

JCM INDUSTRIES

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Typical Specification

JCM 432 All Stainless Steel Tapping Sleeve

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. Flange outlet shall be 304 Stainless Steel or equivalent. Flange outlets shall be recessed per MSS-SP60 to accept tapping valve.

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.

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 standard 304 stainless steel flange:

Sleeves 4" – 24" nominal pipe sizes, outlets 2" – 12": 175 PSI working pressure, hydrostatic test pressure of 262.5 PSI (pressures per ANSI/AWWA Standard C228).

Sleeve pressure rating with optional ANSI stainless steel flange:

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

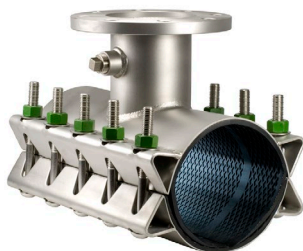
Sleeves 14" – 24" nominal pipe sizes: 200 PSI working pressure, hydrostatic test pressure of 250 PSI

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 432 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, ANSI/AWWA Standard C228 Stainless Steel Pipe Flanges for Water Service as applicable.



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.



Effective 11.11.2021

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Material Specification

JCM 432 All Stainless Steel Tapping Sleeve

Body: Stainless Steel, 18-8 Type 304

Flange: 304 Stainless Steel, per ANSI/AWWA Standard C228, ANSI 150lb. Drilling, recessed for tapping valve per MSS-SP 60.

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.

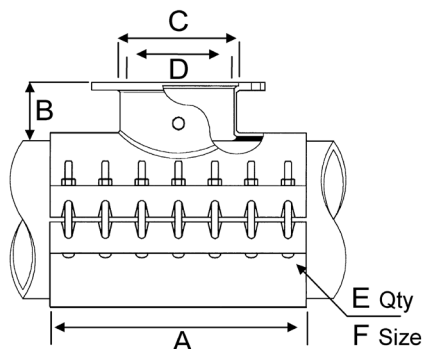
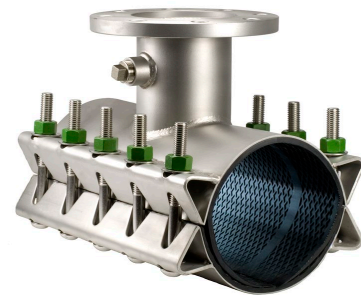
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JCM 432 ALL STAINLESS STEEL TAPPING SLEEVE DIMENSIONS

Flange Size	A	B	C	D	E	F
2	15	4	3-1/32	2.16	10	5/8
3	15	5	4-1/32	3.26	10	5/8
4	15	5	5-1/32	4.26	10	5/8
6	15	5	7-1/32	6.35	10	5/8
8	21	5-1/8	9-1/32	8.32	14	5/8
10	27	5-1/2	11-1/16	10.42	18	5/8
12	30	5-3/4	13-1/16	12.39	20	5/8

Dimensions represented in inches



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Certified to NSF/ANSI 61-G & 372

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