Omega Liner Curing Guidelines

Diameter (in)	Diameter (mm)	Thickness (mm)	Operating pressure at least mbar (psi)	Chain 8 x 400	Chain 8 x 600	LS Chain 10 x 650	Chain 12 x 400	Chain 6 x 1000	Chain 9 x 1000	LS Core Chain 5 x 2000	Double Core 2 x 4000	Double Core 3 x 4000	Prokassro Super Core 2 x 6000	IBG Super Core 1 x 12000	IST Super Core 3 x 6000
				Curing Speed Range Meters / Minute											
6	152	2.4	550 (8.0)	1.4 - 1.6	1.8 -2.1	1.8 -2.1	1.8 -2.1								
		3.6		1.3 - 1.5	1.6 - 1.8	1.6 - 1.8	1.6 - 1.8								
		4.8		1.2 - 1.4	1.4 - 1.6	1.4 - 1.6	1.4 - 1.6								
8	203	2.4	550 (8.0)	1.3 - 1.5	1.8 - 2.0	1.8 - 2.0	1.8 - 2.0								
		3.6		1.2 - 1.4	1.5 - 1.7	1.5 - 1.7	1.5 - 1.7								
		4.8		1.0 - 1.2	1.3 - 1.5	1.3 - 1.5	1.3 - 1.5								
		6.0		0.9 - 1.1	1.1 - 1.3	1.1 - 1.3	1.1 - 1.3								
10	254	2.4	500 (7.25)	1.2 - 1.4	1.7 - 1.9	1.7 - 1.9	1.7 - 1.9								
		3.6		1.0 - 1.2	1.5 - 1.7	1.5 - 1.7	1.5 - 1.7								
		4.8		.9 - 1.1	1.3 - 1.5	1.3 -1.5	1.3 -1.5								
		6.0		.8 - 1.0	1.1 - 1.3	1.1 -1.3	1.1 -1.3								
12	305	3.6	500 (7.25)	1.0 - 1.2	1.1 - 1.3	1.1 - 1.3	1.1 - 1.3								
		4.8		.8 - 1.0	.9 - 1.1	.9 - 1.1	.9 - 1.1								
		6.0		.7 - .9	.8 - 1.0	.8 - 1.0	.8 - 1.0								
15	381	3.6	500 (7.25)	0.8 - 1.0	.9 - 1.1	0.9 - 1.1	0.9 - 1.1								
		4.8		.7 - .9	.8 - 1.0	.8 - 1.0	.8 - 1.0								
		6.0		.5 - .7	.6 - .8	.6 - .8	.6 - .8								
16	406	4.8	500 (7.25)	.7 - .9	.8 - 1.0	.8 - 1.0	.8 - 1.0								
		6.0		.5 - .7	.6 - .8	.6 - .8	.6 - .8								
18	457	4.8	450 (6.5)	.6 - .75	.7 - .85	.7 - .85	.7 - .85								
		6.0		.5 - .65	.6 - .75	.6 - .75	.6 - .75								
20	508	4.8	400 (5.8)	.5 - .65	.6 - .75	.6 - .75	.6 - .75								
		6.0		.4 - .55	.5 - .65	.5 - .65	.5 - .65								
		7.2		.3 - .45	.4 - .55	.4 - .55	.4 - .55								
21	533	4.8	400 (5.8)	.5 - .65	.6 - .75	.6 - .75	.6 - .75								
		6.0		.4 - .55	.5 - .65	.5 - .65	.5 - .65								
		7.2		.3 - .45	.4 - .55	.4 - .55	.4 - .55								
24	610	4.8	350 (5.0)	.7 - .9	.8 - 1.0	.8 - 1.0	.8 - 1.0	.8 - 1.0	1.1 - 1.3	1.1 - 1.3	1.1 - 1.3				
		6.0		.65 - .85	.75 - .95	.75 - .95	.75 - .95	.75 - .95	1.0 - 1.2	1.0 - 1.2	1.0 - 1.2				
		7.2		.6 - .8	.7 - .9	.7 - .9	.7 - .9	.7 - .9	.9 - 1.1	.9 - 1.1	.9 - 1.1				
		8.4		.55 - .75	.65 - .85	.65 - .85	.65 - .85	.65 - .85	.8 - 1.0	.8 - 1.0	.8 - 1.0				
		9.6		.45 - .65	.55 - .75	.55 - .75	.55 - .75	.55 - .75	.7 - .9	.7 - .9	.7 - .9				
		10.8		.35 - .55	.45 - .65	.45 - .65	.45 - .65	.45 - .65	.6 - .8	.6 - .8	.6 - .8				

