

Technical Data Sheet



HH Liner

Description: A single layer liner with a PVC (Polyvinyl Chloride) coating and a fillet and taped joint

Diameter Range: 4", 6", 8", 10", and 12"

Material: PVC (Polyvinyl Chloride)

Thickness Range: 3mm and 4.5 mm (other sizes available)

The liner thickness is the approximate installed thickness after removal of coating. To achieve the installed thickness in accordance with ASTM F1216 the combined curing pressure and fall of the pipe should not exceed the suggested inversion pressures show below:

- Inversion Pressure: .4 bar
- Curing Pressure: .4 bar
- Minimum Pressure: .31 bar
- Maximum Pressure (cold) .62 bar
- Maximum Pressure (warm/hot) .54 bar

Seam: Fillet.

Seam sealing: PVC tape.

Installation Method(s): Air or water inversion

Resin type: Silicate, epoxy, and polyester

Cure temperature/method: Ambient or hot water < 80°C / 176°F

Impregnation Method: Vacuum and pressure rollers set to a specified gap

Pinch gap roller setting: 8 mm or 11 mm depending on liner thickness

This information is provided in good faith only and without warranty. All calculations should be verified. The roller gap setting is for guidance only. We strongly recommend that the resin addition be monitored and controlled by adjustment of the roller gap setting. Ultimately, it is the correct resin addition/impregnation that is imperative, not the roller gap.

This liner should be visually inspected for defects before use. Inability to maintain a good vacuum during impregnation may indicate damage. On detection of any defect, the liner should not be used. This liner is only guaranteed when used with the limitations herein. Should it be necessary to use the liner in circumstances outside of these limits please contact us first for advice. We reserve the right to make technical changes without notice as a result of continuous development.

Notes:

- Can be used unsupported / without calibration tube.
- Used for a maximum bend radius of 45 degrees.
- Increase of liner length measurement for bends:
 - 45 degree turns add 1/2" for each 45 degree bend.
 - 90 degree turns add 3/4" for each 90 degree bend.

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