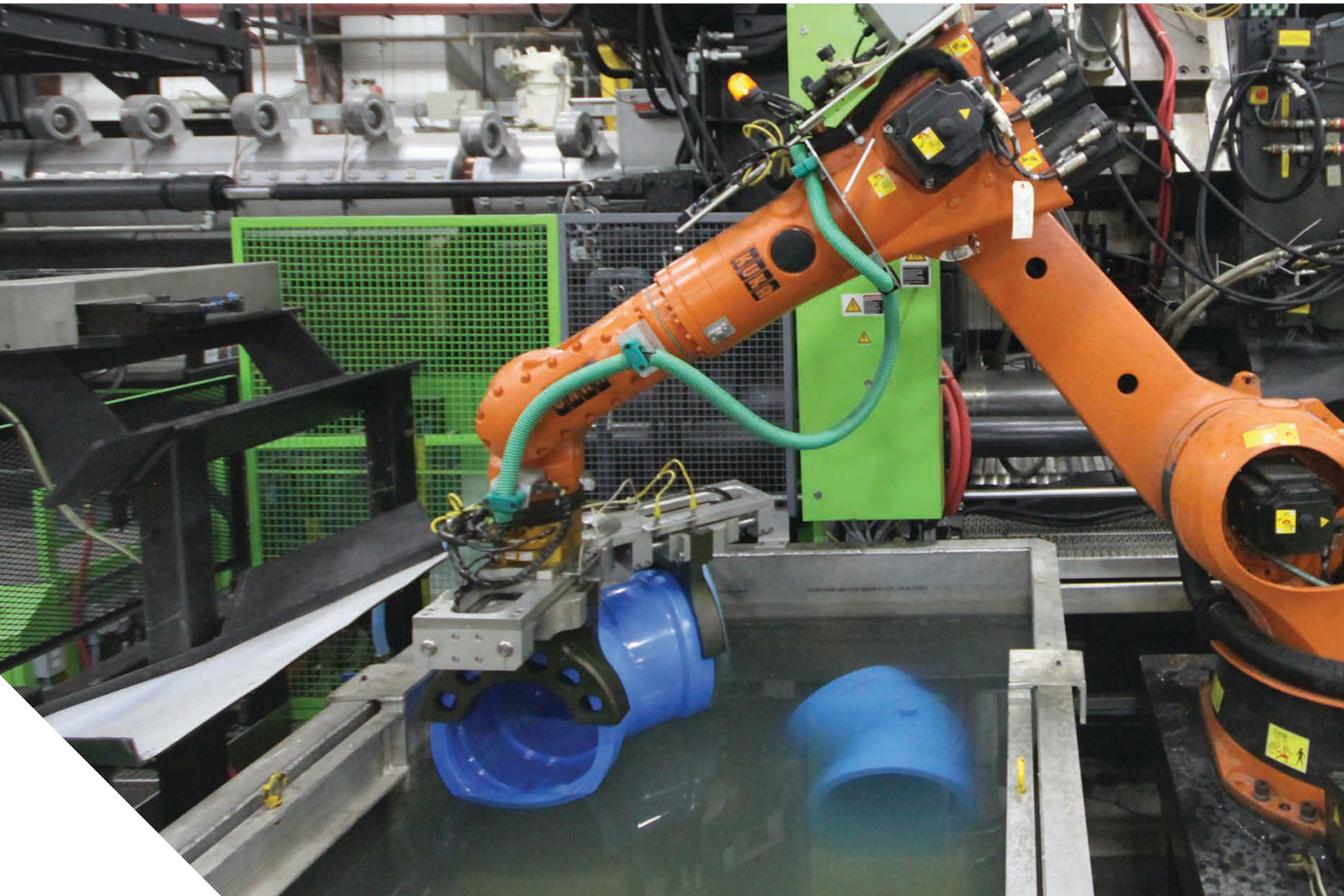


**BLUE BRUTE<sup>®</sup>**  
**FITTINGS**





## Canada's Leader in Thermoplastic Piping Systems

As a leader in thermoplastic piping for more than 50 years – with the longest track record of success in the infrastructure business – IPEX provides unsurpassed product engineering expertise to meet the demanding requirements of today's complex municipal pressure and gravity applications. IPEX designs and manufactures the largest, most recognized and diverse range of integrated piping products. This means that customers can be confident everything they need is designed, built and backed by the same company – one supplier to stand behind you and your complete system.

