

## 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 - 4.0            |
| 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.