

## Plasson Line 7 mechanical compression fittings

PLASSON Line 7 fittings are an internationally recognised range of pressure rated compression fittings, for use with Iplex BLUELINE™, GREENLINE™, REDLINE™, RURAL BLACK™, BLACKLINE™ PN16 and Iplex EFFLUENT PIPE. PLASSON Mechanical fittings are rated to PN16 except as listed in the tables below. PLASSON Line 7 fittings can also be used on 20mm or 25mm (Nominal ID size) Iplex ALKATHENE™ low density polyethylene pipe. Plasson fittings offer effective joint security for metric OD polyethylene pipe and form a seal without distorting the pipe or restricting the pipe bore. A large range of threaded fittings and accessories make PLASSON a versatile product range and allow compatability with other pipe materials.

**See the Iplex Product Catalogue in the Resources section of the Iplex NZ Website for our complete Plasson Fittings Range**



## Plasson "Line 7" Compression Fittings (20 - 110mm)

### 90 Elbow°



Code	Size mm
2501.20	20
2501.25	25
2501.32	32
2501.40	40
2501.50	50
2501.63	63
2501.90	90
2501.110	110

### Slip Tee 90°



Code	Size mm
2502.20	20
2502.25	25
2502.32	32
2502.40	40
2502.50	50
2502.63	63

40 - 63mm: 12.5 Bar

### Female Threaded Tee



Code	Size mm x BSP
2503.20.15	20 x 1/2"
2503.25.20	25 x 3/4"
2503.32.25	32 x 1"
2503.40.32	40 x 1 1/4"
2503.50.40	50 x 1 1/2"
2503.63.50	63 x 2"
2503.75.65	75 x 2 1/2"
2503.90.80	90 x 3"
2503.110.100	100 x 4"

90mm: 10 Bar  
110mm: 6 Bar

### Tee 90°



Code	Size mm
2504.20	20
2504.25	25
2504.32	32
2504.40	40
2504.50	50
2504.63	63
2504.90	90
2504.110	110

### Reducing Tee 90°



Code	Size mm
2505.25.20	25 x 20
2505.32.25	32 x 25
2505.40.32	40 x 32
2505.50.40	50 x 40
2505.63.50	63 x 50
2505.75.63	75 x 63

### Female Threaded Adapter



90mm: 10 Bar  
110mm: 6 Bar

Code	Size mm x BSP
2506.20	20 x 1/2"
2506.25	25 x 3/4"
2506.32	32 x 1"
2506.40	40 x 1 1/4"
2506.50	50 x 1 1/2"
2506.63	63 x 2"
2506.75.65	75 x 2 1/2"
2506.90	90 x 3"
2506.110	110 x 4"

### Male Threaded Elbow 90°



Code	Size mm x BSP
2507.20	20 x 1/2"
2507.25	25 x 3/4"
2507.32	32 x 1"
2507.40	40 x 1 1/4"
2507.50	50 x 1 1/2"
2507.63	63 x 2"

### Female Threaded Elbow 90°



Code	Size mm x BSP
2508.20	20 x 1/2"
2508.25	25 x 3/4"
2508.32	32 x 1"
2508.40	40 x 1 1/4"
2508.50	50 x 1 1/2"
2508.63	63 x 2"

### Wingback Female Adapter



Code	Size mm x BSP
2509.20	20 x 1/2"
2509.25	25 x 3/4"

### Coupling



Code	Size mm
2510.20	20
2510.25	25
2510.32	32
2510.40	40
2510.50	50
2510.63	63
2510.75	75
2510.90	90
2510.110	110

### Universal Slip Repair Coupling



Iplex Code	Size mm x mm
3511.24-28	24 x 28mm
3511.31-35	31 x 35mm
3511.40-43	40 x 43mm
3511.48-51	48 x 51mm
3511.60-64	60 x 64mm

### Slip Coupling



Code	Size mm
2511.20	20
2511.25	25
2511.32	32
2511.40	40
2511.50	50
2511.63	63

Designed for retrofit "slip" assembly into an existing pipeline

### Universal Coupling



Code	Size mm
2512.25x15-22	20 x 15 to 22
2512.25x20-27	25 x 20 to 27
2512.25x27-35	25 x 27 to 35
2512.32x27-35	32 x 27 to 35
2512.50x35-50	50 x 35 to 50

