



Recommended Inversion and Head Curing Chart *Heat-Welded Seams*

Pipe Diameter		CIPP Tube Thickness		Ideal Curing Head		Minimum Installation Head		Maximum Hot Head		Maximum Cold Head	
Inches	mm	Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI
6	4.5	23.4	10.2	18.0	7.8	26.2	11.4	30.0	13.0		
6	5.5	28.6	12.4	21.9	9.5	32.0	13.9	36.7	15.9		
6	6	31.2	13.6	23.9	10.4	34.9	15.2	40.0	17.4		
8	4.5	16.8	7.3	12.8	5.6	19.7	8.5	22.5	9.8		
8	5.5	20.5	8.9	15.7	6.8	24.0	10.4	27.5	11.9		
8	6	22.3	9.7	17.1	7.4	26.2	11.4	30.0	13.0		
8	7.5	27.9	12.1	21.4	9.3	32.8	14.2	37.5	16.3		
10	4.5	13.0	5.7	10.0	4.3	15.7	6.8	18.0	7.8		
10	5.5	15.9	6.9	12.2	5.3	19.2	8.3	22.0	9.6		
10	6	17.4	7.5	13.3	5.8	21.0	9.1	24.0	10.4		
10	7.5	21.7	9.4	16.6	7.2	26.2	11.4	30.0	13.0		
10	9	26.1	11.3	20.0	8.7	31.5	13.7	36.0	15.6		
12	6	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7		
12	6.5	14.1	6.1	10.8	4.7	18.9	8.2	21.7	9.4		
12	7	15.2	6.6	11.7	5.1	20.4	8.9	23.3	10.1		
12	7.5	16.3	7.1	12.5	5.4	21.8	9.5	25.0	10.9		
12	9	19.6	8.5	15.0	6.5	26.2	11.4	30.0	13.0		
12	10.5	22.8	9.9	17.5	7.6	30.6	13.3	35.0	15.2		
15	6	10.4	4.5	8.0	3.5	14.0	6.1	16.0	7.0		
15	7.5	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7		
15	9	15.7	6.8	12.0	5.2	21.0	9.1	24.0	10.4		
15	10.5	18.3	7.9	14.0	6.1	24.5	10.6	28.0	12.2		
15	12	20.9	9.1	16.0	7.0	28.0	12.1	32.0	13.9		
15	13.5	23.5	10.2	18.0	7.8	31.5	13.7	36.0	15.6		
18	6	8.7	3.8	6.7	2.9	11.6	5.1	13.3	5.8		
18	7.5	10.9	4.7	8.3	3.6	14.6	6.3	16.7	7.2		
18	9	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7		
18	10.5	15.2	6.6	11.7	5.1	20.4	8.9	23.3	10.1		
18	12	17.4	7.6	13.3	5.8	23.3	10.1	26.7	11.6		
18	13.5	19.6	8.5	15.0	6.5	26.2	11.4	30.0	13.0		
18	15	21.8	9.4	16.7	7.2	29.1	12.6	33.3	14.5		

