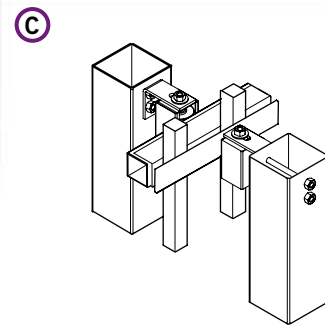
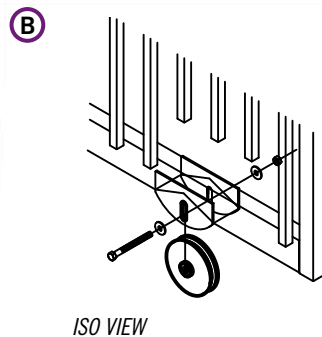
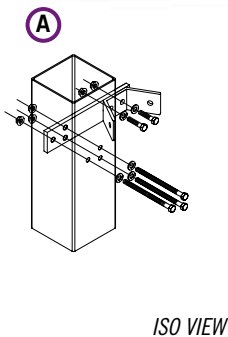
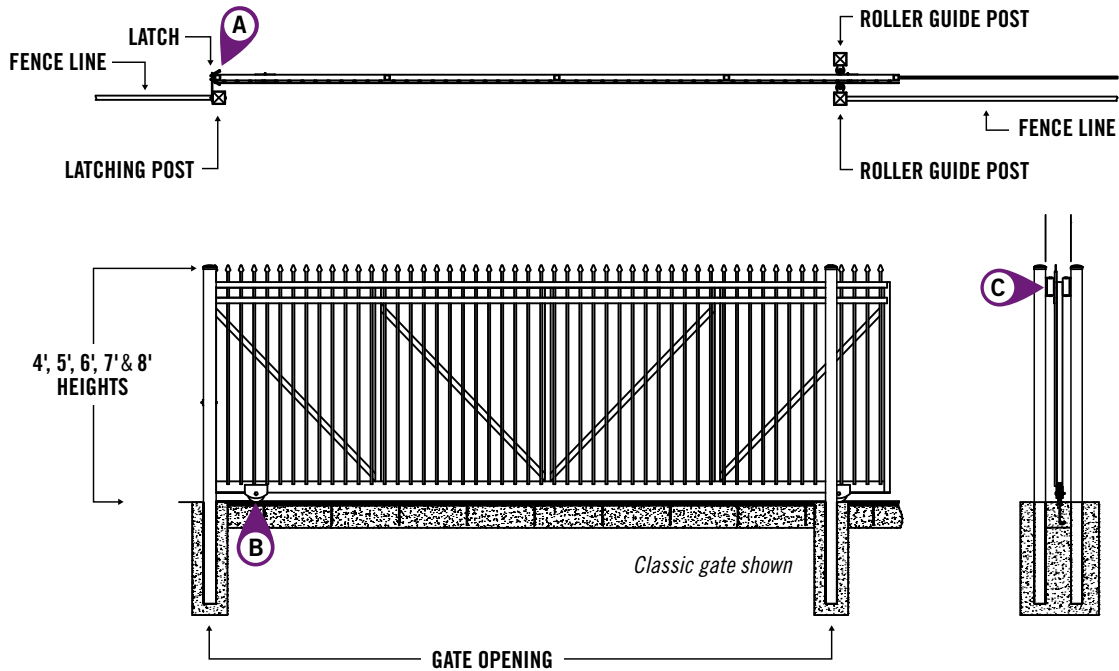


PASSPORT®

2"sq x 12ga UPRIGHTS & DIAGONAL BRACES | .75"sq PICKETS | 2" x 4" x 11ga BOTTOM RAIL (notched & plated for v-track wheels)



ROLL GATE SAFETY WARNING

PassPort Roll Gates are supplied with 2" mesh safety screening in sufficient quantities to cover the entire gate and an equal portion of fence parallel to the gate in the open position up to a height of over 6 feet from ground elevation. ***This screening must be included when the PassPort Gate is installed at the jobsite. Additionally, all of the safety requirements of ASTM F2200 must be met during installation. Failure to incorporate the safety mesh or follow ASTM F2200 safety requirements during gate assembly and installation will cause rejection of the entire gate system any time an attempt is made to attach the gate to an automatic gate operator. Ameristar assumes no responsibility for gate installations that fail to utilize the materials provided or meet the applicable safety standards.***

Refer to construction specification & tables within this section for more details.

