



936 Tapping Machine

Sizes: 12- Through 36-inch



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■ 936 Tapping Machine

Description

Tapping machines are used for making connections to pipelines, tanks, and plant piping without shutdown and are used to make hot taps in preparation for plugging machine applications.

The 936 Tapping Machine is hydraulically operated and is used for making pipe and tank taps from 12" to 36". Its operating temperature is 0°F (-18°C) to 180°F (82°C) at 2,220 psi (153 bar). For temperatures above 180°F (82°C), consult the factory.

The 936 Tapping Machine's unique pressure balanced system eliminates the effects of pipeline pressure, reducing operating loads on the feedscrew.

The 936 Tapping Machine meets NACE standard MR0175-93 (sulfide stress cracking resistant metallic material for oilfield equipment).

Features

The basic machine includes:

- Tapping machine
- Ladder and platform
- Hydraulic piping
- Skid
- Connecting hoses
- Power unit
- 2-Stage drive motors
- Feed motor
- Pressure-balance system

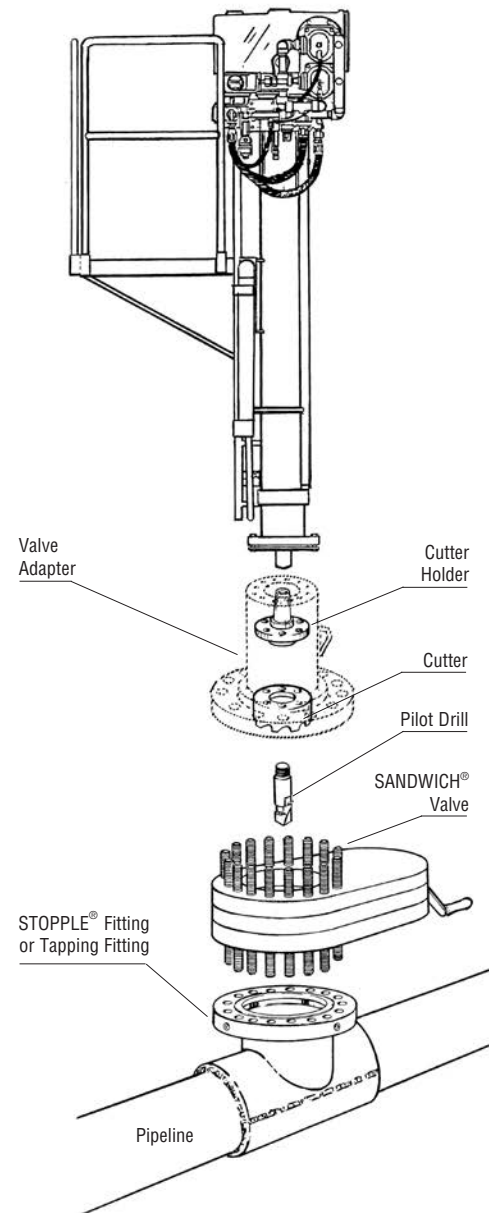
Consult the factory for special cutters and pilots required for tank taps.

Patented in the United States and in foreign countries.
ISO 9001 Certified

Toll Free

1-888-TDWmSon (839-6766)

■ Typical Tapping Setup





936 Tapping Machine

	Lbs.	Kg.	Part Number
Complete System includes the following:*	6000	2730	05-1045-0000
Tapping Machine**	3600	1111	05-2341-0001
Skid	400	180	05-2343-0047
Connecting Hoses	400	180	05-2148-0000
Power Unit with Diesel Engine***	1650	770	05-2432-0000

* Includes twin-drive motors and feed motor

** Includes ladder, platform and hydraulic piping

*** Battery not included

Lengths	Boring Bar Travel		Machine		Machine With Measuring Rod	
	Inches	mm	Inches	mm	Inches	mm
	108	2,743	146	3718	231	5867

Operating Specifications

Maximum Operating Pressure	2,220 psi (153 bar) @ 180°F (38°C)
Power	Hydraulically Powered
Feed	0.004" (0.102 mm) per Revolution
Lower-In Crank	12 Turns per Inch (2.1 mm/turn)

Power Unit

Engine: Hatz Diesel	30.5 HP @ 2400 RPM
Pump	Piston Type
Hydraulic Reservoir Capacity	55 Gallons
Engine Fuel Capacity (Diesel Engine)	5.8 Gallons
Hydraulic Oil Filters	10 Micron
Motors (at tapping machine)	Gear Type
Battery 12-volt, 455 amp, cold crank at 0°F	Customer Provided



