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INSTALLATION PROCEDURE

DRILLING DEVICE: METHOD “C” — Tee or Pipe Nipple Welded to MAIN

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 the connection is either a TEE or a NIPPLE welded to the MAIN. The necessary components for a successful installation when the above method is use 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.	6	7	8	9	10
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.)	2 (1/2” dia.)	11 (¾” 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.
Step #2	Using the guide above, select the designated DRILLING DEVICE number and ADAPTOR number based on the thread size of your TEE or PIPE NIPPLE. 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 TEE of PIPE NIPPLE 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 TEE or PIPE NIPPLE. Remove all metal filings and dirt.