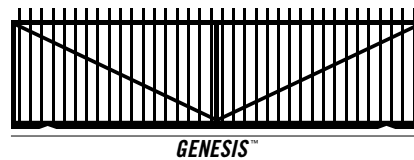
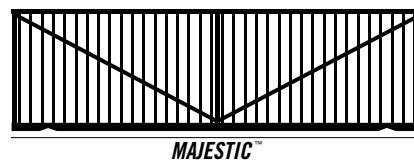
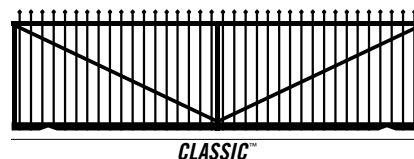
Effective: 09/15/20

PASSPORT® | 2-RAIL ROLL GATES

RAIL SPACINGS MATCH MONTAGE PLUS PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4' - 6'	103.75"	1 [X] ⊗ 204606R*	192 lbs	22
6' - 8'	122.25"	1 [X] ⊗ 204608R*	214 lbs	26
8' - 10'	150"	1 [X] ⊗ 204610R*	248 lbs	31
10' - 12'	168.5"	1 [X] ⊗ 204612R*	271 lbs	35
12' - 14'	205.5"	1 [X] ⊗ 204614R**	378 lbs	43
14' - 16'	224"	1 [X] ⊗ 204616R**	400 lbs	48
16' - 18'	242.5"	1 [X] ⊗ 204618R**	425 lbs	52
18' - 20'	279.5"	1 [X] ⊗ 204620R**	472 lbs	60
20' - 22'	298"	1 [X] ⊗ 204622R**	494 lbs	64
22' - 24'	316.5"	1 [X] ⊗ 204624R**	519 lbs	68
24' - 26'	335"	1 [X] ⊗ 204626R**	541 lbs	72
26' - 28'	362.75"	1 [X] ⊗ 204628R***	642 lbs	78
28' - 30'	390.5"	1 [X] ⊗ 204630R***	681 lbs	84
30' - 32'	418.25"	1 [X] ⊗ 204632R***	719 lbs	89

4'
HEIGHT



4' - 6'	103.75"	1 [X] ⊗ 205806R*	219 lbs	22
6' - 8'	122.25"	1 [X] ⊗ 205808R*	243 lbs	26
8' - 10'	150"	1 [X] ⊗ 205810R*	281 lbs	31
10' - 12'	168.5"	1 [X] ⊗ 205812R*	306 lbs	35
12' - 14'	205.5"	1 [X] ⊗ 205814R**	428 lbs	43
14' - 16'	224"	1 [X] ⊗ 205816R**	452 lbs	48
16' - 18'	242.5"	1 [X] ⊗ 205818R**	479 lbs	52
18' - 20'	279.5"	1 [X] ⊗ 205820R**	531 lbs	60
20' - 22'	298"	1 [X] ⊗ 205822R**	555 lbs	64
22' - 24'	316.5"	1 [X] ⊗ 205824R**	582 lbs	68
24' - 26'	335"	1 [X] ⊗ 205826R**	606 lbs	72
26' - 28'	362.75"	1 [X] ⊗ 205828R***	721 lbs	78
28' - 30'	390.5"	1 [X] ⊗ 205830R***	763 lbs	84
30' - 32'	418.25"	1 [X] ⊗ 205832R***	805 lbs	89

