



Standard Specification for Polyethylene Upright Storage Tanks¹

This standard is issued under the fixed designation D1998; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification covers flat-bottom, upright, cylindrical tanks molded in one-piece seamless construction by rotational molding. The tanks are molded from polyethylene for above ground, vertical installation and are capable of containing aggressive chemicals at atmospheric pressure. Included are requirements for materials, properties, design, construction, dimensions, tolerances, workmanship and appearance. Tank capacities are from 1900 L (500 gal) up.

1.2 This specification covers the design of stationery vessels for use at atmospheric pressure intended for use with liquids heated below their flash points and continuous service temperatures below 66°C (150°F) for Type I tanks and below 60°C (140°F) for Type II tanks.

1.2.1 NFPA Standards 30 and NFPA 31 shall be consulted for installations that are subject to the requirements of these standards.

1.3 For service requirements beyond the scope of this specification (1.2), such as externally imposed mechanical forces, internal pressure or vacuum, higher temperature service, etc., other relevant sources of standards, for example, local and state building codes, NFPA, ASME, ARM, etc., shall be consulted.

1.4 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

NOTE 1—ISO 13341:2005+A1:2011 and ISO 13575:2012 are similar, but not equivalent to this standard.

1.5 The following precautionary caveat pertains only to the test methods portion, Section 11, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

¹ This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.19 on Film, Sheeting, and Molded Products (Section D20.15.01).

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2. Referenced Documents

2.1 ASTM Standards:²

- D618 Practice for Conditioning Plastics for Testing
- D883 Terminology Relating to Plastics
- D1693 Test Method for Environmental Stress-Cracking of Ethylene Plastics
- D2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products
- D3892 Practice for Packaging/Packing of Plastics
- D4703 Practice for Compression Molding Thermoplastic Materials into Test Specimens, Plaques, or Sheets
- E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method
- F412 Terminology Relating to Plastic Piping Systems

2.2 OSHA Standard:

- 29 CFR 1910.106 Occupational Safety and Health Administration, Flammable and Combustible Liquids³

2.3 ANSI Standard:

- B-16.5 Pipe Flanges and Flanged Fittings⁴

2.4 NFPA Standards:

- 30 Flammable and Combustible Liquid Code⁵
- 31 Installation of Oil Burning Equipment⁵

2.5 ISO Standards:⁶

- ISO 13341:2005+A1:2011 Static Thermoplastic Tanks for the Above Ground Storage of Chemicals – Blow Moulded or Rotationally Moulded Polyethylene Tanks – Requirements and Test Methods
- ISO 13575:2012 Static Thermoplastic Tanks for Above Ground Storage of Domestic Heating Oils, Kerosene and Diesel Fuels – Blow Moulded and Rotationally Moulded Polyethylene Tanks and Rotationally Moulded Tanks

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from Occupational Safety and Health Administration (OSHA), 200 Constitution Ave., NW, Washington, DC 20210.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

⁵ Available from National Fire Protection Association (NFPA), 1 Batterymarch Park, Quincy, MA 02269-9101.

⁶ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

*A Summary of Changes section appears at the end of this standard

Made of Anionically Polymerized Polyamide 6 – Requirements and Test Methods

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminologies **D883** and **F412** and the Association of Rotational Molders (ARM) Glossary of Terms,⁷ unless otherwise indicated.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *bottom knuckle radius, n*—the outside corner radius.

3.2.2 *impact failure, n*—any crack in the test specimen resulting from the impact and visible in normal room lighting to a person with normal eyesight.

3.2.3 *rotational molding, n*—a three-stage commercial process consisting of loading the mold with powdered resin, fusing the resin by heating while rotating the mold about more than one axis, and cooling and removing the molded article.

3.2.4 *service factor, n*—a number less than 1.0 (that takes into consideration all the variables and degrees of safety involved in a polyethylene storage tank installation) that is multiplied by the hydrostatic design basis to give the design hoop stress.

4. Classification

4.1 Tanks meeting this specification are classified according to type as follows, and it is the responsibility of the purchaser to specify Type I or Type II:

4.1.1 Type I—Tanks molded from cross-linkable polyethylene.

4.1.2 Type II—Tanks molded from non-cross-linkable polyethylene.

5. Materials

5.1 This specification is based upon the use of 100 % virgin polyethylene intended for the rotational molding process. Any use of regrind, recycled or reprocessed materials, or combinations of such materials, shall not rely upon the performance data of their original constituents, but must meet the requirements of this specification in its own right.

5.1.1 The polyethylene shall have a stress-cracking resistance of 500 h minimum F50 in accordance with Test Method **D1693**, Condition A, full-strength stress-cracking agent. The test specimens shall be compression molded or rotational molded. If compression molded, Procedure C of Annex A1 of Practice **D4703** shall be followed for both types of polyethylene with a minimum platen temperature of 177°C (350°F) for Type II materials. The temperature for Type I (cross-linkable) polyethylene shall be 197°C (390°F) and the platen shall be kept closed under full pressure for five minutes at the specified temperature in order to bring about the crosslinking reaction. If the test specimens are rotational molded, the conditions for rotational molding shall be similar to the conditions used for molding a tank from this polyethylene.