Note: For Small Diameters and Cold temperatures additional pressure may be needed to fully calibrate the Liner. Liner must have full safety caps and be monitored at all times if exceeding the operating pressure. Pressure should be increased at 50mb increments with 3-5min delay at each step until calibration is achieved. Pressure should then be reduced incrementally to the specified operating pressure.

Diameter (in)	Diameter (mm)	Thickness (mm)	Operating pressure at least mbar (psi)	Chain 8 x 400	Chain 8 x 600	LS Chain 10 x 650	Chain 12 x 400	Chain 6 x 1000	Chain 9 x 1000	LS Core Chain 5 x 2000	Double Core 2 x 4000	Double Core 3 x 4000	Prokassro Super Core 2 x 6000	IBG Super Core 1 x 12000	IST Super Core 3 x 6000
				Curing Speed Range Meters / Minute											
27	686	6.0	350 (5.0)	.4 - .6	.5 - .8	.5 - .8	.5 - .8	.5 - .7	.75 - .95	.7 - .9	.75 - .95				
		7.2		.3 - .5	.4 - .6	.4 - .6	.4 - .6	.4 - .6	.7 - .9	.6 - .8	.7 - .9				
		8.4		.2 - .4	.3 - .5	.3 - .5	.3 - .5	.3 - .5	.65 .85	.5 - .7	.65 .85				
30	762	6.0	300 (4.4)	.4 - .6	.5 - .7	.5 - .7	.5 - .7	.5 - .7	.7 - .9	.7 - .9	.7 - .9				
		7.2		.3 - .5	.4 - .6	.4 - .6	.4 - .6	.4 - .6	.65 - .85	.6 - .8	.65 - .85				
		8.4		.2 - .4	.3 - .5	.3 - .5	.3 - .5	.3 - .5	.6 - .8	.5 - .7	.6 - .8				
		9.6		.1 - .3	.2 - .3	.2 - .3	.2 - .3	.2 - .3	.55 - .75	.4 - .6	.55 - .75				
36	914	6.0	300 (4.4)	.3 - .5	.4 - .5	.4 - .5	.4 - .5	.4 - .5	.6 - .8	.55 - .65	.6 - .8				
		7.2		.2 - .4	.25 - .35	.25 - .35	.25 - .35	.25 - .35	.55 - .75	.45 - .65	.55 - .75				
		8.4		.1 - .3	.15 - .25	.15 - .25	.15 - .25	.15 - .25	.5 - .7	.4 - .6	.5 - .7				
		9.6		.05 - .1	.05 - .1	.05 - .1	.05 - .1	.05 - .1	.3 - .5	.35 - .55	.3 - .5				
42	1067	7.2	250 (3.7)	.2 - .4	.3 - .4	.3 - .4	.3 - .4	.4 - .6	.45 - .65	.45 - .65	.45 - .65	.8 - 1.0	.8 - 1.0	.8 - 1.0	
		8.4		.1 - .3	.15 - .35	.15 - .35	.15 - .35	.35 - .55	.4 - .6	.4 - .6	.4 - .6	.7 - .9	.7 - .9	.7 - .9	
		9.6		.05 - .2	.05 - .3	.05 - .3	.05 - .3	.3 - .5	.35 - .55	.35 - .55	.35 - .55	.6 - .8	.6 - .8	.6 - .8	
		10.8		.05 - .1	.05 - .2	.05 - .2	.05 - .2	.25 - .5	.3 - .5	.3 - .5	.3 - .5	.5 - .7	.5 - .7	.5 - .7	
48	1219	8.4	250 (3.7)	.1 - .3	.15 - .35	.15 - .35	.15 - .35	.2 - .4	.25 - .45	.25 - .45	.25 - .45	.7 - .9	.7 - .9	.7 - .9	
