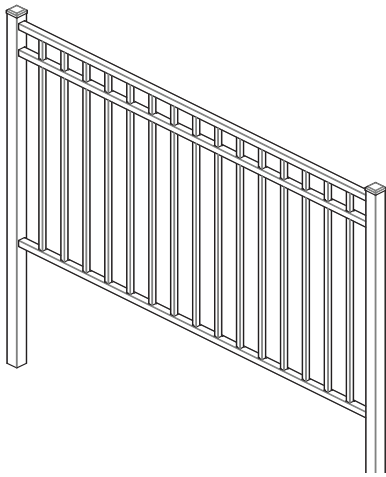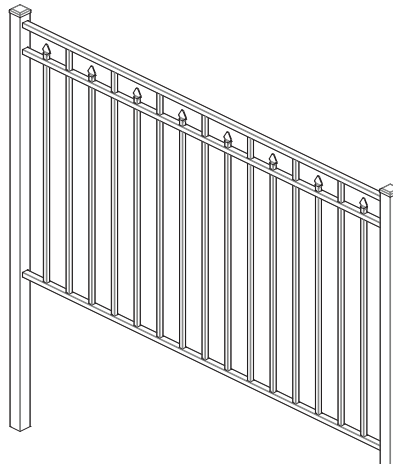# ALUMAX
Aluminum Fencing with Maximum Durability

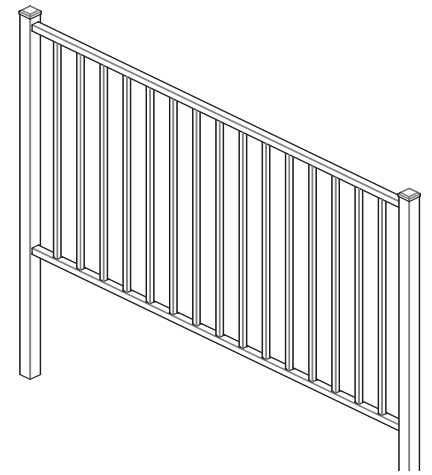# ALUMAX Premium Ready to Install Fence Panel Installation Instructions

ALUMAX Fence Styles

**ALC-4 ALIGNED PICKETS
WITH FLUSH BOTTOM RAIL
(48", 54", 60", 72" TALL) X (72", 96")**

**ALC-5 STAGGERED PICKETS
WITH FLUSH BOTTOM RAIL
(48", 54", 60", 72" TALL) X (72", 96")**

**ALC-6 TWO RAIL DESIGNS
(48", 60", 72" TALL) X (72", 96")**

**Please read instructions carefully before installing Your ALUMAX Premium Aluminum Fence.
If you have questions or issues, please call customer service at 1-800-483-4674.**

Before You Get Started:

• It is the law to notify all local Utility Company for locates of all buried services.

• Check local zoning laws, Homeowner Associations for any height, styles, or fence location that may have to be approved before construction begins.

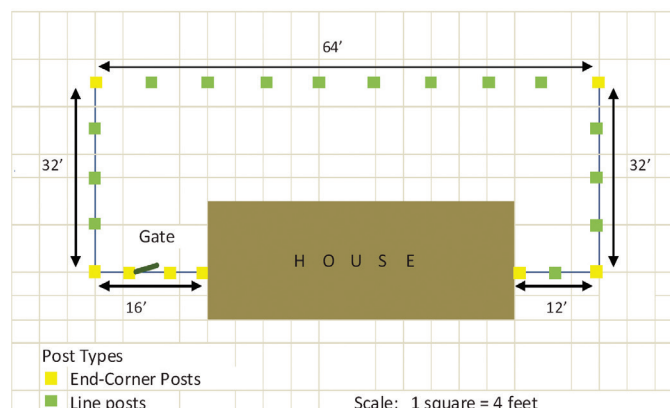• Make sure where all property lines are located.

Take a few minutes to inventory all required items needed are accounted for. If any items are missing or damaged, please call customer service 1-800-483-4674.