NOTE 2—The stress-cracking test is not used as an indicator of general

⁷ Available from Association of Rotational Molders, 800 Roosevelt Road, C-312, Glen Ellyn, IL 60137, tel: 630-942-6589.

chemical resistance of a polyethylene. Refer to the polyethylene supplier's or molder's chemical-resistance chart for information on the resistance of the polyethylene to specific chemicals or products, or test specific products or chemicals prior to use.

5.2 All tanks used for outdoor installation shall contain an ultraviolet stabilizer at a level adequate to give protection for the intended service life of the tanks. This stabilizer shall be compounded into the polyethylene.

5.3 Any pigments added must be compatible with the polyethylene and shall not exceed 0.5 % dry blended, and 2 % compounded in, of the total weight.

NOTE 3—The use of dry-blended pigments may have an effect on physical properties, that is, impact strength.

5.4 Each resin used in designing tanks covered by this specification shall have hydrostatic-hoop-stress data available.

6. Design Requirements for Both Type I and Type II Tanks

6.1 *Cylinder Shell (Unsupported Portion of Tanks)*—The minimum required wall thickness of the cylindrical shell at any fluid level (F) shall be determined by the following equations, but shall not be less than 4.7 mm (0.187 in.) thick. The tolerance indicated in **9.1.2** applies to these dimensions.

$$HL = HM - F \quad (1)$$

where:

HL = head at level F, m (ft),

HM = maximum fluid head, m (ft), and

F = any fluid level, m (ft).

For illustration, see **Fig. 1**.

$$T = P \times OD/2 \text{ SD} \quad (2)$$

where:

T = wall thickness, mm (in.),

P = pressure, MPa (0.0098 MPa/m-H₂O × SG × HL (m)), or psi (0.433 psi/ft-H₂O × SG × HL (ft)),

SG = specific gravity of fluid,

HL = head at level F, m (ft),

OD = outside diameter of tank, mm (in.), and

SD = hydrostatic design stress, MPa (psi).

6.1.1 The hydrostatic design stress that is used to determine the minimum wall thickness at any fluid level must be based on hoop stress data for the resin. The hoop stress data, obtained in accordance with the procedures of Test Method **D2837**, provide a hydrostatic-design-basis for the resin. The hydrostatic-design-basis must be reduced by a service factor to determine the actual hydrostatic design stress. The maximum service factor shall be 0.5 for wall thicknesses less than 9.5 mm (0.375 in.). For thicknesses equal to or greater than 9.5 mm (0.375 in.), the maximum service factor shall be 0.475. For example, if the hydrostatic-design-basis for the resin is 8.7 MPa (1260 psi), the hydrostatic design stress for a tank with wall thickness greater than 9.5 mm (0.375 in.) is 0.475 × 8.7 = 4.1 MPa (or 0.475 × 1260 = 600 psi).

6.1.2 Tank hoop stresses shall be derated for service above 23°C (73.4°F).

6.2 *Cylinder Shell (Externally Supported Tanks)*—The minimum required wall thickness for the cylinder straight shell

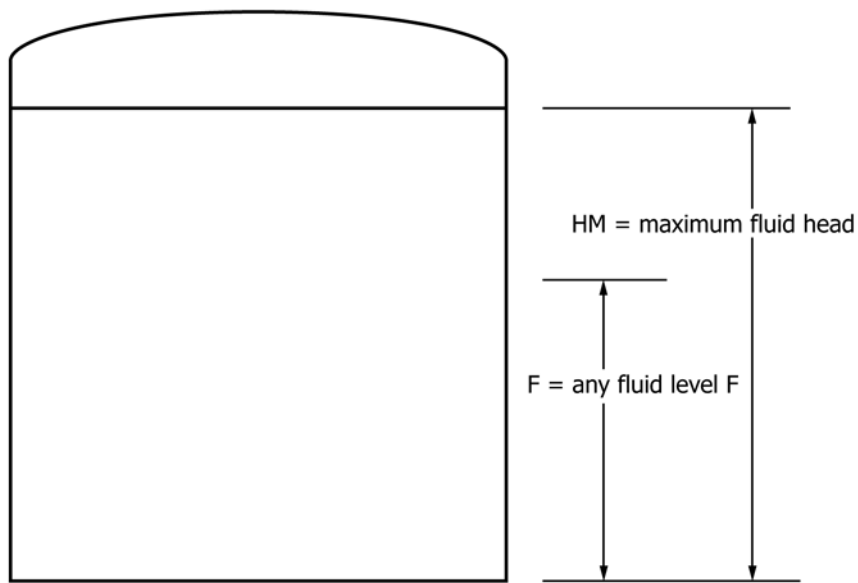


FIG. 1 Illustration of Cylinder Shell

must be sufficient to support its own weight in an upright position without any external support, but shall not be less than 4.7 mm (0.187 in.) thick. The tolerance indicated in 9.1.2 applies to these dimensions.

