

1. **Processing Procedures** – The rotomolding cycle that has been established (Proprietary) will not be altered in time, temperature or rotation.
 - A. Aluminum mold will be prepared with mold release on a regular basis to prevent dimensional changes in the Sand Barrels.
 - B. Top rim circumference will measure $2.95\text{m} \pm .01\text{m}$ such that all lids will fit on all barrels.
 - C. Uniform wall thickness will be maintained with an average thickness of 7mm. Wall section will consists of three layers. Unfoamed inner and outer layer will be 1.5mm, foamed core will be 4mm.
 - D. All barrels will be drilled with 6mm Drainage holes and contains six strips of butyl caulk for adhering the two half barrels together.

2. **Materials** – All sand barrels will be manufactured from High Density Polyethylene plastic with the following specifications:

A. Density	0.948 g/cm ³
B. Melt Index	80 g/min.
C. Flex Modules	1,102 M.Pa
D. Tensile Strength	22.4 M.Pa
E. Heat Distortion Temp.	72° c
F. Low Temp Imp - 40° c	135.58 joules
G. UV Stabilized (Compounded)	1.7g/Kg
H. Yellow Color (dry blend)	19.8g/Kg

3. **Weights** – All sand barrels will be manufactured with the following part weights:

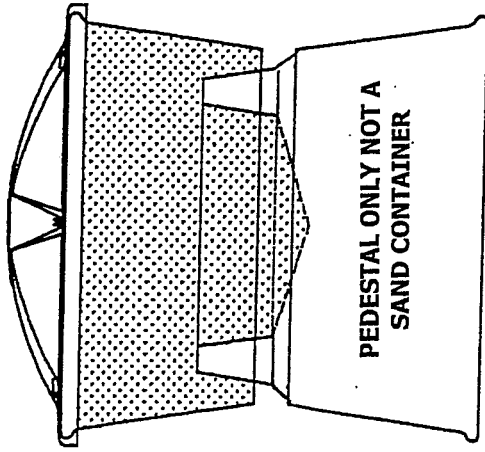
A. Part # 48247-S*	90-320 Capacity	wt = 7.3 Kg \pm .5 Kg
* was 48400		
B. Part # 48247-P**	Base Support	wt = 7.7 Kg \pm .5 Kg
* was 48700		
C. Part # 48140	640 Capacity	wt = 10.4 Kg \pm .5 Kg
D. Part # 48210	960 Capacity	wt = 13.2 Kg \pm .5 Kg

4. **Tests** – The following test will be performed yearly for Q.A. verification:

- A. Thermal stress cycle (Hotbox test).
- B. U.V. Weathering (ASTM D 4329)

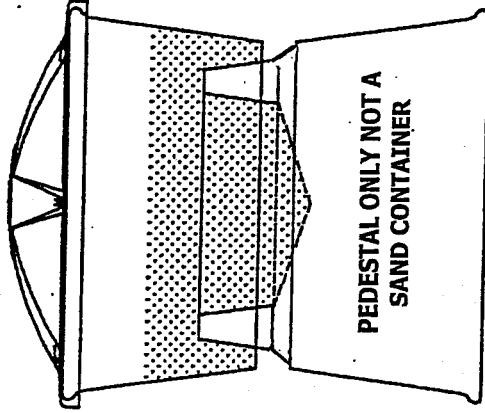
NOTE THAT THERE IS NOW ONLY ONE SAND CONTAINER FOR 200LB, 400LB & 700LB

FILL TO TOP



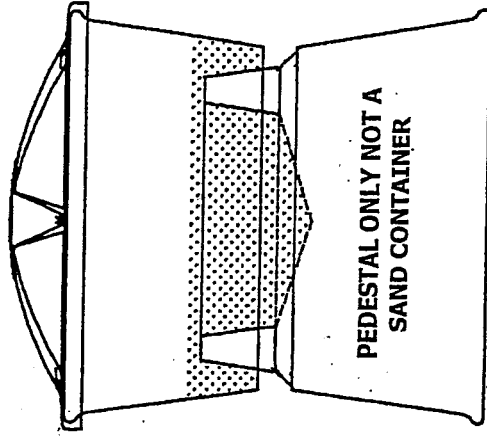
700 LBS
(320 kg)