		9.6		.05 - .1	.05 - .2	.05 - .2	.05 - .2	.15 - .35	.2 - .4	.2 - .4	.2 - .4	.6 - .8	.6 - .8	.6 - .8	.65 - .85
		10.8		.03 - .1	.03 - .1	.03 - .1	.03 - .1	.1 - .3	.15 - .35	.15 - .35	.15 - .35	.5 - .7	.5 - .7	.5 - .7	.55 - .75
		12		.01 - .05	.01 - .05	.01 - .5	.01 - .5	.08 - .25	.1 - .3	.1 - .3	.1 - .3	.4 - .6	.4 - .6	.4 - .6	.45 - .65
52	1321	10.8	250 (3.7)							.025 - .1	.025 - .1	.65 - .85	.65 - .85	.65 - .85	.7 - .9
		12								.02 - .07	.02 - .07	.55 - .75	.55 - .75	.55 - .75	.6 - .8
		13.2								.01 - .05	.01 - .05	.45 - .65	.45 - .65	.45 - .65	.5 - .7
54	1372	10.8	250 (3.7)							.02 - .1	.025 - .1	.45 - .65	.45 - .65	.45 - .65	.55 - .75
		12								.02 - .07	.02 - .07	.35 - .55	.35 - .55	.35 - .55	.4 - .6
		13.2								.01 - .05	.01 - .05	.25 - .45	.25 - .45	.25 - .45	.3 - .5
		14.4								.01 - .04	.01 - .04	.2 - .4	.2 - .4	.2 - .4	.25 - .45
60	1524	10.8	250 (3.7)									.45 - .65	.45 - .65	.45 - .65	.5 - .7
		12										.35 - .55	.35 - .55	.35 - .55	.4 - .6
		13.2										.25 - .45	.25 - .45	.25 - .45	.3 - .5
		14.4										.15 - .35	.15 - .35	.15 - .35	.2 - .4
63	1600	10.8	250 (3.7)									.4 - .6	.4 - .6	.4 - .6	.45 - .65
		12										.3 - .5	.3 - .5	.3 - .5	.35 - .55
		13.2										.2 - .4	.2 - .4	.2 - .4	.25 - .45
		14.4										.1 - .3	.1 - .3	.1 - .3	.15 - .35

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Recommended for this size | Not ideal for this size, consider a larger train | This application may cause excessive heating of inner foil consider a lower wattage

For large diameters over 52" particular care should be taken to ensure IR sensors face towards the pipe surface furthest from the bulbs if not running centered in pipe. This will ensure the most accurate feedback of state of liner cure.

For unusual shapes such as eggs, Ovals or archs, use largest dimension of pipe to select curing speed. For oversizes in large elipses and Arches, use closest listed size and use 60- 80% of indicated speed as a guideline. Additionally perform a thump test on starting bell to verify intended pulling speeds.

Whenever curing pipes that fall outside of the settings in this table please contact omega for guidance on recommended settings.

