Features and Benefits

1. The complete tapping sleeve is made from Carbon Steel and is cleaned and painted with a liquid Epoxy paint designed to protect the steel and ensure adequate protection of the welds.
2. The tapping sleeve shall be rated for a maximum working pressure of 250 psi for nominal sizes up through and including 24 x 8.
3. The tapping sleeve shall be factory hydrostatically tested on pipe to verify proper fit and weld integrity. The duration of the test shall be a minimum of three (3) minutes with zero leakage allowed. **The Tapping Sleeve shall be rated for a maximum working pressure of 250 psi and 312 psi testing pressure for outlet sizes 4" to 8". For outlet sizes 10" and 12" a maximum working pressure 200 psi and 300 psi testing pressure. For pipe sizes larger than 30" a maximum working pressure up to 100 psi and 150 psi testing pressure.**
4. Built in range allows reduction of inventory.
5. "Drop-in" track head bolts allow assembly in either direction.

Branch Size	A (in)	B (in)	C (in)	D (in)	Bolts Size	Bolts Qty	Working Pressure (PSI)	Test Pressure (PSI)
4	12	3.75	4.34	4.80	¾”	6	250	312
6	12	4.25	6.34	6.90	¾”	6	250	312
8	16	4.75	8.34	9.05	¾”	8	250	312
10	20	5.25	10.34	11.1	¾”	10	200	300
12	20	6.25	12.34	13.20	¾”	10	200	300
For all pipe 30 inch and up the working pressure is 100PSI regardless of branch size.								

Scope

The intent of this specification is to receive a Carbon Steel Tapping Sleeve. The Tapping Sleeve furnished shall be equivalent to Model 3460CS-AIS Tapping Sleeve as manufactured by PowerSeal Pipeline Products Corporation.

Design and Material Specification

- The tapping sleeve shall meet or exceed all material specifications as listed below:

1. The sleeve meets all AWWA C223 requirements.
2. The tapping sleeve shall have a Flange face gasket and a branch sealing o-ring gasket all permanently attached to the sleeve at the factory.
   The branch sealing gasket shall be an o-ring in NBR (-25F° - +248F°) rubber. The flange face gasket shall be SBR (-25F° - +200F°).
3. The tapping sleeve shall incorporate drop-in, oval-neck track-head bolts in low alloy steel (Available in 304 or 316 stainless steel). See chart above for quantities.
4. The Branch shall be a minimum of 3/8” larger diameter than nominal to allow the use of a full size cutter.
5. Branch to flange and branch to body connections are double welded. Outer structural weld GMAW (FCAW) and inner fusion weld GTAW (TIG).
6. Lugs shall be structurally welded GMAW (FCAW) to the shell and the test outlet shall be fusion welded GTAW (TIG) to the branch
7. There shall be no paper or plastic adhesive Labels attached to the tapping sleeve, any information appearing on the sleeve shall be stenciled

3460CS-MJ-AIS
TAPPING SLEEVE IN CARBON STEEL
Certified to NSF/ANSI-61

Material Specifications		
Part Name	**Material**	**Mat. specs**
MJ Flange	Carbon Steel	AWWA C115
MJ Gasket	SBR	AWWA C115AP
Branch	¼” Carbon Steel	ASTM A36
Test Plug	Stainless Steel	ANSI B2.1
Shell	3/8” Carbon Steel	ASTM A36
Bolt Lug	Carbon Steel	ASTM A36
Branch O-ring	NBR	ASTM D2000
Bolts	Low Alloy Steel	ASTM A325
Nuts	Low Alloy Steel	ASTM A563
Washers	Stainless Steel	ANSI B18.22.1
Back up plate	3/8” Carbon Steel	ASTM A36
Coating	Epoxy Paint	AWWA C210