Deutsches Institut für Bautechnik

DIBT

General Technical Approval

Approval Body for Construction Products & Types
Construction Engineering Inspection Body
Public-law agency jointly held by the Federal German Government and the German state governments

Member of EOTA, UEAtc and WFTAO

Date: **21 April 2016**

Reference no.: **III 54-1.42.3-29/15**

Approval No:

Z-42.3-466

Valid

from: **30 April 2016**

until: **30 April 2021**

Applicant:

Trelleborg Pipe Seals Duisburg GmbH
Dr. Alfred-Herrhausen-Allee 36
47228 Duisburg

Object of Approval:

General Technical Approval for the "epros®DrainLiner method" and the resin system "epros®EPROPOX FC30" for the rehabilitation of buried damaged sewer lines with nominal diameters from DN 100 to DN 250

The above object of approval is hereby granted general technical approval.
This General Technical Approval covers 31 pages and 33 appendices.
This General Technical Approval replaces the General Technical Approval No. Z-42.3-466 dated 8 December 2014

DIBt

DIBt | Kolonnenstrasse 30 B | D-10829 Berlin | Tel.: +49 30 78730-0 | Fax: +49 30 78730-320 | e-mail: dibt@dibt.de | www.dibt.de

Deutsches Institut für Bautechnik

DIBt

I GENERAL PROVISIONS

1 The General Technical Approval is proof of the usability or applicability of the object of approval for the purpose of the German Lands' building regulations.

2 Where the General Technical Approval calls for the specific expertise and experience of the persons commissioned to manufacture construction products and types according to the regional German state provisions as equivalent to § 17 (5) of the Reference Building Code (*Musterbauordnung*), it is important to note that such expertise and experience can also be proven by means of equivalent supporting documents from other member states of the European Union. This may also apply to equivalent supporting documents submitted under the Agreement on the European Economic Area (EEA) or other bilateral agreements.

3 The General Technical Approval shall be no substitute for the permits, consents and certificates statutorily prescribed for the implementation of building projects.

4 The General Technical Approval is granted without prejudice to any third-party rights including but not limited to private proprietary rights.

5 Manufacturers and distributors of the object hereof shall, notwithstanding any additional regulations laid down in the "Special Provisions" chapter, provide the user of said object with copies of the General Technical Approval and shall instruct the user to the effect that the General Technical Approval must be kept at the point of use or application. Copies of the General Technical Approval shall be provided to the authorities interested whenever requested by them.

6 The General Technical Approval may not be reproduced unless in total. Any publication of part of this Approval shall require the consent of the German Institute for Construction Engineering. Texts and drawings in advertising materials shall not be contradictory to the General Technical Approval. In case of conflict or difference between the German version and its English translation, the German version shall prevail. Translations of the General Technical Approval must contain the information that the "translation of the German original version has not been verified by the German Institute for Construction Engineering".

7 The General Technical Approval is granted subject to revocation. The provisions of the General Technical Approval may be amended by subsequent modifications and additions, especially where required by new technical findings.

II SPECIAL PROVISIONS

1 Object of approval and scope of application

This General Technical Approval applies to the "epros®DrainLiner Method" (Appendix **1**) for the rehabilitation of damaged sewer lines with circular cross sections in the nominal diameters from DN 100 to DN 250 with the liner tubes named "epros®DrainLiner", "epros®DrainFlexLiner", "epros®DrainPlusLiner" and "epros®DrainSteamLiner" along with the related two-component epoxy resin system named "epros®EPROPOX FC 30".

This General Technical Approval also applies to the "epros®DrainLCR Method" with the "epros®DrainLCR hat profile" and the resin systems specified in the General Technical Approvals No. Z-42.3-375, No. Z-42.3-385 and No. Z-42.3-468, as well as to the resin system "epros®EPROPOX FC30".

This Approval applies to the rehabilitation of sewer lines intended for the discharge of sewage as laid down in the standard DIN 1986-3[1].

The cured-in-place pipe lining (CIPP) method can be used for the rehabilitation of sewer pipes made of concrete, reinforced concrete, vitrified clay, asbestos cement, the plastic materials GRP, PVC, PE, PP, and cast iron, if the cross section of the sewer to be repaired meets the method-related requirements and structural stability needs.

Damaged sewer pipes are rehabilitated by the introduction and subsequent curing of a resin-wetted polyester needle nonwoven ("felt") tube. For this purpose, a polyester needle felt (PES) tube with a surrounding outside flexible polyvinylchloride (PVC) coating, or polyurethane (PUR) coating, or silicone (SK) coating, or polypropylene (PP) coating is wetted with a two-component epoxy resin (EP resin) on the job site.

The polyester needle felt tube is available in seven different film coating variants (Appendix 1 item 4):

Variant	a)	"epros®DrainLiner" from DN 100 to DN 250 PVC coated	(PVC film as introducing aid for the liner tube)
Variant	b)	"epros®DrainLiner" from DN 100 to DN 250 PP coated	(PP film as introducing aid for the liner tube)
Variant	c)	"epros®DrainFlexLiner" from DN 100 to DN 250 PP coated	(PP film as introducing aid for the liner tube)
Variant	d)	"epros®DrainPlusLiner" from DN 100 to DN 250 PUR coated	(PUR film as introducing aid for the liner tube)
Variant	e)	"epros®DrainPlusLiner" from DN 100 to DN 250 silicone coated	(SK film as introducing aid for the liner tube)
Variant	f)	"epros®DrainSteamLiner" from DN 100 to DN 250 PP coated	(PP film as component part of the liner tube)

[1] DIN 1986-3 Drainage facilities for buildings and properties – Part 3: Rules for operation and maintenance; issue 2004-11

In the CIPP closed-end method, the polyester needle felt tube is inverted into the damaged host sewer pipe by means of compressed air in connection with an inversion drum and is then cured by means of hot water (VARIANT 1) or steam (VARIANTS 2 and 3). For liner installation in the "water column" variant (VARIANT 4), the polyester needle felt tube is inverted into the host line using a head of water. The open-end lining method uses an additional calibration hose, which is inverted in a separate or simultaneous operation. Due to the inversion of the polyester needle felt tube, the PVC, PUR, SK or PP coating is turned to the inside facing the sewage flow. Air or water pressure is used to press the tube in a tight fit against the inner wall of the host pipe. The resin-wetted polyester needle felt tube is cured by means of hot water circulation.

In all cases, it is required to install a protective polyethylene tube (PE preliner) before inverting the resin-wetted polyester needle felt tube.

Waterproof reconnections of laterals in lines with nominal diameters between DN 100 and DN 200 are performed with the "epros®DrainLCR hat profile" using appropriate lining equipment ("epros®DrainLCR Packer") according to the General Technical Approvals No. Z-42.3-385, No. Z-42.3-375 and No. Z-42.3-468, or using other rehabilitation methods under valid general technical approvals. It is also possible to reconnect laterals by open construction.

Host pipe-to-manhole connections shall be made with swelling tapes (auxiliary material) to be installed prior to the introduction of the PE preliner. In areas where it is not possible to use swelling tapes, the waterproof connection between the liner and the manhole wall can instead be made in any of the following ways after the liner is cured:

a) Liner-to-manhole connection by application of a reaction resin having a valid general technical approval;

b) Liner-to-manhole connection by application of grout systems having a valid general technical approval;

c) GRP laminates;

d) Pressure injection of polyurethane (PU) or epoxy (EP) resins having a valid general technical approval;

e) Installation of liner end sleeves having a valid general technical approval.

2 Provisions related to method components

2.1 Properties and composition

The liner tubes mentioned in the foregoing Section 1 meet the requirements laid down in DIN EN ISO 11296-4[2], where appropriate, and have the specific properties and compositions mentioned below.

[2] DIN EN ISO 11296-4 Plastics piping systems for renovation of underground non-pressure drainage and sewerage networks -- Part 4: Lining with cured-in-place pipes (ISO 11296-4:2009, corrected version 2010-06-01); German version EN ISO 11296-4:2011; issue:2011-07

2.1.1 Materials of the method components in the "M" condition

2.1.1.1 Materials for the inversion tubes (Appendix **1**)

The materials of the polyester needle felt tube (PES tube), its coating made of PVC, PUR, SK or PP films, and the materials of the two-component epoxy resin system named "epros®EPROPOX FC30", inclusive of fillers, hardeners or other additives used, are in compliance with the formulation data kept with the German Institute for Construction Engineering (DIBt).

- The properties of the polyester needle felt (PES) tube include (Appendix **1**):

1. "epros®DrainLiner" from DN 100 to DN 250 – PVC or PP coated:

Mass per unit area:	Table **A** in Appendix **2**
PVC film thickness:	0.40 mm to 0.50 mm
PP film thickness:	0.30 mm to 0.40 mm

2. "epros®DrainFlexLiner" and "epros®DrainSteamLiner" from DN 100 to DN 250 – PP coated:

Mass per unit area:	Table **B** in Appendix **3**
PP film thickness "epros®DrainFlexLiner":	0.30 mm to 0.40 mm
PP film thickness "epros®DrainSteamLiner":	0.40 mm to 0.60 mm

3. "epros®DrainPlusLiner" from DN 100 to DN 250 – PUR or SK coated:

Mass per unit area:	Tables **C** and **D** in Appendix **4**, and Table **E** and **F** in Appendix **5**
PUR film thickness:	0.20 mm to 0.25 mm
SK film thickness:	0.20 mm to 0.60 mm

- The properties of the "epros®EPROPOX FC30" resin system include:

4. The epoxy component A of the two-component resin system "epros® EPROPOX FC30" has the following initial properties before application:

Density at +23°C:	approx. 1.15 g/cm³ ± 0.02 g/m³
Viscosity at +25°C after DIN EN ISO 3219[3]:	approx. 3,000 mPa x s ± 600 mPa x s

5. The hardener component B of the two-component resin system "epros®EPROPOX FC30" has the following initial properties before application:

Density at +23°C:	approx. 1.05 g/cm³ ± 0.02 g/m³
Viscosity at +25°C after DIN EN ISO 3219[2]:	approx. 800 mPa x s ± 160 mPa x s

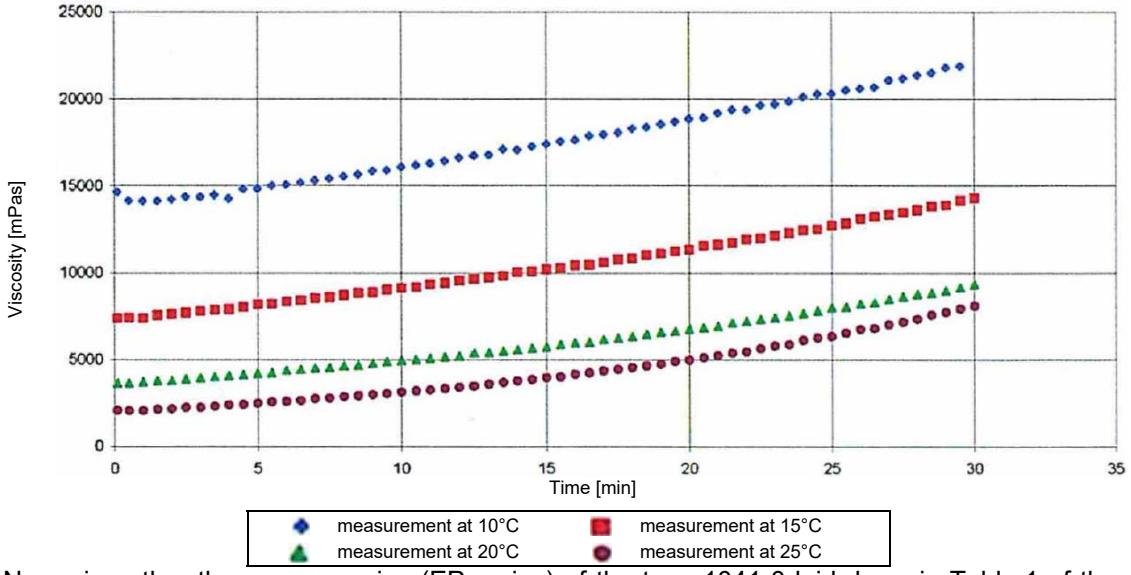
6. The epoxy resin system "epros®EPROPOX FC30", in the cured condition without the PU liner, has the following properties after DIN 16946-2[4], Table 1, type 1041-0:

Density at +25°C:	approx. 1.1 g/cm³
Flexural modulus:	approx. 3,000 N/mm²
Flexural stress σ_{fB}:	approx. 120 N/mm²
Tensile strength:	approx. 60 N/mm²
Elongation at tear:	> 5%
Curing time at +25°C or above:	≈ 2.5 h

[3] DIN EN ISO 3219 Plastics - Polymers/resins in the liquid state or as emulsions or dispersions - Determination of viscosity using a rotational viscometer with defined shear rate (ISO 3219:1993); German version EN ISO 3219:1994; issue: 1994-10

[4] DIN 16946-2 Reaction Resin Moulded Materials; Moulded Casting Resin Materials, Types; Issue: 1989-03

Chart 1: "Mixing viscosity "epros®EPROPOX FC30 (A+B)" "



No resins other than epoxy resins (EP resins) of the type 1041-0 laid down in Table 1 of the standard DIN 16946-2[4] shall be used, and they must conform to the formulation data and IR spectrums kept with the German Institute for Construction Engineering. The IR spectrums shall also be kept with the independent inspection body.

2.1.1.2 Materials for the “epros®DrainLCR Method” using the "epros®DrainLCR hat profile"

The materials for the "epros®DrainLCR hat profile" under the General Technical Approvals No. Z-42.3-375, No. Z-42.3-385, No. Z-42.3-468, as well as the resin systems "epros® EPROPOX HC120" and "epros®EPROPOX HC120+" conform to the formulation data kept with the German Institute for Construction Engineering like the properties and composition of the fibreglass-reinforced polyester as well as the silicate and epoxy resin systems inclusive of the fillers, hardeners or other additives used.

The resin systems conform to the IR spectrums kept with the German Institute for Construction Engineering. The IR spectrums shall also be kept with the independent inspection body.

2.1.1.3 Materials for the swelling tape (auxiliary material)

No materials other than extruded profiles made of a chloroprene (CR/SBR) rubber and water-absorbent resin shall be used for the swelling tape (auxiliary material) at the pipe/manhole interface (see Appendix **20**). The swelling tapes must provide a volume increase of no less than 100% after immersion in water during 72 hours.

2.1.2 Liner tube in the "I" condition

2.1.2.1 Wall thickness

Due to the general system design, the lining operations use resin-wetted liner tubes providing a minimum wall thickness of 3 mm after installation and cure (Tables 1 and 2).

Self-supporting sewer lines (structurally stable in themselves without being supported by surrounding soils), i.e. with no cracks in them (except for hairline cracks with widths less than 0.15 mm or, in case of reinforced concrete pipes, less than 0.3 mm), may be repaired with liners according to Tables 1 and 2 only in case the wall thickness will not fall below a minimum value of 3 mm and a nominal stiffness value of SN ≥ 500 N/mm² will be met. If the host pipe contains one or several continuous longitudinal cracks, it will be necessary to carry out soil investigations, e.g. by dynamic penetration tests, and to furnish calculations as appropriate proof. In infiltration cases, the liner must be dimensioned to its deformation and deflection (buckling) behaviour.

In case the host pipe-soil system is no longer self-supporting, such sewer lines may be relined with CIPP liners of the wall thicknesses specified in Tables 1 and 2 only if a structural design calculation according to DWA-A 142-2[5] is furnished as proof of the liner's ability to withstand the structural loads acting on it.

The calculations for the initial ring stiffness SR of the cured liner must take into account the wall thicknesses given in Tables 1 and 2.

Table 1: Minimum wall thicknesses of the cured liner and nominal stiffness SN [N/m²] [1)]

Outer diameter	Wall thickness			
	3.0 mm	**3.5 mm**	**4.5 mm**	**6.0 mm**
100 mm	7,272.59	11,729.05	25,719.84	–
125 mm	3,655.32	5,876.46	12,803.16	–
150 mm	2,089.55	3,352.22	7,272.59	17,783.08
200 mm	868.17	1,389.18	2,998.04	7,272.59
225 mm	606.66	969.89	2,089.55	5,055.48
250 mm	440.47	703.71	1,513.99	3,655.32

1) SN and SR calculated with short-term modulus of elasticity E = 2,950 N/mm² after DIN EN 1228

Table 2: Minimum wall thicknesses of the cured liner and initial specific ring stiffness values SR [N/mm²] [1)]

Outer diameter	Wall thickness			
	3.0 mm	**3.5 mm**	**4.5 mm**	**6.0 mm**
100 mm	0.058	0.094	0.206	–
125 mm	0.029	0.047	0.102	–
150 mm	0.017	0.027	0.058	0.142
200 mm	0.007	0.011	0.024	0.058
225 mm	0.005	0.008	0.017	0.040
250 mm	0.004	0.006	0.012	0.029

2) SN and SR calculated with short-term modulus of elasticity E = 2,950 N/mm² after DIN EN 1228

The following relationships apply to nominal stiffness SN and initial specific ring stiffness SR:

For SN:

$$SN = \frac{E \cdot s^3}{12 \cdot d_m^3}$$

(SN = nominal stiffness following DIN 16869-2[6])

For SR:

$$SR = \frac{E \cdot s^3}{12 \cdot r_m^3}$$

(r_m=radius of centre of gravity)

For the groundwater load case, the CIPP liner shall be dimensioned in terms of buckling according to DWA-A 143–2[4] (refer also to Section 9).

The CIPP liner has always a three-layered wall structure, which comprises the protective PE film, the polyester fibre layer and the PVC, PUR, SK or PP film (Appendix **1**).

5 DWA-A-143-2 German Association for Water, Wastewater & Waste (DWA) – Worksheet No. 143 – Rehabilitation of Drain and Sewer Systems Outside Buildings – Part 2: Structural Calculations for the Rehabilitation of Drain and Sewer Systems with Relining and Assembly Methods; issue: 2015-07

6 DIN 16869-2 Pipes of glass fibre reinforced polyester resin, wound, filled – Part 2: General quality requirements; testing; issue: 1995-12

2.1.2.2 Physical characteristics of the cured polyester fibre/resin composite

The polyester fibre layer wetted with resin and hardener (without preliner and inner coating) must provide the following characteristic values after final cure:

- Density after DIN EN ISO 1183-2[7]: 1.18 g/cm³ ± 5%
- Circumferential modulus of elasticity after DIN EN 1228[8]: ≥ 2,950 N/mm²
- Short-term flexural modulus after DIN EN ISO 11296-4[2] or DIN EN ISO 178[9] ≥ 2,600 N/mm² (radial)
- Flexural stress σ_{fB} after DIN EN ISO 11296-4[2] or DIN EN ISO 178[9]: ≈ 54 N/mm²

2.1.2.3 Characteristics of the cured polyester fibre/resin composite from thermal (DSC) analysis)

The cured polyester fibre/resin composite provides the following limit values as determined by means of Differential Scanning Calorimetry (DSC).

Glass transition temperature T_{G1} (actual condition of the reaction resin system; first heating phase)

≥ +45 °C

Glass transition temperature T_{G2} (resin system in its fully cured condition; second heating phase)

≥ +102 °C

2.1.3 Environmental compatibility

The construction product meets the requirements of the DIBt principles “Assessment of the impact of construction products on soils and groundwater” (Issue: 2011). This statement applies only in case the Special Provisions of this General Technical Approval are observed.

The requirement to obtain approval from the competent water authorities, especially in protected water zones, shall not be affected thereby.

2.2 Manufacture, packaging, transport, storage and identification

2.2.1 Manufacture

2.2.1.1 Industrial manufacture of liner tubes

The polyester needle felt tubes with the minimum wall thicknesses mentioned in Section 2.1.2.1 shall be manufactured with an outer flexible PVC, PUR, SK or PP film in the sub-supplier’s factory. The Applicant shall check to make sure the specified lengths and wall thicknesses are observed by the sub-supplier.

The Applicant shall cause the sub-supplier to submit test reports according to DIN EN 10204[10] for each delivery as appropriate proof of the characteristics of the resin and the hardener, the fillers or other additives.

