



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



Part Name: Socket Reducer with Male NPT
Part Number: 725-xxxx

Socket Fusion Male Threaded Transitions

Poly-Cam's HDPE socket fusion male threaded transition fitting is a machined barbed transition fitting which is hydraulically compressed into the polyethylene socket fusion coupling. A stainless steel compression ring is installed to increase the pullout resistance.

- Sizes range from 0.5" to 2" NPT.
- All National Pipe Threads are made to ANSI/ASME B1.20.1 - 2013.

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

HDPE socket end: Install transition fitting in accordance to ASTM F2620: Standard Practice for Heat Fusion Joining of Polyethylene Pipe and Fittings.

Threaded Fitting: When installing the transition fitting:

- Always use pipe joint sealant or Teflon tape.
- Always use strap wrenches.
- **Do not use a pipe wrench.**
- **Always use 2 wrenches when connecting.**
- **Over tightening may cause ovality or damage.**

- **Always pressure test for leaks before backfilling.**
- Backfill and compact carefully around transition and service line to prevent ground shifts which could damage the valve and/or transition fitting.

Material

Threaded Fitting:

- Manufactured of Type 304 Stainless Steel, Type 316 Stainless Steel (ASTM A249 or ASTM A269), or C954 grade Aluminum Bronze (lead-free material).

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 725 Socket Reducer with Male NPT

Nominal Size (In.)	Poly-Cam Thread Material	Coupling NPT A	Coupling Length B	Coupling Diameter C	HDPE Socket Diameter D
.75 x 1	C954 Bronze, Stainless 304	1.050	3.800	1.810	1.315
.75 x 1.25	C954 Bronze, Stainless 304	1.050	4.200	2.320	1.660
1 x 1.25	C954 Bronze, Stainless 304	1.315	4.200	2.320	1.660
1.25 x 1.5	C954 Bronze, Stainless 304	1.660	3.500	2.660	1.900

