

Silver-Line Plastics

Yellow Polyethylene Gas Pipe & Tubing

PE2708 (formerly PE 2406) GAS PRESSURE PIPE IPS (Iron Pipe Size)

| Nominal Size | Item Number | Bar Code 717141 | Coil Length | (Value) Inside Diameter | Outside Diameter | Min. Wall Thickness | Max Working Pressure at 73°F | DR Rating | Wt / 100' |
|--------------|-------------|-----------------|-------------|-------------------------|------------------|---------------------|------------------------------|-----------|-----------|
| 1/2" | 50.050 | 500503 | 150' | 0.660 | 0.840 | 0.090 | 96 PSI | 9.3 | 9 |
| | 50.055 | 500558 | 500' | | | | | | |
| 3/4" | 52.070 | 520709 | 150' | 0.860 | 1.050 | 0.095 | 80 PSI | 11 | 12 |
| | 52.075 | 520754 | 500' | | | | | | |
| 1" | 52.100 | 521003 | 150' | 1.077 | 1.315 | 0.119 | 80 PSI | 11 | 19 |
| | 52.103 | 521034 | 300' | | | | | | |
| | 52.105 | 521058 | 500' | | | | | | |
| 1 1/4" | 52.120 | 521201 | 150' | 1.358 | 1.660 | 0.151 | 80 PSI | 11 | 31 |
| | 52.123 | 521232 | 300' | | | | | | |
| | 52.125 | 521256 | 500' | | | | | | |
| 1- 1/4" | 51.120 | 511202 | 150' | 1.328 | 1.660 | 0.166 | 88 PSI | 10 | 33 |
| | 51.125 | 511257 | 500' | | | | | | |
| 1- 1/2" | 52.150 | 521508 | 150' | 1.554 | 1.900 | 0.173 | 80 PSI | 11 | 40 |
| | 52.155 | 521555 | 500' | | | | | | |
| 2" | 52.201 | 522017 | 100' | 1.943 | 2.375 | 0.216 | 80 PSI | 11 | 63 |
| | 52.202 | 522024 | 200' | | | | | | |
| | 52.205 | 522055 | 500' | | | | | | |

PE2708 (formerly PE 2406) GAS PRESSURE PIPE CTS (Copper Tubing Size)

| Nominal Size | Item Number | Bar Code 717141 | Coil Length | (Value) Inside Diameter | Outside Diameter | Min. Wall Thickness | Max Working Pressure at 73°F | DR Rating | Wt / 100' |
|--------------|-------------|-----------------|-------------|-------------------------|------------------|---------------------|------------------------------|-----------|-----------|
| 1/2" | 56.050 | 560507 | 150' | 0.445 | 0.625 | 0.090 | 100 PSI | 7 | 6 |
| | 56.055 | 560552 | 500' | | | | | | |
| 1" | 58.100 | 57.1006 | 150' | 0.927 | 1.125 | 0.099 | 77 PSI | 11.5 | 14 |
| | 58.105 | 57.1051 | 500' | | | | | | |

P E 2708(form erly PE 2406) GAS P RE SS URE P IP E T UBING DR 11 (I r on P ipe S iz e)

| Nominal Size | Item Number | | Ft / Pallet | | (value) Inside Diameter | Out side Diameter | Min. Wall Thickness | Max Working Pressure | Wt / 100' |
|--------------|-------------|--------|-------------|--------|-------------------------|-------------------|---------------------|----------------------|-----------|
| | 20 FT. | 40 FT. | 20 FT. | 40 FT. | | | | | |
| 3" | 52.302 | 52.304 | 920 | 1840 | 2.864 | 3.500 | 0.318 | 80 PSI | 137 |
| 4" | 52.402 | 52.404 | 580 | 1160 | 3.682 | 4.500 | 0.409 | 80 PSI | 226 |

Yellow Polyethylene Gas pipe and tubing conforms to STM D 2513 NSF-gas UPC
 And NSF Standard 14 performance to ASTM D 2513 requirements of the Uniform Plumbing Code
 Manufactured from PE 2708 (formerly PE 2406) with the hydrostatic design basis (HDB) of 1250psi @73F
Rev 5/06

Warranty Stipulation: Silver-Line will reimburse up to \$5.00 per linear foot for reasonable direct labor charges to remove and replace defective gas pipe or tubing.

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Parameters for Socket Fusion of Polyethylene Pipe & Tubing

Silver-Line Plastics recommends using the times and temperatures listed below for heat fusion of pipe and tubing to other pipe, tubing, or fittings produced from PE 2708 (formerly 2406) material. The actual times may need to be adjusted for varying weather conditions such as wind, rain, cold or heat, etc.

Reference: Plastic Pipe Institute (PPI) Handbook of Polyethylene Pipe – Joining Procedures

Heat Fusion Condition – 75psig @ 500°F

Hold assembly under fusion force pressure until joint has solidified.

Heater surface temperature: 500± 10 °F

| Nominal Size | Socket Fusion Heat Time | Holding Cool Time | Curing Prior Handling Time |
|--------------|-------------------------|-------------------|----------------------------|
| 1/2" | 6 - 7 sec | 20 sec | 20 min |
| 3/4" | 8 - 10 sec | 20 sec | 20 min |
| 1" | 10 - 12 sec | 30 sec | 20 min |
| 1-1/4" | 12 - 14 sec | 30 sec | 20 min |
| 1-1/2" | 14 - 17 sec | 30 sec | 20 min |
| 2" | 16 - 19 sec | 30 sec | 30 min |
| 3" | 20 - 24 sec | 40 sec | 45 min |
| 4" | 24 - 29 sec | 50 sec | 60 min |

CAUTION: Excessive heating times can overheat the pipe or fitting and result in brittle joints. Shortened heating times can result in an incomplete bond of materials and a weak joint that may fail. When working against the coil memory, holding times shall be double. Silver-Line Plastics does not recommend fusion of Silver-Line Plastics pipe and tubing to materials of different grade or specification. Fusion joints between dissimilar materials may fail even when the time and temperature are correct.

Parameters for Butt Fusion of Polyethylene Pipe & Tubing

Heater surface temperature: should be a 400 °F min and 450 °F max.

Interface pressure - Minimum 60 psi - Maximum 90 psi

Approximate Melt Bead Size

| Nominal Size | Melt Bead Size |
|---------------------|----------------|
| 3/4" through 1-1/4" | 1/32" - 1/16" |
| 1-1/2" through 3" | About 1/16" |
| 4" | 1/8" |

Parameters for Saddle Fusion of Polyethylene Pipe & Tubing

Heater surface temperature: should be a 490 °F min and 510 °F max.

Interface pressure - Minimum 60 psi - Maximum 90 psi

Approximate Melt Bead Size

| Nominal Size | Melt Bead Size | Holding Cool Time | Curing Prior Handling Time |
|--------------|----------------|-------------------|----------------------------|
| 1-1/4" | 1/16" | 5 min | 20 min |
| 2" | 1/16" | 10 min | 20 min |
| 3" and 4" | 1/8" | 10 min | 20 min |

Never reduce joining force during the Holding Cool Time period, even if joining force increases on its own by the saddle fusion equipment. Determine saddle fusion forces from the fitting label.

Warning: Before you begin with Butt or Saddle Fusion, make sure that the heater faces are clean to insure no contamination of the fusion joints. The heater temperatures should be verified and meet the prescribed temperatures listed above.