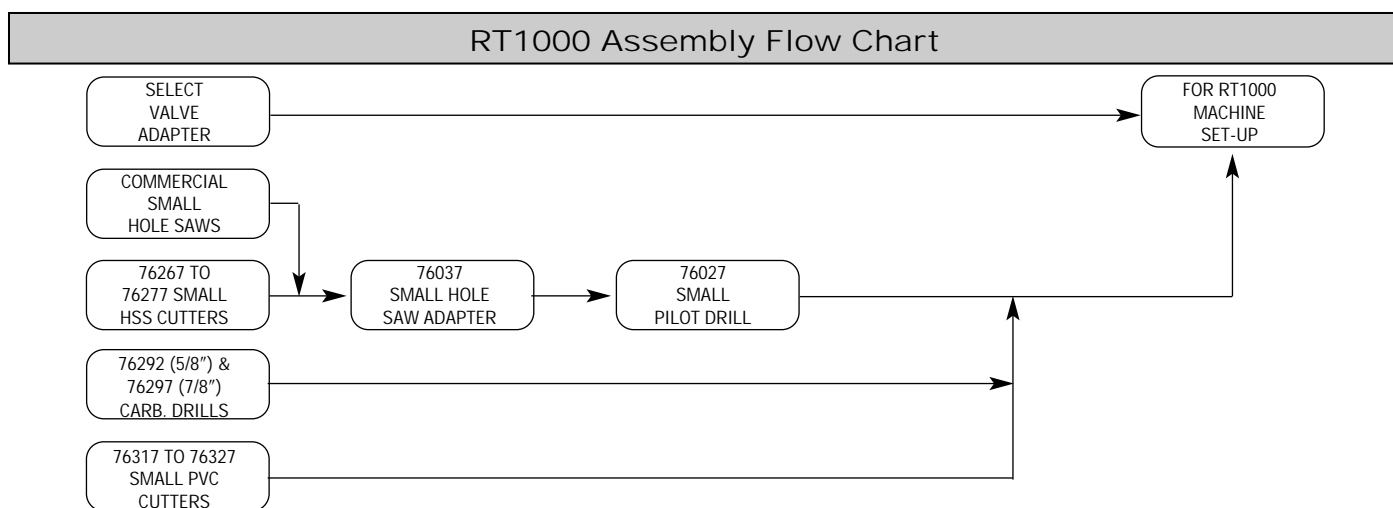


Valve Adapter Selection										
Valve Size	Bore Size	CTS Adapter	NPT Female Adapter	NPT Male Adapter	BSPT Female Adapter	BSPT Male Adapter	M#110 Female Adapter	Pilot Size	Saw Adapter	Remarks
3/4"	0.625 0.688	83317	83332	83337	84437	84432	83327	0.250	0.250	Preferred Configuration
1"	0.750 0.813 0.875 0.938	83322	83342	83347	84447	84442	83572	0.250	76037	Preferred Configuration



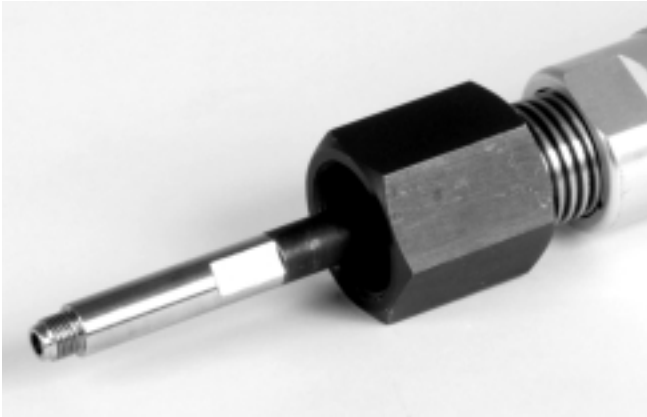
**Tapping Tool is required. The following procedure should be followed to assemble this tool:**

1. Select the correct valve adapter, pilot drill, extension, and saw adapter from the Valve Adapter Chart (*Chart 1*). The Flow Chart (*Chart 2*) will assist in determining the required equipment to perform the tap.
2. Extend the tool by turning the sleeve counter-clockwise.
3. Inspect the o-ring seal in the valve adapter and replace if necessary.
4. Holding the bronze feed screw by the flats, hand-assemble the valve adapter onto the bronze feed screw. Operator will feel first the seal engaging and then feel the adapter reach an abrupt stop as the bronze feed screw "bottoms out" in the valve adapter (*Figure 1*). Collapse the tool by turning the sleeve clockwise.



**Figure 1 – Assembling Valve Adapter Onto Feed Screw**

5. Select cutter from Chart 3. The pilot drill and hole saw adapter may not be required depending on the actual cutter selected. If the selected cutter requires the hole saw adapter, screw it into the end of the extension hand-tight (*Figure 2*).



**Figure 2 – Assembling Hole Saw Adapter**

#### RIDGID Tapping Tool Cutter Selection Chart

Bore Size	Fractional Size (Inches)	RIDGID Bi-Metal Hole Saw	RIDGID Steel Cutter	RIDGID CI/DI Drill	RIDGID PVC Cutter
0.625	5/8	M16-R10	76267	76292	76317
0.688	11/16	M17-R11			
0.750	3/4	M19-R12			
0.813	13/16	M21-R13			
0.875	7/8	M22-R14	76272	76297	76322

**Chart 3 – Cutter Selection Chart**

6. Inspect the selected cutter to ensure that it is in good working order and hand-screw it into the hole saw adapter or directly into the tool's spindle as required (*Figure 3*).



**Figure 3 – Assembling Cutter**

7. Inspect the selected pilot drill to ensure that it is in good working order. The purpose of the pilot drill is to capture the slug when using a hole saw or steel cutter. Pay attention to the coupon retention device, as the coupon may not be captured if the device is damaged.

**NOTE!** Do not use pilot drill with PVC cutters or the CI/DI drills.

8. Insert this pilot drill into the hole saw adapter. Secure the pilot drill in place with the set screw positioned on the flat of the pilot and firmly tighten (*Figure 4*).



**Figure 4 – Installation Of Pilot Drill**

9. Attach the selected service saddle to the main in accordance with the manufacturer's specifications or weld the selected "Thread-O-Let™" or "Weld-O-Let™" to the main in accordance with all applicable welding standards.
10. Apply pipe sealant to the threads on the "corporation stop" or valve and tightly thread it into the saddle or "Thread-O-Let™". Ensure the valve is in the CLOSED position.

#### Determining Feasibility Of The Tap

**⚠ WARNING** Improper measurement may result in tapping through the bottom of the pipe. To prevent extensive property and environmental damage, fire and/or serious injury, follow this procedure to determine if the tap has been properly planned.

1. Measure the distance from the datum of the valve adapter rear face to the end of the sleeve. As shown in *Figure 5* it should be about 1/8".