

# 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 452 All Stainless Steel Tapping Sleeve with Stainless 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 304 stainless steel and shall be indexed per MSS-SP60 to accept tapping valve and have the equivalent O.D. and drilling as Class 125 Cast-Iron Flanges (ANSI/ASME B16.1) and Class 150 Steel-Ring Flanges (ANSI/ASME B16.5). Outlets 2" – 12" rated for 150 PSI\* maximum operating pressure.

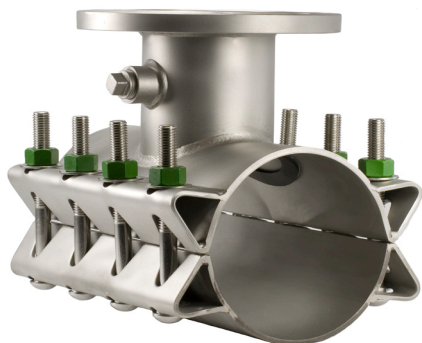
For outlet sizes 14" and larger, the gasket groove must be consistently positioned about throat of tapping waterway. Inside diameter of the gasket groove must be set back a minimum of 1" from the waterway to allow dispersal of forces generated by gasket compression. Gasket grooves machined in a circle and formed to an elliptical shape will not be an accepted equal.

Tapping Sleeves shall be JCM 452 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, 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.



JCM 452 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 452 All Stainless Steel Tapping Sleeve with Stainless Steel Flange

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

**Bolts:** Stainless Steel 18-8 Type 304.  
Sleeve sizes 14.20 and smaller = 5/8", sizes 14.75 and larger = 3/4"

**Flange:** 304 Stainless Steel or equivalent, per ANSI/AWWA C228 Class SD. Flange outlets shall be indexed per MSS-SP60 to accept tapping valve and have the equivalent O.D. and drilling as Class 125 Cast-Iron Flanges (ANSI/ASME B16.1) and Class 150 Steel-Ring Flanges (ANSI/ASME B16.5). Other 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, per ANSI/AWWA C228.  
For higher service ratings, contact JCM Technical Services.

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Effective 09.03.19

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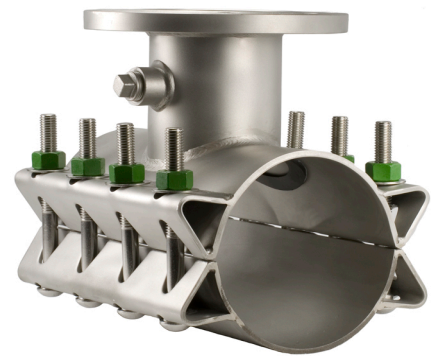
## JCM 452 All Stainless Steel Tapping Sleeve with Stainless Steel Flange Dimensions

### 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