6.3 *Top Head*—Must be integrally molded with the cylinder shell. The minimum thickness of the top head shall be equal to the top of the straight wall.

6.4 *Bottom Head*—Must be integrally molded with the cylinder shell. The minimum thickness for a full-supported flat-bottom head shall be 4.7 mm (0.187 in.). The radius of the bottom knuckle of a flat-bottom tank shall not be less than 25.4 mm (1 in.) for tanks with a diameter less than 1.8 m (6 ft) and 38.1 mm (1.5 in.) for a diameter greater than 1.8 m (6 ft). The minimum thickness of the radius shall not be less than the maximum thickness of the cylinder wall.

6.5 *Bottom Knuckle Radius*—The minimum thickness of the outer radius shall not be less than the maximum thickness of the cylinder wall.

NOTE 4—Since it is difficult to control the absolute radius dimension and, in the absence of any FEA or scientific analysis, it is recommended that the outside radius of the bottom knuckle of a flat-bottom tank not be less than 25.4 mm (1 in.) for tanks with a diameter less than 1.8 m (6 ft) and 38.1 mm (1.5 in.) for a diameter greater than 1.8 (6 ft).

6.6 *Open-Top Tanks*—The top edge of open tanks shall be reinforced by design to maintain its shape after installation.

7. Fittings

7.1 Fabricated nozzles, gaskets, and other fitting accessories must be chemically compatible with the materials to be handled in the tanks.

7.2 Openings that are cut in tanks to install fittings must not have sharp corners. Holes shall have minimum clearance to insure best performance of fittings.

7.3 The size, location, and specification, and so forth, for manways and fittings shall be agreed upon between the purchaser and the manufacturer.

7.4 The vents must comply with OSHA 1910.106 (F) (iii) (2) (IV) (9) normal venting for atmospheric tanks, or other accepted standard, or shall be at least as large as the filling or withdrawal connection, whichever is larger but in no case less than 25.4 mm (1 in.) nominal inside diameter.

7.5 Fittings installed in tanks shall be of appropriate strength to meet manufacturer and purchaser specifications.

7.6 Bolts securing mechanical fittings must be manufactured of materials compatible with tank contents.

7.7 Provisions shall be made to attach hold-down devices to the tanks for outdoor service.

7.8 For all flanged connectors, the flange drilling and bolting shall be in accordance with ANSI/ASME B-16.5 for 150 psi (1 MPa) pressure class straddling the principal center-line of the vessel.

8. Performance Requirements

8.1 The following performance requirements shall be met by Type I and Type II tanks:

8.1.1 *Low-Temperature Impact*—Low-temperature impact shall be determined using the test method described in 11.3. The requirements for Type I and Type II tanks are as follows:

Wall thickness, mm (in.)	Impact energy, min. J (ft-lb)
4.7 mm (0.187 in.) to and including 6.4 mm (0.25 in.)	122.0 (90)
6.6 mm (0.26 in.) to and including 12.9 mm (0.50 in.)	135.5 (100)
12.9 mm (0.51 in.) to and including 19.3 mm (0.75 in.)	203.2 (150)
19.3 mm (0.76 in.) to and including 25.4 mm (1.00 in.)	271.0 (200)
Greater than 25.4 mm (1.00 in.)	271.0 (200)

8.1.2 *Percent Gel, for Type I Tanks Only*—The percent gel level shall be determined using the test method described in 11.4. The percent gel level for Type I tanks on the inside 3.2 mm (0.125 in.) of the wall shall be a minimum of 60 %.

9. Dimensions and Tolerances

9.1 *General*—All dimensions will be taken with the tank in the vertical position, unfilled. Tank dimensions will represent the exterior measurements.

9.1.1 *Outside Diameter*—The tolerance for the outside diameter, including out of roundness, shall be $\pm 3\%$.

9.1.2 *Shell Wall and Head Thickness*—The tolerance for average thickness at each elevation shall be -10% of the design thickness on the low side and shall be unlimited on the high side. The tolerance for individual audit readings shall be limited to -20% of the design thickness. The total amount of surface area on the low side of the tolerance shall not exceed 10% of the total surface area.

9.1.3 *Placement of Fittings*—The tolerance for fitting placements shall be 12.7 mm (0.5 in.) in elevation and 2° radial at ambient temperature.

10. Workmanship

10.1 Type I finished tank walls shall be free, as commercially practicable, of visual defects such as foreign inclusions, air bubbles, pinholes, pimples, crazing, cracking and delaminations that will impair the serviceability of the vessel. Fine bubbles are acceptable with Type II tanks to the degree to which they do not interfere with proper fusion of the resin melt.

