

# JCM INDUSTRIES

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## Typical Specification

### JCM 469 Stainless Steel Tapping Sleeve with Carbon Steel Mechanical Joint Outlet

Tapping sleeve shall be fabricated from 304 Stainless Steel or its equivalent with a pass through bolt design and provide 360° seal around the pipe. Sleeve shall be fully passivated to return the stainless steel to its highest corrosion resistance. To provide the proper strength, support and safety factor for the valve, drilling machine operation and load forces, the body construction shall be a minimum of:

Outlet Half (load bearing half):

Sleeve Sizes 0450 through 1392, Outlet sizes 2" - 8"	12 gauge Stainless Steel
Sleeve Sizes 1075 through 1392, Outlet sizes 10" and 12"	10 gauge Stainless Steel
Sleeve Sizes 1420 and larger, all outlets	10 gauge Stainless Steel

Back Half (conforming half):

14 gauge Stainless Steel

Length:	Outlet Size	Length
	2" - 6"	15"
	8"	21"
	10"	27"
	12"	30"

For proper strength, support and rigidity for the valve, drilling machine operation and load forces, the neck outlet material shall be a minimum of Schedule 10 Stainless Steel pipe sized to accept full size cutter with carbon steel mechanical joint outlet. Shall meet the ANSI 21.11/AWWA C111 Standard 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.

Lugs shall have a pass-through bolt design, to avoid alignment problems and allow tightening from either side of the pipe. Bolts shall not be integrally welded to the sleeve. Bolting lug shall be triangular design with a maximum of 3" bolt center spacing. Bolting hardware shall be a minimum of 304 Stainless Steel. The bolts shall be track head type and furnished with permanently lubricated heavy-hex nuts and stainless washers.

The full circumferential gasket shall be molded of synthetic rubber compounded for use with water salt solutions, mild acids, bases and sewage. The gasket shall have a gridded surface, be a full 1/4" thick with 304 stainless steel bridge plates molded flush into the gasket and have a raised hydromechanical outlet seal to seal against line surges and water hammer.

#### Sleeve pressure rating with mechanical joint outlets:

Sleeves 4" – 12" nominal pipe sizes: 250 PSI working pressure, hydrostatic test pressure of 300 PSI.

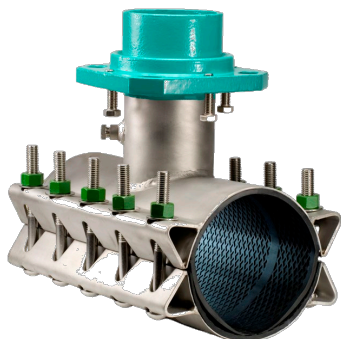
Sleeves 14" – 24" nominal pipe sizes: 200 PSI working pressure, hydrostatic test pressure of 250 PSI

Sleeves shall be rated at 150 PSI working pressure with a hydrostatic test pressure of 200 PSI on pipe with a full circumferential break.

Tapping Sleeves shall be JCM 469 or approved equal.

JCM 400 Series Tapping Sleeves are ANSI/NSF Standard 61, Annex G & ANSI/NSF 372 Certified.

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



*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

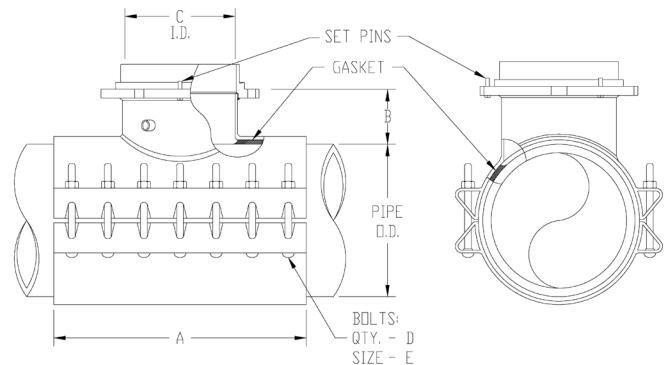
### JCM 469 Stainless Steel Tapping Sleeve with Carbon Steel Mechanical Joint Outlet

- Body:** Stainless Steel, 18-8 Type 304
- Bolts:** Stainless Steel, 18-8 Type 304
- Branch Outlet:** Schedule 10 Stainless Steel Pipe
- Gasket:** Full circumferential 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 -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.
- MJ Outlet:** Carbon Steel meets ANSI 21.11/AWWA C111 Standard for Mechanical Joint Dimensions. Carbon steel outlet coated for corrosion resistance.
- Option:** JCM 439 All Stainless Steel Tapping Sleeve with MJ Outlet

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

### JCM 469 TAPPING SLEEVE DIMENSIONS

OUTLET SIZE	A	B	C	D	E
3	15	5-1/4	3.32	10	5/8
4	15	5-1/4	4.26	10	5/8
6	15	5-1/4	6.36	10	5/8
8	21	5-1/4	8.33	14	5/8
10	27	5-1/4	10.42	18	5/8
12	30	5-1/4	12.39	20	5/8



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