



Installation of Weholite® Reline Pipe with Wehoseal® Joint Wrap

General

Threaded Weholite® pipe joints will move laterally since the engagement between mating threads is not a positive engagement. The lateral movement at the joint may be as much as 25% of the pipe wall thickness (when ‘thickness’ is measured from the outside of the exterior skin to the inside of the interior skin).

Wehoseal® joint wrap reduces this lateral movement and helps prevent the flow of grout through the joint area and into the pipe.

When the ambient temperature during insertion of the liner pipe into the host pipe is above 40°F / 5°C, the Wehoseal® joint wrap has sufficient flexibility to resist the shear forces caused by the differential movement of the threaded pipes at the joint. However, the ability of the wrap to deform to accommodate this lateral movement is significantly reduced at temperatures below 40°F. At extreme low temperatures, rough handling may cause the Wehoseal® to break.

Pipe Staging Recommendation

KWH Pipe recommends that threaded Weholite® liner pipe should be joined (by threading) to the adjacent pipe in a staging area that is properly aligned with the host pipe. The grade and orientation of the host and liner pipe should be selected to enable a ‘straight’ insertion. This will reduce significantly the potential for differential movement of adjacent pipes at the joint. Regardless of the ambient air temperature during Wehoseal® installation, and during insertion of the Weholite® liner pipe into the host pipe, there should be no damage to the Wehoseal® if the liner and host pipe are properly aligned.

Threaded and Wehoseal® wrapped Weholite® pipe should never be assembled in a staging area that is not properly aligned with the host pipe. If it is necessary to assemble longer lengths of liner pipe away from the host pipe, the appropriate pipe joining method is by extrusion welding.

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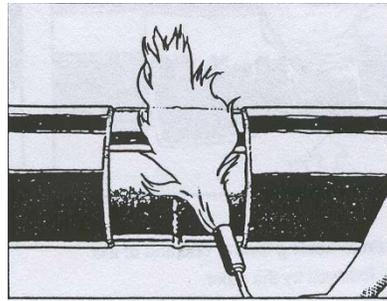
Materials and Equipment:

1. Appropriate size **W**ehoseal sleeve and closure
2. Propane tank
3. AD-1358 Propane regulator and gauge
4. AD-1434 30-foot propane hose
5. Propane torch and 2954 burner
6. Contact pyrometer
7. Hand roller (curved)
8. Hand roller (straight)
9. Standard safety equipment such as: gloves, goggles, hard hat, etc...

Installation is to be done according to local government regulations and all safety precautions must be taken.

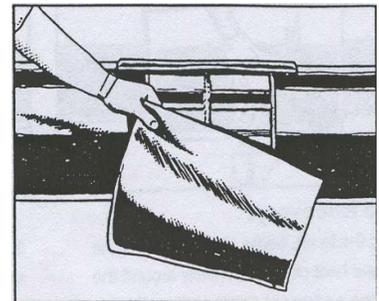
NOTE:

For sleeves 12" (300mm) in diameter and larger, two people for installation are recommended



Sleeve Application:

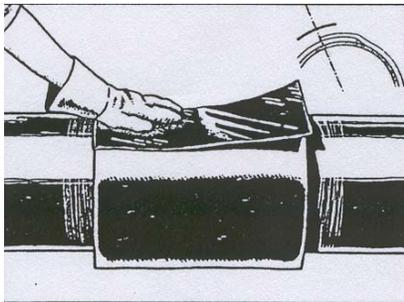
1. Clean exposed pipe to be covered by the sleeve to be removed loose and foreign materials. Wiping may be necessary to remove the particles from cleaning.
2. Butt and align the pipe ends.
3. Preheat the joint area to approximately 158°F (70°C) minimum. Preheating reduces installation time and ensures proper bonding of the sleeve.



4. Remove the protective release plastic from the coated sleeve. Center the sleeve over the joint so it is evenly overlapping the adjacent pipe. Wrap loosely around pipe so that the logo runs circumferentially around the pipe.

