

Overview of trimming the liner and compression pressure

Overview of trimming the liner		
Nominal diameter		Trimming the liner
mm	inch	mm
DN 100 - DN 150 mini	4"	75-85
DN 150 - DN 400	6"	130-140
DN 450 - DN 600	18"	170-180
DN 700	28"	180-200
DN 800	32"	260-280

Overview compressions pressure				
Nominal diameter		Holding pressure	Positioning pressure	Application pressure
mm	inch	bar	bar	bar
DN 100 - DN 150 mini	4"	max 0.5	2.0 -2.5	6.0 - 6.5
DN 150 - DN 200	6"	max 0.5	2.0 -2.5	5.0 - 5.5
DN 225 - DN 400	9"	max 0.5	2.0 -2.5	4.0 - 4.5
DN 450 - DN 800*	18"	max 0.5	2.0 -2.5	3.5 - 4.5

Particularly in DN 800 pipes, the sleeve needs plenty of time to open the full distance. Increase the pressure to the sleeve in stages and let it expand to the fullest extent for each stage.