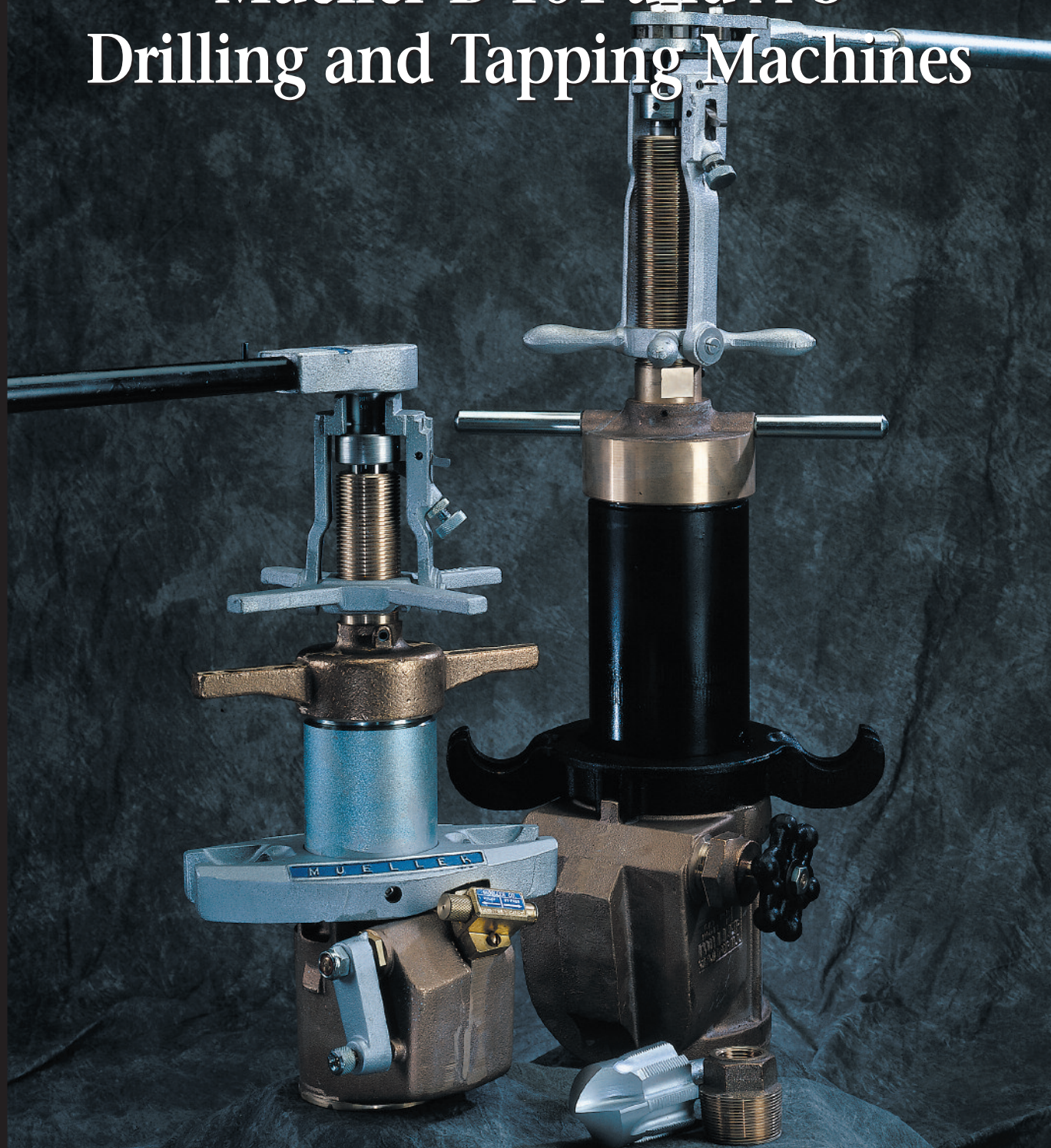


Mueller® B-101™ and A-3™ Drilling and Tapping Machines



A guide to selecting Mueller Equipment

Mueller® B-101™ and A-3™ Drilling and Tapping Machines

When it comes to line stopping and drilling and tapping technology for the gas industry, there's only one leader - Mueller. After all, we invented and patented the very first drilling and tapping machine back in 1871. It's just one of the reasons more people than ever continue to turn to us for solutions and service of unsurpassed quality and performance. They know they can count on over 140 years of innovation and reliability. They know they can count on the industry's broadest selection of products. They know they can count on Mueller.

