

B-1™ DRILLING AND TAPPING MACHINE

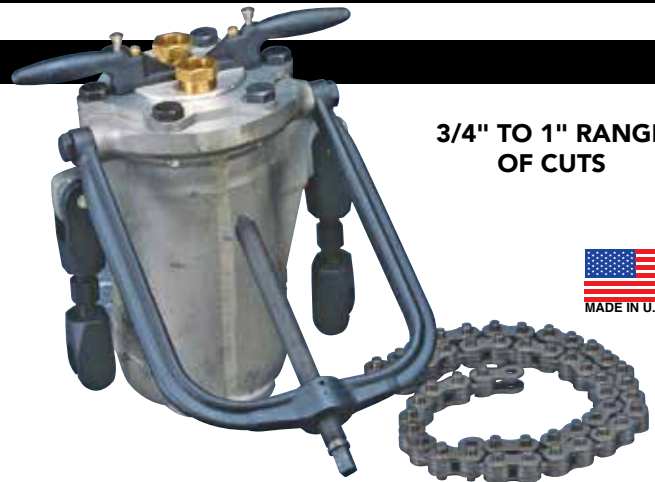


Transmate

a Division of Romac Industries, Inc.

MATERIAL SPECIFICATIONS

- Weighs approximately 32 lbs.
- Performs direct corporation stop insertion without time consuming disassembly
- Inserts any 3/4" to 1" corporation stop under pressure
- Extracts threaded corporation stops from the main and inserts a main plug
- Extracts a defective threaded corporation stop from the main and inserts a new corporation stop (3/4" size only)

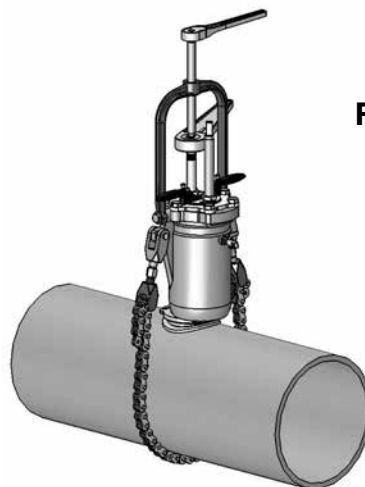


3/4" TO 1" RANGE OF CUTS



FIRST CHOICE IN THE DITCH BECAUSE THE B-1...

- Is lighter and easier to handle.
- Is faster – no disassembly and reassembly during installation.
- Has no chip problems or water loss.
- Is simpler and easier to operate, manually or with power.
- Can be preloaded under cover in foul weather.



PREFERRED BY MANAGEMENT BECAUSE THE B-1...

- Has a low maintenance cost.
- Reduces installation time to save costs.
- Lets you buy only the parts and tools required for your jobs.
- Is made of strong lightweight metal alloys which hold up under stress to provide a long service life.

TO ORDER:

1. Order B-1 Drilling Machine
2. Order Drill/Taps per desired tap size, thread type and pipe type. Drill/Tap corresponds to body inlet threads on corporation stop
3. Order Screw Plugs with threads matching the body outlet threads of the corporation stops used
4. Order a pipe saddle for each size of pipe the B-1 will be used on. NOTE: One extra chain section (Item Number 353-58) required for 14" - 24" mains, two extra chain sections required for 26" - 32" mains (join chain sections with 353-58-4).
5. Order Power Unit if desired, Ridgid 690 (373-00) and B-1 Extended Feed Yoke (353-28E)
6. Order extra Tapping Compound if needed. (see Page TM-30)

POWER OPTION NOTE:

If ordering the Ridgid 690 electric power drive unit (373-00) by itself for use with the B-1 Drilling and Tapping Machine, you must order the Extended Feed Yoke (353-28E) as well. The B-1 cannot be used under power without the Extended Feed Yoke (353-28E).

