



Designation: F2408 – 16 (Reapproved 2023)

Standard Specification for Ornamental Fences Employing Galvanized Steel Tubular Pickets¹

This standard is issued under the fixed designation F2408; 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 (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification establishes the minimum requirements for coated tubular picket ornamental fence systems fabricated from galvanized steel components.

1.2 The requirements of this specification do not apply to vertical bar fence systems utilizing solid bar or wrought iron materials.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 *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:*²

[A239 Practice for Locating the Thinnest Spot in a Zinc \(Galvanized\) Coating on Iron or Steel Articles](#)

[A653/A653M Specification for Steel Sheet, Zinc-Coated \(Galvanized\) or Zinc-Iron Alloy-Coated \(Galvannealed\) by the Hot-Dip Process](#)

[A1008/A1008M Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, Required Hardness, Solution Hardened, and Bake Hardenable](#)

[A1011/A1011M Specification for Steel, Sheet and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low-](#)

[Alloy, High-Strength Low-Alloy with Improved Formability, and Ultra-High Strength](#)

[B117 Practice for Operating Salt Spray \(Fog\) Apparatus](#)

[D523 Test Method for Specular Gloss](#)

[D714 Test Method for Evaluating Degree of Blistering of Paints](#)

[D822 Practice for Filtered Open-Flame Carbon-Arc Exposures of Paint and Related Coatings](#)

[D1654 Test Method for Evaluation of Painted or Coated Specimens Subjected to Corrosive Environments](#)

[D2244 Practice for Calculation of Color Tolerances and Color Differences from Instrumentally Measured Color Coordinates](#)

[D2794 Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation \(Impact\)](#)

[D3359 Test Methods for Rating Adhesion by Tape Test](#)

[E4 Practices for Force Calibration and Verification of Testing Machines](#)

[F2814 Guide for Design and Construction of Ornamental Steel Picket Fence Systems for Security Purposes](#)

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *adhesion, n*—the bonding integrity of an organic coating to the base metal substrate.

3.1.2 *corrosion resistance, n*—the ability of an organically coated metal product to resist attack due to the base metal attempting to return to a more passive oxidized state.

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

3.1.4 *impact resistance, n*—the measure of an organically coated metal 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, n*—any fitting that adds further decoration to an ornamental metal fence system including items such as finials, caps, picket collars, rings, scrolls, or other ornamental panel inserts.

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

¹ 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.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

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

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

3.1.9 *tubular picket ornamental metal fence system, n*—an architectural metal fence system that combines ornamental fence structural components (that is, tubular pickets, rails, and posts) with ornamental accessories and fasteners, assembled and evaluated as a complete installed structure.

3.1.10 *weathering resistance, n*—the ability of an organically coated metal product to resist loss of coating gloss or color change due to excessive humidity or ultra-violet (UV) sunlight exposure.

4. Significance and Use

4.1 The purpose of this specification is to define minimum selection criteria and test procedures to ensure product users that a tubular picket ornamental metal fence system has the strength necessary to withstand reasonable loads and penetration forces, and has the appropriate combination of material and surface protection to withstand the harmful effects of corrosion and weathering for an extended period of time.

4.2 For security applications, more definitive requirements are listed in Guide [F2814](#).

5. Materials and Manufacture

5.1 Steel material 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](#)).

5.1.1 Steel material for fence structural components (that is, tubular pickets, rails, and posts), when galvanized after forming, shall conform to the requirements of Specification [A1008/A1008M](#) or Specification [A1011/A1011M](#), with a minimum yield strength of 45 000 psi (310 MPa). The exterior shall be hot-dip galvanized with a 0.3 oz/ft² (92 g/m²) minimum zinc weight. The exterior galvanized surface shall be chemical treated or conversion coated to adhere a polymeric coating. A polymeric coating shall be applied and provide a minimum of 95 % surface coverage as disclosed by Practice [A239](#), Procedure 7.1. 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.