50mm: 10 Bar

Adapts "metric OD" PE pipe to PVC, steel, copper and imperial OD LDPE or HDPE, within the OD size ranges above

### Male Threaded Adapter



Code	Size mm x BSP
2513.20	20 x 1/2"
2513.25.15	25 x 1/2"
2513.25	25 x 3/4"
2513.32	32 x 1"
2513.40	40 x 1 1/4"
2513.50	50 x 1 1/2"
2513.63	63 x 2"
2513.75.65	75 x 2 1/2"
2513.90	90 x 3"
2513.110	110 x 4"

### Female Threaded Branch Saddle



25 - 63mm: 12.5 Bar  
75 - 110mm: 10 Bar

Code	Size mm x BSP
2519.25.20	25 x 3/4"
2519.32.25	32 x 1"
2519.40.25	40 x 1"
2519.50.15	50 x 1/2"
2519.50.20	50 x 3/4"
2519.50.25	50 x 1"
2519.50.32	50 x 1 1/4"
2519.63.15	63 x 1/2"
2519.63.20	63 x 3/4"
2519.63.25	63 x 1"
2519.63.32	63 x 1 1/4"
2519.63.40	63 x 1 1/2"
2519.75.25	75 x 1"
2519.75.50	75 x 2"
2519.90.25	90 x 1"
2519.90.50	90 x 2"
2519.110.25	110 x 1"
2519.110.32	110 x 1 1/4"
2519.110.40	110 x 1 1/2"

## Reducing Coupling



Code	Size mm
2523.25.20	25 x 20
2523.32.25	32 x 25
2523.40.32	40 x 32
2523.50.40	50 x 40
2523.63.50	63 x 50
2523.75.63	75 x 63
2523.90.75	90 x 75
2523.110.90	110 x 90

## Reducing Set



110mm x 75mm: 10 Bar  
110mm x 90mm: 10 Bar

Reduces the size of  
any Plasson Line 7  
mechanical socket

Code	Size mm
2524.25.20	25 x 20
2524.32.20	32 x 25
2524.32.25	40 x 32
2524.40.25	50 x 40
2524.40.32	63 x 50
2524.50.25	75 x 63
2524.50.32	90 x 75
2524.50.40	50 x 40
2524.63.25	63 x 25
2524.63.32	63 x 32
2524.63.40	63 x 40
2524.63.50	63 x 50
2524.75.63	75 x 63
2524.110.63	110 x 63
2524.110.75	110 x 75
2524.110.90	110 x 90

## Shouldered Adapter



Code	Size mm
2525.63	63
2525.110	110

## End Plug



Code	Size mm
2531.20	20
2531.25	25
2531.32	32
2531.40	40
2531.50	50
2531.63	63
2531.75	75
2531.90	90
2531.110	110

## Barrel Union Threaded Male Adapter



75mm: 12 Bar

Code	Size mm x BSP
2572.25.15	25 x 1/2"
2572.25.20	25 X 3/4"
2572.32.15	32 x 1/2"
2572.32.20	32 x 3/4"
2572.32.25	32 x 1"
2572.40.25	40 x 1"
2572.40.32	40 x 1 1/4"
2572.40.40	40 x 1 1/4"
2572.50.25	50 x 1"
2572.50.32	50 x 1 1/4"
2572.50.40	50 x 1 1/4"
2572.50.50	50 x 2"
2572.63.25	63 x 1"
2572.63.32	63 x 1 1/4"
2572.63.40	63 x 1 1/4"
2572.63.50	63 x 2"
2572.63.65	63 x 2 1/4"
2572.75.40	75 x 1 1/4"
2572.75.50	75 x 2"
2572.75.65	75 x 2 1/4"
2572.75.80	75 x 3"

## Plug Adapter



12.5 Bar

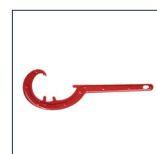
Code	Size mm
2530.20	20
2530.25	25
2530.32	32
2530.40	40
2530.50	50
2530.63	63

