



## JCM 414 Mechanical Joint Tapping Sleeve

### INSTALLATION INSTRUCTIONS

This split tapping sleeve with mechanical joint ends is designed for a quick, simple installation with a minimum of equipment. To assure a proper installation, please follow these steps:

1. Check sleeve, bolts and gaskets to make sure all parts are included and undamaged.  
**NOTE:** If end gasket and bolts are damaged, standard mechanical joint gaskets and tee bolts (3/4 x 4-1/2) may be used.
2. Clean pipe in area where sleeve is to be installed. Check pipe dimension to be certain it is correct for the size sleeve.
3. Check to be sure that the round side gaskets are properly seated in side bar grooves.  
**DO NOT CUT SIDE GASKETS.** Install sleeve in proper position on pipe and match color marks on body.  
**NOTE:** 7/8" x 3-1/2" bolts are to be installed on side bars. Longer 7/8" x 4-1/2" bolts are to be installed in rings on ends of the side bars. Tighten bolts evenly to 80 ft. lbs. of torque.
4. Tighten shorter side bar bolts first, starting in the center and working toward the ends. Next, tighten the longer end bolts so that the sleeve halves are butted together evenly and squarely.  
**NOTE:** At this point the round side gasket should protrude slightly into where end gasket will seat.
5. **Block under sleeve to center it on pipe.** Install end gaskets, placing lap 90° (1/4 turn) from side bars.  
**NOTE 1:** Sleeves for Asbestos Cement Pipe are furnished with long end gaskets. To cut them to length, place the gaskets around the pipe and cut one end on the bias so that the gasket fits snugly around the pipe and the bias cut ends match.  
**NOTE 2:** The end gaskets were lubricated before shipment. If necessary to apply additional lubricant use a standard gasket soap lubricant as used in rubber joint pipe installations.
6. Install end flanges so that joints are 45° (1/8 turn) from side bars. End flanges have color match marks indicating the proper end and location of each segment of the end flanges. Install end flanges so color match marks line up.
7. Test sleeve and valve seals prior to making tap. A test plug is provided on the sleeve for this purpose.

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