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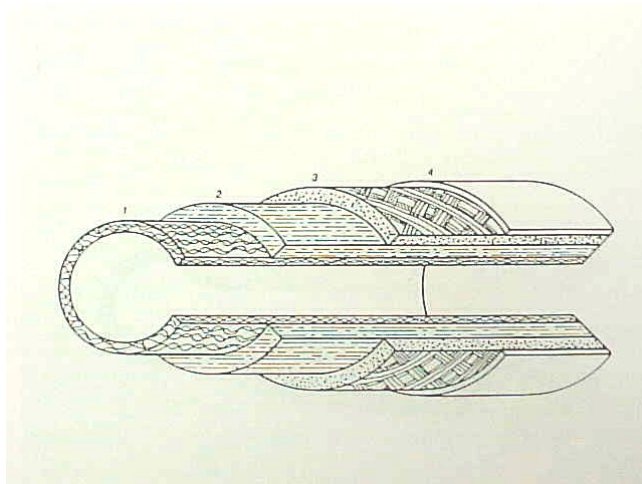
FILAMENT WOUND PIPE CONSTRUCTION

INNER SURFACE: The inner surface exposed to the chemical environment is a resin-rich layer 10 to 20 mils thick reinforced with a chemical resistant glass fiber-surfacing mat or with an organic fiber-surfacing mat suitable for the chemical service. This resin-rich inner surface contains less than 20% reinforcing material.

INTERIOR LAYER: The inner surface layer is followed with a laminate comprised of resin, reinforced only with a non-continuous glass fiber strands applied in a minimum of 2 ply 1-1/2 oz. per square foot chopped strand mat or alternately in a minimum of two passes of chopped roving minimum length of 1/2 inches to a maximum length of 2.0 inches applied uniformly by the spray-up process to an equivalent thickness in this layer of 0.080 inches. Each ply of mat or pass of chopped roving is well rolled prior to the application of additional reinforcement.

STRUCTURAL LAYER: Subsequent reinforcement is laminate comprised of suitable chemical resistant resin reinforced with continuous strand roving wound at an angle of approximately 54°. This portion of the laminate will have a glass content of 50 to 60%.

EXTERIOR SURFACE: For added resistance, weathering, and chemical exposure the surface is protected with a gel coat consisting of a suitable chemical resistant resin containing ultra-violet absorbers and pigment when required. Superior resistance is incorporated in the exterior surface by the addition of one layer of type "C" glass surfacing veil impregnated with corrosion resistant resin.



INNER SURFACE:

1. Surfacing Veil (90% Resin; 10% Glass) 0.01-0.02 thick

INTERIOR LAYER:

2. Chopped Strand Mat (70% Resin; 30% Glass)

STRUCTURAL LAYER:

3. Continuous Filament Wound (25% Resin; 75% Glass)

EXTERIOR SURFACE:

4. Gel Coat and "C" Glass