

**Product Name:** Transition Flex Liner 3mm

**Product Description:** Transition Flex Liner 3mm 150'

**Typical Applications:**

Easily Invertible material typical used in a line with 45° or 90° bends with transitions of one size pipe to another. Materials flexibility allows for ease of inversion as well as molding to the host pipe and leaving little to no void.

**Performance Limits** *\*\* If product is utilized outside the limits defined below, warranty coverage is voided \*\**

| Characteristic                                      | Spec                                       | Comments  |
|---|--|---|
| <b>General</b>                                      |  |   |
| Typical dry Thickness (mm)                          | 5.9 – 6.2 mm                               |   |
| Typical finished Thickness (mm)                     | 3.2 – 4.0 mm                               | Depends on installation pressures, pipe diameter, and number of bends (45° & 90°)   |
| Sizes available (in.)                               | 3, 4, 6                                    | Custom sizes are available. Contact your local sales representative to determine product suitability for your application   |
| <b>Resins</b>                                       |  |   |
| PLI Epoxy (2:1)                                     | YES  | Compatible with cold, warm, hot and heat assist variants of resin   |
| PLI Epoxy (4:1)                                     | YES  | Compatible with cold variant of resin   |
| Vinyl Ester   | NO   | Not recommended – contact PLI representative for guidance   |
| <b>Install Design</b>                               |  |   |
| Maximum Depth of Install (ft)                       | 3" → 35'<br>4" → 18'<br>6" → 8'<br>8" → 5' | Depth assumes flooded conditions with fully deteriorated pipe and 10% ovality, if install expected to exceed recommended max depth, product may still work however <b>requires PLI approval prior to installation.</b>  |
| Can be used across Transitions?                     | YES  | Transitions are sized one size up.<br>3" liner can transition to 4"<br>4" liner can transition to 6"<br>6" liner can transition to 8"   |
| Remote Start Allowed?                               | NO   |   |
| Install with Infiltration Allowed?                  | Situational                                | Thin material may not retain enough resin in high INI situations to form structurally sound liner.<br><b>Contact PLI representative to discuss specific application.</b>  |
| Resin per FT  | Varies by size, resin type                 | <b>Epoxy Resins:</b><br>3" – 0.9 lb/FT, 4" – 1.2 lbs/FT, 6" – 1.7 lbs/FT<br><b>Contact PLI representative for Poly Vinyl Ester values.</b>  |
| <b>Installation</b>                                 |  |   |
| Wet Out Gap Setting                                 | 9.5 mm                                     | When using the WRT Wet Out Roller System<br><b>**DO NOT USE FLOOR ROLLER FOR RISK OF RESIN SHY FINAL PRODUCT**</b>  |
| Typical Inversion Pressures (psi)                   | 5-12                                       | Depends on installation pressures, pipe diameter, and number of bends (45° & 90°)   |
| Maximum Inversion Pressure (psi)                    | 20   | Pressures exceeding this limit run the risk of tearing the liner or excessive "thinning" around bends   |
| Stretch Factor (at recommended inversion pressures) | 5-6%                                       | Highly dependent on inversion pressure, length of install, and pipe diameter. Stretch will be limited to about 5% if the inversion rate is well controlled (slow). The larger the diameter and the longer the run, the more the material will stretch with speed. |
| Max Curing Pressures (psi)                          | 15   | Pressures exceeding this limit run the risk of tearing the liner or excessive "thinning" around bends   |
| Maximum Heat Assist Temperature (°F)                | 220°F                                      | Liner can be cured ambient, hot water or Steam (Do Not exceed 220°F at the liner)   |

Please contact your representative at 1-866-336-2568 if you have any questions.