The Mueller B-101 and A-3 Drilling and Tapping Machines are the industry standard for drilling and tapping cast iron, ductile iron, and steel gas mains from 2" to 48" in size. Both can drill and tap holes up to 2½". The No-Blo® System also allows for the removal of a coupon from the main for inspection, and insertion of a threaded plug, also while maintaining full control over the flow. Both can be power operated or manually operated.

And now, as part of the Mueller® No-Blo® System, the B-101 machine can also be used to bag off low-pressure gas mains, thanks to the new One-Tap System Launch Tube (available from Custom Service Laboratories, Inc.).

The proven Mueller No-Blo System allows two bags to be inserted, the main vented, plugged and "gassed-up" all through one tap hole - while maintaining full control over the gas flow. This enables a section of pipe to be isolated through just two tap holes in the main. The result? Less area to excavate and repave. Reduced crew time. And a savings in time and money. Plus, with no uncontrolled flow of gas, it's environmentally responsible, as well.

Now you can bag off low-pressure gas mains with confidence. With the proven Mueller No-Blo System. With the leaders in line stopping and drilling and tapping technology. Mueller Company.



B-101™ Machine Features

ANTI-FRICTION COLLAR

Fluorocarbon impregnated steel bearing sealed in a steel case. No lubrication required.

FEED NUT AND YOKE

Spring detents hold feed yoke securely in place around boring bar. Square shank on feed yoke fits power operator for automatic feed.

FEED SLEEVE AND CAP

Acme threads require only 2½ turns to remove sleeve and cap for fast disassembly. Long bearing surfaces provide exceptional boring bar rigidity. Positive metal-to-metal contact with upper barrel maintains boring bar alignment.

BORING BAR

Chrome plated to resist corrosion. Helps assure long life of O-ring seals.

TOOL HOLDING METHOD

Transmits force evenly through drive pins on tool to drill and tap pipe. Retaining screw holds tool tightly in boring bar socket for precise alignment of tool and boring bar. Convenient knock-out pin allows easy tool removal.

RATCHET HANDLE

Fully enclosed ratchet. Easily lubricated. Quick reverse button.

LOCKING MECHANISM

Secures boring bar to feed yoke to prevent drill from spiraling into pipe before hole is completely drilled. Helps prevent tool breakage.

O-RING SEALS

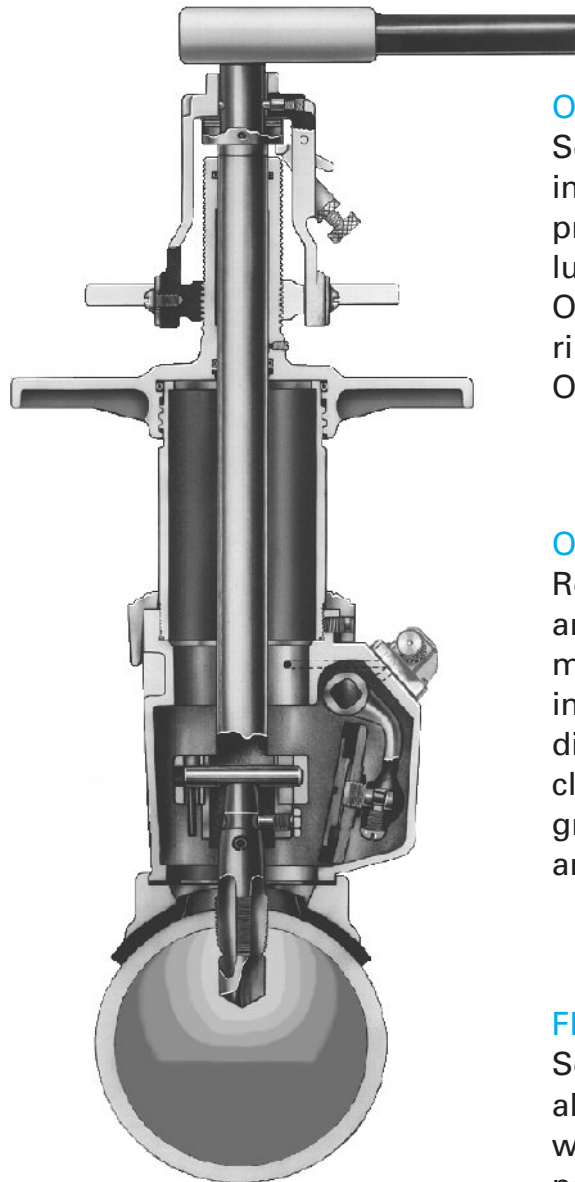
Seals off special cavity inside feed sleeve to provide oil reservoir for lubricating boring bar and O-rings. Boring bar wiper ring protects bottom O-ring.

