

# JCM INDUSTRIES

P. O. Box 1220, Nash, TX 75569-1220

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[www.jcmindustries.com](http://www.jcmindustries.com)

## Typical Specification

### JCM 440 Line Stop Sleeve (sizes 4" through 8")

Line Stop sleeve shall be fabricated from 304 Stainless Steel. They shall have a pass through bolt design and provide 360o seal around the pipe. The 440 is fully passivated to return the stainless steel to its highest corrosion resistance. To provide the proper strength, support and safety factor for the valve, drilling machine operation and load forces, the body construction shall be a minimum of:

Outlet Half (load bearing half):	12 gauge Stainless Steel
Back Half (conforming half):	14 gauge Stainless Steel

For proper strength, support and rigidity for the valve, drilling machine operation and load forces, the outlet construction shall be minimum of:

Outlet: Schedule 40 Stainless Steel pipe sized to accept full size cutter.

Flange: Stainless Steel, 18-8 Type 304 ANSI 150 Drilling, recessed for tapping valve per MSS-SP60.

Bolting System: The lugs shall have a pass-through bolt design, to avoid alignment problems and allow tightening from either side of the pipe. Bolts shall not be integrally welded to the sleeve. Bolting lug shall be triangular design with a maximum of 3" bolt center spacing.

#### Bolts, Nuts & Washers:

304 Stainless Steel, the bolts shall be track head type and furnished with permanently lubricated heavy-hex nuts and stainless washers.

Gasket: The full circumferential gasket shall be molded of synthetic rubber compounded for use with water salt solutions, mild acids, bases and sewage. The gasket shall have a gridded surface, be a full 1/4" thick with 304 stainless steel bridge plates molded flush into the gasket and have a raised hydromechanical outlet seal to seal against line surges and water hammer.

Pressure Rating: The sleeves shall be rated at 150 PSI hydrostatic with a test pressure of 200 PSI on pipe with a full circumferential break.

Line Stop Sleeves shall be JCM 440 Line Stop Sleeve or approved equal.

*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.*



Effective 07.16.10

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## Material Specification

### JCM 440 Line Stop Fittings – Sizes 4” through 8”

Line Stop Plug: Ductile Iron per ASTM A536

Plug O-Ring: Nitrile (NBR, Buna-N) Rubber - Gasket temperature range -40° to 212°F (-40°C to 100°C).

Blind Flange Gasket: Styrene-Butadiene Rubber (SBR) –Compounded for use with water, salt solutions, mild acids and bases. Standard temperature range from -40° to 150°F (-40° to 65° C) constant, maximum intermittent 180° F (82 ° C).

Outlet Gasket: Styrene-Butadiene Rubber (SBR) - Full circumferential gasket compounded for use with water, salt solutions, mild acids and bases. Per ASTM D-2000. Standard temperature range from -40°F to 150°F (-40° to 65° C) constant, maximum intermittent 180° F (82 ° C). For applications on high temperatures or chemical pipelines, contact JCM Industries Technical Services.

Body: Stainless Steel, 18-8 Type 304

Flange: Stainless Steel, 18-8 Type 304 ANSI 150 lb. Drilling, B16.1 Class 125 Compatible, recess for tapping valve MSS-SP60

Blind Flange: 150#, ASTM A36 Carbon Steel, Epoxy Coated

Bolts: Stainless Steel 18-8 Type 304.

JCM 400 Series Sleeves are ANSI/NSF Standard 61 and Standard 61 Annex G Certified.

JCM Sleeves meet ANSI/AWWA Standard C223 Fabricated steel and Stainless steel Tapping Sleeves and MSS SP-124 as applicable.



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