Tool Check List:

Post hole digger	Safety Goggles
Gloves	Tape measure
String lines X's 2	Rubber mallet
Shovel	Concrete
Wheelbarrow	Wooden Stakes
Level	Cordless or Electric Drill
Framing Square	Hacksaw
1/8" - 3/16" Drill bits	Associated Drive Bits
Pen Marker	¼ x 1" Stainless Screws

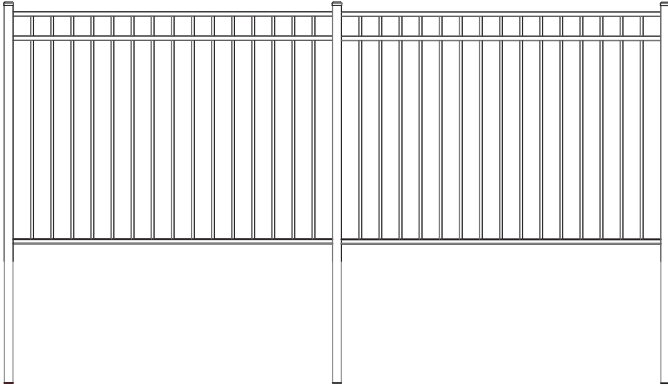**Note:** Fasteners / screws required for fence installation need to be purchased separately.
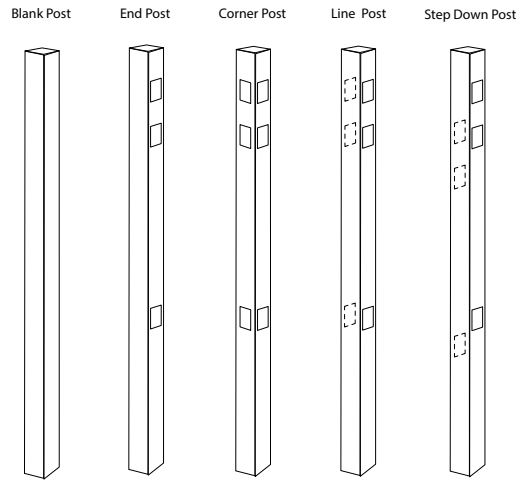
1. Review your fence layout design.

64'

32'   32'

Gate

HOUSE

16'   12'

Post Types
■ End-Corner Posts
■ Line posts

Scale: 1 square = 4 feet

2. Product Overview (Fence Section)

iLLUSTRATION 2

3. Product Overview (Post)

Illustration 3

Blank Post   End Post   Corner Post   Line Post   Step Down Post

3a. Post Centers Spacing/Post Hole Depth Chart

Illustration 3a

Note: Refer to the Post Depth Table

Leave 2″ from bottom post hole to ground

Concrete

4 to 5" Pea Gravel

6″ diameter

3b. Gate Post Spacing Ledger

Gate Post Spacing:
Pre-assembled gate spacing for all styles of fences 48″ 54″ 60″ 72″ tall is 45 ½″ between posts.
All pre-assemble gates are 44″ wide.

ILLUSTRATION 3b
Gate Post

1 ½" wider than finished gate dimension

2″ from ground to top of concrete

Allow concrete to set for 24 hrs before installing gate

Fence Style	Fence Heights				Post Centers
ALC-4 72	48″	54″	60″	72″	72 ½″
ALC-4 96	48″	54″	60″	72″	96 ½″
ALC-5 72	48″	54″	60″	72″	72 ½″
ALC-5 96	48″	54″	60″	72″	96 ½″
ALC-6 72	48″	n/a	60″	72″	72 ½″
ALC-6 96	48″	n/a	60″	72″	96 ½″
Post Hole Depth	26″	32″	26″	30″	
Dig all post holes 6″ in diameter					
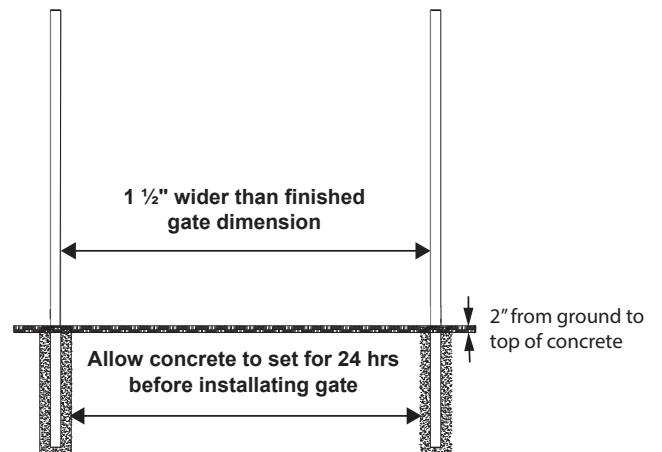
4. Starting Fence Layout

BEFORE YOU START, CHECK THE FOLLOWING:

A. That you meet local codes for frontage locations, property lines, fence heights and any permit requirements.
B. Check with your local utility companies to locate underground pipelines, power lines or cables.
C. Locate property lines.
D. Drive stakes into the ground along property line. Then stretch a string between each stake and extend the string 2' beyond property line as shown below.
E. Mark End-Corner post locations with a stake. For gate posts, refer to gate section for gate opening size.
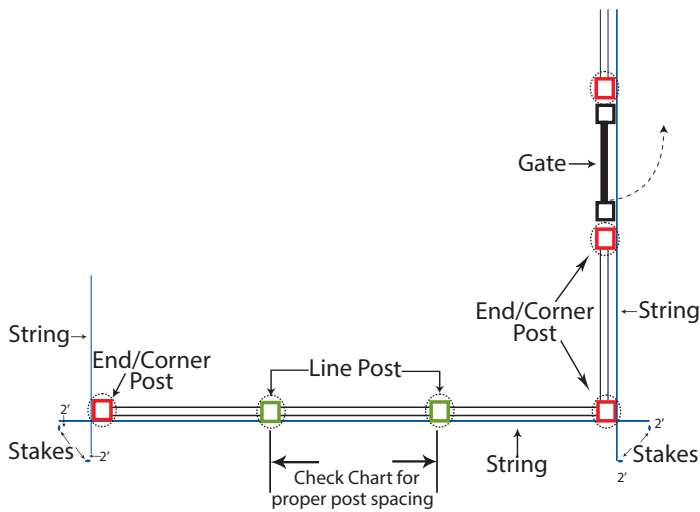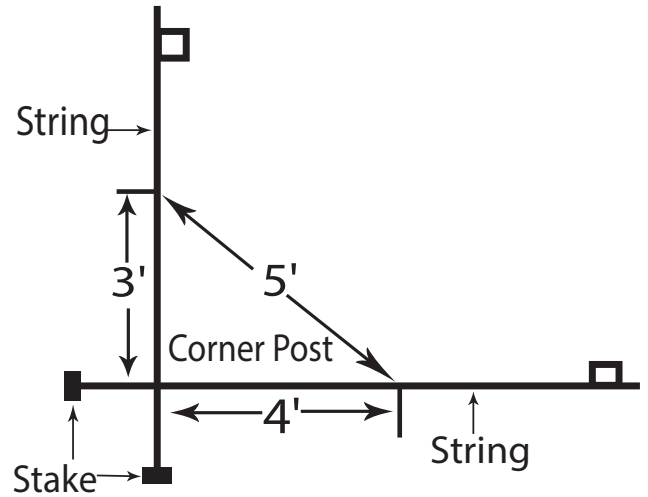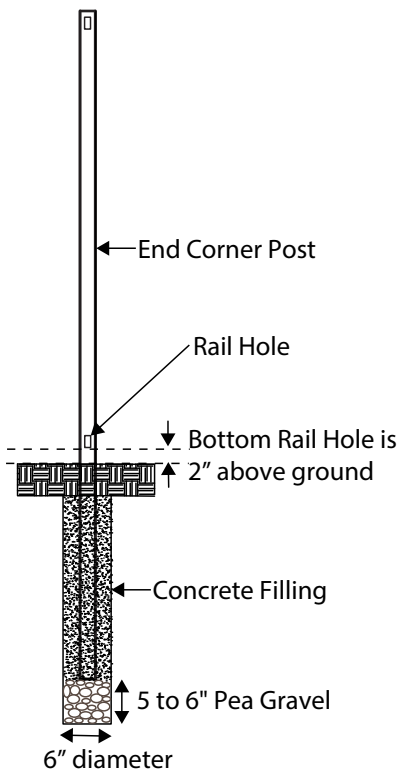
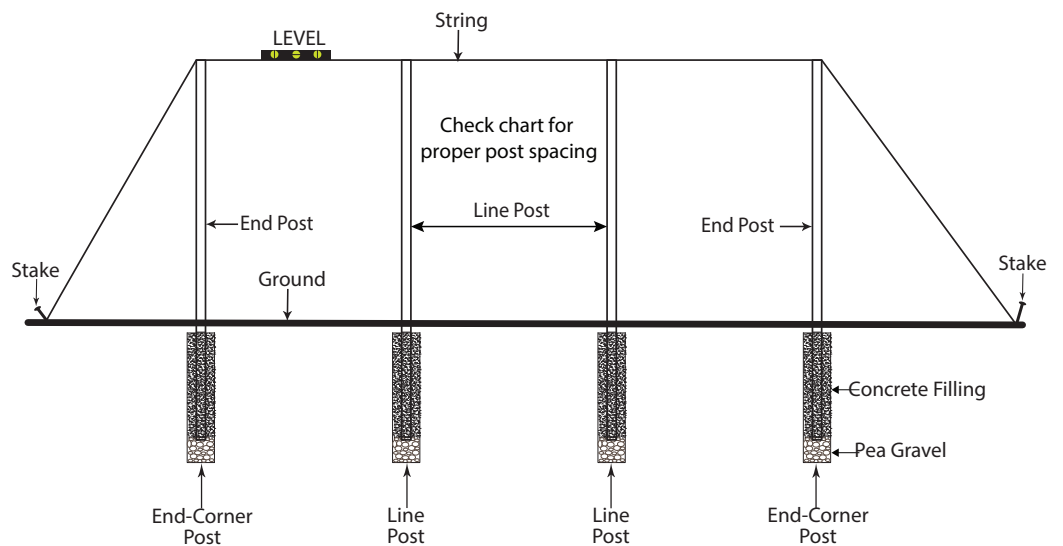Illustration 4a

