



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



Part Name: 90 Degree Socket Transition with Male NPT  
Part Number: 726-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 726 90 Degree Socket Transition with Male NPT

Nominal Size (In.)	Poly-Cam Thread Material	Coupling NPT A	Coupling Length B	Coupling Diameter C	HDPE Socket Diameter D
0.75	C954 Bronze, Stainless 304	1.050	2.450	1.430	1.050
1	C954 Bronze, Stainless 304	1.315	2.665	1.800	1.315
1.25	C954 Bronze, Stainless 304	1.660	3.350	2.300	1.660
1.5	C954 Bronze, Stainless 304	1.900	3.750	2.610	1.900
2	C954 Bronze, Stainless 304	2.375	3.750	3.250	2.375

