

Cured-In-Place Pipe

Hot Air Cured

Hot Water Cured

Resin Wet-Out Rate too Slow

Resin Viscosity too high
Resin Thixotropy too high
Resin is too cold
Bag is too cold
Equipment problems

Resin Viscosity too high
Resin Thixotropy too high
Resin is too cold
Bag is too cold
Equipment problems

Slugging in Service Connections

Too much resin in the bag
Pressure too high
Resin too thin
Resin gel time too slow
Initiators old
Wrong initiators used
Bag heated too slowly

Too much resin in the bag
Inversion head too high
Cooking head too high
Resin too thin
Resin gel time too slow
Initiators old
Wrong initiators used
Bag heated too slowly

Bag Gels Prematurely

Resin catalyzed stability too short
Too much heat history on resin and bag
Initiator level(s) too high
Wrong initiator system used for resin

Resin catalyzed stability too short
Too much heat history on resin and bag
Initiator level(s) too high
Wrong initiator system used for resin

Finning

Bag dimensions incorrect

Bag dimensions incorrect

Lifting or Soft Spots

Condensation in liner
Heat sink outside of liner

Lay flat splice reversed
Hole in lay flat
Insufficient heat to all areas of liner
Resin gel time too long
Cold water infiltration behind liner
Catalyst level too low
Cooking time too short

Low Spots in Line

Insufficient heat to all areas of liner
Resin gel time too long
Catalyst level too low
Cooking time too short
Leak in liner

Cracking – Circumference

Inappropriate initiator system used
Laminate too hot
Cool down too fast
Excessive resin shrink
Excessive external impact forces

Inappropriate initiator system used
Laminate too hot
Cool down too fast or liner too hot when water evacuated
Excessive resin shrink
Excessive external impact forces

Cracking – Lengthwise

Inappropriate initiator system used
Excessive external impact forces

Inappropriate initiator system used
Excessive external impact forces

Blistering

Hot air temperature too high
Resin gelling too slowly
Improper initiators or initiator levels used

For more detailed processing suggestions, refer to our CIPP CD. To obtain your free CD, visit www.interplastic.com/CIPP.

