



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



Part Name: Transition for Ductile Iron Size PVC/HDPE
Part Number: 732-xxxx

Transition Fitting for Ductile Iron Size PVC/HDPE

The transition fitting is constructed out of PVC material, ductile iron, and high density polyethylene (HDPE) 3408 pipe. The PVC and HDPE materials are joined together by hydraulically pressing the HDPE pipe into the ductile iron coupling. The coupling portion of the transition fitting is machined with our multi-level barb system that provides a leak-free radial compressed joint. The HDPE and PVC portions of the transition fitting are cut to a specific length and are pressed into the coupling.

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. Transition joint meets or exceeds the requirements of ASTM D2513 Category 3.

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.

Materials

Carbon steel coupling: The coupling is manufactured out of ductile iron.

The **epoxy coating** (IF 194T Red Iron Oxide) is fusion bonded to the metal. It has approvals NSF 61, FDA 175.300, AWWA C116-01, C213-01, UL 262 and FM 1120/1130

PVC SCH 35: PVC Gasket Sewer Pipe conforms to ASTM D-3034 in sizes 4 through 15” .

High Density Polyethylene: The transition fitting is constructed with a 3408 HDPE pipe (cell class 345454c) classified according to ASTM D3350.

Installation

HDPE pipe end

Install transition fitting to comply with the pipe manufacturer’s recommended procedures. All field welds shall be accomplished per Plastic Pipe Institute’s welding procedure for butt fusion or electrofusion.

PVC coupling

Install the PVC coupling to comply with the pipe manufacturer’s recommended procedures for solvent cement.

- A medium-bodied, medium set multi-purpose cement designed for use on PVC, CPVC and ABS pipe and fittings.
- Schedule 40 & 80, Types I & II, up to 6 inches.
- For potable water, pressure pipe, gas, and conduit drain waste and vent pipe.
- Flows freely and provides a thick layer of cement on the pipe and loose-fitting joints.
- Apply at temperatures 40°F to 100°F.
- Meets ASTM D-2564

Warranty

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

Series 732 Transition for Ductile Iron Size PVC/HDPE

SDR 17

Nominal Size (In.)	PVC, DI O.D. A	PVC I.D. B	DR17 HDPE Min. I.D. C	DR17 HDPE I.D. D	HDPE O.D. E	PVC Length F	DI Length G	HDPE Length H	Total Length J
4 (DIPS HDPE)	4.8	4.23	~3.6	4.202	4.8	4.5	6	4.5	15
4 (IPS HDPE)	4.8	4.23	~3.6	3.938	4.5	4.5	6	4.5	15
6 (DIPS HDPE)	6.9	6.09	~5.4	6.039	6.9	8	8	6	22
6 (IPS HDPE)	6.9	6.09	~5.5	5.798	6.625	8	8	6	22
8 (DIPS HDPE)	9.05	7.98	~7.2	7.922	9.05	9	9	6	24
8 (IPS HDPE)	9.05	7.98	~7.3	7.550	8.625	9	9	6	24
10 (DIPS HDPE)	11.01	9.79	~9.0	9.716	11.1	12	9	9	30
10 (IPS HDPE)	11.01	9.79	~9.0	9.410	10.75	12	9	9	30
12 (DIPS HDPE)	13.2	11.65	~10.8	11.555	13.2	12	13	12	37
12 (IPS HDPE)	13.2	11.65	~10.9	11.160	12.75	12	13	12	37