Illustration 4b
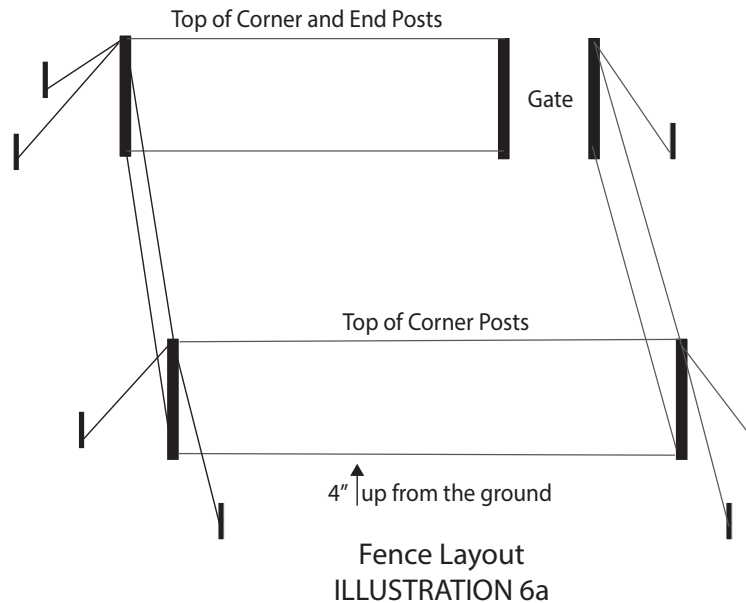
Illustration 4c

Illustration 4d

5. Begin Post Installation

IMPORTANT: ONLY WORK ON ONE POST AND PANEL AT A TIME. DO NOT INSTALL ALL LINE POSTS FIRST AND THEN TRY AND FOLLOW UP WITH INSTALLING PANEL AS IT WON'T WORK!

Using your fence layout #1 design in determine where each Corner, End posts need to be installed. Following the depth chart: in # 3a/b.

- Dig hole to proper depth.
- Pour approx. 4" to 5" of pea gravel into hole.
- Insert post into hole and tap down with rubber mallet until the space from the ground to the bottom of the bottom hole is 2".
- Mix enough concrete to fill all around the outside of the post to within approximate 2" of ground level.
- Mix concrete to have it a stiff consistency to increase set-up time.
- With a level check to make sure post is plumb
- Note: we suggest that after approximately 20/30 minutes that you double check posts to make sure they have not sunk or become out of plum.
- Install remaining posts following steps above.
- Allow Corner, end and gate posts to set for a minimum of 24 hrs.

6. Installing Line Posts and Panels Starting at a Corner Post

- With two (2) string lines fasten one approximately 4" above the ground around a corner or end post and attach it to the last post in the fence run.
- Attach other string line to top of the two posts.
- Refer to drawing below.

