

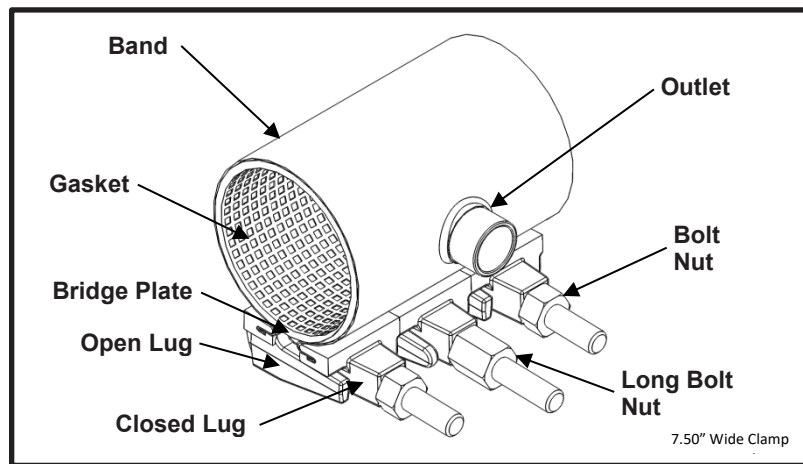


Smith-Blair  
a xylem brand

# SPECIFICATION

## FULL CIRCLE<sup>®</sup> TAPPED REPAIR CLAMP

### MODEL 234



**Do not tap through this product!!!**  
**Only use for repair or installations where the pipe is drilled prior to installation.**

#### APPLICATIONS

- **Typical Uses**
  - Repair leaks at broken or torn out service connections or branch lines
  - For use on installations where the pipe is drilled prior to installation
- **Standard Pipe Sizes**
  - 3" to 8" nominal
- **Standard Taps**
  - NPT: 1/2", 3/4", 1", 1-1/4", 1-1/2", 2"
  - See Smith-Blair catalog for available pipe diameter and tap size combinations as some combinations are not available
- **Standard Widths**
  - 7.5", 10", 12.5", 15"
- **Type of Pipe**
  - Carbon Steel, Stainless Steel, Cast Iron, Aluminum
- **Working Pressure**
  - 125 psi

#### MATERIALS

- **Band**
  - Type 304 Stainless Steel per ASTM A240
  - Band Thickness: 20 gauge
  - Hemmed ends for lug removal in tight applications
- **Lugs**
  - Cast using Ductile Iron 80-55-06 per ASTM A536
  - Flexi-Coat<sup>®</sup> fusion bonded epoxy finish
  - Slot cast in lug to capture band hem
  - Designed for drop in replaceable bolts
  - One open loop lug and one closed loop lug. The bolts do not have to be removed to install clamp, preventing lost hardware
  - Long interlocking fingers allow for up to 0.40 inches of range in clamp
  - Interchangeable lugs allow combining smaller diameter clamps to create larger diameter clamps



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- **Gasket**
  - Nitrile (Buna-N) per ASTM D2000
  - Gasket Thickness: 0.192" thickness for clamps 4.50" diameter and smaller  
0.218" thickness for clamps 4.80" diameter and larger
  - Compounded to resist oil, natural gas, acids, alkalis, most (aliphatic) hydrocarbon fluids, and many other chemicals
  - Temperature range: -20°F to +180°F
  - Full 360° gridded face gasket provides maximum pipe support, reinforcement, and sealing pressure
  - Tapered ends allow for full circumferential sealing
- **Bridge Plate**
  - Type 304 Stainless Steel quarter-hard per ASTM A240
  - Molded and recessed into gasket
  - Preformed for uniform distribution of gasket pressure over the entire pipe circumference
- **Outlet**
  - Type 304 Stainless Steel per ASTM A276
  - Tap size marked on outlet neck for rapid identification
  - Welds accomplished using qualified welders
  - GTAW weld process utilized
- **Bolts**
  - High Strength Low Alloy (HSLA) Steel
  - 5/8"-11UNC x 6.00" long, Track Head Oval Neck
  - Rolled threads for improved physical characteristics, greater thread accuracy, and smooth surface finish
  - Fe/Zn coated per ASTM F1941-10
  - Drop in replaceable bolts
- **Long Bolts**
  - HSLA Steel
  - 5/8"-11UNC x 6.88" long, Track Head Oval Neck
  - Rolled threads for improved physical characteristics, greater thread accuracy, and smooth surface finish
  - Fe/Zn coated per ASTM F1941-10
  - Used on clamps 4.50" diameter and smaller to facilitate the initial clamp installation
  - Drop in replaceable bolts
- **Nuts**
  - HSLA Steel
  - 5/8"-11UNC, Heavy Hex Semi-Finished
  - Fe/Zn coated per ASTM F1941-10
- **Long Nuts**
  - HSLA Steel
  - 5/8"-11UNC x 1.00" long, Heavy Hex Semi-Finished
  - Fe/Zn coated per ASTM F1941-10
  - Used to provide hand tightening during initial clamp installation



