



GEOSYNTHETIC CLAY LINERS

PRODUCT DATA

FOR MORE INFORMATION

The specification charts have been provided for comparative purposes only. Designers should contact manufacturers for additional details and to discuss site-specific considerations.

Information on the use and specification of GCLs is also available from the Geosynthetic Materials Association (GMA).

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PUBLISHER'S NOTE

All information included in this Specifier's Guide was compiled from information submitted by firms in the geosynthetics industry. Specifications were submitted voluntarily and their accuracy is the responsibility of the manufacturer. The appearance of a listing in this directory is not an endorsement of the company or product by *Geosynthetics* magazine or the Industrial Fabrics Association International (IFAI). The Specifier's Guide is intended as a guide, and *Geosynthetics* and IFAI encourage readers to contact the companies listed for further information.

Bonding clay to geosynthetic materials has created an economical, long-term solution for many applications.

Geosynthetic clay liners (GCLs) are hydraulic barriers made of clay bonded to a single geosynthetic layer or to multiple geosynthetic layers. Because of its low permeability, swelling capacity, and relative abundance, natural sodium bentonite is the preferred clay component of GCLs. A wide range of materials, including geotextiles and geomembranes, are used to carry and encapsulate the clay. Also, they provide the product with structural support.

GCLs are used primarily as substitutes for compacted clay liners (CCLs), providing significant advantages in cost, ease of installation, and performance. Primary applications include surface impoundment, secondary containment, and landfills.

The products have been used commercially for more than 10 years. GCL use has grown steadily, and standards have been authored to address swell and fluid-loss index testing, determination of flux, manufacturing, sampling, installation, and more.

Manufacturing process

GCLs are prefabricated sheets of processed bentonite clay available in multiple sizes. They are manufactured by encapsulating the clay between two or more layers of geotextile, or by bonding the clay to one side of a geomembrane. The geotextile-supported products hold the clay in place by soluble adhesives, I-ties, barbed-needle punching that interlocks the geotextile fibers, or by periodic rows of heavy stitching through the clay and fabric.

The numbers

Companies that submitted product data chart lines were asked to provide data determined through industry-accepted testing methods. Companies signed a certificate of compliance verifying the accuracy of this data.

GEOSYNTHETIC CLAY LINERS

Product Name	Bonding Method	Needlepunched Peel Strength ASTM D6496, N/m (lb/in)	GCL Dimensional Properties			GCL Hydraulic Properties		Base Bentonite Properties		GCL Structural Components				Manufacturer's Suggested Applications [3]
			Panel Size Roll Width/ Length m/m (ft/ft)	Average Roll Weight (lb)	Bentonite Mass/Unit Area ASTM D5993 gm/m ² (lb/ft ²)	Flux [1] ASTM D 5887 [2] m ³ /m ² -s	Swell Index ASTM D 5890 (min) ml/2g	Fluid Loss ASTM D 5891 ml	Upper Geosynthetic		Lower Geosynthetic			
									Type or structure	Weight ASTM D5261 or Thickness ASTM D5199 g/m ² or mm (oz/yd ² or mil)	Type or structure	Weight ASTM D5261 or Thickness ASTM D5199 g/m ² or mm (oz/yd ² or mil)		
CETCO Lining Technologies www.cetco.com														
Bentomat 600CL	needlepunched laminated	175 (1.0)	4.6/45.7 (15/150)	1250 (2750)	3660 (0.75)	1 x 10 ⁻⁹	24	18	FML/geotextile composite	NA	woven	105 (3.2)	LL, LC, SIC, CL, SIL	
Bentomat CL	needlepunched laminated	610 (3.5)	4.6/45.7 (15/150)	1250 (2750)	3660 (0.75)	1 x 10 ⁻⁹	24	18	FML/geotextile composite	NA	woven	105 (3.2)	LL, LC, SIC, CL, SIL	
Bentomat CLT	needlepunched laminated	610 (3.5)	4.6/45.7 (15/150)	1340 (2950)	3660 (0.75)	1 x 10 ⁻⁹	24	18	textured FML/geotextile composite	0.5 (20)	woven	105 (3.2)	LL, LC, SIC, CL, SIL	
Bentomat DN	needlepunched	610 (3.5)	4.4/45.7 (14.5/150)	1220 (2700)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	nonwoven	200 (6.0)	LL, LC, SIC	
Bentomat SDN	needlepunched	525 (3.0)	4.4/45.7 (14.5/150)	1200 (2650)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	nonwoven	90 (2.7)	LL, LC, SIC	
Bentomat ST	needlepunched	610 (3.5)	4.6/45.7 (15/150)	1200 (2650)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	woven	105 (3.2)	LL, LC, SIC	
Bentomat STM	needlepunched	610 (3.5)	4.6/60.9 (15/200)	1133 (2500)	2440 (0.50)	3 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	woven	105 (3.2)	LL, LC, SIC	
Bentomat 200R	needlepunched	175 (1.0)	4.6/45.7 (15/150)	1200 (2650)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	105 (3.2)	woven	105 (3.2)	LL, LC, SIC	
GSE Lining Technology Inc. www.gseworld.com														
GSE BentoLiner CNSL	needlepunched, polymer-coated	610 (3.5)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁹	24	18	nonwoven	200 (6.0)	PP geofilm/woven composite	105 (3.1)	high head applications with low hydraulic conductivity	
GSE BentoLiner EC	needlepunched	175 (1.0)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	100 (3.0)	woven	105 (3.1)	Low Loads and Flat Slopes	
GSE BentoLiner NSL	needlepunched	610 (3.5)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	woven	105 (3.1)	Medium Loads and Slopes	
GSE BentoLiner NWL	needlepunched	610 (3.5)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	nonwoven/woven composite	200 (6.0)	Medium Loads and Slopes	
GSE BentoLiner NWL-35	needlepunched	928 (5.3)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	nonwoven/woven composite	200 (6.0)	High Loads and Steep Slopes	
GSE BentoLiner NWL-60	needlepunched	2,100 (12.0)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	nonwoven/woven composite	200 (6.0)	Very High Loads and Steep Slopes	
GSE BentoLiner EC-CAR	needlepunched polymer enhanced	175 (1.0)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	100 (3.0)	woven	105 (3.1)	Coal Ash Resistant	
GSE BentoLiner NSL-CAR	needlepunched polymer enhanced	610 (3.5)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	woven	105 (3.1)	Coal Ash Resistant	

