

Yellow Polyethylene Gas Pipe & Tubing

PE 2708 (formerly PE 2406) GAS PRESSURE PIPE IPS (Iron Pipe Size)

Nominal Size	Item Number	Bar Code 7 17141	Coil Length	(Value) Inside Diameter	Outside Diameter	Min. Wall Thickness	Max Working Pressure at 73° F	DR Rating	Wt/100'
1/2"	50.050	50050 3	150'	0.660	0.840	0.090	96 PSI	9.3	9
	50.055	50055 8	500'						
3/4"	52.070	52070 9	150'	0.860	1.050	0.095	80 PSI	11	12
	52.075	52075 4	500'						
1"	52.100	52100 3	150'	1.077	1.315	0.119	80 PSI	11	19
	52.103	52103 4	300'						
	52.105	52105 8	500'						
1 1/4"	52.120	52120 1	150'	1.358	1.660	0.151	80 PSI	11	31
	52.123	52123 2	300'						
	52.125	52125 6	500'						
1-1/4"	51.120	51120 2	150'	1.328	1.660	0.166	88 PSI	10	33
	51.125	51125 7	500'						
1-1/2"	52.150	52150 8	150'	1.554	1.900	0.173	80 PSI	11	40
	52.155	52155 5	500'						
2"	52.201	52201 7	100'	1.943	2.375	0.216	80 PSI	11	63
	52.202	52202 4	200'						
	52.205	52205 5	500'						

PE 2708 (formerly PE 2406) GAS PRESSURE PIPE TUBING CTS (Copper Tubing Size)

Nominal Size	Item Number	Bar Code 7 17141	Coil Length	(Value) Inside Diameter	Outside Diameter	Min. Wall Thickness	Max Working Pressure at 73° F	DR Rating	Wt/100'
1/2"	56.050	56050 7	150'	0.445	0.625	0.090	100 PSI	7	6
	56.055	56055 2	500'						
1"	58.100	57.100 6	150'	0.927	1.125	0.099	77 PSI	11.5	14
	58.105	57.105 1	500'						

PE 2708 (formerly PE 2406) GAS PRESSURE PIPE TUBING DR 11 (Iron Pipe Size)

Nominal Size	Item Number		Ft/Pallet		(Value) Inside Diameter	Outside 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 **ASTM D 2513** 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 1250 psi @ 73F

NSF-gas UPC

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.

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 PE 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 - 75 psig @ 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.