

FAQ

B-100/B-101 Machine

Q: “The Gate assembly does not open completely.”

A: Check the body offset (where gate sits when fully open) to see if pipe chips and cutting grease has accumulated. If this is the problem, use the body cleaning Chisel (part # 40050) to remove the build up of chips and grease.

Q: “My combined drill and tap and inserting tool shanks do not fit properly in the boring bar.”

A: Make sure the knock out pin (part #500693) is moved into the correct position to allow full insertion of the shank.

Check the tool retaining screw (part #500694) to make sure the “bullet nose” on this screw is not damaged or broken off.

If the tool retaining screw is damaged, also check the inside of the boring bar for damage or “scoring”.

Q: “Can I use a B-101 boring bar in my B-100 machine?”

A: Yes, but you will need to use the B-101 friction collar (part #580610) and you will need to change out the feed nut and yoke to the B-101 style (part #580611).

Q: “My by-pass relief valve is not working.”

A: Some pipe chips or cutting grease is probably blocking the by-pass/relief valve or the machined “channels” in the body leading to the valve.

To clean the channels, remove the by-pass valve and use a small wire to push the blockage out of the channels. The by-pass relief valve should be cleaned as well. Re-attach the by-pass valve.

Q: “I cannot get the gate washer to seal.”

A: Check the body (part# 502046) sealing surface and the gate washer (part #500673) to make sure there are no “nicks” or “dings” or damage. Should damage be found, replace the damaged part.

The gate assembly may be out of adjustment. To check this, apply a thin coating of cutting grease to the gate washer and close the gate. Open the gate and check the impression to see if the gate washer is sealing 360°. If a 360° seal pattern is not seen, adjust the brass gate arm by gently bending it up, down or side to side to achieve a 360° seal pattern.

Check the gate assembly to make sure it spins and “pivots” in the gate arm. If the gate assembly is “locked-up” and does not spin or pivot, remove the gate lock screw (part #500675) and check the end of this screw to make sure it has a non-threaded machined end to allow the gate assembly to spin and pivot (wobble) as this is a self adjusting feature to assure a proper seal.

Q: “I cannot get the body to seal on the small saddle gasket and I have replaced the small saddle gasket.”

A: Check the bottom of the body for damage. If the surface is warped or damaged, replace the body (part #502046).

Q: “The machine is requiring more torque to operate. What can I do?”

A: Check your combined drill and tap or combined shell cutter and taps to make sure the cutting edges are sharp and your tools are not missing any tapping teeth. Replace the combined drill and tap if worn or damaged.

A: Check the friction collar (part #580610) to make sure the top and bottom bearings rotate freely. If the top and bottom bearings do not rotate freely, replace the friction collar and check the underside of feed yoke for damage. Replace the feed yoke (580611) if damaged. Check threads on the feed sleeve and cap (500685) for wear and replace if necessary.

Q: “When should I use a combined shell cutter and tap instead of a combined drill and tap?”

A: Use a combined shell cutter & tap (CSC&T) when customer is concerned about the amount of chips a CD&T will generate on 1-1/4” thru 2-1/2” taps. The combined shell cutter and tap will produce fewer pipe chips than a combined drill and tap. The combined shell cutter and tap will remove a coupon of pipe instead of turning it into chips.

The customer may also require a CSC&T so they can inspect the coupon to determine the condition of the interior of the pipe at the point of tap.

Q: “I am having trouble producing good threads in the pipe during the tapping operation.”

A: Several operational errors can cause improper threads.

A: When tapping ductile or cast iron, the tapping line on the boring bar should be flush with the top of the feed sleeve to assure proper thread depth. Traveling past this point could produce an oversized hole. Stopping short of this point can cause an undersized hole.

A: The feed nut and yoke should not be used to force the boring bar down during the entire thread-tapping portion of installation. This can deform the threads. The feed nut and yoke should be used only to catch a couple of C D & T threads in the main.

A: Make sure the CD&T or CSC&T thread matches the corporation stop inlet thread, “cc” or “ip” threads and correct size.

Call Mueller Customer Service (800-423-1323) if you have any questions.

Q: “When do I use the Power Clevis?”

A: The power clevis is used to control the boring bar movement when working at line pressures above 90 psi.

Note: Operating instruction manual for the B-101 Machine (Form 8910) is available by contacting MUELLER Customer Service Dept. at 1-800-423-1323 or can be downloaded on line at www.muellercompany.com.

MUELLER CO. offers a repair and sharpening service for the B-100/B-101 Machines and cutting equipment. Contact your local distributor for pricing and details.