



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



Part Name: Reducing Extra Heavy ID-Controlled Weld-On Transition Fitting
Part Number: 865-xxxx

Reducing Extra Heavy 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 ERW Carbon Steel / 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 or Green 3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 6233

Series 865 Reducing Extra Heavy ID Controlled Weld-On (A53/A106)

SDR 11

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 11 HDPE I.D. F	HDPE O.D. G
3x2	2.375	1.939	12	24	3.5	2.826	3.500
4x2	2.375	1.939	12	24	3.5	3.633	4.500
4x3	3.5	2.9	14	24	5	3.633	4.500
6x4	4.5	3.826	14	24	5.5	5.349	6.625
8x6	6.625	5.761	20	30	8	6.963	8.625
10x8	8.625	7.625	22	30	10	8.679	10.75
12x8	8.625	7.625	22	30	10	10.293	12.75
12x10	10.75	9.75	26	40	12	10.293	12.75
14x10	10.75	9.75	26	40	12	11.301	14
14x12	12.75	11.75	28	40	12	11.301	14
16x12	12.75	11.75	28	40	12	12.915	16
16x14	14	13	28	40	12	12.915	16
18x12	12.75	11.75	28	40	12	14.532	18
18x14	14	13	28	40	12	14.532	18
18x16	16	15	28	48	14	14.532	18
20x14	14	13	28	40	12	16.146	20
20x16	16	15	28	48	14	16.146	20
20x18	18	17	28	48	14	16.146	20
22x18	18	17	28	48	14	17.760	22
22x20	20	19	28	48	15	17.760	22
24x18	18	17	28	48	14	19.374	24
24x20	20	19	28	48	15	19.374	24
28x24	24	23	28	48	15	22.605	28
30x24	24	23	28	48	15	24.219	30
30x26	26	25	33	48	16	24.219	30
32x30	30	28.5	42	48	28	25.833	32
36x30	30	28.5	42	48	28	29.061	36

