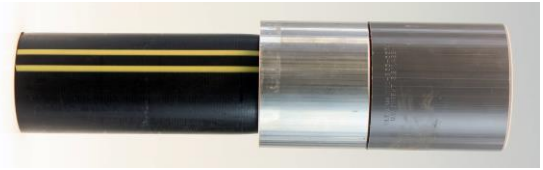




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Part Name: Gas Transition for PVC/HDPE  
Part Number: 816-xxxx

### **Gas Transition for PVC/HDPE**

**General:** The transition fitting is constructed out of PVC material, stainless steel support rings, and medium-density polyethylene (MDPE) PE2406 *or* high-density polyethylene (HDPE) PE3408/4710 pipe. The PVC and HDPE materials are joined together by hydraulically pressing the HDPE pipe into the PVC coupling. The PVC coupling portion of the transition fitting is machined with our multi-level barb system that provides a leak-free radial compressed joint. The HDPE portion of the transition fitting is cut to a specific length and is pressed into the PVC coupling. Two stainless steel rings are installed to lock the PVC coupling and HDPE pipe together thus forming a leak-proof joint.

### **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 ASTM F2897
- Meets ASTM D3261

## **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.

**PVC coupling:** Install the PVC coupling so as to comply with the PVC pipe manufacturer's recommended procedures for solvent cement.

## **Material**

**PVC coupling:** The PVC coupling is manufactured out of PVC round bar and PVC hollow bar. This material is a rigid, unfilled, general-purpose-grade Polyvinyl Chloride (PVC) compound with a cell classification of 12454, per ASTM D1784. (Callout designation S-PVC0111 per ASTM D6263).

**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.

**Stainless Steel outside ring and insert:** The outside ring and insert are manufactured out of 304 stainless steel tubing (ASTM A249 or ASTM A269) and/or ERW pipe (ASTM SA-312).

## **Warranty**

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

# Series 816 Gas Transition for PVC/HDPE

Nominal Size (In.)	Poly-Cam Female Glue Fitting Material	Coupling Diameter <b>A</b>	Coupling Length <b>B</b>	HDPE Length <b>C</b>	HDPE Diameter <b>D</b>
0.75	PVC	1.53	2.5	22.75	1.050
1	PVC	2	3	22.255	1.315
1.25	PVC	2.375	4.5	21.815	1.660
1.5	PVC	2.38	4.5	21.815	1.900
2	PVC	3.025	5.75	21.375	2.375
2.5	PVC	3.535	5.75	21.41	2.875
3	PVC	4.3	6.5	20.59	3.500
4	PVC	5.56	6.5	20.625	4.500
6	PVC	8.625	12.75	17.947	6.625

