



Transmate

B-1™ Drilling and Tapping Machine

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...

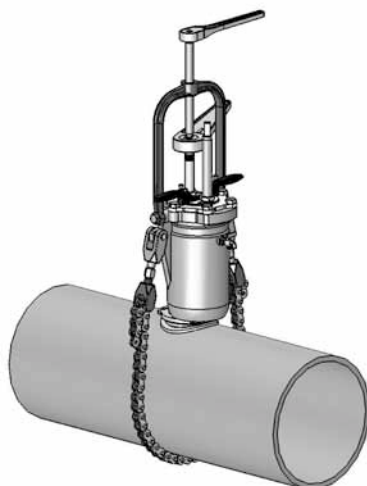
Is lighter and easier to handle.

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

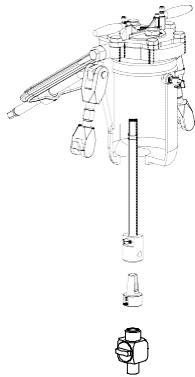
1. Order B-1 Drilling Machine
2. Order Drill/Taps per desired tap size, thread type and pipe type.
Drill/Tap corresponds to body inlet threads on corporation stop
3. Order Screw Plugs with threads matching the body outlet threads of the corporation stops used
4. Order a pipe saddle for each size of pipe 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)

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).

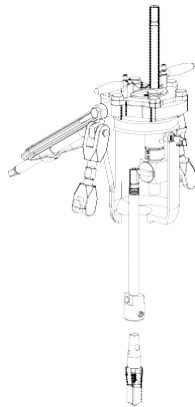


Installation of a corporation stop with pressure in the main is completed in these simple steps

1. Load the Machine



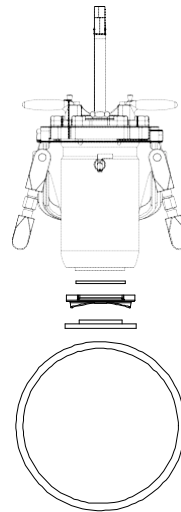
A. Insert stop holder with stop into machine.



