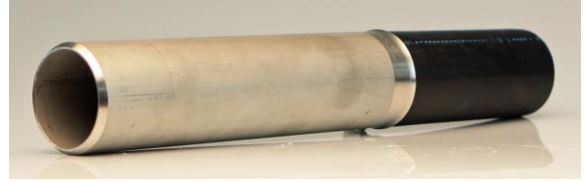




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Part Name: Weld-on Transition Fitting  
Part Number: 815-xxxx

### **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.

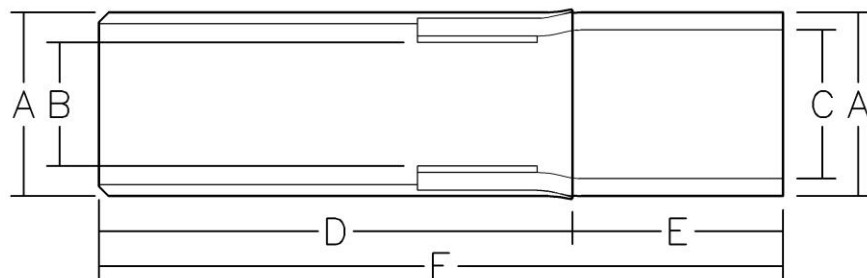


Certified to  
NSF/ANSI/CAN 61

# Series 815 Weld-on Transition for Gas and Water

## SDR 7

Nominal Size (In.)	HDPE/ Steel Pipe O.D. <b>A</b>	Pressed SDR7 PE Pipe I.D. <b>B</b>	Exposed SDR7 PE Pipe I.D. <b>C</b>	Exposed PE Pipe O.D. <b>A</b>	Coupling Length <b>D</b>	Exposed PE Pipe Length <b>E</b>	Overall Length <b>F</b>
1	1.315	~0.86	0.92	1.315	12	~6.21	~18.21
1.25	1.66	~1.07	1.158	1.66	10	~6.15	~16.15
1.5	1.9	~1.21	1.325	1.9	10	~6.09	~16.09
2	2.375	~1.51	1.656	2.375	10	~5.64	~15.64
3	3.5	~2.26	2.44	3.5	12	~6.53	~18.53
4	4.5	~2.97	3.137	4.5	13	8.5	21.5
5	5.563	~3.6	3.88	5.563	17	12	29
6	6.625	~4.3	4.619	6.625	17	11	28
8	8.625	~5.7	6.013	8.625	20	12	32
10	10.75	~7.2	7.494	10.75	26	16	42
12	12.75	~8.7	8.889	12.75	28	20.5	48.5
14	14	~9.4	9.76	14	28	20	48
16	16	~10.8	11.154	16	28	22	50
18	18	~12.1	12.549	18	28	21.75	49.75
20	20	~13.4	13.943	20	28	25.75	53.75
24	24	~16.2	16.731	24	28	29.75	54.75



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Revision Date: 9-22-2024