OFFSET BODY

Reduces collection of chips around flop valve when machine is in horizontal or inclined position. Increased diameter gives adequate clearance for inserting greater variety of tees and plugs.

FLOP VALVE

Seats with pressure, self-aligning, molded neoprene washer. Lever handle has positive lock in open or closed position. Position indicator included. O-ring on flop valve stem eliminates packing adjustment.



MUELLER® B-101™ MACHINE

The B-101 combined drilling and tapping machine will drill and tap cast iron and steel gas mains from 2" - 48" in size. It will perform taps from 1/2" - 2 1/2" inclusive. The B-101 machine is power operated with an optional H-604 air motor or can be hand operated. All necessary standard tools and equipment are provided in a rugged, gray metallic carrying case.



Maximum Working Pressure

90 PSI - Without Power Clevis

250 PSI - With Power Clevis

(See "Equipment for Special Uses Section" - pg 9)

Maximum Temperature Rating

250°F

B-101 - Weight Information

Total Shipping Weight - 114 Pounds

Handling Weight During Operation

Upper Section - 19 pounds

Lower Section - 23 pounds

Equipment Furnished With Each Machine

- Ratchet Handle
- Small Saddle Gasket
- Large Saddle Gasket
- Flat Link Chain
- Chain Hooks & Nuts
- E-Z Release Wrench
- Wrench for Chain, Hooks & Nuts
- Body Cleansing Chisel
- Cutting Grease
- Metal Case
- Chain Washers

Equipment To Be Selected From Following Pages

- Saddles
- Combined Drills & Taps
- Screw Plugs
- Extracting Tools
- Equipment For Special Uses

B-101™ Machine

SCREW PLUGS, INSERTING & EXTRACTING TOOLS

Screw Plugs for Machine Inserted Valve Tees

| Type | Size | | | |
|--------------------------------|--------|--------|--------|---------|
| | 1/2" | 3/4" | 1" | 1 1/4" |
| E-Z Release Screw Plug | 680594 | 680595 | 680596 | 680628* |
| Inside I.P. Thread | | | | 680597 |
| Screw Plug Outside I.P. Thread | 680630 | 680631 | 680632 | N/A |

* Use 680628 with Machine Inserted Valve Tee



Inside Thread



Outside Thread

Extracting Tools for Tees and Valve Tees

| Type | Size | | | |
|---------------------------------------|--------|--------|--------|--------|
| | 1/2" | 3/4" | 1" | 1 1/4" |
| Extracting Tool - Inside I.P. Thread | 680618 | 680619 | 680620 | 680621 |
| Extracting Tool - Outside I.P. Thread | 680637 | 680638 | 680639 | N/A |



Inside Thread



Outside Thread

Inserting and Extracting Tools for H-10037-99004 Plugs

| Type | Size | | | | | | |
|---------------------------------------------------------------|--------|--------|--------|--------|--------|--------|--------|
| | 1/2" | 3/4" | 1" | 1 1/4" | 1 1/2" | 2" | 2 1/2" |
| Inserting Tool - Outside Thread for H-10037-99004 BRASS Plug | 680643 | 680644 | 680644 | 680644 | 680645 | 680645 | 680645 |
| Extracting Tool - Outside Thread for H-10037-99004 BRASS Plug | 680640 | 680641 | 680641 | 680641 | 680642 | 680642 | N/A |



Outside Thread

B-101™ Machine

COMBINED DRILL/SHELL CUTTER & TAPS

The following table lists the available Combined Drill/Shell Cutter & Taps for the B-101 Machine. It also gives reference to the size of pipe, size of tap and the catalog parts number for the same size combined drill and tap (CD&T).