Pipe Diameter		CIPP Tube Thickness		Ideal Curing Head		Minimum Installation Head		Maximum Hot Head		Maximum Cold Head	
Inches	mm	Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI
21	6	7.5	3.2	5.7	2.5	10.0	4.3	11.4	5.0		
21	7.5	9.3	4.0	7.1	3.1	12.5	5.4	14.3	6.2		
21	9	11.2	4.9	8.6	3.7	15.0	6.5	17.1	7.4		
21	10.5	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7		
21	12	14.9	6.5	11.4	5.0	20.0	8.7	22.9	9.9		
21	13.5	16.8	7.3	12.9	5.6	22.5	9.8	25.7	11.2		
21	15	18.7	8.1	14.3	6.2	25.0	10.8	28.6	12.4		
21	16.5	20.5	8.9	15.7	6.8	27.5	11.9	31.4	13.6		
21	18	22.4	9.7	17.1	7.4	30.0	13.0	34.3	14.9		
21	19.5	24.2	10.5	18.6	8.1	32.5	14.1	37.2	16.1		
24	7.5	8.2	3.5	6.3	2.7	10.9	4.7	12.5	5.4		
24	9	9.8	4.3	7.5	3.3	13.1	5.7	15.0	6.5		
24	10.5	11.4	5.0	8.8	3.8	15.3	6.6	17.5	7.6		
24	12	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7		
24	13.5	14.7	6.4	11.3	4.9	19.7	8.5	22.5	9.8		
24	15	16.3	7.1	12.5	5.4	21.8	9.5	25.0	10.9		
24	16.5	18.0	7.8	13.8	6.0	24.0	10.4	27.5	11.9		
24	18	19.6	8.5	15.0	6.5	26.2	11.4	30.0	13.0		
24	19.5	21.2	9.2	16.3	7.1	28.4	12.3	32.5	14.1		
24	21	22.8	9.9	17.5	7.6	30.6	13.3	35.0	15.2		
24	22.5	24.5	10.6	18.8	8.1	32.8	14.2	37.5	16.3		
27	7.5	7.3	3.1	5.6	2.4	9.7	4.2	11.1	4.8		
27	9	8.7	3.8	6.7	2.9	11.6	5.1	13.3	5.8		
27	10.5	10.2	4.4	7.8	3.4	13.6	5.9	15.6	6.8		
27	12	11.6	5.0	8.9	3.9	15.5	6.7	17.8	7.7		
27	13.5	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7		
27	15	14.5	6.3	11.1	4.8	19.4	8.4	22.2	9.6		
27	16.5	16.0	6.9	12.2	5.3	21.4	9.3	24.5	10.6		
27	19	18.4	8.0	14.1	6.1	24.6	10.7	28.2	12.2		
27	19.5	18.9	8.2	14.5	6.3	25.2	11.0	28.9	12.5		
27	21	20.3	8.8	15.6	6.8	27.2	11.8	31.1	13.5		
27	22.5	21.8	9.4	16.7	7.2	29.1	12.6	33.3	14.5		
27	24	23.2	10.1	17.8	7.7	31.1	13.5	35.6	15.4		

Pipe Diameter	CIPP Tube Thickness	Ideal Curing Head		Minimum Installation Head		Maximum Hot Head		Maximum Cold Head	
		Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI
30	7.5	6.5	2.8	5.0	2.2	8.7	3.8	10.0	4.3
30	9	7.8	3.4	6.0	2.6	10.5	4.6	12.0	5.2
30	10.5	9.1	4.0	7.0	3.0	12.2	5.3	14.0	6.1
30	12	10.4	4.5	8.0	3.5	14.0	6.1	16.0	6.9
30	13.5	11.8	5.1	9.0	3.9	15.7	6.8	18.0	7.8
30	15	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7
30	16.5	14.4	6.2	11.0	4.8	19.2	8.3	22.0	9.6
30	18	15.7	6.8	12.0	5.2	21.0	9.1	24.0	10.4
30	19.5	17.0	7.4	13.0	5.6	22.7	9.9	26.0	11.3
30	21	18.3	7.9	14.0	6.1	24.5	10.6	28.0	12.2
30	22.5	19.6	8.5	15.0	6.5	26.2	11.4	30.0	13.0
30	24	20.9	9.1	16.0	6.9	28.0	12.1	32.0	13.9
30	27	23.5	10.2	18.0	7.8	31.5	13.7	36.0	15.6
36	10.5	7.6	3.3	5.8	2.5	10.2	4.4	11.7	5.1
36	12	8.7	3.8	6.7	2.9	11.6	5.1	13.3	5.8
36	13.5	9.8	4.3	7.5	3.3	13.1	5.7	15.0	6.5
36	15	10.9	4.7	8.3	3.6	14.6	6.3	16.7	7.2
36	16.5	12.0	5.2	9.2	4.0	16.0	7.0	18.3	8.0
36	18	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7
36	19.5	14.1	6.1	10.8	4.7	18.9	8.2	21.7	9.4
36	21	15.2	6.6	11.7	5.1	20.4	8.8	23.3	10.1
36	22.5	16.3	7.1	12.5	5.4	21.8	9.5	25.0	10.9
36	24	17.4	7.6	13.3	5.8	23.3	10.1	26.7	11.6
36	27	19.6	8.5	15.0	6.5	26.2	11.4	30.0	13.0