---

7 DIN EN ISO 1183-2 Plastics -- Methods for determining the density of non-cellular plastics -- Part 2: Density gradient column method (ISO 1183 2:2004); German version EN ISO 1183-2:2004; issue:2004-10

8 DIN EN 1228 Plastics piping systems – Glass-reinforced thermosetting plastics (GRP) pipes – Determination of initial specific ring stiffness; German version EN 1228:1996; issue:1996-08

9 DIN 1EN ISO 178 Plastics – Determination of flexural properties (ISO 178:2010); German version EN ISO 178:2010, issue: 2011-04

10 DIN EN 10204 Metallic Products – Types of Inspection Documents; German version EN 10204:2004; issue:2005-01

The following properties shall be checked during the incoming goods inspection:

Properties of the resin:

– Density
– Viscosity

2.2.2 Packaging, transport, storage

The polyester needle felt tubes with a one-sided coating as delivered by the sub-supplier shall be stored in the premises of the Applicant in a way to ensure the tubes will not be damaged.

The components delivered by the sub-supplier for resin impregnation on the job site shall be stored until further use in suitable and separate hermetically closed containers in the premises of the Applicant. The storage temperature must range between approx. +15°C and approx. +25°C. The shelf life for the epoxy resin and the hardener is 12 months after delivery and shall not be exceeded. The containers shall be protected from direct sunlight. They shall be designed such that the epoxy resin and the hardener as well as the silicate resin are kept in separate entities.

The usage amounts of each component as required for the rehabilitation jobs shall be withdrawn from the storage containers and then transported in safe, separate and hermetically closed receptacles to the given place of application. There, said transport containers must be protected from weather. The polyester needle felt tubes shall be transported in suitable containers so as to ensure they are not damaged.

The relevant rules and regulations of accident prevention as well as the instructions given in the Applicant's method statement shall be observed during storage and transport.

2.2.3 Identification

The polyester needle felt tubes and the transport containers of the resin components shall be identified with the compliance mark (Ü mark) in accordance with the applicable compliance and conformity regulations, inclusive of the Approval number Z-42.3-466. Said identification is subject to the condition that the requirements set forth in Section 2.3 Proof of Compliance have been met.

Additionally, the transport containers of the polyester needle felt tubes shall provide the following information:

– Nominal diameter
– Length
– Batch number
– PVC, PP, SK or PUR film coatings
– Reference to PP film as liner part component

In addition, the transport containers for resins, hardeners and other additives shall be identified with the following minimum information:

– Resin designations
– Component designation
– Temperature range
– Quantity contained (volume or weight)
– Where required: hazard symbol according to the hazardous substance regulation

2.3 Proof of Compliance

2.3.1 General

The confirmation that the method components are in compliance with the provisions of this General Technical Approval must be provided for each manufacturing factory by means of a Compliance Certificate based on in-house production control and regular third-party inspection including initial testing of the method components subject to the following conditions.

For obtaining the Compliance Certificate and for third-party inspection including the related product tests, the manufacturer shall commission a generally accepted certification body as well as an accredited inspection body.

To confirm the issuance of a Compliance Certificate, the manufacturer shall identify the construction products with the compliance mark (Ü mark) while indicating the purpose of use.

The certification body shall provide one copy of its Compliance Certificate to the German Institute for Construction Engineering for information purposes.

In addition to that, the German Institute for Construction Engineering shall be given for information a copy of the initial test report.

2.3.2 In-house production control

Every manufacturing factory shall implement and carry out in-house production control. In-house production control shall mean the continuous inspection or monitoring of the production by the manufacturer to ensure that the construction products made by the manufacturer comply with the provisions of this General Technical Approval.

In-house production control should include the following minimum requirements:

– Description and inspection of the base material

  For each delivery of the incoming components, which are PVC, PUR, SK or PP films, PE preliner, polyester fibre, resin, hardener and other additives, the operator of the manufacturing plant shall check and make sure the properties required under Section 2.1.1 are met.

  For this purpose, the operator of the manufacturing plant shall cause each of the sub-suppliers to submit certificates of compliance 2.1 according to DIN EN 10204[10]. In addition, the incoming goods inspection shall include a random check verifying the properties specified in Section 2.1.1.1 hereof in accordance with the methods kept with the German Institute for Construction Engineering.

– Checks and inspections to be performed during manufacture:

  It is to be checked that the requirements laid down in Section 2.2.1 are fulfilled.

– Inspection of containers:

  Check every resin batch for meeting the identification requirements set forth in Section 2.2.3.

The results of in-house production controls shall be recorded. The records shall contain at least the following information:

– Designation of the construction product or of the base product and its components
– Type of control or inspection
– Date when the construction product or base material was manufactured and inspected
– Result of the control checks and inspections and, where appropriate, comparison with the requirements
– Signature of the person responsible for in-house production control

The records shall be kept for at least five years and submitted to the external inspection body commissioned for third-party inspection. On request, they shall be submitted to the German Institute for Construction Engineering and to the competent supreme building inspection authority.

If the inspection result is not satisfactory, the manufacturer shall immediately take the actions required for correcting the defect. Non-conforming construction products shall be handled in a way to ensure no confusion with conforming products is possible. Once the defect has been corrected, the failed test or inspection shall be repeated immediately – where technically feasible and required for proving the success of the corrective action.

2.3.3 Third-party inspection

In every manufacturing plant, the in-house production control system shall be inspected and verified by an external body at regular intervals, but at least twice a year.

The scope of third-party inspection includes an original inspection (initial testing) of the method components. In-house production control shall be performed on the basis of random checks within the scope of third-party inspection. The control checks shall verify compliance with the requirements under Sections 2.1.1 and 2.2.3.

Furthermore, there shall be random checks for compliance with the manufacturing requirements laid down in Section 2.2.1. These include the verification of curing behaviour, density, storage stability, and mass per unit area, as well as IR spectroscopies.

In each case, the accredited inspection body is responsible for sampling and testing. During third-party inspection, the certificates of compliance 2.1 according to DIN EN 10204[10] shall be verified, too.

The results of the certification and third-party inspection processes shall be kept for no less than five years. If so requested, they shall be submitted by the certification body or the inspection body to the German Institute for Construction Engineering and to the competent supreme building inspection authority.

3 Provisions for the design

The necessary pipeline data shall be verified, e.g. routing, depth, position of laterals, manhole depths, groundwater, pipe joints, hydraulic conditions, inspection holes, cleaning intervals. Existing video takes must be analyzed for application-specific evaluation. The correctness of the data must be verified on the job site. The condition of the existing sewer line of the property drainage system must be assessed in terms of the applicability of the lining method.

The hydraulic capacity of the sewer lines shall not be affected by the installation of a liner. If necessary, appropriate proof shall be furnished.

4 Provisions for the performance of the work

4.1 General

The cured-in-place pipelining “epros®DrainLiner Method” can be applied in the following construction conditions:

a) From the start to the end point

b) From the start to the end point through an intermediate manhole

c) From the start point down into a pipe run for a defined length with no further manhole or access point being needed

d) Lateral connections, from the start point down to the main line/lateral interface or from the main line start point to the line/lateral interface.

The start or end points can be a manhole, an inspection or cleaning hole, or an open pipe socket. The basic condition is that the size of the opening is sufficient for accommodating the inversion fitting of the inversion plant.

Also, it is possible to cross several manholes in between a start point and an end point, including manholes with directional changes of the invert. The “epros®DrainLiner”, "epros®DrainFlexLiner" and the “epros®DrainSteamLiner”, as well as the “epros®DrainPlusLiner” are able to reline manhole invert bends up to 45 degrees. Line bends up to 90 degrees can be relined with the “epros®DrainPlusLiner”.

Wrinkles, if any, shall never exceed the values specified in DIN EN ISO 11296-4[2].

The waterproof relining of laterals (see Appendices **15** to **18**) using the “epros®DrainLCR hat profile” in lines with nominal diameters between DN 100 and DN 200 shall be performed from inside the renovated line with the lining device (“epros®DrainLCR packer”) and the resin systems of the General Technical Approvals No. Z-42.3-385, No. Z-42.3-375, No. Z-42.3-468 and/or with the resin system “epros®EPROPOX FC30”, or with other relining methods having valid general technical approvals, or by open construction.

The Applicant shall prepare and provide to the installer a manual describing each of the steps to be carried out according to the type of performance of the lining method.

The Applicant shall also ensure the installers are sufficiently familiarised with the method. Sufficient technical knowledge can be documented for the installer company by means of an appropriate quality mark of the German Association for Sewer Construction Quality Protection *Güteschutz Kanalbau e.V.*[11].

4.2 Equipment and installations

4.2.1 Minimum needs in equipment, components and installations required for implementing the lining method:

- Equipment for sewer cleaning operations
- Equipment for service flow management
- Equipment for sewer inspection (DWA-M 149-2[12])
- Installations for lining operations:
  - Polyester needle felt tubes in the correct nominal diameters (Appendix **1**) (“epros®DrainLiner”, “epros®DrainFlexLiner”, “epros®DrainPlusLiner”, and/or “epros®DrainSteamLiner”)
  - Heat and pressure-resistant calibration hoses according to the nominal diameter
  - Protective polyethylene films (PE preliners) according to the nominal diameter
  - Containers with resin and hardener of the resin system "epros®EPROPOX FC30"
  - Equipment for dosing and mixing the resin system (Appendix **19**)
  - Weatherproof impregnation point (table with belt conveyor or roller table and pinch roller system) with exhaust system where required (Appendix **19**)
  - Vacuum system (Appendix **19**)
  - Heat and pressure-resistant pressure hoses for connection to the "epros®InversionDrum", according to the given nominal diameter

11 Güteschutz Kanalbau e.V.; Linzer Str. 21, Bad Honnef, phone: (02224) 9384-0; fax: (02224) 9384-84

12 DWA-M 149-2 German Association for Water, Wastewater & Waste (DWA) – Information Sheet 149: Inspection and Assessment of the Condition of Drain and Sewer Systems Outside Buildings. Part 2: Coding system for optical inspection: issue: 2006-11

- "epros®LinerEndCap"
- Inflatable "epros®PipePlugs", or stop discs, for the given nominal diameters
- Inversion bends and/or "epros®InversionFittings" for the given nominal diameters
- Supporting (sampling) pipes or tubes for obtaining samples on the job site (for the given nominal diameters)
- Power generating set
- Water supply
- Power supply
- Containers for residual waste
- Temperature sensors
- Temperature monitoring and recording device
- Small equipment such as pneumatic cutting tools
- Pneumatic drill
- Hand tools, ropes
- Social and sanitary rooms, where required

4.2.2 Additional components, equipment and installations required for the "hot water cure method":

- "epros®HWB" & "epros®HotBox" hot water units and accessories for hot water cure
- Control devices for the flow and return water temperatures
- "epros®InversionDrum" (VARIANT 1; Appendix **6**) with pressure monitoring device and hot water connection
- Inversion pipe, rig, cold water hose, suction line, hydrant connection, and accessories for the "water column" (VARIANT 4; Appendix **9**)
- Inversion cone or ring, or optionally stop rods

4.2.3 Additional components, equipment and installations required for the "steam cure method":

- "epros®SteamGen" steam generator with "epros®SteamTelemetry" (semi-automatic control) and/or "epros®SteamMixingLance" (hand control) and accessories for steam cure
- "epros®InversionDrum" (VARIANTS 2 and 3; Appendices **7** and **8**) with pressure monitoring device and steam connection
- Steam temperature monitoring devices
- Pressure gauge
- Steam outlet
- Compressor, air hoses, air pressure regulator
- If required: blind plugs in the range between DN 100 and DN 250 (steam inlet plugs)

Any electrical equipment to be introduced into the pipe such as CCTV cameras (or so-called crawlers) must be in compliance with the VDE regulations.

4.2.4 Minimum needs in components, equipment and installations required for the lining of lateral connections with the "epros®DrainLCR Method" in addition to the items mentioned in Section 4.2.1:

- "epros®DrainLCR hat profile" in the given nominal diameters
- Lining equipment ("epros®DrainLCR packer") and accessories (Appendix **15**).
- Containers with resin and hardener of the resin systems "epros®EPROPOX HC60" according to the General Technical Approval No. Z-42.3-375 and/or "epros®ResinType W01" and/or "epros®ResinType W1" and/or "epros®ResinType S" according to the General Technical Approval No. Z-42.3-385 and/or "epros®EPROPOX HC120 and HC120+" according to the General Technical Approval No. Z-42.3-468 and/or "epros®EPROPOX FC30"
- Locking air push rods (Variant a))
- Carriage (Variant b))
- Camera, control unit with monitor screen
- Lifting gear

4.3 Performance of lining work

4.3.1 Preparatory operations (see Appendices 27 to 29)

Before starting the lining job, it is imperative to ensure the sewer to be renovated is out of service; if necessary, the service flow shall be stopped by inflatable pipe plugs and be bypassed. The sewer to be relined shall be cleaned such that the existing defects can be clearly seen on the monitor. Obstacles are to be removed where necessary (e.g. root intrusions, protruding laterals etc.). For the removal of such obstacles, it is important always to use appropriate tools to ensure the existing sewer will suffer no additional damage.

The rules and regulations of accident prevention applicable to the lining method shall be observed.

No CIPP method equipment to be introduced into the defective sewer section shall be used unless or until it has been ensured by appropriate inspection that there are no inflammable gases in the host sewer section.

More specifically, the relevant sections of the following codes and regulations shall be complied with:

– GUV-R 126[13] (previously GUV 17.6)
– DWA-M 149-2[12]
– DWA-M 199-1 and DWA-A 199-2[14]

The job data stated in Section 3 shall be verified on the job site to make sure they are correct. The pipe run to be relined shall be cleaned with usual high-pressure cleaning equipment (jetters) to the extent necessary to perfectly see the pipe defects on the monitor during the optical inspection according to the Information Sheet DWA-M 149-2[12].

Specifically, where steam generators and steam cure equipment are used, the Machinery Safety Act and the Steam Boiler Ordinance shall be observed.

---

[13] GUV-R 126 Safety rules: Work in confined spaces of wastewater facilities (previously GUV 17.6); issue: 2008-09

[14] DWA-A 199-1 German Association for Water, Wastewater & Waste (DWA) – Worksheet 199: Service and Operating Instructions of the Personnel of Waste Water Systems Part 1: Service Instructions for the Personnel of Wastewater Systems; issue:2011-11

DWA-A 199-2 German Association for Water, Wastewater & Waste (DWA) – Worksheet 199: Service and Operating Instructions of the Personnel of Waste Water Systems Part 2: Operating Instructions for the Personnel of Sewerage Systems and Stormwater Treatment Facilities; issue:2007-07

When persons are sent down into manholes of sewer lines to be renovated as well as in all steps of the lining method, the relevant rules and regulations of accident prevention shall be complied with.

The steps required for the operation of the method shall be recorded for each impregnation and each lining job using the report forms shown in the Appendices **29** to **32**.

4.3.2 Inspection of incoming method components on the job site

The transport containers of the method components shall be checked for proper identification as specified in Section 2.2.3. The circumference of the polyester fibre tube as referred to the host pipe size shall be checked before the tube is wetted with resin. Also, it must be checked that the pre-impregnation storage temperature is maintained between +15°C and +25°C.

4.3.3 Placement of supporting pipes and tubes

Prior to the introduction of the PE preliner, it may be necessary to position supporting (sampling) pipes or tubes as an extension of the sewer line to be renovated, or in the region of intermediate manholes, to allow final samples to be taken there at the end of the lining job and to protect the liner from excessive elongation.

4.3.4 Installation of the PE preliner

Before inversion of the liner tube, a PE preliner must always be installed. The preliner shall be introduced into the host sewer line such that damages are avoided. It is introduced by inversion into the host pipe with the help of the "epros®InversionDrum" (VARIANT 1, VARIANT 2, and VARIANT 3) by means of compressed air, or by means of a water head (VARIANT 4). The preliner may also be pulled in place. The swelling tapes to be installed for creating a watertight seal at the liner connection points shall be positioned in the region of the pipe-to-manhole interfaces during the introduction of the preliner (see Appendix **20**).

4.3.5 Impregnation of the polyester needle felt tube

4.3.5.1 Epoxy resin mixture for the "epros®DrainLiner", "epros®DrainFlexLiner", "epros®DrainPlus Liner" and "epros®DrainSteamLiner"

The resin amount required for wetting a given polyester needle felt tube shall be determined according to the liner material, diameter, wall thickness and length before the resin is mixed (see Appendix **21**).

The mixing ratio between the epoxy resin and the hardener is 100:33 kg by weight, or 100:35 Litres by volume (see Appendices **22** and **23**). Once the container has been opened, the full amount of hardener must be added immediately to the resin. A double stirrer (electrically or air-operated) shall be used to uniformly mix the hardener component with the epoxy resin without bubbles in the resin container. An automatic dosing and mixing unit shall be used in case of usage amounts of approx. 80 Litres or more for the "epros®EPROPOX FC30" resin system.

Resin and hardener usage amounts as well as the temperature conditions shall be recorded in the report according to Section 4.3.1.

A sample shall be taken from every resin batch to verify and report its reactivity.

4.3.5.2 Wetting with resin

The polyester needle felt tube shall be unrolled and placed on the conveyor table, or suspended from appropriate installations, in the weatherproof or air-conditioned room, or CIPP truck. Each component must be thoroughly mixed in itself before the components are mixed together. The mixing temperature shall never fall below ≥ +15°C. For better wetting, it is necessary to remove most of the air contained in the polyester needle felt tube. An appropriate negative pressure of approx. 0.5 bar in the polyester needle felt tube can be achieved by means of the following methods:

1. In case of short lengths, a vacuum incision shall be cut in the top coating at the end of the liner tube. Never cut the seam area. Three incisions of about 15 mm shall be made. They shall be in the coating only and will receive the suction cup of the vacuum unit.
2. For greater lengths or liner diameters, vacuum incisions shall be made at intervals of 7 m to 10 m in the top coating, but not in the seam area. Three incisions of some 15 mm shall be cut in the coating only. The cuts not used for the moment shall be covered with an adhesive tape. Later on, those additional cuts will be taped.

   Then the liner tube shall be folded into a “Z” shape. A weight shall be placed onto the “Z”-fold to press it down. This helps negative pressure build up between the folded liner and the suction cups. Another Z-fold shall be made downstream of every suction cup with a weight being placed on it. The open end of the liner shall be placed on the impregnation table and the resin mixture shall be poured into it. To achieve uniform distribution of the resin inside the polyester needle felt tube, the liner shall then be passed through a pinch roller system. For this purpose, the liner tube shall be placed under the pressing rollers. The nip shall be set to twice the wall thickness of the liner tube plus 2 mm. The relevant operating and maintenance instructions shall be available and observed for this operation.

   The feed line speed shall be selected so as to achieve uniform distribution of the resin in the matrix of the polyester needle felt tube. The line speed of the impregnation process depends on the suction or penetration behaviour of the resin mixture. Should the distribution of the resin be visibly inhomogeneous, it might be useful to pass the liner again through the pinch rollers with a narrower nip setting.

   For less friction during the following inversion step and for avoiding unnecessary temperature increases, the impregnated liner tube coming from the pinch rollers shall immediately be folded into a container with a biodegradable lubricant in a way to ensure the folds will not damage the PVC, PP, SK or PUR film.

   The cure time and the temperature curve shall be recorded in a report according to Section 4.3.1 both for closed-end inversion and for open-end inversion.

4.3.6 Inversion of the resin-wetted polyester needle felt tube

4.3.6.1. VARIANT 1: Pressurised inversion by means of inversion drum and hot water cure (Appendix **6**)

Once the impregnation process is complete, the end of the liner tube together with the control tape shall be tied up (to form the “liner head”) and wound into the inversion drum. For inversion, the still open end of the liner tube shall be passed through the inversion tube to be connected to the inversion drum. This is done by means of a pull rope. The tube end shall be clamped to the pre-mounted “epros®InversionFitting” or epros®InversionBend”.