10.2 The acceptable finish shall be predetermined by agreement between the molder and the buyer.

11. Test Methods

11.1 *Test Specimens*—Test specimens shall be taken from an area that is representative of the bottom side wall. If no representative sample cut-out area in the tank is available, test specimens shall be molded in a test mold. In either case, prior testing shall verify that the tank wall and the test specimen have equal impact resistance.

11.1.1 The test mold shall be constructed of the same type material and have the same wall thickness as the tank mold. The thickness of the specimen from a test mold shall be the same as the thickness of the bottom sidewall within the tolerances as defined in 9.1.2. The test mold shall be molded with each tank.

11.2 *Conditioning*—If requested, test specimens shall be conditioned at $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) and $50 \pm 10\%$ relative humidity for not less than 40 h prior to testing in accordance with Procedure A of Practice D618.

11.3 Low-Temperature Impact Test:

11.3.1 *Scope*—This test method is for the determination of the impact property of rotational-molded polyethylene tanks at low temperature. The test method is used on tanks molded from both crosslinked and non-crosslinked polyethylenes.

11.3.2 *Summary of Test Method*—Test specimens are cut from available areas on the tank and conditioned at -29°C (-20°F) for a specified time. A suitable type of test apparatus

is shown in Fig. 2 and Fig. 3. The specimens are placed, inside-surface down, in the sample holder and immediately impacted from a prescribed height with a dart of specified weight and tip radius. The specimen is observed for failure on both surfaces. The test prescribes a minimum impact value that the specimen must pass.

11.3.3 Significance and Use:

11.3.3.1 The dart impact test at -29°C (-20°F) produces a value that is used as an indication of the quality of the tank. If the molding conditions were inadequate and a homogenous melt was not obtained, the impact will likely be low. Higher impact values are obtained with ideal molding conditions indicating that a quality part with good impact resistance has been molded.

11.3.3.2 The impact test gives a true indication of how well the tank was molded.

11.3.4 Procedure:

11.3.4.1 Cut specimens to loosely fit the 127 mm by 127 mm (5 in. by 5 in.) sample holder (See Fig. 3). Specimens shall be approximately 127 mm by 127 mm (5 in. by 5 in.), or the maximum size available. In those tanks where specimens of the above size are not available, the supplier must show correlation data between the smaller size and the recommended size.

11.3.4.2 Cool bath to -29°C (-20°F) by immersing small quantities of dry ice in isopropyl alcohol used as the bath medium or chill the specimens in a freezer if available. (**Warning**—Care shall be exercised as the dry ice will agitate the solution violently.)

NOTE 5—An alternative temperature for impact is -40°C (-40°F) or, in some cases, the service temperature. In applications that have a service