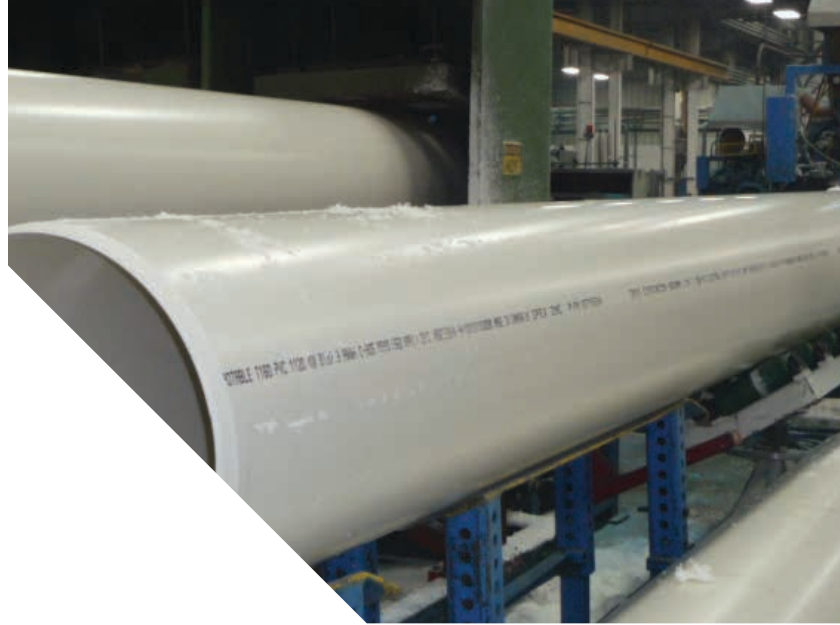






## Quality Manufacturing

To maintain a competitive advantage for our customers, IPEX utilizes the most progressive manufacturing systems, processes and quality control procedures available. This, along with the depth of knowledge that comes from producing high-volume, high quality products day-in day-out for over fifty years, means distributors and customers alike can depend on IPEX to deliver reliable and innovative brand name products synonymous with performance, service and value.



## Innovation

As one of the first to pioneer PVC pipe in North America our commitment to innovation has led IPEX to introduce many industry firsts – including the largest sizes of PVC pressure pipe and fittings available anywhere in North America.

## Service

Our product specialists and application engineers provide the most comprehensive, before-and-after-sale support in the industry. All this along with on-line technical resources and on-site training gives professionals everything they need to get up and running faster, easier and more profitably.

With an efficient coast-to-coast network of distribution centres, and a close working relationship with leading distributors, customers have products and parts when and where they need them.





## ADVANTAGES of Molded PVC Fittings from IPEX



### ENGINEERED FOR STRENGTH

The body of Class 235\* Blue Brute fittings has walls at least 125% of the wall thickness of Class 235\* Blue Brute pipe of the same size. Made of 12454 compound, they have the same long-term hydrostatic strength as the pipe.

\* FM PC150



### MANUFACTURING CONSISTENCY

With ISO 9000 best-in-class manufacturing and quality control processes IPEX provides the most consistent supply of AWWA C907 molded fittings in the market today.



### LIGHT-WEIGHT / COMPACT DESIGN

Typically 50% of the weight of fabricated fittings and metal alternatives, molded PVC fittings from IPEX take less energy to transport and provide more convenience on the jobsite.



## CORROSION RESISTANT

Made of non-corroding PVC, Blue Brute fittings will not rust or corrode in aggressive soils. Consequently, costly sacrificial anodes and expensive protective coatings commonly used with metal fittings are not required.



## IMPROVES WATER QUALITY AND MAINTAINS THE ENVIRONMENT

The precise tolerances of Blue Brute systems ensure tight joints capable of withstanding pressures three times the pressure class of the pipe. The results are bottle tight joints that keep potable water clean. And the smooth interior surface of Blue Brute pipe and fittings virtually eliminates encrustants from adhering to its surface providing better water quality.



## GASKET OPTIONS

All Blue Brute fittings are shipped with standard gaskets that accept cast-iron-sized PVC pipe. Should a more chemically resistant gasket be necessary due to ground contaminants, chemically resistant Nitrile and EPDM gaskets are available.



