



# Pipe Fittings & Fabrications for Industrial Service

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## JCM Fabricated Tapping Sleeves

### JCM 472 Carbon Steel Fabricated Tapping Sleeves

Built-in benefits make these heavy fabricated steel sleeves increasingly popular for making larger taps on all types of pipe. By placing the design emphasis on eliminating problems inherent with older pipe and field installations, JCM Fabricated Tapping Sleeves have taken the complexity out of tapping or branching pipe.

**Built in range** - accommodates pipe industry tolerances and non-standard pipe diam

**Ease of assembly** - eliminates extra equipment, time and specially trained personnel

**Ready availability** - taps can be made without long delays - even taps on special pressure flanges.

**Direct reinforcement of the pipe** - eliminates flexing or deflection of pipe opposite to

**Large gasket cross section set in retaining cavity** - provides a positive initial seal which increases with increases in line pressure.

**Heavy steel sleeve** - eliminates deflection possibility. Most important, JCM Fabricated Tapping Sleeves assure a safe dependable tap.



JCM 472 Carbon Steel Tapping Sleeve  
Flanged Outlet

### MATERIAL SPECIFICATIONS - JCM FABRICATED TAPPING SLEEVES 472

**Body:** ASTM 283, ASTM 285 Grade C, ASTM A516 Grade 70 Steel or equal.

**Bolts:** Corrosion resistant, high strength low alloy ASTM A242, A193 B5, B7. Optional A193 B8 304 stainless steel or 316 stainless steel.

**Gasket:** Nitrile Butadiene Rubber (NBR, Buna-N) per ASTM D2000. Molded virgin rubber with a pressure activated hydromechanical 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. Optional gasket materials available.

**Finish:** Heavy coat of corrosion resistant metal primer.  
Optional Fusion Epoxy Coating available.

**Standard Flange:** ASME/ANSI B16.5 Class 150, 300, ASTM A105

#### Flanges Available Upon Request

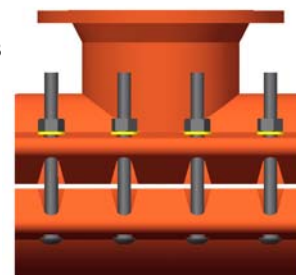
ASME/ANSI B16.1 Class 125, 250

ASME/ANSI B16.47 Series A & B, Class 150, 300

Weld Neck, Blind, Slip-on, Reducing, Threaded, Socket Weld, Lap Joint,  
Angle Face, Van Stone

Concentric and Eccentric Flanges

**Other Flanges available upon request**



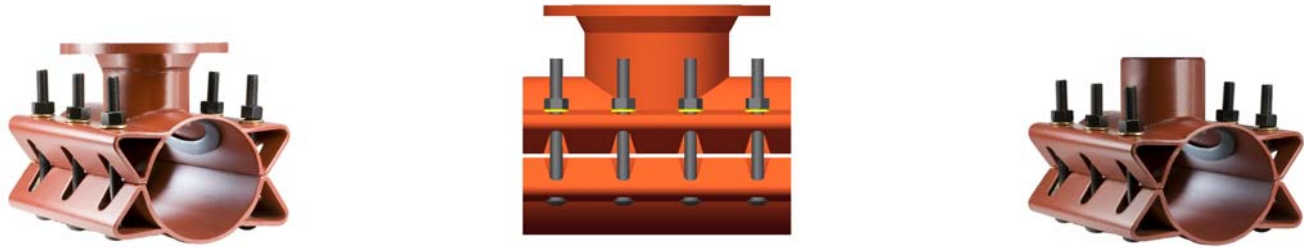
### JCM 471 Carbon Steel Tapping Sleeve with Plain End Outlet

Built to the same exacting standards of the JCM 472 Carbon Steel Sleeve furnished with a plain outlet with options including beveled for welding, square/butt cut and custom outlet/neck lengths.

**Design code and NDE specifications upon request. JCM Fabricated Tapping Sleeves can be manufactured in a variety of styles and configurations including offset outlets, tapping crosses and other designs to best fit your needs. Submit application information to JCM Engineered and Technical Sales at 800-527-8482 or 903-832-2581.**



JCM 471 Carbon Steel Tapping  
Sleeve  
Plain End Outlet



**JCM 472 Fabricated Carbon Steel Tapping Sleeve - Flanged Outlet**  
**JCM 471 Fabricated Carbon Steel Tapping Sleeve - Plain Outlet**