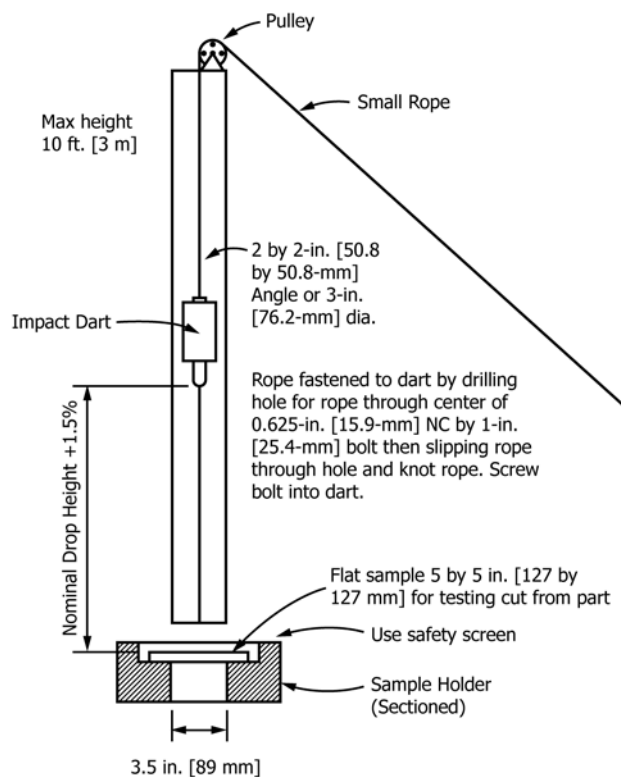


FIG. 2 Dart Drop Impact Test Apparatus

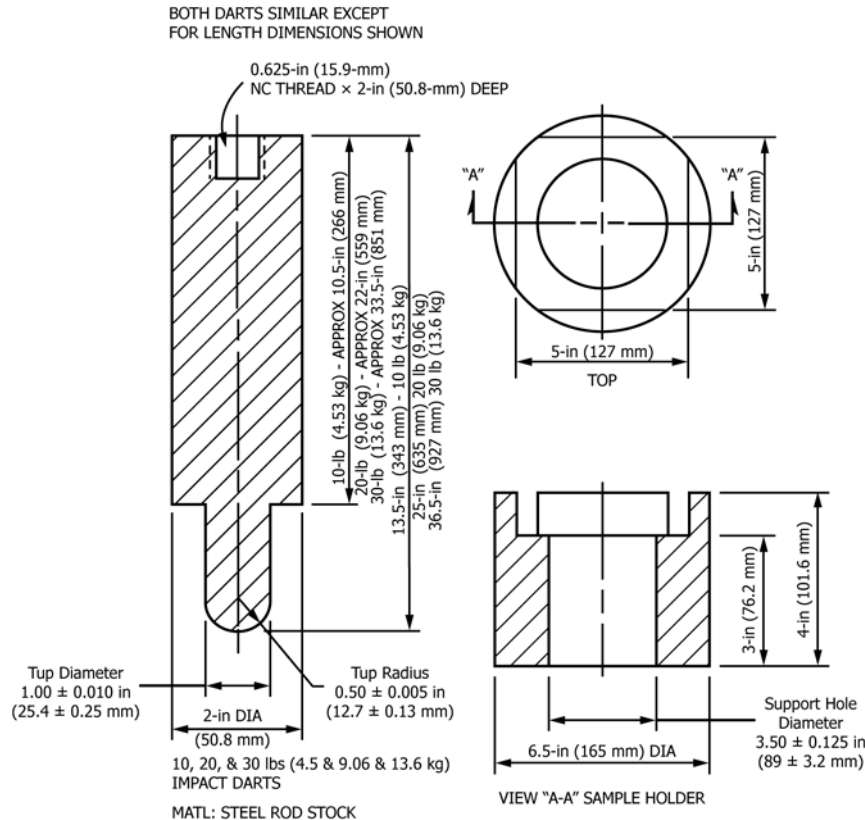


FIG. 3 Dart Drop Impact Test Apparatus

temperature between -29°C (-20°F) and -40°C (-40°F), either the service temperature or -40°C (-40°F) shall be used. For applications that have a service temperature below -40°C (-40°F), the impact temperature shall be at or below the service temperature.

11.3.4.3 Immerse the specimens in the bath for a minimum of 30 min while maintaining the bath temperature. More immersion time is required for specimens greater than 6.4 mm (0.25 in.) thick or for specimens chilled in air instead of alcohol. A minimum of two hours is required for air chilled specimens.

11.3.4.4 Remove specimens from the freezer or bath one at a time. Within five seconds, release the dart and impact each specimen on the outer surface. Use the impact energy specified in 8.1.1 as calculated by multiplying the nominal dart weight (known to $\pm 1\%$) by the drop height (Fig. 2). The specimen shall not fail at the specified impact energy (see 3.2.2 for the definition of failure). Whenever possible, choose a dart weight that permits the drop height to be between 0.8 and 2.3 m (2.5 and 7.5 ft) in order to minimize the effect of velocity on the result of the test.

NOTE 6—Ductile failures indicate proper molding for Type I and Type II tanks, while cracking or shattering indicates improperly molded specimens. The test apparatus is shown in Fig. 2 and Fig. 3.

11.3.5 Report the Following Information:

- 11.3.5.1 Identification of the tank,
 - 11.3.5.2 Date of test,
 - 11.3.5.3 Impact energy used for the test in J (ft-lb), and
 - 11.3.5.4 Pass or fail.
- 11.3.6 Precision and Bias:

11.3.6.1 Table 1 is based on a round robin conducted in 1991 in accordance with Practice E691, involving two materials tested by seven laboratories and two materials tested by four laboratories. For each material, all of the samples were molded at one source. Each laboratory tested 20 specimens of a material on two different days under the same conditions.

11.3.6.2 Table 2 is based on a round robin conducted in 1988 in accordance with Practice E691, involving two materials tested by seven laboratories. For each material, all the samples were prepared at one source, but the individual specimens were prepared at the laboratories that tested them. Each test result was the average of 20 individual determinations. Each laboratory obtained two test results for each material. (Warning—The following explanations of r and R are only intended to present a meaningful way of considering the approximate precision of this test method. The data in Table 1 and Table 2 shall not be rigorously applied to acceptance or

TABLE 1 Precision Summary—Impact Strength at -29°C (-20°F)

Material	Average	S_r^A	S_R^B	V_r^C	V_R^C	r^D	R^D
6	44.4	9.1	11.7	20.5	26.4	25.6	32.8
3	119.8	7.3	11.4	6.1	9.5	20.4	31.9
4	119.8	3.1	15.4	2.6	12.9	8.6	63.1
5	121.6	6.6	26.3	3.8	20.0	12.8	67.9

^A S_r is the within laboratory repeatability.

^B S_R is the between laboratory reproducibility.

^C V_r and V_R are the coefficients of variation (standard deviation expressed as a percent of the average).

^D r and R are the 95% limits for a single sample for repeatability and reproducibility respectively.

