JCM INDUSTRIES
P. O. Box 1220, Nash, TX 75569-1220
Phone 800-527-8482 or 903-832-2581
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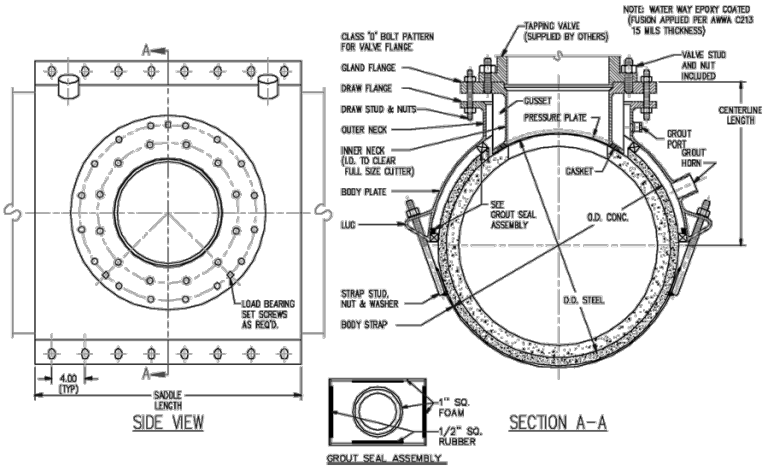
Typical Specification

JCM 415 Concrete Steel Cylinder Pipe Tapping Sleeve

Tapping Sleeves for Concrete Steel Cylinder Pipe shall be in accordance with AWWA Manual M-9. They shall also meet ANSI/AWWA Standards C301 and ANSI/AWWA C303 pertaining to design, manufacturing quality tests and welders qualifications. Manufacturers shall have manufactured this type of tapping sleeve for a minimum of ten (10) years.

The sleeves shall have a separate gland which permits installation of the sleeve prior to the cutting of the prestress wires. The gland shall have a fusion epoxy coated (per ANSI/AWWA Standard C213) waterway, and a minimum 7/8" wide hydromechanical gasket set in a retaining machined groove of a pressure plate. 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 1/2" 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. The pressure plate shall be gusseted to the draw flange to eliminate flexing. The gland shall be equipped with load bearing set screws to protect the cylinder. Sleeves shall be furnished with grouting seals and grout horns to facilitate filling the space between the sleeve and the pipe. Tapping Sleeves shall be JCM 415 Tapping Sleeve or approved equal.

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



Certified to NSF/ANSI/CAN 61 & NSF/ANSI 372

Effective 11.10.2021

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Material Specifications

JCM 415 Concrete Steel Cylinder Pipe Tapping Sleeve

Body: ASTM A36 or A516 GR 70 Steel or equal.

Flange: Combination flange with ANSI 150 lb. Drilling, recessed for tapping valve MSS-SP60 (Outlets 4" – 12")

Outlets 14" and larger, AWWA Class D flange with ANSI 150lb drilling, A36 or equal. Other outlets available.

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.

Bolts: High strength low alloy per ASTM A242 and nuts (per ASTM A563) or equal

Finish: Heavy coat of corrosion resistant primer on sleeve, gland and straps. Waterway of gland is epoxy coated (fusion applied per ANSI/AWWA Standard C213). Optional fusion epoxy coating on entire sleeve.

JCM Industries recommends a template of the outside diameter of the pipe surface on all taps with an outlet of 24" or larger, on all taps where the outlet is more than 60% of the pipe size, on pipe which out-of-roundness is suspected and on high-pressure taps where the fit of the sleeve is critical to the high pressure performance. Instructions for this procedure are available from JCM upon request.

NSF Certified to NSF/ANSI/CAN 61 & NSF/ANSI 372