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#### LISTINGS/STANDARDS

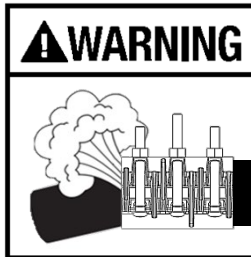
- Meets applicable D.O.T. Title 49 Section 192 regulations
- Flexi-Coat<sup>®</sup> Fusion-Bonded Epoxy Coating meets requirements of AWWA C213

#### OPTIONS

- Type 316 Stainless Steel band
- Type 304 Stainless Steel hardware with fluoropolymer coated nuts to prevent galling
- Type 316 Stainless Steel hardware with fluoropolymer coated nuts to prevent galling
- Alternative gasket material (e.g. Buna-N, EPDM, etc.)
- Offset gaskets to allow for repairing longer cracks using multiple clamps
- Conductivity feature
- Clamps up to 30" wide

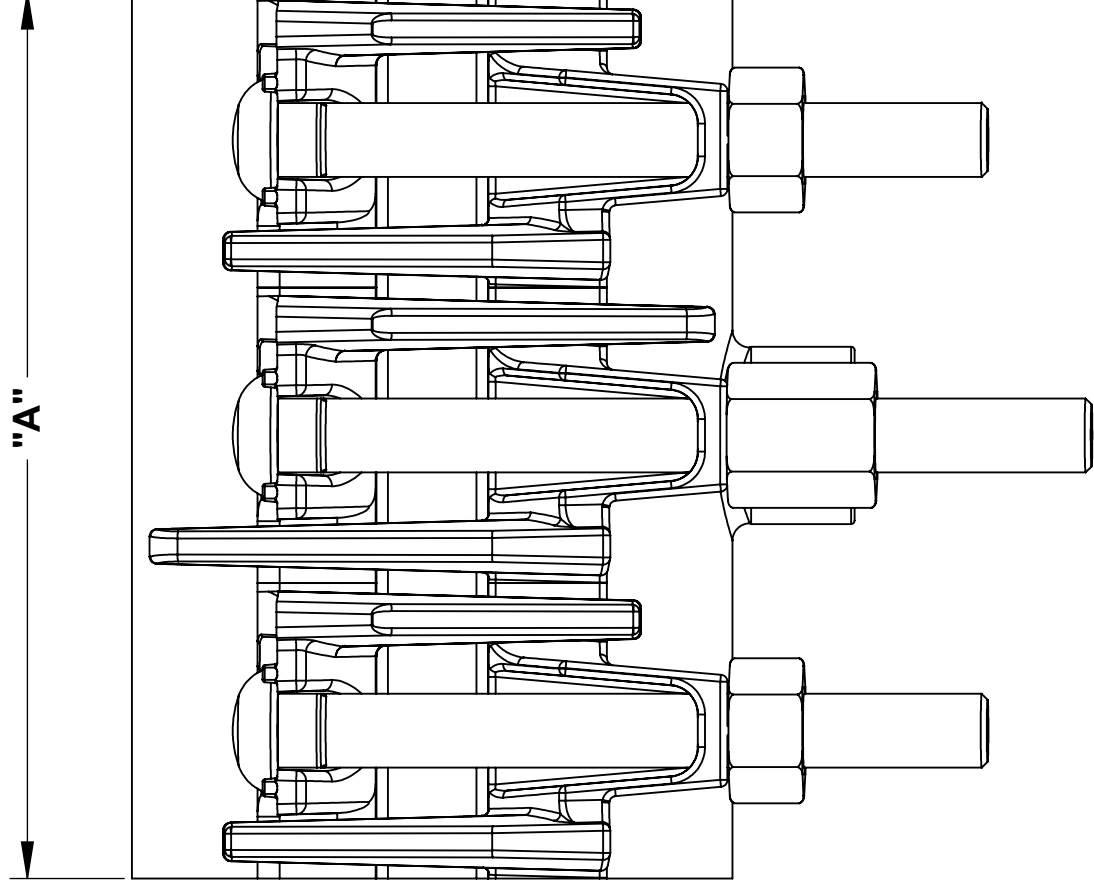
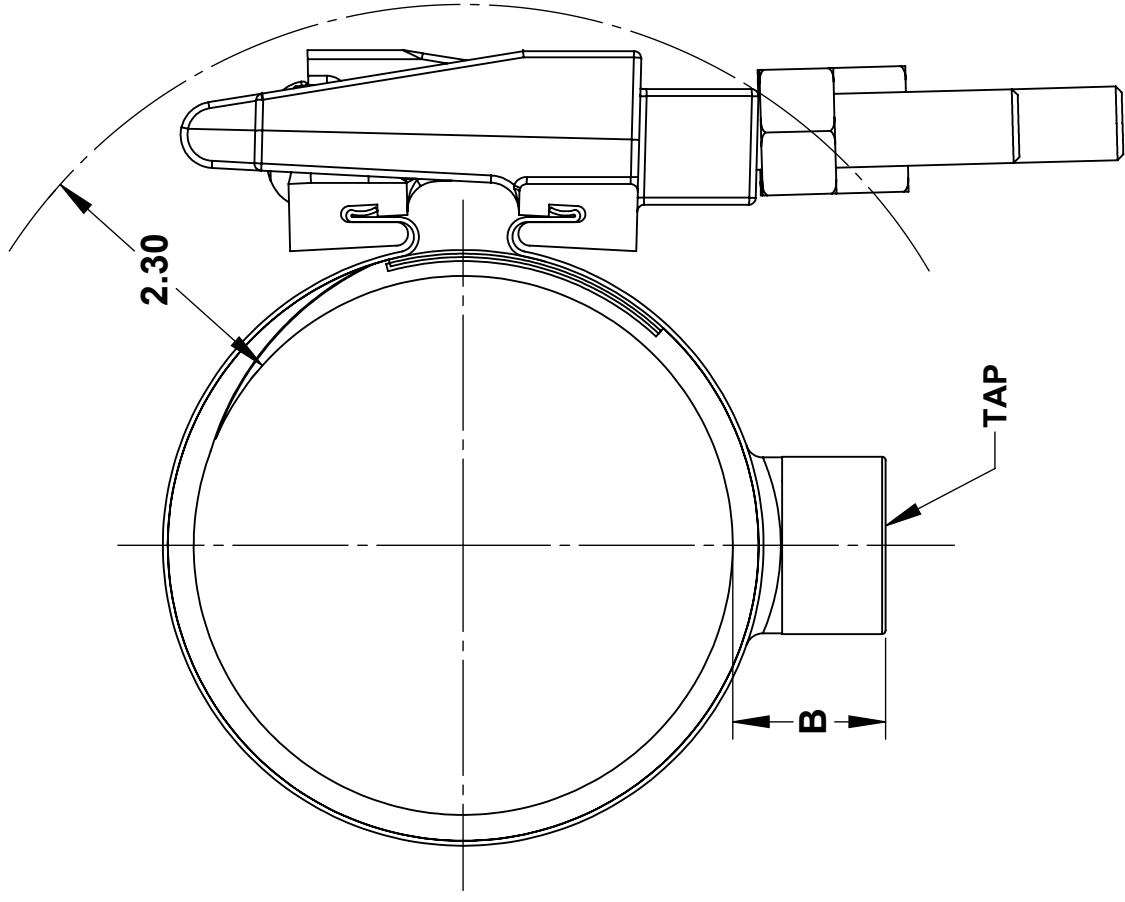
#### NOTES