NOMINAL PIPE SIZE		SLEEVE O.D. RANGE		SLEEVE NUMBER (471 for Plain Outlet) X ANY OUTLET	OUTLET SIZES AVAILABLE	APPR. WT. EACH (LBS.)
IN	MM	IN	MM			
6	150	6.83 - 7.16	173 - 181	472-0690	X 3	74
					X 4	76
					X 6	82
8	200	8.98 - 9.37 9.27 - 9.69	228 - 237 235 - 246	472-0905 472-0940	X 3	83
					X 4	85
					X 6	88
					X 8	118
10	250	9.83 - 10.25 10.64 - 10.86 11.03 - 11.47	249 - 260 270 - 275 280 - 291	*472-1000 472-1075 472-1110	X 3	90
					X 4	92
					X 6	96
					X 8	125
12	300	12.62 - 12.88 13.13 - 13.60	320 - 327 333 - 345	472-1275 472-1320	X 10	168
					X 3	98
					X 4	100
					X 6	104
					X 8	140
14	350	15.23 - 15.80 15.73 - 16.22	386 - 401 399 - 411	472-1530 472-1600	X 10	176
					X 3	113
					X 4	115
					X 6	116
					X 8	150
16	400	17.33 - 17.87 17.88 - 18.43	440 - 453 454 - 468	472-1740 472-1800	X 10	190
					X 3	113
					X 4	115
					X 6	120
					X 8	162
18	450	19.41 - 20.01 20.00 - 20.60 20.29 - 20.94	493 - 508 508 - 523 515 - 531	472-1950 472-2000 472-2050	X 10	210
					X 3	120
					X 4	122
					X 6	126
					X 8	180
20	500	21.51 - 22.15 23.46 - 24.16	546 - 562 595 - 613	472-2160 472-2400	X 10	240
					X 3	131
					X 4	133
					X 6	140
					X 8	185
24	600	25.71 - 26.41 26.55 - 27.25	653 - 670 674 - 692	472-2580 472-2715	X 10	245
					X 3	143
					X 4	143
					X 6	160
					X 8	215
					X 10	280
					X 12	312

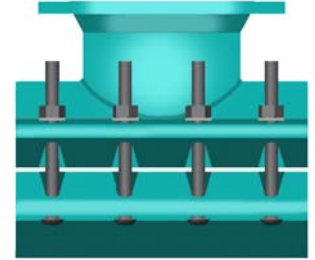
**LARGER AND NON-STANDARD SIZES AVAILABLE UPON REQUEST**

\*These sizes not available with size on size outlets.

For size on size outlets a 1/2" undersize shell cutter is required.

Conversion of U.S./Metric dimensions are approximate; application pipe diameter and range to be verified by the end user.

# JCM 472 Tapping Sleeves for Steel, PVC, HDPE Pipe Size Flanged Outlet



TYPE AND CLASS OF PIPE	NOMINAL PIPE SIZE		SLEEVE O.D. RANGE		CATALOG NUMBER	ADD OUTLET SIZE	APPR. WT. EACH (LBS.)		
	IN	MM	IN	MM					
<b>Steel Pipe</b> IPS SIZES, SCHEDULE PIPE	2	50	2.38	60	472-0238	x 2	15		
			2.50	63	472-0250				
<b>PVC Pipe</b> IPS SIZED SDR 26, 21 SCH. 40 CLASS 200, CLASS 160 C-900 PVC	3	80	3.50	88	472-0350	x 3	18		
			3.96	100	472-0396				
			4	100	4.50			114	472-0450
<b>Ductile Iron Cast Iron</b>	4	100	4.80	121	472-0480	x 4	31		
			5	125	5.56	141	472-0556	x 3 x 4	32 33
	6	150	6.63	168	472-0663	x 3	33		
			6.90	175	472-0690	x 4 x 6	35 44		
			8	200	8.63	219	472-0863	x 3	36
	8	200	9.05	229	472-0905	x 4 x 6 x 8	38 49 64		
			10	250	10.75	273	472-1075	x 3	90
			11.10	281	472-1110	x 4 x 6 x 8 x10	92 96 125 168		
	12	300	12.75	323	472-1275	x 3 x 4	98 100		
			13.20	335	472-1320	x 6 x 8 x10 x12	104 140 176 216		

## How To Order - JCM 472 Tapping Sleeves

1. Determine O.D. of pipe.	3. Specify catalog number and outlet size. For 472 Epoxy is standard. Add (SS) for Stainless Bolts.	<b>EXAMPLE:</b> For PVC pipe with 08.63 O.D. with 6" outlet, order: 472-0863 x 6. For stainless steel bolts, add (SS).
2. Select proper Sleeve O.D. range.		

Conversion of U.S./Metric dimensions are approximate; application pipe diameter and range to be verified by the end user.