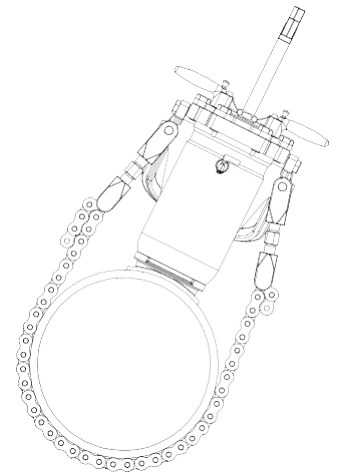
B. Swivel machine head 180°

C. Insert holder with drill/tap into machine.

2. Mount Machine on Main

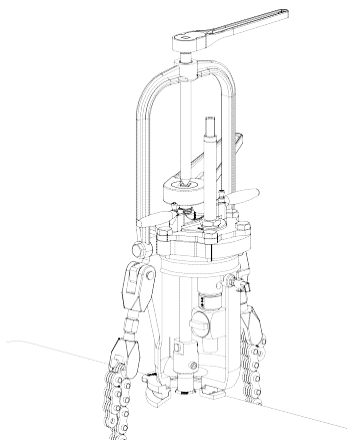


A. Place gaskets, saddle, and machine on main and partially tighten chain.

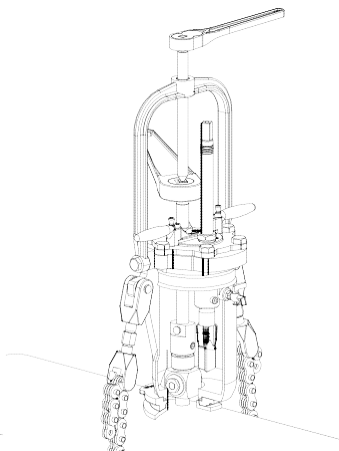


B. Position machine to desired angle and tighten chain.

3. Tap or Drill and Insert Stop



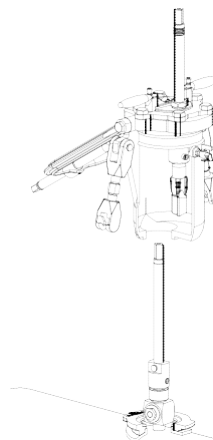
A. Drill and tap pipe wall



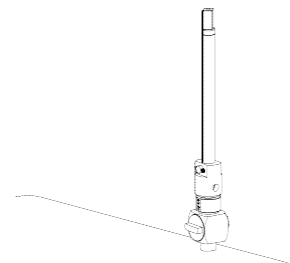
B. Swivel machine head 180°

C. Thread corporation stop into pipe.

4. Remove Machine from Main



A. Open pet cock to release pressure, drop yoke and remove chain.



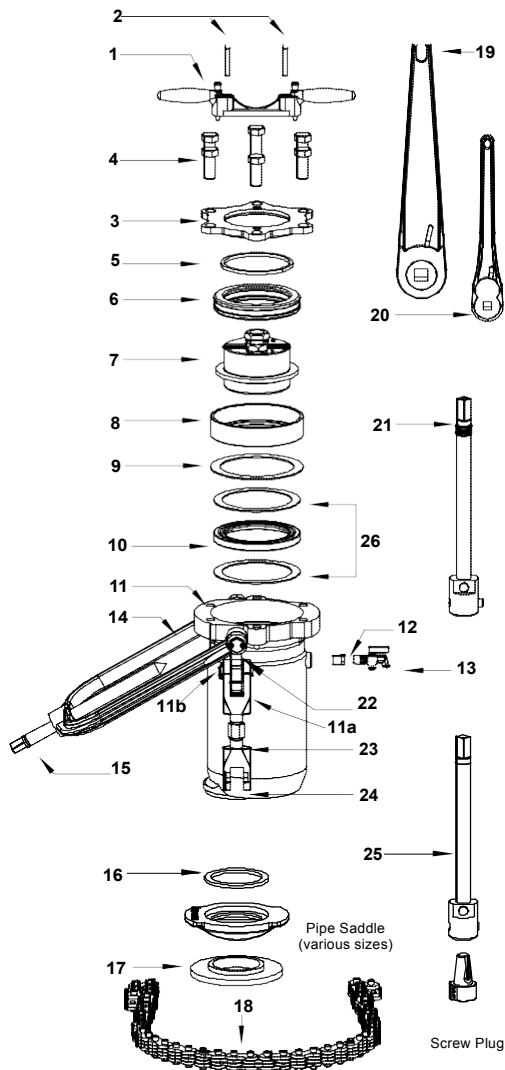
B. Lift machine from Main, leaving stop holder on stop

C. Remove stop holder with wrench provided.



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B-1™ Drilling and Tapping Machine