Pipe Diameter	CIPP Tube Thickness	Ideal Curing Head		Minimum Installation Head		Maximum Hot Head		Maximum Cold Head	
		Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI
42	13.5	8.4	3.6	6.4	2.8	11.2	4.9	12.9	5.6
42	15	9.3	4.0	7.1	3.1	12.5	5.4	14.3	6.2
42	16.5	10.3	4.5	7.9	3.4	13.7	6.0	15.7	6.8
42	18	11.2	4.9	8.6	3.7	15.0	6.5	17.1	7.4
42	19.5	12.1	5.3	9.3	4.0	16.2	7.0	18.6	8.1
42	21	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7
42	22.5	14.0	6.1	10.7	4.7	18.7	8.1	21.4	9.3
42	24	14.9	6.5	11.4	5.0	20.0	8.7	22.9	9.9
42	27	16.8	7.3	12.9	5.6	22.5	9.8	25.7	11.2
42	28.5	17.7	7.7	13.6	5.9	23.7	10.3	27.2	11.8
48	13.5	7.3	3.2	5.6	2.4	9.8	4.3	11.3	4.9
48	15	8.2	3.5	6.3	2.7	10.9	4.7	12.5	5.4
48	16.5	9.0	3.9	6.9	3.0	12.0	5.2	13.8	6.0
48	18	9.8	4.3	7.5	3.3	13.1	5.7	15.0	6.5
48	19.5	10.6	4.6	8.1	3.5	14.2	6.2	16.3	7.1
48	21	11.4	5.0	8.8	3.8	15.3	6.6	17.5	7.6
48	22.5	12.2	5.3	9.4	4.1	16.4	7.1	18.8	8.1
48	24	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7
48	27	14.7	6.4	11.3	4.9	19.7	8.5	22.5	9.8
48	28.5	15.5	6.7	11.9	5.2	20.8	9.0	23.8	10.3
48	30	16.3	7.1	12.5	5.4	21.8	9.5	25.0	10.9
48	33	18.0	7.8	13.8	6.0	24.0	10.4	27.5	11.9
48	36	19.6	8.5	15.0	6.5	26.2	11.4	30.0	13.0
48	42	22.8	9.9	17.5	7.6	30.6	13.3	35.0	15.2

Pipe Diameter	CIPP Tube Thickness	Ideal Curing Head		Minimum Installation Head		Maximum Hot Head		Maximum Cold Head	
		Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI
54	15	7.3	3.1	5.6	2.4	9.7	4.2	11.1	4.8
54	16.5	8.0	3.5	6.1	2.7	10.7	4.6	12.2	5.3
54	18	8.7	3.8	6.7	2.9	11.6	5.1	13.3	5.8
54	19.5	9.4	4.1	7.2	3.1	12.6	5.5	14.5	6.3
54	21	10.2	4.4	7.8	3.4	13.6	5.9	15.6	6.8
54	22.5	10.9	4.7	8.3	3.6	14.6	6.3	16.7	7.2
54	24	11.6	5.0	8.9	3.9	15.5	6.7	17.8	7.7
54	27	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7
54	28.5	13.8	6.0	10.6	4.6	18.4	8.0	21.1	9.2
54	30	14.5	6.3	11.1	4.8	19.4	8.4	22.2	9.6
54	33	16.0	6.9	12.2	5.3	21.4	9.3	24.5	10.6
54	36	17.4	7.6	13.3	5.8	23.3	10.1	26.7	11.6
54	42	20.3	8.8	15.6	6.8	27.2	11.8	31.1	13.5
54	48	23.2	10.1	17.8	7.7	31.1	13.5	35.6	15.4
54	54	26.1	11.3	20.0	8.7	34.9	15.2	40.0	17.4
54	60	29.0	12.6	22.2	9.6	38.8	16.9	44.5	19.3
60	18	7.8	3.4	6.0	2.6	10.5	4.6	12.0	5.2
60	19.5	8.5	3.7	6.5	2.8	11.4	4.9	13.0	5.6
60	21	9.1	4.0	7.0	3.0	12.2	5.3	14.0	6.1
60	22.5	9.8	4.3	7.5	3.3	13.1	5.7	15.0	6.5
60	24	10.4	4.5	8.0	3.5	14.0	6.1	16.0	6.9
60	27	11.8	5.1	9.0	3.9	15.7	6.8	18.0	7.8
60	28.5	12.4	5.4	9.5	4.1	16.6	7.2	19.0	8.2
60	30	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7
60	33	14.4	6.2	11.0	4.8	19.2	8.3	22.0	9.6
60	36	15.7	6.8	12.0	5.2	21.0	9.1	24.0	10.4
60	42	18.3	7.9	14.0	6.1	24.5	10.6	28.0	12.2
60	48	20.9	9.1	16.0	6.9	28.0	12.1	32.0	13.9
60	54	23.5	10.2	18.0	7.8	31.5	13.7	36.0	15.6
60	60	26.1	11.3	20.0	8.7	34.9	15.2	40.0	17.4

