1101 McKinley Street
Anoka, MN 55303
Phone (763) 786-6682
Fax (763) 786-2167

Series 735
Transition for PVC/HDPE

Fitting Description

General – The transition fitting is constructed out of PVC material, stainless steel insert, and high density polyethylene (HDPE) pipe. The PVC and HDPE materials are joined together by hydraulically pressing the HDPE pipe into the PVC coupling. The PVC coupling portion of the transition fitting is machined with our multi-level patented barb system that provides a leak free radial compressed joint. The high density polyethylene portion of the transition fitting is cut to a specific length and is pressed into the PVC coupling. A stainless steel insert is installed to lock the PVC coupling and HDPE pipe together thus forming a leak-proof join that is stronger than the HDPE pipe.

Dimensions

See Poly-Cam, Inc. product dimension sheet provided separately.

System Performance

The transition fitting is designed to handle the pressure rating of the HDPE pipe with a 2:1 safety factor at 73.40 degrees Fahrenheit with a minimum 50 year design life.

Quality Assurance

The transition fitting shall be manufactured by Poly-Cam, Inc. Poly-Cam, Inc. shall provide quality assurance with regards to proper installation, compatibility, performance, and acceptance. Transition joint meets or exceeds the requirements of ASTM D2513 Category 1. All Fittings meet ARRA requirements. Manufactured in USA.

Warranty

Warranty period is one year after date of substantial completion of installation.

Materials Specifications

PVC coupling – The PVC coupling is manufactured out of PVC round bar and PVC hollow bar. This material is a rigid, unfilled, general-purpose-grade Polyvinyl Chloride (PVC) compound with a Cell Classification of 12454, per ASTM D1784. (Callout Designation S-PVC0111 per ASTM D6263).

High Density Polyethylene – HDPE pipe conforming to ASTM D-3350 with minimum cell classification values of 345464C, and shall conform to ASTM F714. Density shall be no less than 0.955 gms/ccm as referenced in ASTM D1505, with melt index no greater than 0.15 gms/10 minutes when tested in accordance with ASTM D 1238. Tensile Strength at yield –tensile shall be 3,200 to less than 3,500 psi as referenced in ASTM D638, and ESCR-Environmental Stress Crack Resistance shall be in excess of 5,000 hours with zero failures when tested in accordance with ASTM D 1693-Condition C.

Stainless Steel insert – The insert is manufacture out of 304 stainless steel tubing (ASTM A249 or ASTM A269) and or ERW pipe (ASTM SA-312).

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Installation

HDPE Pipe End

Install transition fitting so as to comply with the pipe manufacturer's recommended procedures. All field welds shall be accomplished in accordance with Plastic Pipe Institute's welding procedure for butt fusion.

PVC coupling

Install the PVC coupling so as to comply with the pipe manufacturer's recommended procedures for solvent cement.

Multi-Purpose Clear Cement is a medium bodied, medium set multi-purpose cement designed for use on PVC, CPVC and ABS pipe and fittings: Schedule 40 & 80, Types I & II, up to 6 inches. For potable water, pressure pipe, gas, and conduit, drain waste and vent pipe. Flows freely and provides a thick layer of cement on the pipe and loose fitting joints. Apply at temperatures 40°F to 100°F. Meets ASTM D-2564.

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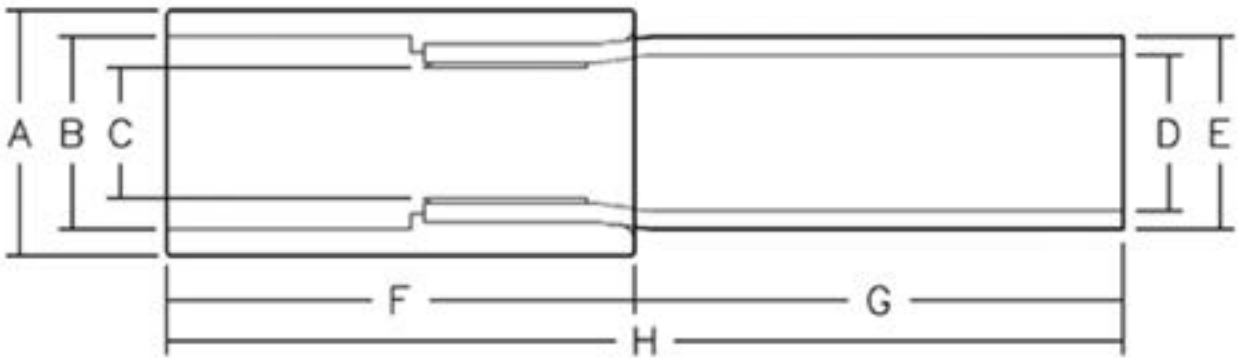
Nominal Size	PVC O.D. "A"	PVC I.D. "B"	Est. I.D. Pressed SDR 9 "C"	Est. I.D. Pressed SDR 11 "C"	HDPE I.D. SDR 9 "D"	HDPE I.D. SDR 11 "D"	HDPE O.D. "E"	PVC Length "F"	Exposed HDPE Length "G"	Total Length "H"
0.75	1.525	1.05	0.65	0.68	0.807	0.851	1.05	2.5	~7	~9.5
1	1.785	1.305	0.81	0.86	1.003	1.051	1.315	3	~6.25	~9.25
1.25	2.375	1.65	1.08	1.15	1.27	1.34	1.66	4.5	~5.75	~10.25
1.5	2.375	1.91	1.15	1.26	1.453	1.533	1.9	4.5	~5.75	~10.25
2	3.025	2.375	1.54	1.64	1.815	1.917	2.375	5.75	~5.5	~11.25
3	4	3.5	2.48	2.63	2.675	2.836	3.5	6.5	~4.5	~11
4	5.625	4.5	3.17	3.36	3.44	3.633	4.5	6.5	~8.5	~15
Stainless Steel ID Insert Standard - PVC ID Insert Available										



Fully pressure rated • Standard SDR sizes 7,9,11
Manufactured to ASTM D—2513-96a, D1599, D1598
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