4.3.6.1.1 Inversion according to the closed-end method (Appendix **10**)

Step 1: Inversion by inversion drum

The "epros®InversionFitting" or "epros®InversionBend" shall be introduced with the liner end first into the start manhole or inspection hole and positioned at the beginning of the host pipe, at the PE preliner if any. Then the inversion pressure indicated in the Appendices **22** to **26** shall be applied to the inversion drum, depending on the given liner diameter and wall thickness. This pressure causes the liner tube to be inverted. The inversion process continues until the final manhole or inspection hole or end point of the defective sewer line is reached. As a result of this process, the resin-wetted interior side of the liner tube enters into contact either with the interior side of the PE preliner or directly with the inner surface of the sewer pipe to be relined. So the PVC, PUR, SK or PP film is turned to the side of the service flow.

Step 2: Hot water cure

While the liner tube is filled with water, the compressed air shall be removed slowly at the inversion drum to prevent the total pressure from increasing in the liner. The liner shall be completely filled with water via the hot water / boiler system connected to the inversion drum in order to maintain the close fit to the inner wall of the host pipe. The hot water produced in the boiler shall be delivered via a pump in the heating circuit (Appendix **6**). The circulating water shall be heated up to approx. +70°C in the flow line. The flow and return temperatures in the heating circuit as well as the temperature between the liner and the inner surface of the host pipe (at the start, intermediate and end points) shall be measured and recorded at the bottom level (lowest point) during the entire cure period. The curing times given in Tables **3** shall be observed. At the end of the cure (heating period), the temperature of the water and thus of the liner shall be reduced to approx. +20°C by the addition of cold tap water. When said temperature is reached, the water shall be drained. The curing times for the "epros®DrainLiner"", "epros®DrainFlexLiner", "epros®DrainPlusLiner" or "epros® DrainSteamLiner" (see Table 3) depend on the specific epoxy resin system according to Section 2.1.1.1 and on the prevailing ambient temperatures. The cure time and the applied pressure shall be recorded during the entire curing period.

4.3.6.1.2 Inversion according to the open-end method (Appendices **11** to **13**)

Step 1: Inversion by inversion drum

Where the lining job run from a start manhole or an inspection hole towards an inaccessible main line (or collector), the liner length must be determined in advance so that the liner will not protrude into such main line. The end of the liner tube must be closed with a Teflon tape or an elastic rubber band before the liner is wound up into the inversion drum.

The liner tube such closed shall be wound into the inversion drum. The next operations are the same as those described in sub-section 4.3.6.1.1 at Step 1.

At the end of the air-supported inversion process, the Teflon tape or rubber band will get loose and release the inner pressure of the liner. At this point, the liner does not enter into contact with the inner surface of the host pipe, or PE preliner installed before.

The liner tube shall be detached from the "epros®InversionFitting" or "epros®InversionBend". A calibration hose with a connected heating hose and control tape shall be wound into the inversion drum. The opposite end of the calibration hose shall be attached to the "epros®InversionFitting" or "epros®InversionBend". Then the calibration hose shall be inverted at the same pressure level as mentioned at 4.3.6.1.1 Step 1. The calibration hose forces the liner against the inner wall of the host pipe or PE preliner in a close and tight fit.

Step 2: Hot water cure

The same operations as those mentioned at 4.3.6.1.1 Step 2 shall be performed.

After final cure and completion of the cooling-down phase, the water shall be drained and the calibration hose shall be removed.

4.3.6.1.3 Inversion with open end and "epros®LinerEndCap" (open-end method, Appendix **14**)

Step 1: Inversion by inversion drum

Where the lining job runs from an entry manhole or inspection hole towards an inaccessible main sewer, the liner length must be determined in advance to prevent the liner from protruding into the sewer. The end of the liner tube shall be closed with the "epros®LinerEndCap" before the liner is wound up.

The liner tube such closed shall be wound into the inversion drum. The next operations are the same as those described in sub-section 4.3.6.1.1 at Step 1.

At the end of the air-supported inversion process, the "epros®LinerEndCap" will get loose and release the pressure from inside the liner. At this point, the liner is not yet in contact with the inner surface of the host pipe, or PE preliner installed before.

The liner tube shall be detached from the "epros®InversionFitting" or "epros® InversionBend". A calibration hose with a connected heating hose and control tape shall be wound into the inversion drum. The opposite end of the calibration hose shall be attached to the "epros®InversionFitting" or "epros®InversionBend". Then the calibration hose shall be inverted at the same pressure level as that mentioned at 4.3.6.1.1 Step 1. The calibration hose forces the liner against the inner wall of the host pipe or PE preliner in a close and tight fit.

Step 2: Hot water cure

The same operations as those described at 4.3.6.1.1 Step 2 shall be performed.

After final cure and completion of the cooling-down phase, the water shall be drained and the calibration hose shall be removed.

4.3.6.2. VARIANTS 2 and 3: Pressurised inversion by means of inversion drum and steam cure (Appendix **7** and Appendix **8**)

4.3.6.2.1 Inversion with closed end and heating hose (Appendix **7**) (closed-end method, Appendix **10**)

Step 1: Inversion by inversion drum

The same operations as those described at Section 4.3.6.1.1 Step 1 shall be performed.

Instead of the tied-up end of the liner, a heating hose shall be attached to the end of the liner tube and shall be inverted together with the liner tube. The heating hose shall be connected with the service window of the inversion drum.

Step 2: Steam cure

The curing pressure shall be kept constant at the values specified in the Appendices **22** to **26** by means of compressed air via the "epros®Steam Telemetry" (semi-automatic control) or "epros®SteamMixingLance" (hand control). The steam generator shall be started and, after the appropriate heating-up period, shall be connected to the "epros®SteamTelemetry" or "epros® SteamMixingLance" unit. The temperature shall be increased continuously by adding the appropriate amount of steam via the "epros®SteamTelemetry" or "epros®SteamMixingLance". The steam/air mixture shall exit the system through the start manhole or start point. The flow rate shall be controlled with the help of a ball valve fitted to the inversion drum. The pressure and the temperature shall be kept constant. The maximum steam/air temperature of +100°C shall never be exceeded.

Both the temperature of the steam/air mixture and the temperature between the liner and the inner wall of the host sewer (at the start and end points as well as at any intermediate manhole or line inspection hole) shall be measured and reported during the entire cure period. The curing temperatures shall be recorded between the inverted liner tube and the inner pipe wall surface of the sewer.

The curing times according to Table 3 shall be observed.

After final cure (completion of the heating phase), the liner tube shall be cooled with air down to a liner temperature of +20°C.

The curing times for the "epros®DrainLiner", "epros®DrainPlusLiner" or "epros® DrainSteamLiner" (Table 3) are variable depending on the epoxy resin system selected according to Section 2.1.1.1 and on the prevailing ambient temperatures. The curing time and the applied pressure shall be measured and reported during the entire cure period.

4.3.6.2.2 Inversion with closed end and steam outlet valve (Appendix **8**) (closed-end method, Appendix **10**)

Step 1: Inversion by inversion drum

The same operations as those described at Section 4.3.6.1.1 Step 1 shall be performed.

Instead of the tied-up end of the liner tube, the "epros®SteamOutlet valve" shall be incorporated and connected with the control tape of the inversion drum.

Step 2: Steam cure

The curing pressure shall be kept constant at the values specified in the Appendices **22** to **26** by means of compressed air via the "epros®Steam Telemetry" (semi-automatic control) or "epros®SteamMixingLance" (hand control). The steam generator shall be started and, after the appropriate heating-up period, connected to the "epros®SteamTelemetry" or "epros®Steam MixingLance" unit. The temperature shall be increased continuously by adding the appropriate amount of steam via the "epros®SteamTelemetry" or "epros®Steam MixingLance". The steam/air mixture shall exit through the "epros®SteamOutlet valve" at the end of the liner tube. The maximum steam/air temperature of +100°C shall never be exceeded.

Both the temperature of the steam/air mixture and the temperature between the liner and the inner wall of the host sewer (at the start and end points as well as at any intermediate manhole or line inspection hole) shall be measured and reported at the invert (lowest point) during the entire cure period. The curing temperatures shall be recorded between the inverted liner tube and the inner pipe wall surface of the sewer.

The curing times according to Table 3 shall be observed.

After final cure (completion of the heating phase), the liner tube shall be cooled with air down to a liner temperature of +20°C.

The curing times for the "epros®DrainLiner", "epros®DrainFlexLiner", "epros® DrainPlusLiner" or "epros®DrainSteamLiner" (see Table 3) are variable depending on the epoxy resin system selected according to Section 2.1.1.1 and on the prevailing ambient temperatures. The curing time and the applied pressure shall be measured and reported during the entire cure period.

4.3.6.2.3 Inversion with open end and heating hose (Appendix **7**) (Open-end method, Appendices **11** to **13**)

Step 1: Inversion by inversion drum

The same operations as those described at Section 4.3.6.1.2 Step 1 shall be performed.

Step 2: Steam cure

The same operations as those described at Section 4.3.6.2.1 Step 2 shall be performed.

4.3.6.2.4 Inversion with open end and steam outlet valve (Appendix **8**) (Open-end method, Appendices **11** to **13**)

Step 1: Inversion by inversion drum

The same operations as those described at Section 4.3.6.1.2 Step 1 shall be performed.

Step 2: Steam cure

The same operations as those described at Section 4.3.6.2.2 Step 2 shall be performed.

4.3.6.2.5 Inversion with open end "epros®LinerEndCap" and heating hose (Open-end method, Appendix **14**)

Step 1: Inversion by inversion drum

The same operations as those described at Section 4.3.6.1.3 Step 1 shall be performed.

The heating hose, instead of the liner tube, shall be connected to the "epros®LinerEndCap".

Step 2: Steam cure

The same operations as those described at Section 4.3.6.2.1 Step 2 shall be performed.

4.3.6.2.6 Inversion with open end and "epros®LinerEndCap" and steam outlet valve (Open-end method, Appendix **14**)

Step 1: Inversion by inversion drum

The same operations as those described at Section 4.3.6.1.3 Step 1 shall be performed.

Instead of the tied-up end of the "epros®LinerEndCap", the "epros®SteamOutlet valve" shall be incorporated and connected with the control tape of the inversion drum.

Step 2: Steam cure

The same operations as those described at Section 4.3.6.2.2 Step 2 shall be performed.

4.3.6.3. VARIANT 4: Water inversion with "water column" by means of an inversion rig and hot water cure (Appendix **9**)

Step 1: Inversion by water gravity

For the installation of a liner according to the "water column" method variant, the polyester needle felt tube shall be inverted into the pipe by means of a water head created by a tower rig to be put up at the start point or entry manhole. The height of said rig shall be chosen according to the required hydrostatic pressure (water head) and the manhole depth. An "epros®InversionPipe" dimensioned to the diameter of the host pipe shall be positioned in the entry manhole or start point. The liner tube shall be introduced through the "epros®InversionPipe", then fixed and turned back through the holding ring. Then water shall be filled in. The head of water will cause the liner tube to invert into the sewer and provide the pressure necessary to press and hold the liner tube in a tight fit against the surface of the host pipe.

The appropriate inversion pressures are indicated in the Appendices **22** to **26**.

Step 2: Hot water cure

The same operations as those described at Section 4.3.6.1.1 Step 2 shall be performed.

4.3.6.4. Curing times

The curing times for the "epros®DrainLiner", "epros®DrainFlexLiner", "epros®DrainPlusLiner" and "epros®DrainSteamLiner" (Table 3) are variable depending on the two-component epoxy resin system selected according to Section 2.1.1.1 and on the prevailing ambient or process temperatures. The curing time and the applied pressure shall be recorded.

Table **3**: "Curing times of the epoxy resin system "**epros®EPROPOX FC30**""[x)]

Curing times in minutes	Curing temperatures
approx. 600	at +10°C
approx. 360	at +15°C
approx. 240	at +20°C
approx. 150	at +25°C

x) Curing times (heating phase without cooling down phase) of the resin systems at ambient, hot water and steam cures up to a maximum heating flow temperature of +40°C

The curing time begins when the temperatures mentioned in Table 3 are reached, as measured between the inverted liner tube and the host pipe surface of the sewer to be relined (at the start, intermediate and end points) at the bottom of the invert (at the lowest point). In case of groundwater infiltration or cold temperatures of the soil, the cure times must be extended.

4.3.7 Final operations

After curing, the ends of the new inner pipe shall be cut off flush with the walls of the start and end manholes by means of pneumatically operated cutting tools and shall be removed. In each intermediate manhole, the upper half-shell of the cured-in-place pipe shall be removed down to the contact point with the manhole bottom.

At the same time, the circular samples (test rings) for the subsequent tests shall be cut from the supporting pipes and tubes, which have to be removed too (refer to Section 7).

The cutting work shall be performed in compliance with the relevant rules and regulations of accident prevention.

4.3.8 Restoring lateral connections

Lateral connections can be performed with the "epros®DrainLCR method" using the epros®DrainLCR hat profile" (Appendices **15** to **18**) in accordance with the General Technical Approval No. Z-42.3-375.

The resin systems of the General Technical Approvals No. Z-42.3-385 (silicate resin systems "epros®ResinType W01", "epros®ResinType W1" and "epros®ResinType S"), of the General Technical Approvals Nr. Z-42.3-375 ("epros®EPROPOX HC60") and of the General Technical Approvals No. Z-42.3-468 ("epros®HC120 and HC120+"), and "epros®EPROPOX FC30" can be used.

4.3.8.1 Resin mixture

a) Silicate resin mixture for the "epros®DrainLCR hat profile" of the General Technical Approval No. Z-42.3-385.

The silicate resin is made up of the components A and B. One volume part of component A shall be mixed with two volume parts of component B. The resin usage amounts required for a given job shall be determined in accordance with the values shown in Table 4. The components A and B shall be mixed in a mixing container by means of a stirring device (e.g. electrically operated mixer) such that a bubble-free resin mixture with a homogeneous colour is obtained.

Table 4: Silicate resin usage amounts[x)] for the resin systems "epros®ResinType W01", "epros®ResinType W1" and "epros®ResinType S"

Lateral connection line	Resin system Litres (total)*	Component A Litres	Component B Litres
DN 100 – 45° and 90°	0.60	0.20	0.40
DN 125 – 45° and 90°	0.75	0.25	0.50
DN 150 – 45° and 90°	0.90	0.30	0.60
DN 200 – 45° and 90°	1.20	0.40	0.80

x) Wall thickness: 3 mm Length: 270 mm (length within the lateral)

b) Epoxy resin mixture for the "epros®DrainLCR hat profile"

The epoxy resin is made up of the components A and B. The resin usage amounts required for a given job shall be determined in accordance with the values shown in Table 5. The components A and B shall be mixed in a mixing container by means of a stirring device (e.g. electrically operated stirrer) such that a bubble-free resin mixture with a homogeneous colour is obtained.

Table 5: "Epoxy resin usage amounts[x)] for the resin system "epros®EPROPOX FC30""

Lateral connection line	Resin system Litres (total)*	Component A Litres	Component B Litres
DN 100 – 45° and 90°	0.60	0.44	0.16
DN 125 – 45° and 90°	0.75	0.56	0.19
DN 150 – 45° and 90°	0.90	0.67	0.23
DN 200 – 45° and 90°	1.20	0.89	0.31

*) Wall thickness: 3 mm Length: 270 mm (length within the lateral)

c) The carrier material of the "epros®DrainLCR hat profile" may also be impregnated with an epoxy resin mixture according to the General Technical Approval No. Z-42.3-468.

The mixing ratio between the epoxy resin and the hardener of the resin system "epros®EPROPOX HC 120" is 100:33 Kg by weight, or 100:40 Litres by volume, and the mixing ratio of the resin system "epros®EPROPOX HC 120+" is 100:30 Kg by weight, or 100:38 Litres by volume. Once the container has been opened, all of the hardener component must be added to the resin. A double stirrer (electrically or air-operated) shall be used to uniformly mix the hardener component with the epoxy resin without bubbles in the resin container.

d) The carrier material of the "epros®DrainLCR hat profile" may also be impregnated with an epoxy resin "epros®EPROPOX HC60".

The mixing ratio between the epoxy resin and the hardener is 100:33 Kg by weight, or 100:40 Litres by volume (Appendix **21**). Once the container has been opened, all of the hardener component must be added to the resin. A double stirrer (electrically or air-operated) shall be used to uniformly mix the hardener component with the epoxy resin without bubbles in the resin container (cf. Section 4.3.5.1).

The resin mixture as well as the temperature conditions shall be recorded in the report according to Section 4.3.1.

A sample shall be taken from each mixed resin batch to verify and report its reactivity.

4.3.8.2 Installation of hat profiles (**Appendices 15** to **18**)

The main/lateral interfaces masked by the inverted liner shall be cut open from the inside of the cured-in-place polyester needle felt tube.

Lateral connections of the sizes DN 100 to DN 200 shall be restored from the main sewer line of the sizes DN 100 to DN 250 by means of the lining device ("epros®DrainLCR packer") and the "epros®DrainLCR hat profile", using the components, equipment and installations specified in Section 4.2.2.

The lining device is composed of a preformed cylindrical inflatable packer body and a lateral tube centrally located on the side surface at an angle of 45 degrees or 90 degrees. The packer body runs on two mounted telescoping-style wheel systems. The "epros®DrainLCR hat profile" is designed as a cap to be put onto the lateral tube of the "epros®DrainLCR packer". Then the lateral tube of the "epros®DrainLCR packer" with the "epros®DrainLCR hat profile" shall be retracted into the packer body to allow the packer to be introduced and moved down the host pipe.

The “epros®DrainLCR hat profile” wetted both sides with silicate resin shall be pushed with the packer down the pipe to the point of repair by means of interlocking push rods (variant a)) or a carriage (variant b)). A camera shall be fitted to the packer for proper positioning. Once the packer is in place, compressed air shall be applied to the packer body to cause the lateral tube with the “epros®DrainLCR hat profile” to be inverted down into the lateral connection pipe. It is important to ensure that the “epros®DrainLCR hat profile” part to be introduced into the lateral connection line will cover the first joint of the lateral pipe and that the transition zones with the host pipe and with the cured-in-place new pipe are formed with no steps or wrinkles that might impair the hydraulic capacity. The pressure applied to the packer body with its lateral extension will be maintained until the resin mixture has hardened completely.

The curing time for the “epros®DrainLCR hat profile” (see Tables 6 and 7 and Approval Z-42.3-385) varies according to the silicate resin system selected according to Section 2.1.1.2 and depends on the mixing ratio of the components A and B according to subsection 4.3.5 b) as well as on the prevailing ambient temperatures. The curing time and the applied pressure shall be recorded. After final cure, the compressed air shall be removed and the packer withdrawn from the sewer.

Table 6: “Curing times and mixing ratio of components A and B” “epros®Resin Type W” and “epros®Resin Type S”

Mixing ratio by volume				Pot time at +20°C min	Curing time at +15°C min
No.	**Comp. A Hardener**	**Comp. B ”epros®Resin Type W”**	**Comp. B ”epros®Resin Type S”**		
1	3	6	—	15	115
2	3	5	1	18	120
3	3	4	2	21	140
4	3	3	3	25	165
5	3	2	4	28	180
6	3	1	5	31	200
7	3	—	6	32	260

Table 7: “Curing times and mixing ratio of components A and B” “epros®ResinType W01”

Mixing ratio by volume			Pot time at +10°C min	Pot time at +22°C min	Curing time at +12°C min	Curing time at +20°C min
No.	**Comp. A Hardener**	**Comp. B ”epros®Resin Type W01”**				
1	1	2	13-15	4.5-7.5	35	20

It is also possible to use the “epros®EPROPOX FC30” epoxy resin system for the “epros®DrainLCR Method” (hat profile technology). The curing times given in Section 4.3.6.4 Table 3 shall be observed.

Should larger amounts of residual resin be obtained from installation and curing, the installer must remove them from the sewer line; smaller residual amounts of resin can be neglected.

The waterproof reconnection of lateral pipes can also be performed with other rehabilitation methods under valid general technical approvals. Open construction is possible, too.

4.3.9 Pipe-to-manhole connection

Waterproof pipe-to-manhole connections shall be made with swelling tapes (Appendix **20**) to be positioned at the pipe-to-manhole interfaces before the PE preliner is installed.

In the start manhole and, if any, end manhole, as well as in any intermediate manholes, both the cured-in-place pipe portions protruding from the face wall into the manhole (see also Section 4.3.7 Final operations) and the transition zones with the invert at the start and end manhole bottoms shall be made watertight.

