

MERCHANTS METALS®

SECTION 32 31 13

ARMORLINK® ALUMINIZED CHAIN LINK FENCE AND GATES 2014

PART 1 GENERAL

1.1 RELATED DOCUMENTS

- A. DIVISION 01 - GENERAL REQUIREMENTS: Drawings, quality, product and performance requirements, general and supplemental conditions apply as applicable to the project and project documents.

2. SUMMARY

- A. This Section includes industrial/commercial chain link fence and gates specifications:
 - 1. Aluminum coated steel chain link fabric
 - 2. Galvanized steel framework and fittings
 - 3. Gates: swing and cantilever slide
 - 4. Barbed wire
 - 5. Installation
- B. Related Sections:
 - 1. 01 33 23 Shop Drawings, product data
 - 2. 01 43 13 Manufacturers Qualifications
 - 3. 03 30 53 Miscellaneous Cast in Place Concrete
 - 4. 25 50 00 Integrated Automation [pertinent to gate operator access control]
 - 5. 26 01 02 Electrical distribution [relating to gate operators]
 - 6. 31 22 19 Finish Grading

1.3 REFERENCES

- A. ASTM A491 Specification for Aluminum-Coated Steel Chain-Link Fabric
- B. ASTM A780 Standard Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings
- C. ASTM F552 Standard Terminology Relating to Chain Link Fencing
- F. ASTM F567 Standard Practice for Installation of Chain Link Fence
- G. ASTM F626 Specification for Fence Fittings

- H. ASTM F900 Specification for Industrial and Commercial Swing Gates
- I. ASTM F1043 Specification for Strength and Protective Coatings of Steel Industrial Chain Link Fence Framework
- J. ASTM F1083 Specification for Pipe, Steel, Hot-Dipped Zinc-Coated (Galvanized) Welded, for Fence Structures
- K. ASTM F1184 Specification for Industrial and Commercial Horizontal Slide Gates
- L. ASTM F2200 Specification for Automated Vehicular Gate Construction
- M. UL325 Automatic operators: Door, Drapery, Gate, Louver and Window

1.4 SUBMITTALS

- A. Shop drawings: Site plan showing layout of fence location with dimensions, location of gates and opening size, cleared area, elevation of fence, gates, footings and details of attachments. Comply with the provisions of Section 01 33 23.
- B. Material samples: When required, provide representative samples of chain link fabric, framework and fittings. <Specify size and number of samples>
- C. Specification Changes: May not be made after the date of bid.

PART 2 – PRODUCTS

1. MANUFACTURERS

- A. Framework, posts, rails, fabric, and fittings for chain link fence system:

1. MERCHANTS METALS®	Oldcastle Architectural®
www.merchantsmetals.com	Tech-Info@merchantsmetals.com
Phone: (888) 260-1600	Fax: (888) 261-3600

2. CHAIN LINK FABRIC

- A. Steel Chain Link Fabric: [Height or heights indicated on drawings] <Select from table below and insert ASTM serial designation, mesh size, wire gauge, coating specification, including class and color when applicable, top/bottom selvage >

1. **ARMORLINK®** Aluminum–Coated Steel Fabric (Aluminized): ASTM A491.

2. Fabric Selection Table: Steel chain link mesh sizes and gauges produced in one piece widths 3 feet (910 mm) to 12 feet (3660 mm)

Mesh Size	6 gauge core	9 gauge core	11 gauge core	11 1/2 gauge core	12 Gauge core	Notes
In. (mm)	0.192 in.	0.148 in.	0.120 in.	0.113 in.	0.105 in.	
	4.88 mm	3.76 mm	3.05 mm	2.87 mm	2.67 mm	N/A = Not applicable for
2 (50)	yes	yes	yes	N/A	N/A	industrial/commercial
1 ¾ (44)	yes	yes	yes	N/A	N/A	applications
1 (25)	N/M	yes	yes	N/A	N/A	N/M = Not manufactured
5/8 (16)	N/M	yes	yes	yes	yes*	*12 ga. only per F668
1/2 (13)	N/M	yes	yes	yes	yes*	
3/8 (10)	N/M	N/M	yes	yes	yes*	
	2170 lbf	1290 lbf	850 lbf	750 lbf	650 lbf	Wire Break Strength
N)	(9650	(5740 N)	(3780 N)	(3340 N)	(2895 N)	

3. Fabric selvage:

Standard fabric selvage for 2 in (50 mm) mesh 72 in. (1.8 m) high and higher is knuckle finish at one end, twist at the other, [K&T]. < Specify K&K for added safety for play and park applications>

Fabric less than 72 in (1.8 m), knuckle finish top and bottom, K&K.

