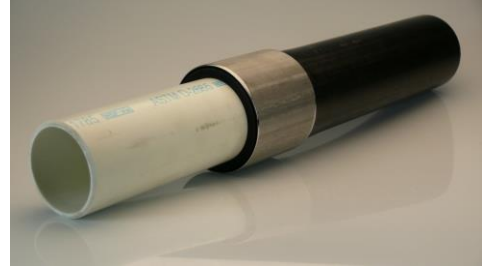




1101 McKinley Street  
Anoka, MN 55303  
Phone (763) 786-6682  
Fax (763) 786-2167  
[www.polycam.com](http://www.polycam.com)



Part Name: ID Controlled PVC/HDPE Transition Fitting

Part Number: 737-xxxx

### **ID Controlled PVC/HDPE Transition Fitting**

**General:** The transition fitting consists of a two-piece construction manufactured of PVC pipe and high-density polyethylene (HDPE) pipe. The two materials are joined together by hydraulically pressing the HDPE pipe onto the PVC fitting. The PVC fitting is machined out of PVC pipe.

The PVC fitting has external barbs machined on one end of the fitting. The HDPE pipe is hydraulically pressed onto the PVC fitting with the barbs. A stainless steel or PVC ring is pressed over the top of the HDPE pipe compressing the pipe onto the barbs.

### **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.

### **Installation**

**HDPE pipe end:** Install transition fitting to comply with the pipe manufacturer's recommended procedures. All field welds shall be completed per Plastic Pipe Institute's welding procedure for butt fusion or electrofusion.

**PVC coupling:** Install the PVC coupling so as to comply with the PVC 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, 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

## **Material**

**PVC:** The PVC side of the transition fitting is manufactured from a short section of domestically produced rigid polyvinyl chloride (PVC) compound Type 1 Grade 1 with cell classification of 12454 as defined in ASTM D1784. This compound shall be white or gray in color as specified and shall be approved by NSF for use with potable water. The pipe shall be manufactured in accordance with ASTM D1785. The PVC pipe is fully pressure rated.

### **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.

**Stainless Steel outside ring:** The outside ring is manufactured out 304 stainless steel tubing (ASTM A249 or ASTM A269) and/or ERW pipe (ASTM SA-312).

**PVC Sleeve:** The Poly-Cam PVC sleeve used to join the HDPE and the PVC end together is manufactured from PVC pipe.

## **Warranty**

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

# Series 737 ID Controlled PVC/HDPE Transition Fitting

Nominal Size (In.)	PVC Diameter <b>A</b>	Overall Length <b>B</b>	PVC Length <b>C</b>	HDPE Diameter <b>D</b>	HDPE Length <b>E</b>
0.5	0.84	13	5	0.85	8
0.75	1.05	14.5	6.5	1.05	8
1	1.315	14.5	6.5	1.315	8
1.25	1.66	19	7	1.66	12
1.5	1.9	19	7	1.9	12
2	2.375	19	7	2.375	12
3	3.5	20	7	3.5	13
4	4.5	21.5	8	4.5	13.5
5	5.563	23	9	5.563	14
6	6.625	23	9	6.625	14
8	8.625	26	10	8.625	16
10	10.75	32	12	10.75	20
12	12.75	36	14	12.75	22
14	14	48	20	14	28
16	16	48	20	16	28
8x6	6.625	25	9	8.625	16
10x8	8.625	30	10	10.75	20
14x12	12.75	42	14	14	28

