

Resin consumption BRAWOLINER® with BRAWO® UVPox US

BRAWOLINER®

DN	To achieve a wall thickness of min. 3 mm / 0.12"		Reduced wall thickness of min. 2 mm / 0.08" (Inhouse)	
	Roller spacing	BRAWO® UVPox US in lbs / foot	Roller spacing	BRAWO® UVPox US in lbs / foot
50 (2")			4.0 mm / 0.16"	0.2
70 (3")			6.5 mm / 0.26"	0.4
100 (4")	8.5 mm / 0.33"	0.7	7.0 mm / 0,28"	0.7
125 (5")		0.9		0.9
150 (6")		1.1		1.1
200 (8")		1.5		1.5

BRAWOLINER® 3D

DN	To achieve a wall thickness of min. 3 mm / 0.12"		Reduced wall thickness of min. 2 mm / 0.08" (Inhouse)	
	Roller spacing	BRAWO® UVPox US in lbs / foot	Roller spacing	BRAWO® UVPox US in lbs / foot
70-100 (3"-4")	10.0 mm / 0,39"	0.6	6.5 mm / 0,26"	0.6
100-150 (4"-6")	12.0 mm / 0,4"	1.0	10.0 mm / 0,39"	1.4
150-225 (6"-9")		1.5		2.2
200 – 300 (8"-12")	14.0 mm / 0.55"	2.8		

BRAWOLINER® XT

DN	Roller spacing	BRAWO® UVPox US in lbs / foot
100	11.0 mm	1.1
125		1.3
150		1.5
200		2,1

All statements are to be understood as approximate and are based on values determined by experiment. Variations are possible depending on ambient conditions.

BRAWOLINER® epoxy resin consumption

BRAWOLINER® / BRAWOLINER® HT

DN	To achieve a wall thickness of min. 3 mm / 0.12"	
	Roller spacing	BRAWO® I US BRAWO® III US BRAWO® SRR US in lbs / foot
50 (2")	7.0 mm / 0.28"	0.3
70 (3")	8.5 mm / 0.33"	0.5
100 (4")		0.7
125 (5")		0.9
150 (6")		1.1
200 (8")		1.5

BRAWOLINER® 3D / BRAWOLINER® HT 3D

DN	To achieve a wall thickness of min. 3 mm / 0,12"	
	Roller spacing	BRAWO® I US BRAWO® III US BRAWO® SRR US in lbs / foot
70-100 (3"-4")	10.0 mm/ 0.39"	0.6
100-150 (4"-6")	12.0 mm / 0.47"	1.0
150-225 (6"-9")		1.5

Processing and curing times BRAWO® epoxy resins

Resin types and areas of use								
BRAWO® Resin type	Processing time saturated liner @ 15°C	approx. curing temperatures and times						
		10°C	20°C	30°C	40°C	50°C	60°C	70°C
		BRAWO® SRR ***)	30 min	4 h	2 h	80 min	50 min	30 min
BRAWO® RR ***)	30 min	6 h	3 h	2 h	1,5 h	75 min	-	-
BRAWO® I	50 min	13 h	6 h	3,5 h	150 min	100 min	70 min	45 min **)
BRAWO® III	3,5 h	24 h	12 h	9 h	6 h	220 min	180 min	140 min **)
BRAWO® TC *)	8 h	-	-	-	-	-	9 h	5 h
BRAWO® HT	70 min @ 20°C	24 h	13 h	6,5 h	3,5 h	140 min	100 min	80 min **)

*) Only usable for BRAWOLINER® 3D DN 300-400

***) Only in combination with BRAWOLINER® HT or with a suitable calibration CIPP

***) Caution: When curing BRAWO® RR and BRAWO® SRR with steam, there is a risk of extreme temperature development as a result of the exothermic resin reaction. Therefore, curing with steam is not recommended.