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

Part Name: Reducing ID-Controlled Weld-On Transition Fitting
Part Number: 864-xxxx

Reducing Seamless 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.

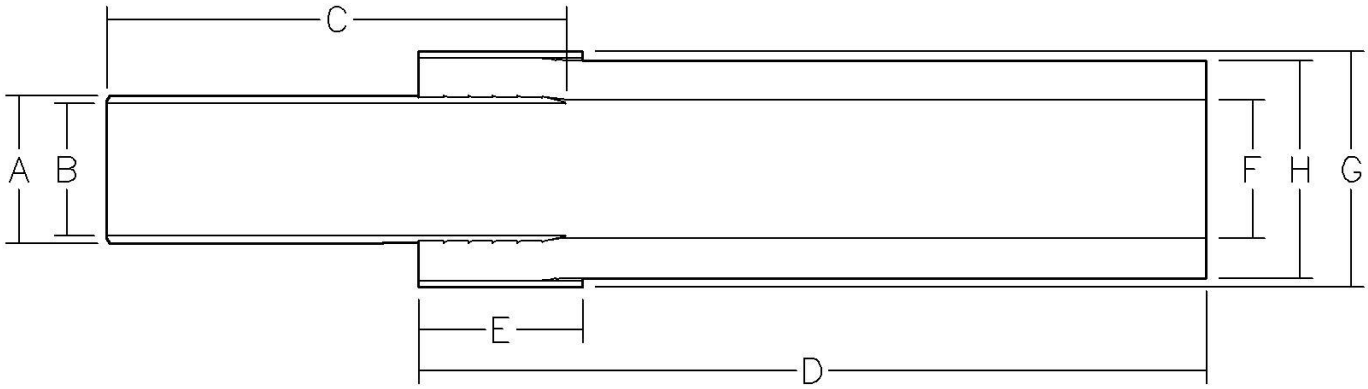
Tested and complies to ASTM D2513, D1599, D1598

Steel Material Options:
- A106 Seamless Carbon Steel
  Available in the following upon request and subject to availability:
  X42, X52, X60, X65, X70, API 5L, NACE MR0175, A333 Grade 6
- 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, Green 3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 6233, **or** 3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 134

Series 864 Reducing Seamless ID Controlled Weld-On (A106)

SDR 17

Nominal Size (In.)	Steel Pipe O.D. **A**	Steel Pipe I.D. **B**	Steel Length **C**	HDPE Pipe Length **D**	Compression Ring Length **E**	SDR 17 HDPE I.D. **F**	HDPE O.D. **G**
3x2	2.375	2.067	12	24	3.5	3.063	3.500
4x2	2.375	2.067	12	24	3.5	3.938	4.500
4x3	3.5	3.068	14	24	5	3.938	4.500
6x4	4.5	4.026	14	24	5.5	5.798	6.625
8x6	6.625	6.065	20	30	8	7.550	8.625
10x8	8.625	7.981	22	30	10	9.410	10.75
12x8	8.625	7.981	22	30	10	11.160	12.75
12x10	10.75	10.02	26	40	12	11.160	12.75
14x10	10.75	10.02	26	40	12	12.253	14
14x12	12.75	12	28	40	12	12.253	14
16x12	12.75	12	28	40	12	14.005	16
16x14	14	13.25	28	40	12	14.005	16
18x12	12.75	12	28	40	12	15.755	18
18x14	14	13.25	28	40	12	15.755	18
18x16	16	15.25	28	48	14	15.755	18
20x14	14	13.25	28	40	12	17.507	20
20x16	16	15.25	28	48	14	17.507	20
20x18	18	17.25	28	48	14	17.507	20
22x18	18	17.25	28	48	14	19.257	22
22x20	20	19.25	28	48	15	19.257	22
24x18	18	17.25	28	48	14	21.007	24
24x20	20	19.25	28	48	15	21.007	24
28x24	24	23.25	28	48	15	24.508	28
30x24	24	23.25	28	48	15	26.258	30
30x26	26	25.25	33	48	16	26.258	30
32x30	30	29.25	42	48	28	28.010	32
36x30	30	29.25	42	48	28	31.510	36