

# JCM INDUSTRIES

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

Phone 800-527-8482 or 903-832-2581

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[www.jcmindustries.com](http://www.jcmindustries.com)

## Typical Specification

### JCM 419 Fabricated Tapping Sleeve with Mechanical Joint Outlet

Tapping Sleeves shall be the high strength type having a wide body, made of a minimum material strength of Carbon Steel per ASTM A36, A516 GR 70 or equal, which conforms to and reinforces the pipe. The sleeve shall have as a minimum 7/8" wide gasket of Nitrile Butadiene Rubber (NBR, Buna-N) per ASTM D2000 with hydromechanical activated lip, captured in a recessed groove around the outlet; test outlet and oval neck track head bolts and nuts.

Mechanical Joint Outlet shall meet the ANSI 21.11/AWWA C111 Standards for Mechanical Joint Dimensions. Outlet shall be furnished with load bearing alignment set pins to prevent movement of the tapping assembly before or during the tapping process.

For outlet sizes 14" and larger, the gasket groove must be consistently positioned about throat of tapping waterway. Inside diameter of the gasket groove must be set back a minimum of 1" from the waterway to allow dispersal of forces generated by gasket compression. Gasket grooves machined in a circle and formed to an elliptical shape will not be an accepted equal.

Tapping Sleeves shall be JCM 419 or approved equal.

JCM 400 Series Tapping Sleeves are ANSI/NSF Standard 61, Annex G and ANSI/NSF 372 Certified. JCM 400 Series Tapping Sleeves meet MSS-SP124 and ANSI/AWWA Standard C223 Fabricated Steel and Stainless Steel Tapping Sleeves as applicable.



JCM 419 Tapping Sleeve  
Image reflects 6" x 4"

*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.*

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## Material Specification

### JCM 419 Fabricated Mechanical Joint Outlet Tapping Sleeve

**Body:** Carbon Steel per ASTM A36, A516 GR 70 or equal.

**Outlet:** Carbon Steel meets ANSI 21.11/AWWA C111 Standard Dimensions  
Outlets 3" & 4" = 1/4" test outlet, outlets 6" and larger = 3/4" test outlet

**Bolts:** Sleeve sizes 7.45 and smaller = 5/8", sleeve sizes 9.05 and larger = 3/4".

**Gasket:** Nitrile Butadiene Rubber (NBR, Buna-N) per ASTM D2000. Molded virgin rubber with a pressure activated hydromechanical design. Gasket is bonded into a cavity for internal and external retention. Gasket temperature range -40°F to 212°F (-40°C - 100°C) Gasket suitable for water, salt solutions, mild acids, bases, and sewage. Optional gasket materials available. Contact JCM Industries, Inc.

#### Service

**Rating:** 4" – 12"\* pipe sizes: 250 PSI working pressure, hydrostatic test pressure of 300 PSI  
\*12 x 12 w/Stainless Bolts: 200 PSI working pressure, hydrostatic test pressure of 250 PSI  
14" – 24" pipe sizes: 200 PSI working pressure, hydrostatic test pressure of 250 PSI

### Select Finish and Hardware Options:

#### Finishes

- Heavy coat of corrosion resistant shop coat primer.
- Fusion applied epoxy coating, minimum 12 mils thickness per ANSI/AWWA Standard C213 Fusion Bonded Epoxy Coatings and Linings for Steel Water Pipe and Fittings.

#### Bolts

- Electro Coated Powercron 590-534, high strength low alloy oval neck track head bolt per ASTM A242 and nuts (per ASTM A563) or equal.
- Stainless Steel Type 304
- Stainless Steel Type 316

JCM 400 Series Tapping Sleeves meet MSS-SP124 and ANSI/AWWA Standard C223 Fabricated Steel and Stainless Steel Tapping Sleeves as applicable.

