

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 consist 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 <sup>3</sup>
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:

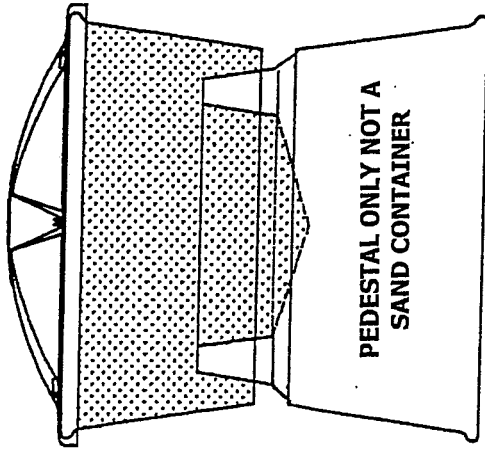
A. Part # 48247-S*	90-320 Capacity	wt = 7.3 Kg $\pm$ .5 Kg
* was 48400		
B. Part # 48247-P**	Base Support	wt = 7.7 Kg $\pm$ .5 Kg
* was 48700		
C. Part # 48140	640 Capacity	wt = 10.4 Kg $\pm$ .5 Kg
D. Part # 48210	960 Capacity	wt = 13.2 Kg $\pm$ .5 Kg

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)

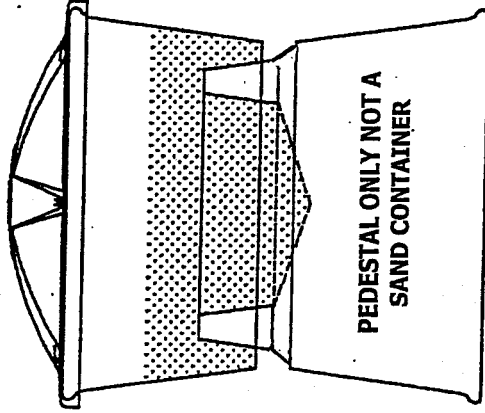
# NOTE THAT THERE IS NOW ONLY ONE SAND CONTAINER FOR 200LB, 400LB & 700LB

FILL TO TOP



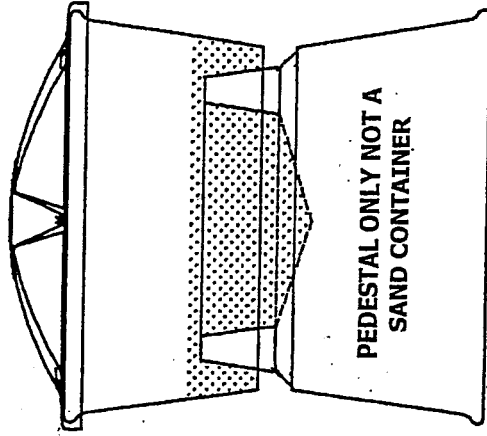
700 LBS  
(320 kg)

FILL TO 6 IN. (150 mm)  
FROM TOP



400 LBS  
(180 kg)

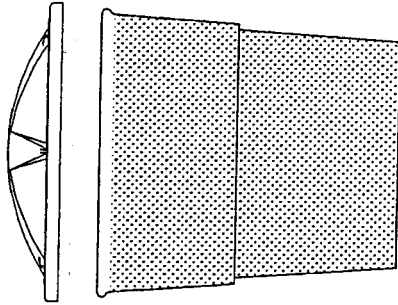
FILL TO 11 IN. (280 mm)  
FROM TOP



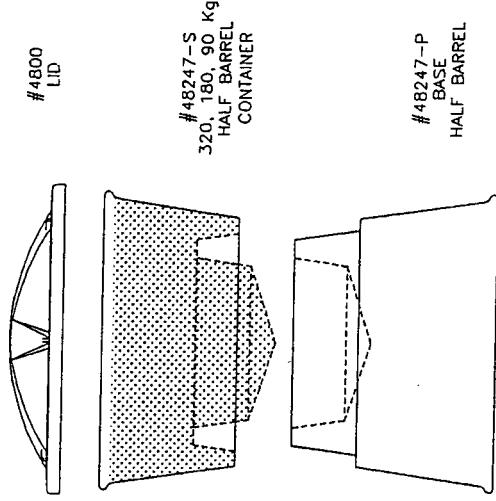
200 LBS  
(90 kg)



PART #48210-0  
ASSEMBLY FOR  
960 Kg MODULE



PART #48140-0  
ASSEMBLY FOR  
640 Kg MODULE



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

NOTES:

Rev	Date	Description	Approved	Date
1	7/11/98			

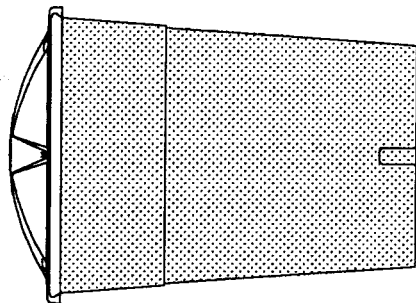
TOLEANCES UNLESS  
OTHERWISE SPECIED  
DIMENALS  
IN - .030  
FRACTIONS  
UNLESS  
OTHERWISE  
SPECIED  
AS 1:1

