

ABSTRACT

METHOD AND APPARATUS FOR LINING A PIPE WITH A POLYMER LINING

A liner 30 of polyethylene is pulled through a die 36 and through the pipe 10 and allowed to revert to the internal diameter of the pipe. The force of pulling is half the yield strength of the liner or less. The die has an entry; a throat and an exit, the entry decreasing in diameter towards the throat and the exit increasing in diameter away from the throat. The liner has a maximum diameter before the die, a minimum diameter in the die and intermediate diameter after the die. The liner bending inwards before first contacting the die at the entry, then continuously bending through its minimum diameter as it passes the throat and then undergoing die swell resulting in said intermediate diameter. The throat is defined by the merger in a continuous curve of a radius joining the entry and a radius joining the exit. the entry is convex between where the liner 30 first contacts the die after bending inwardly and said throat.