Top of Corner and End Posts

Gate

Top of Corner Posts

4" up from the ground

Fence Layout
ILLUSTRATION 6a

- Starting at a corner, special care needs to be taken. Each corner posts top routed hole is marked with a ("C") sticker.
- Corner panels are labeled and must be installed with notched ends inserted into the routed holes marked ("C").
- All panels must be inserted into each post a Maximum of 1".
- Before installing each panel make a mark on the top of each rail 1" from end of rail using a pen.
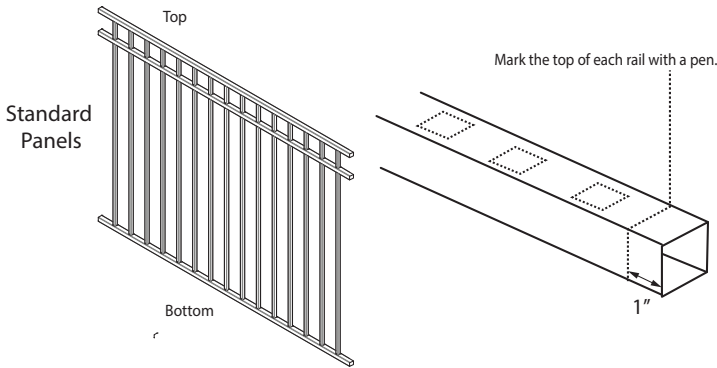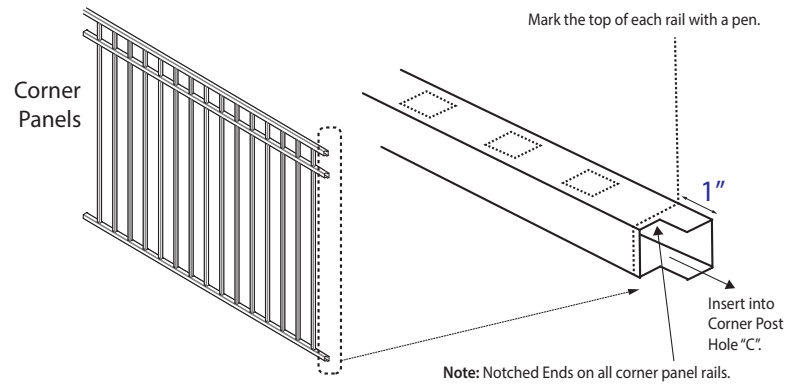
ILLUSTRATION 6b
Standard Panel Rail

Top

Standard
Panels

Mark the top of each rail with a pen.

Bottom

1"

ILLUSTRATION 6c
Corner Panel Rail

Corner
Panels

Mark the top of each rail with a pen.

1"

Insert into
Corner Post
Hole "C".

Note: Notched Ends on all corner panel rails.

- Mark where the first line post is to be installed.
- All posts are installed with the proper spacing between each post allowing pre-assemble panels to be installed correctly.
- If your layout has corner posts, **always install your line posts and panels starting at corner post.**
- When installing corner panels ALWAYS start with CORNER PANEL FIRST INSTALLING it into corner post routed hole marked ("C") All corner panels are marked as CORNER PANELS. Secure each corner panel into posts by installing # ¼ x 1 Black stainless-steel screws into the top of each corner post and into the outside of each rail location.

ILLUSTRATION 6d
Top of Corner Post

2" x 2" Corner Post

1"

1"

1"	Measurement is from end of rail to outside of post
⊕	Screws going into the rail at an angle
··········	Mark with a pen

Corner Panel
insert into Corner
Post Hole "C"

Standard Panel
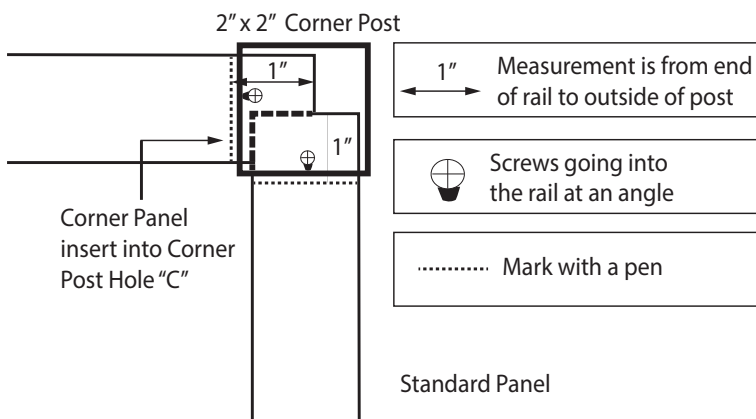
ILLUSTRATION 6e
Mid Rail or Bottom of Corner Post

use ¼ x 1 Fastener through
bottom Post and
into Rail

2" x 2" Corner Post

1"

1"

use ¼ x 1 Fastener through
bottom Post and
into Rail

Corner Panel
insert into Corner
Post Hole "C"