## Modular Adapter



Code	Size mm
2579.20	20
2579.25	25
2579.32	32
2579.40	40
2579.50	50
2579.63	63

## Wrench



Designed for use with Plasson Line 7 fittings only

Code	Size mm
2550.40.75	40 to 75
2550.63.125	63 to 125

## Chamfering Tool



Code	Size mm
2555.20.63	25 to 63

# Plasson Threaded Fittings

## Threaded Nipple



16 Bar

Code	Size BSP
2516.15	1/2"
2516.20	3/4"
2516.25	1"
2516.32	1 1/4"
2516.40	1 1/2"
2516.50	2"

## Threaded Tee



1/2" - 1": 16 Bar  
1 1/4" - 2": 10 Bar

Code	Size BSP
2514.15	1/2"
2514.20	3/4"
2514.25	1"
2514.32	1 1/4"
2514.40	1 1/2"
2514.50	2"

## Threaded Reducing Nipple



16 Bar

Code	Size mm
2518.20.15	3/4" x 1/2"
2518.25.15	1" x 1/2"
2518.25.20	1" x 3/4"
2518.32.15	1 1/4" x 1/2"
2518.32.20	1 1/4" x 3/4"
2518.32.25	1 1/4" x 1"
2518.40.15	1 1/2" x 1 1/2"
2518.40.20	1 1/2" x 1 1/4"
2518.40.25	1 1/2" x 1"
2518.40.32	1 1/2" x 1 1/4"
2518.50.15	2" x 1/2"
2518.50.20	2" x 3/4"
2518.50.25	2" x 1"
2518.50.32	2" x 1 1/4"
2518.50.40	2" x 1 1/2"

## Threaded Reducing Bush



1/2" - 1": 16 Bar  
1 1/4" - 4": 10 Bar

Code	Size mm
2517.20.15	3/4" x 1/2"
2517.25.15	1" x 1/2"
2517.25.20	1" x 3/4"
2517.32.15	1 1/4" x 1/2"
2517.32.20	1 1/4" x 3/4"
2517.32.25	1 1/4" x 1"
2517.40.15	1 1/2" x 1/2"
2517.40.20	1 1/2" x 3/4"
2517.40.25	1 1/2" x 1"
2517.40.32	1 1/2" x 1 1/4"
2517.50.15	2" x 1/2"
2517.50.20	2" x 3/4"
2517.50.25	2" x 1"
2517.50.32	2" x 1 1/4"
2517.50.40	2" x 1 1/2"
2517.65.50	2 1/2" x 2"
2517.80.25	3" x 1"
2517.80.32	3" x 1 1/4"
2517.80.40	3" x 1 1/2"
2517.80.50	3" x 2"
2517.80.65	3" x 2 1/2"
2517.100.50	4" x 2"
2517.100.80	4" x 3"

## Threaded Elbow



1/2" - 1": 16 Bar  
1 1/4" - 2": 10 Bar

Code	Size BSP
2515.15	1/2"
2515.20	3/4"
2515.25	1"
2515.32	1 1/4"
2515.40	1 1/2"
2515.50	2"

## Threaded Socket



1/2" - 1": 16 Bar  
1 1/4" - 2": 10 Bar

Code	Size BSP
2521.15	1/2"
2521.20	3/4"
2521.25	1"
2521.32	1 1/4"
2521.40	1 1/2"
2521.50	2"

## Threaded Plug



16 Bar

Code	Size BSP
2530T.15	1/2"
2530T.20	3/4"
2530T.25	1"
2530T.32	1 1/4"
2530T.40	1 1/2"
2530T.50	2"

## Valves

		Order Number	Size (mm)	
<b>Quick Coupling Valve</b> (10 Bar Rating)		2711	20 (¾")	<ul style="list-style-type: none"> <li>instant on/off water supply valve</li> <li>compatible with GREENLINE, REDLINE™ and ALKATHENE™ pipes</li> <li>ideal for wash down areas and filling spray tanks</li> </ul>
		2712	25 (1")	
<b>Valve</b> (10 Bar Rating)		2731	20 (¾")	<ul style="list-style-type: none"> <li>economical BSP female threaded valve</li> <li>small size and rugged polypropylene body make it ideal for use around the farm.</li> </ul>
		2732	25 (1")	
<b>Riser Key</b> (10 Bar Rating)		2713 (Used with 2712)		<ul style="list-style-type: none"> <li>bayonet type fitting used on end of hose to turn on PLASSON quick coupling valves</li> </ul>
<b>Compression Stopcock</b> (16 Bar Rating)		2741.20	20	<ul style="list-style-type: none"> <li>direct connection to GREENLINE, REDLINE™, RURAL BLACK and 20mm and 25mm ALKATHENE™ pipe</li> <li>no more leaking threaded joints</li> <li>cost effective – do away with threaded adapters, to connect valve to the pipe.</li> </ul>
		2741.25	25	
		2741.32	32	
<b>Angle Seat Valve</b> (8 Bar Rating)		2735.32	32 (1¼")	<ul style="list-style-type: none"> <li>economical BSP male threaded valve</li> <li>rugged polypropylene construction to take the knocks</li> <li>full-bore flow performance when the valve is open</li> </ul>
		2735.40	40 (1½")	
		2735.50	50 (2")	
<b>Check Valve Insert</b> (16 Bar Rating)		2720.25	25	<ul style="list-style-type: none"> <li>check valve designed to be inserted into 25mm PLASSON fittings</li> <li>compatible with REDLINE™, RURAL BLACK, BLACKLINE PN16 and 20mm ALKATHENE™ pipes</li> <li>used for backflow protection.</li> </ul>
<b>Valve Box</b>		193*	155 x 200 x 200 high	<ul style="list-style-type: none"> <li>house and protect valves and meters</li> <li>tough polyethylene construction</li> <li>snap on lid for easy access</li> <li>colour coded lids for asset identification</li> </ul>
		193LIDGR**	155 x 200	
		193LIDBL***	155 x 200	

**Notes:** \*Valve box only - no lid \*\*Green lid \*\*\* lue lid

## Technical Specifications

### Fittings

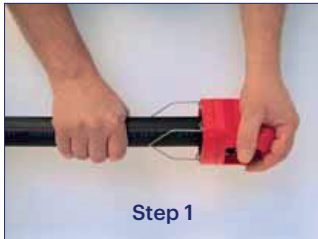
- Body - polypropylene - food grade polymer
- Backing nut - polypropylene - food grade polymer
- Split ring - acetyl
- 'O' ring - nitrile rubber (70 Shore A.NBR)

### Saddles

- Reinforcing ring on BSP threaded outlets - stainless steel
- Nuts - stainless steel
- Bolts - stainless steel
- Threads - B.S.P. standard



## Plasson Line 7 Fittings (20mm - 63mm)- Assembly Instructions



Step 1



Step 1



Step 2



Step 3



Step 4

### General Instructions

Follow these assembly Instructions for a secure, leakproof connection to last a lifetime.

- Ensure the pipe end to be inserted into the fitting, and the fitting itself, are both totally free of dirt, grit, scratches and any other damage
- **Do not overtighten the Backing Nut** when closing. NEVER use wrenches with handle lengths longer than 22cm – excessive torque during tightening can spread the Backing Nut cone and result in pullouts.
- If fittings are reused, ensure the Split Grip Ring is sharp and can bite into the pipe to avoid pull outs. Alternatively replace the Split Grip Ring.

**Note:** Use PTFE tape for all threaded connections.

**1.** Cut the pipe square and remove burrs. It is good trade practice to chamfer (with a file or Plasson 2555 chamfering tool) and lubricate the pipe ends. (use Medlube or an approved equivalent). Chamfering and lubrication will ease insertion, particularly for sizes DN 40, DN 50 and DN 63, however these steps are optional.

**2.** Undo the nut up to the last thread. **Do not remove the Backing Nut** from the fitting body.

**3.** Twist the pipe into the fitting through the Backing Nut and through the Split Grip Ring until it meets the first resistance – pushing against the captive O-ring. Then push and twist the pipe **through and past the O-ring** until it stops at the pipe stop inside the fitting – the final stop.

