



## Max FLEX 4D™

Max FLEX 4D is a non-woven, needle punched PE felt liner with a unique elastic and impermeable PU coating. This specially designed stitched skived seam and extruded taped joint, make it capable of transitioning up to four diameters (4D) while maintaining finished thickness and negotiating bends up to 90°.

### TECHNICAL DATA:

**Coating:** PU

**Carrying Material:** Polyester Felt

**Seam:** Linear triple stitch with skived overlap and extruded taped joint

**Installation:** Inversion

**Recommended Curing Methods:** Ambient, Heat or Light Cure

**Resin Compatibility:** Use with MaxPox®, VertiPox® Epoxy

Resin Systems, MaxLight® UV LED Resin Systems or approved equal

### DIAMETER RANGE:

3" and larger

3" expands to 4", 4" expands to 6", 6" expands to 8", 8" expands to 10". Larger diameter sizes and lengths available

### THICKNESS RANGE:

4.5 mm

### AVAILABLE MANUFACTURER LENGTHS:

164' and 328' stock lengths (+/-)

Custom longer lengths available.

### APPLICATIONS:

- Open-End (Blindshot) with Calibration Tube
- Closed-End
- Ideal for transitioning sizes / change in diameter.
- May be used on sweeping bends up to 90° with slight wrinkling.
- Custom sizes are available.

### INSTALLATION:

Refer to Field Installation Sheet for resin calculations

**Vacuum:** -0.5 bar

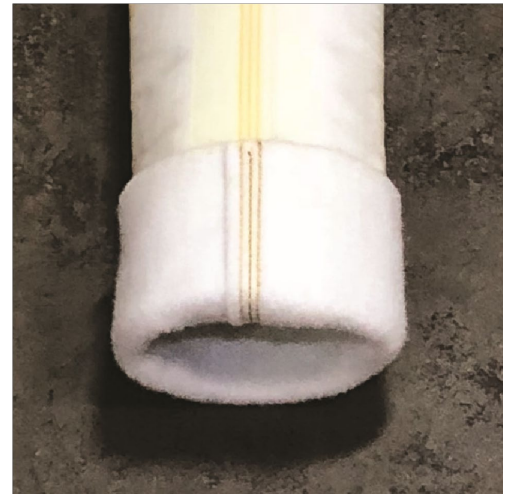
**Calibration Roller recommended gap setting:** Thickness of liner x 2 + 1mm for standard, thickness of liner x 2 + 2mm for transitions

**Installation air pressure:** 7 to 10 psi (may need additional pressure to invert around bends).

**Curing pressure:** 6 to 8 psi. Consult with MaxLiner regarding dimensional changes and curing methods.

**Heat curing:** 120-185°F without CalTube, must use CalTube when steam curing.

*Vacuum level shall meet or slightly exceed inversion and curing Pressure. Always use a vacuum with proper vacuum gauge and regulator. Always use a guide tube to contain unsupported liners from radial expansion.*





## STORAGE/HANDLING:

### Avoid extremes of temperature

- Freezing may cause the coating structure to degrade locally, especially areas where the coating is in tension or compression – at bends and edges, and immediately adjacent to seam welds.
- Recommended storage temperature 40°F – 95°F.
- Shelf life at this temperature: in excess of 1 year.

### Avoid extremes of humidity

- Very high relative humidity (especially at high temperature such as tropical countries) will accelerate the degradation, consequently reducing the shelf life.
- Recommended storage humidity 25% rh – 65% rh.
- Shelf life at 65%, 95°F: in excess of 1 year.

### Avoid prolonged wet storage

As with high humidity, the coating is more susceptible to degradation at higher temperatures, and even further susceptible if pH of liquid in contact is significantly above or below 45°F. Wet storage is not recommended.

### Avoid direct sunlight

Prolonged exposure to the sun's ultra-violet light will accelerate the degradation of the coating. Store away from direct sunlight, preferably in dark conditions.

### Mechanical damage should be avoided

- Ensure that liner is not placed directly onto grit or gravel floor – sweep and cover floor first.
- Ensure personnel are instructed not to walk on or smoke around the liner.
- Handle with care and ensure safe transport at all times
- Ensure any rollers are clean, and the liner is not in contact with any sharp edges or snags anywhere during use.

### Chemical attack

Avoid prolonged contact with solvents and chemicals.

### Call technical support with additional questions at 877.426.5948

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