Omega Liner Curing Guidelines

Diameter (in)	Diameter (mm)	Thickness (mm)	Operating pressure at least mbar (psi)	Chain 8 x 400	Chain 8 x 600	LS Chain 10 x 650	Chain 12 x 400	Chain 6 x 1000	Chain 9 x 1000	LS Core Chain 5 x 2000	Double Core 2 x 4000	Double Core 3 x 4000	Prokassro Super Core 2 x 6000	IBG Super Core 1 x 12000	IST Super Core 3 x 6000
				Curing Speed Range Feet / Minute											
6	152	2.4	550 (8.0)	4.7 - 5.3	6 - 7	6 - 7	6 - 7								
		3.6		4.3 - 5	5.3 - 6	5.3 - 6	5.3 - 6								
		4.8		4 - 1.4	4.7 - 5.3	4.7 - 5.3	4.7 - 5.3								
8	203	2.4	550 (8.0)	4.3 - 5	6 - 6.6	6 - 6.6	6 - 6.6								
		3.6		4 - 4.7	5 - 5.7	5 - 5.7	5 - 5.7								
		4.8		3.3 - 4	4.3 - 5	4.3 - 5	4.3 - 5								
		6.0		3 - 3.7	3.7 - 4.3	3.7 - 4.3	3.7 - 4.3								
10	254	2.4	500 (7.25)	4 - 4.7	5.7 - 6.3	5.7 - 6.3	5.7 - 6.3								
		3.6		3.3 - 4	5 - 5.7	5 - 5.7	5 - 5.7								
		4.8		3 - 3.7	4.3 - 5	4.3 - 5	4.3 - 5								
		6.0		2.7 - 3.3	3.7 - 4.3	3.7 - 4.3	3.7 - 4.3								
12	305	3.6	500 (7.25)	3.3 - 4	3.7 - 4.3	3.7 - 4.3	3.7 - 4.3								
		4.8		2.7 - 3.3	3 - 3.7	3 - 3.7	3 - 3.7								
		6.0		2.4 - 3	2.7 - 3.3	2.7 - 3.3	2.7 - 3.3								
15	381	3.6	500 (7.25)	2.7 - 3.3	3 - 3.7	3 - 3.7	3 - 3.7								
		4.8		2.4 - 3	2.7 - 3.3	2.7 - 3.3	2.7 - 3.3								
		6.0		1.7 - 2.4	2 - 2.7	2 - 2.7	2 - 2.7								
16	406	4.8	500 (7.25)	2.4 - 3	2.7 - 3.3	2.7 - 3.3	2.7 - 3.3								
		6.0		1.7 - 2.4	2 - 2.7	2 - 2.7	2 - 2.7								
18	457	4.8	450 (6.5)	2 - 2.5	2.4 - 2.9	2.4 - 2.9	2.4 - 2.9								
		6.0		1.7 - 214.5	2 - 2.5	2 - 2.5	2 - 2.5								
20	508	4.8	400 (5.8)	1.7 - 2.2	2 - 2.5	2 - 2.5	2 - 2.5								
		6.0		1.4 - 1.9	1.7 - 2.2	1.7 - 2.2	1.7 - 2.2								
		7.2		1 - 1.5	1.4 - 1.9	1.4 - 1.9	1.4 - 1.9								
21	533	4.8	400 (5.8)	1.7 - 2.2	2 - 2.5	2 - 2.5	2 - 2.5								
		6.0		1.4 - 1.9	1.7 - 2.2	1.7 - 2.2	1.7 - 2.2								
		7.2		1 - 1.5	1.4 - 1.9	1.4 - 1.9	1.4 - 1.9								
24	610	4.8	350 (5.0)	2.4 - 3	2.7 - 3.3	2.7 - 3.3	2.7 - 3.3	2.7 - 3.3	3.7 - 4.3	3.7 - 4.3	3.7 - 4.3				
		6.0		2.2 - 2.9	2.5 - 3.2	2.5 - 3.2	2.5 - 3.2	2.5 - 3.2	3.3 - 4	3.3 - 4	3.3 - 4				
		7.2		2 - 2.7	2.4 - 3	2.4 - 3	2.4 - 3	2.4 - 3	3 - 3.7	3 - 3.7	3 - 3.7				
		8.4		1.9 - 2.5	2.2 - 2.9	2.2 - 2.9	2.2 - 2.9	2.2 - 2.9	2.7 - 3.3	2.7 - 3.3	2.7 - 3.3				
		9.6		1.5 - 2.2	1.9 - 2.5	1.9 - 2.5	1.9 - 2.5	1.9 - 2.5	2.4 - 3	2.4 - 3	2.4 - 3				
		10.8		1.2 - 1.9	1.5 - 2.2	1.5 - 2.2	1.5 - 2.2	1.5 - 2.2	2 - 2.7	2 - 2.7	2 - 2.7				

