



- INFINITY ALUMINUM FENCE PARTS AND MATERIALS SPECIFICATIONS -

PART 1.01: MATERIALS

- **POSTS, PICKETS, FRAMES AND RAILS:** All aluminum material for the fence and gate system shall conform to and meet the requirements of ASTM B-221 for extruded aluminum composition. Components are as follows:
 - Pickets: Aluminum Extrusions of 6063-T52
 - Posts: Aluminum Extrusions of 6005-T5
 - Rails: Aluminum Extrusions of 6005-T5
 - Gate Frames: Aluminum Extrusions of 6005-T5
- **ALUMINUM CASTINGS:** All fence finials, post caps and brackets are sand-cast using aluminum alloy in accordance with ASTM B26 / B26M – 09.

PART 1.02: FENCE PANELS

1.02A – SIGNATURE GRADE PANELS

- **PANEL SIZE** – Aluminum Signature grade panels will be either 8' wide (95" actual) or 6' wide (71" actual) depending on the fence style.
- **HORIZONTAL RAILS** - Rail members will be extruded aluminum in a 1.25" wide x 1.25" tall x .10" beveled profile. Rails will be punched for picket pass-through.
- **PICKETS:** Material for the pickets will be 3/4" x 3/4" x .050" thick extruded aluminum.
- **PICKET SPACING:** Standard pickets will have a 3.875" air gap in-between. Double or puppy pickets will have a 1.56" to 1.63" air gap.
- **FINIALS:** Finial tips will be 6" tall x 2" wide and are sand-cast from solid aluminum with a safety ball top as part of the casting. All aluminum finial tips will be welded to the picket.



1.02B - TRADITIONAL GRADE PANELS

- **PANEL SIZE** – All aluminum Traditional grade panels will be 6' (71" actual) wide
- **HORIZONTAL RAILS** - Rail members will be extruded aluminum in a 1.125" wide x 1" tall x .070" beveled profile. Rails will be punched for picket pass-through.
- **PICKETS**: Material for the pickets will be 5/8" x 5/8" x .050" thick extruded aluminum
- **PICKET SPACING**: Standard pickets will have a 3.875" air gap in-between. Double or puppy pickets will have a 1.56" to 1.63" air gap.
- **FINIALS**: Finial tips will be 4" tall x 1" wide and are sand-cast from solid aluminum with a safety ball top as part of the casting. All aluminum finial tips will be welded to the picket.

PART 1.03: WALK GATES

1.03A – SIGNATURE GRADE WALK GATES

- **FRAME**: All gates will match fence panel styles and be framed with 2" x 2" x .125" square tubing mitered and welded in a u-frame.
- **HORIZONTAL RAILS** - Rail members will be extruded aluminum in a 1.25" wide x 1.25" tall x .10" beveled profile. Rails will be punched for picket pass-through.
- **PICKETS**: Material for the pickets will be 3/4" x 3/4" x .050" thick extruded aluminum.
- **PICKET SPACING**: Standard pickets will have a 3.875" air gap in-between. Double or puppy pickets will have a 1.56" to 1.63" air gap.
- **FINIALS**: Finial tips will be 6" tall x 2" wide and are sand-cast from solid aluminum with a safety ball top as part of the casting. All aluminum finial tips will be welded to the picket.



1.03B – TRADITIONAL GRADE WALK GATES

- **FRAME:** All gates will match fence panel styles and be framed with 2" x 2" x .125" thick square tubing mitered and welded in a u-frame.
- **HORIZONTAL RAILS** - Rail members will be extruded aluminum in a 1.125" wide x 1" tall x .070" beveled profile. Rails will be punched for picket pass-through.
- **PICKETS:** Material for the pickets will be 5/8" x 5/8" x .050" thick extruded aluminum
- **PICKET SPACING:** Standard pickets will have a 3.875" air gap in-between. Double or puppy pickets will have a 1.56" to 1.63" air gap.
- **FINIALS:** Finial tips will be 4" tall x 1" wide and are sand-cast from solid aluminum with a safety ball top as part of the casting. All aluminum finial tips will be welded to the picket.

