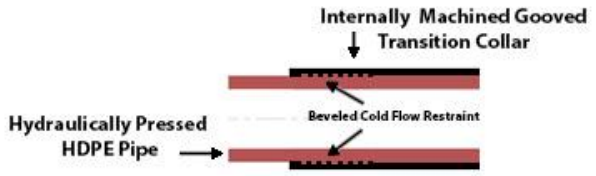
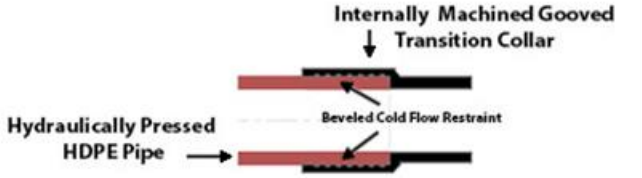
poxy Coated Carbon Steel and Stainless-Steel Transition Fittings are simple and reliable, and come in a variety of pipe diameters, configurations, SDR's that meet or exceed **ASTM D2513 Category 3** mechanical joint requirements. The Integrity Fusion Products Standard Transition Fitting design utilizes an internally machined and beveled groove on the interior circumference of the transition collar to hold the hydraulically pressed HDPE pipe in place with a robust mechanical joint that allows it to work at the MAOP of the inserted HDPE pipes SDR.

Once the HDPE pipe is hydraulically pressed into the transition collard, the pipe will "cold flow" into the machined grooves and relax, creating an airtight/watertight seal to prevent leakage. When subjected to pressure, the internal operating pressure flowing through the transition fitting will result in more force being placed on the pipe material that cold flowed into the machined grooves, creating stronger connection, and stronger seal between the pipe material and the transition collar.



Cat. 3 Standard Style



Cat. 3 Heavy Duty Style

INSTALLATION RECOMMENDATIONS

HDPE Transition Fitting Pipe Ends: can be joined with Butt Fusion, Electrofusion or Compression fittings rated for use with HDPE pipe and fittings. All joints should comply with the pipe manufacturer's recommended procedures.

Standard Transition Threaded Ends: the installer should always use pipe joint sealant or Teflon tape on the threads, then hand tighten the transition fitting into place. Using two (2) **strap wrenches -** tighten the transition fitting the rest of the way.

Do not use pipe wrenches when installing Standard Transition Fittings, only use strap wrenches!

Pipe wrenches will deform the transition collar and compromise the HDPE pipe seal around internally machined grooves and create a potential leak path. Over tightening the transition collar may also cause ovality or damage. Always pressure test for leaks before backfilling. Backfill and compact carefully around the transition and service line to prevent ground shifts which could damage the valve and/or transition fitting.

Heavy Duty Transition Threaded Ends: the installer should always use pipe joint sealant or Teflon tape on the threads, then hand tighten the transition fitting into place. It is ***highly recommended*** to use two (2) **strap wrenches** to tighten the transition fitting the rest of the way. However, ***pipe wrenches can be used*** but care must be taken to not be over-aggressive when tightening the transition and inadvertently break the seal around the internally machined grooves.