

# JCM INDUSTRIES

P. O. Box 1220, Nash, TX 75569-1220  
Phone 800-527-8482 or 903-832-2581  
Fax 800-874-9524 or 903-838-6260  
[www.jcmindustries.com](http://www.jcmindustries.com)

## Typical Specification

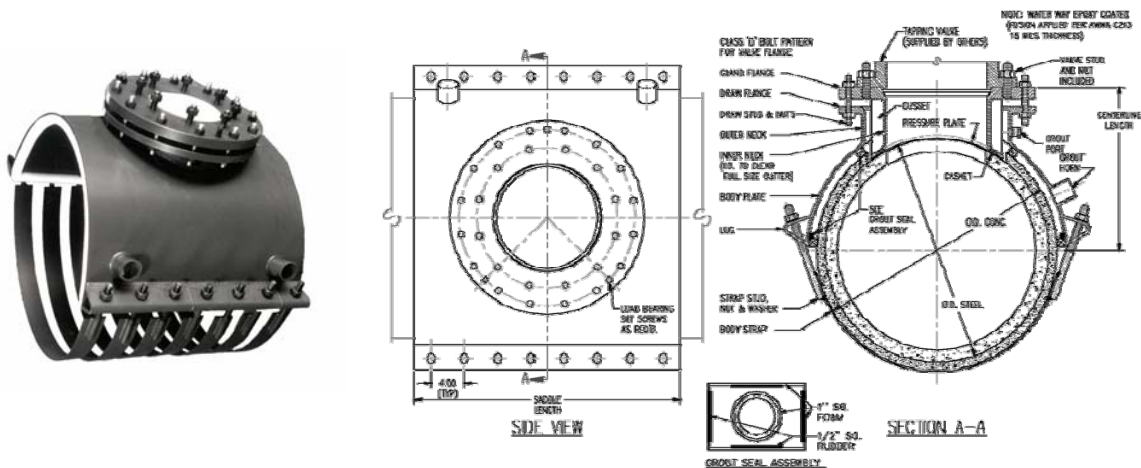
### JCM 415 Concrete Steel Cylinder Pipe Tapping Sleeve

Tapping Sleeves for Concrete Steel Cylinder Pipe shall be in accordance with AWWA Manual M-9. They shall also meet ANSI/AWWA C-301 and ANSI/AWWA C-303 Standards 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 C-213) 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. Tapping sleeves shall be ANSI/NSF Standard 61 Certified.

JCM 400 Series Tapping Sleeves meet MSS-SP124 and ANSI/AWWA Standard C223-02 as applicable.

JCM 400 Series Tapping Sleeves are ANSI/NSF Standard 61 Certified.



Effective 11.30.07

# JCM INDUSTRIES

P. O. Box 1220, Nash, TX 75569-1220

Phone 800-527-8482 or 903-832-2581

Fax 800-874-9524 or 903-838-6260

[www.jcmindustries.com](http://www.jcmindustries.com)

## Material Specifications

### JCM 415 Concrete Steel Cylinder Pipe Tapping Sleeve

Body: ASTM 283 Grade C, ASTM 285 Grade C, ASTM A-36 Steel or equal.

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

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: Corrosion resistant, high strength low alloy (AWWA C-111, ANSI A21.11). Optional stainless steel, 18-8 Type 304.

Finish: Heavy coat of corrosion resistant primer on sleeve, gland and straps. Waterway of gland is epoxy coated (fusion applied per ANSI/AWWA C-213). Optional fusion epoxy coating on entire sleeve.



Effective 11.30.07