



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



Part Name: CPVC/HDPE Transition Fitting
Part Number: 738-xxxx

CPVC/HDPE Transition Fitting

General: The transition fitting is constructed out of CPVC material, CPVC insert, and high-density polyethylene (HDPE) pipe. The CPVC and HDPE materials are joined together by hydraulically pressing the HDPE pipe into the CPVC coupling. The CPVC 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 CPVC coupling. A CPVC insert is installed to lock the CPVC 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:

- ARRA requirements

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.

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

Solvent Cement needs to meet ASTM F493.

Material

CPVC coupling and insert: The CPVC coupling is manufactured out of CPVC round bar and CPVC hollow bar. This material is a rigid, unfilled, light grey Chlorinated Polyvinyl Chloride (CPVC) compound with a cell classification of 23447-B, per ASTM D1784.

High Density Polyethylene: HDPE pipe

- Meets ASTM D-3350 with minimum cell classification values of 345464C (PE 3408), PE445574C (PE 4710)
- Meets ASTM F714.
- Density shall be no less than 0.955 g/cm as referenced in ASTM D1505
- Melt index no greater than 0.15 g/10 minutes when tested per ASTM D 1238
- Tensile Strength at Yield -tensile shall be 3,200 psi to less than 3,500 psi as referenced in ASTM D638
- ESCR-Environmental Stress Crack Resistance shall be over 5,000 hours with zero failures when tested per ASTM D 1693-Condition C
- All pipe meets ASTM 3035.
- All certifications will be submitted upon request.

Warranty

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

Series 738 Transition for CPVC/HDPE

Nominal Size (In.)	CPVC O.D. A	CPVC I.D. B	Est. I.D. Pressed SDR 9 C	Est. I.D. Pressed SDR 11 C	HDPE I.D. SDR 9 D	HDPE I.D. SDR 11 D	HDPE O.D. E	CPVC Length F	Exposed HDPE Length G	Total Length H
0.75	1.53	1.058	0.65	0.68	0.807	0.851	1.05	2.5	~7	~9.5
1	2	1.31	0.81	0.86	1.003	1.051	1.315	3	~6.25	~9.25
1.25	2.375	1.65	1.08	1.15	1.27	1.34	1.66	4.5	~5.75	~10.25
1.5	2.375	1.91	1.15	1.26	1.453	1.533	1.9	4.5	~5.75	~10.25
2	3.025	2.375	1.54	1.64	1.815	1.917	2.375	5.75	~5.5	~11.25
3	4.3	3.5	2.48	2.63	2.675	2.836	3.5	6.5	~4.5	~11
4	5.56	4.5	3.17	3.36	3.44	3.633	4.5	6.5	~8.5	~15
6	8	6.625	4.5	4.8	5.07	5.35	6.625	12	~18	~30
8	10	8.625	6	6.3	6.59	6.96	8.625	12	~18	~30