TABLE 2 Precision Summary—Impact Strength at –40°C (–40°F)

Material	Average	S_r^A	S_R^B	V_r^C	V_R^C	r^D	R^D
2	155.5714	5.1686	16.3623	3.3	10.5	14.472045	8.146
1	167.6429	6.2393	13.6268	3.7	8.1	17.470038	15.51
Average:				3.5	9.3		

^A S_r is the within laboratory repeatability.

^B S_R is the between laboratory reproducibility.

^C V_r and V_R are the coefficients of variation (standard deviation expressed as a percent of the average).

^D r and R are the 95 % limits for a single sample for repeatability and reproducibility respectively.

rejection of material, as those data are specific to the round robin and are not necessarily representative of other lots, conditions, materials, or laboratories. Users of this test method shall apply the principles outlined in Practice E691 to generate data specific to their laboratory and materials, or between specific laboratories. The principles shown below would then be valid for such data.)

11.3.6.3 *Concept of r and R* —If S_r and S_R have been calculated from a large-enough body of data, and for test results that were averages from testing 20 specimens:

(1) *Repeatability, r* —In comparing two test results for the same material, obtained by the same operator using the same equipment on the same day, the two test results shall be judged not equivalent if they differ by more than the r value for that material.

(2) *Reproducibility, R* —In comparing two test results for the same material, obtained by different operators using different equipment on different days, the two test results shall be judged not equivalent if they differ by more than the R value for the material.

(3) Any judgment in accordance with (1) or (2) would have an approximate 95 % (0.95) probability of being correct.

11.3.6.4 There are no recognized standards by which to estimate the bias of this test method.

11.4 O-Xylene-Insoluble Fraction (Gel Test):

11.4.1 *Scope*—This test method is for determination of the ortho-xylene insoluble fraction (gel) of crosslinked polyethylene. (Type I tanks)

11.4.2 *Summary of Test Method*—A weighed specimen of the crosslinked polyethylene sample is placed in a screen container and the total weight is taken. The container is submerged in boiling o-xylene overnight, which dissolves the uncross-linked portion of the sample. The container with the specimen is dried in an oven and weighed. The percentage gel content is calculated from the weight loss and the original specimen weight.

11.4.3 *Significance of Test*—The o-xylene insoluble portion (gel) of crosslinked polyethylene is an indication of the amount of crosslinking in the polyethylene. The gel is not a direct measure of the extent of the crosslinking network, but indirectly serves to provide a good measure of the crosslinking. It is, therefore, valuable as a test for the quality of the crosslinked polyethylene part.

11.4.4 Apparatus:⁸

11.4.4.1 Extraction Apparatus:

(1) Resin Kettle 2-L

(2) Heating Mantle 2-L

(3) Clamp, Resin Kettle

(4) Condenser, with ground taper joint to fit hole in resin kettle lid

(5) Variable Transformer

(6) Stand with clamp to support the kettle and condenser

(7) Metal pan, for setting the apparatus in to retain the o-xylene in the event the kettle breaks

11.4.4.2 *Analytical Balance*, that weighs to four decimal places.

11.4.4.3 *Stainless Steel Screen*, 100-mesh.

11.4.4.4 *Muffle Furnace*.

11.4.4.5 *Forced-Draft Oven*.

11.4.4.6 *Reagents*:

(1) O-xylene, technical grade

(2) Cyanox 2246, antioxidant⁹ or equivalent (2,2'-Methylenebis(4-methyl-6-tert-butylphenol))

11.4.5 *Hazards*:

11.4.5.1 Care shall be exercised in handling o-xylene. The Material Safety Data Sheet shall be consulted prior to its use. O-xylene is listed in Subpart Z—Toxic and Hazardous Substances of 29 CFR Ch. VII (7-1-88 Edition). Other applicable EPA and government standards shall also be consulted.

11.4.6 *Test Specimens*:

11.4.6.1 The test specimen shall be from the 3.2 mm (0.125 in.) thickness of the interior wall of Type I tanks. It shall be cleanly cut so there are no frayed edges or corners.

11.4.6.2 The specimen shall be taken from a manway, drain opening or similar area that is normally removed from the tank before use.

11.4.7 *Procedure*:

11.4.7.1 Weigh a 0.3 g specimen cut from the molded part to ± 0.0002 g. Record the specimen weight as W_1 .

11.4.7.2 Cut a 35 by 76 mm (1.5 by 3 in.) piece of 100-mesh stainless steel screen for each specimen. Clean the screen with o-xylene, rinse with acetone, and dry in a stream of air.

11.4.7.3 Fold the screen to form a 38 by 38 mm (1.5 by 1.5 in.) square. Make a fold about 6.4 mm (1/4 in.) along each of the two open edges to form a pouch, and staple the folds.

