WARNING:
Read and fully understand all instructions before operating any of Reed’s tapping or drilling machines. Failure to follow all instructions listed inside, may result in serious personnel injury and/or property damage.

CONTENTS:
1) Basic Product Information
2) Operating Instructions
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Direct Tapping Machine Operator’s Manual
Manual del operador para aterrajar

DIRECT TAPPING MACHINE - TM1100
COMBINATION TAPPING & DRILLING MACHINE - CDTM1100, CDTM2100
Basic Product Information:
The TM1100 Direct Tapping Machine drills and taps pressurized water mains. The tool additionally installs a 3/4” or 1” corporation stops. The tool can drill and tap 4”-48” cast or ductile iron and C-900 PVC. The base tool requires saddles for specific sizes and chain extensions above 16”. The tool uses Reed DT series drill taps.

Additional Specifications
• Tool Box overall outside dimensions:
  TM1100: 27 x 5/8 x 13 3/4 X 14
  See sketch for overall machine dimensions.
• Machine Clearance radius:
  TM1100 = 32”
• Pressure Rating: Design pressure rating for valve and chamber = 250 psi.
• Operating Pressure Rating - 90 psi - ie - Drilling or Tapping into pressurized mains.

Warning:
Drilling or Tapping into highly pressurized mains is not recommended. However, it is permissible at pressure up to 250 psi, if utilizing special precautions and incorporating high pressure attachments such as the Mueller® Power Clevis #H-10800. (See operations and maintenance manual.) DO NOT USE on natural gas or petroleum piping.

Materials and Finish:
A. Hard anodized and powder epoxy painted aluminum frames.
B. Alloy steel boring bar.
C. Heavy duty steel chain and forged steel chain hooks.
D. Bronze and zinc aluminum parts.
E. EPR rubber gaskets and “O” rings.
F. Plated steel parts.

TM1100 Operating Instructions:
Warning:
The maximum operating pressure for this tool is 90 psig (621 kPa). When using a power clevis, the maximum operating pressure is 250 psig (1724 kPa). DO NOT USE this tool on pipes containing natural gas or petroleum products.

Warning: Dry tap a piece of pipe to acquaint personnel with the machine and to preset groove depth for tapping.

Catalog No. Item Code  Size Pipe Dia  Net Shipping Wt
TM1100 09300  3/4” - 1” 4”-48” TAP  114 lbs./52 kg
CDTM1100 09304  3/4” - 1” TAP & DRILL 4”-48” TAP  114 lbs/52 kg
CDTM2100 09314  3/4”- 1” TAP/ 2” DRILL 4”-48” TAP  116 lbs/53 kg

1. Select proper tools necessary to perform tap.
   A. Corporation stop.
   B. Drill tap size to match corporation stop threads.
   C. Proper size saddle.
   D. Proper size corp insertion tool.
   E. Any other necessary accessories to meet operating requirements.

2. Assemble chamber to the pipe.
   A. Clean area of pipe where tap will occur. Use a REED DS12 or DS36 Descaler.
   B. Place bottom gasket into the tapping saddle before placing saddle on the pipe.
   C. Place tapping saddle on the top of the pipe with the tabs/ears of the saddle parallel with the length of the pipe.
   D. Place disc gasket on the top recess area of the saddle.
   E. Unscrew the top cap (assembled with Boring Bar).
   F. Place the machine chamber onto the disc gasket recess. Position the machine so the swing valve is on the same side as the operator.
   G. Place chain hooks and swivels into slots on both sides of the chamber.
   H. Connect the chain to one of the chain hooks, bring chain under the pipe and connect on the other side to the nearest link. Do not twist or create kinks in the chain.
   I. Hand tighten nuts.

NOTE: Use additional chain extensions and clevis for diameters over 16”.

3. Position chamber at desired angle between 45° and 90° from vertical.
   Tighten down chain nuts EVENLY, using REED CW12 Adjustable Wrench or L2017 Dual Socket Ratchet Wrench.
   A. Ensure the gaskets make good contact.
   B. Verify chain holds the machine securely on the pipe and saddle.

4. Insert Drill Tap into Boring Bar.
   A. Push knockout pin in Boring Bar to its holding position. (Toward flat side of bearing)
   B. Insert shank end of drill tap and align pin with slots in bar end.

NOTE: Make sure inside taper of the boring bar is clean before inserting the drill tap.
C. Make sure drill tap is securely seated and lightly tighten the tool retaining screw.

NOTE: Do not over tighten the retaining screw that holds the drill tap. Over tightening can strip out the threads.
D. Retract tool end of Boring Bar all the way into the top cap.
E. Generously coat tap with REED Tapping Compound #98425 or #99140.

**NOTE:** Always use clean drill taps coated with tapping compound. Fully clean drill tap threads with wire brush between taps and reapply tapping compound.

5. **Assemble top and bottom halves**

   A. Verify:
      a. Swing valve open.
      b. Upper ball valve shut.
      c. Needle valve (silver star knob) shut, clockwise.
   B. Screw Boring Bar top cap hand tight onto the top chamber (1 3/4 Turns).
   C. Push down Boring Bar slowly until bit touches the pipe.
   D. Adjust the Star Feed as necessary. Place the Yoke over the bearing.
   E. Put ratchet wrench on top of Boring Bar.

6. **Drilling and Tapping**

   A. Preparing to Drill
      a. **Manually:** Adjust the ratchet wrench to turn clockwise.
      OR
      b. **Power Drive:** Reed Power Drive Adapter #98427, 700PDTMPDA #05276 or 601PDTAP #05246. The operator can control the feed rate for drilling.
   B. Drill through the pipe by pulling the ratchet wrench clockwise and turning the star feed clockwise in a smooth and consistent manner. An easily turning Boring Bar and star feed indicates one has completed drilling through the pipe wall.

   **NOTE:** Do not overfeed the drill taps, let the bits do the cutting before feeding. Turn the drill tap one full revolution by hand before feeding.
   C. If appropriate, open the ball valve to allow flushing of chips while drilling.
   D. Feed drill tap down until feeling resistance. One will feel resistance when the tapping threads contact the pipe wall.
   E. Begin tapping by rotating the ratchet wrench with star feed swing clamp engaged.
   F. Continuously turn the feed housing, slow enough to allow the drill tap threads to feed. Rotate in a smooth and constant manner. DO NOT FORCE the star feed. Forcing the star feed will strip off the threads. After two full turns of drill tap into pipe, remove swing clamp of star feed and continue tapping.
   G. Continue tapping until start of the 3/32” wide groove (Depth Stop Line) in the Boring Bar sits flush with the Main Body. This depth should result in

   a satisfactory tap. Resharpened drill taps may require two additional turns. Other manufacturer’s drill taps may vary. Consult drill tap manufacturer’s instructions. Consider conducting dry taps to determine a depth that works best for you.

   **NOTES:**
   - Pay attention to the Depth Stop Line on the boring bar to keep from cutting too deep.
   - Weight of a power drive could possibly affect downward pressure when tapping the pipe, especially on PVC.

7. **Drill Tap Removal**

   A. Reverse the ratchet detent lever (or Power Drive Switch) and carefully back the drill tap out of the tapped hole using a counterclockwise rotation.
   B. Once the drill tap is free of the pipe, retract the Boring Bar to its uppermost position.
   CAUTION: If pipe is pressurized, apply resisting force to allow boring bar to slowly retract.
   C. Close the swing valve by pushing down on the handle and turning it 90 degrees counter-clockwise.
   D. Open the pressure relief valve on the top chamber to release pressure, then close it again.
   E. Unscrew the top cap assembly from the valve chamber.
   F. Loosen the tool retaining screw and strike the end of the knockout pin to release the drill tap.

8. **Attaching Corporation Stop to Boring Bar**

   A. Verify the selected corp stop matches the size intended and the drill tap size.
   B. Verify the corporation stop is in closed/off position.
   C. Screw the corp stop and corp adapter together.
10. Releasing the Corporation Adapter

A. Reverse the ratchet to turn counter clockwise.

B. Remove play from the ratchet wrench with one hand, and strike the wrench handle with the other hand to disen gage the corporation adapter from the adapter shank.

C. Rotate the ratchet wrench counter clockwise until the adapter shank is completely free.

D. Verify quality of corp stop seal by opening the chip flush valve and attempting to release pressure in the chamber. If pressure does not drop and water continues to flow, re-engage corp stop with the boring bar and attempt to tighten the corp stop further.

9. Inserting the Corp Stop

A. Attach the ratchet wrench onto the Boring Bar and set it for clockwise rotation.

B. Turn the star knob counter clockwise 1 turn to balance the pressure.

C. Push down on the swing valve handle and turn 90 degrees clockwise.

D. Push the Boring Bar down until the corp stop threads touch the pipe.

E. If not already done, swing Yoke over the Boring Bar to engage the bearing. Feed the bar as needed.

F. To start the engagement, rotate the Boring Bar clockwise while carefully turning the feed housing clockwise. Once the threads are engaged, disengage the Yoke. Continue rotating until the corporation stop feels solid. Do not attempt to permanently tighten the corporation stop with the machine.

11. Machine Removal

A. Unscrew top chamber assembly.

B. Loosen the chain hook nuts and unhook the chain. Remove hooks from the machine.

C. Carefully remove the machine, saddle, and gaskets and place them on a clean surface.

D. Tighten the corporation stop using a Smooth Jaw Wrench only on the corporation stop body. DO NOT USE A PIPE WRENCH.

E. Remove the corp adapter using the REED RCORP wrench provided.

D. Screw the adapter shank to the corp adapter.

E. Push knockout pin in Boring Bar to its holding position. (Toward flat side of bearing sleeve.)

F. Insert tapered end of the adapter shank into the Boring Bar and align the pin with the slots in the bar end. Tighten, but do not over tighten, the tool retaining screw.

G. Make sure the Boring Bar retracts all the way into the top cap. Apply non-toxic pipe dope to corp inlet threads.

H. Screw assembly into the valve chamber.
CDTM1100 and CDTM2100
Operating Instructions:

1. Drilling
   A. Convert direct tapping set up to drilling set up.
      i. Remove 99307 Bearing Assembly by backing out the single set screw.
      ii. Remove the tapping boring bar from the 99300 Threaded Body
      iii. Insert the drilling machine boring bar into the threaded body.
         1. 3/4” and 1” branch taps - reinstall bearing assembly. Line the set screw up with the lower hole in the boring bar. Drive the screw in until recessing the screw slightly. (See figures 2 & 3)
         2. 1-1/2” and 2” branch taps -
            a. Install 99301 Sleeve.
            b. Reinstall bearing assembly. Line the set screw up with the lower hole in the boring bar. Drive the screw in until recessing the screw slightly. (See figures 2 & 3)
            c. Follow DM1100/DM2100 Operator’s Manual #59305 to drill for service lines.
   B. Follow TM1100 Operator’s Manual #59300 to direct tap service lines.

2. Tapping
   A. Convert drilling set up to tapping set up.
      i. Remove 99307 Bearing Assembly. Back the single set screw out past the sleeve then remove the bearing assembly and sleeve.
      ii. Remove the drilling boring bar from the 99300 Threaded Body
      iii. Insert the tapping machine boring bar into the threaded body.
      iv. Reinstall the bearing assembly on the tapping bar.
      v. Line the set screw up with the lower hole in the boring bar.
         Drive the screw in until recessing the screw slightly.
   B. Follow TM1100 Operator’s Manual #59300 to direct tap service lines.

Maintenance Instructions:
TM1100, CDTM1100, CDTM2100

Before Using
1. Clean and oil all bearing and wear surfaces and threads.
2. Inspect and clean tapping bits, and remove chips and scale. Chips and scale may prevent proper function of the tool.
3. Inspect and clean the Boring Bar tool end. Chips and scale may interfere with the insertion of the tapping bit or adapter shank.

After Using
1. Clean the machine and oil the machined surfaces. If necessary, the top and bottom chambers can be easily disassembled to clean more thoroughly.
2. Lubricate the tool holding area of the boring bar with REED #98425 Tapping Compound.
3. Flush the bottom chamber with a water hose to remove any chips. DO NOT hammer frames to remove chips or debris - Handle Carefully!
4. Protect threaded pieces by assembling them with their mating parts.
5. Periodically, inspect the Boring Bar’s o-ring seals and replace if worn.
6. Carefully, place the tool back in the toolbox for storage.

Choose

0118-59300
TM1100 Tapping Parts Illustration, Parts List, and Necessary Accessories:

Boring Bar Assembly

Feed Assembly

Saddle See “Necessary Accessories”
### TM1100 Tapping Machine Parts List

<table>
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<th>Ref. No.</th>
<th>Description</th>
<th>REED Item Code</th>
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<tbody>
<tr>
<td>1</td>
<td>Boring Bar</td>
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<tr>
<td>2</td>
<td>Top Chamber</td>
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<tr>
<td>3</td>
<td>Bottom Chamber</td>
<td>98404</td>
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<td>Top Chamber Cap</td>
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<td>5</td>
<td>Valve Poppet</td>
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<td>Threaded Body</td>
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<td>7</td>
<td>Valve Lever</td>
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<td>Valve Poppet Bar</td>
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<td>Mini-Valve</td>
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<td>Swivel</td>
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<td>Hi Test Chain</td>
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<td>31</td>
<td>Wrench</td>
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<td>Adapter Shank</td>
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<td>36</td>
<td>3/4&quot; Insert Tool</td>
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<td>37</td>
<td>1&quot; Insert Tool</td>
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* Included but not shown
**99309 assembly includes: 99302, 98410, 98411, 98412, 93436, 98416.

### TM1100 Necessary Accessories

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<td>Saddle 48&quot;</td>
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<td>13</td>
<td>Ext Chain 5&quot; Lengths</td>
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<td>14</td>
<td>Chain Clevis 5/16&quot;</td>
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<tr>
<td>15</td>
<td>Tapping Compound 16 oz. can</td>
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Note: Extension chain and clevis to be used to extend TM1100 beyond basic 16" diameter capacity. Add one chain and clevis for up to 32" capacity. Add two chains and clevis for capacity up to 48".

See Also RP11
Reed Lifetime Warranty

Reed Hand Tools are for the professional trade and are warranted against all failure due to defects in workmanship and materials for the normal life of the tool.

FAILURES DUE TO MISUSE, ABUSE, OR NORMAL WEAR AND TEAR ARE NOT COVERED BY THIS WARRANTY.

Power units for Universal Pipe Cutters, Saw It® pneumatic saw, hydrostatic test pumps, cordless power pipe bevelers, and threading power drives are warranted for a period of one year from date of purchase. Hydraulic pumps for PE Squeeze-Off tools have a one year warranty from date of purchase.

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