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## Crown Vantage Landfill Closure

Environmental Protection, Inc. recently completed installation of 2,000,000 square feet of 30 mil PVC for the closure of this paper mill waste landfill near Kalamazoo, MI. The project was originally designed and permitted to use 40 mil LLDPE, textured both sides. EPI worked with the engineers at Blasland Bouck and Lee, the Michigan DEQ, and Terra Contracting, LLC to provide and install 30 mil smooth PVC geomembrane. Smooth PVC easily met the minimum friction angle requirements for this site.

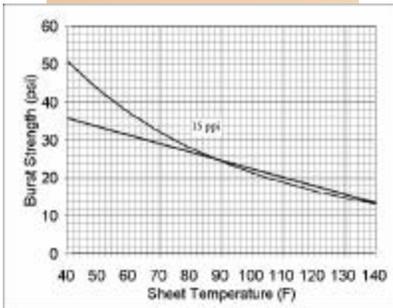
32 PVC panels (600,000 Sq. Ft.) requiring 8,200 feet of field seam were used on the Type II cell closure, and 72 PVC panels (1,400,000 Sq. Ft.) requiring 23,000 lineal feet of field seams were used on the Type III portion of the landfill. All of the dual track thermal field seams were made using Leister Twinny hot air welders over slopes that varied from 3/1 to 5/1. Air blowing into the seam from these hot air welders removes any debris, dirt, and moisture prior to dual track welding the PVC, creating a more uniform and consistent weld.

Trial welds were made with each welder at the beginning and end of each morning and afternoon welding session. 100% of EVERY field seam was air channel tested and passed per the Temperature / Pressure curve developed for dual track welded PVC seams. With this testing **EPI was able to verify the peel strength exceeded minimum specifications along 100% of the length of EVERY dual track welded PVC field seam!**



This method of testing also exposes failing portions of field seams (no matter how small) that destructive testing at 500 foot intervals may not identify.

Six miles of field seams, every inch verified to exceed minimum specification. Doesn't your project deserve the same?



PVC Temperature vs Pressure Curve