**4.** Firmly hand tighten the Backing Nut. Use a Plasson "C-Ring" wrench for a further half turn past hand tight for final tightening of fittings, for diameters DN40, DN 50 and DN 63. The full hydraulic seal is achieved when the pipe passes through the O-ring. Nut tightening is only to achieve pullout resistance – the hydraulic seal is automatically created when the pipe is pushed past the captive O-ring.

## Technical Specifications

### Fittings

- Body - polypropylene - food grade polymer
- Backing nut - polypropylene - food grade polymer
- Split ring - acetyl
- 'O' ring - nitrile rubber (70 Shore A.NBR)

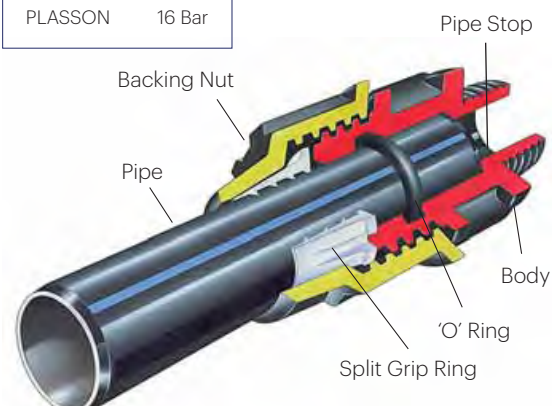
### Saddles

- Reinforcing ring on BSP threaded outlets - stainless steel
- Nuts - stainless steel
- Bolts - stainless steel
- Threads - B.S.P. standard

### 20mm - 63mm

**Maximum operating pressure at 20°C**

PLASSON 16 Bar





## Plasson Line 7 Fittings (75mm - 125mm) - Assembly Instructions



### General Instructions

Cut the pipe, square. Unscrew the Backing Nut and **remove the Split Grip ring**. Reposition Backing Nut, Follower Bush and O ring on the pipe, two diameters back. Lubricate pipe and O ring, with Medlube.



Push the pipe fully into the fitting body, up to the internal stop. Push the O ring and Follower Bush forward until they rest against the fitting (They will not enter the body of the fitting).



Tighten the Backing Nut to drive the Follower Bush and O ring together, right into the fitting until the Follower Bush is flush with fitting mouth. Use a Plasson C ring spanner to assist as needed.



Fully unscrew the Backing Nut, and pull back along the pipe.

Now, open the Split Grip Ring and place directly over and onto the pipe, with the lugs and flat end, **facing and touching** the Follower Bush.



Firmly tighten the Backing Nut with **only** a Plasson "C-ring" spanner. (**Max handle length = 46cm**) **Do not overtighten.**

## Technical Specifications

### Fittings

- Body - polypropylene - food grade polymer
- Backing nut - polypropylene - food grade polymer
- Split ring - acetyl
- 'O' ring - nitrile rubber (70 Shore A.NBR)

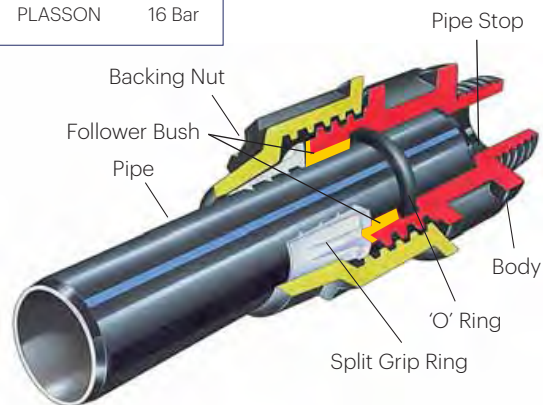
### Saddles

- Reinforcing ring on BSP threaded outlets - stainless steel
- Nuts - stainless steel
- Bolts - stainless steel
- Threads - B.S.P. standard

### 75mm - 125mm

**Maximum operating pressure at 20°C**

PLASSON 16 Bar



# Assembly Instructions

## Modular Adaptor (2579 Series)

1



The modular adaptor may be used with a wide variety of Plasson Series 7 compression fittings. Tee fittings are shown for illustration purposes.