5'
HEIGHT

6' HEIGHTS ON NEXT PAGE

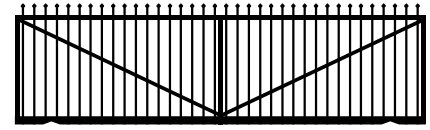
Effective: 09/15/20

PASSPORT® | 2-RAIL ROLL GATES

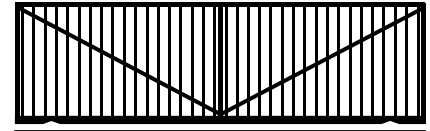
RAIL SPACINGS MATCH MONTAGE PLUS PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4' - 6'	103.75"	1 207006R*	246 lbs	22
6' - 8'	122.25"	1 207008R*	273 lbs	26
8' - 10'	150"	1 207010R*	314 lbs	31
10' - 12'	168.5"	1 207012R*	341 lbs	35
12' - 14'	205.5"	1 207014R**	479 lbs	43
14' - 16'	224"	1 207016R**	505 lbs	48
16' - 18'	242.5"	1 207018R**	534 lbs	52
18' - 20'	279.5"	1 207020R**	590 lbs	60
20' - 22'	298"	1 207022R**	617 lbs	64
22' - 24'	316.5"	1 207024R**	646 lbs	68
24' - 26'	335"	1 207026R**	673 lbs	72
26' - 28'	362.75"	1 207028R***	802 lbs	78
28' - 30'	390.5"	1 207030R***	846 lbs	84
30' - 32'	418.25"	1 207032R***	891 lbs	89

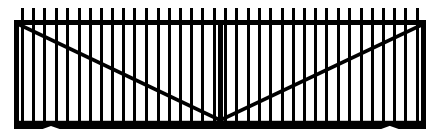
6'
HEIGHT



CLASSIC™



MAJESTIC™



GENESIS™

= FENCE STYLES AVAILABLE | **C** = Classic **M** = Majestic **G** = Genesis

= COLOR OPTIONS AVAILABLE | **B** = Black **N** = Bronze **W** = White **S** = Sand

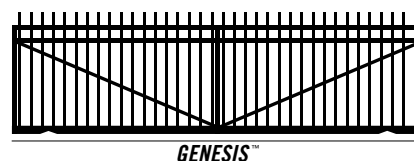
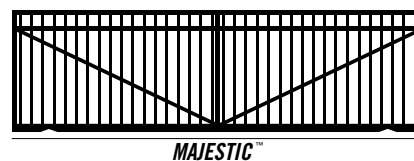
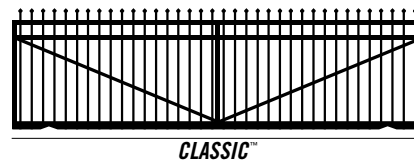
* 2-Bays | ** 4-Bays | *** 6-Bays

Effective: 09/15/20

PASSPORT® | 3-RAIL ROLL GATES

RAIL SPACINGS MATCH MONTAGE PLUS PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4' - 6'	103.75"	1 [X] ⊗ 304606R*	219 lbs	22
6' - 8'	122.25"	1 [X] ⊗ 304608R*	245 lbs	26
8' - 10'	150"	1 [X] ⊗ 304610R*	286 lbs	31
10' - 12'	168.5"	1 [X] ⊗ 304612R*	314 lbs	35
12' - 14'	205.5"	1 [X] ⊗ 304614R**	430 lbs	43
14' - 16'	224"	1 [X] ⊗ 304616R**	457 lbs	48
16' - 18'	242.5"	1 [X] ⊗ 304618R**	487 lbs	52
18' - 20'	279.5"	1 [X] ⊗ 304620R**	543 lbs	60
20' - 22'	298"	1 [X] ⊗ 304622R**	569 lbs	64
22' - 24'	316.5"	1 [X] ⊗ 304624R**	600 lbs	68
24' - 26'	335"	1 [X] ⊗ 304626R**	626 lbs	72
26' - 28'	362.75"	1 [X] ⊗ 304628R***	735 lbs	78
28' - 30'	390.5"	1 [X] ⊗ 304630R***	780 lbs	84
30' - 32'	418.25"	1 [X] ⊗ 304632R***	826 lbs	89