## BIONAX® COMPATIBILITY

IPEX manufactures the most innovative pressure piping system in the market today – Bionax® PVCO. 4" to 12" Bionax can now be specified as an all PVC system utilizing one-piece molded Blue Brute fittings from IPEX. All designed, manufactured and supported from a single Canadian source.



## PRISTINE FITTINGS FROM PLANT TO JOBSITE

All IPEX Blue Brute 10" fittings and larger are individually bagged and factory sealed, arriving on the jobsite looking the same as the day they were produced.





## IPEX Quality Assurance

At IPEX, we leave nothing to chance, ensuring quality is built-in, instead of simply being inspected in. During daily production, samples are randomly collected and tested to meet or exceed the toughest industry standards. In addition, our quality systems and manufacturing plants are ISO registered.



### DIMENSIONAL TESTS

The minimum wall thickness of the Blue Brute molded fitting body must be at least 125% of the wall thickness of AWWA C900 pipe of the same size. Also, the ratio of the outside diameter to the wall thickness (DR) at any point of the bell must be 18 or less.

The unobstructed inside diameter of the fitting's body must not be less than the inside diameter of DR25 AWWA pipe. Fabricated fittings must have DR18 inside diameters.



### MATERIAL TESTS

PVC compound must meet the requirements of cell classification 12454 according to ASTM D1784. The compound must also have a Hydrostatic Design Basis (HDB) of 27.6 MPa (4,000 psi) when tested as molded tubes in accordance with ASTM D1598 and D2837.



D1784



5.21 MPa



### BURST PRESSURE TESTS

Blue Brute fittings must have a Quick Burst Strength of 5.21 MPa (755 psi), the same as Class 235\* (DR18) pipe, when tested in accordance with ASTM D1599.

\* FM PC150



### QUALIFICATION TESTS

Fittings are subjected to long-term pressure tests described in ASTM D1598. They demonstrate an average extrapolated LTPS of 470 psi at 100,000 hrs.



### FUSION TESTS

Randomly selected fittings must pass the heat reversion test ensuring optimum homogeneity.

## IPEX Blue Brute Fittings Meet These Standards



AWWA C907 Injected Molded Polyvinyl Chloride (PVC) Pressure Fittings, 4" through 12" (100mm through 300mm), for Water, Wastewater and Reclaimed Water Service



CSA B137.2 Polyvinyl Chloride (PVC) Injection-Moulded Gasketed Fittings for Pressure Applications



UL 1285 Pipe and Couplings, Polyvinyl Chloride (PVC), and Oriented Polyvinyl Chloride (PVCO) for Underground Fire Services



FM Polyvinyl Chloride (PVC) Pipe and Fittings for Underground Fire Protection Services Factory Mutual Approved