[Manufacturing and installation issues dictate all mesh sizes less than 2 in. (50 mm) have a knuckle selvage for both top and bottom, K&K.]

2.3 ROUND STEEL PIPE FENCE FRAMEWORK [Specify option A. or B.]

A. Round steel pipe and rail: Schedule 40 standard weight pipe, in accordance with ASTM F1083, 1.8 oz/ ft² (550 g/m²) hot dip galvanized zinc exterior and 1.8 oz/ft² (550 g/m²) hot dip galvanized zinc interior coating.

Regular Grade: Minimum steel yield strength 30,000 psi (205 MPa)

High Strength Grade: Minimum yield strength 50,000 psi (344 MPa)

[Specify Grade: Regular or High Strength]

1. Line post <Insert outside diameter, zinc coating, weight >
2. End, Corner, Pull post <Insert outside diameter, zinc coating, weight >
3. Top, brace, bottom and intermediate rails, 1.660 in. (42.2 mm) OD: <Insert outside diameter, zinc coating, weight>

B. Round steel pipe and rail: Cold-rolled electric-resistance welded pipe in accordance with ASTM F1043 Materials Design Group IC (**LG-40**), minimum steel yield strength 50,000 psi (344 MPa). Type B external coating, hot dip galvanized zinc 0.9 oz/ ft² (305 g/m²) with a clear polymeric overcoat, Type D interior 90% zinc-rich coating having a minimum thickness of 0.30 mils (0.0076 mm).

1. Line post <Insert outside diameter, weight>
2. End, Corner, Pull post < Insert outside diameter, weight>
3. Top, brace, bottom and intermediate rails, 1.660 in. (42.2 mm) OD: <Insert, outside diameter, weight>

C. Typical post and rail size for normal Commercial / Industrial applications

Item	Fence Height	Outside Diameter	*F1083 Schedule 40		F1043-IC (LG-40)
		Inches (mm)	Weight lb/ft (kg/m)		Weight lb/ft (kg/m)
Line post	up to 6 ft. (1.8 m)	1.900 (48.3)	2.72	(4.0)	2.28 (3.39)
	over 6 to 8 ft. (1.8 to 2.4 m)	2.375 (60.3)	3.65	(5.4)	3.12 (4.64)
	over 8 to 12 ft. (2.4 to 3.7 m)	2.875 (73.0)	5.79	(8.6)	4.64 (6.91)
	over 12 to 16 ft. (3.7 to 4.9 m)	4 . 0 0 0 (101.6)	9.11	(13.6)	6.56 (9.78)
Terminal post	up to 6 ft. (1.8 m)	2.375 (60.3)	3.65	(5.4)	3.12 (4.64)
	over 6 to 8 ft. (1.8 to 2.4 m)	2.875 (73.0)	5.79	(8.6)	4.64 (6.91)
	over 8 to 12 ft. (2.4 to 3.7 m)	4.000 (101.6)	9.11	(13.6)	6.56 (9.78)

	over 12 to 16 ft. (3.7 to 4.9 m)	6.625 (168.3)	18.97 (28.2)	Not available
		8.625 (219.1)	28.58 (42.5)	Not available
Rails		1.660 (42.2)	2.27 (3.4)	1.84 (2.74)

*Regular Grade F1083 Schedule 40

Framework Wind Load Caution:

Fences containing windscreens or privacy slats and fences greater than 8 feet (2.4 m) in height using, 1 in. (25 mm) mesh or smaller - recommend a wind load force analysis for post selection and post spacing. See Chain Link Manufactures Institute – Wind Load Guide CLFMI: WLG 2445. A interactive Wind load Fence Post Calculator is available at www.wheatland.com

2.4 TENSION WIRE

- A. Metallic Coated Steel Marcellled Tension Wire: 7 gauge core (0.177 in.) (4.50 mm) marcellled wire complying with ASTM A824 [Match coating type to that of the chain link fabric] <Insert metallic coating Type and class when applicable>
 - 1. Type I Aluminum–Coated **ARMORLINK®** (Aluminized) 0.40 oz/ft² (122 g/m²)

2.5 BARBED WIRE

- A. Metallic Coated Steel Barbed Wire: Comply with ASTM A121, Design Number 12-4-5-14R, double 12-½ gauge (0.099 in.) (2.51 mm) twisted strand wire, with 4 point 14 gauge (0.080 in.) (2.03 mm) round barbs spaced 5 inches (127 mm) on center. Match coating type to that of the chain link fabric. <12-4-5-14R is specifically designed for chain link fence applications> <Insert material coating specification including type and class when applicable>
 - 1. Coating Type A - Aluminum-Coated **ARMORLINK®** (Aluminized): Strand wire coating Type A - 0.30 oz/ft² (90 g/m²) with aluminum alloy barbs.

