LINK-PIPE® INC.
Manufacturer of No-Dig Pipe Repair Products

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Link-Pipe Jacketed End Sealer™
Installation Tips

Jacketed End Sealer™ Sleeve  Product Series "ESJ"	**Pipe Materials:** ➢ Concrete ➢ Reinforced Concrete ➢ Steel ➢ Cast Iron ➢ PVC ➢ HDPE **Pipe Diameter:** ∅4 Inch to 48 Inch	Link-Pipe Jacketed End Sealer™ Sleeve has two layers from different materials.* The inner perforated SST layer is mechanically locked in place and does not depend on internal or external pressure changes. The outer resilient layer is compressed between SST core and a host pipe wall. The diameter of this layer varies with the plastic host pipe or CIPP liner diameter which depends on operation pressure and temperature. The sealing efficiency of the Sleeve increases with higher operation (internal) pressure. *US patent Pending

1. Carefully remove End Sealer Sleeve from the package (Pic.1). Don't use sharp knife in order not to damage rubber parts in the box!

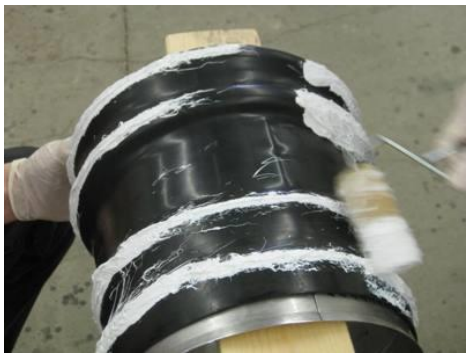
Note: Rubber jacket may be in black or white color.

2. Clean the Sleeve's Jacket (with dry cloth), the Host Pipe and CIPP Liner, areas to be located under the Sleeve. The Host Pipe area must be cleaned to the bare metal.

Apply **Sikaflex-221** Adhesive Sealant evenly to cover the Rubber Jacket in the area of the protruding O-Rings (Pics.2 & 3). The thickness of the applied adhesive bands is approximately 1 to 3mm. No gaps in the applied grout are allowed. To distribute adhesive evenly a paint roller is recommended. To speed-up curing time evenly spray small quantity of water as mist on applied Adhesive (Pic.4).

Pic.1

Pic.2



Pic.3

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Notes:

- Carefully read the Safety Instructions before using the plug.
- Keep the sleeve to be installed at 20°C to 25°C. It is needed to keep rubber parts at the prescribed durometer.

3. Carefully insert Sleeve into the Host Pipe (Pic.5) and orient the Sleeve in the Pipe so that the locking mechanism is located at 12 O-clock (Pic.6). The Sleeve area with bigger O-Rings should be located in the Host Pipe, and area with smaller O-Rings should be located in the CIPP Liner.

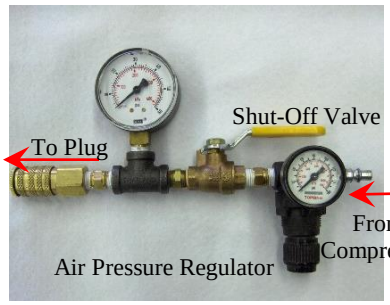
Pic.4

Pic.5

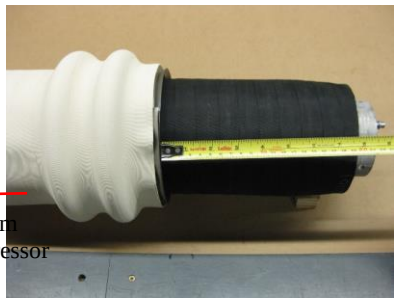
Pic.6

4. Attach Air Hose to the Plug, and Air Pressure Regulator (Pic.7) to the upper end of the Air Hose. Connect Regulator with Air Compressor by another shorter Air Hose. Carefully insert Plug into, and locate it as shown on the Pic.8 (The plug rubber is approximately 8" out from the Sleeve's edge). This plug location is caused by high tensile resistance of the large O-Rings. Installer should pay special attention on the sleeve edges during the sleeve expansion. If sleeve starts to expand as a cone (edges are not parallel) as shown on the Pic.9, release the air pressure and relocate the plug (slightly move the plug to the end with smaller diameter).

5. To install the sleeve, bring the air pressure to 70 - 90psi.



Pic.7



Pic.8

Pic.9

Pic.10

6. Release the air pressure, remove the Plug, and check that all locks are engaged along a single row (Pic.10); if locks are not engaged along a single row, insert the plug again, move the plug to the end with smaller diameter and apply 5 to 10psi more pressure. Check again.

7. Wait for 24 hours before putting the host pipe into service.

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