

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

SPECIFICATIONS FOR STAINLESS STEEL TAPPING SLEEVES, MECHANICAL JOINT OUTLET

SPECIFICATIONS

The shell, flange, armor plate, sidebars, bolts, washers, and nuts shall be AISI 304 (18-8) stainless steel. The triangular sidebars shall be Heliarc welded (GMAW or GTAW) to the shell. All welding shall be chemically treated and the residue removed (passivated) so as to return the welded stainless steel to its original corrosion resistant quality.

The stainless steel tapping sleeve shall have a raised branch-sealing gasket which seats upon the pipe barrel, and a complete circle repair clamp gasket. The circle gasket shall be a full ¼ inch thick between the tapping sleeve and the pipe, permanently bonded to the sleeve, and shall give a complete 360-degree seal. The gaskets shall be virgin GPR or SBR rubber, or equal, compounded for water service, in accordance with ASTM D2000 MAA 610 for water service.

Unless specified differently on the order, the sleeve outer diameter range for each size of tapping sleeve shall be the following:

4 inch	4.70 – 5.00 inches
6 inch	6.90 – 7.30 inches
8 inch	9.04 – 9.45 inches
10 inch	11.06 – 11.45 inches
12 inch	13.16 – 13.56 inches
16 inch	17.40 – 17.80 inches
20 inch	21.40 – 21.80 inches
24 inch	25.60 – 26.00 inches

The branch shall be larger in diameter than nominal to allow the use of a full size cutter. There shall be a ¾" plug for testing the sleeve prior to tapping the main.

The branch outlet shall have a plain end and a mechanical joint gland welded fully around its circumference. The mechanical joint gland shall be either 304 stainless steel or ASTM A536 ductile iron. The outlet gland shall accept a standard mechanical joint gate valve. The dimensions of the outlet gland and the rubber gasket shall conform to AWWA Standard C111.

The heavy-duty sidebar shall employ trackhead bolts and nuts. Sleeves employing studs will not be accepted. The nuts shall be heavy hex and coated to prevent galling or

seizing and shall employ nylon washers for ease of operation. The bolts shall be 5/8" NC threads.

Each sleeve shall be furnished with the mechanical joint gasket and proper number of 3/4 inch UNC low-alloy steel T-bolts and nuts, packaged.

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

Each sleeve shall be rated for a working pressure of 200 psi for pipe diameters up to 24 inches, and 150 psi for 30 inches and above.

Workmanship employed in the fabrication and assembly of the tapping valves shall be first class in every respect.

Tapping sleeve shall be the PowerSeal Model 3490MJ or Romac SSTIII-MJ, or approved equal. Award of bid will be based on product best meeting specifications.

INSTRUCTIONS TO BIDDERS

Bidder shall specify make of the tapping sleeve proposed to be furnished and the delivery date. Bidder shall furnish descriptive literature and specifications for the repair sleeves they propose to furnish.