Eastern States Consortium Split Sample Comparison

Manufacturing Plant	**ADS Wooster**
Date of Production	**7/13/2006**
Type:	**S**
Size:	**450mm (18")**
Perforation Class:	**Non-Perf.**
Specification:	**AASHTO M294**

		Test Results	
Section	**Specification**	**TRI/Environmental**	**ADS QC Lab**
6.1 Basic Materials	Minimum Cell Class 335400C and SP-NCTL 15% 24hours	Pass	Pass
	Density .948 to .955 g/cm3	0.951	0.953
	Melt index .15 to .40 g/10 min.	0.228	0.29
	Carbon Black Content 2% minimum / 5% Maximum	2.61%	2.40%
7.1 Workmanship	Free of foreign inclusions and visible defects. Inner liner shall be fused to outer corrugated wall at all internal corrugation crests.	Pass	Pass
7.2 Pipe Dimensions, 7.2.2 Wall Thickness	The minimum inner wall thickness requirement is 1.3mm (0.051")	0.063	.057"
7.2 Pipe Dimensions, 7.2.3 Inside Diameter	Nominal inside diameter shall not exceed 4.5% oversize or 1.5% undersize and not more than 37mm oversize. 443mm / 470mm (17.45" / 18.51")	18.00"	18.03"
7.3 Perforations	Solid Pipe, Class 1, Class 2	N/A	N/A
7.4 Pipe Stiffness	Minimum pipe stiffness requirement at 5% deflection is 275kPa (40psi), @ 0° / 45° / 90°	46 / 44 / 45	45 / 43 / 44
7.5 Pipe Flattening	No evidence of buckling, cracking, splitting or delamination. when the vertical inside diameter is reduced by 20%.	Pass	Pass
7.6 ESCR	There shall be no cracking of the pipe.	Pass	Pass
7.7 Brittleness	The pipe specimens shall not crack or split. Five non-failures out of six impacts will be acceptable.	Pass	Pass
7.8 Fitting Requirements	Pipe connections shall not separate to create a gap exceeding 5mm. (0.197") when measured between the bell and spigot portions of pipe fittings shall not crack or delaminate.	Pass	Pass
11 Marking	Pipe and fitting shall be marked at intervals not more than 3.5m, manufacture's name or trademark, nominal size, AASHTO M294, plant code and date of manufacture of appropriate code.	Not on report	ADS 18" 450mm, 27(Wooster)-07/13/06

Quality Control Manager