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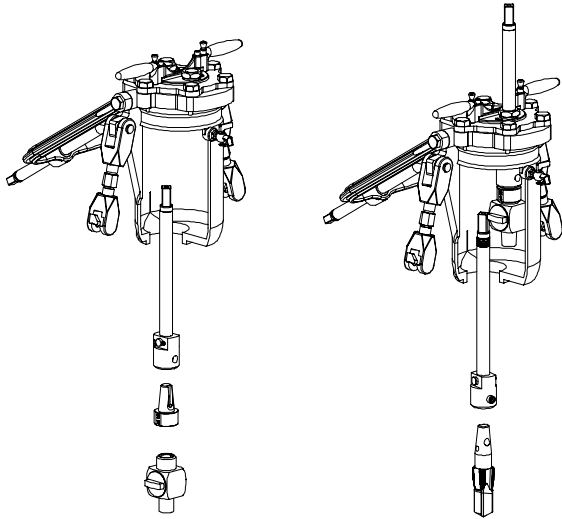
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INSTALLATION OF A CORPORATION STOP WITH PRESSURE IN THE MAIN IS COMPLETED IN THESE SIMPLE STEPS

1. LOAD THE MACHINE

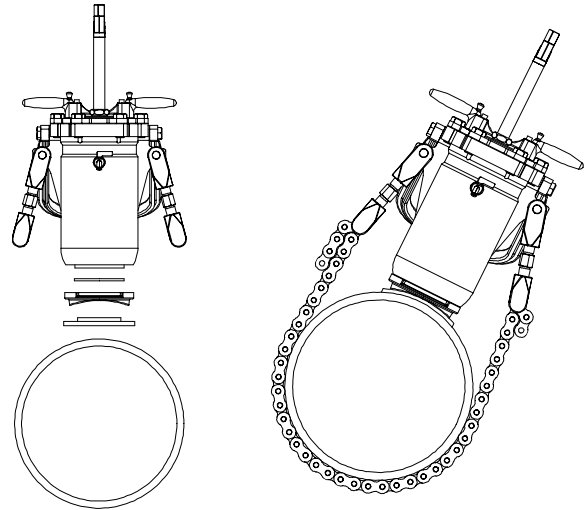


A. INSERT STOP HOLDER WITH STOP INTO MACHINE.

B. SWIVEL MACHINE HEAD 180°

C. INSERT HOLDER WITH DRILL/TAP INTO MACHINE.

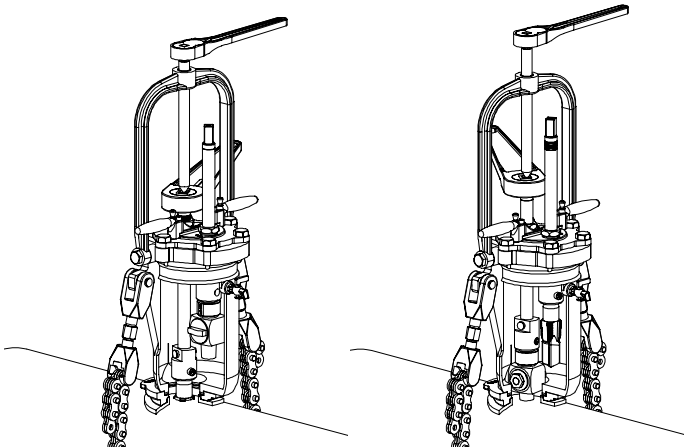
2. MOUNT MACHINE ON MAIN



A. PLACE GASKETS, SADDLE, AND MACHINE ON MAIN AND PARTIALLY TIGHTEN CHAIN.

B. POSITION MACHINE TO DESIRED ANGLE AND TIGHTEN CHAIN.