1"	Measurement is from end of rail to outside of post
··········	Mark with a pen

Standard Panel
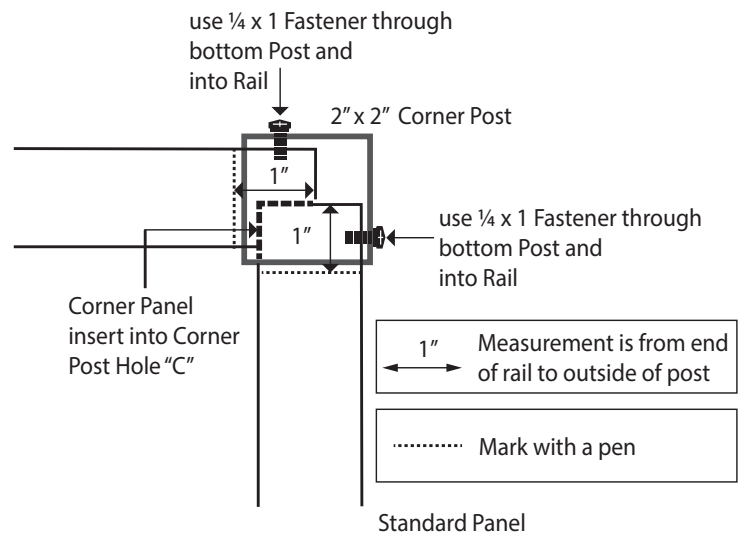
7. Installing Line Posts and Panels Starting at End Post

▪ Fence runs with only end posts line posts and panels can be installed beginning with a post closest to any end post.
▪ The line post and panel is now ready to install. Follow the same installation procedure as outlined in STEP 5.
▪ The line post top should be at the same height as top string line and outside of post should be against the bottom string line.
▪ Every 30/40 minutes to go back on the posts that are concreted in place to make sure they have not sunk or become out of plumb.
▪ Repeat this procedure until all line posts and panels are installed.

Secure each panel into each post by installing stainless steel screws # ¼ x 1 into the top of each post. It is not necessary to install screws into the bottom rails. This is an option for each installation.
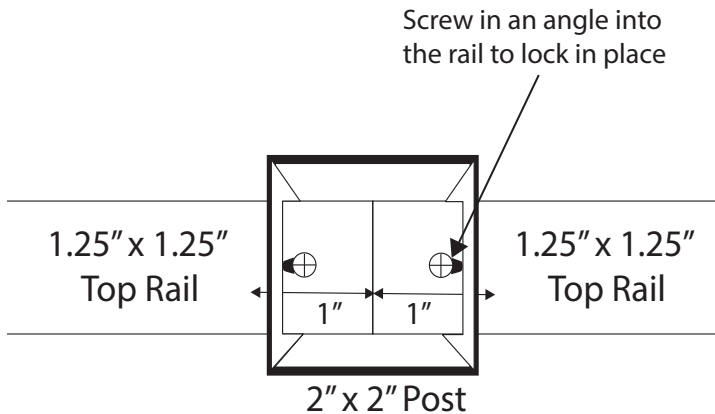
ILLUSTRATION 7a
Alumax Line Post Installation

Screw in an angle into
the rail to lock in place

1.25″ x 1.25″
Top Rail

1.25″ x 1.25″
Top Rail

1″   1″

2″ x 2″ Post

ILLUSTRATION 7b
Alumax End Post Installation

Screw in at an angle into
the rail to lock in place.

2″ x 2″ Post

1.25″ x 1.25″
Top Rail

1″
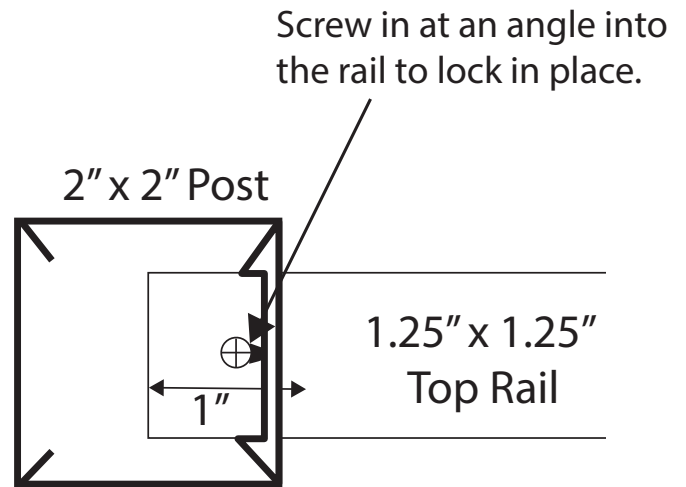
8. Installing Post Caps

With a rubber mallet lightly tap post caps onto each post.