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Diameter (in)	Diameter (mm)	Thickness (mm)	Operating pressure at least mbar (psi)	Chain 8 x 400	Chain 8 x 600	LS Chain 10 x 650	Chain 12 x 400	Chain 6 x 1000	Chain 9 x 1000	LS Core Chain 5 x 2000	Double Core 2 x 4000	Double Core 3 x 4000	Prokassro Super Core 2 x 6000	IBG Super Core 1 x 12000	IST Super Core 3 x 6000
				Curing Speed Range Feet / Minute											
27	686	6.0	350 (5.0)	1.4 - 2	1.7 - 2.7	1.7 - 2.7	1.7 - 2.7	1.7 - 2.4	2.5 - 3.2	2.4 - 3	2.5 - 3.2				
		7.2		1 - 1.7	1.4 - 2	1.4 - 2	1.4 - 2	1.4 - 2	2.4 - 3	2 - 2.7	2.4 - 3				
		8.4		0.7 - 1.4	1 - 1.7	1 - 1.7	1 - 1.7	1 - 1.7	2.2 - 2.9	1.7 - 2.4	2.2 - 2.9				
30	762	6.0	300 (4.4)	1.4 - 2	1.7 - 2.4	1.7 - 2.4	1.7 - 2.4	1.7 - 2.4	2.4 - 3	2.4 - 3	2.4 - 3				
		7.2		1 - 1.7	1.4 - 2	1.4 - 2	1.4 - 2	1.4 - 2	2.2 - 2.9	2 - 2.7	2.2 - 2.9				
		8.4		0.7 - 1.4	1 - 1.7	1 - 1.7	1 - 1.7	1 - 1.7	2 - 2.7	1.7 - 2.4	2 - 2.7				
		9.6		0.4 - 1	0.7 - 1	0.7 - 1	0.7 - 1	0.7 - 1	1.9 - 2.5	1.4 - 2	1.9 - 2.5				
36	914	6.0	300 (4.4)	1 - 1.7	1.4 - 1.7	1.4 - 1.7	1.4 - 1.7	1.4 - 1.7	2 - 2.7	1.9 - 2.2	2 - 2.7				
		7.2		0.7 - -1.4	0.9 - 1.2	0.9 - 1.2	0.9 - 1.2	0.9 - 1.2	1.9 - 2.5	1.5 - 2.2	1.9 - 2.5				
		8.4		0.4 - 1	0.5 - 0.9	0.5 - 0.9	0.5 - 0.9	0.5 - 0.9	1.7 - 2.4	1.4 - 2	1.7 - 2.4				
		9.6		0.2 - 0.4	0.2 - 0.4	0.2 - 0.4	0.2 - 0.4	0.2 - 0.4	1 - 1.7	1.2 - 1.9	1 - 1.7				
42	1067	7.2	250 (3.7)	0.7 - 1.4	1 - 1.4	1 - 1.4	1 - 1.4	1.4 - 2	1.5 - 2.2	1.5 - 2.2	1.5 - 2.2	2.7 - 3.3	2.7 - 3.3	2.7 - 3.3	
		8.4		0.4 - 1	0.5 - 1.2	0.5 - 1.2	0.5 - 1.2	1.2 - 1.9	1.4 - 2	1.4 - 2	1.4 - 2	2.4 - 3	2.4 - 3	2.4 - 3	
		9.6		0.2 - -0.7	0.2 - 1	0.2 - 1	0.2 - 1	1 - 1.7	1.2 - 1.9	1.2 - 1.9	1.2 - 1.9	2 - 2.7	2 - 2.7	2 - 2.7	
		10.8		0.2 - 0.4	0.2 - 0.7	0.2 - 0.7	0.2 - 0.7	0.9 - 1.7	1 - 1.7	1 - 1.7	1 - 1.7	1.7 - 2.4	1.7 - 2.4	1.7 - 2.4	
48	1219	8.4	250 (3.7)	0.4 - 1	0.5 - 1.2	0.5 - 1.2	0.5 - 1.2	0.7 - 1.4	0.9 - 1.5	0.9 - 1.5	0.9 - 1.5	2.4 - 3	2.4 - 3	2.4 - 3	
		9.6		0.2 - 0.4	0.2 - 0.7	0.2 - 0.7	0.2 - 0.7	0.5 - 1.2	0.7 - 1.4	0.7 - 1.4	0.7 - 1.4	2 - 2.7	2 - 2.7	2 - 2.7	2.2 - 2.9
		10.8		0.1 - 0.4	0.1 - 0.4	0.1 - 0.4	0.1 - 0.4	0.4 - 1	0.5 - 1.2	0.5 - 1.2	0.5 - 1.2	1.7 - 2.4	1.7 - 2.4	1.7 - 2.4	1.9 - 2.5
		12		0.1 - 0.2	0.1 - 0.2	0.1 - 1.7	0.1 - 1.7	0.3 - 0.9	0.4 - 1	0.4 - 1	0.4 - 1	1.4 - 2	1.4 - 2	1.4 - 2	1.5 - 2.2
52	1321	10.8	250 (3.7)							0.1 - 0.4	0.1 - 0.4	2.2 - 2.9	2.2 - 2.9	2.2 - 2.9	2.4 - 3
		12								0.1 - 0.3	0.1 - 0.3	1.9 - 2.5	1.9 - 2.5	1.9 - 2.5	2 - 2.7
		13.2								0.1 - 0.2	0.1 - 0.2	1.5 - 2.2	1.5 - 2.2	1.5 - 2.2	1.7 - 2.4
54	1372	10.8	250 (3.7)							0.1 - 0.4	0.1 - 0.4	1.5 - 2.2	1.5 - 2.2	1.5 - 2.2	1.9 - 2.5
		12								0.1 - 0.3	0.1 - 0.3	1.2 - 1.9	1.2 - 1.9	1.2 - 1.9	1.4 - 2
		13.2								0.1 - 0.2	0.1 - 0.2	0.9 - 1.5	0.9 - 1.5	0.9 - 1.5	1 - 1.7
		14.4								0.1 - 0.2	0.1 - 0.2	0.7 - 1.4	0.7 - 1.4	0.7 - 1.4	0.9 - 1.5
60	1524	10.8	250 (3.7)									1.5 - 2.2	1.5 - 2.2	1.5 - 2.2	1.7 - 2.4
		12										1.2 - 1.9	1.2 - 1.9	1.2 - 1.9	1.4 - 2
		13.2										0.9 - 1.5	0.9 - 1.5	0.9 - 1.5	1 - 1.7
		14.4										0.5 - 1.2	0.5 - 1.2	0.5 - 1.2	0.7 - 1.4
63	1600	10.8	250 (3.7)									1.4 - 2	1.4 - 2	1.4 - 2	1.5 - 2.2
		12										1 - 1.7	1 - 1.7	1 - 1.7	1.2 - 1.9
		13.2										0.7 - 1.4	0.7 - 1.4	0.7 - 1.4	0.9 - 1.5
		14.4										0.4 - 1	0.4 - 1	0.4 - 1	0.5 - 1.2

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