Pipe Diameter		CIPP Tube Thickness		Ideal Curing Head		Minimum Installation Head		Maximum Hot Head		Maximum Cold Head	
Inches	mm	Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI		
63	18	7.5	3.2	5.7	2.5	10.0	4.3	11.4	5.0		
63	19.5	8.1	3.5	6.2	2.7	10.8	4.7	12.4	5.4		
63	21	8.7	3.8	6.7	2.9	11.6	5.1	13.3	5.8		
63	22.5	9.3	4.0	7.1	3.1	12.5	5.4	14.3	6.2		
63	24	9.9	4.3	7.6	3.3	13.3	5.8	15.2	6.6		
63	27	11.2	4.9	8.6	3.7	15.0	6.5	17.1	7.4		
63	28.5	11.8	5.1	9.1	3.9	15.8	6.9	18.1	7.9		
63	30	12.4	5.4	9.5	4.1	16.6	7.2	19.1	8.3		
63	33	13.7	5.9	10.5	4.5	18.3	7.9	21.0	9.1		
63	36	14.9	6.5	11.4	5.0	20.0	8.7	22.9	9.9		
63	42	17.4	7.6	13.3	5.8	23.3	10.1	26.7	11.6		
63	48	19.9	8.6	15.2	6.6	26.6	11.6	30.5	13.2		
63	54	22.4	9.7	17.1	7.4	30.0	13.0	34.3	14.9		
63	60	24.9	10.8	19.1	8.3	33.3	14.4	38.1	16.5		
69	18	6.8	3.0	5.2	2.3	9.1	4.0	10.4	4.5		
69	19.5	7.4	3.2	5.7	2.5	9.9	4.3	11.3	4.9		
69	21	7.9	3.4	6.1	2.6	10.6	4.6	12.2	5.3		
69	22.5	8.5	3.7	6.5	2.8	11.4	4.9	13.0	5.7		
69	24	9.1	3.9	7.0	3.0	12.2	5.3	13.9	6.0		
69	27	10.2	4.4	7.8	3.4	13.7	5.9	15.7	6.8		
69	30	11.4	4.9	8.7	3.8	15.2	6.6	17.4	7.6		
69	33	12.5	5.4	9.6	4.2	16.7	7.3	19.1	8.3		
69	36	13.6	5.9	10.4	4.5	18.2	7.9	20.9	9.1		
69	42	15.9	6.9	12.2	5.3	21.3	9.2	24.4	10.6		
69	48	18.2	7.9	13.9	6.0	24.3	10.6	27.8	12.1		
69	54	20.4	8.9	15.7	6.8	27.4	11.9	31.3	13.6		
69	57	21.6	9.4	16.5	7.2	28.9	12.5	33.1	14.3		
69	61	23.1	10.0	17.7	7.7	30.9	13.4	35.4	15.4		
69	63	23.8	10.3	18.3	7.9	31.9	13.8	36.5	15.9		

