

# JCM INDUSTRIES

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

Phone 800-527-8482 or 903-832-2581

Fax 800-874-9524 or 903-838-6260

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

## Typical Specification

### JCM 121 Gas Repair Clamp (sizes 2" – 8")

All full circumferential single band repair clamps 2" and larger shall have a minimum material standard of certifiable prime 304 Stainless Steel band; heavy duty, low profile ductile iron lugs per ASTM A536 with mutually supporting sliding fingers; 5/8" corrosion resistant alloy bolts, per ASTM A242/ANSI 21.11/AWWA C-111, and a Nitrile Butadiene Rubber (NBR, Buna-N) gridded gasket with tapered lap joint ends and a 304 stainless steel bridge plate molded flush into the gasket. Gaskets in sizes 3" and larger shall be 1/4" thick. To provide extra tightening capability, the band shall be permanently attached to the lugs by crimping the lug and locking it in place with a minimum of three stainless welds per lug. Clamp shall be similar to JCM 121 Gas Repair Clamp or approved equal. Optional features available; see material specification.

### JCM 121 Gas Repair Clamp (sizes 10" and larger)

All full circumferential single band repair clamps 10" and larger shall have a minimum material of 17 gauge certifiable prime 304 Stainless Steel band; heavy duty ductile iron lugs per ASTM A536 with mutually supporting sliding fingers; 3/4" corrosion resistant alloy bolts, per ASTM A242/ANSI 21.11/AWWA C-111, and a 1/4" thick Nitrile Butadiene Rubber (NBR, Buna-N) gridded gasket with tapered stainless steel bridge plate molded flush into the gasket. To provide extra tightening capability, the band shall be permanently attached to the lugs. The attachment shall withstand a minimum of 100 ft. lbs. of torque per bolt. Clamp shall be similar to JCM 121 Gas Repair Clamp or approved equal. Optional features available; see material specification.



JCM 121 Gas Repair Clamp  
Image reflects 6" width

*Do not use for the repair of Polyethylene Gas Pipe. Suitable for reshaping and marking squeeze off locations.*

*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.*

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## Material Specification

### JCM Gas Repair Clamps – Model 121

Band: 18-8 Type 304 Certifiable Prime Stainless Steel

Lugs: Ductile Iron ASTM A-536, 60-40-18

Bolts: Corrosion resistant low alloy per ASTM A242, ANSI A21.11, AWWA C-111. National coarse rolled thread and heavy hex nut.  
Optional Stainless Steel 18-8 Type 304 or 316 available.  
Optional Epoxy Coated low alloy bolts/nuts available.

Gasket: Nitrile Butadiene Rubber (NBR, Buna-N) per ASTM D2000. Molded virgin rubber for natural gas, oil, mild acids, bases, water and sewage. Gasket temperature range -40°F to 180°F (-40°C – 82°C). For applications on high temperatures or chemical pipelines, contact JCM Industries Technical Services.

Coating: Corrosion resistant shop coat paint primer.

### JCM 123 Service Clamp

Threaded

Outlet: 18-8 Type 304 Stainless Steel

### Pressure Rating of 121 & 123 Gas Clamps

#### Cast Iron Pipe:

2" through 8" 100 PSI Gas

10" through 12" 60 PSI Gas

#### Steel Pipe:

2" through 8" 100 PSI Gas

10" through 12" 60 PSI Gas

For ranges and widths, see JCM Industries Industrial Products Manual.

Information based on data available at the date printed below and subject to change without notice.

Contact JCM Industries for amendments or changes.

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## JCM 121 Gas Repair Clamp Design Specifications

Clamp Width (Inches)	Number of Bolts
6	2
7	2
12	4
15	4
18	6
24	8
30	10

Clamp Size (Inches)	Stainless Band Gauge
2 – 4.50	24
4.80 – 9.40	20
10 – 12	17

Clamp Size (Inches)	Gasket Thickness
2	3/16"
3 and larger	1/4"

Clamp Size (Inches)	Bolt Size
2 – 8	5/8"
10 – 12	3/4"