5.1.2 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 [A653/A653M](#), with a minimum yield strength of 45 000 psi (310 MPa). For Industrial applications (see [Table 1](#)), the steel shall be hot-dip galvanized to meet Specification [A653/A653M](#) with a minimum zinc coating weight of 0.9 oz/ft² (276 g/m²), Coating Designation G-90. For Commercial and Residential applications (see [Table 1](#)), the steel shall be hot-dip galvanized to meet Specification [A653/A653M](#) with a minimum zinc coating weight of 0.6 oz/ft² (184 g/m²), Coating Designation G-60.

5.2 Organic Coating Materials:

5.2.1 Powder coatings applied to the exterior surface of fence components shall be polymer material: polyester or epoxy and polyester combinations having a minimum thickness of 3 mils; polyolefin elastomer having a minimum thickness of 7 mils; or PVC having a minimum thickness of 10 mils.

5.2.2 Wet coating applied to the exterior surface of fence components shall be a two-coat paint application system (one coat of epoxy, polyester or polyurethane primer; one coat of polyester, polyurethane, or acrylic liquid) with the total combined coating having a minimum thickness of 2 mils.

5.3 Fittings, fasteners, and decorative accessories for ornamental steel fence systems shall be manufactured with a material and finish coating that meets the same protective coating performance requirements as required for panels and posts.

6. Physical Dimensions

6.1 Cross-section and thickness dimensional requirements for ornamental metal fence structural components shall be as specified by the manufacturer, provided that the performance criteria of Section 8 are met. [Table 1](#) is provided as a guideline to show nominal values typically used for residential, commercial, and industrial applications.

6.2 Fence height and space between rails may vary in accordance with manufacturer's standards, provided local ordinances and building codes do not limit these dimensions for a specific application, such as might be the case for pool safety, gate safety, or structural wind load bearing capacity. No sharply pointed picket tops shall be used on fences less than four ft (1.22 m) in height.

TABLE 1 Nominal Sizes for Ornamental Fence Structural Components

Application	Component	Typical Cross-Section	Wall Thickness
Residential	Picket	5/8 in. by 5/8 in. (15.9 mm by 15.9 mm)	18 Ga.
	Rail	1 in. by 1 in. (25.4 mm by 25.4 mm)	18 Ga.
	Post	2 in. by 2 in. (50.8 mm by 50.8 mm)	16 Ga.
Commercial	Picket	3/4 in. by 3/4 in. (19.0 mm by 19.0 mm)	16 Ga.
	Rail	1-3/8 in. by 1-1/2 in. (34.9 mm by 38.1 mm) or 1-1/2 in. by 1-1/2 in. (38.1 mm by 38.1 mm)	14 Ga.
	Post	2-1/2 in. by 2-1/2 in. (63.5 mm by 63.5 mm)	14 Ga.
Industrial	Picket	1 in. by 1 in. (25.4 mm by 25.4 mm)	16 Ga.
	Rail	1-3/8 in. by 1-1/2 in. (34.9 mm by 38.1 mm) or 1-1/2 in. by 1-1/2 in. (38.1 mm by 38.1 mm)	14 Ga.
	Post	3 in. by 3 in. (76.2 mm by 76.2 mm)	12 Ga.

NOTE 1—Fence height is a nominal value and is typically the distance from grade to the top of the fence.

6.3 The spacing between pickets shall be four in. (101.6 mm) or less; however, if applicable local regulations (such as may be applied to pool fencing, child care facility fencing, public railing systems, or fencing adjacent to automated gates, and so forth) have more restrictive spacing requirements, then those local regulations shall govern.

7. Workmanship

7.1 All ornamental metal fence system components shall be produced using materials and finishes specified in Section 5, and shall be free from defects in workmanship.

8. Testing—Structural

8.1 *Structural Test Method A—Application of Horizontal Concentrated Load:*

8.1.1 *Installation of Test Specimen*—One line of fence with a minimum of three panels of the fence system to be tested shall be installed in accordance with the manufacturer’s specifications and drawings. Selection of the test specimen should consider the maximum range of styles and sizes to be certified (see Section 10).

8.1.2 *Apparatus:*

8.1.2.1 *Testing Machine*—Any testing machine or loading device, capable of imposing forces accurate to within 1 % (plus or minus), when calibrated in accordance with Practices E4, is suitable and may be used, provided the requirements of specified rate of loading and unloading are met. The testing device shall be of sufficient capacity to prevent yielding of its various components and shall ensure that the applied load remains essentially parallel to the relevant axis of the assembly during testing.

