

MAXFLEX



DRAINAGE PRODUCTS

...is now pleased to offer MaxFlex!
This innovative product is expected to revolutionize the agricultural drainage industry.

Exceptional flow characteristics coupled with a refreshing ease of use are key benefits for installers and landowners.

As a new product, we ask that you read the following recommendations carefully to get the most out of your MaxFlex project.

Flexible Dual Wall Pipe 6" | 8" | 10" | 12" | 15"

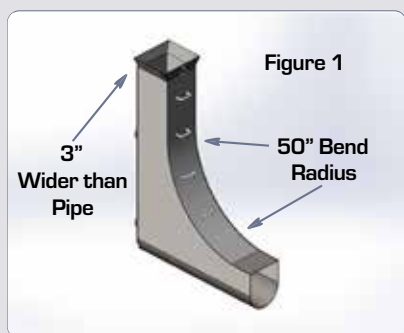


MaxFlex is manufactured under tight quality standards with specially engineered resin blends for the internal and external layers. The rugged, yet pliable inner liner is perfect for plowing or trenching in greater performance on any farm.

EQUIPMENT

MaxFlex can be conveniently installed behind your trencher or tile plow. When preparing your current equipment, there are a few **important considerations** to keep in mind including: Internal Bend Radius and sizing of your Chute/Boot, Support Groove Design and Shatter Plate Width for starters.

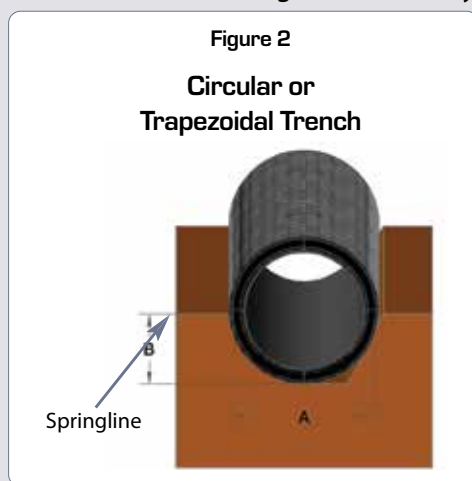
During the design/build process, it is important to insure that your boot's internal pipe path has a **minimum bend radius of 50"**. This minimum radius will provide a smooth transition during the installation process.



When sizing the boot, be sure the internal width is at least **3" wider** than the outside diameter of the pipe you are installing. In the case of 10" MaxFlex for example, the 11.5" OD would require a minimum internal boot diameter of 14.5". 12" with an OD of 14.5" would need a 17.5" internal boot diameter. The extra width will decrease installation friction on the pipe.

Support groove design is critical to long term service life. Please see Figure 2 which illustrates the acceptable circular or trapezoidal trench support groove for MaxFlex pipe. The installed support groove should extend from the base of the pipe to the springline with no void areas in the haunches to provide the greatest support possible.

Your plow's **shatterplate width** is another point of interest. Your shatterplate should be wide enough to efficiently and effectively break up and clear away enough soil to accommodate the trailing boot size. A recommended cutting width roughly 25% wider than the pipe's outside diameter is preferred.



INSTALLATION TECHNIQUES

Pipe Handling

Since MaxFlex is stiffer than standard single wall, some special handling methods should be observed during installation. Like single wall of any size, care should be taken to eliminate stretching. Stretching HDPE pipe during installation can reduce strength and decrease the material's long term effectiveness. Stretched pipe may buckle or have excessive deflection.

When installing MaxFlex, it is best to guide the material in a manner that will provide a gradual

angel into the boot. Stringing from the tile trailer to the machine is preferred with a mechanism to insure the pipe's entry angle does exceed the boot radius of 50".

Coupling the Pipe

Coupling the pipe can be accomplished using an external split coupler but we recommend using twice the tape of a traditional coupling due to the pipe's rigidity.

Figure 3

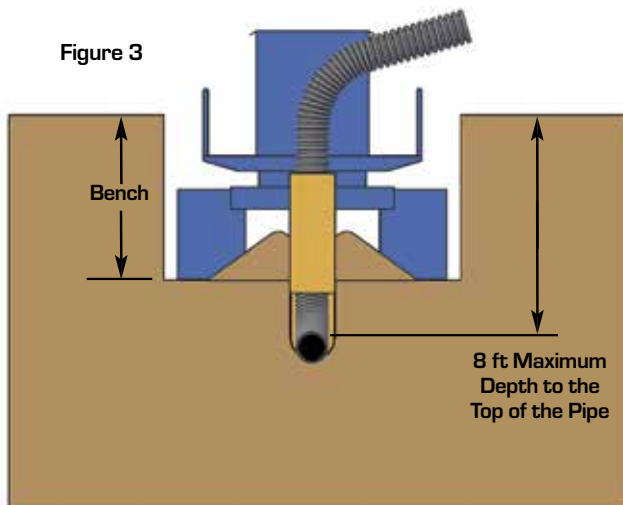
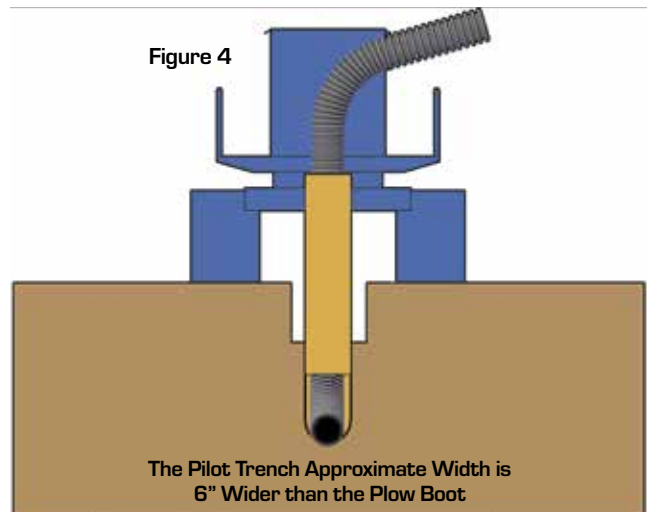


Figure 4



Burial Depth

HDPE pipe burial depths are highly impacted by two key ingredients: Compaction and Quality of Backfill. Your trench envelope, the material and structure surrounding your installed pipe are critical to its strength and longevity. MaxFlex is recommended for plow installations at burial depths up to 8'. See Figure 3. In some cases, installation can be aided via the digging of a pilot trench along the plow's path. See Figure 4. Excavated trenches with Class 1,2 or 3 backfill materials and mechanical compaction can allow greater burial depths.

Nominal Diameter	Inside Diameter (Average)	Outside Diameter (Average)	Weight (lbs/20ft)	Min Pipe Stiffness at 5% Deflection	Maxi Length
6"	5.93"	6.87"	22 lbs	50	1320'
8"	8.06"	9.34"	31 lbs	50	940'
10"	10.08"	11.87"	53 lbs	50	575'
12"	12.09"	14.68"	76 lbs	50	380'
15"	15.12"	17.65"	86 lbs	42	220'