Where the use of swelling tapes (auxiliary material) is not possible due to structural reasons, the waterproof connection between the liner and the manhole wall can instead be made in any of the following ways after the liner is cured:

a) Liner-to-manhole connection by application of a reaction resin having a valid general technical approval;
b) Liner-to-manhole connection by application of grout systems having a valid general technical approval;
c) GRP laminates;
d) Pressure injection of polyurethane (PU) or epoxy (EP) resins having a valid general technical approval;
e) Installation of liner end sleeves having a valid general technical approval.

The sealing work for watertight transitions must be performed in good workmanship.

5 Job data in the manhole

The following job data should be indicated by means of a permanent and readily legible inscription in the start or end manhole of the CIPP job:

– Type of relining operation
– Designation of the pipe section
– Nominal diameter
– Wall thickness of the liner
– Year the relining work was performed

6 Final inspection and tightness test

After completion of the work, the relined pipe run shall undergo optical inspection as proof there is no residual waste material left in the line and no wrinkles impairing the hydraulic capacity.

After final cure of the liner including reconnection of the laterals, the sewer line shall be subjected to a tightness test including, where appropriate, the pipe-to-manhole connections. Such test may be performed section by section.

The tightness test for the relined pipes shall be performed with water “W” (Appendix **32**) or air “L” according to DIN EN 1610[15]. The air tightness test shall observe the specifications contained in Table 3 of DIN EN 1610[15], LD test method for moist concrete pipes and all other materials. The relined main-to-lateral interfaces can be subjected to a separate water tightness test by means of suitable inflatable pipe plugs or stop discs.

[15] DIN EN 1610 Construction and testing of drains and sewers; German version EN 1610:1997; issue: 1997-10 in connection with DIN EN 1610 Supplement 1; issue:1997-10

7 Testing of samples

7.1 General

Rings or segments shall be taken as samples from the cured circular liners on the job site (sample delivery note in Appendix **33**). Should the specimens be found to be unsuitable for the tests mentioned at 7.2.1, or should it be impossible to take any ring or segment samples, an alternative DSC analysis according to Section 7.2.2 can be made for lateral liners up to DN 200.

Samples shall be taken from the sewer line on the job site for the analysis of the characteristic material properties by means of the differential scanning calorimetry (DSC). The samples shall be core samples to be drilled with a diameter of no less than 2.5 cm.

7.2 Strength properties

7.2.1 Determination of strength properties by means of the three-point bending test and long-term ultimate ring deflection test

The samples shall be tested for their flexural modulus and flexural stress σ_{fB}.

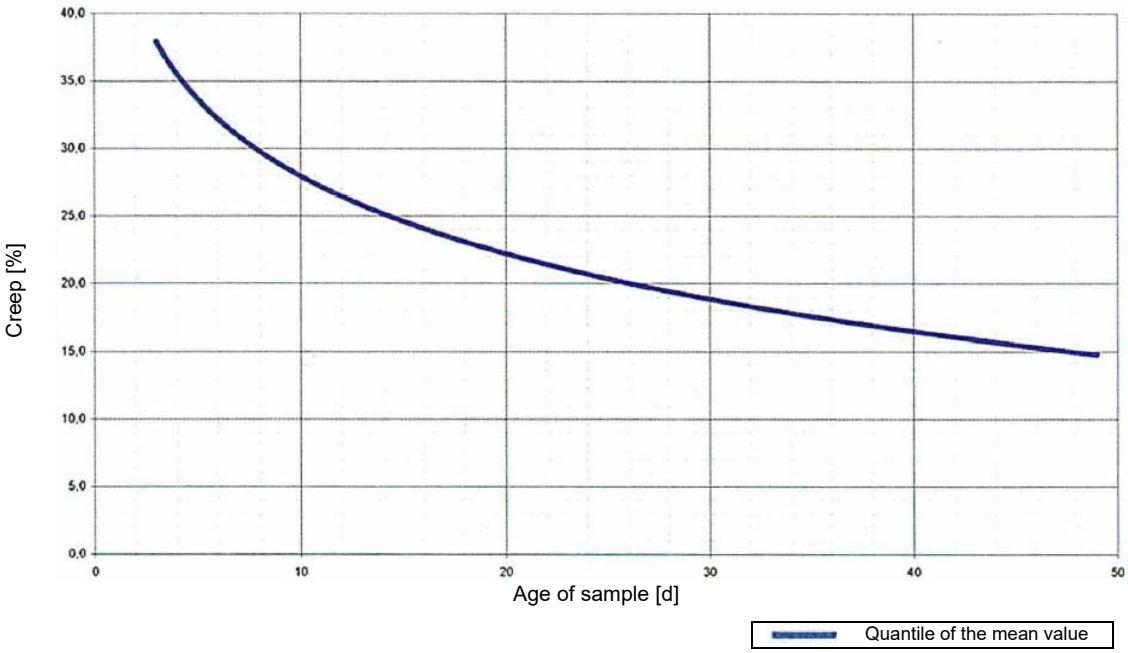
The initial value, the 1-hour value and the 24-hour value of the flexural E-modulus and the initial value of the flexural stress σ_{fB} shall be recorded. The test shall also show whether the creep value according to DIN EN ISO 899-2[16] is observed according to the following formula or according to the relationship shown in Chart 2:

$$K_n = \frac{E_{1h} - E_{24h}}{E_{1h}} \text{ x } 100$$

Creep behaviour depends on the amount of subsequent cross-linkage of the resin and can thus be seen from Chart 2 according to the age of the sample.

16 DIN EN ISO 899-2 Plastics – Determination of creep behaviour – Part 2 Flexural creep by three-point loading (ISO 899-2:2003); German version EN ISO 899-2:2003; issue:2003-10

Chart **2**: "Assessment of creep behaviour as a function of sample age for the epoxy resin system "**epros®EPROPOX FC30**""



The creep behaviour determined in the test on the sample taken on the job site shall not exceed the age-related creep value shown in Chart 2.

Also, the flexural modulus and the flexural stress σ_{fB} according to DIN EN ISO 178[9] (three-point bending test) shall be determined on the cured liner. The specimens used in the tests must be curved rods cut from the appropriate circular section with a minimum width of 50 mm in radial direction. The testing and calculation of the modulus of elasticity must take into account the span measured between the supporting points of the test rod.

The initial values determined for the modulus and flexural stress σ_{fB} shall be equal to or greater than the value mentioned in Section 9.

When there is a change in resin suppliers, the initial value, the 1-hour value and the 24-hour value of ring stiffness shall be additionally recorded as determined on circular rings. The ring stiffness test shall conform to the test procedure laid down in DIN 53769-3[17]. Creep shall also be tested.

7.2.2 Determination of strength properties by means of DSC analysis for lateral liners up to DN 200

If it is not possible to take circular ring samples or segments, an alternative option for lateral liners up to DN 200 is to make a DSC analysis of the samples taken on the job site.

17 DIN 53769-3 Testing of pipelines made of fibre glass reinforced plastics; initial specific ring stiffness and long-term ultimate ring deflection tests on pipes, issue: 1988-11

For this purpose, the following procedure shall be complied with:

1. Cutting through the drilled core sample (diamond cut);
2. Measuring the wall thickness of the structural laminate in three points;
3. Qualitative assessment of the structural layer in the sawn region according to DIN 18820-3[18] Section 5.2;
4. Preparation of specimen from the laminate for DSC analysis;
5. DSC analysis according to DIN 53765[19], Method A-20;
6. Evaluation of test results according to Section 9.

7.3 Water tightness of the samples

The water tightness of the cured liner with integrated PP film of variant f) of the "epros®DrainSteamLiner" can be tested either on a circular liner sample (test ring) with PP coating or on sample specimens taken from the cured PP-coated liner.

The water tightness of the cured liner of the variants a) to e) (PVC, PP, SK or PUR films) of the "epros®DrainLiner", "epros®DrainFlexLiner" and the "epros®DrainPlusLiner" can be tested either on a circular liner sample (ring) without film coating or on specimens taken from the cured liner without film coating. For testing, the coating film of the liner sample or specimen shall be either removed or perforated. It is important to make sure the structural layer is not damaged.

The test on specimens may use either a positive or a negative pressure of 0.5 bar.

For the negative pressure test, water shall be supplied to one end of the specimen. No visible leakage of water shall occur at the opposite end of the specimen during a load period of 30 minutes at a negative pressure of 0.5 bar.

In the positive pressure test, a water pressure of 0.5 bar shall be applied and held for a period of 30 minutes. Again, there shall be no visible leakage at the opposite end of the specimen.

7.4 Wall structure

The wall structure according to the conditions specified in Section 2.1.21 shall be verified by examining cut edges e.g. with a light microscope having a magnification power of approx. 10X. Also, the average area percentage occupied by air bubbles shall be determined according to DIN EN ISO 7822[20].

7.5 Physical characteristics of the cured liner

The samples taken shall be tested for the characteristics mentioned at Section 2.1.2.2.

---

18 DIN 18820-3 Glass fibre reinforced unsaturated polyester (GF-UP) and phenacrylic (GF-PHA) resin structural composites; Protection for structural layer; issue:1991-03

19 DIN 53765 Testing of plastics and elastomers; Thermal analysis; Differential Scanning Calorimetry (DSC); issue:1994-03

20 DIN EN ISO 7822 Textile glass reinforced plastics -- Determination of void content -- Loss on ignition, mechanical disintegration and statistical counting methods (ISO 7822:1990); German version EN ISO 7822:1999, issue: 2000-01

8 Declaration of Compliance for the performed lining job

The installing company must certify that the performed relining job is in compliance with the provisions laid down in this General Technical Approval by issuing a Declaration of Compliance based on the specifications in Tables 8 and 9. Said Declaration of Compliance shall be accompanied by documents showing the properties of the method components mentioned at Section 2.1.1 and by the results of the tests mentioned in Table 8 and Table 9.

The relining job manager or a technically competent representative of the job manager shall be present on the job site during the performance of the lining operation. This person shall see to the proper execution of the work according to the provisions laid down in Section 4 and, more specifically, shall perform or arrange for the tests specified in Table 8 and arrange for the tests specified in Table 9. The specified number and scope shall be minimum requirements.

The tests on specimens according to Table 9 shall be carried out by an accredited inspection body (refer to the List of Inspection, Control and Certification Bodies under the Regional Building Codes, Part V, No. 9).

Once every six months, the aforesaid inspection body shall take a sample from a CIPP liner of a completed lining job. Also, this body shall inspect the documentation of the tests performed according to Table 8 for the same lining job.

Table 8: "Tests to be carried out during operation"

Test object	**Type of requirement**	**Testing interval**
Optical inspection of the line	according to 4.3.1 and DWA-M 149-2[12]	before each lining operation
Optical inspection of the line	according to 6 and DWA-M 149-2[12]	after each lining operation
Equipment	according to 4.2	each job site
Identification of containers of lining components	according to 2.2.3	
Air or water tightness	according to 6	
Resin mixture, resin amount & cure behaviour for each liner tube	mixing report according to 4.3.5	
Curing temperature and curing time	according to 4.3.6.4	
Analysis of glass transition temperatures T_{G1} and T_{G2} by means of DSC[1] for lateral liners up to DN 200	according to 2.1.2.3 and 7.2.2 (alternative)	

1) If the DSC analysis finds the job-site samples to meet the glass transition temperatures T_{G1} and T_{G2} mentioned at Section 2.1.2.3, this result shall be deemed appropriate proof of compliance with the physical characteristics of the cured polyester/resin composite as specified in Section 2.1.2.2.

The lining job manager or the technically competent representative of the job manager shall arrange for the tests mentioned in Table 9. The samples for the tests mentioned in Table 9 shall be taken from the described sample tubes.

Table 9: "Tests to be carried out on specimens"

Test object	Type of requirement	Testing interval
Initial flexural modulus and initial flexural stress σ_{fB} and creep behaviour on pipe segments or rings, or DSC analysis for lateral liners up to DN 200	according to 7.1 and 7.2.1 according to 2.1.2.3 and 7.2.2	each job site, at least every second liner
Density and hardness of sample without preliner and without coating film	according to 2.1.2.2	
Water tightness of the sample of the variants a) to e) without preliner and without PVC, PP, SK or PUR film of the sample of the variant f) without preliner but with the PP film	according to 7.3	
Wall structure	according to 7.4	
Resin identity by means of IR spectroscopy	according to 2.1.1	each time there is a new resin supplier, with declaration of resins
Initial modulus of elasticity (initial ring stiffness) and creep behaviour on pipe segments or rings	according to 2.1.2.2 and 7.2.1	each time there is a new resin supplier, with declaration of resins
Creep behaviour on pipe segments or rings	according to 7.2.1	if value falls below the initial modulus of elasticity mentioned at Section 9, and at least 1 liner every six months

The test results shall be recorded and evaluated; they shall be submitted to the German Institute for Construction Engineering when so requested. The number and scope of testing given in the tables shall be minimum requirements.

Deutsches Institut für Bautechnik

DIBt

9 Provisions for dimensioning

If structural design calculations are required for a given lining job, appropriate proof of structural stability of the liner system shall be furnished according to the Information Sheet DWA-A 143-2[5] of the German Association for Water, Wastewater and Waste (DWA) before the lining operations are started.

The structural design calculation shall include a safety coefficient of γ = 1.35 for the liner tube material.

The reduction factor A for long-term values under the 10,000-hrs test (after DIN EN 761[21]) is A = 3.80.

The following values shall be taken into account for the structural design calculations:

- Initial flexural stresses σ_{fB} after DIN EN ISO 11296-4[8] or DIN EN ISO 178[9]: 54 N/mm²
- Long-term flexural stresses σ_{fB}: 14 N/mm²
- Circumferential initial modulus of elasticity acc. to DIN EN 1228[8]: 2,950 N/mm²
- Circumferential long-term modulus of elasticity: 776 N/mm²

Rudolf Kersten
Head of Unit

Attested
[stamp & signature]

Liner cross-sections

1. Host pipe

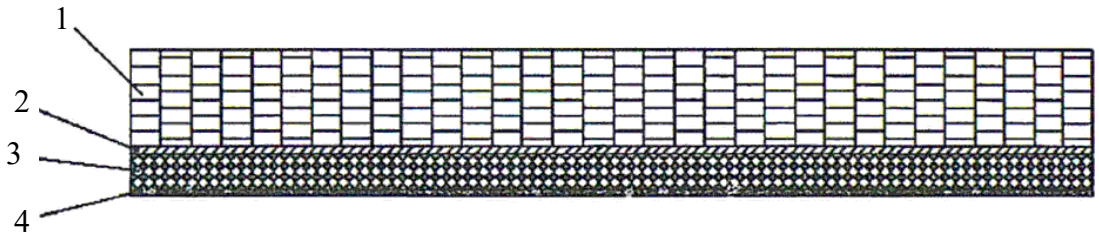
2. Preliner

3. Cured impregnated DrainLiner, DrainFlexLiner, DrainSteamLiner, DrainPlusLiner (PUR/1.0/2.0)

4a	for DrainLiner	DN 100 - DN 250	PVC coating	thickness: 0.40 – 0.50 mm
4b	for DrainLiner	DN 100 - DN 250	PP coating	thickness: 0.30 – 0.40 mm
4c	for DrainFlexLiner	DN 100 - DN 250	PP coating	thickness: 0.30 – 0.40 mm
4d	for DrainPlusLiner	DN 100 - DN 250	PUR coating	thickness: 0.20 – 0.25 mm
4e	for DrainPlusLiner	DN 100 - DN 250	silicone coating	thickness: 0.45 – 0.75 mm
4f	for DrainSteamLiner	DN 100 - DN 250	PP coating	thickness: 0.40 – 0.60 mm

The coatings of variants **4a** to **4e** are used as an installation aid for the tube liner.

The PP coating of variant **4f** “DrainSteamLiner” is an integrated component part of the tube liner.



“DrainLiner method” with “EPROPOX FC 30” resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 1
DrainLiner Method Liner cross sections	

Table A: epros®DrainLiner PVC / PP, characteristics before installation

Nominal diameter	Final wall thickness	Initial wall thickness	Mass per unit area (w/o coating)	Liner overall weight including seam/coating 300 µm	Liner overall weight including seam/coating 500 µm	Liner overall weight including seam/coating 600 µm	Maximum deviation
DN	mm	mm	g/m²	g/lm	g/lm	g/lm	+/- %
100	3	>3,0	650	303	360	388	15
100	4,5	>4,5	900	374	431	459	15
125	3	>3,0	650	371	441	477	15
125	4,5	>4,5	900	459	530	565	15
150	3	>3,0	650	438	522	565	15
150	4,5	>4,5	900	544	628	671	15
150	6	>6,0	1200	671	756	798	15
200	3	>3,0	650	572	685	742	15
200	4,5	>4,5	900	713	826	883	15
200	6	>6,0	1200	883	996	1052	15
225	3	>3,0	650	639	766	830	15
225	4,5	>4,5	900	798	925	989	15
225	6	>6,0	1200	989	1116	1180	15
250	3	>3,0	650	706	847	918	15
250	4,5	>4,5	900	883	1024	1095	15
250	6	>6,0	1200	1095	1236	1307	15

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 2
DrainLiner Method DrainLiner PVC / PP: characteristics before installation	

Table B: DrainFlexLiner / DrainSteamLiner PP, characteristics before installation

Nominal diameter	Final wall thickness	Initial wall thickness	Mass per unit area (w/o coating)	Liner overall weight including seam/coating 300 µm	Liner overall weight including seam/coating 500 µm	Liner overall weight including seam/coating 600 µm	Maximum deviation
DN	mm	mm	g/m²	g/lm	g/lm	g/lm	+/- %
100	3	>3,0	650	303	360	388	15
100	4,5	>4,5	900	374	431	459	15
125	3	>3,0	650	371	441	477	15
125	4,5	>4,5	900	459	530	565	15
150	3	>3,0	650	438	522	565	15
150	4,5	>4,5	900	544	628	671	15
150	6	>6,0	1200	671	756	798	15
200	3	>3,0	650	572	685	742	15
200	4,5	>4,5	900	713	826	883	15
200	6	>6,0	1200	883	996	1052	15
225	3	>3,0	650	639	766	830	15
225	4,5	>4,5	900	798	925	989	15
225	6	>6,0	1200	989	1116	1180	15
250	3	>3,0	650	706	847	918	15
250	4,5	>4,5	900	883	1024	1095	15
250	6	>6,0	1200	1095	1236	1307	15

Table C: DrainPlusLiner with 9% undersize, characteristics before installation

Nominal diameter	Final wall thickness	Initial wall thickness	Mass per unit area (without coating)	Liner overall weight incl. seam and coating	Maximum deviation
DN	mm	mm	g/m²	g/m	± %
100	3	>3.0	416	198	15
125	3	>3.0	416	244	15
150	3	>3.0	416	290	15
200	3	>3.0	416	381	15
225	3	>3.0	416	427	15
250	3	>3.0	416	473	15

Table D: DrainPlusLiner with 18% undersize, characteristics before installation

Nominal diameter	Final wall thickness	Initial wall thickness	Mass per unit area (without coating)	Liner overall weight incl. seam and coating	Maximum deviation
DN	mm	mm	g/m²	g/m	± %
100	3	>3.0	416	180	15
125	3	>3.0	416	221	15
150	3	>3.0	416	263	15
200	3	>3.0	416	345	15
225	3	>3.0	416	386	15
250	3	>3.0	416	428	15

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 4
DrainLiner Method DrainPlusLiner with 9% and 18% undersize: characteristics before installation	

Table E: DrainPlusLiner 1.0 with 10% undersize, characteristics before installation

Nominal diameter	Final wall thickness	Initial wall thickness	Mass per unit area (without coating)	Liner overall weight incl. seam and coating	Maximum deviation
DN	mm	mm	g/m²	g/m	± %
100	>3.0	>4.0	650	434	15
125	>3.0	>4.0	650	542	15
150	>3.0	>4.0	650	650	15
200	>3.0	>4.0	650	867	15
225	>3.0	>4.0	650	975	15
250	>3.0	>4.0	650	1084	15

