

FAQ

C1-36/C1-36-99002 Machine

Q: “What is the difference between the C1-36 and C1-36-99002 machines?”

A: The C1-36-99002 Machine has an eight (8) thread per inch feed screw and the C1-36 Machine has a six (6) thread per inch feed screw.

This means the C1-36-99002 machine boring bar will advance slower than the C1-36. This is important when making cuts over 12” in size. The slower feed allows the C1-36-99002 to make cuts through 14” to 24” valves.

Q: “What type of oil do I use in the C1 machines?”

A: Model three (3) and earlier, use MUELLER lubricant part number 580685 (Amovis 5x). Model four (4) and newer, use MUELLER lubricant part number 89347 (EP220 Permagear, non-foaming).

The machine should be horizontal with the plugs at the top when being filled.

The front (flange end that attaches to the drilling machine adapter) gear case requires four (4) pints of lubricant and the rear gear case requires 1.6 pints of lubricant. These two gear cases are not connected and must be filled separately. **DO NOT OVERFILL.**

To check oil, the machine should be horizontal with the plugs 90° from the top and oil should be even with the bottom of the plughole.

Q: “How often should I change the oil in my C1 Machine?”

A: A new machine should have its first oil change after ten hours of operation and after each fifty hours of operation thereafter.

Q: “The travel indicator is not working. How do I fix it?”

A: The indicator wheel set screw has probably loosened allowing the wheel to slip on the indicator shaft. With the boring bar retracted fully, remove the cover plate (54446) from the indicator body and rotate the indicator shaft until the indicator arrow is set to zero. Tighten the wheel set screw to secure the wheel to the indicator shaft and replace the cover plate and indicator knob. If the set screw loosens again, repeat procedure and put a thread locking compound on the screw.

Note: The wheel set screw can loosen if the C1 Machine Boring Bar is retracted under power with the MUELLER H-600 or H-601 Air Power Operators and the power operator continues the run in reverse after the boring bar reaches its rear most position.

Q: “Which MUELLER shell cutters do I use to cut plastic pipe?”

A: A line of shell cutters and pilot shells are made specifically for cutting plastic pipe (IPS PVC, CI OD PVC and PE pipe). These cutters and pilot shells will retain almost all of the chips generated during the cut.

A: The carbide tipped shell cutters can also be used to cut plastic mains, but these cutters will generate a lot more plastic chips. Check ID of pipe and shell cutter O. D. to make sure coupon will be retained.

Contact your MUELLER Distributor or check your catalog for details.

Q: “Can I use the C1 Machine on steam lines?”

A: No. The C1 Machines are for water or natural gas service only.

The C1 Machines can be used on pipe containing different types of fluids but you Must contact MUELLER CO. (800-423-1323) for compatibility before using the C1 Machines on pipes containing fluids other than potable water or natural gas.

Q: “I cannot retract the boring bar of my C1 Machine. What happened and how do I fix it?”

A: If your machine was manufactured or repaired by MUELLER CO. in 1995 or later, you have an over travel feature which activates when you extend the boring bar out past the limit line on the boring bar.

This over travel feature allows the feed screw to disengage from the feed nut to prevent damage to the feed screw and machine.

The feed nut and feed screw can be re-engaged under pressure with no disassembly required by simply working the boring bar back in using the crank at the rear of the machine.

If the bar is too far out, you may need to remove the cotter pin in the castellated nut and back the nut off 2-3 turns. **Caution - do not remove the nut.** Then lightly tap the nut with a hammer and crank the boring bar back in. Tighten the castellated nut and replace the cotter pin.

Call 1-800-423-1323 before performing the procedure if you have any questions.

C1 Machines with the over travel feature will have the letters “OT” stamped in the brass drive box or on the cast panel of the body. If the drive box is stamped, “Model 6”, it will have the over travel feature but will not have the OT stamp.

If your machine does not have the over travel feature, you have probably damaged the feed screw and you will not be able to retract the boring bar. Call factory for further instructions, 800-423-1323.

Note: Operating Instruction Manual for the C1-36/C1-36-99002 Machines (Form 8513) is available by contacting MUELLER Customer Service Dept. at 1-800-423-1323. The Operating Instruction Manual is also available on line at www.muellercompany.com.

MUELLER Co. offers a repair and sharpening service for the C1-36-99002 Machine and cutting equipment. Contact your local distributor for details and pricing.