**Traffir Devices, Inc.**

Part No. **BARREL ASSEMBLIES.**  
320, 180, 90 Kg MODULE

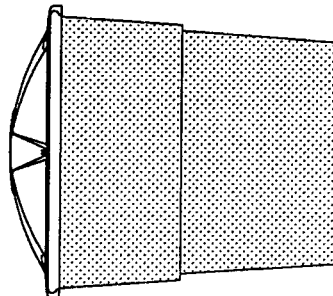
Quantity 1 CAD File No. ASSEMBLY2 Drawing No. \_\_\_\_\_ Rev -  
Scale: \_\_\_\_\_ Sheet 1 of 1

FILL TO TOP



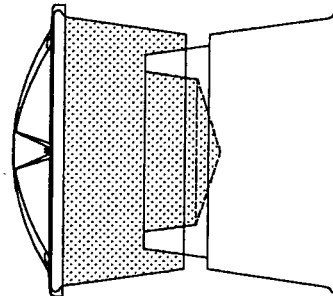
2100 LBS

FILL TO 1 IN.  
FROM TOP



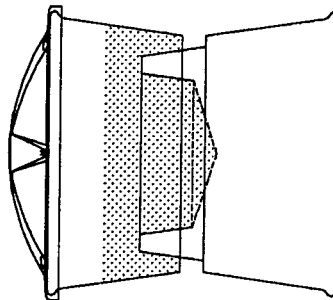
1400 LBS

FILL TO TOP



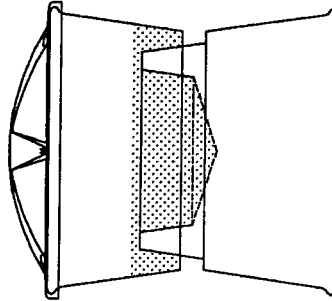
700 LBS

FILL TO 6 IN.  
FROM TOP



400 LBS

FILL TO 11 IN.  
FROM TOP



200 LBS

NOTES:

Quantity	Revised Description	Approved	Date

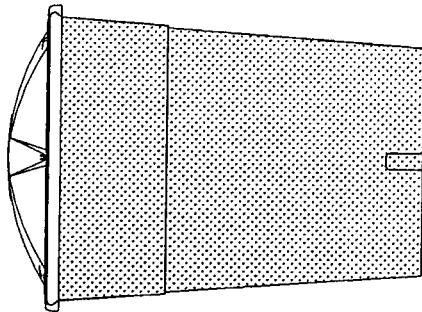
TRAFFIX  
INDUSTRIES, INC.  
TRAFFIC CONTROL SYSTEMS  
EQUIPMENT  
P.O. BOX 150  
MAYFIELD, KY 40150  
Tel: 606/335-1172

TrafficFix Devices, Inc.

BARREL WEIGHTS,  
200 thru 2100 LBS

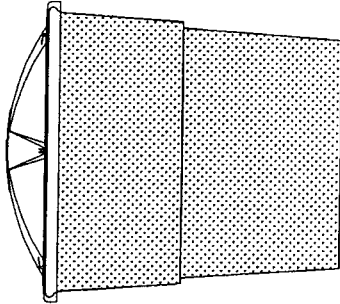
CAD File No.  
Drawing No.  
Rev.  
Scale  
Sheet 1 of 1

FILL TO TOP



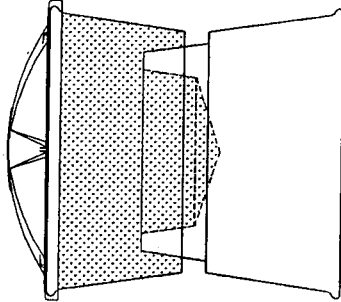
960 Kg

FILL TO 25 mm  
FROM TOP



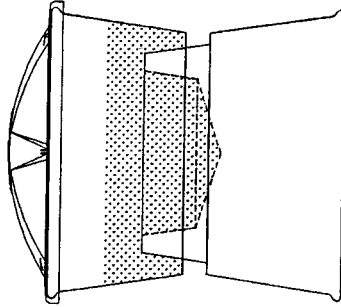
640 Kg

FILL TO TOP



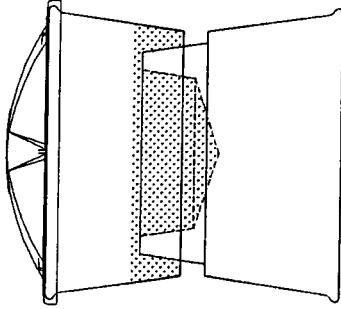
320 Kg

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	
Quantity	1	Drawing No.	90THRU960
Scale	1:1	Sheet	C of 1

Revision	Revision Description	Approved	Date
1	Size 9001		2/17/92

TOLERANCES UNLESS OTHERWISE SPECIFIED	FRACTIONS
FRACTIONS	DECIMALS
1/16" = 0.0625	1/100" = 0.001
3/16" = 0.1875	1/50" = 0.002
1/4" = 0.25	1/25" = 0.004
5/16" = 0.3125	1/12" = 0.008
3/8" = 0.375	1/6" = 0.016
1/2" = 0.5	1/3" = 0.033
5/8" = 0.625	1/2" = 0.0625
3/4" = 0.75	1/1" = 0.125
7/8" = 0.875	1/1" = 0.25
1" = 1.0	