

**CITY OF AKRON, OHIO
DEPARTMENT OF PUBLIC SERVICE
WATER SUPPLY BUREAU**

SPECIFICATIONS FOR STAINLESS STEEL REPAIR SLEEVES

PRIMARY SPECIFICATIONS

Sleeves shall be Romac SS1 style, or equal as approved by the Akron Water Supply Bureau (AWSB). Unless noted, all sleeves shall be one section style and have the following O.D. ranges and lengths.

<u>Nominal Coupling Size</u>	<u>Size Range (inches)</u>	<u>Length (inches)</u>
4 inch	4.74 - 5.14	7, 15
6 inch	6.84 - 7.24	10, 15
8 inch	9.05 - 9.45	10, 15
10 inch	11.05 - 11.40	10, 15
12 inch	13.10 - 13.50	12, 20, 30
16 inch	17.15 - 17.90	16

Two-section style sleeves shall be 12 inches long and shall have the following range.

<u>Nominal Coupling Size</u>	<u>Size Range (inches)</u>	<u>Length (inches)</u>
12 inch	12.70 - 13.50	30"

The shell, armor plate, sidebars, lifter bar, lugs, bolts and nuts shall be AISI 304 (18-8) stainless steel. The armor shall be permanently bonded to the gasket. The gasket shall be full thickness between the armor and the pipe. The armor shall have full wedges at each edge, so as to offset any sharp differential or pressure against the pipe.

The lugs shall be Heliarc welded (MIG weld) to the top side bar. The sidebars shall be Heliarc welded (TIG weld) to form a permanent fusion with the shell. The lifter bar shall be designed to slide up the profile of the receiver lugs to hold its position under the side bar, and to act as a bearing surface while tightening the nuts.

The nuts shall be heavy hex and lubricated to prevent galling or seizing. The bolts shall be 5/8" NC thread.

The gasket shall be of virgin styrene butadiene rubber (SBR), or equal, compounded for water service, in accordance with ASTM D2000-AA415.

Workmanship employed in the fabrication and assembly of the repair sleeves shall be first class in every respect.

All welding shall be chemically treated and the residue removed (passivation) so as to return the welded stainless steel to its original corrosion resistant state.

There shall be no paper or plastic adhesive labels attached to the repair sleeve. Any information appearing on the sleeve shall be stenciled.

ALTERNATE SPECIFICATIONS

As an alternate, vendor may also provide repair sleeves meeting the following specifications. Vendor may bid either or both types of repair sleeves.

Stainless steel repair sleeves shall be Hydro-Flex 3000 as manufactured by Total Piping Solutions.

The shell, armor plate, sidebars, lifter bar, bolts and nuts shall be AISI 304 (18-8) stainless steel. Gasket shall be EPDM rubber. The lug retainer shall employ ABS plastic. The bolts shall be coated with an anti-seize compound. The gasket shall be bonded to the armor with stainless steel rivets only. The gasket shall have pressure ribs to facilitate sealing.

The repair sleeve shall not employ any welds in its construction.

INSTRUCTIONS TO BIDDERS

Bidder shall specify make of the repair sleeve they propose to furnish. Bidder shall furnish descriptive literature and specifications for the repair sleeves they propose to furnish.