

# Omega Liner Curing Guidelines

Diameter (in)	Diameter (mm)	Thickness (mm)	Operating pressure at least (psi)	Chain				LS Core	Double Core	Double Core	Prokassro Super Core	BG Super Core	IST Super Core			
				8 x 400	8 x 600	10 x 650	12 x 400							6 x 1000	9 x 1000	5 x 2000
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	.9 - 1.1	.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					
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		
		10.8		.03 - .1	.03 - .1	.03 - .1	.03 - .1	.1 - .3	.15 - .35	.15 - .35	.15 - .35	.5 - .7	.5 - .7	.5 - .7		
		12		.01 - .05	.01 - .05	.01 - .05	.01 - .05	.08 - .25	.1 - .3	.1 - .3	.1 - .3	.4 - .6	.4 - .6	.4 - .6		
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
60	1524	10.8	250 (3.7)							.45 - .65	.45 - .65	.45 - .65	.45 - .65	.5 - .7		
		12									.35 - .55	.35 - .55	.35 - .55	.35 - .55	.4 - .6	
		13.2									.25 - .45	.25 - .45	.25 - .45	.25 - .45	.3 - .5	
		14.4									.15 - .35	.15 - .35	.15 - .35	.15 - .35	.2 - .4	
63	1600	10.8	250 (3.7)							.4 - .6	.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		

Refer to Omega Installation Manual on proper use of this table. This table represents estimated curing speeds, However IR sensor readings must be used to monitor curing and speeds adjusted accordingly. This table is intended for use with Omega Liner Company Products and may not be applicable to other vendors products.

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 ellipses 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.