TECHNICAL DROP-IN SPECIFICATION

**HydraFlex® H-Series Blended Linear Polyethylene**

The following technical drop-in specifications are provided as guidelines to be customized and finalized by the design engineer for preparing specific project specifications. This information is provided for reference purposes only and is not intended as a warranty or guarantee. Viaflex Inc. assumes no liability in connection with the use of this information. Please visit the Viaflex website at www.viaflex.com for current product specification sheets.

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**BLENDED LINEAR POLYETHYLENE GEOMEMBRANE SPECIFICATION**

Blended Linear Polyethylene Geomembranes serve as liners and covers for the containment of water, leachate or other liquids. As a liner they can contain the liquid to prevent leakage or environmental impact and as a cover to minimize evaporation or contamination. It is of great importance that the Blended Linear Polyethylene Geomembrane be free from defects and installed without damage.

1. **DESCRIPTION**
2. GENERAL:

The purpose of this specification is to provide details of Manufacturing Quality Control (MQC), Manufacturing Quality Assurance (MQA), Construction Quality Control (CQC), and Construction Quality Assurance (CQA) for the manufacture and pre-assembly of geomembrane products. The Contractor shall furnish all labor, material, and equipment to install the Blended Polyethylene Geomembrane including all necessary and incidental items as detailed or required to complete the installation in accordance with the Contract Drawing and these Specifications.

1. RELATED WORK:

Related Contract Work is described in the following section of the specification as approved by the CQA Engineer.

1. REFERENCE STANDARDS:

ASTM D5199 *Standard Test Method for Measuring the Nominal Thickness of Geosynthetics*

ASTM D6693 *Standard Test Method for Non-Reinforced Polyethylene and Non-Reinforced Flexible Polypropylene Geomembranes.*

ASTM D751 *Standard Test Methods for Coated Fabrics.*

ASTM D1004 *Standard Test Method for Initial Tear Resistance of Plastic Film and Sheeting.*

ASTM D4833 *Standard Test Method for Index Puncture Resistance of Geomembranes and Related Products.*

ASTM D6392 *Standard Test Method for Determining the Integrity of Non-Reinforced Geomembrane Seams Produced Using Thermo-Fusion Methods*

1. QUALITY ASSURANCE:

Quality Assurance during installation of Blended Polyethylene Geomembrane will be provided by the Owner as described in the accompanying Project CQA Manual.

1. MANUFACTURERS QUALIFICATIONS:
   1. The Manufacturer shall have previously demonstrated his ability to produce the required Blended Polyethylene Geomembrane by having successfully manufactured a minimum of 10,000,000 ft2 of Blended Polyethylene Geomembrane.
   2. Manufacturer must be ISO 9001 certified.
2. INSTALLER QUALIFICATIONS:

The Blended Polyethylene Geomembrane Installer shall have installed a minimum of 500,000 ft2 of Blended Polyethylene Geomembrane (or similar material).

**B. MATERIALS**

1. GENERAL:

The materials supplied under these Specifications shall consist of first-quality virgin products and select reprocessed resins designed and manufactured specifically for the purpose of this work, which shall have been satisfactorily demonstrated, by prior use, to be suitable and durable for such purposes.

1. BLENDED POLYETHYLENE GEOMEMBRANE MATERIALS::
2. Blended Polyethylene Geomembrane shall be manufactured to meet the following requirements:
3. Provide finished product free from holes, pinholes, bubbles, blisters, excessive gels, undispersed resins and/or carbon black, or contamination by foreign matter.
4. Blended Polyethylene Geomembrane shall be a flexible Geomembrane containing carbon black forUV stability and contain no plasticizers.
5. Approved Blended Polyethylene Geomembrane:
6. HydraFlex H20B, HydraFlex H30B, HydraFlex H40B as manufactured by Viaflex Inc. of Sioux Falls, SD
7. Equal material, as approved by the Engineer.

**C. FACTORY FABRICATION**

1. The Blended Polyethylene Geomembrane shall be supplied in panels which shall be of maximum size to providethe largest manageable sheet for the fewest seams.
2. Factory seams are produced by thermal sealing methods and shall have a minimum seam width of 1½ inch.
3. Factory seams are 100% visually inspected and destructive testing is done to verify quality compliance.
4. Labels on the panels shall identify the thickness, length, width, lot and panel numbers, and name of Manufacturer.
5. Factory pre-assembled panels are accordion folded and rolled on a cardboard core. Rolled panels are wrapped in a protective layer for shipment.