| MACHINE | TYPE OF PIPE | SIZE OF PIPE | TAP SIZE | CD&T NUMBER | SHELL CUTTER & TAP COMPLETE NUMBER |
|---------|--------------|--------------|----------|-------------|------------------------------------|
| B-101 | Cast Iron | 4"-24" | ¾" | 680581 | NA |
| B-101 | Cast Iron | 4"-24" | 1" | 680582 | NA |
| B-101 | Cast Iron | 4"-24" | 1¼" | 681503 | 681970 |
| B-101 | Cast Iron | 4"-24" | 1½" | 681504 | 681971 |
| B-101 | Cast Iron | 4"-24" | 2" | 681505 | 681972 |
| B-101 | Cast Iron | 4"-24" | 2½" | 681506 | 681973 |
| B-101 | Steel | 4"-24" | ½" | 680569 | NA |
| B-101 | Steel | 4"-24" | ¾" | 680586 | NA |
| B-101 | Steel | 4"-24" | 1" | 680587 | NA |
| B-101 | Steel | 4"-48" | 1¼" | 681507 | 682263 |
| B-101 | Steel | 4"-48" | 1½" | 681508 | 682264 |
| B-101 | Steel | 4"-48" | 2" | 681509 | 682265 |
| B-101 | Steel | 4"-48" | 2½" | NA | 681973 |

The following table consists of a list of B-101 machine saddles for cast iron pipe. A saddle must be selected to use the B-101 machine so that the machine can be attached to the pipe. The table is broken down by part number, the maximum and minimum O.D. and nominal size of the pipe.

SADDLES FOR CAST IRON MAINS - B-101 MACHINE

| PART NUMBER | O.D. RANGE OF PIPE | | CAST IRON PIPE SIZE |
|-------------|-----------------------------------|----------------------------------|---------------------|
| | MINIMUM | MAXIMUM | |
| 75832 | 2 ¹ / ₁₆ " | 3" | 2" |
| 75810 | 3 ¹ / ₂ " | 4" | 3" |
| 75812 | 4 ³ / ₈ " | 5" | 4" |
| 75833 | 5 ¹³ / ₁₆ " | 6 ³ / ₈ " | 5" |
| 75815 | 6 ⁷ / ₁₆ " | 7 ¹ / ₈ " | 6" |
| 75817 | 8" | 9 ¹ / ₂ " | 8" |
| 40074 | 10" | 11 ⁵ / ₈ " | 10" |
| 75821 | 11" | 14 ¹ / ₂ " | 12" |
| 75835 | 14" | 17 ³ / ₈ " | 14" |
| 75836 | 16" | 19 ³ / ₈ " | 16" |
| 75837 | 17" | 21 ¹ / ₈ " | 18" |
| 75204 | 19" | 27 ¹ / ₈ " | 20" |
| 75838 | 21" | 29 ¹ / ₈ " | 24" |
| 75839 | 26" | 41" | 30" |
| 75840 | 28" | 47" | 36" |
| 75841 | 32" | 77" | 48" |



B-101™ Machine

SADDLES FOR STEEL MAINS

The following table consists of a list of B-101 machine saddles for steel pipe. A saddle must be selected to use the B-101 machine so that the machine can be attached to the pipe. The table is broken down by part number, the maximum and minimum O.D. and nominal size of the pipe.

SADDLES FOR STEEL MAINS - B-101 MACHINE

| PART NUMBER | O.D. RANGE OF PIPE | | STEEL PIPE SIZE |
|-------------|--------------------|---------|-----------------|
| | MINIMUM | MAXIMUM | |
| 75808 | 2¼" | 2⅞" | 2" |
| 75809 | 2⅝" | 3⅛" | 2½" |
| 75810 | 3½" | 4" | 3" |
| 75811 | 4" | 4⅝" | 3½" |
| 75812 | 4¾" | 5" | 4" |
| 75833 | 5 13/16" | 6¾" | 5" |
| 75815 | 6 7/16" | 7⅛" | 6" |
| 75817 | 8" | 9½" | 8" |
| 75819 | 9½" | 12¼" | 10" |
| 75820 | 10⅝" | 13⅛" | 12" |
| 75821 | 11" | 14½" | 14" |
| 75835 | 14" | 17¾" | 16" |
| 75836 | 16" | 19¾" | 18" |
| 75837 | 17" | 21⅞" | 20" |
| 75204 | 19" | 27⅞" | 24" |
| 75839 | 26" | 41" | 30" |
| 75840 | 28" | 47" | 36" |



Listed below is "Equipment for Special Uses" for the B-101 machine. This is optional equipment and must be ordered separately.

PART NUMBER

500684 - RATCHET HANDLE EXTENSION

Extends length of ratchet handle to give more leverage when hand opening.



H-10802- POWER CLEVIS

Allows the maximum pressure rating of the B-101 machine to be increased to 250 PSI.



40321 - CHAIN SPREADER

Used when tapping pipe 3" or smaller to spread the chain so that it will clear the lower edge of the body of the machine.