6. FITTINGS

- A. Tension and Brace Bands: Galvanized pressed steel complying with ASTM F626, minimum steel thickness of 12 gauge (0.105 in.) (2.67 mm), minimum width of 3/4

in. (19 mm) and minimum zinc coating of 1.20 oz/ft² (366 g/m²). Secure bands with 5/16 in. (7.94 mm) galvanized steel carriage bolts.

- B. Terminal Post Caps, Line Post Loop Tops, Rail and Brace Ends, Boulevard Clamps, Rail Sleeves: In compliance to ASTM F626, pressed steel galvanized after fabrication having a minimum zinc coating of 1.20 oz/ft² (366 g/m²).
- C. Truss Rod Assembly: In compliance with ASTM F626, 3/8 in. (9.53 mm) or 5/16" (7.94 mm) diameter steel truss rod with a pressed steel tightener, minimum zinc coating of 1.2 oz/ft² (366 g/m²), assembly capable of withstanding a tension of 2,000 lbs. (970 kg).
- D. Tension Bars: In compliance with ASTM F626. Galvanized steel one-piece length 2 in. (50 mm) less than the fabric height. Minimum zinc coating 1.2 oz. /ft² (366 g/m²).
 - *[Bars for 2 in. (50 mm) and 1 ¾ in. (44 mm) mesh shall have a minimum cross section of 3/16 in. (4.8 mm) by 3/4 in. (19 mm)]
 - *[Bars for 1 in. (25 mm) mesh shall have a cross section of 1/4 in. (6.4 mm) by 3/8 in. (9.5 mm)]
 - *[Small mesh 3/8 in. (10 mm), 1/2 in. (13 mm) and 5/8 in. (16 mm) shall be attached (sandwiched) to the terminal post using a galvanized steel strap having a minimum cross section of 2 in. (51 mm) by 3/16 in. (4.8 mm) with holes spaced 15 in. (381 mm) on center to accommodate 5/16 in. (7.9 mm) carriage bolts which are to be bolted thru the strap the mesh and thru the terminal post.]
- E. Barbed Wire Arms: In compliance with ASTM F626, pressed steel galvanized after fabrication, minimum zinc coating of 1.20 oz. /ft² (366 g/m²), capable of supporting a vertical 250 lb (113 kg) load. [Type I – three strand 45 degree (0.785 rad) arm] [Type II – three strand vertical arm] [Type III – “V” shaped six strand arm]

7. TIE WIRE and HOG RINGS

- A. Basic commercial / industrial applications - specify 9 gauge core aluminum alloy ties and hog rings per ASTM F626.

2.9 SWING GATES

- A. Swing Gates: Galvanized steel pipe welded fabrication in compliance with ASTM F900. Gate frame members 1.900 in. OD (48.3 mm) <Insert pipe specification> [ASTM F 1083 schedule 40 galvanized steel pipe] or [ASTM F1043 Group IC (LG-40) galvanized steel pipe] Frame members spaced no greater than 8 ft. (2440 mm) apart vertically and horizontally. Welded joints protected by applying zinc-rich paint in accordance with ASTM Practice A780. Positive locking gate latch,

pressed steel galvanized after fabrication. Galvanized malleable iron or heavy gauge pressed steel post and frame hinges. Provide lockable drop bar and gate holdbacks with double gates. <Match gate fabric to that of the fence system> Gateposts per ASTM F1083 schedule 40 galvanized steel pipe. <Select the gatepost diameter from table 2.9 B> <Insert diameter and weight>

B. Gateposts: Regular Grade ASTM F1083 Schedule 40 pipe

Gate fabric height up to and including 6 ft. (1.2m)		
Gate leaf width	Post Outside Diameter	Weight
up to 4 ft. (1.2 m)	2.375 in. (60.3 mm)	3.65 lb/ft (5.4 kg/m)
over 4 ft. to 10 ft. (1.2 to 3.05 m)	2.875 in. (73.0 mm)	5.79 lb/ft (8.6 kg/m)
over 10 ft. to 18 ft. (3.05 to 5.5 m)	4.000 in. (101.6 mm)	9.11 lb/ft (13.6 kg/m)
Gate fabric height over 6 ft. to 12 ft. (1.2 to 2.4m)		
Gate leaf width		
up to 6 ft. (1.8 m)	2.875 in. (73.0 mm)	5.79 lb/ft (8.6 kg/m)
over 6 ft. to 12 ft. (1.8 to 3.7 m)	4.000 in. (101.6 mm)	9.11 lb/ft (13.6 kg/m)
over 12 ft. to 18 ft. (2.4 to 5.5 m)	6.625 in. (168.3 mm)	18.97 lb/ft (28.2 kg/m)
over 18 ft. to 24 ft. (5.5 to 7.3 m)	8.625 in. (219.1 mm)	28.58 lb/ft (42.5 kg/m)