Compound listed by National Sanitation Foundation for potable water service




NQ 3660-950 Safety of Products and materials in Contact with Drinking Water

# C907 BLUE BRUTE MOLDED PVC FITTINGS

|   | Inches              | mm        | Product Code |   | Inches                                 | mm        | Product Code |
|---|---------------------|-----------|--------------|---|--|-----------|--------------|
|    | 90° Elbow (BxB)     |           |              |    | Coupling with Stop (B x B)             |           |              |
|   | 4                   | 100       | 073150       |   | 4                                      | 100       | 073030       |
|   | 6                   | 150       | 073151       |   | 6                                      | 150       | 073031       |
|   | 8                   | 250       | 073152       |   | 8                                      | 200       | 073032       |
|   | 10                  | 250       | 373012       |   | New 10                                 | 250       | 373028       |
|   | 12                  | 300       | 373013       | New 12  | 300                                    | 373032    |              |
|    | 45° Elbow (BxB)     |           |              |    | Repair Coupling (B x B)                |           |              |
|   | 4                   | 100       | 073120       |   | 4                                      | 100       | 073404       |
|   | 6                   | 150       | 073121       |   | 6                                      | 150       | 073406       |
|   | 8                   | 200       | 073122       |   | 8                                      | 200       | 073408       |
|   | 10                  | 250       | 373123       |   | New 10                                 | 250       | 373027       |
|   | 12                  | 300       | 373124       | New 12  | 300                                    | 373031    |              |
|    | 22-1/2° Elbow (BxB) |           |              |    | Tapped Plugs (I.P.S. Threads)          |           |              |
|   | 6                   | 150       | 073106       |   | 4 x 3/4                                | 100 x 20  | 273192       |
|   | 8                   | 200       | 073107       |   | 4 x 1                                  | 100 x 25  | 073193       |
|   | 10                  | 250       | 373108       |   | 4 x 1-1/2                              | 100 x 40  | 073194       |
|  | 12                  | 300       | 373109       |   | 4 x 2                                  | 100 x 50  | 273195       |
|   | 11-1/4° Elbow (BxB) |           |              |   | 6 x 3/4                                | 150 x 20  | 273199       |
|   | 4                   | 100       | 273104       |   | 6 x 1                                  | 150 x 25  | 273200       |
|   | 6                   | 150       | 073091       |   | 6 x 1-1/2                              | 150 x 40  | 273201       |
|   | 8                   | 200       | 073092       |   | 6 x 2                                  | 150 x 50  | 273196       |
|  | Tee (BxBxB)         |           |              |   | 8 x 3/4                                | 200 x 20  | 073203       |
|   | 4                   | 100       | 073285       |   | 8 x 1                                  | 200 x 25  | 073204       |
|   | 6                   | 150       | 073286       |   | 8 x 1-1/2                              | 200 x 40  | 073197       |
|   | 6 x 4               | 150 x 100 | 073241       |   | 8 x 2                                  | 200 x 50  | 273198       |
|   | 8                   | 200       | 073287       |  | Plug (Plain End)                       |           |              |
|   | 8 x 4               | 200 x 100 | 073242       |   | 4                                      | 100       | 073180       |
|   | 8 x 6               | 200 x 150 | 073243       |   | 6                                      | 150       | 073181       |
|   | 10                  | 250       | 373288       |   | 8                                      | 200       | 073182       |
|   | 10 x 4              | 250 x 150 | 373239       |   | 10                                     | 250       | 073183       |
|   | 10 x 6              | 250 x 150 | 373244       |   | 12                                     | 300       | 073184       |
|   | 10 x 8              | 250 x 200 | 373250       |  | High Deflection Couplings              |           |              |
|   | 12                  | 300       | 373289       |   | • 4                                    | 100       | 273523       |
|   | 12 x 4              | 300 x 150 | 373727       |   | • 6                                    | 150       | 273524       |
|   | 12 x 6              | 300 x 150 | 373245       |   | • 8                                    | 200       | 273525       |
|   | 12 x 8              | 300 x 200 | 373246       |   | • 10                                   | 250       | 273526       |
|   | 12 x 10             | 300 x 250 | 373247       |   | • 12                                   | 300       | 273527       |
|  | Reducer (B x SP)    |           |              |  | New Fitting – Hydrant Tee (B x B x SP) |           |              |
|   | 6 x 4               | 150 x 100 | 273211       |   | 10 x 6                                 | 250 x 150 | 273989       |
|   | 8 x 6               | 200 x 150 | 073212       |   | 12 x 6                                 | 300 x 150 | 273070       |
|   |                     | 10 x 8    | 250 x 200    | 273213  |  |           |              |
|   | 12 x 10             | 300 x 250 | 273214       |   |  |           |              |



|   | Inches                 | mm       | Product Code         |
|---|------------------------|----------|----------------------|
|  | <b>Tapped Coupling</b> |          |                      |
|   | 4 x 4 x 3/4            | 100 x 20 | 073267 (AWWA Thread) |
|   | 4 x 4 x 1              | 100 x 25 | 073268 (AWWA Thread) |
|   | 6 x 6 x 3/4            | 150 x 20 | 073256 (AWWA Thread) |
|   | 6 x 6 x 1              | 150 x 25 | 073257 (AWWA Thread) |
|   | 6 x 6 x 1-1/4          | 150 x 32 | 273144 (AWWA Thread) |
|   | 6 x 6 x 1-1/2          | 150 x 40 | 073300 (AWWA Thread) |
|   | 6 x 6 x 1-1/2          | 150 x 40 | 073301 (NPT Thread)  |
|   | 6 x 6 x 2              | 150 x 50 | 073299 (AWWA Thread) |
|   | 6 x 6 x 2              | 150 x 50 | 073258 (NPT Thread)  |
|   | 8 x 8 x 3/4            | 200 x 20 | 073259 (AWWA Thread) |
|   | 8 x 8 x 1              | 200 x 25 | 073260 (AWWA Thread) |
|   | 8 x 8 x 1-1/4          | 200 x 32 | 073147 (AWWA Thread) |
|   | 8 x 8 x 1-1/2          | 200 x 40 | 273265 (AWWA Thread) |
|   | 8 x 8 x 1-1/2          | 200 x 40 | 073264 (NPT Thread)  |
|   | 8 x 8 x 2              | 200 x 50 | 073266 (AWWA Thread) |
|   | 8 x 8 x 2              | 200 x 50 | 073261 (NPT Thread)  |
|   | New 10 x 10 x 3/4      | 250 x 20 | 373029 (AWWA Thread) |
|   | New 10 x 10 x 1        | 250 x 25 | 373030 (AWWA Thread) |
|   | New 12 x 12 x 3/4      | 300 x 20 | 373033 (AWWA Thread) |
|   | New 12 x 12 x 1        | 300 x 25 | 373034 (AWWA Thread) |