936 Tapping Machine

Adapters for Standard Valves

Nominal Tap Size		ASME Class 150 RF Flange*			ASME Class 300 RF Flange*			ASME Class 600 RF Flange*		
Inches	DN	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number
12	300	170	77	06-5184-0012	255	116	06-5085-0012	268	122	06-5185-0012
14	350	240	109	06-5184-0014	232	105	06-6106-0014	354	161	06-5185-0014
16	400	280	127	06-5184-0016	315	143	06-6106-0016	510	231	06-5185-0016
18	450	329	149	06-5184-0018	363	165	06-6106-0018	560	254	06-5185-0018
20	500	425	193	06-5184-0020	465	211	06-6106-0020	730	331	06-5185-0020
22	550	416	189	06-5184-0022	567	257	06-6106-0022	925	420	06-5185-0022
24	600	612	278	06-5184-0024	786	357	06-6106-0024	1,125	510	06-5185-0024
26	650	633	287	06-5184-0026	920	417	06-6106-0026	960	435	06-5185-0026
28	700	700	318	06-5184-0028	1,066	484	06-6106-0028	1,530	694	06-5185-0028
30	750	791	359	06-5184-0030	1,375	624	06-6106-0030	1,875	851	06-5185-0030
32	800	990	449	06-5184-0032	1,580	720	06-6106-0032	2,036	924	06-5185-0032
36	900	1,650	748	06-5184-0036	2,650	1200	06-6106-0036	2,615	1,186	06-5185-0036

* Use with Class 900 to 600 Spool Adapter (06-9524-0000)

Adapters for TDW SANDWICH® Valves

Nominal Tap Size		ASME Class 600 RF Flange*		
Inches	DN	Lbs.	Kg.	Part Number
12	300	234	106	06-5087-0012
14	350	440	200	06-5087-0014
16	400	614	279	06-5087-0016
18	450	687	312	06-5087-0018
20	500	1,148	521	06-5087-0020
22	550	1,400	635	06-5087-0022
24	600	1,750	794	06-5087-0024
26	650	2,011	912	06-5087-0026
28	700	2,380	1,080	06-5087-0028
30	750	2,573	1,167	06-5087-0030
32	800	3,180	1,442	06-5087-0032
34	850	3,550	1,610	06-5087-0034
36	900	4,050	1,837	06-5087-0036

* Use with Class 900 to 600 Spool Adapter (06-9524-0000)

LOCK-O-RING® Plug Holder

12-36	300-900	14	6.4	05-0076-0000
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Cutter Holders

12-30	300-750	17-1/2	7.9	05-0056-0000
30-36	750-900	17	7.7	05-0278-0000

LOCK-O-RING® Bypass Gauge

8 oz.	227 grams	07-0963-0000
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936 Tapping Machine

Standard Hot Tap Applications

Nominal Tap Size		Actual Size		Standard Cutters			Standard Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number	Part Number
12	300	11-1/2	292	36	16	05-0389-0012	5	2	05-0294-0001	00-1424-0008
14	350	12-3/4	324	42	19	05-0389-0014	5-1/2	3	05-0294-0002	00-1424-0008
16	400	14-11/16	373	55	25	05-0389-0016	6	3	05-0294-0003	00-1424-0008
18	450	15-1/16	383	53-1/2	24	05-0388-0016	6	3	05-0294-0003	00-1424-0008
20	500	17	432	84	38	05-0388-0018	6-1/2	3	05-0294-0004	00-1424-0008
22	550	19	483	98	45	05-0388-0020	7-1/2	3	05-0294-0005	00-1424-0008
24	600	21	533	125	57	05-0388-0022	8	3	05-0294-0006	00-1424-0008
26	650	23	584	126	57	05-0388-0024	8-1/2	4	05-0294-0007	00-1424-0008
28	700	25	635	156	71	05-0388-0026	10-1/2	5	05-0294-0008	00-1424-0008
30	750	27	686	232	105	05-0388-0028	11	5	05-0294-0009	00-1424-0008
32	800	29	737	275	125	05-0388-0030	15	7	05-0294-0010	00-1424-0009
34	850	31	787	230	150	05-0388-0032	15	7	05-0294-0010	00-1424-0009
36	900	33	838	395	179	05-0388-0034	18	8	05-0294-0011	00-1424-0009

STOPPLE® Applications

Nominal Tap Size		Actual Size		STOPPLE® Cutters			STOPPLE® Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number	Part Number
12	300	11-13/16	300	40-1/2	18	05-0388-0012	5	2	05-0294-0001	00-1424-0008
14	350	13-1/16	332	49	22	05-0388-0014	5-1/2	3	05-0294-0002	00-1424-0008
16	400	15-1/16	383	53-1/2	24	05-0388-0016	6	3	05-0294-0003	00-1424-0008
18	450	17	432	84	38	05-0388-0018	6-1/2	3	05-0294-0004	00-1424-0008
20	500	19	483	98	45	05-0388-0020	7-1/2	3	05-0294-0005	00-1424-0008
22	550	21	533	125	57	05-0388-0022	8	4	05-0294-0006	00-1424-0008
24	600	23	584	126	57	05-0388-0024	8-1/2	4	05-0294-0007	00-1424-0008
26	650	25	635	156	71	05-0388-0026	10-1/2	5	05-0294-0008	00-1424-0008
28	700	27	686	232	105	05-0388-0028	11	5	05-0294-0009	00-1424-0008
30	750	29	737	275	125	05-0388-0030	11	5	05-0294-0009	00-1424-0008
32	800	31	787	330	150	05-0388-0032	15	7	05-0294-0010*	00-1424-0009
34	850	33	838	395	179	05-0388-0034	18	8	05-0294-0011	00-1424-0009
36	900	35	889	430	195	05-0388-0036	18	8	05-0294-0011	00-1424-0009

*Required with Cutter Holder 05-0278-0000 for making 30" (750 mm) taps