11.4.7.4 Place the specimen into the screen pouch, fold the remaining edge, staple the fold and identify each screen with a metal tag. Do not squeeze the pouch sides together. Leave space for the specimen to swell. Weigh the sample plus screen to ± 0.0002 g and record this weight as W_2 .

NOTE 7—An alternative specimen holder is a reusable cage made from 100-mesh stainless steel screen as shown in Fig. 4 and Fig. 5. A size of 15.2 mm by 35.6 mm (0.6 in. by 1.4 in.) has been found satisfactory for the cage. The cages must be cleaned after each test by burning off remaining polyethylene at 427°C (800°F) for approximately 30 min in a muffle furnace.

⁹ The sole source of supply of this reagent known to the committee at this time is Cytec Industries, Inc., Five Garret Mountain Plaza, West Paterson, NJ 07424. If you are aware of alternative suppliers, please provide this information to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee,¹ which you may attend.

⁸ Suitable apparatus is available from many laboratory supply firms.

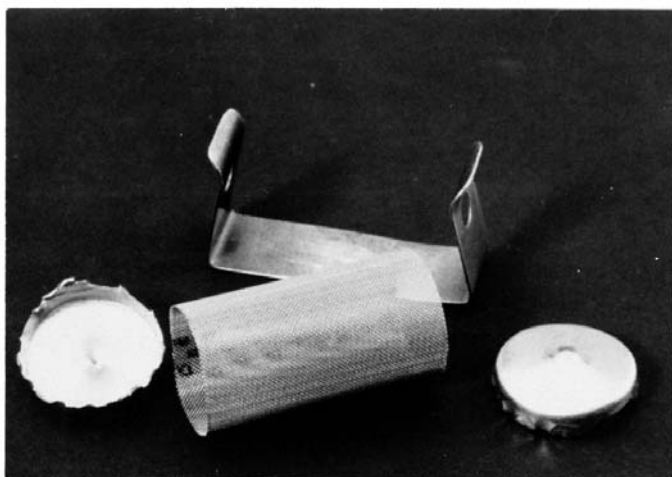


FIG. 4 Gel Cage

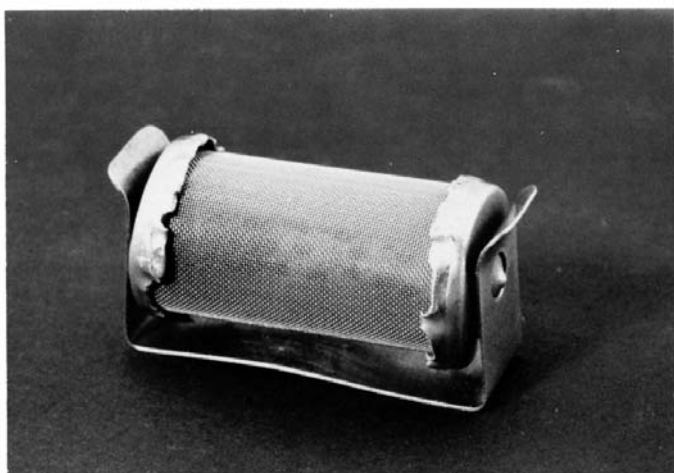


FIG. 5 Gel Cage

11.4.7.5 Place 1500 mL of o-xylene and 10 g of Cyanox 2246 or equivalent antioxidant in the resin kettle and heat to reflux.

NOTE 8—The antioxidant is added to prevent further crosslinking of the polymer during the extraction.

11.4.7.6 Suspend the sample screen in the refluxing solvent for 16 h. An overnight run is convenient.

NOTE 9—Do not test more than eight specimens per run to avoid saturating the solvent with dissolved polyethylene.

11.4.7.7 Remove the sample screen while hot and dry to constant weight (W_3) in a forced-draft oven at 170°C (338°F) for about two h.

11.4.8 Calculation:

$$\text{Gel Weight, \%} = \frac{[W_1 - (W_2 - W_3)] \times 100}{W_1} \quad (3)$$

where:

- W_1 = weight of sample, g,
- W_2 = weight of sample plus screen, g, and
- W_3 = weight of sample plus screen after extraction, g.

11.4.9 Report the Following Information:

- 11.4.9.1 Identification of the tank,
 - 11.4.9.2 Date of the test, and
 - 11.4.9.3 Percentage of gel determined in 11.4.8.
- 11.4.10 Precision and Bias:

11.4.10.1 Table 3 is based on a round robin conducted in 1989 in accordance with Practice E691, involving eight materials tested by seven laboratories. For each material, all the samples were prepared at one source, but the individual specimens were prepared at the laboratories that tested them. Each test result was the average of two individual determinations. Each laboratory obtained three test results for each material. (Warning—The following explanations of r and R are only intended to present a meaningful way of considering the approximate precision of this test method. The data in Table 3 shall not be rigorously applied to acceptance or rejection of material, as those data are specific to the round robin and are not necessarily representative of other lots, conditions, materials, or laboratories. Users of this test method shall apply the principles outlined in Practice E691 to generate data specific to their laboratory and materials, or between specific laboratories. The principles shown below would then be valid for such data.)

