

SECTION 630

Case 17-10

Revised 8/29/17

630.4.2 Tapping sleeves for use on pipelines constructed of cast iron, ductile iron, asbestos cement, and PVC:

Tapping sleeves shall be of extra heavy construction to provide resistance to line pressures. They shall be built in two halves for assembly around the main to be tapped. The branch outlet shall have a flanged face for bolting to the tapping valve.

Tapping sleeves shall be of the following types:

(A) Mechanical Joint Tapping Sleeves shall conform to the following:

The circumferential joints at both ends of the sleeve shall be sealed by mechanical joints and end gaskets. Mechanical joints shall conform to the requirements set forth in the most recent publication of AWWA C-111 as to the dimensions, clearance, and materials. Sleeve body shall be constructed of ASTM A283 Grade C, ASTM A285 Grade C, ASTM A-36 Steel or equal. The body shall be coated with a corrosion resistant shop coat primer unless otherwise specified by the **Utility Owner**. A ¾" NPT test port is required on branch of sleeve for field testing prior to tap.

Flanged outlet shall have dimensions and drilling that complies with ASME B16.1 class 125 and per Manufacturer's Standardization Society (MSS SP-60).

Unless otherwise noted, approved elastomer compounds are SBR, Buna-N, EPDM, and Viton. Elastomer shall be compounded for use with water, salt solutions, mild acids and bases per ASTM D-2000.

Bolts to be corrosion resistant low alloy (AWWA C-111) unless otherwise specified by the **Utility Owner**.

Sleeve shall be compliant with the federal requirements of the Drinking Water Standard NSF/ANSI **Standard** 61 regulating the health effects of drinking water materials, treatment chemicals, and restricting the use of lead-containing materials.

Tapping sleeve shall be installed per the manufacturer's recommendations and MAG Detail 340. Coupon extraction shall be available for inspection.

(B) Stainless Steel Tapping Sleeves shall conform to the following:

Stainless Steel, Type 304 ASTM A240, and meets or exceeds applicable AWWA C223 standards. Each weld is to be fully chemically passivated in accordance with ASTM A380. A ¾" NPT test port is required on branch of sleeve for field testing prior to tap.

Flanged outlets shall be Type 304 Stainless Steel ASTM A 240, AWWA C228 Class SD ANSI 150# drilling and recessed for tapping valves per Manufacturer's Standardization Society (MSS-SP 60).

The gasket shall be fully circumferential providing a 360 degree seal. The elastomer compound shall be ¼" thick, have a grid patterned face, and certified to NSF/ANSI **Standard** 61-G & 372. Unless otherwise noted, approved elastomer compounds are SBR, Buna-N, EPDM, and Viton.

Elastomer shall be compounded for use with water, salt solutions, mild acids and bases per ASTM D-2000.

Bolts and Nuts shall be Type 304 Stainless Steel per ASTM A193 or ASTM A194.

Sleeve shall be compliant with the federal requirements of the Drinking Water Standard NSF/ANSI **Standard** 61 regulating the health effects of drinking water materials, treatment chemicals, and restricting the use of lead-containing materials.

Contractor to verify if size-on-size is **acceptable to the Utility Owner**.

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Tapping sleeve shall be installed per the manufacturer's recommendations and Detail 340. Coupon extraction shall be available for inspection.

(C) Tapping Sleeve Testing shall comply with the following:

Unless otherwise noted, the tapping sleeve assembly shall be pressure tested utilizing a sanitized hydrostatic pump to 200 psi for a minimum of 30 minutes. The pressure test shall occur prior to tapping the main. A 3/4" NPT test port is required on all sleeves for field testing prior to tap. Original manufacturer's test plug must be properly re-installed after testing is complete. All testing procedures shall comply with the NSF/ANSI Standard 60 and Standard 61 drinking water standard regulating the health effects of drinking water supplies, treatment chemicals, and restricting the use of lead-containing materials.

630.4.3 Tapping sleeves for concrete pressure pipes shall be fabricated tapping sleeves and comply with the following:

