Drilling & Tapping Machines
Rugged design. Proven dependability.
Mueller Co. offers a complete selection of drilling and tapping machines – and small and large drilling machines – for installing water services and extending mains on virtually every type and size of pipe. Their rugged design, accuracy and proven dependability deliver superior overall performance on both dry and pressurized lines.

**B-101™ Drilling and Tapping Machine**

The B-101 Machine is designed for hand or power operation. It will drill and tap a main under pressure or dry, insert or extract corporation valves up to 1” and pipe plugs to 2-1/2”. It can be used on all pipe from 2” through 48”, including plain and cement-lined cast iron or ductile iron, PVC, asbestos-cement and steel. A special mechanism on the B-101 Machine permits the boring bar to be locked to the feed yoke. This prevents the drill from spiraling into the hole before the cut has been completed, and the tool cannot drop to the threaded portion and cause breakage. This locking mechanism is especially useful for work on low pressure mains. Maximum working pressure is 90 psig (250 psig with optional Power Clevis).

**A-3™ Drilling and Tapping Machine**

Similar to the B-101 Machine, the A-3 Machine is designed to tap water mains and insert or extract larger corporation valves ranging from 1” to 2” and pipe plugs from 1” to 2-1/2”. It can be used with all pipe in sizes 6” through 48” and has the additional versatility of being able to use “B” Machine tools. Maximum working pressure is 90 psig (250 psig with optional Power Clevis).

**“J”™ Drilling and Tapping Machine**

The “J” Machine is an open frame machine designed primarily for drilling and tapping dry or open mains. It can drill and tap holes from 1/4” to 3” on all types of pipe. Although developed for use on water mains, it can also drill and tap any machinable metal object to which it can be attached, such as columns, boilers and structural steel.
Anti-friction thrust collar
Fluorocarbon impregnated steel bearing sealed in steel case; no lubrication needed, resists galling under power operation.

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.

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

Chip flushing valve
Continually flushes away chips during drilling and tapping operations on all kinds of pipe; threaded outlet for attaching hose to direct flush water out of ditch.

Tool holding method
Transmits force evenly through drive pins on tool for smooth drilling and tapping. Retaining screw holds tool tightly in boring bar socket for precise alignment of tool with boring bar. Convenient knock-out pin allows easy tool removal.

Ratchet handle
Fully enclosed ratchet; permanently lubricated; quick-reverse button.

Feed sleeve and cap
Acme threads require only 2 1/2 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; O-ring seals.

Boring bar
Chrome plated to resist corrosion; helps assure long life of O-ring seals.

Relief/bypass valve
O-rings assure positive seal; allow smooth, easy push/pull operation.

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 1” valves.

Flop valve
Seats with pressure, self-aligning, molded neoprene washer; lever handle has positive lock—open or closed—with position indicator; O-ring on flop valve stem provides reliable seal.
**D-5™ Drilling Machine**

Hand or power operated, the D-5 Machine drills holes under pressure from 5/8” to 2” in almost any type of main. When using a service clamp and corporation valve, the D-5 Machine is used to drill through the pipe to activate the service. Length of travel is 14”. A combined feed nut and yoke provides positive feed for the full boring bar travel, and makes it possible to disengage the feed to permit the boring bar to be positioned quickly. The long feed tube helps protect the acme threads and automatically cleans them as the feed tube is rotated. A special mechanism on the feed yoke locks the boring bar to the yoke to prevent the drill from spiraling into the hole prematurely. Maximum working pressure is 500 psig at 100°F or 250 psig at 375°F.

**E-5™ Drilling Machine**

Similar in design and operation to the D-5 Machine, this machine will bore holes from 7/16” to 1” in most types of pipe. Boring bar travel is 12-1/8”. Maximum working pressure is 500 psig at 100°F or 250 psig at 375°F.

**Mega-Cut™ Drilling Machine**

Robust, yet lightweight and easy to use, the Mega-Cut Machine will drill holes from 7/16” to 1” on pressurized mains. Designed primarily for use on PVC, it can also be used on cast iron, ductile iron or steel mains. It has a manual feed sleeve for independent control of the cutting speed and the tool feed rate. The boring bar can be disengaged from the feed sleeve for quick repositioning. The drive nut accepts a 7/8” socket wrench. The Mega-Cut Machine is compatible with E-5 Machine tools, as well as Mueller two-tooth shell cutters for PVC pipe. Boring bar travel is 12-1/8”. Maximum working pressure is 200 psig at 100°F.

**Tru-Cut™ Drilling Machine**

Similar in design but smaller and lighter than the Mega-Cut Machine, the Tru-Cut Machine is designed specifically to drill 11/16” and 7/8” holes in PVC pipe. Its drive nut accepts both a 3/8” drive ratchet and a 3/4” socket/box wrench. The Tru-Cut Machine uses the same cutters and adapters as the PL-2 Machine. Boring bar travel is 7”. Maximum working pressure is 200 psig at 100°F.

**PL-2™ Drilling Machine**

The PL-2 Machine is used to drill 11/16” or 7/8” holes in PE or PVC plastic pipe under pressure. It has a 7” travel. A special feature permits the boring bar to be easily disengaged from the feed mechanism. The PL-2 Machine is operated with a standard 3/8” drive ratchet and 7/16” socket. Maximum working pressure is 200 psig at 100°F.
How it Works
The Mueller® Tapping Sleeve and Valve are attached to the main.

Mega-Lite® Drilling Machine
At just 65 pounds, the Mega-Lite Drilling Machine has been optimized to drill mains quickly, yet be light enough for one person to handle easily and still rugged enough to give years of dependable field service. The machine can be operated by air or hydraulic power. Its boring bar is controlled at all times, and can be quickly and easily advanced or retracted by hand, reducing the time needed for the drilling process. The Mega-Lite Machine can cut through valves 4” to 12” in size and be used on plain or cement-lined ductile or cast iron, A/C, steel, PVC or HDPE pipe. Maximum working pressure is 250 psig at 125°F.

CL-12™ Drilling Machine
The CL-12 Machine cuts holes from 2” to 12” under pressure for lateral connections in all types of pipe. While it may be operated manually, most users prefer faster, easier power operation. An automatic tool position indicator shows the position of the pilot drill and shell cutter at all times. Automatic feed control can be set for any 12” of the total 25” boring bar travel. The feed travel indicator automatically subtracts, showing the amount of travel remaining, so the operator always knows how much of the cut remains to be made. When the feed control reaches the preset amount, the feed automatically disengages. To prevent damage, the tool feed also disengages automatically at the maximum 25” machine travel. Maximum working pressure is 250 psi at 100°F or 150 psi at 500°F.

C1-36-99002™ Drilling Machine
For cutting holes to 18-1/2”, the C1-36-99002 Machine incorporates many of the same operation and performance features as the CL-12 Machine. With 36” boring bar travel, it makes cuts through tapping valves from 2” to 24” in all types of pipe. Maximum working pressure is 500 psi at 100°F or 250 psi at 500°F.
Tools and Accessories
Power operators ease machine operation and help to optimize machine performance, reducing stress on both machines and tools. This can significantly extend their useful life and reduce the need for repair. Air, electric and hydraulic powered operators are available (refer to sections 1 through 3 of the Mueller Co. Water Distribution Products Catalog for each machine’s specific compatibility with power operation).

Mueller cutting grease is a must for all drilling, tapping and cutting operations on metallic and PVC pipe materials to help assure cutting tools provide the long service life designed into them. Available in conveniently sized cans.

For Small Drilling Machines
- Drills for all popular types of pipe.
- Shell cutters for plastic pipe. Two-tooth design provides smoother cutting on plastic and helps avoid splitting the pipe.
- Nipples adapt machines to corporation valves. They permit the machine to be used with all types and sizes of Mueller corporation valves within the machine’s range.

For Large Drilling Machines
- Drills for small holes in most types of pipe. Different types of drills are available for use on various pipe materials.
- Shell cutters, pilot drills and center hubs are available for larger holes on a variety of pipe materials
- Adapters required to attach machines to valves and fittings are available for all popular end connections.
Mueller® Tapping Tools
The capability to drill and tap a hole in a pipe to attach a corporation valve without leakage depends to a great extent upon the quality of the threads cut in the pipe by the machine. Mueller tapping tools are designed to cut a thread with a special profile designed to complement the threads on Mueller corporation valves. When the threads on the valve engage those in the pipe, they form a tight metal-to-metal seal that resists leakage without the need for undue tightening. Using Mueller tapping tools to install Mueller corporation valves is your only assurance of gaining this special benefit.

Mueller Repair Service
Mueller Co. offers a complete repair service for most of its machines and tools. Machines are restored to like new condition and backed by a full warranty. Drilling, tapping and cutting tools are restored to like new condition, including resharpening to specifications and replacing chipped or missing carbide teeth. Only Mueller Co. knows all the critical resharpening parameters to assure tools perform smoothly and to specs. This also avoids undue stress and wear on machines, allows machines to operate at design speeds, and extends the life of tools and machines.
Our Products
Mueller Co. has built its reputation on producing innovative water distribution products of superior quality – a reputation that is literally “on the line” every day throughout the world. Mueller Co. products and those of its affiliates are used throughout the water system…from the source to the consumer. And we are committed to continuing research and development of new products and services to meet the growing needs of the water infrastructure industry. Mueller Co. is the largest and only full-line supplier of potable water distribution products in North America and its markets continue to expand globally.

Our People
The capacity to deliver the widest array of products and stand behind those products to ensure your satisfaction is our strength. The success of Mueller Co. is dependent upon the success of those who are involved, both inside and outside our company. Therefore, we feel our future is wholly dependent on long-term relationships with our employees, customers and suppliers. This is why we strive to be proactive and responsive to their needs, always looking for a “better way”. It’s an approach that has set us apart since 1857 and will assure our mutual achievement and prosperity in the future.

For more information about Mueller Co. or to view Mueller Co.’s full line of water products, please visit www.muellercompany.com or call Mueller Co. Customer Service at 1.800.423.1323.

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Complementary Mueller Products

Corporation Ball Valve
Mueller corporation ball valves offer reliable service, and are available with either CC or iron pipe thread inlets specially matched to Mueller drilling and tapping tools to assure leak-tight installation. Corporation ball valves are easy to install and require no adjustment for easy turning. A style is available which includes a “Reclaimed Water” tag attached prominently at the base of the operating stem.

Sizes:
• 3/4”, 1”, 1-1/2”, 2”

Connection Combinations:
• Inlets: CC, IP
• Outlets: Mueller 110® Compression Connections for either CTS tubing or IPS pipe, copper flare, pack joint (CTS, PEP, PVC), and male and female iron pipe thread (Mueller Grip) Connection, Copper Flare, M.I.P and F.I.P. thread.