



## JCM 416 & 417 Weld On Tapping Sleeve INSTALLATION INSTRUCTION

1. Thoroughly clean pipe surface. Check the size of the tapping sleeve to verify correct size product.
2. Check pipe integrity. Verify outside diameter, wall thickness, pipe condition and suitability for product application.
3. Position fitting on pipe. Check fit and alignment of tapping sleeve to pipe surface.
4. Weld fitting into place as follows:
  - A. Tack weld fitting onto pipe with outlet properly positioned.
  - B. Weld end of fitting to pipe. Allow to cool.
  - C. Weld opposite end of fitting. Allow to cool.
  - D. Weld sides of fitting.
  - E. Re-check alignment.

**Note: All welds should be in accordance with applicable standards.**

5. Pressure test fitting prior to tapping.
6. Re-weld any areas as indicated by pressure test. Pressure test as required.
7. Proceed with tapping operation. JCM recommends adherence to the AWWA M-44 Manual for proper valve installation, support and trenching.

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