

# 360 Tapping Machine

Sizes: 2- to 6-inch

Model 360B



T.D. Williamson

Bulletin No: 1000.004.09

Version: 01.2019

Cross Indexing No: n/a

Supersedes: 1000.004.08 (06.2018)



## Description

Tapping machines are used for making connections to pipelines, tanks, and plant piping without shutdown and are used to make hot taps in preparation for plugging machine applications.

Model 360 Tapping Machines can be either manual or hydraulically operated and are used for making tank and pipe taps from 2 in. to 6 in. Its maximum working pressure is 1,480 psi (100 bar) at 100°F (38°C). Its operating temperature is -20°F (-29°C) to 700°F (371°C) at 700 psi (48 bar) for intermittent service. Its maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar).

## Features

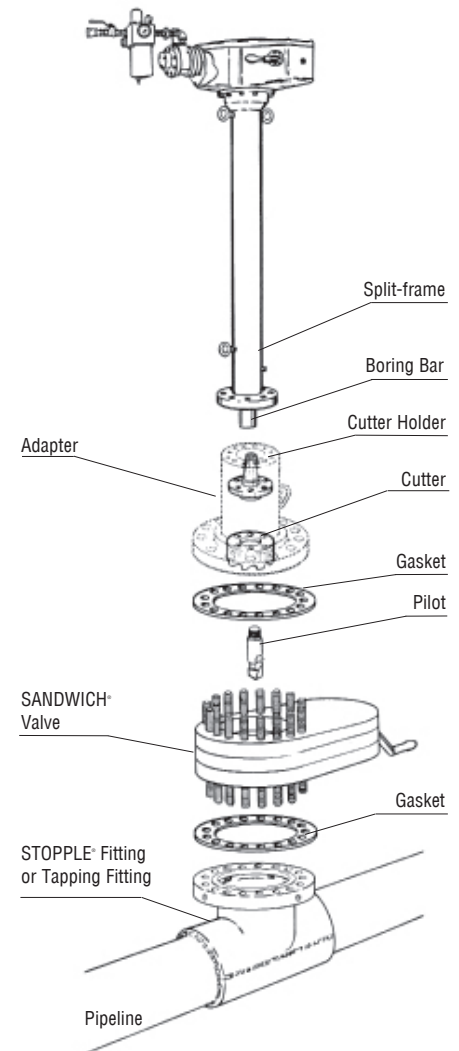
The basic machine includes:

- Lower-in crank
- Measuring rod
- Retainer rod pusher
- Ring gasket
- Bleeder valve and nipple
- Motor adapter
- Set of bolts and nuts
- LOCK-O-RING® bypass gauge
- Capability to set LOCK-O-RING® and LOCK-O-RING® Plus completion plugs

## Options

T.D. Williamson is committed to providing you with the exact product to assist you in planning, budgeting and meeting the specifications for your individual application needs. The following options are available:

- The Model 360B Tapping Machine is air or hydraulic operated.



\* For design code options not listed and additional sizes, consult your sales representative.



# 360 Tapping Machine

## Operating Specifications

Boring Bar Travel	24" (610 mm)
Tank Taps*	2" to 4" (100 DN)
Pipe Taps*	2" to 6" (150 DN)
THREAD-O-RING™ Plug Setting	2" (50 DN) and 3" (80 DN)
LOCK-O-RING® and LOCK-O-RING Plus Plug Setting	4" (100 DN) and 6" (150 DN)
Maximum Operating Pressure	1,480 psi (100 bar) at 100°F (38°C)
Maximum Operating Temperature	700°F (371°C) at 700 psi (48 bar)**
Power	Manual, Air Motor or Hydraulic
Feed Rate	0.005" (0.127 mm) per revolution
"Lower-In" Crank	12 turns per inch (2 mm per turn)
Length (without measuring rod)	42-3/4" (1,086 mm)
Length (with measuring rod)	70" (1,778 mm)
Meets NACE specification	MR0175-93

\* See note 4 in "Recommended Options" Chart.      \*\* For intermittent service only. Maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar).

## Assembly Options

Tapping Machines	Model	Type of Drive		Container		Weight
		Air Motor Drive	Hydraulic Motor Drive	Skid *	Steel Carrying Case	
Assembly Number	360b					LB (KG)
12346995	•	•				200 (91)
12346996	•	•			•	300 (136)
12346997	•	•		•		260 (118)
12346998	•		•			205 (93)
12346999	•		•		•	305 (138)
12347000	•		•	•		265 (120)

All basic Tapping Machines include: measuring rod and stop collar, bleeder valve, packing wrenches, "lower-in" crank, and power crank.