4' - 6'	103.75"	1 [X] ⊗ 305806R*	245 lbs	22
6' - 8'	122.25"	1 [X] ⊗ 305808R*	274 lbs	26
8' - 10'	150"	1 [X] ⊗ 305810R*	319 lbs	31
10' - 12'	168.5"	1 [X] ⊗ 305812R*	349 lbs	35
12' - 14'	205.5"	1 [X] ⊗ 305814R**	480 lbs	43
14' - 16'	224"	1 [X] ⊗ 305816R**	509 lbs	48
16' - 18'	242.5"	1 [X] ⊗ 305818R**	541 lbs	52
18' - 20'	279.5"	1 [X] ⊗ 305820R**	602 lbs	60
20' - 22'	298"	1 [X] ⊗ 305822R**	630 lbs	64
22' - 24'	316.5"	1 [X] ⊗ 305824R**	663 lbs	68
24' - 26'	335"	1 [X] ⊗ 305826R**	691 lbs	72
26' - 28'	362.75"	1 [X] ⊗ 305828R***	813 lbs	78
28' - 30'	390.5"	1 [X] ⊗ 305830R***	862 lbs	84
30' - 32'	418.25"	1 [X] ⊗ 305832R***	911 lbs	89





































4' - 6'	103.75"	1 [X] ⊗ 307006R	273 lbs	22
6' - 8'	122.25"	1 [X] ⊗ 307008R	304 lbs	26
8' - 10'	150"	1 [X] ⊗ 307010R	352 lbs	31
10' - 12'	168.5"	1 [X] ⊗ 307012R	384 lbs	35
12' - 14'	205.5"	1 [X] ⊗ 307014R	531 lbs	43
14' - 16'	224"	1 [X] ⊗ 307016R	562 lbs	48

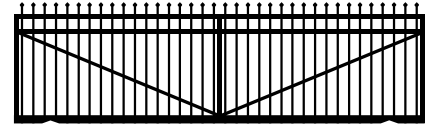
6', 7' & 8' HEIGHTS CONTINUED ON NEXT PAGE

Effective: 09/15/20

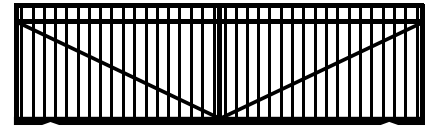
PASSPORT® | 3-RAIL ROLL GATES

RAIL SPACINGS MATCH MONTAGE PLUS PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

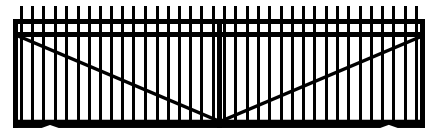
	OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
6' HEIGHT	16' - 18'	242.5"	1  307018R**	596 lbs	52
	18' - 20'	279.5"	1  307020R**	661 lbs	60
	20' - 22'	298"	1  307022R**	692 lbs	64
	22' - 24'	316.5"	1  307024R**	727 lbs	68
	24' - 26'	335"	1  307026R**	758 lbs	72
	26' - 28'	362.75"	1  307028R***	894 lbs	78
	28' - 30'	390.5"	1  307030R***	945 lbs	84
	30' - 32'	418.25"	1  307032R***	997 lbs	89
7' HEIGHT	4' - 6'	103.75"	1  308206R*	300 / 303†	22
	6' - 8'	122.25"	1  308208R*	333 / 337†	26
	8' - 10'	150"	1  308210R*	385 / 389†	31
	10' - 12'	168.5"	1  308212R*	420 / 424†	35
	12' - 14'	205.5"	1  308214R**	582 / 587†	43
	14' - 16'	224"	1  308216R**	615 / 621†	48
	16' - 18'	242.5"	1  308218R**	652 / 658†	52
	18' - 20'	279.5"	1  308220R**	722 / 729†	60
	20' - 22'	298"	1  308222R**	755 / 763†	64
	22' - 24'	316.5"	1  308224R**	792 / 800†	68
	24' - 26'	335"	1  308226R**	825 / 834†	72
	26' - 28'	362.75"	1  308228R***	975 / 984†	78
	28' - 30'	390.5"	1  308230R***	1030 / 1040†	84
	30' - 32'	418.25"	1  308232R***	1085 / 1096†	89
8' HEIGHT	4' - 6'	103.75"	1  309406R*	328 / 330†	22
	6' - 8'	122.25"	1  309408R*	364 / 367†	26
	8' - 10'	150"	1  309410R*	418 / 422†	31
	10' - 12'	168.5"	1  309412R*	456 / 460†	35
	12' - 14'	205.5"	1  309414R**	634 / 639†	43
	14' - 16'	224"	1  309416R**	670 / 675†	48
	16' - 18'	242.5"	1  309418R**	708 / 714†	52
	18' - 20'	279.5"	1  309420R**	783 / 790†	60
	20' - 22'	298"	1  309422R**	818 / 826†	64
	22' - 24'	316.5"	1  309424R**	857 / 865†	68
	24' - 26'	335"	1  309426R**	893 / 902†	72
	26' - 28'	362.75"	1  309428R***	1057 / 1067†	78
	28' - 30'	390.5"	1  309430R***	1115 / 1125†	84
	30' - 32'	418.25"	1  309432R***	1174 / 1185†	89