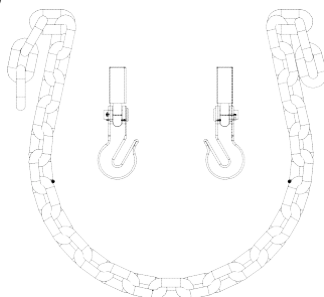
REF NO.	DESCRIPTION	ITEM NO.	LIST PRICE
B-1 Drilling and Tapping Machine			353-003
Included with B1 Machine:			\$5,746.92
1	Handle Assembly	353-29	\$281.92
	Handle	353-29-29	ea. 157.74
	Stop Pin Knobs (2)	353-29-49	ea. 42.14
	Stop Pins (2)	353-29-501	ea. 41.86
	Stop Pin Springs (2)	353-29-55	ea. 4.07
2	Socket Head Cap Screws (2)	353-51-2	2.43
3	Aluminum Alloy Flange Assembly	353-27	244.74
	Flange	353-27-27	ea. 159.74
	Stop Pin Inserts (2)	353-27-48	ea. 39.84
4	Hex Head Cap Screws (6)	353-51-1	ea. 2.90
5	Felt Dirt Seal	353-57-4	6.99
6	Thrust Bearing	353-56	398.19
7	Aluminum Alloy Head Assembly	353-26	492.14
	Head	353-26-26	428.87
	Bronze Bushings (2)	353-26-62	ea. 25.19
	Bronze Gland Nuts (2)	353-26-39	ea. 63.05
	Gland Packings (4)	353-26-573	ea. 8.84
8	Aluminum Alloy Ring	353-59-2	155.12
9	Ring Gasket	353-57-59	13.51
10	Pressure Seal	353-57-5	81.99
11	Aluminum Alloy Body Assembly	353-23	709.30
	Body	353-23-23	567.69
	11a Clevises (2)	353-23-42	ea. 112.45
	11b Clevis Pins (2)	353-23-4250	ea. 21.34
12	Brass Iron Pipe Plug	353-65	ea. 6.99
13	Brass Pet Cock (Replaces Brass Iron Pipe Plug)	353-64	69.32
14	Feed Yoke Assembly	353-28	442.99
	Feed Yoke	353-28-28	320.21
	Threaded Insert	353-28-48	86.72
	Socket Head Set Screw	353-28-512	1
15	Feed Screw	353-43	219.34
16	Top Saddle Gasket	353-57-080	15.70
17	Bottom Saddle Gasket 4" and Larger	353-57-084	47.28
	2" Size (not included)	353-57-082	36.19
	3" Size (not included)	353-57-083	20.88
18	B-1 Chain	353-58	428.67
	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.	353-58-4	6.46
19	Ratchet Wrench (large)	353-60-11	280.58
20	Ratchet Wrench (small)	353-60-12	196.25
21	Combination Drill/Tap Holder	353-11-1	613.61
	Holder	353-11-111	555.17
	Knockout Pin	353-11-505	50.07
	Cotter Pin	353-11-506	1.43
	Drive Stud	353-11-515	41.33
	Socket Head Set Screw	353-11-514	2.17
22	Yoke Bolts	353-28-511	39.42
23	Chain Tightening Studs (2)	353-58-515	ea. 74.55
24	B-1 Chain Holder (2)	353-58-6	ea. 82.87
25	Stop Holder	353-11-2	568.00
26	Brass Rings (2)	353-59-1	ea. 35.28
Following Item NOT ILLUSTRATED			
	1/4" Hex Wrench	353-60-32	5.05
	3/16" Hex Wrench	353-60-31	3.11
	7/8" Open End Wrench	353-60-21	44.33
	1-15/16" Open End Wrench	353-60-22	74.55
	Steel Chest	353-61	570.32
	Tech Lube Tapping Compound	353-10-1	31.68

NOTE: B-1 Chain Retrofit Kit

INCLUDES:

353-58-7, B-1 Round Chain Hook Assembly (2)
356-11 B-Too™ Chain, Round

353-58A \$290.49



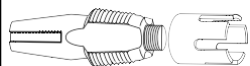


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B-1™ Drilling and Tapping Machine Parts List

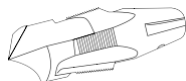
Cutting Tools and Accessories Use for Threaded Corporation Stops

Cutting Drill/Taps



355-01-210 PVC Cutter 3/4"
353-04-206 PVC Tap 3/4" CC

353-01-206 PVC Cutter 1"
353-04-208 PVC Tap 1" CC

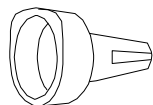


Iron pipe thread or
AWWA Thread



Drive Thread

Screw Plugs



Compression or
Female Iron Pipe

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.
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).