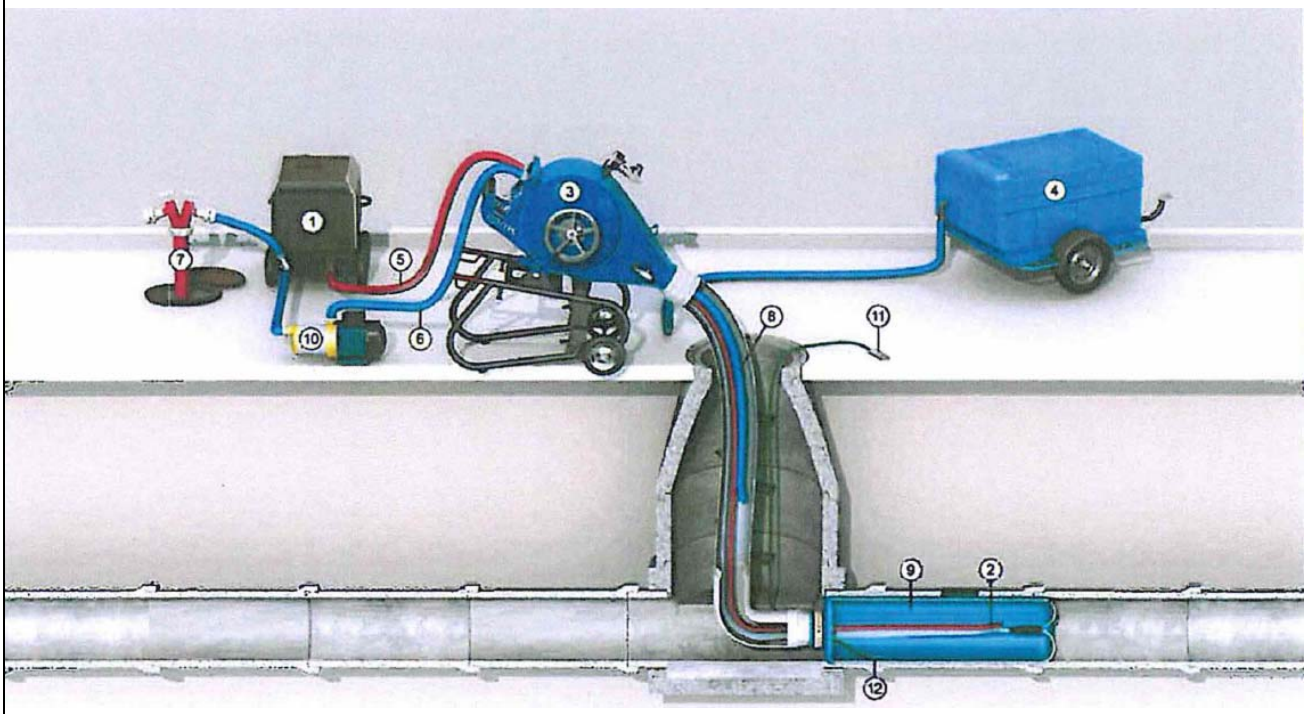
Table F: DrainPlusLiner 2.0 with 10% undersize, characteristics before installation

Nominal diameter	Final wall thickness	Initial wall thickness	Mass per unit area (without coating)	Liner overall weight incl. seam and coating	Maximum deviation
DN	mm	mm	g/m²	g/m	± %
100	>4.0	>5.0	800	481	15
125	>4.0	>5.0	800	601	15
150	>4.0	>5.0	800	721	15
200	>4.0	>5.0	800	961	15
225	>4.0	>5.0	800	1081	15
250	>4.0	>5.0	800	1202	15

VARIANT 1:

Hot Water Cure with Circulation
System Layout

Item	Description
1	HotBox
2	Flat hose for hot water circulation or push hose
3	Inversion drum or inversion air lock
4	Air supply
5	Hot-water flow line
6	Cold-water return line
7	Water supply
8	Circulation line suction hose or push hose
9	DrainLiner
10	Circulating pump

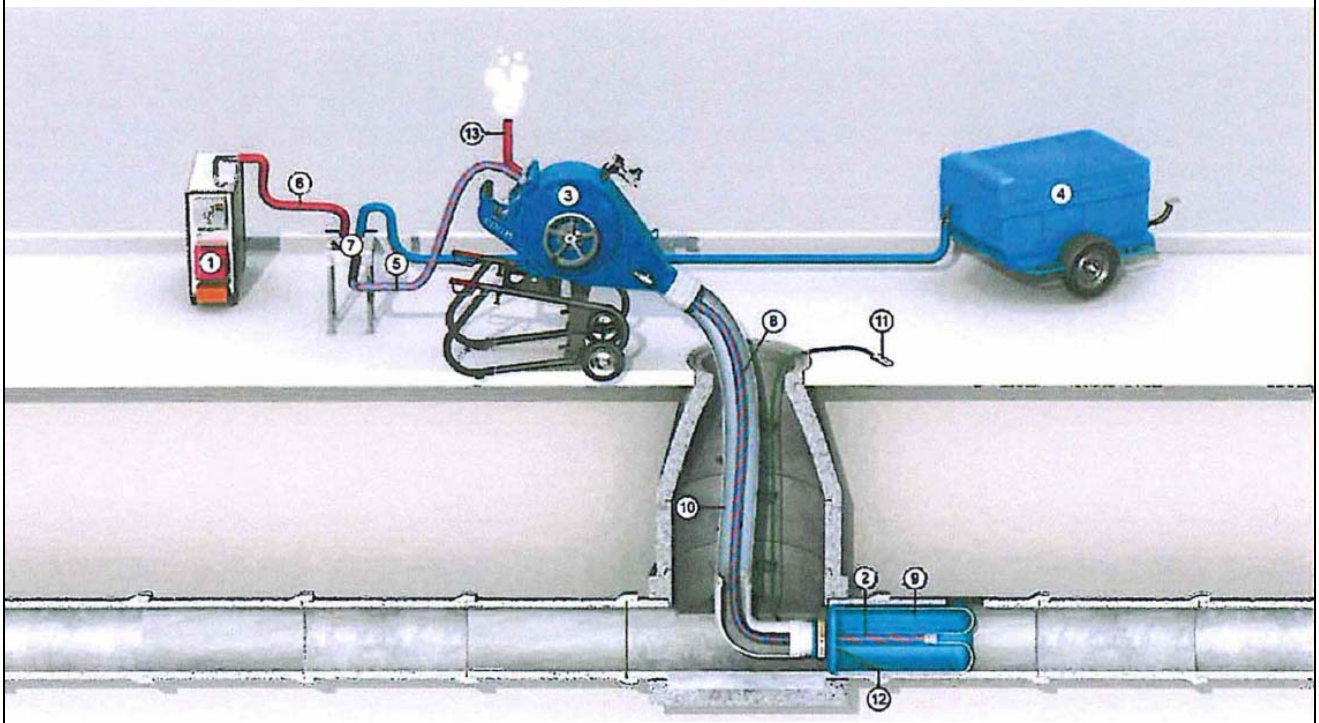


"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 6
VARIANT 1 Hot-water cure with circulation	

VARIANT 2:

Steam Cure with Heating Hose System Layout

Item	Description
1	SteamGen (steam generator)
2	Control tape
3	Inversion drum or inversion air lock
4	Air supply
5	Steam/air feed line
6	Steam line
7	Steam telemetry unit
8	Heating hose
9	DrainLiner
10	Inversion hose, resistant to steam
11	Temperature sensor
12	Temperature measuring point at pipe invert
13	Steam outlet hose

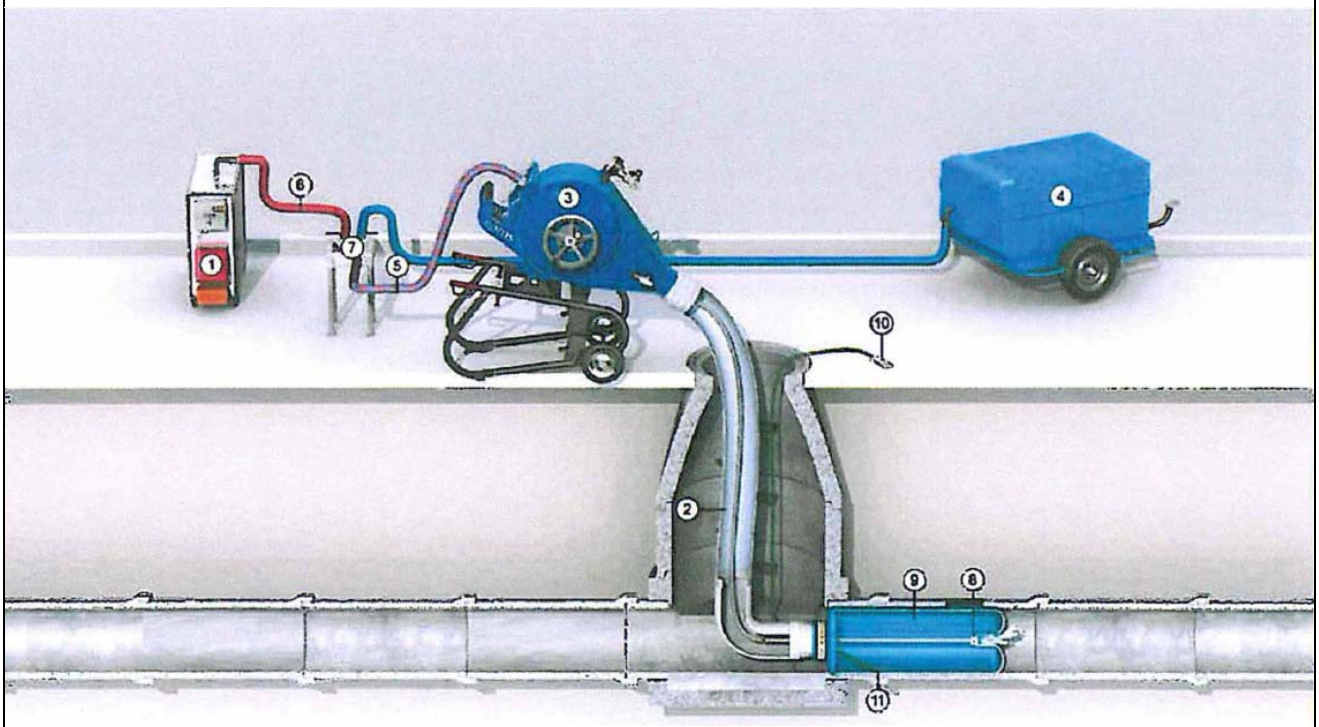


"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 7
VARIANT 2 Steam cure with heating hose	

VARIANT 3:

Steam Cure with Steam Outlet Valve
System Layout

Item	Description
1	SteamGen (steam generator)
2	Control tape
3	Inversion drum or inversion air lock
4	Air supply
5	Steam/air feed line
6	Steam line
7	Steam telemetry unit
8	SteamGen steam outlet valve
9	DrainLiner
10	Temperature sensor
11	Temperature measuring point at pipe invert

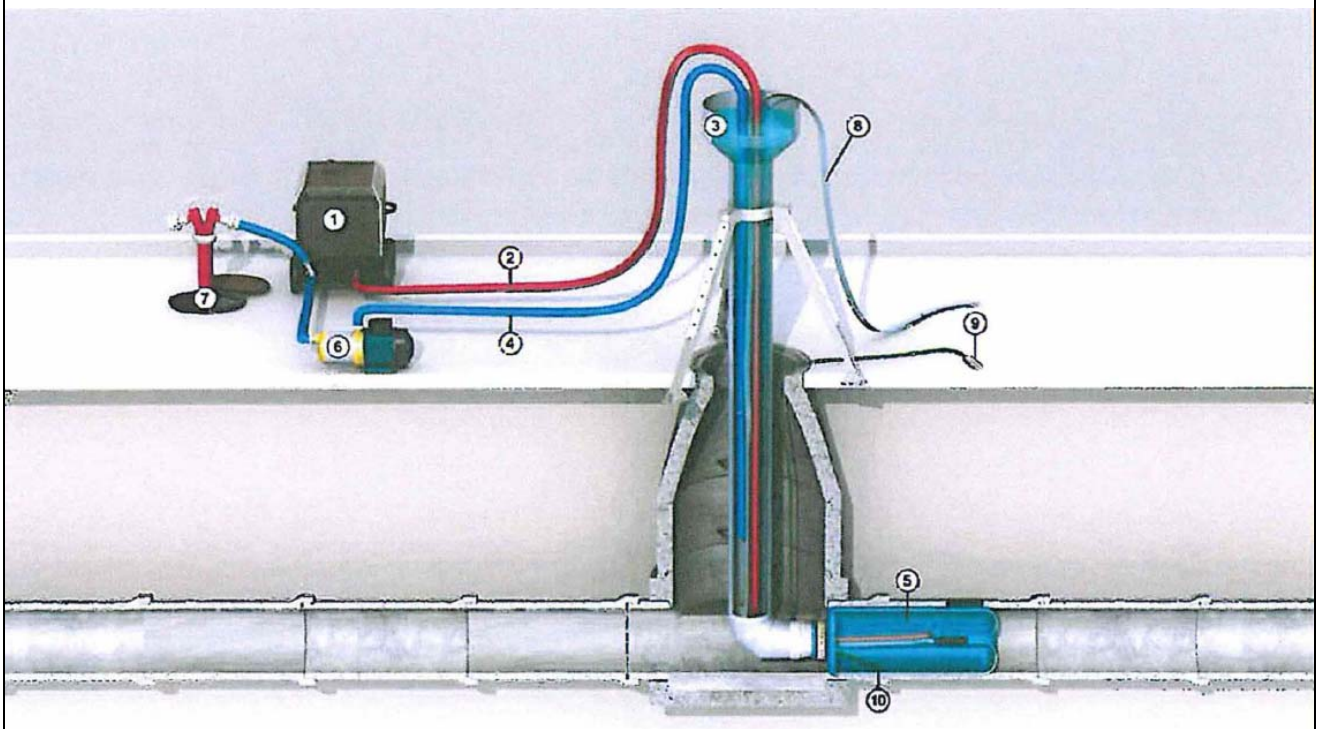


"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 8
VARIANT 3 Steam cure with steam outlet valve	

VARIANT 4:

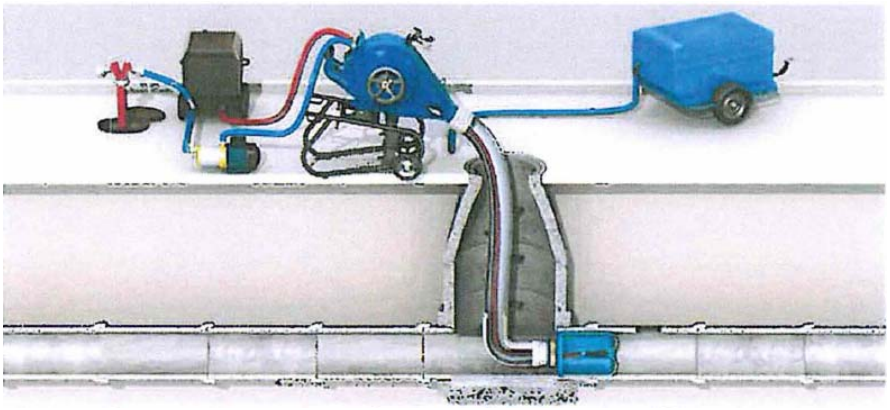
"Water Column" Inversion with Hot Water Cure
System Layout

Item	Description
1	HotBox
2	Hot water circulation (flat) hose
3	Inversion pipe
4	Circulation line suction hose, return line
5	DrainLiner
6	Circulating pump
7	Water supply
8	Control tape
9	Temperature sensor
10	Temperature measuring point at pipe invert

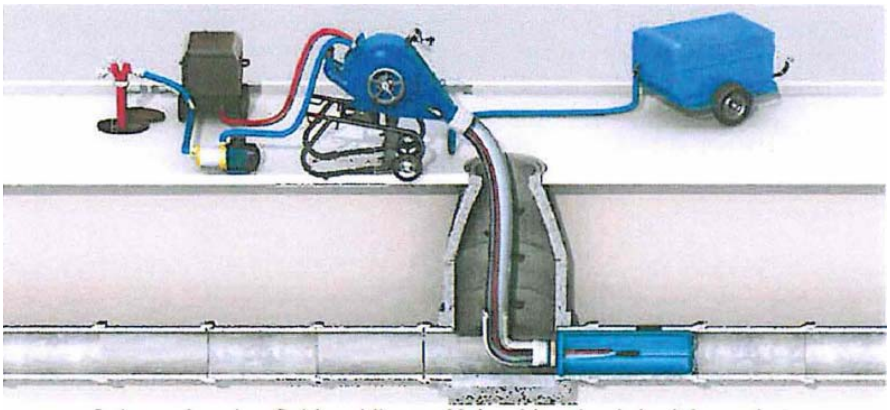


"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 9
VARIANT 4 Water inversion with hot water cure	

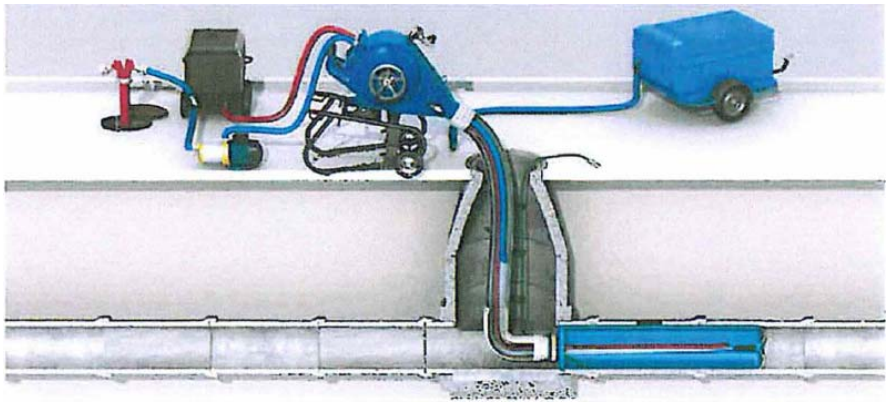
Hot Cure with Circulation/Steam Outlet Valve
Closed-End Method



1. Position the liner tube at the starting point; attach the control tape and the heating hose.



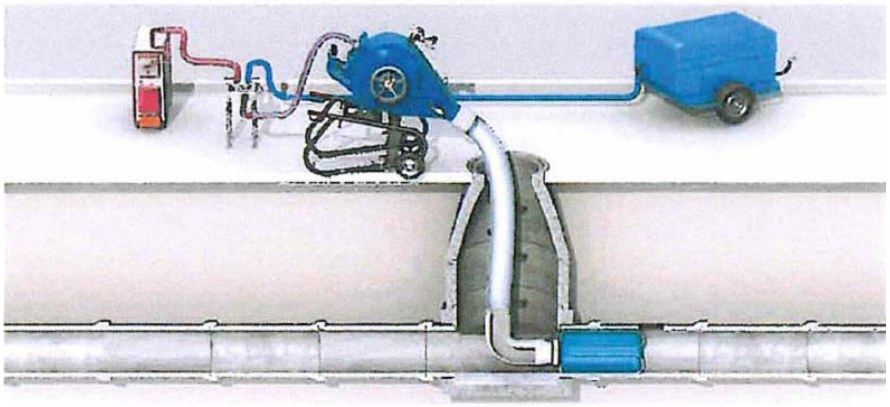
2. Invert the liner tube together with the heating hose.



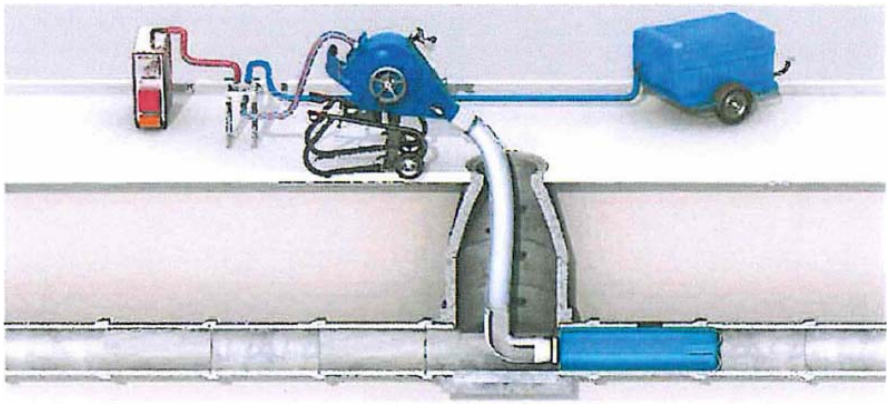
3. Hot water cure. The fluid flows to the end of the liner tube and returns within the liner. Alternative option: When a steam outlet valve is used, the steam/air mixture flows in inversion direction and exits at the head of the liner.

