

B-Too™ Drilling and Tapping Machine Instruction and Maintenance Manual



Thank you for your purchase of the 'B-Too' Drilling and Tapping Machine. Please read and understand this short operation manual. Our goal is to serve you, our customer. If you have any questions, complaints or improvement suggestions please call us at 1-800-426-9341



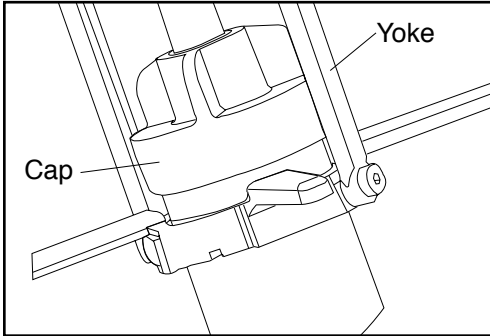
Transmate

a Division of Romac Industries, Inc.

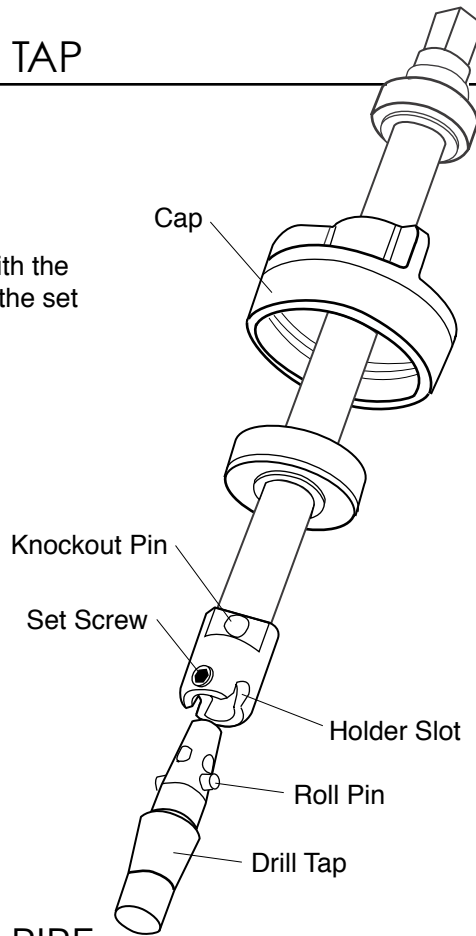
1 step one

LOAD DRILL TAP

Load the drill tap into the holder by aligning the roll pin with the slots in the holder and pushing it into the holder. Tighten the set screw with 1/4" hex wrench provided.



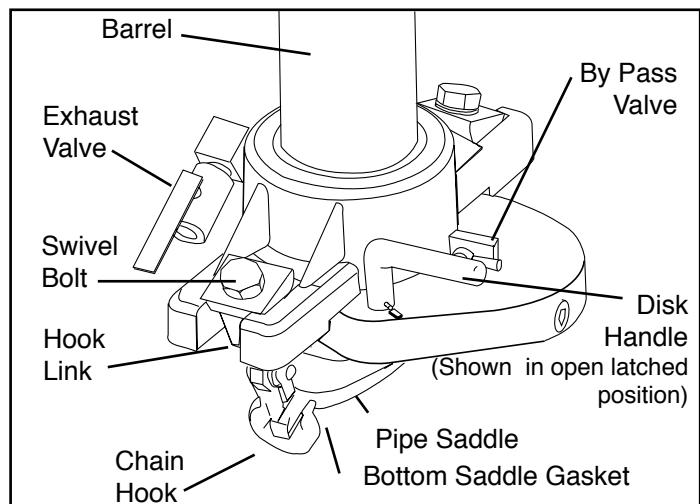
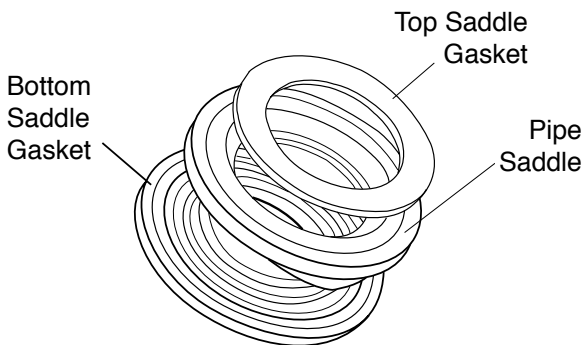
Thread the Cap on to the Barrel until it stops.
Note: Be sure the cap is tight, not just snug. You're compressing a gasket.



