

# Steele Plastics, Inc

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## Specifications

### Fiberglass Fillet

#### SCOPE

This specification is intended to describe the minimum design and manufacturing requirements for Fiberglass Reinforced Plastic Sump Basin and Wetwell fillets supplied by Steele Plastics Inc.

#### REFERENCED STANDARDS

- ASTM D2583, Standard Test Method for Indentation Hardness of Rigid Plastics by Means of a Barcol Impressor.
- ASTM D3753, Standard Specification for Glass-Fiber Reinforced Polyester Manholes and Wetwells.
- AWWA C950, Fiberglass Pressure Pipe.

#### FILLET

A fiberglass fillet shall be installed in the bottom of the wet well. It shall extend up the wall of the tank, and shall extend into the diameter of the bottom of the wet well. It shall have a 1:1 slope. The fillet shall be attached to the wet well wall and bottom using polyester resin and fiberglass.

#### SIZES

6" X 6" fillet- 30", 36", 42", 48", 54", 60", 72".

12" x 12" fillet- 48", 54", 60", 72".

#### MATERIALS

**Resin:** Resins used shall be commercial grade unsaturated polyester type, suitable for the intended service as indicated by usage history or resin manufacturer's recommendation.

**Cure System:** Resin promotion and catalyst system used shall follow resin manufacturers' guidelines.

**Fillers and additives:** No fillers or resin extenders of any type shall be utilized. A maximum of two percent by weight of any commercial grade thixotropic agent may be added to resins for the purpose of viscosity control.

**Reinforcing Materials:** Reinforcing material shall be commercial grade "E" type glass fibers in the form of chopped strand mat, chopped roving, woven roving or continuous roving. Glass fibers shall be treated with a coupling agent that facilitates bonding between the reinforcement and the resin.

## **QUALITY ASSURANCE**

**Visual Acceptance:** The inner surface shall be free of exposed fiber, crazing and delaminations. No Blisters larger than 1/2 inch or wrinkles more than 1/8 inch in depth will be allowed.

**Laminate Cure:** Laminate cure shall be indicated by means of Barcol hardness measured in accordance with ASTM D2583. The average Barcol hardness shall not be less than 90 percent of the resin manufacturer's recommendation for clear resin castings.

**Workmanship:** All workmanship and materials throughout shall be of the highest quality available.

This fillet shall be as manufactured by Steele Plastics Inc, Conway Arkansas.