#### Double Tapped Coupling

|                   |                     |                      |
|-------------------|---------------------|----------------------|
| 6 x 6 x 3/4 x 3/4 | 150 x 150 x 20 x 20 | 073305 (AWWA Thread) |
| 6 x 6 x 1 x 1     | 150 x 150 x 25 x 25 | 073308 (AWWA Thread) |
| 8 x 8 x 3/4 x 3/4 | 200 x 200 x 20 x 20 | 073290 (AWWA Thread) |
| 8 x 8 x 1 x 1     | 200 x 200 x 25 x 25 | 073307 (AWWA Thread) |

\* One-piece machined coupling.

For alternate gasket options and additional fabricated fittings, please refer to our Blue Brute Fittings Price List

## Specifications

### GENERAL

Blue Brute fittings shall conform to AWWA C907 "Injection-Molded Polyvinyl Chloride (PVC) Pressure Fittings, 4" through 12" (100 mm through 300 mm), for Water, Wastewater and Reclaimed Water Service applications." They shall also be CSA certified, UL listed and FM approved.

### MATERIAL

Blue Brute fittings shall be made of PVC compound 12454 (ASTM D1784) and have a Hydrostatic Design Basis of 27.6 MPa (4,000 psi). The compound shall be listed with the National Sanitation Foundation.

### LUBRICANT

All fittings must be assembled with IPEX nontoxic, water-soluble, NSF-listed lubricant.

### COLOUR CODING

Fittings shall be coloured-coded blue.

IMPROVES  
WATER QUALITY

MANUFACTURING  
CONSISTENCY

CORROSION  
RESISTANT

ENVIRONMENTAL  
FRIENDLY

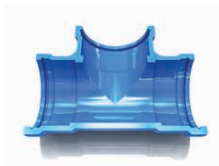
ENGINEERED  
FOR STRENGTH

LIGHT-WEIGHT/  
COMPACT DESIGN

QUALITY  
ASSURANCE

BETTER  
PACKAGING

BIONAX<sup>®</sup>  
COMPATIBILITY







IPEX Inc.  
Toll Free: (866) 473-9462  
[ipexna.com](http://ipexna.com)

### About the IPEX Group of Companies

As leading suppliers of thermoplastic piping systems, the IPEX Group of Companies provides our customers with some of the world's largest and most comprehensive product lines. All IPEX products are backed by more than 50 years of experience. With state-of-the-art manufacturing facilities and distribution centers across North America, we have established a reputation for product innovation, quality, end-user focus and performance.

Markets served by IPEX group products are:

- Municipal pressure and gravity piping systems
- Irrigation systems
- Electrical systems
- Telecommunications and utility piping systems
- PVC, CPVC, PP, PVCO, ABS, PEX, FR-PVDF and PE pipe and fittings (1/4" to 48")
- Industrial process piping systems
- Plumbing and mechanical piping systems
- PE Electrofusion systems for gas and water
- Industrial, plumbing and electrical cements



This literature is published in good faith and is believed to be reliable. However, it does not represent and/or warrant in any manner the information and suggestions contained in this brochure. Data presented is the result of laboratory tests and field experience. A policy of ongoing product improvement is maintained. This may result in modifications of features and/or specifications without notice.

Products are manufactured by IPEX Inc.