2



Remove nut and split ring and set them aside.

3



Assemble adaptor on fitting body, hand tighten nut then add 1/2 turn with Plasson wrench. The nut need not reach the last thread for an effective seal.

4



Repeat procedure with a second fitting body.

5



The assembly is ready for a third fitting or for nut and split ring.



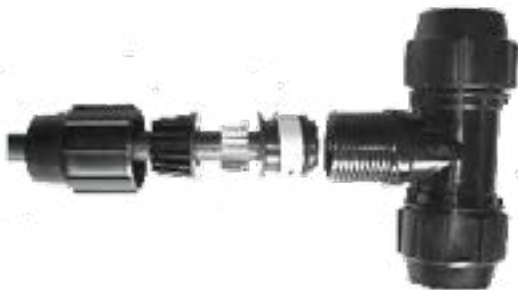
## Assembly Instructions

### Reducing Set - (2524 Series) 63mm to 20mm and combinations



1. Remove nut from fitting and discard white split ring.
2. Slide nut, grey nut reducer(s) and white split ring from set onto the pipe as shown.
3. Make a mark on the pipe to depth of Reducing Bush.
4. Push pipe into bush up to the mark you have made.
5. Push reducing bush and pipe into body of the fitting until the shoulder of the reducing bush reaches the end of the fitting. Some lubricant at this point would be of help.
6. Draw the split ring and grey nut reducer(s) close to the body of the fitting.
7. Hand tighten and a maximum half turn past hand tight with a Plasson wrench. Maximum handle length 22cm.

### Reducing Set - (2524 Series) 110 mm to 63mm and combinations

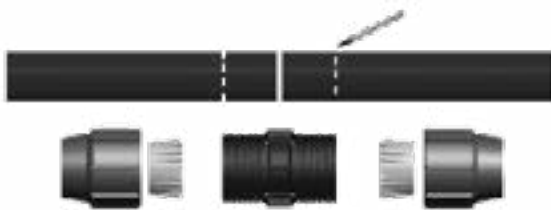


1. Cut pipe square, remove burrs.
2. Remove nut from fitting and discard white split ring.
3. Insert reducing adaptor into fitting body. It will be stopped by the resistance of the internal o-ring.
4. Reposition nut onto fitting body.
5. Tighten nut with a wrench to push the reducing adaptor in through the o-ring until its shoulder abuts fitting bushing.
6. Unscrew nut from fitting.
7. Mount the nut, nut reducer and 63 white split ring (with large end facing the fitting) on the pipe.
8. Twist the pipe into the reducer through the seal to the pipe stop. Lubrication and chamfering of the pipe end will ease insertion of the pipe. Use a silicone lubricant.
9. Slide split ring to abut the reducer.
10. Hand tighten nut firmly and a further 1/2 turn with a Plasson wrench or a wrench with maximum handle length of 22cm.

## Assembly Instructions

### Slip Repair Coupling (2511 Series)

1



Mark insertion depth on pipe ends.  
Lubricate o-rings with inert lubricant.

2



Lift pipe end and slip nut, split ring and body fully onto pipe as shown.  
Lift other pipe end and slip remaining nut and split ring onto it.

3



Realign pipe ends, then twist and push coupler body into place, ensuring that the insertion depth lines meet fittings body.  
Position split rings adjacent to body.

4



Assemble nuts on fitting body, hand tighten firmly then add 1/2 turn with Plasson wrench or wrench handle with length not exceeding 22cm.



## Assembly Instructions

### Universal Slip Repair Coupling (3511 Series)

1



Mark pipe insertion depth

2



Insert the pipe

3



Tighten the nut

### Universal Coupling (2512 series)



1. Remove any unsound material adhering to the pipe.
2. Select correct fitting using the Plasson gauge to measure the pipe.
3. Cut and de-burr pipe as necessary.
4. Slide the Plasson Universal Adaptor fitting end onto the pipe until the first resistance point.
5. Tighten the nut against the body. Final tightening to be done with a Plasson wrench or similar.
6. Assemble the metric PE joint following the standard fitting instructions.

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