrete center drop to foundation depth and drop rod retainers at center. Lubricate to insure smooth operation and verify proper latch operation.

3.04 CLEANING

- A. Remove all cutting and drilling chips that are attached to the fencing, post, brackets or additions to prevent corrosion.
- B. Repair scratches and other installation-incurred damage. Using a spray paint of the appropriate color that includes a zinc additive, repaint and seal any scratches or holes drilled in the fencing, post, brackets, or additions to prevent rust from forming.
- C. Clean up debris and unused material, and remove from site.



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