CLASSIC™



MAJESTIC™





GENESIS™



INVINCIBLE™



 = FENCE STYLES AVAILABLE | **C** = Classic
M = Majestic **G** = Genesis **I** = Invincible†
 = COLOR OPTIONS AVAILABLE | **B** = Black
N = Bronze **W** = White **S** = Sand

Note: All gates that exceed 192" in length for Invincible and all 8' gates that exceed 192" in length for Classic, Genesis & Majestic will have bolt-on panels with face-welded pales.

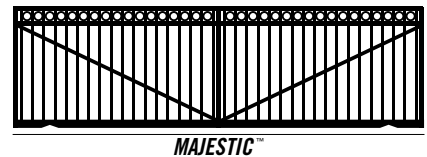
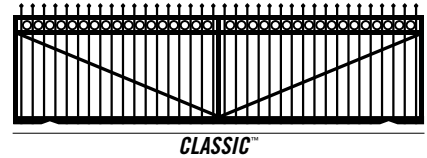
* 2-Bays | ** 4-Bays | *** 6-Bays

Effective: 09/15/20

PASSPORT® | 3-RAIL ROLL GATES WITH RINGS

RAIL SPACINGS MATCH MONTAGE PLUS PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
4' - 6'	103.75"	1 [X] ⊗ 304606RR*	226 lbs	22
6' - 8'	122.25"	1 [X] ⊗ 304608RR*	254 lbs	26
8' - 10'	150"	1 [X] ⊗ 304610RR*	297 lbs	31
10' - 12'	168.5"	1 [X] ⊗ 304612RR*	327 lbs	35
12' - 14'	205.5"	1 [X] ⊗ 304614RR**	446 lbs	43
14' - 16'	224"	1 [X] ⊗ 304616RR**	473 lbs	48
16' - 18'	242.5"	1 [X] ⊗ 304618RR**	505 lbs	52
18' - 20'	279.5"	1 [X] ⊗ 304620RR**	564 lbs	60
20' - 22'	298"	1 [X] ⊗ 304622RR**	592 lbs	64
22' - 24'	316.5"	1 [X] ⊗ 304624RR**	623 lbs	68
24' - 26'	335"	1 [X] ⊗ 304626RR**	651 lbs	72
26' - 28'	362.75"	1 [X] ⊗ 304628RR***	762 lbs	78
28' - 30'	390.5"	1 [X] ⊗ 304630RR***	809 lbs	84
30' - 32'	418.25"	1 [X] ⊗ 304632RR***	857 lbs	89



4' - 6'	103.75"	1 [X] ⊗ 305806RR*	253 lbs	22
6' - 8'	122.25"	1 [X] ⊗ 305808RR*	283 lbs	26
8' - 10'	150"	1 [X] ⊗ 305810RR*	330 lbs	31
10' - 12'	168.5"	1 [X] ⊗ 305812RR*	362 lbs	35
12' - 14'	205.5"	1 [X] ⊗ 305814RR**	496 lbs	43
14' - 16'	224"	1 [X] ⊗ 305816RR**	526 lbs	48
16' - 18'	242.5"	1 [X] ⊗ 305818RR**	559 lbs	52
18' - 20'	279.5"	1 [X] ⊗ 305820RR**	623 lbs	60
20' - 22'	298"	1 [X] ⊗ 305822RR**	653 lbs	64
22' - 24'	316.5"	1 [X] ⊗ 305824RR**	687 lbs	68
24' - 26'	335"	1 [X] ⊗ 305826RR**	717 lbs	72
26' - 28'	362.75"	1 [X] ⊗ 305828RR**	841 lbs	78
28' - 30'	390.5"	1 [X] ⊗ 305830RR***	891 lbs	84
30' - 32'	418.25"	1 [X] ⊗ 305832RR***	942 lbs	89

4' - 6'	103.75"	1 [X] ⊗ 307006RR*	280 lbs	22
6' - 8'	122.25"	1 [X] ⊗ 307008RR*	313 lbs	26
8' - 10'	150"	1 [X] ⊗ 307010RR*	363 lbs	31
10' - 12'	168.5"	1 [X] ⊗ 307012RR*	397 lbs	35
12' - 14'	205.5"	1 [X] ⊗ 307014RR*	546 lbs	43
14' - 16'	224"	1 [X] ⊗ 307016RR**	579 lbs	48

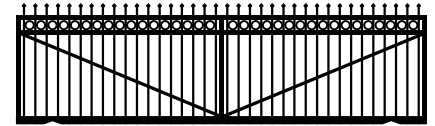
6', 7' & 8' HEIGHTS CONTINUED ON NEXT PAGE

Effective: 09/15/20

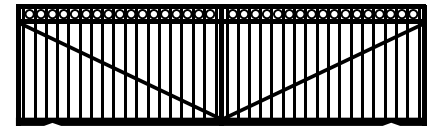
PASSPORT® | 3-RAIL ROLL GATES WITH RINGS

RAIL SPACINGS MATCH MONTAGE PLUS PANELS | OPENINGS OVER 32' HAVE A 2-PIECE FRAME

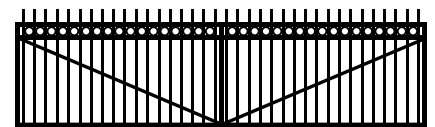
OPENING	LENGTH	ITEM NUMBER	WEIGHT	PICKET QTY
6' HEIGHT	16' - 18'	1 ⊗ 307018RR**	614 lbs	52
	18' - 20'	1 ⊗ 307020RR**	682 lbs	60
	20' - 22'	1 ⊗ 307022RR**	715 lbs	64
	22' - 24'	1 ⊗ 307024RR**	751 lbs	68
	24' - 26'	1 ⊗ 307026RR**	783 lbs	72
	26' - 28'	1 ⊗ 307028RR***	921 lbs	78
	28' - 30'	1 ⊗ 307030RR***	975 lbs	84
30' - 32'	1 ⊗ 307032RR***	1029 lbs	89	
7' HEIGHT	4' - 6'	1 ⊗ 308206RR*	308 / 310†	22
	6' - 8'	1 ⊗ 308208RR*	343 / 346†	26
	8' - 10'	1 ⊗ 308210RR*	396 / 400†	31
	10' - 12'	1 ⊗ 308212RR*	432 / 437†	35
	12' - 14'	1 ⊗ 308214RR**	597 / 603†	43
	14' - 16'	1 ⊗ 308216RR**	632 / 638†	48
	16' - 18'	1 ⊗ 308218RR**	670 / 676†	52
	18' - 20'	1 ⊗ 308220RR**	743 / 750†	60
	20' - 22'	1 ⊗ 308222RR**	778 / 785†	64
	22' - 24'	1 ⊗ 308224RR**	816 / 824†	68
	24' - 26'	1 ⊗ 308226RR**	850 / 859†	72
	26' - 28'	1 ⊗ 308228RR***	1002 / 1012†	78
	28' - 30'	1 ⊗ 308230RR***	1059 / 1069†	84
30' - 32'	1 ⊗ 308232RR***	1117 / 1127†	89	
8' HEIGHT	4' - 6'	1 ⊗ 309406RR*	335 / 338†	22
	6' - 8'	1 ⊗ 309408RR*	373 / 376†	26
	8' - 10'	1 ⊗ 309410RR*	430 / 433†	31
	10' - 12'	1 ⊗ 309412RR*	468 / 472†	35
	12' - 14'	1 ⊗ 309414RR**	649 / 654†	43
	14' - 16'	1 ⊗ 309416RR**	686 / 692†	48
	16' - 18'	1 ⊗ 309418RR**	726 / 732†	52
	18' - 20'	1 ⊗ 309420RR**	804 / 811†	60
	20' - 22'	1 ⊗ 309422RR**	841 / 848†	64
	22' - 24'	1 ⊗ 309424RR**	881 / 889†	68
	24' - 26'	1 ⊗ 309426RR**	918 / 927†	72
	26' - 28'	1 ⊗ 309428RR***	1085 / 1094†	78
	28' - 30'	1 ⊗ 309430RR***	1145 / 1155†	84
30' - 32'	1 ⊗ 309432RR***	1205 / 1216†	89	



CLASSIC™



MAJESTIC™



GENESIS™



INVINCIBLE™



= FENCE STYLES AVAILABLE | **C** = Classic
M = Majestic **G** = Genesis **I** = Invincible†
 = COLOR OPTIONS AVAILABLE | **B** = Black
N = Bronze **W** = White **S** = Sand

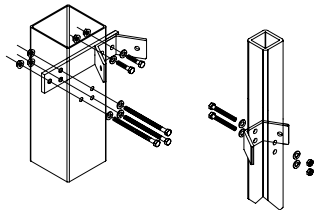
Note: All gates that exceed 192" in length for Invincible and all 8' gates that exceed 192" in length for Classic, Genesis & Majestic will have bolt-on panels with face-welded pales.

* 2-Bays | ** 4-Bays | *** 6-Bays

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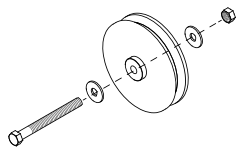
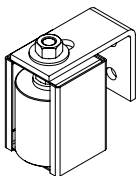
PASSPORT® | HARDWARE

V-TRACK NOT INCLUDED



DESCRIPTION	ITEM NUMBER	WHEEL QTY	BOX QTY	WEIGHT
PassPort Gate Kit	PGKODN	2	1	35

Kits include: (2) 6" Wheel Kits / includes wheels, bearings, spacer bushings, washers, bolts & lock nuts | (2) Safety Guide Rollers | (1) Gate Latch



PASSPORT® | ORNAMENTAL SQUARE POST

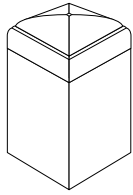
DESCRIPTION	POST LENGTH	ITEM NUMBER	POST WEIGHT
4" sq. x 11ga. STEEL	6'	P⊗ 40072	39 lbs
	7'	P⊗ 40084	47 lbs
	8'	P⊗ 40096	54 lbs
	9'	P⊗ 40108	61 lbs
	10'	P⊗ 40120	67 lbs
	11'	P⊗ 40132	74 lbs
	12'	P⊗ 40144	81 lbs
	13'	P⊗ 40156	87 lbs
	14'	P⊗ 40168	94 lbs
	15'	P⊗ 40180	101 lbs
	16'	P⊗ 40192	108 lbs

⊗ = COLOR OPTIONS AVAILABLE | **B** = Black **N** = Bronze **W** = White **S** = Sand

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PASSPORT® | STEEL PLATED ORNAMENTAL SQUARE POSTS

PLATED POSTS USED WITH MAJESTIC PANELS REQUIRE 1" DEPENDING ON GRADE ELEVATION



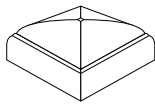
STEEL POSTS

4"sq. x 11ga.

POST LENGTH	PLATE SIZE	ITEM NUMBER	WEIGHT
4'	8" sq. x .375" / .5625" holes (8876G)	P⊗40048P	33 lbs
5'	8" sq. x .375" / .5625" holes (8876G)	P⊗40060P	39 lbs
6'	8" sq. x .375" / .5625" holes (8876G)	P⊗40072P	47 lbs
7'	8" sq. x .375" / .5625" holes (8876G)	P⊗40084P	54 lbs
8'	8" sq. x .375" / .5625" holes (8876G)	P⊗40096P	61 lbs
9'	8" sq. x .375" / .5625" holes (8876G)	P⊗40108P	67 lbs
10'	8" sq. x .375" / .5625" holes (8876G)	P⊗40120P	74 lbs

⊗ = COLOR OPTIONS AVAILABLE | B = Black | N = Bronze | S = Sand | W = White

PASSPORT® | POST CAPS



STANDARD FLAT CAP

Steel

CAP SIZE	ITEM NUMBER	WEIGHT
4"sq.	A⊗509	.4 lbs

⊗ = COLOR OPTIONS AVAILABLE | B = Black | N = Bronze | S = Sand | W = White

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PASSPORT® | CONSTRUCTION SPECIFICATION 32 31 00

STEEL ROLL GATE SYSTEM

PART 1 - GENERAL

1.01 WORK INCLUDED

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

1.02 RELATED WORK

Section 022__ - Earthwork

Section 030__ - Concrete

1.03 SYSTEM DESCRIPTION

The manufacturer shall supply a total roll gate system of Ameristar® PassPort® Commercial Ornamental design series and (*specify the style as Classic™, Majestic™, Genesis™, or Invincible™*) style. The system shall include all components (*i.e., pickets, rails, gate uprights, wheels 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 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 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 D6695** – Standard Practice for Xenon-Arc Exposures of Paint and Related Coatings

1.06 SUBMITTAL

The manufacturer's submittal package shall be provided prior to installation.

1.07 PRODUCT HANDLING AND STORAGE

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

PART 2 - MATERIALS

2.01 MANUFACTURER

The steel roll gate system shall conform to Ameristar PassPort Commercial Ornamental design series, (*specify Classic, Majestic, Genesis, or Invincible* style and (*specify 2-rail or 3-rail*) frame configuration manufactured by Ameristar Fence Products, Inc. in Tulsa, Oklahoma.

2.02 MATERIAL

- A. Steel material for roll gate components (*i.e. pickets, rails, diagonals and uprights*), shall be commercial steel with a minimum yield strength of 45,000 psi (344 MPa).
- B. Ornamental picket material shall be 3/4" square x 14 Ga. Tubing. Picket spacing shall be 4-5/8". Material for top rails, uprights and diagonals rails shall be 2" square x 16ga. Material for the bottom rail shall be 2" x 4" x 11ga. Posts shall be a minimum of 4" square x 11ga.

2.03 FABRICATION

- A. Pickets, rails, uprights and posts shall be pre-cut to specified lengths. Diagonals shall be pre-cut to specified lengths and angles. Frame materials shall be joined by welding. Pickets shall be face welded to roll gate frame, except for Invincible gates over 18' long. Invincible style gates over 18' long shall have pickets face-welded to 2" x 2" angle iron to form panels equal in length to the gate frame bay width.
- B. The manufactured roll gates and bolt-on panels (*if applicable*) 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 pre-treatment/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 1**.
- C. Completed gates shall be capable of supporting a 200 lb. load applied at midspan without permanent deformation.

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PASSPORT® | CONSTRUCTION SPECIFICATION 32 31 00

STEEL ROLL GATE SYSTEM

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

Gate posts shall be set in accordance with the spacings shown in the construction plans. The "Earthwork" and "Concrete" sections of this specification shall govern post base material requirements. 6" wheels shall be bolted to the gate (*between the wheel plates welded near the ends of the gate bottom rail*). The gate shall be set upright with the V-grooved wheels positioned over the pre-installed steel V-track that traverses the gate opening. Roller guides shall be affixed to the gate posts at a height even with the gate top rail to hold the gate in a vertical position. Gate stops shall be welded to the end of the gate or track so gate cannot pass rollers in either direction.

3.03 CLEANING

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

TABLE 1

COATING PERFORMANCE REQUIREMENTS		
QUALITY CHARACTERISTICS	ASTM TEST METHOD	PERFORMANCE REQUIREMENTS
ADHESION	D3359 – METHOD B	Adhesion (<i>retention of coating</i>) over 90% of test area (<i>tape and knife kit test</i>).
CORROSION RESISTANCE	B117, D714, D1654	Corrosion resistance over 1,000 hours (<i>scribed per D1654; failure mode is accumulation of 1/8" coating loss from scribe or medium #8 blisters</i>)
IMPACT RESISTANCE	D2794	Impact resistance over 60" lb. (<i>forward impact using 0.625" ball</i>).
WEATHERING RESISTANCE	D822 D2244, D523 (60° method)	Weathering resistance over 1,000 hours (<i>failure mode is 60% loss of gloss or color variance of more than 3 delta-E color units</i>).

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