**D. SUBMITTALS**

The Contractor shall submit the following to the CQA Engineer:

1. PRE-INSTALLATION REQUIREMENTS:

Prior to Blended Polyethylene Geomembrane installation, the Contractor shall submit the following:

1. Certificate of Conformance and Sample: Prior to shipping to the site, the Contractor shall submit acertificate or affidavit signed by a legally authorized official of the Manufacturer for the BlendedPolyethylene Geomembrane attesting that the Blended Polyethylene Geomembrane meets the physicaland manufacturing requirements stated in these Specifications. The Contractor shall also submit a sampleof the Blended Polyethylene Geomembrane to be used (sample may be of different color). The sample shallbe labeled with the product name and be accompanied by the Manufacturer's specifications.
2. Shipping, Handling, and Storage Instructions: The Manufacturer's plan for shipping, handling, and storage shall be submitted for review.
3. Installation Procedures:

Submit installation procedures for carrying out the work. Installation procedures to be addressed shallinclude but not be limited to material installation, repair, and protection to be provided in the event of rainor strong winds. With regard to protection, the Contractor shall provide a plan of sufficiently anchoring theBlended Polyethylene Geomembrane to satisfy the Contractor’s Performance Warranty. This plan shall beapproved by the Engineer prior to construction.

1. Furnish copies of the delivery tickets or other approved receipts as evidence for materials received that will be incorporated into the construction.

2. POST-INSTALLATION REQUIREMENTS:

Upon completion of the Blended Polyethylene Geomembrane installation, the Contractor shall submit the following:

1. Completed material performance warranty.

**E. SITE PREPARATION AND INSTALLATION**

1. Installation shall be in done in accordance with the Manufacturers Geomembrane Installation Guidelines.

**TABLE 1:** REQUIRED BLENDEED POLYETHYLENE GEOMEMBRANE PROPERTIES 20 MIL

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **PROPERTY** | **TEST METHOD** | **IMPERIAL UNITS** | **METRIC UNITS** | **IMPERIAL MIN. ROLL AVERAGES** | **METRIC MIN. ROLL AVERAGES** |
| Thickness | Nominal | mils | mm | 18 | .46 |
| Tensile Strength | ASTM D6693 | ppi | N/cm | 68 | 119 |
| Tensile Elongation | ASTM D6693 | % | | 700 | |
| Tear Resistance | ASTM D1004 | lbs | N | 10 | 44 |
| Puncture Resistance | ASTM D4833 | lbs | N | 24 | 107 |
| Bonded Seam Strength | ASTM D6392 | lbs/in width | N | 30 | 133 |
| Seam Peel Adhesion | ASTM D6392 | lbs/in width | N | 25 | 111 |

**TABLE 2:** REQUIRED BLENDED POLYETHYLENE GEOMEMBRANE PROPERTIES 30 MIL

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **PROPERTY** | **TEST METHOD** | **IMPERIAL UNITS** | **METRIC UNITS** | **IMPERIAL MIN. ROLL AVERAGES** | **METRIC MIN. ROLL AVERAGES** |
| Thickness | ASTM D5199 | mils | mm | 27 | .69 |
| Tensile Strength | ASTM D6693 | ppi | N/cm | 102 | 179 |
| Tensile Elongation | ASTM D6693 | % | | 700 | |
| Tear Resistance | ASTM D1004 | lbs | N | 15 | 67 |
| Puncture Resistance | ASTM D4833 | lbs | N | 36 | 160 |
| Bonded Seam Strength | ASTM D6392 | lbs/in width | N | 45 | 200 |
| Seam Peel Adhesion | ASTM D6392 | lbs/in width | N | 38 | 169 |

**TABLE 3:** REQUIRED BLENDED POLYETHYLENE GEOMEMBRANE PROPERTIES 40 MIL

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **PROPERTY** | **TEST METHOD** | **IMPERIAL UNITS** | **METRIC UNITS** | **IMPERIAL MIN. ROLL AVERAGES** | **METRIC MIN. ROLL AVERAGES** |
| Thickness | ASTM D5199 | mils | mm | 36 | .91 |
| Tensile Strength | ASTM D6693 | ppi | N/cm | 136 | 238 |
| Tensile Elongation | ASTM D6693 | % | | 700 | |
| Tear Resistance | ASTM D1004 | lbs | N | 20 | 89 |
| Puncture Resistance | ASTM D4833 | lbs | N | 48 | 214 |
| Bonded Seam Strength | ASTM D6392 | lbs/in width | N | 60 | 267 |
| Seam Peel Adhesion | ASTM D6392 | lbs/in width | N | 50 | 222 |

Notes:

1. The Engineer may allow alternates to these requirements.