2 step two

MOUNT ON PIPE

Put the bottom saddle gasket, the nominal size pipe saddle, and the top saddle gasket onto the pipe.



Place the B-Too onto the saddle and loop the chain around the pipe. Tighten the chain using the swivel bolts provided. Make sure the swivel bolt and hook link are unthreaded enough to provide enough travel to tighten chain around pipe. Make sure the bottom of the slide gate is in bore of saddle. It is common now to move the machine to a 45 degree angle on the pipe.

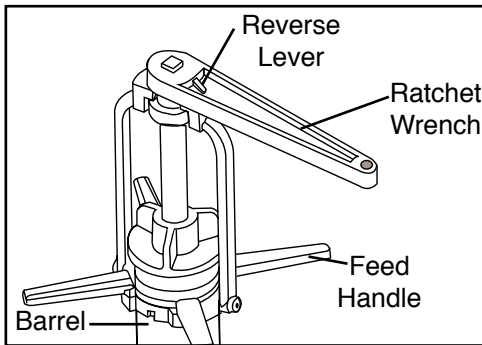
3 step three

DRILL / TAP

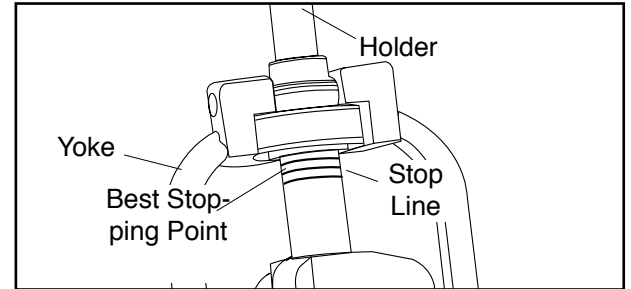
Engage yoke onto holder. Make sure the slide gate is open and if needed, in the locked position. Using the feed handle, feed the holder toward the pipe until the drill tap contacts the pipe.

Place the ratchet wrench onto the square end of the holder. Using the feed handle, alternately feed the drill tap into the pipe while turning the holder with the ratchet. Continue until the threads on the drill tap engage. When tapping starts, disengage the yoke.

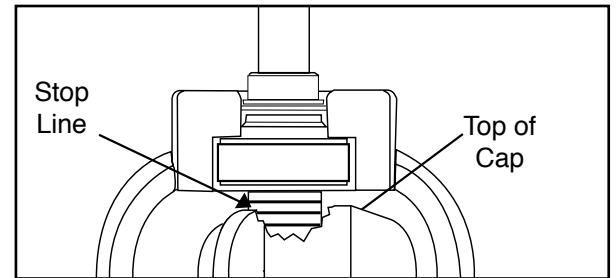
Turn the ratchet to thread the hole you've just



drilled until the stop line on the holder is aligned with the top edge of the cap. There are 2 to 3 stop lines on the holder. The second line down or the lower stop line is used generally for IP inlet threads, and the top stop line is generally used for CC inlet



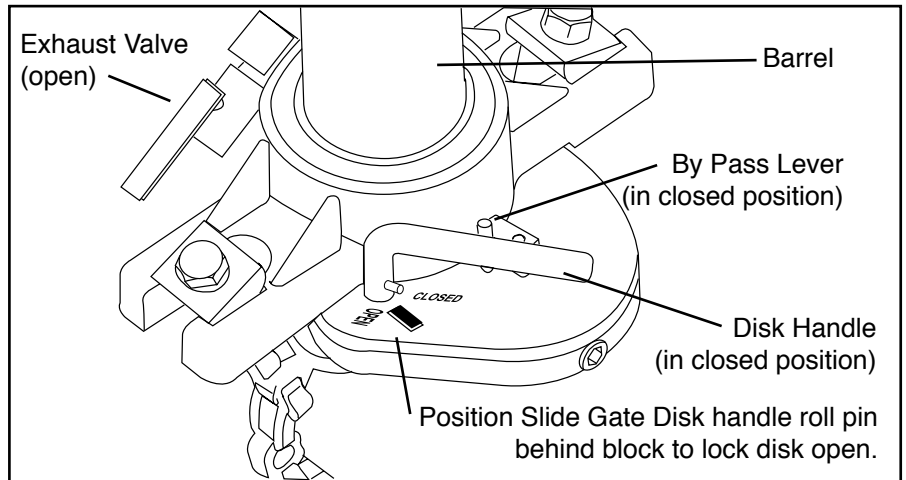
threads. We recommend threading the hole until the top of the cap is aligned between the top two grooves.