Pipe Diameter		CIPP Tube Thickness		Ideal Curing Head		Minimum Installation Head		Maximum Hot Head		Maximum Cold Head	
Inches	mm	Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI
72	19.5	7.1	3.1	5.4	2.4	9.5	4.1	10.8	4.7		
72	21	7.6	3.3	5.8	2.5	10.2	4.4	11.7	5.1		
72	22.5	8.2	3.5	6.3	2.7	10.9	4.7	12.5	5.4		
72	24	8.7	3.8	6.7	2.9	11.6	5.1	13.3	5.8		
72	27	9.8	4.3	7.5	3.3	13.1	5.7	15.0	6.5		
72	28.5	10.3	4.5	7.9	3.4	13.8	6.0	15.8	6.9		
72	30	10.9	4.7	8.3	3.6	14.6	6.3	16.7	7.2		
72	33	12.0	5.2	9.2	4.0	16.0	7.0	18.3	8.0		
72	36	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7		
72	42	15.2	6.6	11.7	5.1	20.4	8.8	23.3	10.1		
72	48	17.4	7.6	13.3	5.8	23.3	10.1	26.7	11.6		
72	54	19.6	8.5	15.0	6.5	26.2	11.4	30.0	13.0		
72	57	20.7	9.0	15.8	6.9	27.7	12.0	31.7	13.7		
72	61	22.1	9.6	17.0	7.4	29.6	12.9	33.9	14.7		
72	63	22.8	9.9	17.5	7.6	30.6	13.3	35.0	15.2		
78	21	7.0	3.1	5.4	2.3	9.4	4.1	10.8	4.7		
78	22.5	7.5	3.3	5.8	2.5	10.1	4.4	11.5	5.0		
78	24	8.0	3.5	6.2	2.7	10.8	4.7	12.3	5.3		
78	27	9.0	3.9	6.9	3.0	12.1	5.3	13.9	6.0		
78	28.5	9.5	4.1	7.3	3.2	12.8	5.5	14.6	6.3		
78	30	10.0	4.4	7.7	3.3	13.4	5.8	15.4	6.7		
78	33	11.0	4.8	8.5	3.7	14.8	6.4	16.9	7.3		
78	36	12.1	5.2	9.2	4.0	16.1	7.0	18.5	8.0		
78	42	14.1	6.1	10.8	4.7	18.8	8.2	21.5	9.4		
78	48	16.1	7.0	12.3	5.3	21.5	9.3	24.6	10.7		
78	54	18.1	7.8	13.9	6.0	24.2	10.5	27.7	12.0		
78	57	19.1	8.3	14.6	6.3	25.5	11.1	29.2	12.7		
78	61	20.4	8.9	15.6	6.8	27.3	11.9	31.3	13.6		
78	63	21.1	9.2	16.2	7.0	28.2	12.3	32.3	14.0		

Pipe Diameter	CIPP Tube Thickness	Ideal Curing Head		Minimum Installation Head		Maximum Hot Head		Maximum Cold Head	
		Feet	PSI	Feet	PSI	Feet	PSI	Feet	PSI
84	21	6.5	2.8	5.0	2.2	8.7	3.8	10.0	4.3
84	22.5	7.0	3.0	5.4	2.3	9.4	4.1	10.7	4.7
84	24	7.5	3.2	5.7	2.5	10.0	4.3	11.4	5.0
84	27	8.4	3.6	6.4	2.8	11.2	4.9	12.9	5.6
84	28.5	8.9	3.8	6.8	2.9	11.9	5.1	13.6	5.9
84	30	9.3	4.0	7.1	3.1	12.5	5.4	14.3	6.2
84	33	10.3	4.5	7.9	3.4	13.7	6.0	15.7	6.8
84	36	11.2	4.9	8.6	3.7	15.0	6.5	17.1	7.4
84	42	13.1	5.7	10.0	4.3	17.5	7.6	20.0	8.7
84	48	14.9	6.5	11.4	5.0	20.0	8.7	22.9	9.9
84	54	16.8	7.3	12.9	5.6	22.5	9.8	25.7	11.2
84	57	17.7	7.7	13.6	5.9	23.7	10.3	27.2	11.8
84	61	19.0	8.2	14.5	6.3	25.4	11.0	29.1	12.6
84	63	19.6	8.5	15.0	6.5	26.2	11.4	30.0	13.0
84	65	20.2	8.8	15.5	6.7	27.0	11.7	31.0	13.4

Warranty Disclaimer: The above chart provides the estimated installation and curing pressures of polyester felt inversion liners. Many factors can affect the outcome of a cured-in-place pipe installation. This table assumes proper installation techniques, type of equipment, and resin impregnation of the tube diameter. It is important to note that these and other factors associated with the installation of cured-in-place pipe will vary greatly between installations; each installation is unique. There is no warranty of merchantability or fitness for any particular purpose. Under no circumstances shall Applied Felts Inc., be liable for incidental, punitive special, indirect or consequential damages or for lost profits or labor costs, and in no event shall damages exceed the purchase price paid for the products.