



## IMPREGNATION OF SLEEVE "IN-SITU"

### Descriptive of the Impregnation IN-SITU

The resin epoxy comes in separated cans, in dose of resin and stiffener, which is mixed and gets in the sleeve.

It(He, She) spreads in all his(her, your) length and later, to assure his(her, your) perfect distribution and to guarantee a minimal thickness, is laminated between(among) two locks. Between (among) both locks there has been left before a space calibrated for the thickness of the sleeve that is wanted to obtain.

#### The conformity of the impregnation depends:

##### 1 ° Of the mixture (mixing) of the resin.

The resin is stored in cans separately (resin in red and stiffener in white (target)) that later mixes with blender. The control of the mixture (mixing) is realized by his (her, your) proportions, besides visually depending on the homogeneity of the colour of the (pink) resin.

##### 2 ° Of the quantity of resin.

The introduced quantity is established depending on the length and the thickness of the sleeve to impregnating. The quantity of resin to introduce is given by the following formula (it (he, she) formulates NORDITUBE):

$Q = \pi \times d \times DN \times Ea \times P$

Q: Quantity of resin (KG/ML) AND: 3.1416

d: Density of the resin (KG/dm<sup>3</sup>)

Dn: nominal Diameter (m)

Ea: Thickness of the sleeve (mm)

P: porous Volume (delivered by the manufacturer)

##### 3 ° Of The space balanced between (among) the locks of impregnation.

This space corresponds (fits) to the double of the thickness of the wall that we want to obtain and that is obtained by the placement of coves measured for every thickness of sleeve.

##### 4 ° of the aspect of the sleeve.

Visual control, to check the homogeneity of the colour of the sleeve The control of conformity;  
To spend (pass) the sleeve between (among) both locks of impregnation and to check.

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