FILL TO 6 IN. (150 mm)
FROM TOP

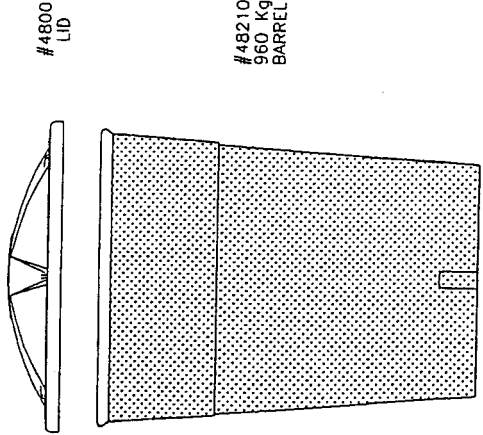


400 LBS
(180 kg)

FILL TO 11 IN. (280 mm)
FROM TOP



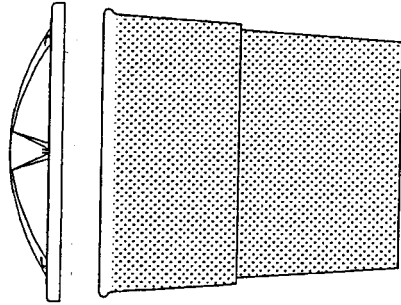
200 LBS
(90 kg)



#4800
LID

#48210
960 Kg
BARREL

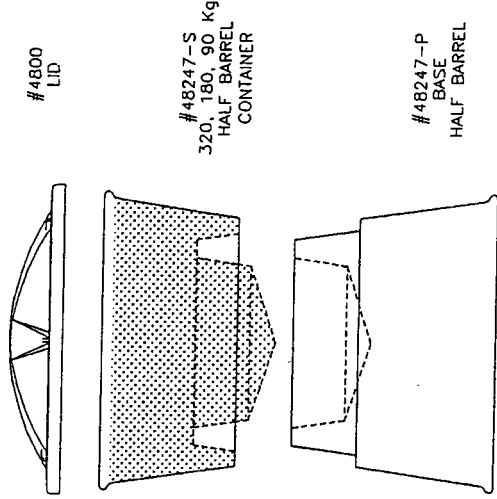
PART #48210-0
ASSEMBLY FOR
960 Kg MODULE



#4800
LID

#48140
640 Kg
BARREL

PART #48140-0
ASSEMBLY FOR
640 Kg MODULE



#4800
LID

#48247-S
320, 180, 90 Kg
HALF BARREL
CONTAINER

#48247-P
BASE
HALF BARREL

PART #48247-AB
ASSEMBLY FOR
320, 180, 90 Kg MODULE

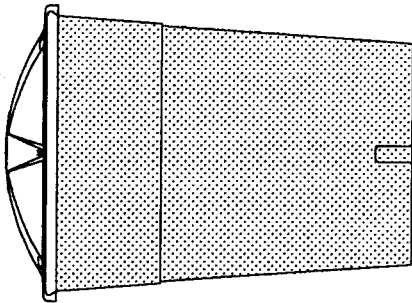
Traffic Devices, Inc.	
TRAFFIC DEVICE	BARREL ASSEMBLIES, 320, 180, 90 Kg MODULE
Drawing No.	
Scale	1" = 1'
Sheet	1 of 1

Rev	By	Date	Description	Approved	Date

Item	Quantity	Unit	Notes

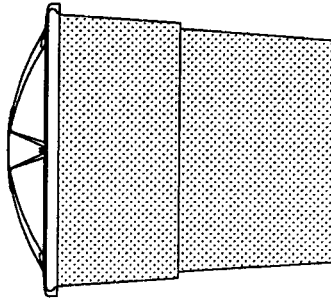
NOTES:

FILL TO TOP



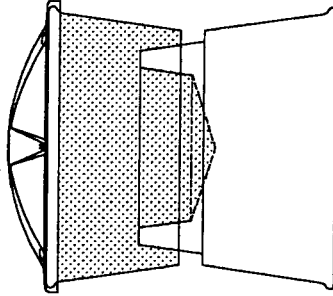
2100 LBS

FILL TO 1 IN.
FROM TOP



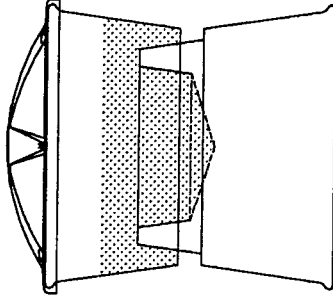
1400 LBS

FILL TO TOP



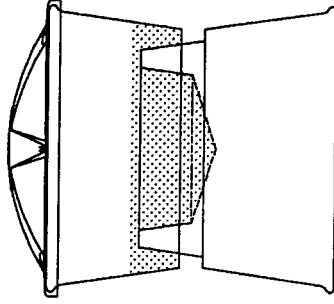
700 LBS

FILL TO 6 IN.
FROM TOP



400 LBS

FILL TO 11 IN.
FROM TOP



200 LBS

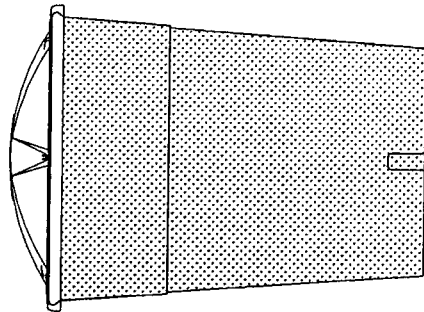
NOTES:

Revolutions	Revolutions	Revolutions	Revolutions	Revolutions	Date	Approved
					7/18/88	

TRAFFIX DEVICES, INC.
 MODEL: 2100
 DATE: 1/77
 REVISION: 1.00
 PART: 2100
 1/78 - 0

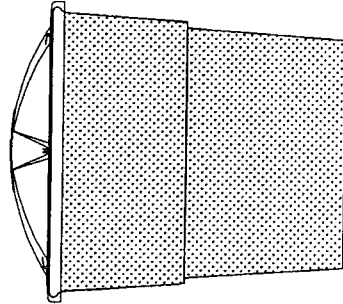
TRAFFIX DEVICES, INC.		
BARREL WEIGHTS.		
200 thru 2100 LBS		
Quantity	CAD Part No.	Drawing No.
	2100LBS	
Scale:		Size: C
		Sheet 1 of 1

FILL TO TOP



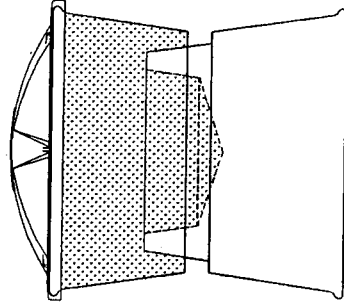
960 Kg

FILL TO 25 mm FROM TOP



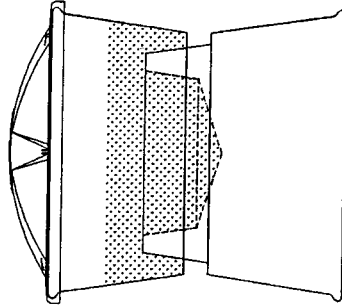
640 Kg

FILL TO TOP



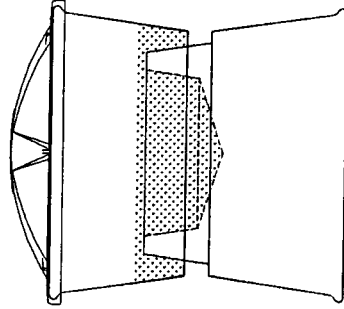
320 Kg

FILL TO 150 mm FROM TOP



180 Kg

FILL TO 280 mm FROM TOP



90 Kg

NOTES:

Traffix Devices, Inc.

Title

BARREL WEIGHTS,

90 THRU 960 Kg MODULE

Drawn

Checked

Approved

Date

Revision

Revision Description

Size

Material

Quantity

Unit

Weight

Volume

Notes

Remarks

Part No.

Rev

Sheet 1 of 1

TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS DECIMALS
.005 = .005 .005 = .005
.01 = .01 .01 = .01
.05 = .05 .05 = .05
1.00 = 1.00 1.00 = 1.00

TRAFFIX DEVICES, INC.
1717 1/2
1/7/92

Approved Date

Revision Description

Size

Material

Quantity

Unit

Weight

Volume

Notes

Remarks

Part No.

Rev

Sheet 1 of 1