



Report No. 1108.1

Date: 03-JAN-01

Re: Polylok Riser – P/N 3008 and Lid – P/N 3008-RC

Test Conducted For: Polylok Inc.
173 Church Street
Yalesville, CT 06492

Test Performed At: Polylok Inc. Laboratory
951 South Meriden Road
Cheshire, CT 06410

Test Witnessed By: George E. Nelson on 08- NOV – 01

Item Tested: One (1) sample column of assembled Risers. The column consists of seven (7) HDPE molded round Risers and one (1) HDPE molded Lid. The Riser and Lid joints contain foam seals and all sections are secured together with number 10 x 1 ½ inch long stainless steel sheet metal screws. The Riser column is 24 inches in diameter, 42 inches in height, and the gasket mounted on a flat plate

Object of Test: To determine the ability of the column to maintain vacuum.

Finding: The column maintained a 5.5-inch Hg vacuum for a minimum of 20 minutes with no visible deflection of the column or visible deterioration of the Riser or Lid joints.

Respectfully submitted,

George E. Nelson
President

Report No. 1108.2

Date: 03-JAN-01

Re: Polylok Riser – P/N 3008 and Lid – P/N 3008-RC

Test Conducted For: Polylok Inc.
173 Church Street
Yalesville, CT 06492

Test Performed At: Polylok Inc. Laboratory
951 South Meriden Road
Cheshire, CT 06410

Test Witnessed By: George E. Nelson on 08- NOV – 01

Item Tested: One (1) sample column of assembled Risers. The column consists of seven (7) HDPE molded round Risers and one (1) HDPE molded round Lid. The Riser and Lid joints contain foam seals and all sections are secured together with number 10 x 1 ½ inch long stainless steel sheet metal screws. The Riser column is 24 inches in diameter, 42 inches in height and secured in a 4 inch slab of concrete.

Object of Test: To determine the compressive strength of the Riser column and load bearing capacity of the lid.

Finding: A force of 6,000 pounds was uniformly distributed on the Riser column and Lid assembly. There was no visible sidewall failure. The test was terminated.
A force of 2,500 pounds was center loaded on the Riser column and Lid assembly with a 6 inch diameter steel disk. The lid was severely deflected, but contained no visible evidence of Riser rim joint failure. The test was terminated and the lid quickly resumed its original shape.

Respectfully submitted,

George E. Nelson

George E. Nelson
President



Report No. 1107.1

Date: 03-JAN-01

Re: Polylok Riser – P/N 3008 and Lid – P/N 3008-RC

Test Conducted For: Polylok Inc.
173 Church Street
Yalesville, CT 06492

Test Performed At: United Concrete Products, Inc.
173 Church Street
Yalesville, CT 06492

Test Witnessed By: George E. Nelson on 07- NOV – 01

Item Tested: One Riser column with Lid, surface mounted to a large six (6) inch Slab of concrete. The column consists of seven (7) HDPE injection Molded Risers and one (1) HDPE injection molded Lid. Each Riser column is 24 inches in diameter and 42 inches in height. The Riser and Lid joints contain foam seals and all sections are Secured together with number 10 x 1 ½ inch long stainless steel sheet metal screws. The bottom Riser is surface mounted on the concrete slab with six (6) ¼ inch diameter x 2 ¾ inch long Tapcon screws.

Object of Test: To determine the side pull force required to rip the column from the concrete slab, measured with a Dillon 10,000 lb. Capacity Dynamometer.

Finding: A two ply-heavy duty nylon sling was positioned on the upper area Of the seventh (top) Riser. The sling was linked to a 6,000 lb. Capacity Lug-All ratchet cable puller next to the Dynamometer and the loose end was secured on the frame of a 10-ton heavy duty fork lift truck.
It required 1,000 lbs. Of side pull force to rip the Riser column from the concrete slab.

Respectfully submitted,

George E. Nelson
President



Report No. 1107.2

Date: 03-JAN-01

Re: Polylok Riser – P/N 3008 and Lid – P/N 3008-RC

Test Conducted For: Polylok Inc.
173 Church Street
Yalesville, CT 06492

Test Performed At: United Concrete Products, Inc.
173 Church Street
Yalesville, CT 06492

Test Witnessed By: George E. Nelson on 07- NOV – 01

Item Tested: Four (4) Riser columns with Lids, secured and equally spaced, in a common six (6) inch slab of concrete. Each column consists of seven (7) HDPE injection Molded Risers and one (1) HDPE injection molded Lid. Each Riser column is 24 inches in diameter and 42 inches in height. The Riser and Lid joints contain foam seals and all sections are secured together with number 10 x 1 ½ inch long stainless steel sheet metal screws.

Object of Test: To determine the side pull force required to cause catastrophic Riser column failure measured with a Dillon 10,000 lb. Capacity Dynamometer, on two Riser columns.

- Finding: A/ A two ply-heavy duty nylon sling was positioned on one column in the upper area of its third Riser. It required 2,800 lbs. Of side pulling force to cause catastrophic failure to the Riser column.
- B/ A two ply-heavy duty nylon sling was positioned on the upper area of the seventh (top) Riser, of one column. It required 1,000 lbs. Of side pull force to create a sufficient column movement to initiate cracking in the 2nd Riser, the one positioned directly over the concrete slab. It required 1,200 lbs. of side pull force to cause catastrophic failure of this Riser column.