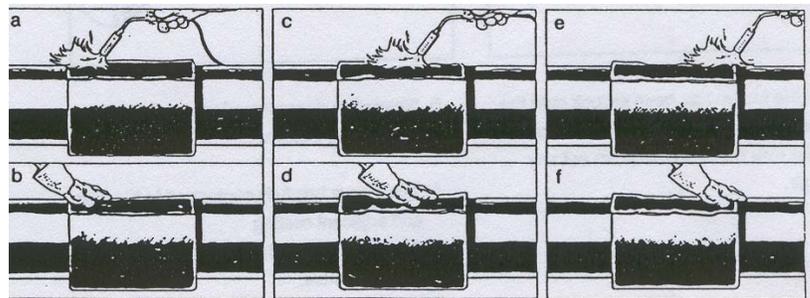
NOTE:

- 1) Clean the overlap area of the sleeve to remove dirt and other foreign materials.
- 2) Overlap ends of sleeve should align evenly.
- 3) Position overlap to permit easy access for installing closure.



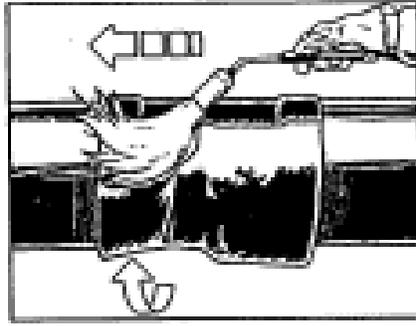
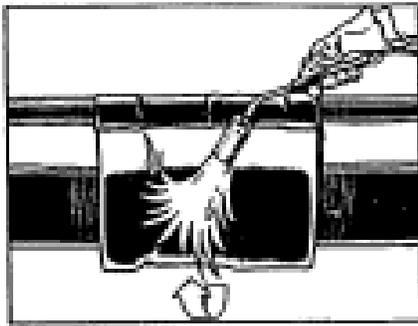
Closure Application:

1. Press the closure in position, centering over the exposed sheet end. The sheet should overlap the sheet (excluding closure) by 2" (50mm) minimum.



2. Using a torch, adjust the flame length to approximately 20" (50cm) to produce a yellow flame. Using the yellow portion of the flame, heat the closure evenly until the pattern of the fabric reinforcement is visible.

With a gloved hand, pat down the closure and smooth away any wrinkles by gently working them outward from the center of the closure.



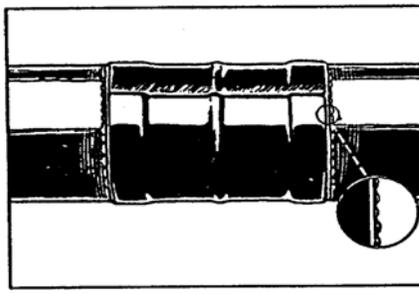
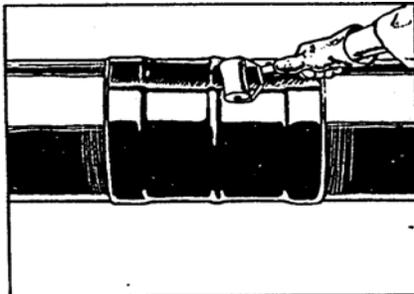
Sleeve Recovery:

1. Using the torch, begin at the center of the sleeve and heat circumferentially around the pipe, using a constant paintbrush motion.

2. Continue heating toward one end of the sleeve, followed by the other.

3. During shrinkdown, occasionally check adhesive flow with gloved finger. Wrinkles should disappear automatically.

NOTE: The sleeve may be recovered starting at one end and proceeding toward the opposite end, depending on conditions (i.e. wind).



4. When the sleeve has been shrunk onto the joint area, and is still hot and soft, run a small hand roller over the sleeve to push out any trapped air.

Sleeve is fully recovered when all of the following have occurred:

- 1) The sleeve has fully conformed to the pipe and adjacent coating.
- 2) There are NO cold spots or dimples on the sleeve surface.
- 3) After sleeve is cool, adhesive flow is evident on both edges.

Wehoseal Length Required per Joint		
Nom Size (inch)	Max. OD (inch)	Length (ft)
18	20.4	5.90
19.5	22.4	6.40
21	23.6	6.80
24	27	7.70
27	30.4	8.50
30	33.8	9.40
33	37.6	10.40
36	40.6	11.20
40	45.1	12.40
42	47.4	13.00
48	53.7	14.60
54	60.4	16.40
60	67.1	18.20
66	73.8	19.90
72	80.5	21.70
78	86.5	23.20
84	93.2	25.00
90	99.2	26.60
96	100.6	26.90
102	107.4	28.70
108	120.8	32.20
120	134.2	35.70



The length of a standard roll of Wehoseal is 100'. The length per nominal size is based on providing 7" of overlap on the largest OD in that size. The overlap for stiffness classes other than the highest stiffness will exceed 7".