



LINK-PIPE[®]

INC.

Manufacturer of No-Dig Pipe Repair Products

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Link-Pipe Slotted Sewer Sealer[™] Installation Tips

<p>Slotted Sewer Sealer[™]</p>  <p>Product Series "SSS"</p>	<p><u>Sewers</u></p> <p>Pipe Materials:</p> <ul style="list-style-type: none">• Concrete• Reinforced Concrete• Steel• Cast Iron• PVC• HDPE <p>Pipe Diameter: Ø4 to 48 Inch</p>	<p>Link-Pipe Slotted Grouting Sleeve[™] has stainless steel core with slots and strips*.</p> <p>These slots and strips allow the shaping of the sleeves by repeating the abnormal shape of pipes and conduits.</p> <p>Note: Installer should exercise extreme care when the Sleeve-Plug Assembly is passing offsetting in pipes, bumps inside pipe, protruded welding seams, pipe bends, et cetera.</p> <p>*US patent Pending</p>
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Recommended Grout:

Link-Pipe Inc. recommends that **G-101 Grout** is used with **Link-Pipe Slotted Sewer Sealer[™]** for Sealing Infiltration and offset repair. The G-101 grout expands about 4 times and together with the Slotted Sewer Sealer[™], forms a rubber-like structure; which has excellent sealing capability.

Grout Application:

All Grout supplied with the sleeve must be used.

Grout should be stored in a dry and cool place at all times.

Pour the Grout slowly onto the gasket. Use a paint roller (provided in the package) to work the Grout into the gasket. The area of the gasket under the "flap" (The so-called "flap" is the top loose foam sheet not glued to the sleeve) must be filled first (See Pic.1), after which the rubber bands are applied to keep the flap in place (Pic.2). The rest of the gasket is then filled with the remaining Grout. **Grout must be applied evenly. The Grout is easily absorbed and could leave some part of the gasket empty if it is not carefully and evenly spread. This may cause a failure in sealing.**

Warning:

Water must be poured onto the Grout before the sleeve is inserted into the pipe. The Grout starts reacting within 18 to 20 minutes after coming into contact with water. If the sleeve is not installed within 18 to 20 minutes after the reaction with water, the grout may already be in the final stage of curing. Therefore, no time should be wasted after the Grout is put into contact with water. **The sooner the sleeve is installed, the thinner the grout mixture is, the easier the installation will be and better sealing.**

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Preparation for the Sleeve Installation:

In preparation for the sleeve installation, the installation plug must be calibrated. “**Calibration Pressure**” is the pressure required to inflate the plug only to the diameter of the inside diameter of the host pipe (See Pic.3). In the photos below, an example is provided. Here the Calibration Pressure equals 30psi (see Pic.4)



Pic.1



Pic.2



Pic.3



Pic.4



Pic.5



Pic.6

Installation:

1. Apply the Grout onto the sleeve gasket (see **Grout Application**).
2. Insert the plug into the sleeve and center the sleeve on the plug*.
* Note: For small diameters the plug is equipped with centralizing cones instead of wheels (Pic.5).
3. Orient the sleeve on the plug so that the label is up (at 12 o'clock of the crown of the sleeve).
4. Carefully inflate the plug a little bit just to keep the sleeve from moving on the plug while traveling in the pipe. If too much pressure is applied, the sleeve may open prematurely or if the pressure drops, the sleeve may slip. Both could result in lost control when the assembly is being transported in the sewer.
5. Before inserting the plug-sleeve assembly into the sewer, the sleeve should be flushed over with cool water, so that the entire surface of the Grout-filled gasket is wet.
6. Pull the plug-sleeve assembly to the repair site. For the purpose of keeping good control over the installation process, the installer must monitor the accuracy of locating the plug-sleeve assembly over the intended repair site. It is always helpful to accurately predetermine the distance from pipe entrance at the Manhole to the damaged area, and mark the camera cable for later easy reference.
7. **To install the sleeve, bring the air pressure to 30 to 35psi** above the calibration pressure.**

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**** Note:** The relatively high installation pressure is needed for possibility to envelop any irregularities such as offset drop in the pipe line. The slotted sleeve can repair an offset joint without disturbance an existing offset drop (Pic.6). It is obvious that the pipe drop must be located in the middle of the sleeve (and slots in the SST core).

8. Hold the pressure until the pressure in the Flow-Through Plug equalized to the Pressure Gauge. Release the air pressure and, using the camera, check to see if all the locks are engaged along a single row in each part of the split sleeve; if locks are not engaged along a single row, insert the plug again, move the plug to the sleeve end with smaller diameter and apply 5psi more pressure.

It is not a problem if water builds up during the installation and the sight is lost. Simply apply the prescribed pressure with an added 5-psi and do it all within the 20 minutes of allocated time.

For more information, please call Lembit (Lem) Maimets or Danny Gan at 1-800-265-5696.

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