

# 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 464 Stainless Steel Tapping Sleeve with Carbon Steel Flange

Tapping Sleeve shall be of the high strength type having a wide body, made of corrosion resistant, 304 stainless steel, which conforms to and reinforces the pipe. The sleeve shall have a wide gasket of Nitrile Butadiene Rubber (NBR, Buna-N) per ASTM D2000 with hydromechanical activated lip, captured in a recessed groove around the outlet; 18-8 Type 304 stainless steel hardware and nuts. Stainless steel tapping sleeve shall be furnished with a stainless steel test plug in the test outlet. Sleeve shall be fully passivated to return the stainless steel to its highest corrosion resistance.

Flanged outlets shall be AWWA C207 Class D, ANSI 150 lb. Drilling, recessed for tapping valve per MSS-SP60. Outlets 2" – 12" rated for 175 PSI\* maximum operating pressure. Flanged outlet shall be coated for corrosion resistance.

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" 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.

Nominal pipe sizes 36" and larger shall be of the heavy duty type.  
Tapping Sleeves shall be JCM 464 or approved equal.

\*Higher test and working pressure ratings available upon request, contact JCM Industries.

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

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



JCM 464 Tapping Sleeve  
Image reflects 6" x 4"

*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.*



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## Material Specification

### JCM 464 Stainless Steel Tapping Sleeve with Carbon Steel Flange

**Body:** Stainless Steel 18-8 Type 304.

**Bolts:** Stainless Steel 18-8 Type 304.

**Flange:** AWWA C207 Class D, ANSI 150 lb. Drilling, recessed for tapping valve per MSS-SP60. Flanged outlet shall be coated for corrosion resistance. Optional flanges available upon request.

**Branch**

**Outlet:** Schedule 10 Stainless Steel Pipe Type 304

**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.

**Service**

**Rating:** 2" - 12" Outlets: 175 PSI. For service rating of 250 PSI or higher contact JCM Technical Services.

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Effective 02.09.11

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## JCM 464 Stainless Steel Tapping Sleeve with Carbon Steel Flange Dimensions

### Nominal Pipe Sizes 4" - 12"\*

#### Outlet Sizes 2" - 12"\*

Outlet	A	B	C	D	E	F
2	9	4	3-1/32	2-1/16	6	5/8
3	9	5	4-1/32	3-1/4	6	5/8
4	12	5	5-1/32	4-1/4	8	5/8
6	12	5	7-1/32	6-5/16	8	5/8
8	15	5-1/8	9-1/32	8-5/16	10	5/8
10	21	5-1/2	11-1/16	10-3/8	14	5/8
12	24	5-3/4	13-1/16	12-3/8	16	5/8

Dimensions represented in inches  
 3 x 3 Size on Size fittings available upon request.



### Nominal Pipe Sizes 14" - 30"

#### Outlet Sizes 2" - 12"

Outlet	A	B	C	D	E	F
2	12	4	3-1/32	2-1/16	6	3/4
3	12	5	4-1/32	3-1/4	6	3/4
4	12	5	5-1/32	4-1/4	6	3/4
6	12	5	7-1/32	6-5/16	6	3/4
8	16	5-1/8	9-1/32	8-5/16	8	3/4
10	20	5-1/2	11-1/16	10-3/8	10	3/4
12	24	5-3/4	13-1/16	12-3/8	12	3/4

Dimensions represented in inches

