



PROPER CARE OF LMK 656 POLYESTER RESIN AND CATALYST

PROMOTED LMK 656 The promoted thermoset polyester resin should be stored in a cool, dry area. The ideal temperature is 60°f. The resin can be chilled prior to liner impregnation. Avoid excessive heating and cooling of the resin prior to installation. Keep the thermoset resin out of direct sunlight, away from sparks and open flame. Protective gear should be worn when handling this product. Shelf life of LMK 656 Polyester resin is 6 months. See MSDS sheet for further information. LMK will promote the steam cure mix resin prior to shipping based on the season and ambient temperatures.

CATALYST The catalyst should be stored in a cool, dry area and kept between 55°f and 70°f. Keep hardener away from excessive heat, sparks, open flame and direct sunlight. Protective gear should be worn when handling this product. See MDS sheet for further information.

MIXING RESIN Upon opening the pre-measured kit, the promoted thermoset resin should be thoroughly mixed. Next, the pre-measured catalyst is dispensed into the pail. Once the catalyst is added there is a specific time before the resin system will gel and then cure. Temperature (resin and ambient) affects the gel and cure. The mixing ratio is variable based on length of liner tube and required working time. LMK 656 resin and catalyst may have a mixing ratio ranging from 1: 1.5% up to 2.5% (resin:catalyst).

Resin consumption via vacuum impregnation:

4-inch @ 3mm = .92-lbs/L.F.

6-inch @ 3mm = 1.27-lbs/L.F.

6-inch @ 4.5mm = 1.9-lbs/L.F.

GEL-TIME Steam cure mix will generally gel in 2 to 3 hours @ 72-degrees F.

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CURE-TIME

Steam cure mix will generally cure within 30-minutes including cool down.

WETOUT

Compliant with ASTM F2561

Connect the vacuum pump hose to the closed mainline sheet.

- Start the pump and ensure approximately 20-inches of mercury is pulled.
- Mix the resin with the catalyst completely so the color is constant with no discoloration.
- The catalyzed resin is introduced into the open end of lateral liner tube.
- The slug of resin is moved through the liner tube by the action of a weighted roller.
- Thorough impregnation is visually verified by the technician and inspector as the liner is positioned within a translucent inversion bladder.
- Next, the open end of the lateral inversion bladder is prepared by creating the steam exhaust port and sealing the bladder end by inserting a brass grommet in conjunction with the combination of ½-inch rope tied in a series of half hitch configurations.
- Load the lateral liner/bladder assembly in through the aperture of the launching until the assembly is fully drawn into the lay-flat hose.
- Insert fixture pins in the mainline bladder ensuring proper placement of the bladder on the launching device.
- Secure and seal the ends of the mainline bladder by attaching a double wrapped stainless steel band to each end of the launching device.
- Firmly wrap the flat sheet liner forming a tube.
- Place 2-hydrophilic O-rings on each side of the lateral connection. (4) in total.
- Mark the main/lateral connection by applying marking paint for visual positioning.
- Wet out procedure is complete.

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INFLATION PRESSURE 5-6 PSI

CURING SCHEDULE The curing schedule should take 20-minutes @ 240-degrees F. and cool down for 10-minutes.

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