Typical Specification

JCM 101 Universal Clamp Couplings (sizes 1-1/2 – 8”)

All full circumferential single band repair clamps 1-1/2” and larger shall have a minimum material standard of certifiable prime 304 Stainless Steel band; heavy duty, low profile Ductile Iron Lugs per ASTM A536 with mutually supporting sliding fingers; 5/8” corrosion resistant alloy bolts, per ASTM A242/ANSI 21.11/AWWA C-111, and a Styrene-Butadiene Rubber (SBR) gridded gasket with tapered lap joint ends and a 304 stainless steel bridge plate molded flush into the gasket. Gaskets in sizes 3” and larger shall be 1/4” thick. To provide extra tightening capability, the band shall be permanently attached to the lugs by crimping the lug and locking it in place with a minimum of three stainless welds per lug. Clamp shall be similar to JCM 101 Universal Clamp Coupling or approved equal. Optional features available; see material specification.


JCM 100 Series Universal Clamp Couplings meet or exceed ANSI/AWWA C230 Standard for Stainless – Steel Full-Encirclement Repair and Service Connection Clamps 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.
Material Specification

JCM Universal Clamp Couplings – Models 101, 102, 171, 172

**Band:** 18-8 Type 304 Certifiable Prime Stainless Steel

**Lugs:** Ductile Iron ASTM A-536, 60-40-18

**Bolts:** Corrosion resistant low alloy per ASTM A242, ANSI A21.11, AWWA C-111. National coarse rolled thread and heavy hex nut. Optional Stainless Steel 18-8 Type 304 or 316 available. Optional Epoxy Coated low alloy bolts/nuts available.

**Gasket:** 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 -40º to 150ºF (-40º to 65º C) constant, maximum intermittent 180º F (82 º C). For applications on high temperatures or chemical pipelines, contact JCM Industries Technical Services.

**Coating:** Corrosion resistant shop coat paint primer.

**Pressure Rating:** Pressure holding capabilities vary according to application. For specific pressure ratings, contact JCM Industries Technical Services.


JCM 100 Series Universal Clamp Couplings meet or exceed ANSI/AWWA C230 Standard for Stainless – Steel Full-Encirclement Repair and Service Connection Clamps as applicable.
### JCM 101 Universal Clamp Coupling Design Specifications

<table>
<thead>
<tr>
<th>Clamp Width (Inches)</th>
<th>Number of Bolts</th>
</tr>
</thead>
<tbody>
<tr>
<td>6</td>
<td>2</td>
</tr>
<tr>
<td>7</td>
<td>2</td>
</tr>
<tr>
<td>12</td>
<td>4</td>
</tr>
<tr>
<td>15</td>
<td>4</td>
</tr>
<tr>
<td>18</td>
<td>6</td>
</tr>
<tr>
<td>24</td>
<td>8</td>
</tr>
<tr>
<td>30</td>
<td>10</td>
</tr>
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</table>

<table>
<thead>
<tr>
<th>Clamp Size (Inches)</th>
<th>Stainless Band Gauge</th>
</tr>
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<tbody>
<tr>
<td>1-1/2 – 4.50</td>
<td>24</td>
</tr>
<tr>
<td>4.80 – 9.40</td>
<td>20</td>
</tr>
<tr>
<td>10 – 12</td>
<td>17 minimum</td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>Clamp Size (Inches)</th>
<th>Gasket Thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-1/2 – 2</td>
<td>3/16”</td>
</tr>
<tr>
<td>3 and larger</td>
<td>1/4”</td>
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</table>

<table>
<thead>
<tr>
<th>Clamp Size (Inches)</th>
<th>Bolt Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-1/2 – 8</td>
<td>5/8”</td>
</tr>
<tr>
<td>10 – 12</td>
<td>3/4”</td>
</tr>
</tbody>
</table>

Certifiable 304 Stainless Steel Band
High Strength, Low Alloy Bolts/Nuts per ASTM A56

Ductile Iron Lugs per ASTM 242/ANSI 21.11/AWWA C-111

Virgin SBR Diamond Grid Gasket with recessed, molded in Bridge Plate

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JCM 101 Universal Clamp Coupling
Image reflects 18” width

Effective 01.30.19