



Designation: F2957 – 13 (Reapproved 2019)<sup>ε1</sup>

# Standard Specification for Ornamental Aluminum Fence Systems<sup>1</sup>

This standard is issued under the fixed designation F2957; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

<sup>ε1</sup> NOTE—Subsection 6.3.7 was corrected editorially and other editorial changes were made throughout in June 2019.

## 1. Scope

1.1 This specification establishes the minimum requirements for architecturally coated, tubular picket, ornamental aluminum fence systems.

1.2 The values stated in inch-pound units are to be regarded as standard. No other units of measurement are included in this standard.

1.3 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

## 2. Referenced Documents

2.1 *ASTM Standards:*<sup>2</sup>

B117 Practice for Operating Salt Spray (Fog) Apparatus

D1654 Test Method for Evaluation of Painted or Coated Specimens Subjected to Corrosive Environments

D714 Test Method for Evaluating Degree of Blistering of Paints

D2244 Practice for Calculation of Color Tolerances and Color Differences from Instrumentally Measured Color Coordinates

D3359 Test Methods for Rating Adhesion by Tape Test

D523 Test Method for Specular Gloss

D714 Test Method for Evaluating Degree of Blistering of Paints

G154 Practice for Operating Fluorescent Ultraviolet (UV) Lamp Apparatus for Exposure of Nonmetallic Materials

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee F14 on Fences and is the direct responsibility of Subcommittee F14.35 on Architectural Metal Fence Systems.

Current edition approved May 1, 2019. Published June 2019. Originally approved in 2013. Last previous edition approved in 2013 as F2957 – 13. DOI: 10.1520/F2957-13R19E01.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

2.2 *AEC (Aluminum Extruders Council) Standards:*<sup>3</sup>  
Alloys as specified by AEC

2.3 *AAMA (American Architectural Manufacturers Association) Standards:*<sup>4</sup>

AAMA 2603-02 Voluntary Specification, Performance Requirements and Test Procedures for High Performance Organic Coatings on Aluminum Extrusions and Panels

## 3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *adhesion*—the bonding integrity of an organic coating to the aluminum substrate.

3.1.2 *corrosion resistance*—the ability of an organic coating to resist attack from manmade and natural elements while maintaining adhesion and protecting the aluminum substrate from corrosion.

3.1.3 *fence panel*—fabricated unit consisting of rails and pickets. Also referred to as a *fence section*.

3.1.4 *impact resistance*—the measure of an organically coated aluminum product to resist indentation; the ability of a coating to resist cracking or loss of adhesion due to reforming the metal during bending or a shape change from abuse.

3.1.5 *ornamental accessory*—any fitting that adds further decoration to an ornamental aluminum fence system including items like finials, caps, picket collars, rings, scrolls, or other ornamental panel inserts.

3.1.6 *post*—vertical fence structural component that supports the fence panel in the ornamental aluminum fence system.

3.1.7 *rail*—horizontal structural component of a fence panel.

3.1.8 *tubular picket*—hollow vertical component of a fence panel.

3.1.9 *weathering resistance*—the ability of an organically coated aluminum fence panel to resist the effects of natural

<sup>3</sup> Available from Aluminum Extruders Council (AEC), 1000 N. Rand Rd. Suite 214 Wauconda, IL 60084, <http://www.aec.org>

<sup>4</sup> Available from American Architectural Manufacturers Association (AAMA), 1827 Walden Office Square, Suite 550 Schaumburg, IL 60173-4268, <http://www.aamanet.org>

sunlight and humidity measured by loss of gloss and color change (fade) over time.

**4. Materials and Manufacture**

4.1 Ornamental aluminum fence pickets, rails, and posts shall be manufactured from aluminum. The testing criteria, within this document, will determine the alloy, temper, and thickness of the aluminum.

4.2 *Manufacture:*

4.2.1 Uncoated aluminum extrusion to be protected from outdoor elements prior to coating.

4.2.2 Chemicals used in the manufacture process to be removable by the coating pretreatment process and not affect the weathering or corrosion resistance of the organically coated fence panel.

4.3 *Organic Coating Material:*

4.3.1 Organic coating system can be a liquid coat or powder coat process capable of meeting specifications listed in #8 Testing-Surface finish.

4.3.2 Organic coating to be applied and cured to the organic coating manufacturer application and curing specifications.

4.4 Visible fittings, screws/mechanical fasteners, and decorative ornamental accessories shall be manufactured from a substrate that will permit the organic coating to meet the coating specifications listed in #8 Testing-Surface Finish.