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 10
Rehabilitation with closed liner end Closed-End Method	

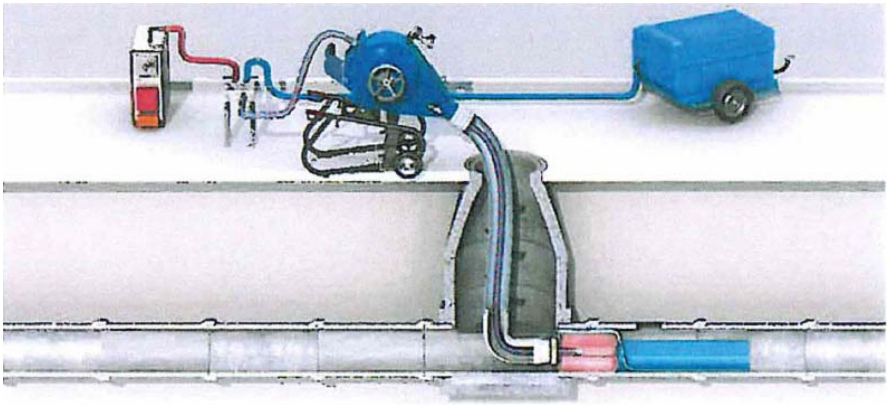
Hot Cure with Circulation/Steam Outlet Valve 1 of 2
Open-End Method, subsequent inversion of calibration hose



1. Position the liner tube at the starting point



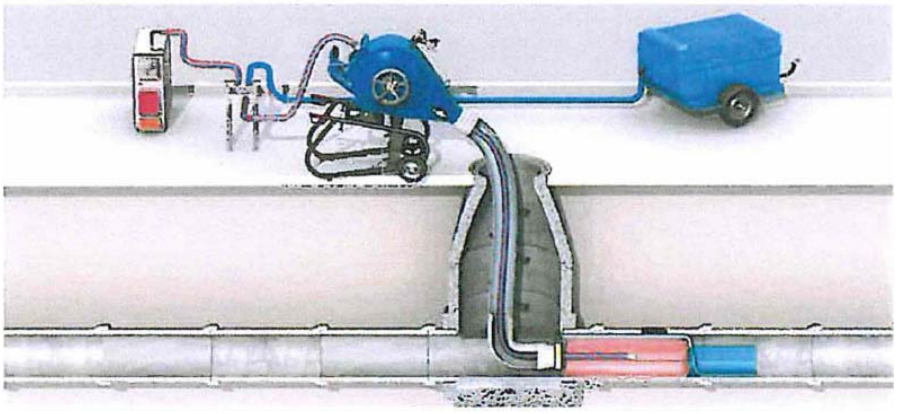
2. Invert the open-ended liner tube



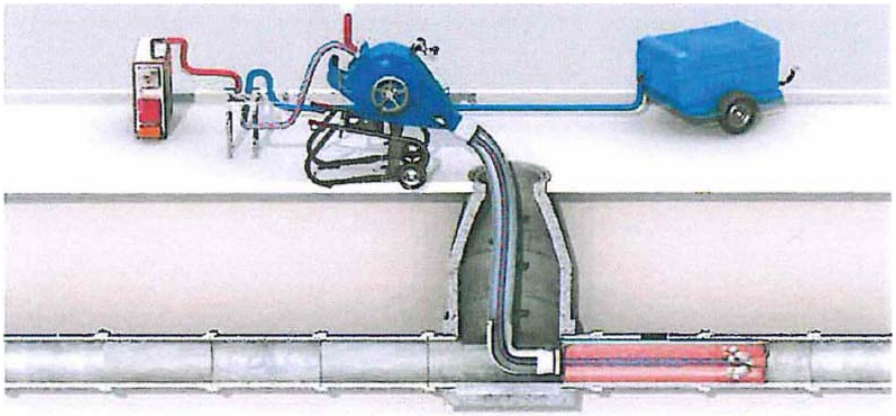
3. Remove the liner tube from the inversion fitting, introduce the calibration hose and position it at the starting point

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 11
Rehabilitation with open liner end, subsequent inversion of calibration hose Open-End Method 1 of 2	

Hot Cure with Circulation/Steam Outlet Valve 2 of 2
Open-End Method, subsequent inversion of calibration hose



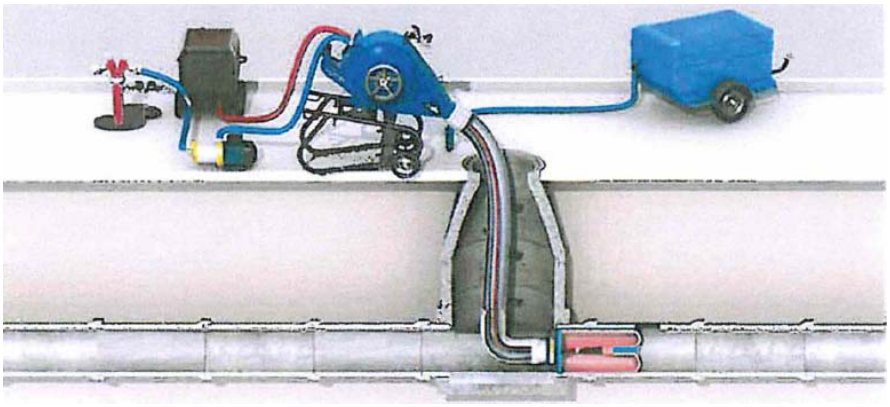
4. Invert the calibration hose into the liner tube. For circulation, invert also the heating hose; otherwise fix the steam outlet valve to the head end of the calibration hose.



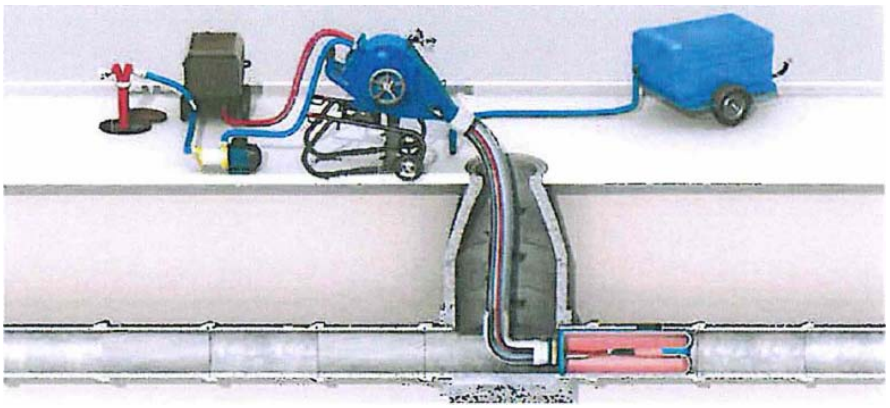
5. Curing with calibration hose. The hot fluid is passed to the liner head and returns inside the liner tube.
   Alternative option: With the steam outlet valve, the steam/air mixture flows in inversion direction and exits the head of the liner.

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 12
Rehabilitation with open liner end, subsequent inversion of calibration hose Open-End Method 2 of 2	

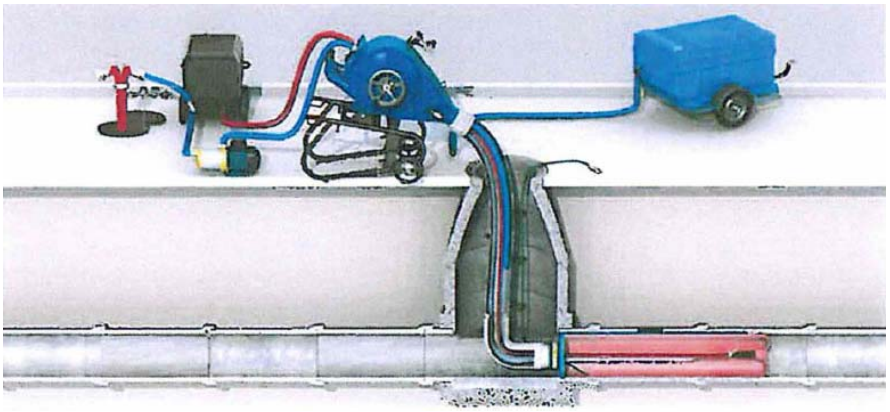
Hot Cure with Circulation (Water or Steam)
Open-End Method, simultaneous inversion of calibration hose



1. Position the liner tube with calibration hose at the starting point



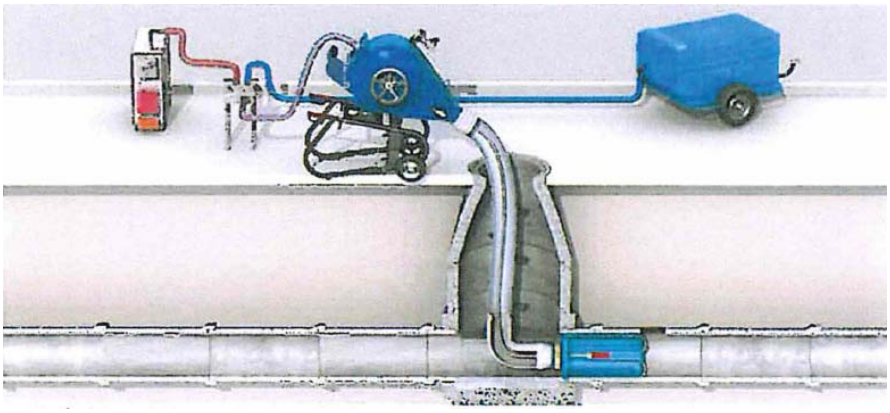
2. Invert the liner tube simultaneously with the calibration hose



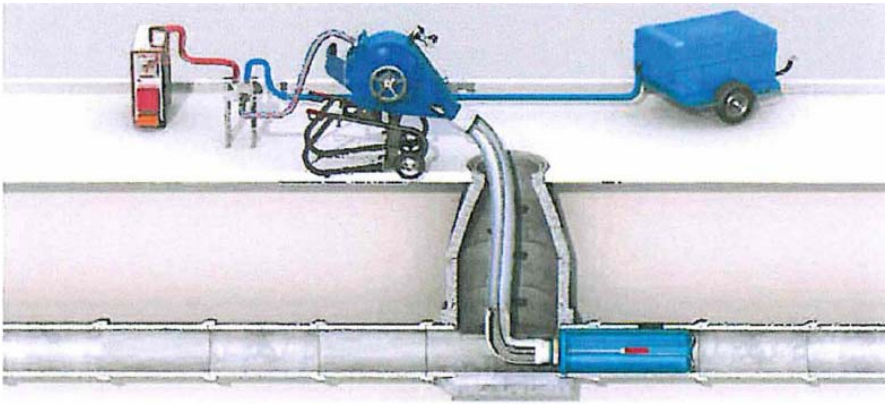
3. Curing with calibration hose. The hot fluid is passed to the liner head and returns inside the liner tube.
   Alternative option: With the steam outlet valve, the steam/air mixture flows in inversion direction in the liner and exits the head of the liner.

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 13
Rehabilitation with open liner end, simultaneous inversion of calibration hose Open-End Method	

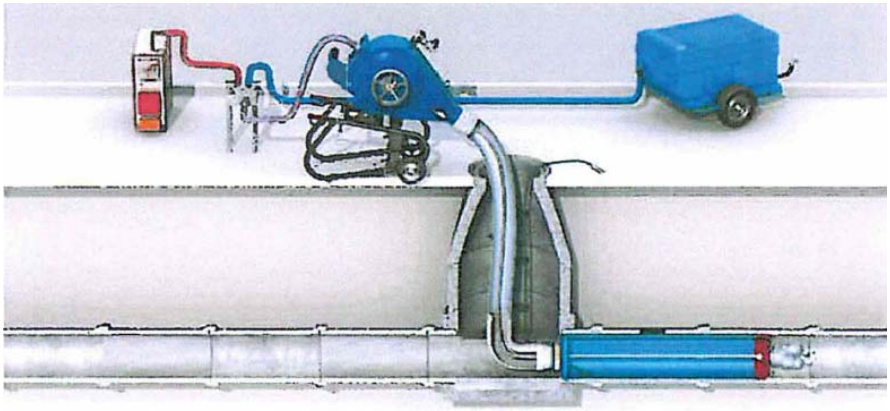
Hot Cure with Circulation/Steam Outlet Valve Open-End Method with LinerEndCap



1. Position the liner tube with calibration hose at the starting point



2. Invert the liner tube with LinerEndCap



3. Curing with calibration hose: hot fluid is passed to the liner head and returns inside the liner tube.
   Alternative option: With the steam outlet valve, the steam/air mixture flows in inversion direction through the liner and exits the head of the liner.

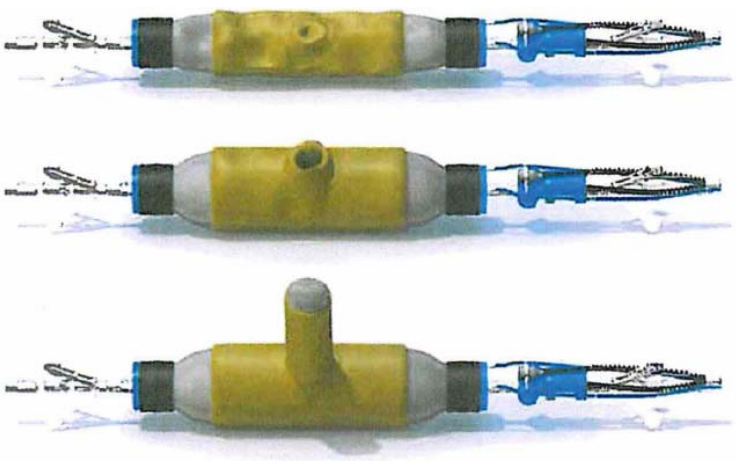
"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 14
Rehabilitation with open liner end, with LinerEndCap Open-End Method	

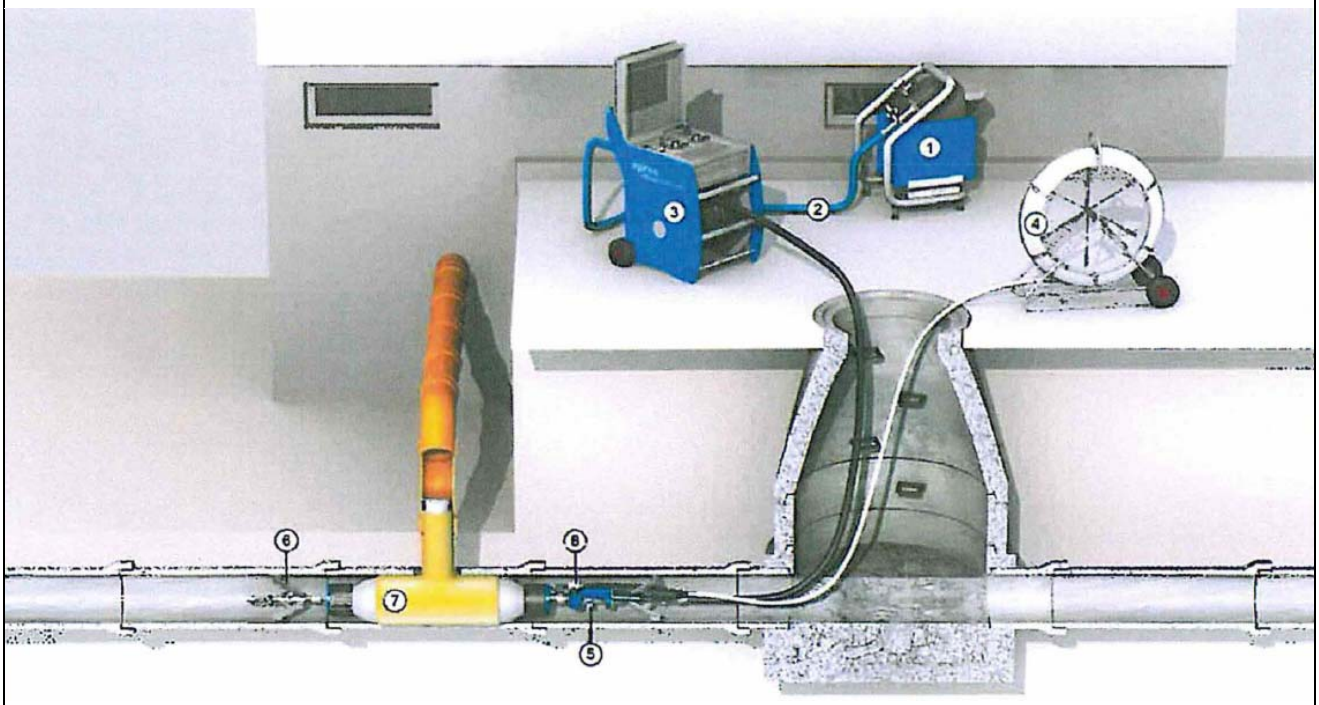
DrainLCR S Method
DrainLCR-S System

A. Deflated packer prior to introduction into the pipe

B. Slightly inflated packer after positioning

C. Fully inflated DrainLCR-S hat profile or DrainLCR-S liner



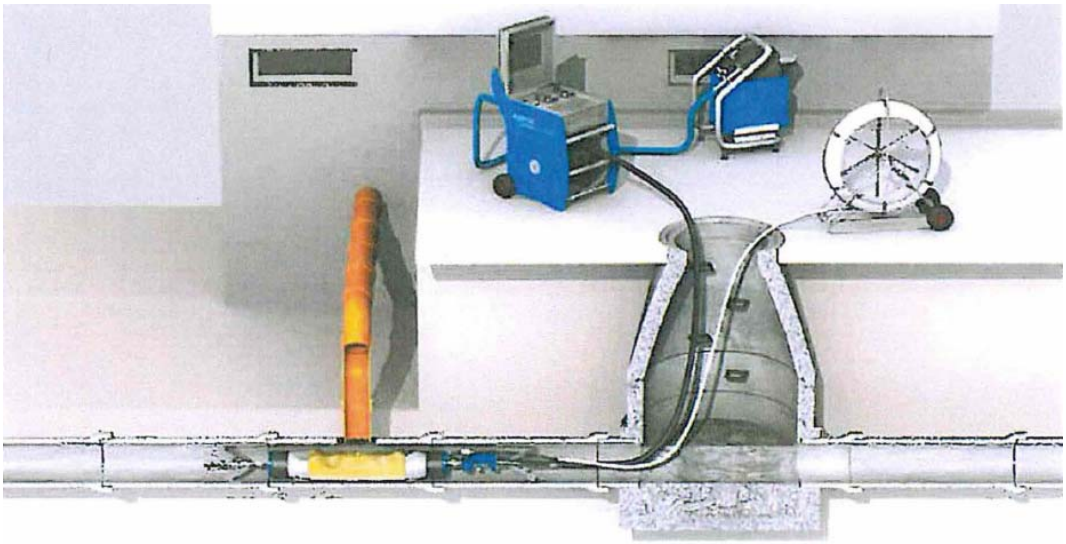


1. Compressor, min. 300 L/min / 8 bar
2. Compressed-air hose, 10 m
3. DrainLCR-S control unit
4. DrainLCR-S fibreglass rod
5. DrainLCR-S rotary actuator
6. DrainLCR-S wheel set
7. DrainLCR-S packer
8. DrainLCR-S camera

"DrainLCR method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 15
DrainLCR-S Method LCR-S Hat Profile & LCR-S Liner	

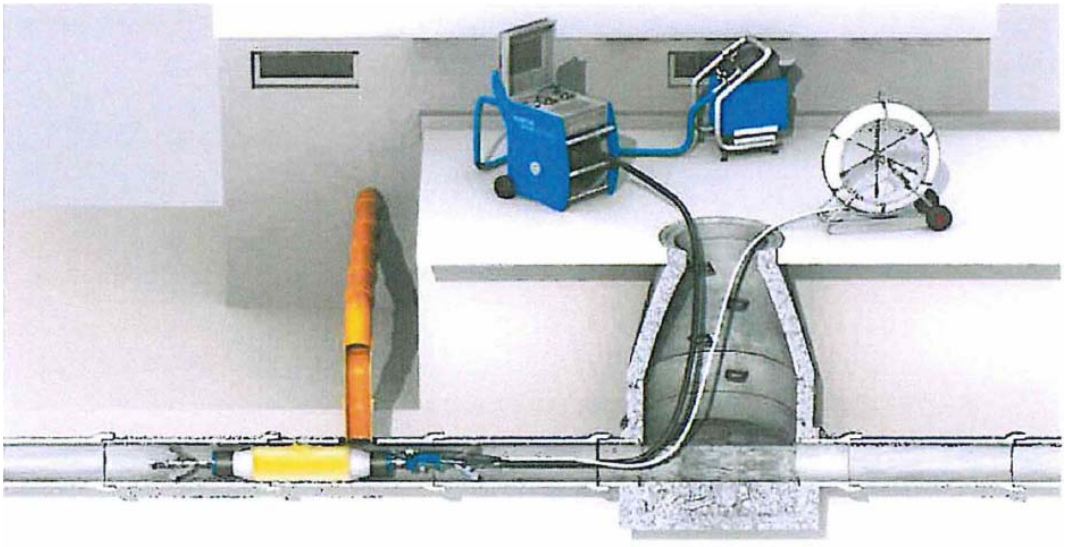
DrainLCR-S Method
Installation Process

1. Position the DrainLCR-S packer:



Push or pull the DrainLCR-S packer way down behind the lateral. Turn the DrainLCR-S packer basket with the help of the camera and the rotary actuator until the basket is properly aligned with the lateral.

