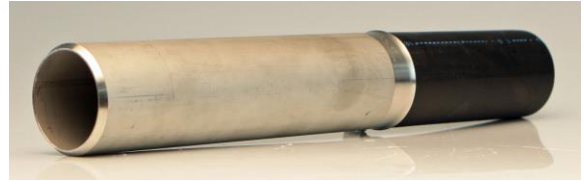




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Part Name: Weld-on Transition Fitting
Part Number: 815-xxxx

Weld-on Transitions

The Poly-Cam weld-on transition is a multi-level mechanical transition fitting. The polyethylene or pipe-quality copolymer material are hydraulically compressed into the transition fitting.

Design

Relaxation of the pipe creates a seal to prevent leakage. Under pressure, the internal pressure within the pipe increases the sealing surface area on the barb. Under zero internal pressure, the compression and tensional strain created by the compression of the multi-level barbs are greater than the stress created by relaxation and/or thermal expansion and contraction. As the internal pressure increases, the connection between the pipe material and transition fitting increases.

- Sizes range from .75 to 30" Iron Pipe Size.
- Sizes range from .75" to 2" Copper tube size HDPE
- Available in MDPE or HDPE
- Rated for both water and gas use

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 D2513 Category 1.
- Meets NSF 61, listing PM20928
- ASTM D3261
- ASTM F2897: Tracking and Traceability Encoding System

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.

Steel Fitting: The entrance of the coupling is tapered at the beginning. The polyethylene or copolymer material is cold pressed into the coupling. This allows the material to relax into the multi-level barb system.

Material

Steel Fitting:

- Manufactured of Carbon Steel (A53 or A106 grade), Type 304, or Type 316 (ASTM A249 or ASTM A269) and or ERW pipe (ASTM SA-312)
- For carbon steel, the **epoxy coating** (IF 194T Red Iron Oxide) is fusion bonded to the metal. Meets NSF 61, FDA 175.300, AWWA C116-01,C213-01, UL 262 and FM 1120/1130
- Inserts are manufactured out 304 stainless steel tubing (ASTM A249 or ASTM A269) and/or ERW pipe (ASTM SA-312).

High-Density Polyethylene (HDPE) or Medium-Density Polyethylene Pipe (MDPE):

- Incorporated with the fitting is:
 - MDPE - PE2406/2708 (PE234373E and PE234375E)
 - HDPE - PE3408/3608(cell class 345464C)/PE4710 (PE445574C)
- All pipe meets ASTM D3035 and ASTM D2513.

Warranty

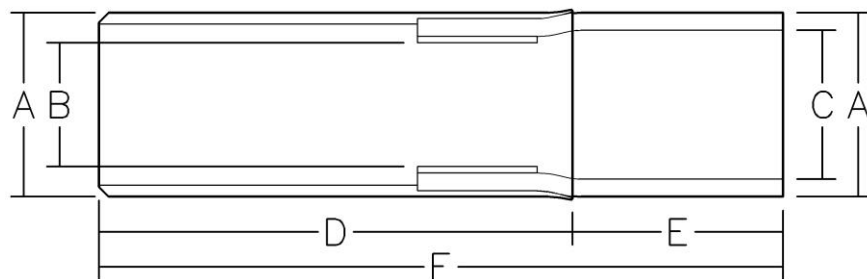
The warranty period is one year after the date of substantial completion of installation.



Series 815 Weld-on Transition for Gas and Water

SDR 17

Nominal Size (In.)	HDPE/ Steel Pipe O.D. A	Pressed SDR17 PE Pipe I.D. B	Exposed SDR17 PE Pipe I.D. C	Exposed PE Pipe O.D. A	Coupling Length D	Exposed PE Pipe Length E	Overall Length F
2	2.375	~1.90	2.078	2.375	10	~5.64	~15.64
3	3.5	~2.84	3.063	3.5	12	~6.53	~18.53
4	4.5	~3.71	3.938	4.5	13	8.5	21.5
5	5.563	~4.6	4.87	5.563	17	12	29
6	6.625	~5.4	5.798	6.625	17	11	28
8	8.625	~7.1	7.55	8.625	20	12	32
10	10.75	~9.0	9.41	10.75	26	16	42
12	12.75	~10.7	11.16	12.75	28	20.5	48.5
14	14	~11.8	12.253	14	28	20	48
16	16	~13.5	14.005	16	28	22	50
18	18	~15.1	15.755	18	28	21.75	49.75
20	20	~16.8	17.507	20	28	25.75	53.75
24	24	~20.2	21.007	24	28	29.75	54.75
30	30	~25.6	26.258	30	28	28	56



Certified to
NSF/ANSI/CAN 61

Revision Date: 9-22-2024