4.5 Non-visible screwless fasteners, concealed fasteners, and/or screws to be manufactured from a substrate that will not deteriorate, break down, or corrode over the life of the fence panel.

**5. Testing—Structural**

5.1 *Structural Test Method A—Vertical Load Assembled Panel Testing:*

5.1.1 *Installation of Test Specimen*—One panel and two posts with mounting hardware will be required.

5.1.2 Posts will be mounted to a stationary object at the manufacturer’s on center distance specified for the model to be tested. Allow at least 12 in. of clearance from grade to the bottom of the fence panel to allow for fence panel deformation.

5.1.3 Install the fence panel into or onto the posts using the manufacture specified mounting system for the model being tested.

5.1.4 Distribute weight to the top rail of the panel to be tested at two locations 12 in. on either side of the center point of the panel. Allow fence panel to support the prescribed weight for two minutes.

5.1.5 Remove weight after two minutes and inspect rails for deformation. Panels are to have less than ¼ in. visible deformation after weight is removed.

5.1.6 Weight ratings for various models.

Residential 2 rail	150 pounds
Residential 3-4 rail	225 pounds
Commercial 2 rail	220 pounds
Commercial 3-4 rail	325 pounds
Industrial 2 rail	300 pounds
Industrial 3-4 rail	500 pounds

NOTE 1—Four rail systems are required to meet the same weight specification as a three-rail system.

5.2 *Structural Test Method B Picket Testing:*

5.2.1 Pickets to be inserted in a secured section (in accordance with 6.1.7, 6.2.8, or 6.3.6) with spacing between rails not to exceed 55 inches. Industrial sections over 72 in. and up to 120 in. height to be tested with rail spacing not to exceed 82 inches.

5.2.2 Minimum of three pickets shall be tested using a 12 in. by 12 in. flat surface with testing force pulled horizontally on a vertically installed section.

5.2.3 Apply force centered between posts and rails.

5.2.4 Remove weight after two minutes and inspect rails for deformation. Pickets to have less than ¼ in. visible deformation after weight is removed.

5.2.5 *Weight Ratings for Various Models:*

Residential 55 in. spacing	50 pounds
Commercial 55 in. spacing	80 pounds
Industrial 55 to 82 in. spacing	125 pounds

**6. Physical Dimensions**

6.1 *Residential Fence Systems:*

6.1.1 Typical minimum post dimension is 2 by 2 in. (0.060-in. wall).

6.1.2 Typical minimum picket dimension is 5/8 by 5/8 in. (0.045-in. wall) or similar dimensions and wall thickness in a round, oval, or rectangular shape to meet specifications listed in 5.2.

6.1.3 Typical minimum rail dimension is 1 by 1 inch. Rails shall have sufficient dimension and wall thickness to meet specifications listed in Section 5.

6.1.4 A residential fence panel can be attached to vertical posts by aluminum or stainless steel brackets, welding, or a notched rail/routed post system. The rail to be inserted inside the routed post and secured with stainless steel screws or the rail can be notched or have a protrusion and inserted inside the routed post.

6.1.5 The opening between rails shall not exceed 55 inches.

6.1.6 Residential fence panels where the picket extends above the top rail shall be no less than 48-in. height if the pickets have sharp pointed ornamental spears.

6.1.7 Picket spacing (open area) shall be less than 4 inches.

6.1.8 Clearance from grade to the bottom most location of a fence panel shall be less than 4 inches.

NOTE 2—Fence height is typically the distance from the grade to top of the top rail unless the picket extends through the top rail and the height is the distance from the grade to the top of the picket.

6.2 *Commercial Fence Systems:*

6.2.1 Typical minimum post dimension is 2 by 2 in. (0.060 in. wall) for 72 in. wide panels. 2 ½ by 2 ½ in. (0.065 in. wall) for 96 in. wide panels.

6.2.2 Typical minimum picket dimension is ¾ by ¾ in. (0.050 in. wall) or similar dimensions and wall thickness in a round, oval, or rectangular shape of equal strength to meet specifications listed in 5.2.

6.2.3 Typical minimum rail dimension for a 72 in. wide section is 1 by 1 inch. Minimum rail dimension for a 96 in. wide section 1 by 1 7/16 inches. Rails shall have sufficient dimension and wall thickness to meet specifications listed in Section 5.