



JCM 168 Fabricated Lug Lightweight Installation Instructions

1. Clean and scrape pipe. Remove any dirt or debris that would interfere with the complete sealing of the gasket around the pipe. Lubricate the pipe with soapy water. Do not use oil base pipe lubricant. *Trick of the Trade: Place a mark on the pipe to each side of the damaged area equal to the width of the clamp. This presents a visual mark to center the repair clamp over the damage area (1/2 of this distance is center).*
2. Inspect pipe for integrity, size and outside diameter. Confirm the proper size and range of repair clamp.
3. Open the repair clamp by loosening (without removing) the nuts to the top of the stainless studs/bolts. Disengage the locking "C-Plate" and lift plate to open clamp. Wrap repair clamp around the pipe centering the clamp over the damaged area.
4. Tuck tapered gasket(s) in place ensuring there are no folds in the tapered edge.
5. Loosely close the clamp around the pipe by lifting the C-Plate(s) lip over the lug system stainless receiver bar, meeting the stud and fingers, and lock in place. Rotate the clamp slightly in the direction of the arrow stamped on the clamp band to ensure the tapered gasket lies flat under the clamp.
6. Complete tightening of the clamp by squeezing the lugs together and tighten the nuts. Start at the center bolt and work out toward clamp ends, alternating from one side to the other for equal gap between clamp halves. Continue tightening sequence to reach the appropriate torque levels.
7. Tighten the nuts evenly with a hand wrench to the following torque values. To ensure proper torque level, wait 15 minutes and retighten to recommended torque. *Trick of the Trade: Pneumatic wrenches could cause the stainless nuts to seize on the stainless steel studs.*

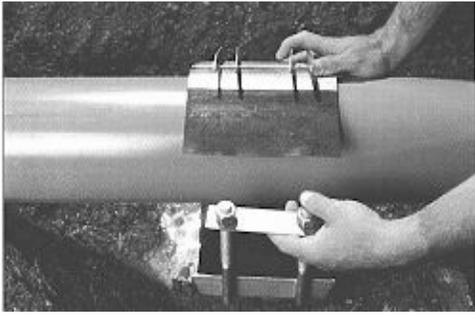
5/8" Bolts/Studs tighten to 70 Foot Pounds of Torque*

*Ensure proper torque level with a field grade torque wrench equal to the JCM 905 Torque Wrench. Thin wall, small diameter & flexible types of pipe are subject to many variables which affect torque values. Use discretion when tightening fittings on thin wall, small diameter & flexible pipe in order to not crush or severely deform the pipe.

Note: Clamps do not provide restraint of pipe ends. For applications in which pipe may pull out of clamp, external restraint must be provided.

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Open the repair clamp by loosening (without removing) the nuts to the top of the stainless studs/bolts. Disengage the locking "C-Plate" and lift plate to open clamp.

Wrap repair clamp around the pipe centering the clamp over the damaged area. Tuck tapered gasket in place ensuring there are no folds in the tapered edge.



Loosely close the clamp around the pipe by lifting the C-Plate lip over the lug system stainless receiver bar, meeting the stud and fingers, and lock in place. Rotate the clamp slightly in the direction of the arrow stamped on the clamp band to ensure the tapered gasket lies flat under the clamp.



Complete tightening of the clamp by squeezing the lugs together and tighten the nuts to the appropriate torque levels.



Tighten the nuts evenly with a hand wrench to the following torque values. *Trick of the Trade: Pneumatic wrenches could cause the stainless nuts to seize on the stainless steel studs.*

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Completed JCM 168 Clamp Installation