2.10 HORIZONTAL SLIDE GATES

A. Cantilever Slide Gates: **SECURE-TRAC®** Made in accordance with ASTM F 1184 Type II Class 2, and in compliance with UL-325, and ASTM 2200. (No substitution) Gate to be made of Aluminum Alloy 6005A-T61. All square members are 2" sq. weighing 0.94 lb/FT (139 kg/m). Complete frame welded to top one piece track and 4" x 2" bottom rail weighing 1.71 lbs./ft. (2.54 kg/m) Supply 2 truck assemblies that are swivel type having lubricated and scaled ball bearing wheels that will align in the track during all normal operations of the gate.

Standard Opening	Standard Support Overhang
11'-0" (3354 mm) through 14'-0" (4267 mm)	7'-6" (2286 mm)
15'-0" (4572 mm) through 22'-0" (6706 mm)	10'-0" (3048 mm)
23'-0" (7010 mm) through 30'-0" (9144 mm)	12'-0" (3857 mm)
31'-0" (9449 mm) through 40'-0" (12192 mm)	16'-0" (4876 mm)

Gates 31'0" (9449 mm) through 40'0" (12192 mm) dual top tracks and two additional truck assemblies. For gates over 40'0" (12192 mm), contact Merchants Metals for custom drawings and specs.

- B. Chain Link 2" Fabric: **ARMORLINK®** Aluminized fabric.
- C. Finish - choose one: Natural Aluminum or Polymer coated horizontal slide gates and posts shall match the coating type and color as that specified for the fence framework, available colors - black, green, or brown.
- D. Gateposts, 4" O.D. (101.6 mm) schedule 40 weighing 9.11 lb/ft (13.6 kg/m). Single gates with single tracks require 3 gate posts. (1 latch post and 2 support posts) Single gates with dual tracks require 5 gate posts. (1 latch and 2 dual support posts) Double gates require twice the number of support posts but do not have a latch post.
- E. Electrically operated horizontal slide gates must be manufactured and installed to comply with the safety requirements of ASTM F2200 and UL 325.

2.11 CONCRETE

Concrete for post footings shall have a 28-day compressive strength of 2,500 psi. (17.2 MPa).

PART 3 EXECUTION

1. CLEARING FENCE LINE

Clearing: Surveying, clearing, grubbing, grading and removal of debris for the fence line or any required clear areas adjacent to the fence <Insert project requirement> [is included in the earthwork contractor's contract under the provisions of Division 31 - Earthwork.] [is not included in the earthwork contractor's contract and is the responsibility of the fence contractor in accordance with the provisions of Division 31 - Earthwork.] The contract drawings indicate the extent of the area to be cleared and grubbed.

3.2 FRAMEWORK INSTALLATION

- A. Posts: Posts shall be set plumb in concrete footings in accordance with ASTM F567. Minimum footing depth, 24 in. (609.6 mm) plus an additional 3 in. (76.2 mm) depth for each 1 ft. (305 mm) increase in the fence height over 4 ft. (1220 mm). Minimum footing diameter four times the largest cross section of the post up to a 4.00" (101.6 mm) dimension and three times the largest cross section of post

greater than a 4.00" (101.6 mm) dimension. <Insert footing depth and diameter>
<Local codes, site soil conditions, local frost depth, fence height and wind load may require larger diameter or deeper footings - See Chain Link Manufactures Institute – Product Guide and Wind Load Guide CLFMI: WLG 2445> Top of concrete footing to be [at grade crowned to shed water away from the post or 6 inches (152 mm) below grade] <Insert footing grade requirement> crowned to shed water away from the post. Line posts installed at intervals not exceeding 10 ft. (3.05 m) on center.