580550- FLAT LINK CHAIN HOOK WITH NUT



580551- FLAT LINK CHAIN AND EYEBOLT WITH NUT

For pipe up to 12"



Flat link chain with eye bolt and nut

89059- 4 FT. FLAT LINK EXTENSION CHAIN

Increases 12" chain to fit 12" - 24" pipe.

88126- 6 FT. FLAT LINK EXTENSION CHAIN

Increases 12" chain to fit 12" - 36" pipe.

88127- 10 FT. FLAT LINK EXTENSION CHAIN

Increases 12" chain to fit 12" - 48" pipe.



Flat link chain extension with bolts and nuts

MUELLER® A-3™ MACHINE

The A-3 combined drilling and tapping machine will drill and tap cast iron and steel gas mains from 4" - 48" in size. It will perform taps from 1" - 2½" inclusive. The A-3 machine is power operated with an optional H-604 air motor or can be hand operated. All necessary standard tools and equipment are provided in a rugged, wooden carrying case.



Maximum Working Pressure

90 PSI - Without Power Clevis

250 PSI - With Power Clevis

(See "Equipment for Special Uses Section" - pg 15)

Maximum Temperature Rating

250°F

A-3 - Weight Information

Total Shipping Weight - 188 Pounds

Handling Weight During Operation

Upper Section - 40 pounds

Lower Section - 58 pounds

Equipment Furnished With Each Machine

Ratchet Handle

Small Saddle Gasket

Large Saddle Gasket

Flat Link Chain

Chain Hooks & Nuts

Wrench for Chain, Hooks & Nuts

Body Cleansing Chisel

Cutting Grease

Stuffing Nut Spanner Wrench

Chain Washers

Equipment To Be Selected From Following Pages

Saddles

Combined Drills & Taps

Screw Plugs

Extracting Tools

Equipment For Special Uses

Screw Plugs for Machine Inserted Valve Tees

| Type | Size | | | | |
|--------------------------------|--------|---------|-------|-------|-------|
| | 1" | 1¼" | 1½" | 2" | 2½" |
| E-Z Release Screw Plug | 690596 | 680628* | 83065 | 83066 | 83157 |
| Inside I.P. Thread | | 680597 | | | |
| Screw Plug Outside I.P. Thread | 680632 | 61212 | 61213 | 61214 | N/A |

* Use 680628 with Machine Inserted Valve Tee



Inside Thread



Outside Thread

Extracting Tools for Tees and Valve Tees

| Type | Size | | | | |
|---------------------------------------|--------|--------|-------|-------|-----|
| | 1" | 1¼" | 1½" | 2" | 2½" |
| Extracting Tool - Inside I.P. Thread | 680620 | 680621 | 83179 | 83180 | N/A |
| Extracting Tool - Outside I.P. Thread | 680639 | N/A | N/A | N/A | N/A |



Inside Thread



Outside Thread

Inserting and Extracting Tools for H-10037 Plugs

| Type | Size | | | | |
|---------------------------------------------------|--------|--------|--------|--------|--------|
| | 1" | 1¼" | 1½" | 2" | 2½" |
| Inserting Tool - Outside Thread for H-10037 Plug | 680644 | 680644 | 680645 | 680645 | 680645 |
| Extracting Tool - Outside Thread for H-10037 Plug | 680641 | 680641 | 680642 | 680642 | N/A |



Outside Thread

A-3™ Machine

COMBINED DRILL/SHELL CUTTER & TAPS

The following table lists the available Combined Drill/Shell Cutter & Taps for the A-3 Machine. It also gives reference to the size of pipe, size of tap and the previous catalog part number for the same size combined drill and tap (CD&T).



| MACHINE | TYPE OF PIPE | SIZE OF PIPE | TAP SIZE | CD&T NUMBER | SHELL CUTTER & TAP COMPLETE NUMBER |
|---------|--------------|--------------|----------|-------------|------------------------------------|
| A-3 | Cast Iron | 4"-24" | ¾" | 680581 | NA |
| A-3 | Cast Iron | 4"-24" | 1" | 680582 | NA |
| A-3 | Cast Iron | 4"-24" | 1¼" | 681503 | 681970 |
| A-3 | Cast Iron | 4"-24" | 1½" | 681504 | 681971 |
| A-3 | Cast Iron | 4"-24" | 2" | 681505 | 681972 |
| A-3 | Cast Iron | 4"-24" | 2½" | 681506 | 681973 |
| A-3 | Steel | 4"-24" | ½" | 680569 | NA |
| A-3 | Steel | 4"-24" | ¾" | 680586 | NA |
| A-3 | Steel | 4"-24" | 1" | 680587 | NA |
| A-3 | Steel | 4"-48" | 1¼" | 681507 | 682263 |
| A-3 | Steel | 4"-48" | 1½" | 681508 | 682264 |
| A-3 | Steel | 4"-48" | 2" | 681509 | 682265 |
| A-3 | Steel | 4"-48" | 2½" | NA | 681973 |

