TECHNICAL DATA SHEET

MAXLINER®

MAX FLEX 4D

Polyurethane Coated Felt Liner

DESCRIPTION

Polyester fibre single layer flexible Liner with Polyurethane coating custom sized for pipe rehabilitation manufactured in accordance with ISO 9001:2015.

DIMENSION AVAILABILITY

	HOT CURE EVERSION	AMBIENT/WARM CURE EVERSION	HOT CURE DRAG-IN	AMBIENT/WARM CURE DRAG-IN
DIAMETER	75mm to 250mm	75mm to 250mm	75mm to 250mm	75mm to 250mm
THICKNESS	4.5mm	4.5mm	4.5mm	4.5mm
LENGTH	328 feet | 100 metres	328 feet | 100 metres	328 feet | 100 metres	328 feet | 100 metres
COATING WEIGHT	150 micron (Nominal)			
LINER DESIGN	Liner must be adequately supported to limit extension to the design diameter.			
	Liner features a stitched butt seam with welded seal tape.			
	Liner can negotiate pipe bends up to 90°.			

INSTALLATION METHODS

	RESIN TYPE		CURING REGIME				
	EPOXY	POLYESTER/ VINYL ESTER	HOT WATER <90°C	STEAM <90°C	AMBIENT	WARM WATER <50°C	WARM AIR ACCELERATED
HOT CURE EVERSION	✓	✓	✓	✓	✓	✓	✓
AMBIENT/ WARM CURE EVERSION	✓	✓	X	X	✓	✓	✓
HOT CURE DRAG-IN	✓	✓	✓	✓	✓	✓	✓
AMBIENT/ WARM CURE DRAG-IN	✓	✓	X	X	✓	✓	✓

Note: Liner must be supported outside the pipe.

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TEST SPECIFICATIONS

	CHARACTERISTIC	TEST	STANDARD
ROLL	Density and density distribution at various applied pressures.	Compression measured at increasing pressure.	ISO 845
	Load at break in machine and cross directions.	Tensile testing - Maximum Resistive Force.	ISO 1421
	Secant Modulus in machine and cross directions (resistance to stretch).	Tensile testing - Maximum Resistive Force vs Extension %.	ISO 1421
	Coating weight and distribution.	Samples weighed to determine distribution of coating in cross direction of the roll.	—
	Coating adhesion and ability to weld.	Peel strength of welded tape.	ISO 2411
LINER	Density, Gauge of liner under various applied pressures.	Compression test of sample of all layers.	ISO 845
	Felt weld strengths.	Each weld is sampled and destructively tested.	ISO 1421
	Sealing tape weld strengths.	Each weld is sampled and destructively tested.	ISO 1421

NOMINAL DIAMETER (MM)	TRANSITION DIAMETER (MM)	LINER THICKNESS (MM)	EVERSION PRESSURE (BAR)	CURING PRESSURE TO MEET NOMINAL DIAMETER (BAR)	CURING PRESSURE TO MEET TRANSITION DIAMETER (BAR)	RESIN AMOUNT (LITRE/M)	PPINCH ROLLER GAP (MM)
75	100	4.5	0.30	0.50	0.70	1.05	10—11mm
100	150	4.5	0.30	0.50	0.70	1.4	10—11mm
125	175	4.5	0.20	0.50	0.60	1.8	10—11mm
150	200	4.5	0.20	0.30	0.40	2.1	10—11mm
200	250	4.5	0.10	0.20	0.25	2.9	10—11mm
225	275	4.5	0.10	0.20	0.20	3.3	10—11mm
250	300	4.5	0.10	0.15	0.20	3.6	10—11mm

1. Suitable only for Applied Felts liners designed for and to be installed by eversion.
2. Roller gap setting is for guidance only. Impregnation equipment differs: Rubber wrappings on rollers, positional hysteresis and flexing of rollers cause roller gap settings to vary between different equipment. Roller gap setting for any given equipment should be reasonably repeatable.
3. We strongly recommend the resin addition be monitored and controlled by adjustment of the roller gap setting. Ultimately, it is the correct resin addition which is imperative, not the roller gap.
4. All information is provided by Applied Felts in good faith, but without warranty. All calculations should be verified.