[1] Flux is defined as "Flow rate/unit area" which can be converted to permeability using the equation: Permeability = flux/hydraulic gradient

[2] Report result at a maximum confining stress of 35 kPa (5 psi) and 14 kPa (2 psi) head pressure

[3] CL = Canal liner
LL = Landfill liner
SIC = Surface impoundment cover
LC = Landfill cover
SIL = Surface impoundment liner

NP = Not provided by manufacturer
NA = Not applicable, per manufacturer

Companies were requested to provide minimum roll values (MARV). All claims are the responsibility of the manufacturer.

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GSE Lining Technology Inc. www.gseworld.com														
GSE BentoLiner NWL-CAR	needlepunched polymer enhanced	610 (3.5)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	nonwoven/ woven composite	200 (6.0)	Coal Ash Resistant	
GSE BentoLiner NWL3S-CAR	needlepunched polymer enhanced	928 (5.3)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	nonwoven/ woven composite	200 (6.0)	Coal Ash Resistant	
GSE BentoLiner NWL60-CAR	needlepunched polymer enhanced	2,100 (12.0)	4.7/46 (15.5/150)	1180 (2600)	3660 (0.75)	1 x 10 ⁻⁸	24	18	nonwoven	200 (6.0)	nonwoven/ woven composite	200 (6.0)	Coal Ash Resistant	
GSE GundSeal Smooth HDPE	adhesive	NA	5.3/61 (17.5/200)	1900 (4200)	3660 (0.75)	<<<4 x 10 ⁻¹⁴	24	18	smooth HDPE geomembrane	0.4-2.0mm (15 80mil)	spunbond geotextile	25 (0.75)	all	
GSE GundSeal Textured HDPE	adhesive	NA	5.3/51 (17.5/170)	1900 (4200)	3660 (0.75)	<<<4 x 10 ⁻¹⁴	24	18	textured HDPE geomembrane	0.5-2.0mm (20 80mil)	spunbond geotextile	25 (0.75)	all	
NAUE GmbH & Co. KG www.naue.com www.bentofix.com www.secugrid.com														
Bentofix BFG 5000	needle-punched	360 (2.1)	4.85/40 (15.9/131)	1100 (2400)	4400 (0.95)	5x10 ⁻⁹	24	18	bentonite- impregnated needle- punched nonwoven	800+270 (23.7+8)	PP slit film woven	180 (5.3)	CL, LL, SIC, LL, SIL, waterproofing	
Bentofix BFG 5500 X2	needle-punched	362 (2.1)	4.85/40 (15.9/131)	1100 (2400)	4400 (0.95)	<<<1x10 ⁻⁹	24	18	bentonite- impregnated needle- punched nonwoven	800+270 (23.7+8)	geo film/PP woven	300 (9.0)	CL, LL, SIC, LL, SIL, waterproofing	
Bentofix NSP 4900	needle-punched	361 (2.1)	4.85/40 (15.9/131)	980 (2160)	4000 (0.82)	5x10 ⁻⁹	24	18	needle-punched (PP nonwoven)	200 (6.0)	PP slit film woven	100 (3.0)	CL, LL, SIC, LL, SIL, waterproofing	

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