8.1.2.2 *Test System*—A diagrammatic test set-up for applying horizontal tension forces to the assembly is shown in Fig. 1. The bearing plate, normally 6 in. (150 mm) long, shall be of sufficient size to prevent local failure of the surrounding structural members or components. The loading device shall be attached to the assembly by means of pins or a swivel connector to prevent the direct transfer of any flexural forces through the connection.

8.1.2.3 *Deflection Measurements*—Dial gauges, having a smallest division of not more than 0.01 in. (0.25 mm), or any suitable measurement devices or calibrated sensors of at least comparable accuracy and sensitivity shall be used to measure the horizontal displacements of the top rail relative to its original location at each loading point prior to load application. These devices shall have sufficient measurement capability to indicate the displacement throughout the test range.

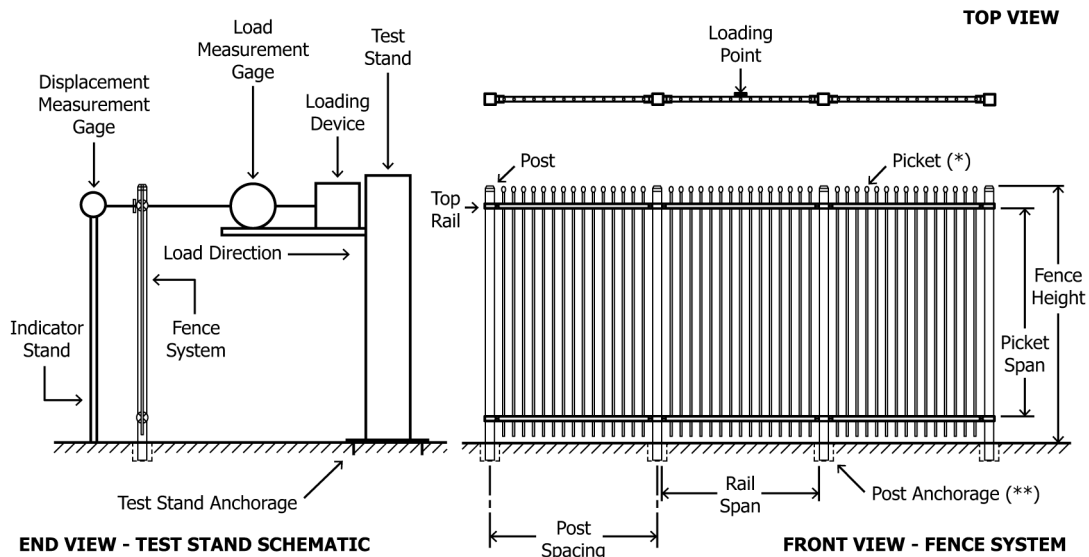
8.1.3 *Procedure:*

8.1.3.1 *Positioning*—Position the test stand in such a way that the load is applied, as shown in Fig. 1, to the structural member perpendicular to the plane of the fence system without causing any local failure at the point of load application.

8.1.3.2 *Mounting of Instruments*—Mount the dial gauge, measurement device, or sensor at the loading point as is shown in Fig. 1. Place the sensing element of the instrument in contact with and normal to the surface or an extension of the surface of the top rail of the fence system being tested in such a way as to measure displacement in the direction of the applied load.

8.1.4 *Load Application:*

8.1.4.1 *Initial Load Application*—Apply an initial load corresponding to 50 % of the required test load (see Table 2) for a minimum of two minutes in order to bring all members into full bearing. Reduce load to 25 % of the required test load (50 % of the preload), and observe the initial deflection. The



* Note 1 - Any picket point style is acceptable on tested system; pickets may extend through the rails (as shown) or may terminate at the rails. Range of qualification is based on maximum picket span.
 **Note 2 - Anchorage should be to concrete surface using core-drilled holes filled with grout or welded base plates and anchor bolts. Anchorage is not intended to be part of the structural test; failure of the anchorage system will void the test.

FIG. 1 Test Set-Up for Application of Horizontal Concentrated Load