ILLUSTRATION 8
Alumax Post Cap Installation

Rubber Mallet

Tap gently the post
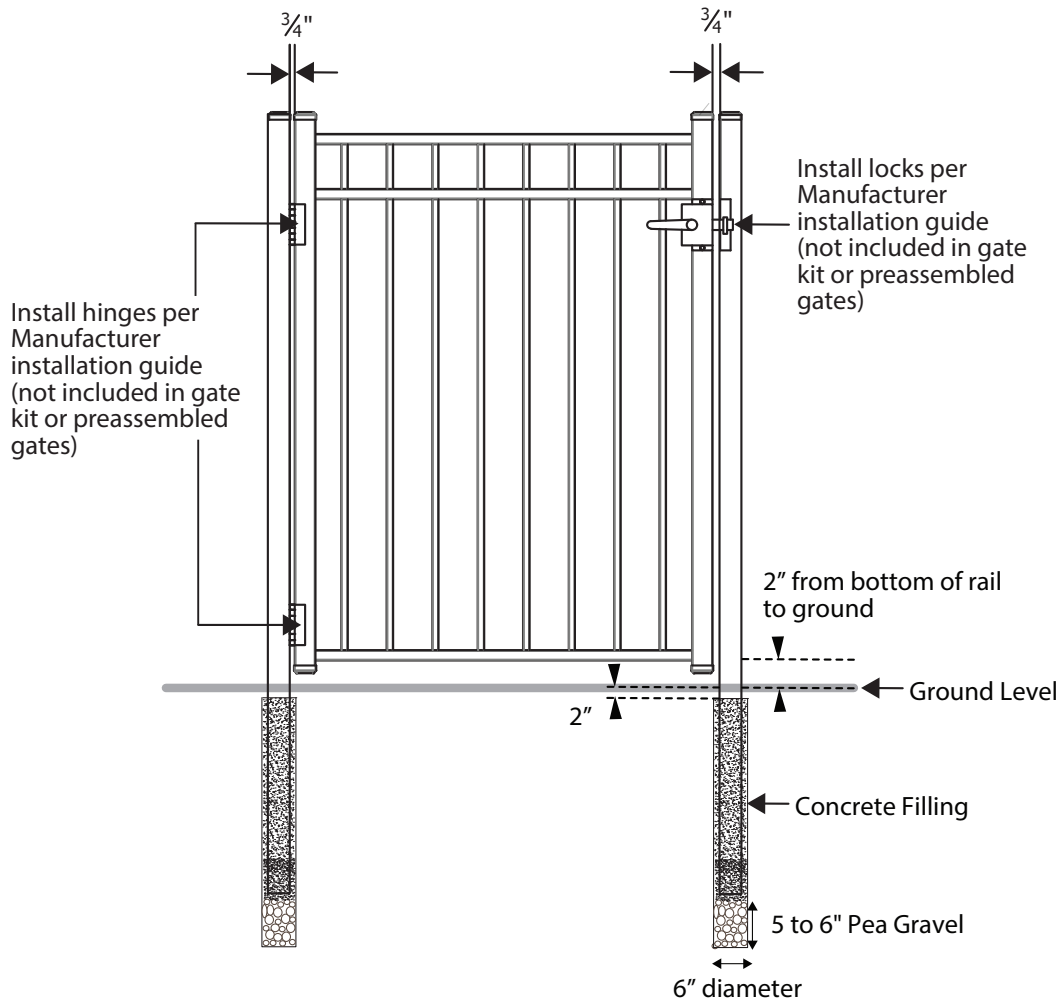cap onto the post

Post Cap

Post
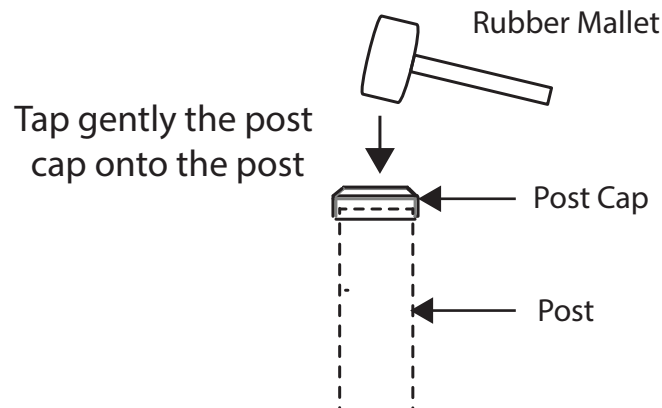
9. Installation of Alumax Gates:

Note: All fasteners required to build gates are provided in Alumax Gate Kits

- All pre-assembled gates have a finished width of 44".
- Determine which way gate is to swing.
- Lay the gate down on a flat and level surface.
- Protect the finish of the gate with cardboard or tarp.
- Install hinges to the gate at height that is not in line with any of the horizontal rails.
- Pre-drill all hinge holes in gate upright where they will be attached.
- Using screws (fasteners) provided, use a drill or screwdriver to tighten all fasteners.
- With two wooden blocks to rest the bottom of the gate on, place the gate into the entrance opening making sure that the gate top rail is even with panel top rails.
- Securely fasten gate to gate post.
- Remove wooden support blocks.
- Determine where latch is to be positioned and secure latch to gate.
- Install latch striker onto gate post.
- Install post caps.