\* If skid is not purchased with tapping machine, there is special crating charge. Consult factory.

\*\* Manual Drive Tapping Machine is not compatible with an air or hydraulic drive.

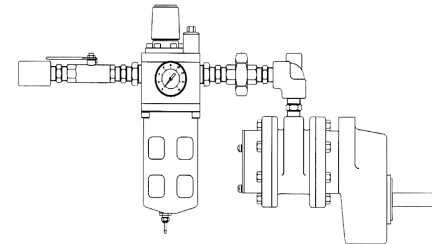


# 360 Tapping Machine

Hydraulic Power Unit and 50 ft. Hose w/Oil	Lb.	Kg.	Part Number
Manual Start/Diesel	585	266	05-2017-0000
Electric Start/Diesel	600	272	12303420
Manual Start/Gas	533	242	05-2351-0000
Electric Start/Gas	550	250	05-2354-0000

\* If skid is not purchased with the tapping machine, there will be a special crating charge; consult factory

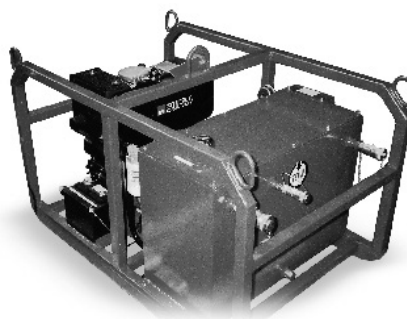
■ **Vitalizer for Air Motor**  
Minimum compressor requirement:  
105 cfm at 90 psi (6 bar).  
Compressor and connecting  
hose not included.



■ Gasoline Power Unit



■ Diesel Power Unit



## Adapters

Nominal Tap Size		ASME Class 150 RF Flange			ASME Class 300 RF Flange			ASME Class 600 RF Flange			600# SANDWICH® & Ball Valves		
Inches	DN	Part Number	Lb.	Kg.	Part Number	Lb.	Kg.	Part Number	Lb.	Kg.	Part Number	Lb.	Kg.
1	25	06-0027-0001	18	8	06-0028-0001	17	8	06-0030-0001	20	9	--	--	--
1-1/4	32	06-0027-0002	19	9	06-0028-0002	20	9	06-0030-0002	22	10	--	--	--
1-1/2	40	06-0027-0003	19	9	06-0028-0003	22	10	06-0030-0003	23	10	--	--	--
2	50	06-0027-0004	16	7	06-0028-0004	18	8	06-0030-0004	20	9	--	--	--
3	80	06-0027-0005	21	10	06-0028-0005	24	11	06-0030-0005	27	12	--	--	--
4	100	06-6098-0004*	32	15	06-6099-0004	42	19	06-6101-0004**	35	16	06-6097-0004-01***	53	24
6	150	06-6098-0006*	45	20	06-6099-0006	62	28	06-6101-0006**	100	45	06-6097-0006-01***	110	50

\* Will also work on SHORTCUTT® Valves

\*\* See special adapters for SANDWICH® & Ball valves.

\*\*\* Compatible with LOCK-O-RING® and LOCK-O-RING® Plus Plugs

## Cutter Holders & Plug Holders

Size		Cutter Holder			Plug Holders		
Inches	DN	Lb.	Kg.	Part Number	Lb.	Kg.	Part Number
2	50	--	--	--	1/2	0.2	05-0061-0001
3	80	2	9	05-0053-0003	1-1/4	0.6	05-0073-0001
4	100	2	9	05-0053-0003	--	--	--
6	150	6-1/2	3	05-0053-0002*	--	--	--

\* Cutter holder extension (P/N 05-0071-0000) required for 6 in. (150 DN) ASME Class 600 taps



# 360 Tapping Machine

## LOCK-O-RING® & LOCK-O-RING® Plus Plug Holders

Size		LOCK-O-RING® Holders			LOCK-O-RING® Plus Holders			LOCK-O-RING® Bypass Gauge		
Inches	DN	Lb.	Kg.	Part Number	Lb.	Kg.	Part Number	Lb.	Kg.	Part Number
2	50	--	--	--	--	--	--	1/2	0.2	07-1723-0000
4	100	5	2	05-0074-0000	5	2	12309297	--	--	
6	150	5	2	05-0074-0000	5	2	12309297			
4-#900	100	--	--	--	5	2	12309298	--	--	
6-#900	150	--	--	--	5	2	12309298	--	--	

