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Part Name: ID-Controlled Weld-On Transition Fitting  
Part Number: 864-xxxx

### **ID Controlled Weld-On Transition Fitting**

**Description** - The Poly-Cam ID-Controlled Weld-On is designed to provide a smooth, interior transition between the steel pipe and the polyethylene pipe. The connection between the steel fitting and the polyethylene pipe is accomplished with a multi-level barb system and a compression ring supporting the connection. The multi-level barb system provides the sealing connection between the steel and the polyethylene pipe. The interior of the fitting contains no sharp edges in which pipeline cleaning pigs can be caught or damaged. The weld-on is coated with an epoxy coating. The compression ring is constructed out of carbon steel material and coated with an epoxy-coated material. Stainless steel compression rings are optional.

The Poly-Cam ID-Controlled Weld-On is a custom design fitting allowing the installer to transition from one specific type steel materials to a specific type of polyethylene pipe.

Tested and complies to ASTM D2513, ASTM 1973-05, D1599, D1598

#### **Steel Material Options:**

- A53B
- 304 Stainless Steel
- 316 Stainless Steel

#### **Polyethylene Pipe Options:**

- PE 3408 ASTM F-714
- PE 3408 ASTM 2513 Gas Pipe
- PE 2406
- PE 4710

Additional options are available.

#### **Epoxy Coated Material:**

- Color HB, Red Oxide, IF1947T or Green 3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 6233

# Series 864 Sch 40 ID Controlled Weld-On (A106)

## SDR 11

Nominal Size (In.)	HDPE Steel Pipe O.D. <b>A</b>	Steel Pipe I.D. <b>B</b>	Steel Length <b>C</b>	HDPE Pipe Length <b>D</b>	Compression Ring Length <b>E</b>	SDR 11 HDPE I.D. <b>F</b>	Compression Ring O.D. SDR 11 <b>G</b>
0.75	1.05	0.824	11	8	1.57	0.85	~1.84
2	2.375	2.067	12	24	3.5	1.917	~2.84
2.5	2.875	2.469	14	24	3.5	2.321	~3.41
3	3.5	3.068	14	24	5	2.826	~4.14
4	4.5	4.026	14	24	5.5	3.633	~5.44
6	6.625	6.065	20	30	8	5.349	~8.0
8	8.625	7.981	22	30	10	6.963	~10.3
10	10.75	10.02	26	40	12	8.679	~12.9
12	12.75	12	28	40	12	10.293	~15.3
14	14	13.25	28	40	12	11.301	~16.8
16	16.02	15.27	28	48	14	12.915	~19.2
18	18	17	28	48	14	14.532	~21.6
20	20	19	28	48	15	16.146	~24.0
24	24	23	28	48	15	19.374	~28.8

