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Part Name: Electrofusion Tapping Saddle with Groove Transition
Part Number: 578-xxxx

Electrofusion Branch Saddle with Groove Transition

The transition fitting consists of a two-piece construction. The electrofusion branch saddle and the fitting are joined together by hydraulically pressing the fitting onto the HDPE electrofusion branch saddle. The steel fitting portion of the transition fitting is machined with a multi-level barb system that provides a leak-free radial compressed joint.

Design

Relaxation of the pipe creates a seal to prevent leakage. Under pressure, the internal pressure within the pipe increases the sealing surface area on the barb. Under zero internal pressure, the compression and tensional strain created by the compression of the multi-level barbs are greater than the stress created by relaxation and/or thermal expansion and contraction. As the internal pressure increases, the connection between the pipe material and transition fitting increases.

- Sizes range from 1" to 8" Iron Pipe Sizes.
- Grooves are cut to standard cut groove specification.

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. The transition joint meets or exceeds the requirements of:

- ASTM 1598 and ASTM 1599
- All Fittings meet ARRA requirements.

Installation

Electrofusion Branch Saddle: Use the electrofusion manufacturer's guidelines to install the fitting on the main pipe. Saddle comes with straps for proper installation.

Steel Fitting: The entrance of the coupling is tapered at the beginning. The polyethylene or copolymer material is pressed into the coupling. This allows the material to relax into the multi-level barb system.

Material

Steel Fitting:

- Manufactured of Carbon Steel (A53 or A106 grade), Type 304, or Type 316 (ASTM A249 or ASTM A269), ERW pipe (ASTM SA-312), or C954 grade Aluminum Bronze (lead-free material).
- For carbon steel, the **epoxy coating** (IF 194T Red Iron Oxide) is fusion bonded to the metal. FDA 175.300, AWWA C116-01, C213-01, UL 262, and FM 1120/1130

High-Density Polyethylene: HDPE pipe

- Meets ASTM D-3350 with minimum cell classification values of 345464C (PE 3408), PE445574C (PE 4710)
- Meets ASTM F714.
- Density shall be no less than 0.955 g/cm as referenced in ASTM D1505
- Melt index no greater than 0.15 g/10 minutes when tested per ASTM D 1238
- Tensile Strength at Yield -tensile shall be 3,200 psi to less than 3,500 psi as referenced in ASTM D638
- ESCR-Environmental Stress Crack Resistance shall be over 5,000 hours with zero failures when tested per ASTM D 1693-Condition C
- All pipe meets ASTM 3035.
- All certifications will be submitted upon request.

Warranty

The warranty period is one year after the date of substantial completion of installation.

Series 578 Electrofusion Tapping Saddle with Groove Transition

Nominal Size (In.)	Poly-Cam Thread Material	Groove Outlet A	Outlet to Main Length B	IPS Radius R	DIPS Radius R2
3	Carbon Steel, Stainless 316, Stainless 304	3"	6	3.500	N/A
4	Carbon Steel, Stainless 316, Stainless 304	3-4"	6	4.500	4.800
6	Carbon Steel, Stainless 316, Stainless 304	3-6"	7	6.625	6.900
8	Carbon Steel, Stainless 316, Stainless 304	3-8"	8	8.625	9.050
10	Carbon Steel, Stainless 316, Stainless 304	3-10"	9	10.750	11.100
12	Carbon Steel, Stainless 316, Stainless 304	3-12"	11	12.750	13.200
14	Carbon Steel, Stainless 316, Stainless 304	3-14"	11	14.000	15.300
16	Carbon Steel, Stainless 316, Stainless 304	3-16"	12	16.000	17.400
18	Carbon Steel, Stainless 316, Stainless 304	3-18"	16	18.000	19.500
20	Carbon Steel, Stainless 316, Stainless 304	3-20"	18	20.000	21.600
24	Carbon Steel, Stainless 316, Stainless 304	3-24"	20	24.000	25.800
30	Carbon Steel, Stainless 316, Stainless 304	3-24"	20	30.000	32.000

