



Installation Instructions

Model 472 Fabricated Steel Tapping Sleeve

Read instructions before starting installation*

1. Clean and scrape pipe. Remove any scale, pipe wrap, debris or dirt that may interfere with the complete sealing of the gasket. Inspect pipe for integrity, size, outside diameter and surface irregularities. Confirm the proper size and range of tapping sleeve. Inspect fitting to ensure all parts are included.

For fittings furnished with stainless steel hardware, see reverse for fastener management.

2. Lubricate the pipe and the fitting gasket with soapy water. **Do not use oil base pipe lubricant.**
3. Position outlet half of body on pipe, making sure outlet is aligned with branch line to be connected. Do Not position so that rotation is required. Rotation can result in gasket dislocation. **NOTE:** If pre-assembling valve to tapping sleeve before installing sleeve on pipe, for size on size sleeve install center bolts before installing the valve.
4. Position back half of body and install bolts. **NOTE:** For fittings with hardware furnished with double washer sets, to assure ease of installation and obtain optimum bolt torque levels, install the double set of washers under each nut.

Tighten outside bolts first, working toward the center. Tighten bolts evenly. Alternate from one side of sleeve to the other. The gap between sleeve halves should be equal on both sides. JCM recommends the use of a torque wrench to ensure proper torque levels. Improper torque levels can result in leaking assembly or damage to the pipe wall. Tighten bolts to the following torque levels:

Pipe sizes 6" - 12"	100 ft. lbs. of torque
Pipe sizes 14" & larger	125 ft. lbs. of torque

NOTE: For test or working pressure above 250 PSI contact JCM for proper application. Bolts must be tightened to 125 - 150 ft. lbs. of torque.

On Thin Wall, PVC (SDR21, 26), and Flexible Pipe	50 - 55 ft. lbs. minimum
HDPE SDR11, SDR17 - 6" - 12"	55 - 60 ft. lbs. minimum
HDPE SDR11, SDR17 - 14" and Larger	90 ft. lbs. minimum

5. Check inside of sleeve neck to make certain gasket is properly seated and not protruding where tapping cutter may damage it. Complete installation of fitting, return after approximately 15 minutes and confirm minimum bolt torque levels have been maintained. Test assembly seals using test plug provided on sleeve or test connection on tapping machine.

Alignment and support of the tapping sleeve is the responsibility of the end user, per best engineering practice, industry standard practice, or local code. For water applications: if applicable, test assembly seals with water (per ANSI/AWWA C-223). When testing the assembly against the pipe to pressures greater than the internal pressure of the host pipe, application should be treated with caution to prevent imploding or damaging the pipe wall due to thin wall, flexible or brittle conditions. No more than 10% above line pressure. Size on size tapping cutter must not be larger than recommended by pipe manufacturer. Tapping operation must not force the pipe away from the gasket seal. For inquires, contact JCM Industries, Inc.

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*Ensure fitting is suitable for application (confirm size, materials, pressure ratings, line content, meets local governing & association standards, etc.). Pipeline operation forces, including pressure fluctuations, thermal expansion/contraction, movement/shifting, etc. will influence the success of the application. Proper anchorage, restraint, harnessing, thrust blocks or other devices must be provided to prevent pipe movement (lateral, angular, axial) or pipe pullout from the bolt-on fitting. Inspection of the pipe integrity is the responsibility of the end user. JCM recommends the use of calibrated torque wrench. Failure to follow installation instructions will result in voided product warranty.

For application review or questions contact JCM Industries at 1-800-527-8482, 903-832-2581





Tricks of the Trade for Installation

Model 472 Fabricated Steel Tapping Sleeve

JCM Quality Fitting Equipped With 18-8 Stainless Steel Bolts and Nuts

When not properly handled it is the nature of stainless steel fasteners to gall and freeze (seize up). This is due to the inherent properties of the stainless material. Galling and freezing is often triggered by the presence of metal chips, burrs and grains of sand on the threads of the bolts and nuts. Extra care has been taken by JCM prior to assembly and packing of this fitting to assure a trouble-free installation.

1. The nuts and bolts are made from material of different hardness so that they have different strengths.
2. Nuts are coated with a special anti-seize coating. Additional lubricant may be needed. **A Molybdenum-Base lubricant is recommended.**
3. Each nut is assembled by hand to be sure that it went on the bolt freely.
4. The bolts and nuts are handled carefully to avoid damage to the threads.
5. The bolts and nuts are made to exacting specifications to assure that the correct material is used and that the thread form is correct.

Stainless hardware is especially susceptible to galling. JCM supplies specially coated nuts to eliminate the galling caused by over-torquing, but **the bolt threads must be kept clean, free from nicks and not pitched or thrown into the tool bucket during the installation process.** Use of the **JCM 901 Master Wrench or JCM 905 Torque Wrench with Deep Socket is highly recommended.** Use of pneumatic wrench for installation could cause hardware to seize and is not recommended.