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Part Name: PVC Glue x HDPE Transition Fitting
Part Number: 735-xxxx

PVC Glue x HDPE Transition Fitting

General: The transition fitting is constructed out of PVC material, stainless steel insert, and high-density polyethylene (HDPE) 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. A stainless-steel insert is 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:

- 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.

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

Multi-Purpose Clear Cement is 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, 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

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 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.

Stainless Steel insert: The insert is 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 735 Transition for PVC/HDPE

Nominal Size (In.)	PVC O.D. A	PVC 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	PVC 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
Stainless Steel ID Insert Standard - PVC ID Insert Available										