11.4.10.2 Concept of r and R —If S_r and S_R have been calculated from a large enough body of data, and for test results that were averages from testing two specimens:

(1) Repeatability, r —In comparing two test results for the same material, obtained by the same operator using the same equipment on the same day, the two test results shall be judged not equivalent if they differ by more than the r value for that material.

TABLE 3 Precision Summary—O-Xylene Insoluble Fraction (Gel)

Material ^A	Average	S_r ^B	S_R ^C	V_r ^D	V_R ^D	r ^E	R ^E
6	79.9605	2.4733	4.1864	3.1	5.2	6.9251	11.7219
5	81.9357	2.1598	3.4861	2.6	4.3	6.0475	9.7612
4	82.1852	1.2954	3.0863	1.6	3.8	3.6271	8.6415
1	84.1072	1.6594	2.9802	2.0	3.5	4.6462	8.3447
7	84.6600	2.0078	2.9978	2.4	3.5	5.6219	8.3938
8	85.4129	1.7201	3.2507	2.0	3.8	4.8164	9.1019
3	91.4138	2.9248	5.1655	3.2	5.7	8.1894	14.4633
2	92.5576	0.9363	1.8244	1.0	2.0	2.6217	5.1083
Average:				2.2	4.0		

^A The thicknesses of the molded samples from which the specimens were taken were as follows:

	in.	mm
6	>3/4	>19
5	>1/2	>13
4	>1/4	>6
1	1/4	6
7	>3/4	>19
8	1/4	6
3	1/2	13
2	1/4	6

The materials were the same for samples (2 and 3), (4, 5 and 6) and (7 and 8). Sample 1 was different from the others.

^B S_r is the within-laboratory repeatability and

^C S_R is the between-laboratory reproducibility

^D V_r and V_R are the coefficients of variation (standard deviation expressed as a percent of the average)

(2) *Reproducibility, R*—In comparing two test results for the same material, obtained by different operators using different equipment on different days, the two test results shall be judged not equivalent if they differ by more than the *R* value for the material.

(3) Any judgment in accordance with (1) or (2) would have an approximate 95 % (0.95) probability of being correct.

11.4.10.3 There are no recognized standards by which to estimate the bias of this test method.

11.5 *Visual Inspection*—The tank shall be visually inspected to determine such qualities as are discussed in the Workmanship Section.

11.6 *Water Test*—Each tank shall be hydrostatically tested by the supplier by filling the tank completely with water. The tank shall also be pre-tested at the time of installation by the user by filling the tank completely with water. Such a test also allows final inspection for proper installation of all fittings.

12. Marking

12.1 The tank shall be marked to identify the producer, date (month and year) of manufacturer, capacity, maximum specific gravity of tank design, serial number and Type I or Type II. The marking shall be permanent.

12.2 The proper caution or warning signs as prescribed by OSHA standard 29 CFR 1910.106 shall be affixed to the tank.

12.3 Tank capacity shall be based on the fluid level used to determine the minimum wall thickness as defined in 6.1.

13. Packing, Packaging and Marking

13.1 All packing, packaging, and marking provisions of Practice **D3892** shall apply to this specification.

14. Shipping

14.1 Since there are variations in methods of shipping and handling, the manufacturer's instructions shall be followed in all cases.

14.2 A suitable means shall be provided, if required, at the open end of open-top tanks to keep the loaded tank rigid.

14.3 All fittings and flange faces shall be protected from damage by covering with suitable plywood, hardboard or plastic securely fastened. Tanks shall be positively vented at all times.

14.4 Pipe and tubing, fittings and miscellaneous small parts shall be packaged. Loose items that scratch the interior surface shall not be placed inside the tank during shipment. Additional protection, such as battens, end wrapping, cross bracing, or other interior fastenings shall be used as required to assure such individual equipment pieces are not damaged in transit.

14.5 Upon arrival at the destination, the purchaser shall be responsible for inspection for damage in transit. If damage has occurred, a claim should be filed with the carrier by the purchaser. The supplier shall be notified if the damage is not first repaired by the fabricator prior to the tank being put into service. The purchaser accepts all future responsibility for the effects of the tank failure resulting from damage.

15. Keywords

15.1 polyethylene; tanks; upright

SUMMARY OF CHANGES

Committee D20 has identified the location of selected changes to this standard since the last issue, D1998 - 13, that may impact the use of this standard. (September 15, 2015)

(1) Revised Section 1.2 to clarify scope.

(2) Revised Section 1.3 to clarify service conditions outside the scope of this specification

(3) Added 3.2.2, Definition of knuckle radius

(4) Expanded 6.1 to clarify calculation of minimum wall thickness

(5) Corrected drawing describing Equation (1).

(6) Added 6.5 and discussion as a separate recommendation for bottom knuckle radius.

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