

## Bores & HDD

CORE Linepipe® products are compatible with HDD and boring scenarios.

CORE Linepipe® has developed custom pull heads to be used when pulling drag sections of CORE Liner®. The pull heads are specially designed to eliminate damage to the mandrel while providing excellent tensile pull capability.

The reusable CORE pull head can only attach to the factory end mandrel. Keep this configuration in mind when planning the directionality of a bore pull. It is possible to reverse the direction to accommodate nonconforming bore directions, but this will lead to extra work time and costs (i.e. welded pull head or transition pup).

To facilitate tie-in locations, ensure a minimum of 32.8 feet (10 meters) of pipe protrudes from the bore entry and exit.

Follow the below guidance for a successful pull job:

1. Ensure plugs, seals, and shrink sleeves are installed prior to pulling the drag section.
2. The leading edge of shrink sleeves should be protected to avoid damage. A Thrust-Bore Kit, Scar-Guard, or other protection is recommended on HDD sections.
3. The custom pull head, steel bell cover, and mandrel sealing plug must be used to eliminate damage and debris from entering the ClickWeld® joint.
4. Precautions should be taken to protect external coating of lined pipe if being installed into a bore casing (as per standard steel line pipe practices).
5. The pipe section must be pulled from the factory end side (male mechanical end).

Product Description	Maximum Recommended Tensile Force	Maximum Recommended Torsional Force	Minimum Reamer Size in Compressible Soil	OD of ClickWeld® Joint
6" x 0.188"WT CORE Liner®	170,000lbs 756kN	**	12"	9.5"
8" x 0.22"WT CORE Liner®	190,000lbs 845kN	**	14"	12.8"

\*Parameters listed above are based on typical bore/HDD scenarios. Please consult CORE Linepipe® for any job specific considerations.

\*Consultation with HDD contractor is recommended.

**\*Care must be taken to ensure no dirt or contaminants enter the pipeline. Electrofusions that come in contact with any drilling fluid must be cut out. Please review with your CORE Service® team.**

\*\*No special design considerations required for torsional force. Use standard Engineering design limits for the base steel pipe.