PART 1.04: ESTATE DRIVEWAY GATES

1.04A – SIGNATURE GRADE ESTATE GATES

- **FRAME:** All gates will match fence panel styles and be framed with 2" x 2" x .125" thick square tubing mitered and welded in a u-frame.
- **HORIZONTAL RAILS** - Rail members will be extruded aluminum in a 1.25" wide x 1.25" tall x .10" beveled profile. Rails will be punched for picket pass-through.
- **PICKETS:** Material for the pickets will be 3/4" x 3/4" .050" thick extruded aluminum.
- **PICKET SPACING:** Standard pickets will have a 3.875" air gap in-between. Double or puppy pickets will have a 1.56" to 1.63" air gap.
- **FINIALS:** Finial tips will be 6" tall x 2" wide and are sand-cast from solid aluminum with a safety ball top as part of the casting. All aluminum finial tips will be welded to the picket.



1.04B – TRADITIONAL GRADE ESTATE GATES

- **FRAME:** All gates will match fence panel styles and be framed with 2" x 2" x .125" thick square tubing mitered and welded in a u-frame.
- **HORIZONTAL RAILS** - Rail members will be extruded aluminum in a 1.125" wide x 1" tall x .070" beveled profile. Rails will be punched for picket pass-through.
- **PICKETS:** Material for the pickets will be 5/8" x 5/8" x .050" thick extruded aluminum
- **PICKET SPACING:** Standard pickets will have a 3.875" air gap in-between. Double or puppy pickets will have a 1.56" to 1.63" air gap.
- **FINIALS:** Finial tips will be 4" tall x 1" wide and are sand-cast from solid aluminum with a safety ball top as part of the casting. All aluminum finial tips will be welded to the picket.

PART 1.05: POSTS AND STANDARD HARDWARE

- **ALUMINUM PANEL POSTS:** All posts used for hanging fence panels will be aluminum and offered in a 2" square size in a 0.060" thickness for Traditional grade and a 2.5" square size in a 0.070" thickness for Signature grade. Lengths offered based on panel height.
- **ALUMINUM WALK GATE AND BLANK POSTS:** All posts used for hanging walk gates or blanks will be aluminum, 0.125" thick and offered in a 2" square size for Traditional grade and a 2.5" square size for Signature grade. Lengths offered based on gate height.
- **POST CAPS:** All post caps are comprised of sand-cast aluminum. Offered in standard and ball style to match all available post sizes.
- **FENCE PANEL BRACKETS:** All panel wall and angle brackets are comprised of sand-cast aluminum. Sizes vary based on wall, flex or angle configuration.
- **SELF-TAPPING SCREWS:** Used to secure panels to the post. Size is 1" x #8. All screws are steel have an anodized black finish for rust inhibition.



INFINITY ALUMINUM FENCE FABRICATION

PART 2.01 – ASSEMBLY

- **RAILS:** All aluminum horizontal rails will be extruded and punched at approximately 4 ½” on center to provide standard picket air-gap spacing of 3.875”. Double or puppy pickets will have a 1.56” to 1.69” air gap.
- **PICKET TO RAIL ASSEMBLY:** All members will be firmly positioned square in a jig fixture and screwed together via a TEK screw at each intersection of picket and rail.
- **PICKET SPACING:** Standard pickets will have a 3.875” air gap in-between. Double or puppy pickets will have a 1.56” to 1.63” air gap.
- **FINIAL TO PICKET WELDING:** Finials will be placed on top of pickets and then TIG welded on all four sides with the use of an inert shielding gas to reduce splatter and insure good penetration. All welds are then cleaned for appearance.
- **WALK AND ESTATE GATES:** All gate frames are miter cut in the corners and TIG welded with the use of an inert shielding gas to reduce splatter and insure good penetration. Using gate jigs, the picket and rail components are then TIG welded to the frame. All welds are then cleaned for appearance.

INFINITY ALUMINUM FENCE FINISHING

PART 3.01 – FINISHING

- **CLEANING:** All finished pieces are inspected for weld spatter and wire brushed accordingly. The inspected pieces then go through a 4-stage pretreatment and wash cycle to remove any impurities from handling and the manufacturing process.
- **POWDER COATING** – A satin black polyester-based TGIC powder coating is electrostatically applied to a minimum 2.5 mils to all finished pieces. The powder contains a UV fade inhibitor to resist fading of the finish.