After the insertion is complete, check to see if 3 - 5 threads show between the top of the pipe and the corp body. If 3 - 5 threads are not showing, adjust your thread cutting depth.

Caution: The disk handle is designed to operate easily. Please do not apply any type of "cheater" bar to the disk handle.

Reverse the ratchet using the reverse lever on the ratchet, and back the drill tap out of the pipe. Using feed handle, feed machine back up to the top of the barrel. Close the slide gate using the disk handle. Close the by pass valve, then open the exhaust valve. Disengage the yoke from the holder, then thread cap off of the barrel. Pull the holder out of the barrel. You're now ready to load the screw plug and corporation stop.

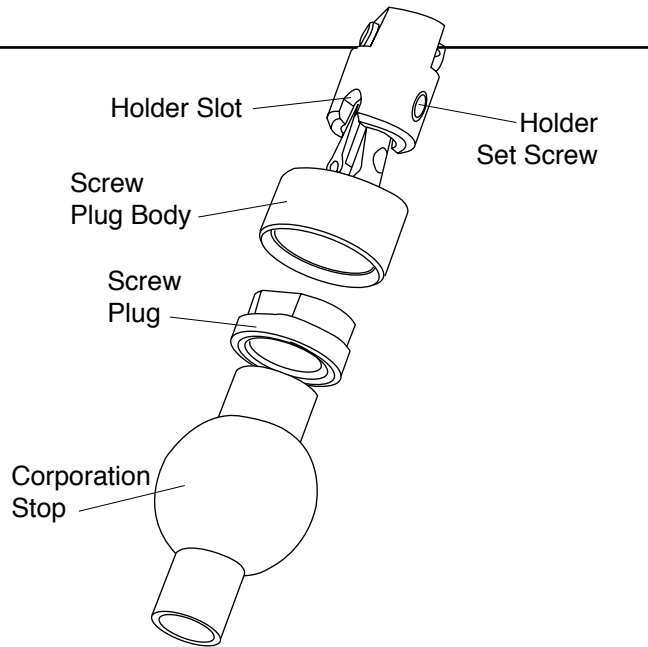


4 step four

PREPARE CORPORATION STOP FOR INSERTION

Thread the screw plug on to the outlet threads of the corporation stop. The size and type of screw plug is stamped on the back of the screw plug. Thread the screw plug body on to the screw plug. Push this assembly into the holder, align the roll pin with the slot, and tighten the set screw.

Thread the cap back on to the machine until it stops. Engage the yoke on to the holder.



A word about screw plug bodies.

The screw plug bodies are designed to fit a range of screw plugs.

Body Size	Screw Plugs that fit	Second Size that fits
1" Body	1" FC	3/4" FC
	1" FIP	3/4" FIP
	1" MIP	3/4" MIP
	1" Drive Thread	3/4" Drive Thread
	1" Mueller Thread	3/4" Mueller Thread
5/8" Body	5/8" FC	1/2" FC
	5/8" Drive Thread	1/2" FIP
		1/2" MIP
		1/2" Drive Thread
1 1/4" Body	1 1/4" FC	
	1 1/4" FIP	

5 step five

INSERT CORPORATION STOP

Close the exhaust valve. Open the by pass valve to pressurize the barrel of the B-Too. Turn the disk handle to the 'open' position.



Caution: The disk handle is designed to operate easily. Please do not apply any type of "cheater" bar to the disk

Using the feed handle thread the holder down, until the corporation stop contacts the pipe. Thread the corporation stop into the pipe tightly. Open the exhaust valve to check if the corporation stop is in place and sealing.

Reverse the ratchet and back holder up, to release the holder from the corporation stop. Remove the machine from the pipe. **It's a good idea to clean the shavings from the machine while they're still loose and easily removed.**

Using the B-Too with Transmate / Hays B1 Parts

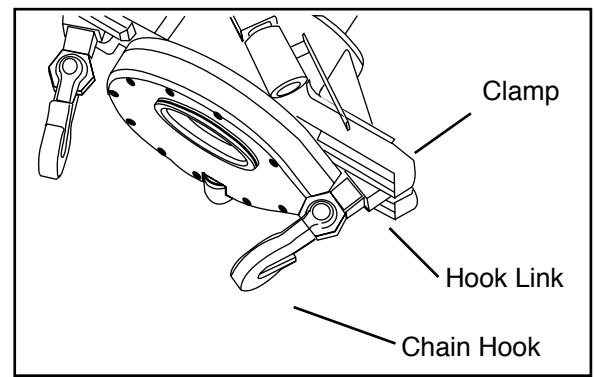
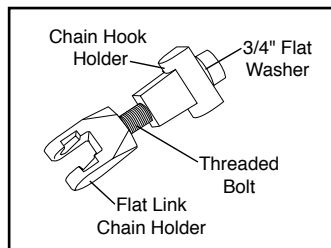
The B-Too is designed to use Transmate /Hays B1 machine, or Mueller B100 and 101 accessories. The B1 parts that can be used are: Drill taps without roll pins; B1 bottom saddle gaskets- 2",3" and 4"; B1 flat link chain. A conversion kit is also available to convert your 5/8" square large ratchet to a 13/16" square ratchet.

Drill Taps Without Roll Pins:

The B1 uses a drive stud instead of a roll pin to turn the drill tap. Our first recommendation is to press a 3/8" diameter by 1 1/2 " long roll pin into the side hole provided in the drill tap. If you want to continue to use your drill taps on your B-Too and B1 you can purchase a B1 drive stud (Part no. 353-11-515)

B1 Flat Link Chain:

The B1 flat link chain can be used with the B-Too. Remove the hook link and the chain hook from the clamp then remove the chain hook holder and put it into the assembly as shown.



Maintenance

The B-Too is easily maintained for years of service if the following instructions are followed.

Slide Gate: After each tap clean out the chips that have accumulated inside the slide gate. Ample room is provided to fit a gloved hand inside to sweep chips out. The 3/4" plug can be removed so that water can be sprayed through the hole to flush the chips out. A 3/4" ball valve can be attached to these holes for quick flushing during and after tapping.

Holder: The holder shaft should be periodically lubricated with a light oil, such as Triflow, WD 40, or grease.

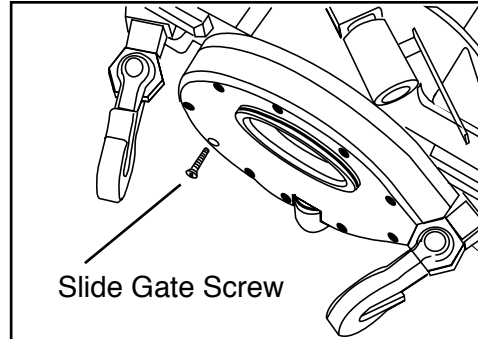
Barrel: The barrel should be kept clean and free of 'dings' and 'dents' on the threaded section.


By Pass Valve: Periodically remove the 1/16" pipe plugs from the by pass valve block and clean the holes out using a steel rod or coat hanger.

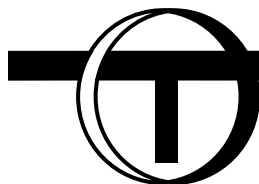
Keep it clean. Like any tool, the B-Too will work and perform better if it is kept clean and well lubricated.

To remove Slide Gate Bottom:

Place B-Too on its side and remove the 10 5/16" screws out from the bottom. Once the bottom is removed, check Slide Gate gasket for tears. Replace if necessary



 **WARNING:** This product can expose you to chemicals including lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.



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