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Part Name: ID-Controlled Weld-On Transition Fitting
Part Number: 863-xxxx

ID Controlled Weld-On Transition Fitting

Description - The Poly-Cam ID-Controlled Weld-On is designed to provide a smooth, interior transition between the steel pipe and the polyethylene pipe. The connection between the steel fitting and the polyethylene pipe is accomplished with a multi-level barb system and a compression ring supporting the connection. The multi-level barb system provides the sealing connection between the steel and the polyethylene pipe. The interior of the fitting contains no sharp edges in which pipeline cleaning pigs can be caught or damaged. The weld-on is coated with an epoxy coating. The compression ring is constructed out of carbon steel material and coated with an epoxy-coated material. Stainless steel compression rings are optional.

The Poly-Cam ID-Controlled Weld-On is a custom design fitting allowing the installer to transition from one specific type steel materials to a specific type of polyethylene pipe.

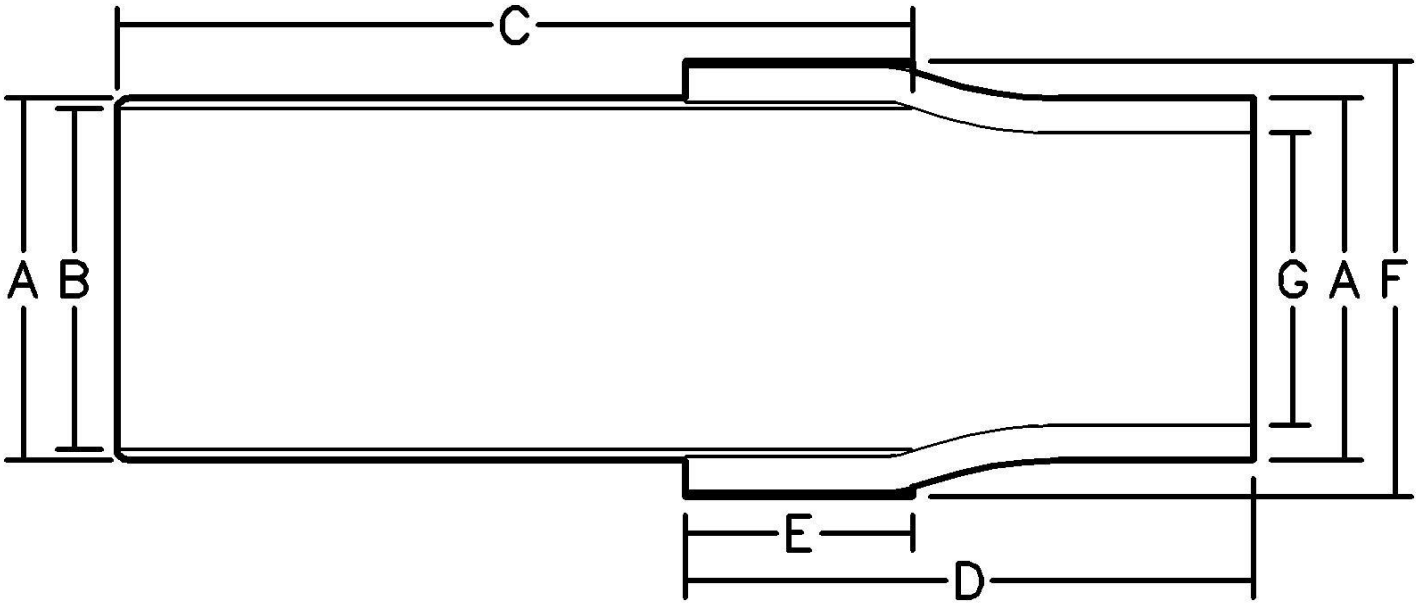
Tested and complies to ASTM D2513, ASTM 1973-05, D1599, D1598

Steel Material Options:
- A53B
- 304 Stainless Steel
- 316 Stainless Steel

Polyethylene Pipe Options:
- PE 3408 ASTM F-714
- PE 3408 ASTM 2513 Gas Pipe
- PE 2406
- PE 4710

Additional options are available.
Epoxy Coated Material:
- Color HB, Red Oxide, IF1947T **or** Green 3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 6233

Series 863 ID Controlled Weld-On (A53B)

SDR 9

Nominal Size (In.)	HDPE/ Steel Pipe O.D. **A**	Steel Pipe I.D. **B**	Steel Length **C**	HDPE Pipe Length **D**	Compression Ring Length **E**	Compression Ring O.D. SDR 9 **F**	SDR 9 HDPE I.D. **G**
2	2.375	2.067	12	24	3.5	~2.95	1.815
2.5	2.875	2.469	14	24	3.5	~3.54	2.198
3	3.5	3.068	14	24	5	~4.29	2.675
4	4.5	4.026	14	24	5.5	~5.64	3.44
6	6.625	6.065	20	30	8	~8.2	5.065
8	8.625	7.981	22	30	10	~10.7	6.594
10	10.75	10.020	26	40	12	~13.4	8.219
12	12.75	12.000	28	40	12	~15.9	9.746
14	14	13.250	28	40	12	~17.4	10.701
16	16	15.250	28	48	14	~19.9	12.231
18	18	17.250	28	48	14	~22.4	13.76
20	20	19.250	28	48	15	~24.9	15.289
24	24	23.250	28	48	15	~29.8	18.346