

# DATA SHEET UV CURING PULLING SPEEDS - WILLPOX LC



Liner: lineTEC ProFlex		<u>Pulling Speeds in m/min</u>						Resin Con. (kg)
Resin: Willpox LC	Closed End	Open End	Closed End	Open End	Closed End	Opend End		
Watts // Nominal Diameter (DN)	300/400	300/400	600	600	1200	1200		
100	0,30	0,10	0,80	0,60	-	-	1,36	
125	0,20	-	0,65	0,45	-	-	1,64	
150	-	-	0,50	0,30	0,80	0,60	2,09	
200	-	-	0,40	0,20	0,60	0,40	2,73	

Liner: lineTEC ProFlex XT		<u>Pulling Speeds in m/min</u>						Resin Con. (kg)
Resin: Willpox LC	Closed End	Open End	Closed End	Open End	Closed End	Opend End		
Watts // Nominal Diameter (DN)	300/400	300/400	600	600	1200	1200		
100	0,2	-	0,7	0,50	-	-	1,64	
125	-	-	0,6	0,40	-	-	1,98	
150	-	-	0,5	0,30	0,70	0,50	2,57	
200	-	-	0,2	-	0,50	0,30	3,26	

Liner: lineTEC ProFlex S UV		<u>Pulling Speeds in m/min</u>						Resin Con. (kg)
Resin: Willpox LC	Closed End	Open End	Closed End	Open End	Closed End	Opend End		
Watts // Nominal Diameter (DN)	300/400	300/400	600	600	1200	1200		
100	0,60	0,40	> 1,00	> 1,00	-	-	1,50	
125	0,50	0,30	> 1,00	> 1,00	-	-	1,80	
150	0,40	0,20	1,00	0,80	> 1,00	> 1,00	2,30	
200	-	-	0,90	0,70	> 1,00	> 1,00	3,00	

Liner: lineTEC Glass Liner		<u>Pulling Speeds in m/min</u>						Resin Con. (kg)
Resin: Willpox LC	Closed End	Open End	Closed End	Open End	Closed End	Opend End		
Watts // Nominal Diameter (DN)	300/400	300/400	600	600	1200	1200		
100	0,80	0,60	> 1,00	> 1,00	-	-	-	
150	0,60	0,40	1,00	0,80	> 1,00	> 1,00	-	

### Application Notes Willpox LC

The data given is based on installation tests in cleaned KG pipes at an ambient temperature of 20° Celsius. Curing took place using SewerTronics SpeedyLight with new LED heads in each case in the wattages stated.

The specified pulling speeds allow complete curing of the resin under these conditions. In case of deviating conditions, such as the presence of extraneous water or impaired luminosity of the LED heads etc., it is recommended to reduce the pulling speed by up to 50% in order to achieve complete curing and adhesion with the old pipe.

For pipes with dimensional changes, the pulling speed corresponding to the respective dimension can be used. If the position of the dimensional change within the pipe cannot be determined exactly, it is advisable to select the pulling speed according to the respective larger dimensional size.

Please note that after curing, the laminate may have a temperature of up to 90° Celsius due to the exothermic reaction of the resin. To minimize the risk of creating an annular gap, it is recommended to keep the liner under pressure during a cooling phase of approx. 30 minutes since this significantly reduces tensions stemming from thermal differences.

To enable solid adhesion and/or a good frictional connection, it is essential that the pipes are sufficiently cleaned, ideally even slightly roughened.

Compaction of the laminate (liner & resin) is favored by installation with an inversion or curing pressure of 0.2 bar above the recommended curing pressure of the liner used. The liner must not be used for this purpose. For liners suitable for dimensional changes, increasing the inversion pressure (at least briefly, if necessary) favors stretching of the textile and thus dimensional adaptation.

Due to the high viscosity of Willpox LC, a processing temperature of  $\geq 20^\circ$  Celsius for the resin is recommended. Higher resin temperatures allow faster impregnation of the liner.

Pre-impregnation of the liner during preparation for installation is possible. However, it is recommended that this be carried out no longer than 72 hours before installation in order not to weaken the stability of the liner.

Please note that the curing of the resin is already triggered by ambient light. It is therefore important to protect both the container and the impregnated liner as best as possible from exposure to light.

Please refer to the respective safety data sheets.

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Errors and omissions excepted. Please note the current status of this data sheet, available at „[www.linetec.info/downloads](http://www.linetec.info/downloads)“.