Respectfully submitted,

George E. Nelson
President



Report No. 1107.3

Date: 03-JAN-01

Re: Polylok Riser – P/N 3008 and Lid – P/N 3008-RC

Test Conducted For: Polylok Inc.
173 Church Street
Yalesville, CT 06492

Test Performed At: United Concrete Products, Inc.
173 Church Street
Yalesville, CT 06492

Test Witnessed By: George E. Nelson on 07- NOV – 01

Item Tested: Four (4) Riser columns with Lids, secured and equally spaced, in a common six (6) inch slab of concrete. Each column consists of seven (7) HDPE injection Molded Risers and one (1) HDPE injection molded Lid. Each Riser column is 24 inches in diameter and 42 inches in height. The Riser and Lid joints contain foam seals and all sections are secured together with number 10 x 1 ½ inch long stainless steel sheet metal screws.

Object of Test: On one Riser column, to determine the side pull force required to cause catastrophic Riser column failure measured, with a Dillon 10,000 lb. Dynamometer, in a simulated shear load from an uneven frost heave.

Finding: A two ply-heavy duty nylon sling was positioned on one column in the upper area of the seventh (top) Riser. It was placed under light tension. A two ply-heavy duty nylon sling was positioned on the same column, directly opposite, in the middle of the third Riser. The column withstood a sustained pull force of 3,000 lbs. in the middle area of the third Riser, without visible deterioration of the column or joints. It required 4,000 lbs. of side pull force to cause catastrophic failure of the Riser column.

Respectfully submitted,

George E. Nelson
President



Report No. 1107.4

Date: 03-JAN-01

Re: Polylok Riser – P/N 3008 and Lid – P/N 3008-RC

Test Conducted For: Polylok Inc.
173 Church Street
Yalesville, CT 06492

Test Performed At: United Concrete Products, Inc.
173 Church Street
Yalesville, CT 06492

Test Witnessed By: George E. Nelson on 07- NOV – 01

Item Tested: Four (4) Riser columns with Lids, secured and equally spaced, in a common six (6) inch slab of concrete. Each column consists of seven (7) HDPE injection Molded Risers and one (1) HDPE injection molded Lid. Each Riser column is 24 inches in diameter and 42 inches in height. The Riser and Lid joints contain foam seals and all sections are secured together with number 10 x 1 ½ inch long stainless steel sheet metal screws.

Object of Test: On one Riser column, to determine the side pull force required to cause catastrophic top Riser failure, measured with a Dillon 10,000 lb. Dynamometer, while the fourth Riser is firmly supported against the pulling force.

Finding: A two ply-heavy duty nylon sling was positioned on one column in the upper area of the seventh (top) Riser. The fork of a 10-ton heavy duty lift truck was positioned against the top of the fourth Riser, in line with the nylon sling. The sling was linked to a 6,000 lb. Capacity Lug-All ratchet cable puller next to the Dynamometer and the loose end was secured on the frame of the lift truck. The top Riser withstood a direct pull of 2,000 lbs. and showed no visible indication of failure. At 2,500 lbs. the top two Risers broke from the column, while the other five Risers were intact with the bottom Riser still secured in the concrete slab.

Respectfully submitted,

George E. Nelson
President

ExxonMobil HDPE HD 6605

Injection Molding Resin

ExxonMobil
Chemical
RISERS + LOVERS

Product Description

HD 6605 is a narrow molecular weight hexene copolymer designed for a wide range of injection molding applications, offering excellent ESCR with good stiffness-toughness balance. Ideally suited for articles requiring rugged physical performance in cold temperature environments.

Applications

- Waste carts
- Recreational vehicle components
- Industrial closures
- Automotive components

| Additive Package | Form | Stabilizer |
|------------------|--------|-------------------------|
| HD 6605.29 | Pellet | UV-8 Protection Package |
| HD 6605.70 | Pellet | Gas Fade Resistant |

| Resin Properties | Test Based On ² | Typical Value / Unit |
|-----------------------|---------------------------------|-------------------------|
| Melt Index | ASTM D-1238 (190°C, 2.16 kg) | 5 g/10 min. |
| Density | ASTM D-4883 | 0.948 g/cm ³ |
| Melting Point | ASTM D-3418 | 130 (266) °C (°F) |
| Crystallization Point | ASTM D-3418 | 114 (237) °C (°F) |

Molded Properties¹

| | | |
|---|-----------------------------|--|
| Flexural Modulus 1% Secant | ASTM D-790 Procedure B | 710 (102,400) MPa (psi) |
| Tensile Yield Stress | ASTM D-638 | 23.3 (3360) MPa (psi) |
| Tensile Break Elongation | ASTM D-638 | 48 % |
| Tensile Impact @ -40°C | ASTM D-1822 | 325 (155) kJ/m ² (ft-lb/in ²) |
| Notched Izod Impact @ -40°C | ASTM D-256 | 70.5 (1.32) J/m(ft-lb/in) |
| Brittleness Temperature | ASTM D-746 | < -70 (< -94) °C (°F) |
| Environmental Stress Crack Resistance, F ₅₀ | ASTM D-1693 Cond. B, 10% | 18 hr |
| Deflection Temperature @ 66 psi @ 264 psi | ASTM D-648 | 67 (152) °C (°F) 38 (101) |

1. Properties are based on injection molded samples.
2. Test procedures may be modified to accommodate operating conditions or facility limitations.

HD 6605 grade - in principle - can be used in food contact applications in the USA (FDA) and in Canada (HPB). Migration or use limitations may apply. Please contact your ExxonMobil Chemical representative for more detailed information and/or actual compliance certification documents for the specific grade of interest.

November 2008

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