ILLUSTRATION 9a
Alumax Gate Hardware

Gate Hardware needs to be ordered separately

¾"   ¾"

Install locks per Manufacturer installation guide (not included in gate kit or preassembled gates)

Install hinges per Manufacturer installation guide (not included in gate kit or preassembled gates)

2" from bottom of rail to ground

Ground Level

2"

Concrete Filling
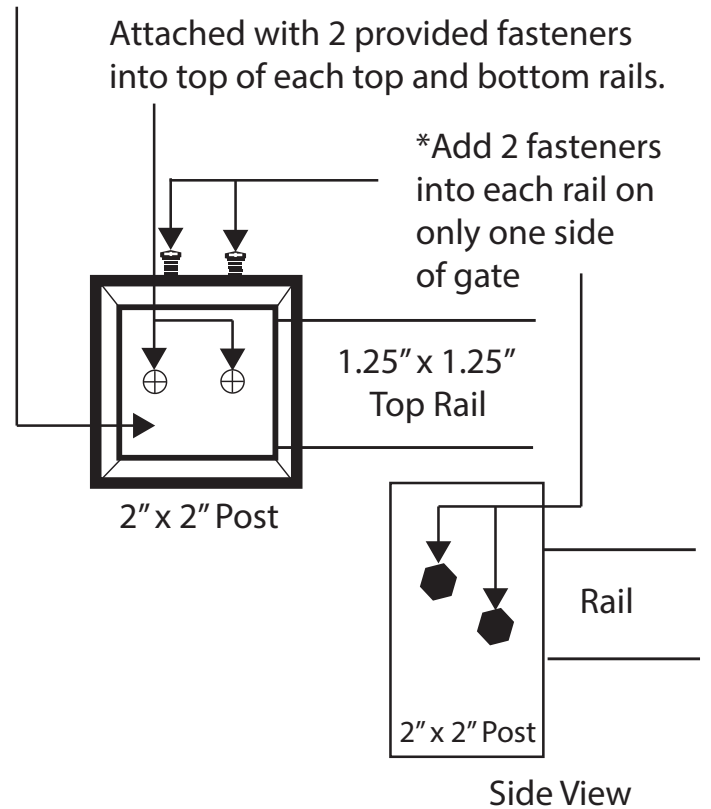
5 to 6" Pea Gravel

6" diameter

For installing gates using Alumax Gate Kits, follow the how to build instructions in pre-packaged gate kits.
Completed gates built with DuraMax Gate Kits install the same as preassembled gates above (Step 8)

ILLUSTRATION 9b
Alumax Custom Gate Width

Standard Fence Panel

Carpenter Square Tool

Figure No. 1
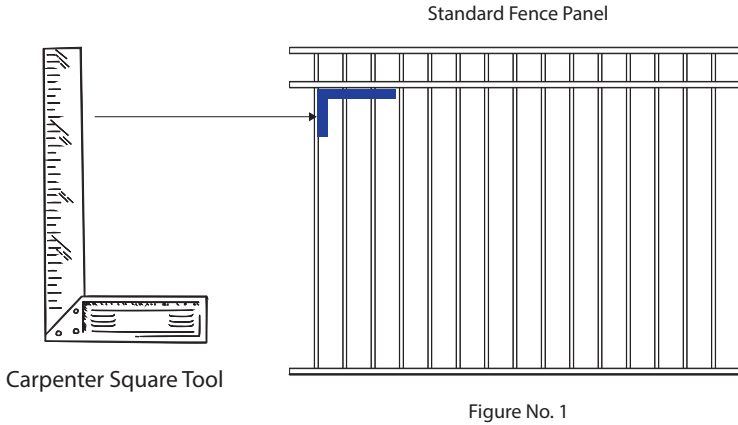
ILLUSTRATION 9d
Alumax Gate Post Installation

Internal post corner support

Attached with 2 provided fasteners
into top of each top and bottom rails.

*Add 2 fasteners
into each rail on
only one side
of gate

ILLUSTRATION 9c
Alumax Custom Gate Width

1.25" x 1.25"
Top Rail

Figure No. 2
Custom Gate Width

Figure No. 3
Distance between post and
picket is the same on each side

Figure No. 4
Sqaure Tool

Figure No. 5
Marked Rails to be cut

2" x 2" Post

Rail

DISCARD

2" x 2" Post

Side View

DURAMAX
Building Products
Engineered For The Southwest Sun™