2. Lift the DrainLCR-S packer basket:



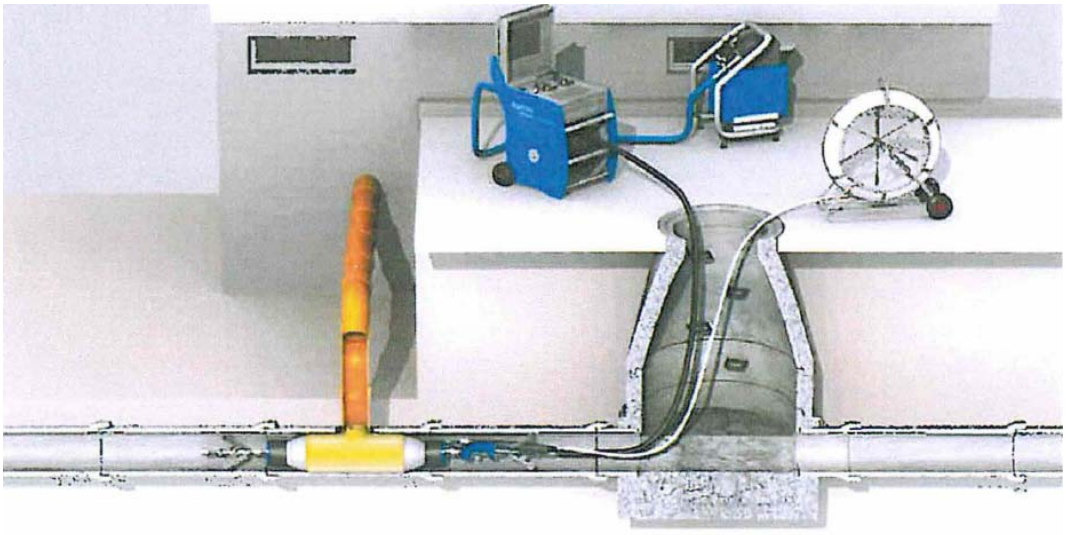
Turn the “Air/Vacuum” lever of the DrainLCR control box briefly into the “Air” position. Then lift the DrainLCR packer basket by turning the “pathfinder” lever to “up”. The LCR-S packer basket will then be extended against the pipe wall.

“DrainLCR-S method” with “EPROPOX FC 30” resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 16
DrainLCR-S Method Installation steps Page 1 of 3	

DrainLCR-S Method
Installation Process

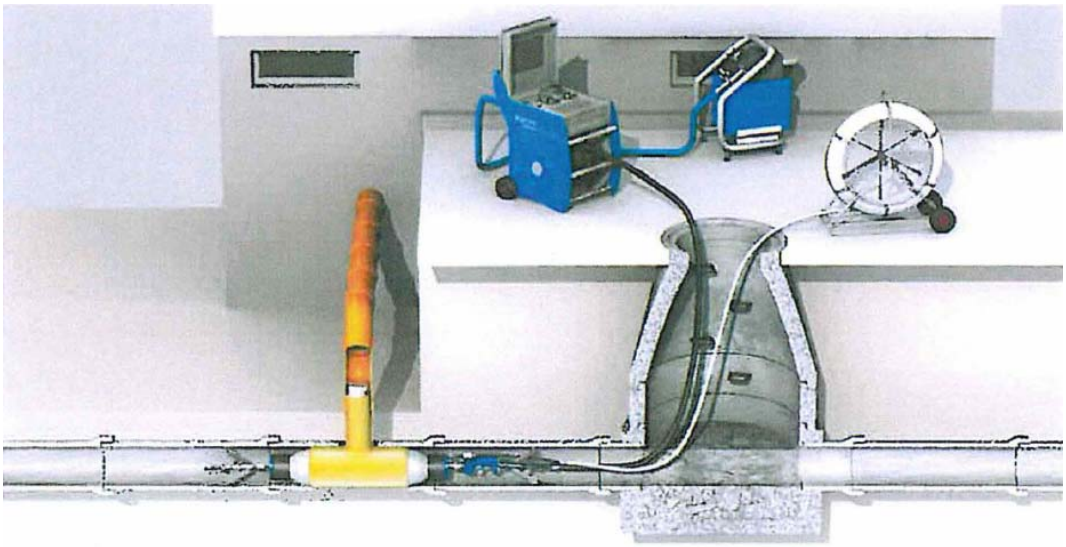
Turn the “pathfinder” lever (counterclockwise) into its “up” positions. Then the DrainLCR packer basket will be extended against the pipe wall.

3. Final positioning:



Draw the DrainLCR packer way back until the DrainLCR packer basket is engaged and locked with the lateral.

4. Invert the hat profile or LCR liner into the lateral connection line:



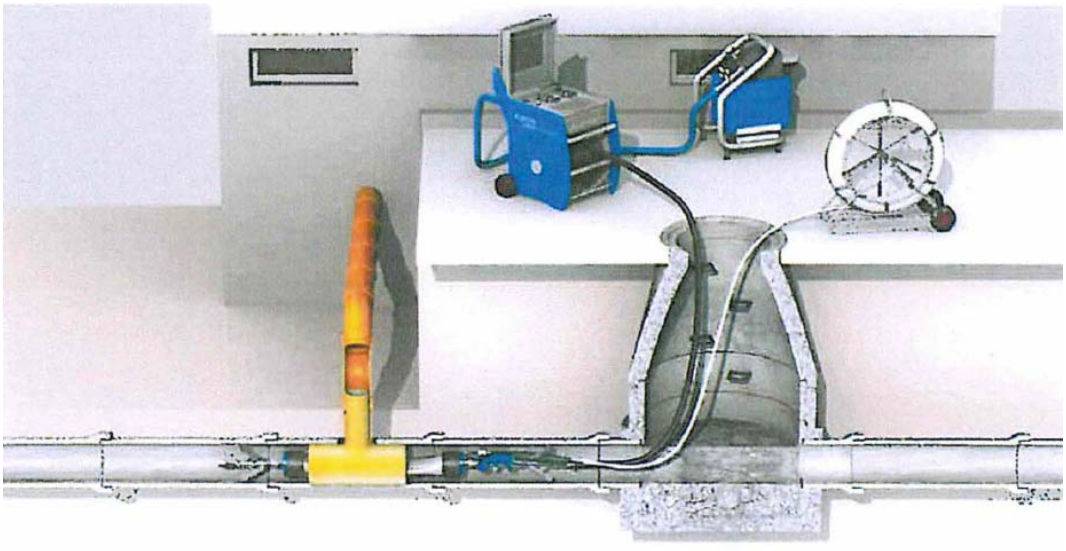
Turn the “Air/Vacuum” lever of the DrainLCR control box to “air” again. The inflation pressure... ***[incomplete text, the translator]***

“DrainLiner method” with “EPROPOX FC 30” resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 17
DrainLCR Method Installation steps Page 2 of 3	

DrainLCR-S Method
Installation Process

In a first step, the DrainLCR-S packer body in the main line will be filled with compressed air; only then the inversion process will be started. A whistling sound will signal the end of the inversion process. The sound signal indicates that the DrainLCR-S hat profile or DrainLCR-S liner has been completely inverted into the lateral connection line. Turn the “pathfinder” lever to “down” to cause the DrainLCR-S basket to retract and the signal sound to stop. Then set the lever to its “zero” position. The inflation pressure must be maintained until the end of the curing process. If you wish to use the DrainLCR control box for further installations, connect an air source and maintain the inflation pressure at 0.7 bar as mentioned before.

5. Remove the DrainLCR packer from the pipe:

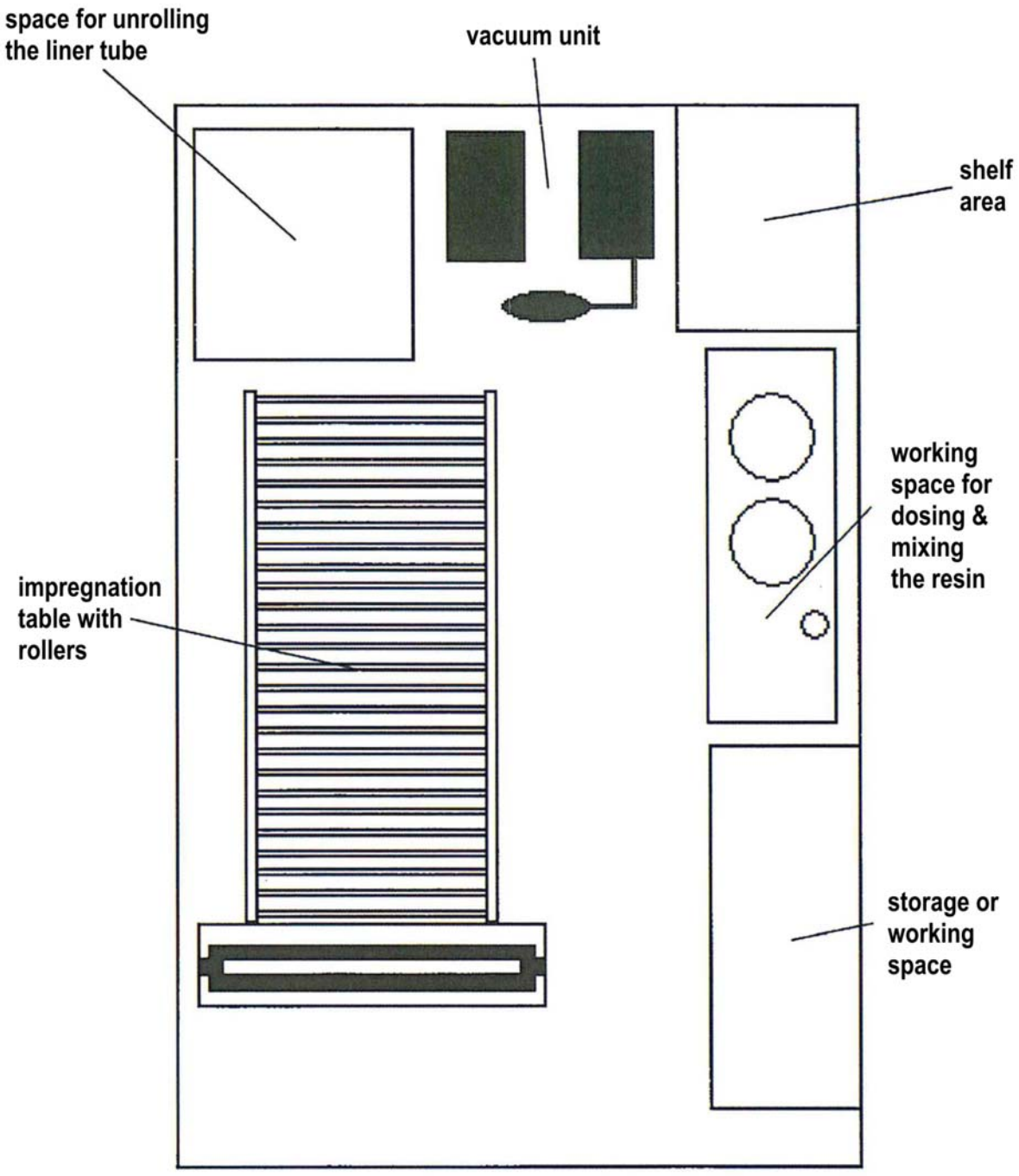


Once the curing process is complete, turn the “pathfinder” lever to its “down” position. Set the “Air/Vacuum” lever to “Vacuum”. After complete deflation of the DrainLCR-S packer, it can be removed from the pipe.

The DrainLCR-S packer must be cleaned and examined for damages after use.

“DrainLiner method” with “EPROPOX FC 30” resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 18
DrainLCR-S Method Installation steps Page 3 of 3	

Trailer configuration



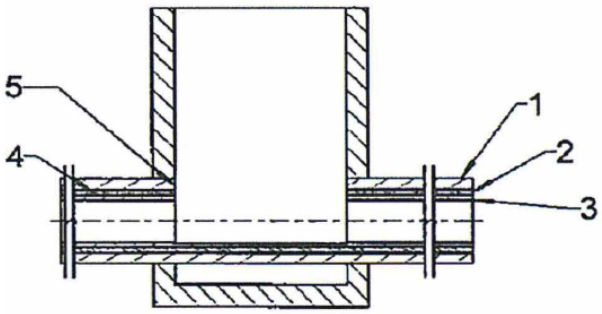
"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 19
DrainLiner Method Trailer configuration	

Pipe-to-Manhole Interface

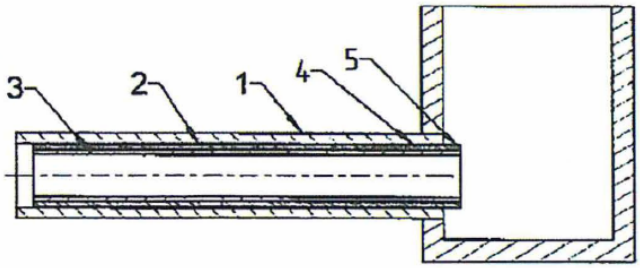
Option 1
1 Host pipe
2 Preliner (PE tube)
3 Impregnated polyester needle felt tube
4 Swelling tape
3 Grouting seal

Option 2
1 Host pipe
2 Preliner (PE tube)
3 Impregnated polyester needle felt tube
4 LinerEndSeal

Intermediate manhole



Final (exit) manhole



"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 20
DrainLiner Method Pipe-to-manhole interface	

Calculation of EPROPOX FC 30 usage amounts

epros® DRAIN SYSTEMS

Calculation of usage amounts

for epros®EPROPOX epoxy resins

Liner type	DrainFlexLiner
Resin system	FC30
Units	metric

Diameter	150	mm
Wall thickness	5	mm
Length	3	mm
Roller nip setting	12	m

Resin mixture in total	7.42	Litres
	8.44	Kg

Volume	**Component A (resin)**	**5.52**	**Litres**
	Component B (hardener)	**1.90**	**Litres**

Weight	**Component A (resin)**	**6.35**	**Kg**
	Component B (hardener)	**2.09**	**Kg**

IMPORTANT
Please observe the data sheet of both the liner and the resin system actually used

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 21
DrainLiner Method Calculation of resin usage amounts	

Inversion & Curing Pressures for epros®DrainLiner PVC / PP

Diameter		Wall thickness		*min.* inversion pressure		*max.* inversion pressure		*min.* curing pressure at 10 °C		*min.* curing pressure at 80 °C		*max.* curing pressure		Resin amount	
mm	inch	mm	inch	bar	psi	bar	psi	bar	psi	bar	psi	bar	psi	Litre/m	Gallon (US) / feet
100	4	3	0.12	0.32	4.6	1.12	16.2	0.40	5.8	0.27	3.9	0.45	6.5	1.04	0.08
100	4	4.5	0.18	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	1.56	0.13
125	5	3	0.12	0.32	4.6	1.12	16.2	0.40	5.8	0.27	3.9	0.45	6.5	1.30	0.10
125	5	4.5	0.18	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	1.95	0.16
150	6	3	0.12	0.32	4.6	1.12	16.2	0.40	5.8	0.27	3.9	0.45	6.5	1.56	0.13
150	6	4.5	0.18	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	2.34	0.19
150	6	6	0.24	0.64	9.3	2.24	32.5	0.81	11.7	0.54	7.8	0.90	13.0	3.12	0.25
200	8	3	0.12	0.24	3.5	0.88	12.8	0.32	4.6	0.21	3.1	0.35	5.1	2.08	0.17
200	8	4.5	0.18	0.40	5.8	1.28	18.6	0.46	6.7	0.31	4.5	0.51	7.4	3.12	0.25
200	8	6	0.24	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	4.15	0.33
225	9	3	0.12	0.24	3.5	0.88	12.8	0.32	4.6	0.21	3.1	0.35	5.1	2.34	0.19
225	9	4.5	0.18	0.40	5.8	1.28	18.6	0.46	6.7	0.31	4.5	0.51	7.4	3.50	0.28
225	9	6	0.24	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	4.67	0.38
250	10	4.5	0.18	0.32	4.6	0.96	13.9	0.35	5.0	0.23	3.3	0.38	5.6	3.9	0.31
250	10	6	0.24	0.40	5.8	1.36	19.7	0.49	7.1	0.33	4.7	0.54	7.9	5.2	0.42
250	10	9	0.35	0.56	8.1	2.00	29.0	0.72	10.4	0.48	7.0	0.80	11.6	7.8	0.63

Inversion & Curing Pressures
epros®DrainFlexLiner PP / epros®DrainSteamLiner PP

Diameter		Wall thickness		*min.* inversion pressure		*max.* inversion pressure		*min.* curing pressure at 10 °C		*min.* curing pressure at 80 °C		*max.* curing pressure		Resin amount	
mm	inch	mm	inch	bar	psi	bar	psi	bar	psi	bar	psi	bar	psi	Litre/m	Gallon (US) / feet
100	4	3	0.12	0.32	4.6	1.12	16.2	0.40	5.8	0.27	3.9	0.45	6.5	1.04	0.08
100	4	4.5	0.18	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	1.56	0.13
125	5	3	0.12	0.32	4.6	1.12	16.2	0.40	5.8	0.27	3.9	0.45	6.5	1.30	0.10
125	5	4.5	0.18	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	1.95	0.16
150	6	3	0.12	0.32	4.6	1.12	16.2	0.40	5.8	0.27	3.9	0.45	6.5	1.56	0.13
150	6	4.5	0.18	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	2.34	0.19
150	6	6	0.24	0.64	9.3	2.24	32.5	0.81	11.7	0.54	7.8	0.90	13.0	3.12	0.25
200	8	3	0.12	0.24	3.5	0.88	12.8	0.32	4.6	0.21	3.1	0.35	5.1	2.08	0.17
200	8	4.5	0.18	0.40	5.8	1.28	18.6	0.46	6.7	0.31	4.5	0.51	7.4	3.12	0.25
200	8	6	0.24	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	4.15	0.33
225	9	3	0.12	0.24	3.5	0.88	12.8	0.32	4.6	0.21	3.1	0.35	5.1	2.34	0.19
225	9	4.5	0.18	0.40	5.8	1.28	18.6	0.46	6.7	0.31	4.5	0.51	7.4	3.50	0.28
225	9	6	0.24	0.48	7.0	1.68	24.4	0.60	8.8	0.40	5.8	0.67	9.7	4.67	0.38
250	10	4.5	0.18	0.32	4.6	0.96	13.9	0.35	5.0	0.23	3.3	0.38	5.6	3.9	0.31
250	10	6	0.24	0.40	5.8	1.36	19.7	0.49	7.1	0.33	4.7	0.54	7.9	5.2	0.42
250	10	9	0.35	0.56	8.1	2.00	29.0	0.72	10.4	0.48	7.0	0.80	11.6	7.8	0.63

