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INSTALLATION PROCEDURE

DRILLING DEVICE: METHOD “B” - Service Saddle w/o Street Tee

The Skinner Drilling Device is a high grade “ratchet-handled” machine for drilling a hole in the Main through various service fittings. The following procedure is used for drilling a hole in the Main when there is no Street Tee connected to the Skinner Service Saddle. The necessary components for a successful installation when a SERVICE SADDLE only is used are; an Adaptor, a Drilling Device (with Skinner supplied ratchet handle or customer supplied ratchet handle), and a Cutter.

Top Thread of Tee	¾”	1”	1 ¼”	1 ½”	2”
Drill Device No.	4	7	7	7	7
Adaptor No.	14	15	16	23	24
Cutter No. (option a)	11 (¾” dia.)	7 (1” dia.)	19 (1 3/16” dia.)	20 (1 3/8”)	21 (1 7/8” dia.)
Cutter No. (option b)	1 (5/8” dia.)	11 (¾” dia.)	7 (1” dia.)	19 (1 3/16” dia.)	20 (1 3/8” dia.)
Cutter No. (option c)	2 (1/2” dia.)	2 (1/2” dia.)	11 (¾” dia.)	7 (1” dia.)	19 (1 3/16” dia.)
Cutter No. (option d)	4 (1/4” dia.)	4 (1/4” dia.)	2 (1/2” dia.)	11 (¾” dia.)	7 (1” dia.)

Installation Procedure:

Step #1	Thoroughly clean the area with a wire brush. Remove all pipe scale, rust, and foreign material. This will help insure a “bubble tight” seal. Assure that the Service Saddle and Street Tee are both properly installed.
Step #2	Using the guide above, select the designated DRILLING DEVICE number and ADAPTOR number based on the thread size of your SERVICE SADDLE. Also, select the CUTTER Number according to the size diameter hole you wish to drill (four diameter options are listed in the guide).
Step #3	Thread the FEED TUBE up through the ADAPTOR and the LOCK NUT and into the FEED NUT. Thread the CUTTER onto the end of the SPINDLE.
Step #4	Thread the ADAPTOR/DRILLING DEVICE onto the SERVICE SADDLE firmly. Position the assembly so that the CUTTER is in position resting on the top of the pipe to be drilled. Recommend that Tapping Compound be applied to CUTTER at this time to ease cutting operation and prolong life of the CUTTER.
Step #5	Position the LOCK NUT and tighten so that the FEED TUBE is locked onto the top of the ADAPTOR
Step #6	Holding the FEED NUT in the left hand, rotate the RATCHET WRENCH with the right hand. Rotate ratchet several rotations in a rapid fashion. Stop and turn the FEED NUT slowly until the CUTTER is pushing against the pipe. Now rotate the ratchet several more rotations. Repeat this sequence until the hole is completed. Do not over tighten the FEED NUT. DO NOT ROTATE THE RATCHET AND THE FEED NUT AT THE SAME TIME.
Step #7	Remove device by unthreading the ADAPTOR from the SERVICE SADDLE. Remove all metal filings and dirt.