

**TDR LINK**  
ULTRA SERIES

**HDPE FABRICATED FITTINGS**



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TDR™ LINK is here to turn pipes into working water management systems. Integrating custom-made and standard fittings with a wide range of accessories, we can deliver a flexible, efficient, and easy-to-install solution for any water management infrastructure project.

## SCOPE

This specification designates the requirements for 4" through 60" TDR™ LINK fittings for use in gravity flow drainage applications. Common corrugated fittings include in-line joint fittings, such as couplings and reducers, and branch or complementary assembly fittings such as tees, wyes, and end caps.

## PRODUCT REQUIREMENTS

Fabricated fittings shall be supplied with joints compatible with the overall system and shall be manufactured from pipe meeting the requirements of this specification and all seams must be completely sealed with compatible material. Only fittings supplied or recommended by the pipe manufacturer shall be used. The fittings shall not reduce or impair the overall integrity or function of the pipe line and shall be such that when connected with the pipe, the axis of the assembly will be level and true.

Couplings shall be corrugated to match the pipe corrugations and shall provide sufficient longitudinal strength to preserve pipe alignment and prevent separation at the joints. Couplings shall be bell and spigot or split coupler. Split couplings shall engage at least two full corrugations on each pipe section.

## MATERIALS

TDR™ LINK fittings are manufactured from pipe using high-density polyethylene (HDPE) meeting the minimum requirements of cell classification 435420C/E for all pipe sizes as defined and described in ASTM D3350. Carbon black content shall be between 2 and 4%. Materials for 12" through 60" pipe sizes shall comply with NCLS test according to sections 9.4 and 5.1 of AASHTO M294 and ASTM F2306 respectively.

## JOINT PERFORMANCE

The joining system(s) shall be of a design that preserves alignment during construction and prevents separation at the joints. Bell and spigot, external snap or split couplers are examples of typical designs. Watertight joints meet a 10.8 psi laboratory test in accordance with Test Method ASTM D3212 and utilize a bell and spigot design with a gasket meeting Specification ASTM F477.

## INSTALLATION

Pipe and fittings shall be installed in accordance with ASTM D2321 and TDR's published Installations Guideline. Minimum cover for trafficked areas shall be 12" (0.3m). Maximum cover height depends on materials used for embedment and haunching. Please refer to TDR's Technical Service for more detail. Contact your TDR's representative for the latest installations guideline and recommendations.

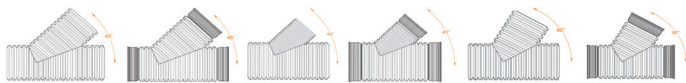
22.5°, 30°, 45° And 90° Bends



Reducing, Cross and Standard Tees



45°, 60° Reducing and Standard Wyes



Eccentric and Concentric Reducers