- Full Circle<sup>®</sup> is a registered trademark of Smith-Blair
- These product specifications were correct at the time of publication and are subject to change without notice.
- See the Smith-Blair website for part numbers and ordering information
- See the Smith-Blair website for warranty information
- See the Smith-Blair website for corrosion notice



**THIS PRODUCT DOES NOT RESTRAIN PIPE MOVEMENT.** Proper anchoring is required to prevent pipe pull out. Failure to anchor or improper anchoring can result in dangerous pipe content escape, property damage, serious injury, and/or death. Read the product installation instructions prior to installing this product.

30 Globe Ave, Texarkana, AR 71854  
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Toll-Free Numbers: Ph: 800-643-9705 • Fax: 800-648-6792



**NOTES:**

1. LONG OVAL NECK BOLTS ONLY PROVIDED ON CLAMPS 4.50" DIAMETER AND SMALLER.
2. SEE SMITH-BLAIR CATALOG FOR AVAILABLE PIPE DIAMETER AND TAP SIZE COMBINATIONS AS SOME COMBINATIONS ARE NOT AVAILABLE.
3. 7.50" WIDE CLAMP SHOWN OTHER SIZES SIMILAR.

TAP CHART		
B	SIZE	NPT
1.30	1/2"	03
	5/8"	-
	3/4"	06
1.50	1"	08
	1-1/4"	10
	1-1/2"	12
	2"	14

A	BOLT QUANTITY		LONG NUT QUANTITY	SOCKET SIZE
	SHORT	LONG		
7.50	2	1	1	1-1/16"
10.00	2	2	2	
12.50	3	2	2	
15.00	4	2	2	

TOLERANCES U.N.O. XX= ±.03 XXX= ±.015 FRACTIONS= ANGLES=±1° MACH. FIN= ALL DIMENSIONS ARE IN INCHES.	NOTES: REMOVE BURRS AND SHARP EDGES DO NOT SCALE DWG.	APP'D	DATE
SCALE: N/A		CK'D	DATE
		DRN	DATE
		CHD	5/20/15

**TITLE**  
**SPECIFICATION**  
**FULL CIRCLE® TAPPED REPAIR CLAMP**  
**MODEL 234**

P/N N/A

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DWG. NO. **SPEC\_234.DRW**

4 OF 4 SHEET  
8/1/17 REV.