

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

Typical Specification

JCM 422 Fabricated Tapping Sleeve for PVC and Steel Pipe

Tapping sleeves for 4" through 12" PVC and steel pipe shall be the high strength type having a wide body, made of a minimum material strength of ASTM 285 Grade C Steel, which conforms to and reinforces the pipe. The sleeve shall be sized to fit the exact dimension of the pipe and have 5/8" bolts on 3" centers. The sleeve shall have a Nitrile Butadiene Rubber (NBR, Buna-N) per ASTM D2000 gasket with hydromechanical activated lip, captured in a recessed groove around the outlet. Flanged outlets shall be AWWA C207 Class D, ANSI 150 lb. Drilling, recessed for tapping valve per MSS-SP60. The sleeve shall be fusion epoxy coated to a minimum 12 mils thickness, per ANSI/AWWA C-213 and furnished with a type 304 stainless steel plug in the test outlet. Tapping Sleeves shall be JCM 422 or approved equal.

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

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



JCM 422 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 422 Fabricated Tapping Sleeve for PVC and Steel Pipe

Body: ASTM 285 Grade C, ASTM A-36 Steel or equal.

Bolts: 5/8" Corrosion resistant, high strength low alloy oval neck track head bolt per ASTM A242/ANSI 21.11/AWWA C-111 and heavy hex nut per A563 epoxy coated, Powercron 590-534.
Optional: Stainless Steel 18-8 304 or 316 available.

Flange: AWWA C207 Class D, ANSI 150 lb. Drilling, recessed for tapping valve MSS-SP60.

Gasket: Nitrile Butadiene Rubber (NBR, Buna-N) per ASTM D2000. Molded virgin rubber with a pressure activated hydro mechanical 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.

Finish: Fusion applied epoxy coating, minimum 12 mils thickness per ANSI/AWWA C-213.

Service Rating: 4" to 12" Outlets: 175 PSI. Higher service rating available for specific applications and sizes.

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JCM 422 Tapping Sleeve Dimensions

Flange Size	A	B	C	D	E	F
3	9*	5	4-1/32	3-1/2	6	5/8
4	9*	5	5-1/32	4	6	5/8
6	12	5	7-1/32	6-1/8	8	5/8
8	15	5-1/8	9-1/32	8-1/8	10	5/8
10	21	5-1/2	11-1/16	10-1/4	14	5/8
12	24	5-3/4	13-1/16	12-1/4	16	5/8

422 Tapping Sleeves require that a standard 1/2" undersized cutter be used.

*Nominal Pipe Sizes 3", 10" & 12" – dimension A is 12"

