



**Recommended Field Welding Guidelines for Restraint Assembly
Fittings on Carbon Steel Pipelines**

Model 617 Weld On Restrainer Assembly

Read instructions before starting installation*

Review of "Considerations for Installation" on the reverse will assist with installation.

For purposes other than water, contact JCM Industries for application and product assistance.

Prior to welding, clean and scrape pipe. Remove any scale, pipe wrap, debris or dirt that may interfere with the welding of the fitting. Inspect pipe for type and integrity, size, outside diameter and surface irregularities. Ultrasound may be performed if pipe wall thickness is in question. Confirm the proper size of restraint assembly. Inspect fitting to ensure all parts are included.

Single Unit Installation:

(Restraint from JCM 617 to a third party restraint system).

Position one half of body on pipe, making sure anchor loops are in alignment with any opposite, fixed position anchoring restraint system. Make certain the hollow side of the restrainer ears face toward the joint. The gap between sleeve halves should be no more than 1/8" between halves.

1. Field weld the longitudinal sides of the unit first.
2. Weld first circumference end only
3. Allow the first circumference end to cool
4. After cooling time, weld the other end
5. After installation and cool down, visually inspect welds for completeness. Re-weld any areas as indicated by inspection

Note: Welding both ends of the fitting at the same time can cause a stress riser in the pipeline.

Double Unit Installation:

(Restraint from a JCM 617 to JCM 617)

When restraining opposite a JCM 617 Weld On Restraint Assembly, follow the steps above on the opposite side of the pipe - ensuring the anchor loops are in alignment. Follow steps on through 5.

Upon completion of welding, installation restrainer rods. from Unit One to Unit Two. Place a washer and nut on end(s) of each bolt or rod and hand tighten. Then tighten each nut one full turn. Install second nut on restrainer rods to lock into place.

See reverse for diagram.

INT617-011315

*Ensure fitting is suitable for application (confirm size, materials, pressure ratings, line content, meets local governing & association standards, etc.). Pipeline operation forces, including pressure fluctuations, thermal expansion/contraction, movement/shifting, etc. will influence the success of the application. Proper anchorage, restraint, harnessing, thrust blocks or other devices must be provided to prevent pipe movement (lateral, angular, axial) or pipe pullout from the bolt-on fitting. Inspection of the pipe integrity is the responsibility of the end user. JCM recommends the use of calibrated torque wrench. Failure to follow installation instructions will result in voided product warranty.

For application review or questions contact JCM Industries at 1-800-527-8482, 903-832-2581