The following table consists of a list of A-3 machine saddles for cast iron pipe. A saddle must be selected to use the A-3 machine so that the machine can be attached to the pipe. The table is broken down by part number, the maximum and minimum O.D. and nominal size of the pipe.

SADDLES FOR CAST IRON MAINS - A-3 MACHINE

| PART NUMBER | O.D. RANGE OF PIPE | | CAST IRON PIPE SIZE |
|-------------|----------------------------------|----------------------------------|---------------------|
| | MINIMUM | MAXIMUM | |
| 75906 | — | 5" | 4" |
| 75908 | 6 ⁹ / ₁₆ " | 7 ¹ / ₈ " | 6" |
| 75909 | 8 ⁷ / ₈ " | 9 ³ / ₈ " | 8" |
| 75910 | 10 ¹ / ₈ " | 11 ¹ / ₄ " | 10" |
| 40236 | 11 ⁷ / ₈ " | 13 ¹ / ₂ " | 12" |
| 75911 | 14 ¹ / ₈ " | 16 ¹ / ₄ " | 14" |
| 40238 | 16" | 18 ³ / ₄ " | 16" |
| 75831 | 17 ³ / ₄ " | 20 ¹ / ₂ " | 18" |
| 40240 | 18 ¹ / ₈ " | 22 ³ / ₄ " | 20" |
| 40241 | 22 ¹ / ₂ " | 27 ¹ / ₂ " | 24" |
| 75912 | 25 ³ / ₄ " | 35" | 30" |
| 75913 | 30 ¹ / ₈ " | 43" | 36" |
| 76701 | 31 ¹ / ₄ " | 45" | 40" |
| 59582 | 34" | 51" | 42" |
| 75914 | 34" | 58" | 48" |



A-3™ Machine

SADDLES FOR STEEL MAINS

The following table consists of a list of A-3 machine saddles for steel pipe. A saddle must be selected to use the A-3 machine so that the machine can be attached to the pipe. The table is broken down by part number, the maximum and minimum O.D. and nominal size of the pipe.

SADDLES FOR STEEL MAINS - A-3 MACHINE

| PART NUMBER | O.D. RANGE OF PIPE | | STEEL PIPE SIZE |
|-------------|----------------------------------|----------------------------------|-----------------|
| | MINIMUM | MAXIMUM | |
| 75906 | – | 5" | 4" |
| 46703 | 6" | 6 ⁵ / ₈ " | 6" |
| 45384 | 8" | 8 ⁵ / ₈ " | 8" |
| 43294 | 10" | 10 ³ / ₄ " | 10" |
| 40236 | 11 ⁷ / ₈ " | 13 ¹ / ₂ " | 12" |
| 75911 | 14 ¹ / ₈ " | 16 ¹ / ₄ " | 16" |
| 40238 | 16" | 18 ³ / ₄ " | 18" |
| 75831 | 17 ³ / ₄ " | 20 ¹ / ₂ " | 20" |
| 40241 | 22 ¹ / ₂ " | 27 ¹ / ₂ " | 24" |
| 75912 | 25 ³ / ₄ " | 35" | 30" |
| 75913 | 30 ¹ / ₈ " | 43" | 36" |



Listed below is "Equipment for Special Uses" for the A-3 machine. This is optional equipment and must be ordered separately.

PART NUMBER

H-10800 - POWER CLEVIS

Allows the maximum pressure rating of the A-3 machine to be increased to 200 PSI.



40321 - CHAIN SPREADER

Used when tapping pipe 6" or smaller to spread the chain so that it will clear the lower edge of the body of the machine.



82314 - 2'4" EXTENSION CHAIN

Increases 16" chain to fit 16" - 24" pipe.

81028 - 5'4" EXTENSION CHAIN

Increases 16" chain to fit 16" - 36" pipe.

81029 - 8'2" EXTENSION CHAIN

Increases 16" chain to fit 16" - 48" pipe.



Flat link chain extension with bolts and nuts



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All products must be installed and maintained in accordance with applicable instructions and/or standards.