## Twist Drills

Nominal Tap Size		Actual Size		Weight		Part Number
Inches	DN	Inches	mm	Lb.	Kg.	
2	50	1-7/16	37	6	3	05-0046-0004

## Insert Drills

Nominal Tap Size		Actual Size		Weight		Part Number
Inches	DN	Inches	mm	Lb.	Kg.	
1	25	3/4	19	2-1/2	1	05-0047-0001
1-1/4	32	1	25	4	2	05-0047-0002
1-1/2	40	1-1/4	32	5-1/2	3	05-0047-0003

## Standard Cutters & Pilot Drills

Nominal Tap Size		Actual Size		Cutters			Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Wt./Lb.	Wt./Kg.	Part Number	Wt./Lb.	Wt./Kg.	Part Number	Part Number
3	80	2-7/16	61.9	1	0.4	05-0001-0001	1/22	0.2	05-0293-0001	00-1424-0012
4	100	3-7/16	87.3	2	0.9	05-0328-0004	1/2	0.2	05-0293-0008	00-1424-0012
6	150	5-15/32	138.9	5-3/4	3	05-0328-0006	2	0.9	05-0293-0002	00-1424-0003

## SHORTSTOPP® Cutters & Pilot Drills

Nominal Tap Size		Actual Size		Cutters			Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Wt./Lb.	Wt./Kg.	Part Number	Wt./Lb.	Wt./Kg.	Part Number	Part Number
4	100	3-7/8	98.4	3-1/4	1	05-0330-0004	1/2	0.2	05-0293-0008	00-1424-0012
6	150	5-7/8	149.2	8-3/4	3	05-0330-0006	2	0.9	05-0293-0002	00-1424-0003

## STOPPLE® Cutters & Pilot Drills

Nominal Tap Size		Actual Size		Cutters			Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Wt./Lb.	Wt./Kg.	Part Number	Wt./Lb.	Wt./Kg.	Part Number	Part Number
4	100	3-15/16	100	3-1/2	2	05-0329-0004	1/2	0.2	05-0293-0008	00-1424-0012
6	150	5-15/16	150.8	9	4	05-0329-0006	2	0.9	05-0293-0002	00-1424-0003



# 360 Tapping Machine

## Tapping Size-On-Size (Recommended Options)

Cutter Size			
2"	3"	4"	6"
A	A	A	A
B	B	B	B
C	C	C	
D	D	D	
E	E	E	E
F	F	F	

### Notes:

- The following letters represent:  
 A = Carbon steel pipe SMYS (Specified Minimum Yield Strength) 30,000 to 50,000 psi maximum, tensile strength of 70,000 psi.  
 B = Carbon steel pipe SMYS 50,000 to 70,000 psi maximum, tensile strength of 90,000 psi.  
 C = Cast iron pipe. Cutting characteristics vary widely; hard to predict.  
 D = Chrome-moly, high temperature, steel pipe.  
 E = 300 series stainless steel pipe.  
 F = Flat-plate cuts using special cutters on the materials listed above (refer to Notes 3 and 4). Pilot drill must be through before cutter tooth engages material.
- The table for selecting power options (above) is based on the latest TDW designs and past experience. The data should be used as a guideline. There have been, and will be, conditions which will not strictly follow the guidelines.
- Special cutters are available for flat plates, stainless steel pipe, cast iron pipe and other special conditions.
- When tapping a larger pipe or tank, the cutter will sometimes go through the flat-plate condition. For example, all teeth are cutting at the same time. This is the most power-consuming condition possible and special cutters may be required. Considering cutter size, diameter of cylinder, wall thickness, feed rates, different materials of construction, etc., there are many possibilities. The following table gives some examples of flat-plate conditions. Any pipe or tank with wall thicknesses greater than those shown will also be considered flat-plate.

Cutter Size	Nom. Pipe x Wall	Nom. Pipe x Wall	Nom. Pipe x Wall
3"	4" x .359"	6" x .232"	8" x .176"
4"	6" x .481"	8" x .357"	10" x .282"
6"	10" x .748"	12" x .616"	14" x .556"

Dimensions and Part Numbers

# 360 Tapping Machine



T.D. Williamson

1000.004.09 - p6