

CLAMPS WITH STANDARD STRAIGHT GASKET

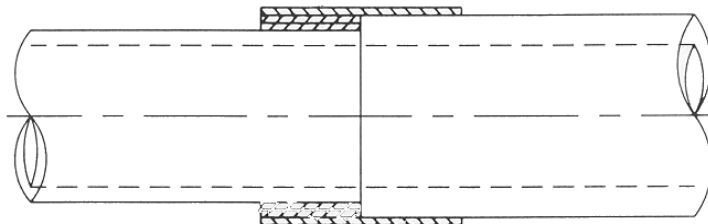
Pipe with a wall thickness of $5/32$ " or less are best repaired with a **JCM Universal Clamp Coupling** with a standard straight extra thick gasket. To install:

- Clean pipe and place reference mark on pipe, back from joint to help center clamp over joint.
- Place clamp on pipe and center over joint, using the reference marks.
- Tuck tapered gasket in place, mesh finger lugs and rotate clamp in direction of arrow, shown on clamp label, to smooth gasket flap.
- Engage bolts and tighten finger tight to hold in place. Tighten bolts evenly until band conforms to joint and forms a tight seal. (Approximately 30 - 40 Ft/Lbs of torque.)

CLAMPS WITH STEP GASKET

Pipe and coupling joints with a wall thickness greater than $5/32$ " and less than $5/16$ " are best repaired with a **JCM Collar Leak Clamp** utilizing an extra thickness of gasket on one end. To install:

- Clean pipe and place clamp on joint with the extra thick portion of the gasket on the smaller diameter portion of the joint.
- Carefully tuck tapered gasket in place, mesh finger lugs and rotate clamp in direction of area, shown on clamp label, to smoother gasket flap.
- Before tightening - PUSH CLAMP COMPLETELY UP AGAINST JOINT STEP to assure proper positioning.
- Engage bolts and tighten finger tight to hold in place. Tighten bolts evenly until clamp is tight or leak is stopped. (Approximately 40 - 50 Ft/Lbs of torque.)



Note: Universal Clamp Couplings do not provide restraint of pipe ends. For applications in which pipe may pull out of clamp, external restraint must be provided.

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Recommendations For Installation Of Fittings With Stainless Steel Bolts And Nuts

This JCM Quality Fitting is equipped with 18-8 stainless steel bolts and nuts for superior corrosion resistance. It is the nature of stainless steel fasteners to gall and freeze if not properly handled. This undesirable characteristic is due to the inherent properties of the stainless material. The galling and freezing action is often triggered by the presence of metal chips, burrs and grains of sand on the threads of the bolts and nuts.

Extra care has been taken by JCM prior to assembly and packing of this fitting to assure a trouble-free installation.

1. The nuts and bolts are made from material of different hardness so that they have different strengths.
2. The nuts are coated with a special (antiseize) coating.
3. Each nut is assembled by hand to be sure that it went on the bolt freely.
4. The bolts and nuts are handled carefully to avoid damage to the threads.
5. The bolts and nuts are made to exacting specifications to assure that the correct material is used and that the thread form is correct.

However, it must be pointed out that during field installation, the threads **MUST BE KEPT CLEAN AND FREE FROM NICKS.**

When a mild steel or bronze bolt is used, the low ultimate strength of the material allows the nut to tear itself free. Not so with 18-8 Stainless Steel. The ultimate strength of the material is so great, that it increases rapidly with cold work. However, once foreign matter such as a grain of sand wedges the threads, or the thread form is altered by over-torquing, the nuts cannot be removed.

The specially coated nuts supplied by JCM help to eliminate the galling caused by overtorquing, but **the bolts must be kept clean and not pitched or thrown into the tool bucket during installation. Should additional lubrication be required, a Molybdenum-Base lubricant is recommended.**

NOTE: Installation of this fitting with a pneumatic wrench may cause seizure of the nut. **A JCM 901 Master Wrench or JCM 905 Torque Wrench with Deep Socket is recommended.**

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