3. TAP OR DRILL AND INSERT STOP

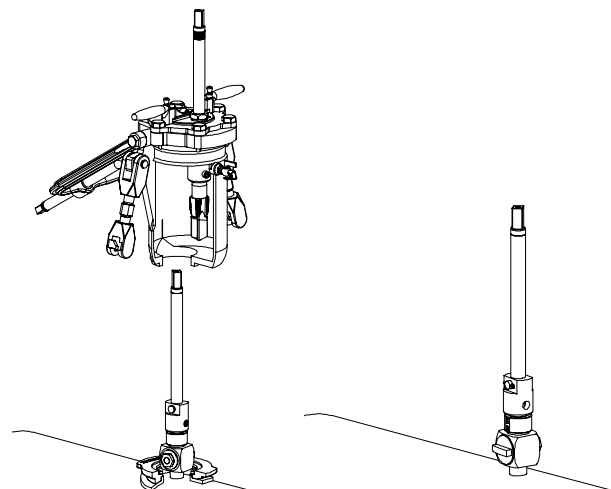


A. DRILL AND TAP PIPE WALL

B. SWIVEL MACHINE HEAD 180°

C. THREAD CORPORATION STOP INTO PIPE.

4. REMOVE MACHINE FROM MAIN



A. OPEN PET COCK TO RELEASE PRESSURE, DROP YOKE AND REMOVE CHAIN.

B. LIFT MACHINE FROM MAIN, LEAVING STOP HOLDER ON STOP

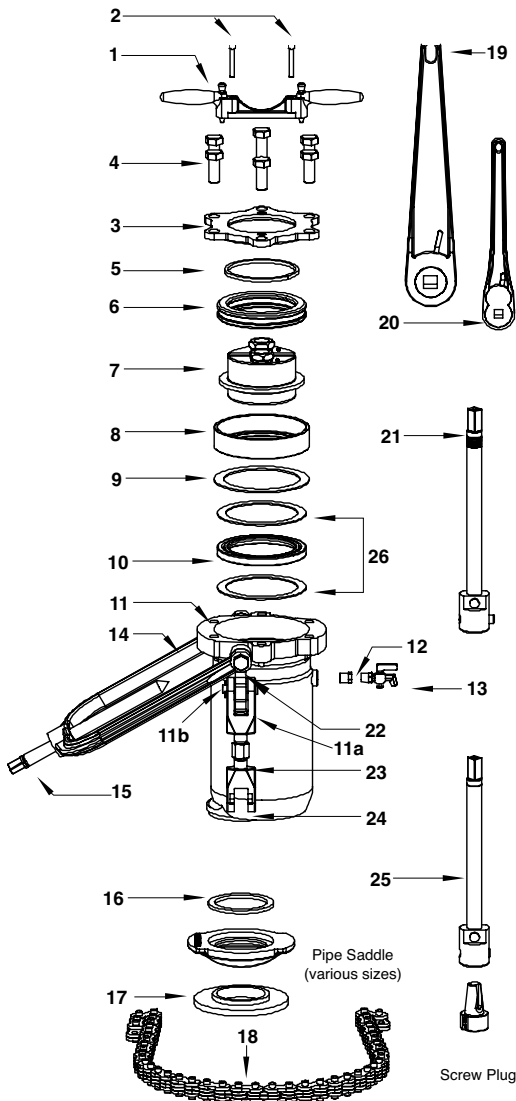
C. REMOVE STOP HOLDER WITH WRENCH PROVIDED.

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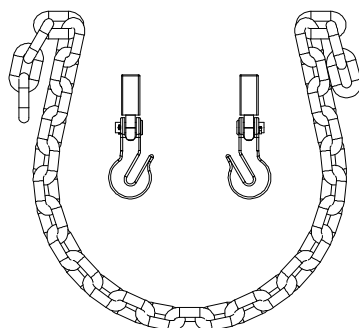
B-1 CHAIN RETROFIT KIT

353-58A.....\$310.82

INCLUDES:

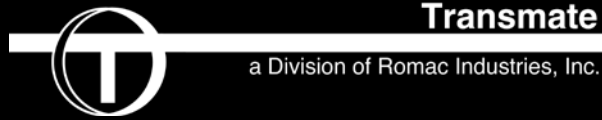
353-58-7, B-1 ROUND CHAIN HOOK ASSEMBLY (2)

356-11 B-TOO™ CHAIN, ROUND



REF. NO.	DESCRIPTION	ITEM NUMBER	LIST PRICE
B-1 Drilling and Tapping Machine			353-003 \$6,149.20
Included with B1 Machine:			
1	Handle Assembly	353-29	\$301.65
	Handle	353-29-29	168.78 ea.
	Stop Pin Knobs (2)	353-29-49	45.09 ea.
	Stop Pins (2)	353-29-501	44.79 ea.
	Stop Pin Springs (2)	353-29-55	4.35 ea.
2	Socket Head Cap Screws (2)	353-51-2	2.60
3	Aluminum Alloy Flange Assembly	353-27	261.87
	Flange	353-27-27	170.92 ea.
	Stop Pin Inserts (2)	353-27-48	42.63 ea.
4	Hex Head Cap Screws (6)	353-51-1	3.10 ea.
5	Felt Dirt Seal	353-57-4	7.48
6	Thrust Bearing	353-56	426.06
7	Aluminum Alloy Head Assembly	353-26	526.59
	Head	353-26-26	458.89
	Bronze Bushings (2)	353-26-62	26.95 ea.
	Bronze Gland Nuts (2)	353-26-39	67.46 ea.
	Gland Packings (4)	353-26-573	9.46 ea.
8	Aluminum Alloy Ring	353-59-2	165.98
9	Ring Gasket	353-57-59	14.46
10	Pressure Seal	353-57-5	87.73
11	Aluminum Alloy Body Assembly	353-23	758.95
	Body	353-23-23	607.43
11a	Clevises (2)	353-23-42	120.32
11b	Clevis Pins (2)	353-23-4250	22.83 ea.
12	Brass Iron Pipe Plug	353-65	7.48 ea.
13	Brass Pet Cock (Replaces Brass Iron Pipe Plug)	353-64	74.17
14	Feed Yoke Assembly	353-28	474.00
	Feed Yoke	353-28-28	342.62
	Threaded Insert	353-28-48	92.79
	Socket Head Set Screw	353-28-512	1.53
15	Feed Screw	353-43	234.69
16	Top Saddle Gasket	353-57-080	16.80
17	Bottom Saddle Gasket 4" and Larger	353-57-084	50.59
	2" Size (not included)	353-57-082	38.72
	3" Size (not included)	353-57-083	22.34
18	B-1 Chain	353-58	458.68
	Additional 4 ft. chain section required for 14" - 24" mains, Two additional chain sections required for 26" - 32" mains Join chain sections with 353-58-4. 6.91		
19	Ratchet Wrench (large)	353-58-4	300.22
20	Ratchet Wrench (small)	353-60-11	209.99
21	Combination Drill/Tap Holder	353-11-1	656.56
	Holder	353-11-111	594.03
	Knockout Pin	353-11-505	53.57
	Cotter Pin	353-11-506	1.53
	Drive Stud	353-11-515	44.22
	Socket Head Set Screw	353-11-514	2.32
22	Yoke Bolts	353-28-511	42.18
23	Chain Tightening Studs (2)	353-58-515	79.77 ea.
24	B-1 Chain Holder (2)	353-58-6	88.67 ea.
25	Stop Holder	353-11-2	607.76
26	Brass Rings (2)	353-59-1	37.75 ea.
<i>Following Items NOT ILLUSTRATED:</i>			
	1/4" Hex Wrench	353-60-32	5.40
	3/16" Hex Wrench	353-60-31	3.33
	7/8" Open End Wrench	353-60-21	47.43
	1-15/16" Open End Wrench	353-60-22	79.77
	Steel Chest	353-61	610.24
	Tech Lube Tapping Compound	353-10-1	33.90

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B-1™ DRILLING & TAPPING MACHINE PARTS LIST

TO ORDER:

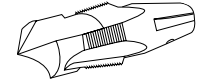
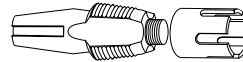
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4. Order a pipe saddle for each size of pipe the B-1 will be used on.

NOTE: One extra chain section (Item Number 353-58) required for 14" - 24" mains, two extra chain sections required for 26" - 32" mains.

5. Order Power Unit, Ridgid 600 (373-00) and the Extended Feed Yoke (353-28E) if desired.
6. Order extra Tapping Compound if needed (see Page TM-30).

**CUTTING TOOLS AND ACCESSORIES
USE FOR THREADED CORPORATION STOPS**

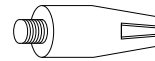
CUTTING DRILL/TAPS



355-01-210 PVC CUTTER 3/4"
353-04-206 PVC TAP 3/4" CC

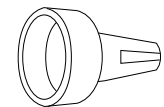
IRON PIPE THREAD OR
AWWA THREAD

353-01-206 PVC CUTTER 1"
353-04-208 PVC TAP 1" CC



DRIVE THREAD

**SCREW
PLUGS**



COMPRESSION
OR FEMALE
IRON PIPE

ITEM NUMBER	DESCRIPTION	LIST PRICE
PVC CUTTER AND TAP (requires both)		
For PVC Only		
355-01-210	Cutter, PV 3/4": 5957 (AWWA CC thread)	\$311.50
353-04-206	Tap, 3/4" PVC: 5956 (AWWA CC thread)	436.39
353-01-206	Cutter, 1" PVC: 5975-1 (AWWA CC thread)	312.24
353-04-208	Tap, 1" PVC: 5956 (AWWA CC thread)	504.54
DRILL/TAPS		
For Ductile, Cast Iron & A/C		
353-02-106	Drill/tap, 3/4" IP: 5951 (Iron Pipe thread)	457.16
353-02-108	Drill/tap, 1" IP: 5951 (Iron Pipe thread)	484.87
353-02-206	Drill/tap, 3/4" CC: 5950, 5952 (AWWA thread)	323.53
353-02-208	Drill/tap, 1" CC: 5950, 5952 (AWWA thread)	442.36
SCREW PLUGS (other thread forms available upon request)		
353-06-106	Screw Plug: 5960 (3/4" Coarse Thread Compression)	241.71
353-06-108	Screw Plug: 5960 (1" Coarse Thread Compression)	244.74
353-06-110	Screw Plug: 5960 (1 1/4" Coarse Thread Compression) ¹	322.22
353-06-306	Screw Plug: 5960-2 (3/4" Female Iron Pipe)	320.83
353-06-308	Screw Plug: 5960-2 (1" Female Iron Pipe)	329.74
353-06-406	Screw Plug: 5961 (3/4" Drive Thread)	329.74
353-06-408	Screw Plug: 5961 (1" Drive Thread)	338.64

¹ For use on 1" Corporations with 1-1/4" outlet threads.

ITEM NUMBER	DESCRIPTION	LIST PRICE
PIPE SADDLES		
353-08-016	*Pipe Saddle: 5970 (to mount B-1 on 2" pipe)	\$ 75.64
353-08-024	*Pipe Saddle: 5970 (to mount B-1 on 3" pipe)	75.64
353-08-032	Pipe Saddle: 5970 (to mount B-1 on 4" pipe)	75.64
353-08-048	Pipe Saddle: 5970 (to mount B-1 on 6" pipe)	75.64
353-08-064	Pipe Saddle: 5970 (to mount B-1 on 8" pipe)	75.64
353-08-080	Pipe Saddle: 5970 (to mount B-1 on 10" pipe)	75.64
353-08-096	Pipe Saddle: 5970 (to mount B-1 on 12" pipe)	75.64
353-08-112	Pipe Saddle: 5970 (to mount B-1 on 14" pipe)	75.64
353-08-128	Pipe Saddle: 5970 (to mount B-1 on 16" pipe)	75.64
353-08-144	Pipe Saddle: 5970 (to mount B-1 on 18" pipe)	75.64
353-08-160	Pipe Saddle: 5970 (to mount B-1 on 20" pipe)	75.64
353-08-192	Pipe Saddle: 5970 (to mount B-1 on 24" pipe)	75.64
353-08-240	Pipe Saddle: 5970 (to mount B-1 on 30" pipe)	248.02
353-08-288	Pipe Saddle: 5970 (to mount B-1 on 36" pipe)	248.02
353-08-336	Pipe Saddle: 5970 (to mount B-1 on 42" pipe)	248.02
353-08-384	Pipe Saddle: 5970 (to mount B-1 on 48" pipe)	248.02
353-08-432	Pipe Saddle: 5970 (to mount B-1 on 54" pipe)	248.02
353-08-480	Pipe Saddle: 5970 (to mount B-1 on 60" pipe)	248.02

* must order Bottom Saddle Gasket (see TM-12)

TAPPING COMPOUND		
353-10-1	Tapping Compound	33.90
353-10-3	Tapping Compound / Case (12)	390.95

POWER OPTION		
373-00	Rigid 690 Electric Drive with 5/8" sq. drive adapter (373-05-1)	3,075.52
370-70	GF-15 Ground Fault Interrupter Plug (required)	131.61
353-28E	Extended Feed Yoke (required for use)	567.54