ITEM NUMBER	DESCRIPTION	LIST PRICE	ITEM NUMBER	DESCRIPTION	LIST PRICE
PVC Cutter and Tap (requires both)			Pipe Saddles		
For PVC only	355-01-210	Cutter, PVC 3/4": 5957 (AWWACC thread)	353-08-016	*Pipe Saddle: 5970 (to mount B-1 on 2" pipe)	\$70.69
	353-04-206	Tap, 3/4" PVC: 5956 (AWWACC thread)	353-08-024	*Pipe Saddle: 5970 (to mount B-1 on 3" pipe)	70.69
	353-01-206	Cutter, 1" PVC: 5975-1 (AWWACC thread)	353-08-032	Pipe Saddle: 5970 (to mount B-1 on 4" pipe)	70.69
	353-04-208	Tap, 1" PVC: 5956 (AWWACC thread)	353-08-048	Pipe Saddle: 5970 (to mount B-1 on 6" pipe)	70.69
For Ductile, Cast Iron & A/C	Drill/Taps		353-08-064	Pipe Saddle: 5970 (to mount B-1 on 8" pipe)	70.69
	353-02-106	Drill/tap, 3/4" IP: 5951 (Iron Pipe thread)	353-08-080	Pipe Saddle: 5970 (to mount B-1 on 10" pipe)	70.69
	353-02-108	Drill/tap, 1" IP: 5951 (Iron Pipe thread)	353-08-096	Pipe Saddle: 5970 (to mount B-1 on 12" pipe)	70.69
	353-02-206	Drill/tap, 3/4" CC: 5950, 5952 (AWWA thread)	353-08-112	Pipe Saddle: 5970 (to mount B-1 on 14" pipe)	70.69
	353-02-208	Drill/tap, 1" CC: 5950, 5952 (AWWA thread)	353-08-128	Pipe Saddle: 5970 (to mount B-1 on 16" pipe)	70.69
Screw Plugs (other thread forms available upon request)			353-08-144	Pipe Saddle: 5970 (to mount B-1 on 18" pipe)	70.69
353-06-106	Screw Plug: 5960 (3/4" Coarse Thread Compression)	225.90	353-08-160	Pipe Saddle: 5970 (to mount B-1 on 20" pipe)	70.69
353-06-108	Screw Plug: 5960 (1" Coarse Thread Compression)	228.73	353-08-192	Pipe Saddle: 5970 (to mount B-1 on 24" pipe)	70.69
353-06-110	Screw Plug: 5960 (1 1/4" Coarse Thread Compression) ¹	301.14	353-08-240	Pipe Saddle: 5970 (to mount B-1 on 30" pipe)	231.79
353-06-306	Screw Plug: 5960-2 (3/4" Female Iron Pipe)	299.84	353-08-288	Pipe Saddle: 5970 (to mount B-1 on 36" pipe)	231.79
353-06-308	Screw Plug: 5960-2 (1" Female Iron Pipe)	308.17	353-08-336	Pipe Saddle: 5970 (to mount B-1 on 42" pipe)	231.79
353-06-406	Screw Plug: 5961 (3/4" Drive Thread)	308.17	353-08-384	Pipe Saddle: 5970 (to mount B-1 on 48" pipe)	231.79
353-06-408	Screw Plug: 5961 (1" Drive Thread)	316.49	353-08-432	Pipe Saddle: 5970 (to mount B-1 on 54" pipe)	231.79
			353-08-480	Pipe Saddle: 5970 (to mount B-1 on 60" pipe)	231.79
				* must order Bottom Saddle Gasket (see TM-12)	
			Tapping Compound		
			353-10-1	Tapping Compound	31.68
			353-10-3	Tapping Compound / Case (12)	365.37
			Power Option		
			373-00	Rigid 690 Electric Drive with 5/8" sq. drive adapter (373-05-1)	2,874.32
			370-70	GF-15 Ground Fault Interrupter Plug (required)	123.00
			353-28E	Extended Feed Yoke (required for use)	530.41

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