

# JCM INDUSTRIES

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

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

## Typical Specification

### JCM 219 Restrained Ductile Iron Couplings

Couplings for pipe sizes 3" - 12" shall be of ductile iron construction. Couplings shall be of the wide range type to fit Steel, Cast Iron and Ductile Iron. Coupling sleeves shall be 6" in length on nominal sizes 3" - 12". Coupling end rings will be machined to accept the appropriate number of furnished torque head set screws. Set screws will embed in the pipe without penetrating the interior. Ductile Iron couplings shall be JCM 219 Restrained Coupling or approved equal.

JCM 200 Series Ductile Couplings are ANSI/NSF Standard 61 and Standard 61 Annex G Certified. JCM 200 Series Couplings meet or exceed the ANSI/AWWA C-219 Standard as applicable.

### JCM 219 Restrained Ductile Iron Coupling

Nominal Pipe Size (IN)	Sleeve Length (IN)	Number of Restraining Set Screws Each End	Number of Bolts
3	6	4	4
4	6	4	4
6	6	8	8
8	6	8	8
10	6	12	12
12	6	12	12

**Note:** JCM RESTRAINED FITTINGS USING TORQUE HEAD SET SCREWS ARE NOT RECOMMENDED FOR ASBESTOS CEMENT, PVC, HDPE, FIBERGLASS OR ANY OTHER TYPES OF NON-RIGID OR BRITTLE PIPE MATERIALS. INSPECTION OF PIPE INTEGRITY IS THE RESPONSIBILITY OF THE END USER.



*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 219 Restrained Ductile Iron Couplings

**Sleeve & Flanges:** Ductile Iron Per ASTM A536 65-45-12

**Gaskets:** Styrene-Butadiene Rubber (SBR) has good physical properties. Compounded for use with water, salt solutions, mild acids and bases; has excellent abrasion resistance. Per ASTM D-2000. 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. The material is not recommended for use on oil, ozone or weather resistant applications.

**Bolts:** 5/8" Corrosion resistant, high strength low alloy oval neck track head bolts per ASTM A242/ANSI 21.11/AWWA C111 and heavy hex nuts per A563 or equal.  
Optional Hardware: Stainless Steel 18-8 Type 304 or 316  
Epoxy Coated Alloy Hardware, Powercron 590-534 black cationic electrocoat.

**Restraining Set Screws:** Torque Head Set Screws – note JCM RESTRAINED FITTINGS USING TORQUE HEAD SET SCREWS ARE NOT RECOMMENDED FOR ASBESTOS CEMENT, PVC, HDPE, FIBERGLASS OR ANY OTHER TYPES OF NON-RIGID OR BRITTLE PIPE MATERIALS. INSPECTION OF PIPE INTEGRITY IS THE RESPONSIBILITY OF THE END USER.

Use a 12 point 7/16" socket wrench to evenly tighten all restraining set screws until they are in contact with the pipe. Alternately tighten in a star rotation pattern to approximately 50 foot pounds of torque. To complete installation, tighten all set screws in a star pattern until the special break away head shears off. This indicates that the pre-set optimum torque value of the set screw (80-90ft/lbs) has been reached. The 5/8" square head remaining on the set screw is for the convenience of removing the set screw should removal of the fitting be necessary.

**Coating:** Corrosion resistant shop coat paint primer. Optional fusion applied epoxy coating per ANSI/AWWA C-213. Other coatings available upon request.

**Working Pressure:** Fittings are rated for 150 PSI working pressure when installed per manufacturer's instructions. Inspection of pipe integrity is the responsibility of the end user. For higher working pressure applications, contact JCM Industries.

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