- B. Top rail: When specified, install 21 ft. (6.4 m) lengths of rail continuous thru the line post or barb arm loop top. Splice rail using top rail sleeves minimum 6 in. (152 mm) long. Rail shall be secured to the terminal post by a brace band and rail end. Bottom rail or intermediate rail shall be field cut and secured to the line posts using boulevard clamps or brace band with rail end. <Fences 12 feet (3.66 m) high or higher require mid rail>
- C. Terminal posts: End, corner, pull and gate posts shall be braced and trussed for fence 6 ft. (1.8 m) and higher and for fences 5 ft. (1.5 m) in height not having a top rail. The horizontal brace rail and diagonal truss rod shall be installed in accordance with ASTM F567.
- D. Tension wire: Shall be installed 4 in. (101.6 mm) up from the bottom of the fabric. Fences without top rail shall have a tension wire installed 4 in. (101.6 mm) down from the top of the fabric. Tension wire to be stretched taut, independently and prior to the fabric, between the terminal posts and secured to the terminal post using a brace band. Secure the tension wire to each line post with a tie wire. <Install the top tension wire through the barb arm loop for fences having barbed wire and no top rail.>

3. CHAIN LINK FABRIC INSTALLATION

Chain Link Fabric: Install fabric to [outside or inside] of the framework maintaining a ground clearance of no more than 2 inches (50 mm). Attach fabric to the terminal post by threading the tension bar through the fabric; secure the tension bar to the terminal post with tension bands and 5/16 in. (7.94 mm) carriage bolts spaced no greater than 12 inches (304.8mm) on center. Small mesh fabric less than 1 in. (25 mm), attach to terminal post by sandwiching the mesh between the post and a vertical 2 in. wide (50mm) by 3/16 in. (4.76 mm) galvanized steel strap using carriage bolts, bolted thru the bar, mesh and post spaced 15 in. (381 mm) on center. Chain link fabric to be stretched taut free of sag. Fabric to be secured to the line post with tie wires spaced no greater than 12 inches (304.8 mm) on center and to horizontal rail spaced no greater than 18 inches (457.2 mm) on center. [Aluminum alloy tie wire shall be installed following ASTM F567: Wrap the tie around the post

or rail and attached to a fabric wire picket on each side of the post or rail by twisting the tie wire around the fabric wire picket two full turns, cut off excess wire and bend over to prevent injury.] [Preformed 9 gauge power-fastened wire ties shall be installed following ASTM F626: Wrap the tie a full 360° around the post or rail and fabric wire picket, using a variable speed drill, twist the two ends together three full turns, cut off any excess wire and bend over to prevent injury.] Secure the fabric to the tension wire by crimping hogs rings around a fabric wire picket and tension wire.

3.4 BARBED WIRE INSTALLATION

Barbed Wire: Stretched taut between terminal posts and secured in the slots provided on the line post barb arms. Attach each strand of barbed wire to the terminal post using a brace band. <Indicate type of barb arm, Type I, II or III and direction [inward] [outward] for installation of Type I arm. >

3.5 GATE INSTALLATION

- A. Swing Gates: Installation of swing gates and gateposts in compliance with ASTM F 567. Direction of swing shall be [inward or outward.] Gates shall be plumb in the closed position having a bottom clearance of 3 in. (76 mm), grade permitting. Hinge and latch offset opening space shall be no greater than 3 in. (76 mm) in the closed position. Double gate drop bar receivers shall be set in a concrete footing minimum 6 in. (152 mm) diameter 24 in. (609.6 mm) deep. Gate leaf holdbacks shall be installed for all double gates.

Electrically operated gates must be manufactured and installed in compliance with ASTM F2200 and UL 325.

- B. Horizontal Slide Gates: Install according to manufacturer's instructions and in accordance with ASTM F567. Gates shall be plum in the closed position, installed to slide with an initial pull force no greater than 40 lbs. (18.14 kg). Double gate drop bar receivers to be installed in a concrete footing as required by site conditions and codes. Ground clearance shall be 3 in. (76 mm), grade permitting. Electrically operated gate installation must conform to ASTM F2200 and UL 325.

3.6 NUTS AND BOLTS

Bolts: Carriage bolts used for fittings shall be installed with the head on the secure side of the fence. All bolts shall be peened over to prevent removal of the nut.

7. ELECTRICAL GROUNDING

Grounding: Grounding of the fence and gates is not the responsibility of the fence contractor and not included in the fencing scope of work for this contract. Grounding, when required, shall be specified and included in Contract Section 33 79 00 Site Grounding. A licensed electrical contractor shall install grounding when required.

8. CLEAN UP

Clean Up: The area of the fence line shall be left neat and free of any debris caused by the installation of the fence.

END OF SECTION 32 31 13

SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE