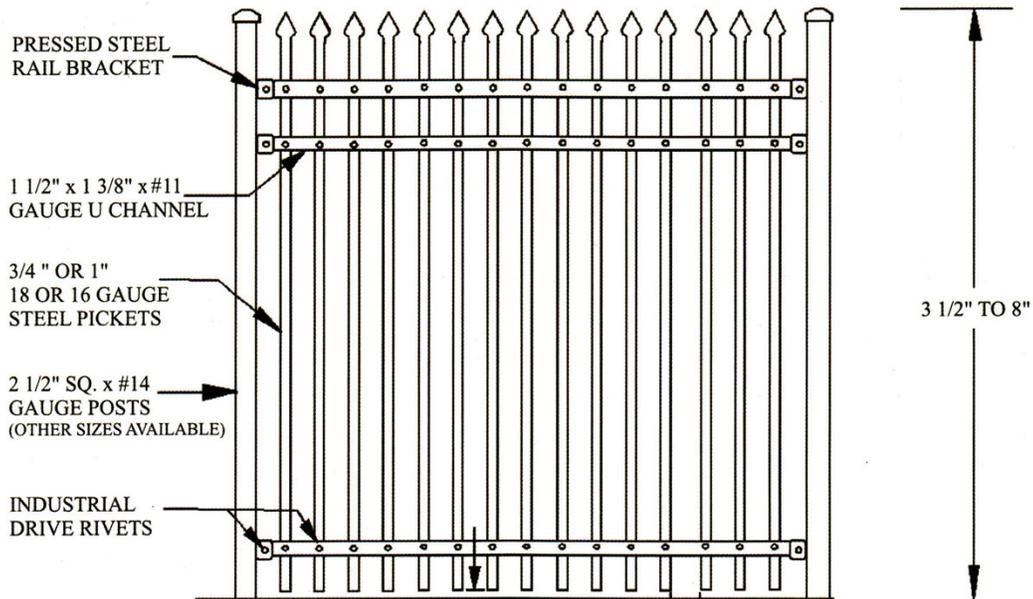


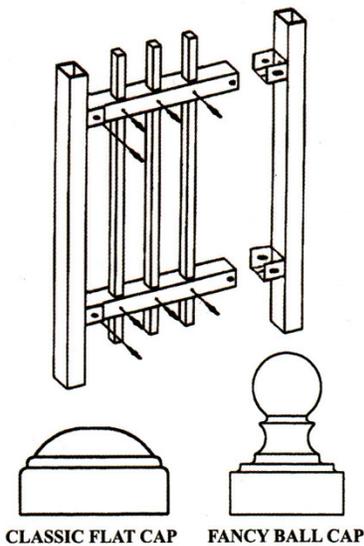


Westmoreland II

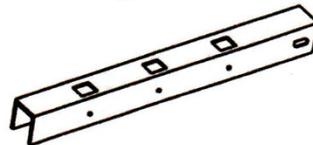
"Superior Ornamental Steel Fencing & Gates"



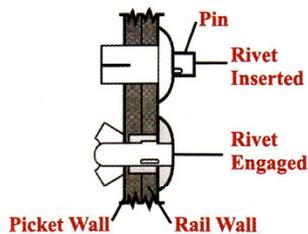
Picket Attachment



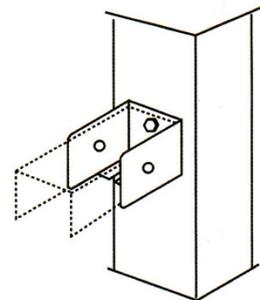
11 Gauge Rails



Drive Rivets



Pressed Steel Rail Bracket

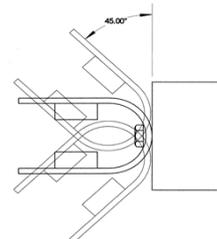


Choose Your Picket Size

1" - 18 GAUGE 3/4" - 18 GAUGE
 1" - 16 GAUGE 3/4" - 16 GAUGE

**DETAILED SPECIFICATIONS
 ARE AVAILABLE FOR EVERY
 STYLE OF FENCE.
 CONTACT US AT
 215-335-1681**

Standard Colors



TOP VIEW OF SWIVEL BRACKET BACK OF BRACKET
 Available Upon Request



Westmoreland II

WESTMORELAND II SPECIFICATIONS

This specification covers materials and construction requirements for Westmoreland II tubular ornamental picket fence and gates per reference standards ASTM F -2408-06.

1. Steel

- 1.1 Steel materials for tubular picket ornamental fence system structural components shall be galvanized by the hot – dip process, either after forming [in accordance with 5.1.1] or prior to forming [in accordance with 5.1.2]
- 1.2 Steel material for fence structural components [that is, tubular pickets, rails, and posts], when galvanized after forming shall conform to the requirements of Specification A 1008/A 1008M, with a minimum yield strength of 45,000 psi [310 MPa]. The exterior shall be hot dipped galvanized with a 0.3 oz/ft² [92 g/m²] minimum zinc weight. The interior surface shall be coated with a thermosetting coating containing zinc or other rust inhibitors and have 0.3 mils [0.0076 mm] minimum thickness.
- 1.3 Steel material for fence structural components [that is, tubular pickets, rails, and posts], when galvanized prior to forming, shall conform to the requirements of Specification A 653/A 653M, with a minimum yield strength of 45,000 psi [310MPa]. For Industrial and Light Industrial applications the steel shall be hot dipped galvanized to meet Specification A653/A653 with a minimum zinc coating weight of 0.9 oz/ft² [276 g/m²], Coating Designation G-90.

2. Coating

- 2.1 The primary components of Westmoreland II (pickets, rails, posts, and gates) shall receive a three-stage pretreatment, to clean and prepare the surface for finish coating.
- 1st Stage: Iron phosphate surface pretreatment to clean and promote adhesion.
- 2nd Stage: Clean water rinse.
- 3rd Stage: Conversion coating to seal the surface and to provide additional corrosion protection.
- 4th Stage: Finished color coating of Polyester Powder applied by the electrostatic spray method to a thickness of 2-4 mils and baked at 450 degrees until fully cured.

3. Fence Sections:

- 3.1 Panels will be pre-fabricated in nominal 6ft and 8ft lengths. Heights of 4', 5' 6", 7' and 8' with 2, 3 or 4 rails as indicated by the customer.
- 3.2 Pickets shall be square tubular steel as indicated on the plans per the following:
- | Picket Size | Gauge | | Picket Size | Gauge |
|-------------|--------|----|-------------|--------|
| 3/4" sq. | 18 ga. | or | 1" | 18 ga. |
| 3/4" sq. | 16 ga. | or | 1" | 16 ga. |
- 3.2 Rails shall be 1 1/2" x 1 3/8" x 1 1/2" 11 gauge U channel steel weighing 2.21 pounds per ft. with square holes punched to allow pickets to pass through. (Picket 3 15/16" apart face to face.)

4. Line, Corner Posts and End Posts:

- 2" x 14 Gauge
- 2-1/2" x 14 Gauge
- 3" x 12 Gauge
- 4" x 11 Gauge
- 6" x 3/16" wall

5. Gate Posts:

- 5.1 For standard swing gates, furnish posts to support single gate leaf, or one leaf of a double date, per the following gate sizes.

Leaf Width	Gate Post Size	Gauge Size	Weight per Ft.
36" to 60"	3" Sq.	12	4.286
60" to 120"	4" Sq.	11	5.77

For other size openings, consult factory.

- 5.2 For Aluminum Cantilever Side Gates, furnish two posts to support each gate leaf for the following gate widths:

Leaf Width	Gate Post Siz	Gauge Size	Weight per Ft.
5' to 30'	4" Sq.	12	5.77

For other size openings, consult factory.

6. Fitting and Accessories:

- 6.1 General: All fittings, accessories and fasteners shall be powder coated to match fence system.
- 6.2 Fasteners: Industrial drive rivets each having a holding power of 1100 ft. and a shear strength of 1500 lbs.
- 6.3 Post Caps: Pressed steel Polyester Coated (Standard).
- 6.4 Finials: Cast aluminum.
- 6.5 Rail Post Brackets: 11 gauge pressed steel and formed brackets with a minimum coating of .90 ounces of zinc (G-90) per sq. ft. Brackets shall be attached to posts with two concealed self-tapping screws. Horizontal channels to be slotted to allow for deviations in post setting. Sections to be attached to the brackets with industrial drive rivets, one side only.

7. Gates:

- 7.1 All gates and gate hardware shall be supplied in accordance with standard procedures. (For detailed gate specifications consult the factory).
- 7.2 Swing Gates: Shall be supplied with the same cross-section as the fence rails. Gate pickets shall match fence section. Gate frames shall be welded with alloy wire.
- 7.3 Aluminum Cantilever Ornamental Sliding Gates: Shall be manufactured in accordance with Westmoreland II shop drawings. One piece enclosed track with unique roller bearing system. Gate pickets and style shall match ornamental fence design as specified in Section 2.
- 7.4 Hinges: Hinges shall be steel. Post (male) and gate frame (female) hinges shall be manufactured to allow a 90 degree opening of gate.
- 7.5 Latch: Fork latch for single swing gates and plunger-bar type for double swing gates, both to permit operations from either side of gate with padlock eye as integral part of latch.

8. Assembly:

- 8.1 All tubular picket sections are to be factory assembled unless otherwise specified.

9. Installation:

- 9.1 Upon receipt at job site, all materials shall be checked to ensure that no damage occurred during handling or shipping. If polyester coating is damaged during installation, contractor shall repair or replace material at their expense.
- 9.2 Dig holes in firm, undisturbed compacted soil. Concrete footing diameter to be 4 times the size of post as per ASTM specifications, and 3'0" deep, posts set 6" above bottom of excavation.
- 9.3 Set fence posts 92-1/2" inside to inside for 8 ft nominal panels and 68" inside to inside for 6 ft nominal panels. Set gate posts for gate opening as specified on the construction plans.
- 9.4 Install all posts and sections plumb and level in accordance to plans in a workman-like manner.

Warranty:

Northeast Fence & Iron Works, Inc. offers a **LIFETIME WARRANTY** when purchased from an authorized dealer. See actual warranty for specific details.

Westmoreland II manufactured by: Northeast Fence & Iron Works, Inc.
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Phone: 215-335-1681 ♦ Fax: 215-743-7112
Email us at: sales@northeastfence.net

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