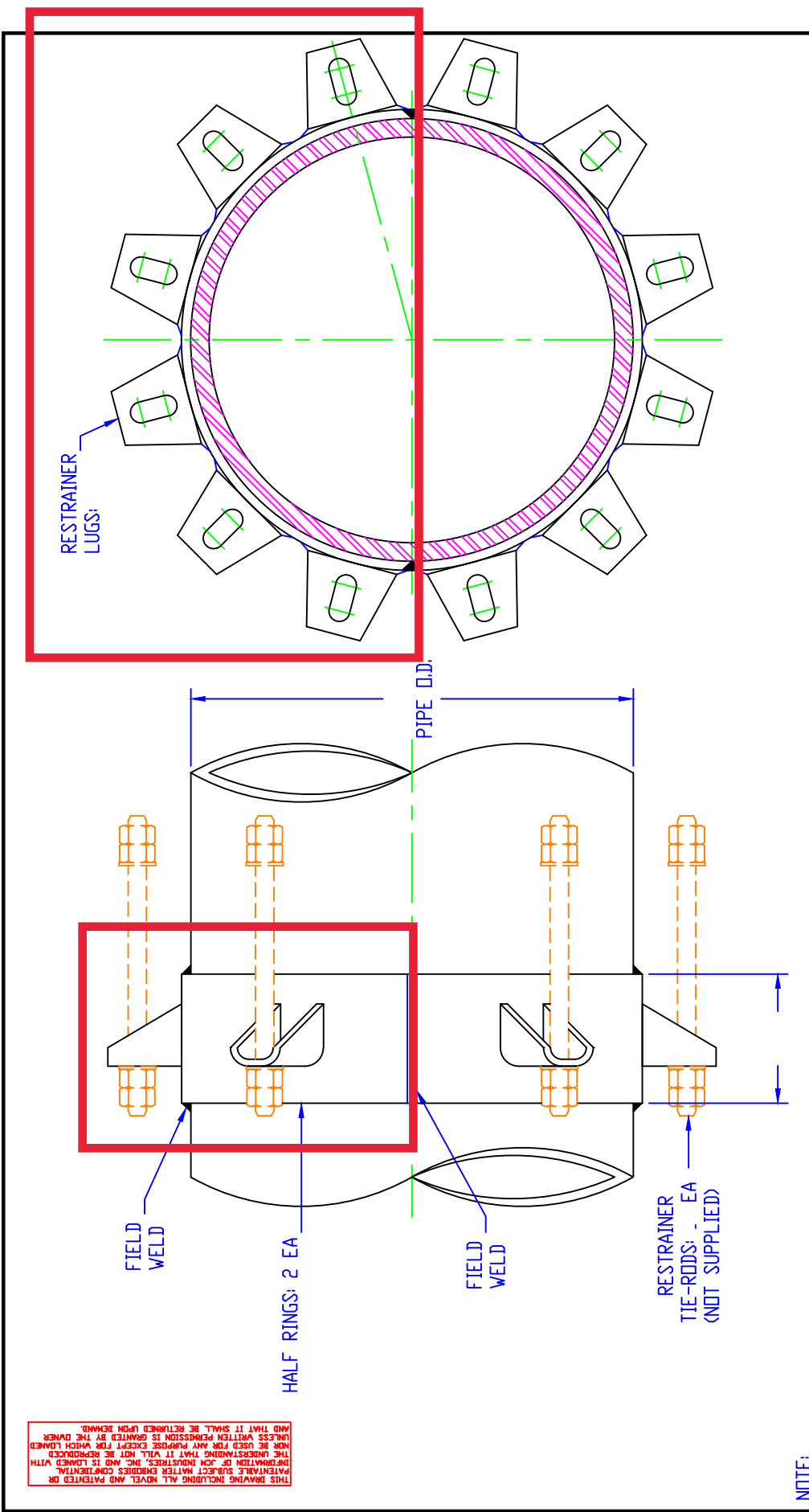
JCM 617 Weld On Restrainer Assembly

Can be furnished with or without restrainer tie rods

Number of tie rods will vary with number of anchor loops (i.e. batwings).

When entering an order with tie rods - the following identifier should be LR (long rods)

The 617 are (2)1/2 rings customer welds the two rings onto steel pipe in the field. It takes (2) 1/2 rings to make up (1) restrainer - (4) 1/2 rings to make up (2) restrainers.



NOTE:

1. ALL WELDS PER AWWA STDS.
2. WORKING PRESSURE: 150 PSI
3. FINISH: SHOP COAT
4. FASTENERS: NONE

JCM INDUSTRIES, INC. NASH, TX.				617-			
P.O. BOX 1220 NASH, TX 75569 www.jcmindustries.com				WELD-ON RESTRAINER ASSY			
DATE		BY		CHECKED BY		DWG. NO.	
REV/ISSUES		APVD.		PIR		GEN-01491	
				DATE		PART NO.	
				3/30/17		SUBMITTAL	
				NO. SHEETS		SCALE	
				1 of 1		---	
				FRACTIONS (DECIMALS)		---	
				1/8" .063		---	
				ANGLES		---	
				2"		---	
				UNLESS OTHERWISE SPECIFIED		---	
				TOLERANCES TO BE		---	
				PIR		---	
				REV.		---	