

JCM INDUSTRIES

P. O. Box 1220, Nash, TX 75569-1220

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Typical Specification

JCM 432 All Stainless Steel Tapping Sleeve

Tapping sleeve shall be fabricated from 304 Stainless Steel or its equivalent, CF8 Cast Stainless Steel. They shall have a pass through bolt design and provide 360° seal around the pipe. Sleeve shall be fully passivated to return the stainless steel to its highest corrosion resistance. To provide the proper strength, support and safety factor for the valve, drilling machine operation and load forces, the body construction shall be a minimum of:

Outlet Half (load bearing half):

Sleeve Sizes 0450 through 1392, Outlet sizes 2" - 8"	12 gauge Stainless Steel
Sleeve Sizes 1075 through 1392, Outlet sizes 10" and 12"	10 gauge Stainless Steel
Sleeve Sizes 1420 and larger, all outlets	10 gauge Stainless Steel

Back Half (conforming half):

14 gauge Stainless Steel

Length:	Outlet Size	Length
	2" - 6"	15"
	8"	21"
	10"	27"
	12"	30"

For proper strength, support and rigidity for the valve, drilling machine operation and load forces, the neck outlet construction shall be a minimum of Schedule 10 Stainless Steel pipe sized to accept full size cutter. Flange outlet shall be CF8 Cast Stainless Steel or equivalent 304 Stainless Steel. Flange outlets shall be indexed per MSS-SP60 to accept tapping valve.

The lugs shall have a pass-through bolt design, to avoid alignment problems and allow tightening from either side of the pipe. Bolts shall not be integrally welded to the sleeve. Bolting lug shall be triangular design with a maximum of 3" bolt center spacing. Bolting hardware shall be a minimum of 304 Stainless Steel. The bolts shall be track head type and furnished with permanently lubricated heavy-hex nuts and stainless washers.

The full circumferential gasket shall be molded of synthetic rubber compounded for use with water salt solutions, mild acids, bases and sewage. The gasket shall have a gridded surface, be a full 1/4" thick with 304 stainless steel bridge plates molded flush into the gasket and have a raised hydromechanical outlet seal to seal against line surges and water hammer.

Sleeve pressure rating with standard CF8 cast stainless steel flange:

Sleeves 4" – 24" nominal pipe sizes: 175 PSI working pressure, hydrostatic test pressure of 218 PSI (pressures per ANSI/AWWA C207 Standard).

Sleeve pressure rating with optional ANSI stainless steel flange:

Sleeves 4" – 12" nominal pipe sizes: 250 PSI working pressure, hydrostatic test pressure of 300 PSI.
Sleeves 14" – 24" nominal pipe sizes: 200 PSI working pressure, hydrostatic test pressure of 250 PSI

Sleeves shall be rated at 150 PSI working pressure with a hydrostatic test pressure of 200 PSI on pipe with a full circumferential break.

Tapping Sleeves shall be JCM 432 or approved equal.

JCM 400 Series Tapping Sleeves are ANSI/NSF Standard 61 and ANSI/NSF Standard 61 Annex G. Certified.

JCM Industries Tapping Sleeves meet or exceed the ANSI/AWWA C-223 and the MSS-SP 124 Standards as applicable.



This typical specification, provided by JCM Industries, is a proposed guideline for use by specifying agencies to ensure significant design and material features of this product are included within the agencies' individual specifications.



Effective 02.09.11

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Material Specification

JCM 432 All Stainless Steel Tapping Sleeve

Body: Stainless Steel, 18-8 Type 304

Flange: CF8 Cast Stainless Steel - equivalent to 18-8 Type 304 Stainless Steel. ANSI 150lb. Drilling, recessed for tapping valve per MSS-SP 60.

Bolts: Stainless Steel, 18-8 Type 304

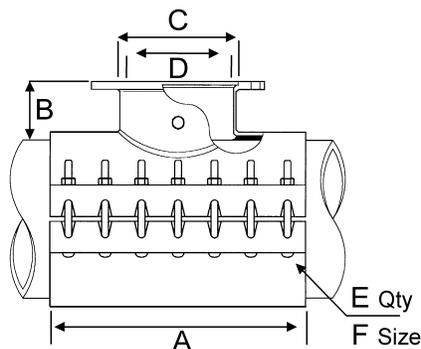
Branch Outlet: Schedule 10 Stainless Steel Pipe

Gasket: Full circumferential Virgin Styrene-Butadiene Rubber (SBR) - Compounded for use with water, salt solutions, mild acids and bases. Per ASTM D-2000 M4AA 607. Standard temperature range from -40° to 150°F (-40° to 65°C) constant, maximum intermittent 180° F (82°C). For applications on high temperatures or chemical pipelines, contact JCM Industries Technical Services.

JCM 432 All Stainless Steel Tapping Sleeve Dimensions

Flange Size	A	B	C	D	E	F
4	15	5	5-1/32	4.26	10	5/8
6	15	5	7-1/32	6.35	10	5/8
8	21	5-1/8	9-1/32	8.32	14	5/8
10	27	5-1/2	11-1/16	10.42	18	5/8
12	30	5-3/4	13-1/16	12.39	20	5/8

Dimensions represented in inches



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Effective 12.10.10