

JCM INDUSTRIES

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

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Typical Specification

JCM 112 Heavy Duty Patch Clamps

All single band patch clamps 1-1/2" and larger shall have a minimum material standard of certifiable prime 304 Stainless Steel band; heavy duty, low profile Ductile Iron Lugs per ASTM A536 with mutually supporting sliding fingers; 5/8" corrosion resistant alloy bolts, per ASTM A242/ANSI 21.11/AWWA C-111, and a Styrene-Butadiene Rubber (SBR) gridded gasket. To provide extra tightening capability, the band shall be permanently attached to the lugs by crimping the lug and locking it in place with a minimum of three stainless welds per lug. Clamp shall be similar to JCM 112 Heavy Duty Patch Clamp or approved equal. Optional features available; see material specification.

Clamps 10" and 12" shall have a minimum material of 17 gauge certifiable prime 304 Stainless Steel band; heavy duty Ductile Iron Lugs per ASTM A536 with mutually supporting sliding fingers; 3/4" corrosion resistant alloy bolts, per ASTM A242/ANSI 21.11/AWWA C-111, and a 1/4" thick Styrene-Butadiene Rubber (SBR) gridded gasket. To provide extra tightening capability, the band shall be permanently attached to the lugs. The attachment shall withstand a minimum of 100 ft. lbs. of torque per bolt. Optional features available; see material specification.

JCM 113 Multi Band Patch Clamps (sizes 10" – 36" and larger)

All multi-band patch clamps 10" and larger shall have a minimum material of 17 gauge certifiable prime 304 Stainless Steel band; heavy duty Ductile Iron Lugs per ASTM A536 with mutually supporting sliding fingers; 3/4" corrosion resistant alloy bolts, per ASTM A242/ANSI 21.11/AWWA C-111, and a 1/4" thick Styrene-Butadiene Rubber (SBR) gridded gasket. To provide extra tightening capability, the bands shall be permanently attached to the lugs. The attachment shall withstand a minimum of 100 ft. lbs. of torque per bolt. Clamp shall be similar to JCM 113 Multi Band Patch Clamp or approved equal. Optional features available; see material specification.

JCM 100 Series Universal Clamp Couplings are ANSI/NSF Standard 61, Annex G and ANSI/NSF Standard 372 Certified.



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 01.30.19

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Material Specification

JCM 112 Heavy Duty Patch Clamps

JCM 113 Multi Band Patch Clamps (sizes 10" – 36" and larger)

Band: 18-8 Type 304 Certifiable Prime Stainless Steel

Lugs: Ductile Iron ASTM A-536, 60-40-18

Bolts: Corrosion resistant low alloy per ASTM A242, ANSI A21.11, AWWA C-111.
National coarse rolled thread and heavy hex nut.
Optional Stainless Steel 18-8 Type 304 or 316 available.
Optional Epoxy Coated low alloy bolts/nuts available.

Gasket: 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.
Optional Buna-N, EPDM, Viton and other gasket available.

Coating: Corrosion resistant shop coat paint primer.

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