"DrainLiner method" with "EPROPOX FC30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 23
DrainLiner Method Installation pressures for DrainFlexLiner PP / DrainSteamLiner PP	

Guidance For Use: DrainPlusLiner with 9% undersize

DrainPlusLiner/ pipe dimension	Unit	DN 50 in pipe DN 50	DN 50 in pipe DN 70	DN 70 in pipe DN 70	DN 70 in pipe DN100	DN100 in pipe DN100	DN100 in pipe DN125	DN100 in pipe DN150	DN125 in pipe DN125	DN125 in pipe DN150	DN150 in pipe DN150	DN150 in pipe DN200	DN200 in pipe DN200	DN200 in pipe DN225	DN200 in pipe DN250	DN225 in pipe DN225	DN225 in pipe DN250
Undersize	%	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
Extra length per metre for open-end process with subsequent calibration hose	cm per m	-6	13	4	16	2	10	20	-5	9	0	16	-1	8	11	0	2
Cut length per lining metre	m	0.94	1.13	1.04	1.15	1.02	1.10	1.20	0.96	1.09	1.0	1.16	0.99	1.08	1.11	1.0	1.02
Contact pressure in conjunction with lubricated calibration hose – in straight pipe	bar	0.7	0.9	0.5	1.2	0.3	0.6	1.0	0.4	0.55	0.1	0.55	0.2	0.36	0.4	0.2	0.3
	psi	10.2	19.2	7.3	17.4	4.4	7.3	14.5	5.8	8.0	1.5	8.0	2.9	5.1	5.8	2.9	4.4
Burst pressure	bar	1.2	1.2	1.3	1.3	1.3	1.2	1.3	0.9	0.9	0.8	0.8	0.8	0.8	0.8	1.2	1.2
	psi	17.4	17.4	18.9	18.9	18.9	17.4	18.9	13.1	13.1	11.6	11.6	11.6	11.6	11.6	17.4	17.4

Important comments:	• Values apply to applications using the resin system epros®EPROPOX HC60. • The calibration hose must always be dimensioned to the largest pipe diameter. • Extra length: a value of 15 cm/m means e.g. that a length of 15 cm must be added for each metre of pipe of the relevant DN size. • All data were determined at an ambient temperature of 20°C. They are lab-scale values, which may differ under in-situ conditions. Please note that the values will change when heat is added.
Recommended use:	• For hot water cures and/or in case of diameter changes, always use the orange-coloured epros calibration hose. • Using the epros®DrainPlusLiner in connection with silicate resin may cause bubbles in the coating if the resin system isn't mixed properly.
Legal mention:	• The statements and values contained in this information sheet are made to the best of our knowledge on the basis of our experience, but they are not binding. • They need to be adjusted to the particular purposes, applications, structures and prevailing local conditions. Subject to the foregoing, we assume liability for the correctness of the statements within the scope of our standard terms & conditions of sale & delivery. • Recommendations deviating from what is indicated in our information and work sheets, whether or not made by members of our staff, shall not be binding unless or until confirmed in writing. The generally accepted rules of good engineering practice shall always be observed.

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 24
DrainLiner Method Guidance for use of DrainPlusLiner at 9% undersize	

Deutsches Institut für Bautechnik
DIBt

Guidance For Use: DrainPlusLiner with 18% undersize

DrainPlusLiner/ pipe dimension	Unit	DN 50 in pipe DN 50	DN 50 in pipe DN 70	DN 70 in pipe DN 70	DN 70 in pipe DN100	DN100 in pipe DN100	DN100 in pipe DN125	DN125 in pipe DN125	DN125 in pipe DN150	DN150 in pipe DN150	DN150 in pipe DN200	DN200 in pipe DN200	DN200 in pipe DN225	DN200 in pipe DN250	DN225 in pipe DN225	DN225 in pipe DN250
Undersize	%	18	18	18	18	18	18	18	18	18	18	18	18	18	18	18
Extra length per metre for open-end process with subsequent calibration hose	cm per m	-5	15	3	Not possible – use liner with 9 % undersize.	5.5	12	0	12	5	12	2	14	16	7	8
Cut length per lining metre	m	0.95	1.15	1.03		1.055	1.12	1.0	1.12	1.05	1.12	1.02	1.14	1.16	1.07	1.06
Contact pressure in conjunction with the lubricated calibration hose – in straight pipe	bar	1.1	1.2	0.8		0.3	0.6	0.3	0.5	0.3	0.6	0.3	0.4	0.5	0.2	0.4
	psi	16.0	17.4	11.6		4.4	8.7	4.4	7.3	4.4	8.7	4.4	5.8	7.3	2.9	5.8
Burst pressure	bar	1.3	1.3	1.3		1.4	1.4	1.3	1.3	1.0	1.0	0.7	0.7	0.7	1.3	1.3
	psi	18.9	18.9	18.9		20.3	20.3	18.9	18.9	14.5	14.5	10.2	10.2	10.2	18.9	18.9

Important comments:

- Values apply to applications using the resin system epros®EPROPOX HC60.
- The calibration hose must always be dimensioned to the largest pipe diameter.
- Extra length: a value of 15 cm/m means e.g. that a length of 15 cm must be added for each metre of pipe of the relevant DN size.
- All data were determined at an ambient temperature of 20°C. They are lab-scale values, which may differ under in-situ conditions. Please note that the values will change when heat is added.

Recommended use:

- For hot water cures and/or in case of diameter changes, always use the orange-coloured epros calibration hose.
- Using the epros®DrainPlusLiner in connection with silicate resin may cause bubbles in the coating if the resin system isn't mixed properly.

Legal mention:

- The statements and values contained in this information sheet are made to the best of our knowledge on the basis of our experience, but they are not binding.
- They need to be adjusted to the particular purposes, applications, structures and prevailing local conditions. Subject to the foregoing, we assume liability for the correctness of the statements within the scope of our standard terms & conditions of sale & delivery.
- Recommendations deviating from what is indicated in our information and work sheets, whether or not made by members of our staff, shall not be binding unless or until confirmed in writing. The generally accepted rules of good engineering practice shall always be observed.

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250

DrainLiner Method
Guidance for use of DrainPlusLiner at 18% undersize

Appendix 25

Guidance For Use: DrainPlusLiner 1.0/2.0 with 10% undersize

eprosDrainPlusLiner 1.0 DN in mm – installed in host pipe DN in mm

Final wall thicknesses		≥ 3 mm on DN basis, in expansion: ≥ 2.5 mm																			
Resin amount calculated for		3.5 mm																			
Roller (nip) distance		9 mm																			
Liner size (mm)		70		100			125			150			200			225			250		
Pipe diameter (mm)		70	100	100	125	150	125	150	200	150	200	250	200	225	250	225	250	300	250	300	400
Extra length per metre	cm / m	-2	1	-2	1	2	-2	1	1	-2	1	2	-2	1	2	-2	1	1	-2	1	2
Cut length per lining metre	m	0.98	1.01	0.98	1.01	1.02	0.98	1.01	1.01	0.98	1.01	1.02	0.98	1.01	1.02	0.98	1.01	1.01	0.98	1.01	1.02
Inversion pressure in straight pipe run	bar	0.41	0.49	0.24	0.24	0.24	0.24	0.24	0.24	0.24	0.2	0.16	0.24	0.2	0.16	0.2	0.16	0.16	0.2	0.16	0.08
Curing pressure	bar	0.33	0.49	0.24	0.28	0.33	0.24	0.28	0.24	0.16	0.24	0.28	0.2	0.24	0.28	0.16	0.2	0.2	0.16	0.2	0.32
Burst pressure	bar	1.14	1.14	0.81	0.81	0.81	0.73	0.73	0.65	0.65	0.65	0.65	0.57	0.57	0.57	0.49	0.49	0.41	0.41	0.41	0.41

eprosDrainPlusLiner 2.0 DN in mm – installed in host pipe DN in mm

Final wall thicknesses		≥ 4 mm on DN basis, in expansion: ≥ 3 mm																			
Resin amount calculated for		4.5 mm																			
Roller (nip) distance		11 mm																			
Liner size (mm)		70		100			125			150			200			225			250		
Pipe diameter (mm)		70	100	100	125	150	125	150	200	150	200	250	200	225	250	225	250	300	250	300	400
Extra length per metre	cm / m	-2	1	-2	1	2	-2	1	1	-2	1	2	-2	1	2	-2	1	1	-2	1	2
Cut length per lining metre	m	0.98	1.01	0.98	1.01	1.02	0.98	1.01	1.01	0.98	1.01	1.02	0.98	1.01	1.02	0.98	1.01	1.01	0.98	1.01	1.02
Inversion pressure in straight pipe run	bar	0.5	0.6	0.3	0.3	0.3	0.3	0.3	0.25	0.3	0.25	0.2	0.3	0.25	0.2	0.25	0.2	0.2	0.25	0.2	0.08
Curing pressure	bar	0.4	0.6	0.3	0.35	0.4	0.3	0.35	0.3	0.2	0.3	0.3	0.25	0.3	0.35	0.2	0.25	0.25	0.2	0.25	0.32
Burst pressure	bar	1.4	1.4	1	1	1	0.9	0.9	0.8	0.8	0.8	0.8	0.7	0.7	0.7	0.6	0.6	0.6	0.5	0.5	0.5

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 26
DrainLiner Method Guidance for use of DrainPlusLiner 1.0/2.0 with silicone coating and 10% undersize	

Site Visit Form for buried sewers

DrainLiner method – rehabilitation of underground pipes
Site visit for sectional repair / relining of sewers

Single report for each repair ☐ foul water ☐ TV pre-inspection Date of survey:

Job site Project No.: storm water ☐ available ☐ Name:

Street address combined sewer ☐ not available ☐ Name:

From manhole (1) no.	To manhole (2) no.	MH depth (manhole 1)	MH depth (manhole 2)	DN (mm) checked?	DN acc. to site plan	Length in metre	Profile shape	Egg-shaped: pipe circumference	Remarks: MH centre to MH centre distance

Distances from rig or inversion drum — Remarks: — Sketch if necessary

Standpost hydrant		m
Undergr. hydrant		m
Hose racks	yes	☐
	no	☐
Road width		m
Truck accessibility	yes	☐
	no	☐
	distance (m)	
Traffic load	private site	☐
	side road	☐
	main road	☐
Traffic control required	yes	☐
	no	☐
Service flow management	yes	☐
	no	☐
Flow management by	plugging	☐
	pumping	☐
Containment of lateral flow	yes	☐ inspection manhole available: yes ☐ no ☐
	no	☐

“DrainLiner method” with “EPROPOX FC 30” resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 27
DrainLiner Method Site Visit Form for buried sewers	

Site information

Site Data:	
CIPP truck:	
Operator:	
Site manager:	
Project:	
Cost Centre	
Client:	
Contact:	
Meeting point:	
Works:	
Subcontractor:	
Miscellaneous:	

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 28
DrainLiner Method Site Data Form	

Fabrication Report

epros®DrainLiner Method for the rehabilitation of damaged sewer lines
Liner Fabrication Report

Project Data

CIPP truck:		Date:		Site No.:	
Project:					
Street address:		ZIP code:		Town/city:	
Client:					
Job No.:		From point:		To point:	
Pipe shape:		DN:	mm	Liner length	
				Target wall thickness	

Material / Material Consumption

Carrier material

epros®DrainFlexLiner (PP)		Batch No. / wall thickness	/	mm
epros®DrainLiner (PP)		Batch No. / wall thickness	/	mm
epros®DrainLiner (PVC)		Batch No. / wall thickness	/	mm
epros®DrainSteamLiner (PP)		Batch No. / wall thickness	/	mm
epros®DrainHybridLiner "S"		Batch No. / wall thickness	/	mm
epros®DrainHybridLiner "P"		Batch No. / wall thickness	/	mm
epros®DrainPlusLiner (PUR)		Batch No. / wall thickness	/	mm
epros®DrainPlusLiner 1.0 (SK)		Batch No. / wall thickness	/	mm
epros®DrainPlusLiner 2.0 (SK)		Batch No. / wall thickness	/	mm

Resin system name / type:

Basic Data

Resin data	Target*	Actual
Storage temperature	s. data sheet	*C
Resin : hardener mixing ratio (kg)	: (see TDS)	:
Mixing temperature	≥ 15°C	
Pot time at 25°C in minutes	HB: Tab. 11	
Usage amount of component A (kg)		
Usage amount of component B (kg)		
Total usage amount of components A + B		
Comp. A Batch no.:		
Comp. B batch no.:		

Fabrication Conditions

		Target*	Actual
Impregnation	Vacuum	0.5 bar	
	Roll nip setting	2 x "s" + 2 mm	
Temperatures	Ambient (°C)		
	Resin (°C)		
	Hardener (°C)		
	Liner after impregnation (°C)		
Time / duration		Start (time)	End (time)
	Mixing target: 3 minutes		
	Impregnation		
	Inversion		
	Filling with water		

On-site retention samples Carrier material / site description

Carrier material / site description

Remarks

Date Signature

* Target values must be taken from the Method Statement or Technical Data Sheets according to the resin system used.

Installation Report

Liner Installation Report

CIPP truck: _____ Date: _____ Site No.: _____

Project _____

Street address _____

Client _____

Job No. _____ from point _____ to point _____

Pipe shape: _____ Final wall thickness: _____ mm

DN _____ mm MH-to-MH length: _____ m

Inversion method:

Water column		*Inversion drum*	
Rig height + manhole:	_____ metres	Inversion pressure:	_____ bar
Water pressure:	_____ bar	Curing pressure:	_____ bar

Downstream inversion: ☐ closed end: ☐

Upstream inversion: ☐ open end: ☐

Groundwater encountered?	yes ☐	☐ no
Preliner inverted?	yes ☐	☐ no
Calibration hose used?	yes ☐	☐ no

Curing method:

Hot water:: ☐ Steam: ☐ Ambient: ☐

Amount of water required for hot cure: _____ m²

Curing from _____(time) to _____(time) Checked (name): _____

Cooling from _____(time) to _____(time) Checked (name): _____

Sampling position:

Sample taken from manhole no. _____ Wall segment: ☐

Supporting pipe: ☐

Length of head section: _____ m (with closed end)

Signature: Responsible person (foreman): _____ Date: _____

"DrainLiner method" with "EPROPOX FC 30" resin system for the rehabilitation of buried damaged sewer lines in the sizes DN 100 to DN 250	Appendix 30
DrainLiner Method Liner Installation Report Form	

Cure Report Form

DrainLiner Method for the rehabilitation of damaged pipes CIPP Liner Cure Report

Date: _____

Project: _____

Client: _____

Pipe run: _____ **Operative:** _____

Plant: _____ **1st measurement at :** _____ (time)

Measuring points schedule

a	—	Air temperature	°C
b1	—	Heating flow temperature	°C
b2	—	Steam/air mixture temperature	°C
c	—	Curing pressure	bar

		Meas.point 1	Meas.point 2	Meas.point 3	Time	°C	Remark
1	—						
2	—						
3	—						
4	—						
5	—						
6	—						
7	—						
8	—						
9	—						
10	—						
11	—						
12	—						
13	—						
14	—						
15	—						
16	—						
17	—						
18	—						
19	—						
20	—						

Leakage Test

Leakage Test Report

1. Project Data:			
Project:			
Address:		ZIP/town:	
Project owner:			
Address:		ZIP/town:	
Installer:			
Address:			
Type of liner:	○ CIPP liner ○ Short liner	Product description:	
Leakage test:			
Address:		ZIP/town:	
2. Drain/Sewer Line Data			
Sewage type:	○ Foul water ○ Stormwater ○ Combined		
Pipe geometry:	○ Circular ○ Egg-shaped		
Liner material:		DN size/bore:	Lining date:
Pipe section #			
MH-to-MH length:			
from manhole		to manhole:	

3. Air tightness test:					
Test method:	○ LA		○ LB	○ LC	○ LD
Test pressure p_0:		mbar	Stabilisation time:		min
adm.press.loss Δp		mbar	Test duration:		min
Start pressure:		mbar			
Final pressure:		mbar	Pressure drop:		mbar

4. Water tightness test:		
○ Pipes only ○ Manholes and inspection holes ○ Pipe with manhole		
Test duration:	30	min
Water head above pipe crown at start of test (water gauge [WG]))		kPa (= mWG· 10)
Water added:		L
Water added / manhole-to-manhole length:		L/m²
Admissible make-up water per m of wetted area acc. to DIN EN 1610:	0.15	L/m²
Calculated admissible total make-up water as referred to the test section		L
Actual amount of make-up water		L

5. Result			
Test passed:	○ yes ○ no		
Comments:			
Place / date:		Signature	

Sample Delivery Note

SAMPLE DELIVERY NOTE FOR TESTING OF LINER MATERIAL

☐ *INITIAL TEST* ☐ *REPEATED TEST* *for Test Report No.* ____

1. Sampling data:

Sample taken by:		Test institute:	
Date / time:		Address:	

2. Sample identification:

Project:			Material ID:			
Project owner / client:			Sample description:			
Cost centre:			Sewer line description:			
Installer firm:			Nominal diameter:			
Liner manufacturer:			Date installed:			
Carrier material:			Host pipe condition:	O I	O II	O III
Resin material:			Sampling location:	O MH-MH line	O final MH	O interm. MH
Pipe geometry:	O circular	O egg shape	Sampling position:	O crown	O springline	O invert

3. Required initial properties according to structural design calculations:

Flexural E-modulus$_{DIN}$ E_f [N/mm^2]:		Circumferential E-modulus E_U [N/mm^2]:	
Flexural stress$_{at\ first\ break}$ σ_{fB} [N/mm^2]:		Initial ring stiffness S_0 [N/m^2]:	
Wall thickness **d** [mm]:		Maximum creep K_{N24} [%]:	
Reduction factor A_1 :		Density δ [g/cm^3]:	

4. Test results:

Flexural modulus, bending stress acc. to DIN EN ISO 178

Date tested	E_f [N/mm^2]	σ_{fB} [N/mm^2]	h [mm]
	Load type	O axial	O radial

24 h creep after DIN EN ISO 899-2

Date tested	K_N [%]

Circumf. E-modulus, initial ring stiffness acc. to DIN EN 1228

Date tested	E_U [N/mm^2]	S_0 [N/m^2]	h [mm]

24 h creep after DIN EN 761

Date tested	K_N [%]

Water tightness acco. to DIN EN 1610

Date tested	Load period	Test pressure [bar]	Test result	
	30 minutes		O passed (tight)	O failed (leaking)

Calcination method acc. to DIN EN ISO 1172

Date tested	Resin [%]	Total residues [%]	Glass content [%]	Additive [%]

Spectral analysis after ASTM D 5576 (FT-IR)

Date tested	EP resin	UP resin	VE resin	Other resin

Density acc. to DIN EN ISO 1181-1 or -2

Date tested	δ [g/cm^3]

Thermal analysis acc. to DIN EN ISO 11357-1 / DSC analysis DIN 53765 Method A

Date tested	Glass transition temperature [°C]			Enthalpy [J/g]	
	T_{G1}		ΔT_G	O exothermic	O endothermic
	T_{G2}				

Residual styrene content acc. to DIN 53394-2 (GC)

Date tested	Weighed-in quantity [mg]	Residual styrene [mg/kg]	Residual styrene [%]	Weight-in quantity referred to	
				O Total quantity	O Pure resin

5. Evaluation of results:

Requirement	met	not met	Requirement	met	not met
Flexural-E-modulus E_f	O	O	Circumfer. E-modulus E_U	O	O
Flexural stress σ_{fB}	O	O	Initial ring stiffness S_0	O	O
Wall thickness **d**	O	O	24 h creep K_N	O	O
Water tightness	O	O	Density δ	O	O

6. Remarks:

7. Signature of tester / laboratory: