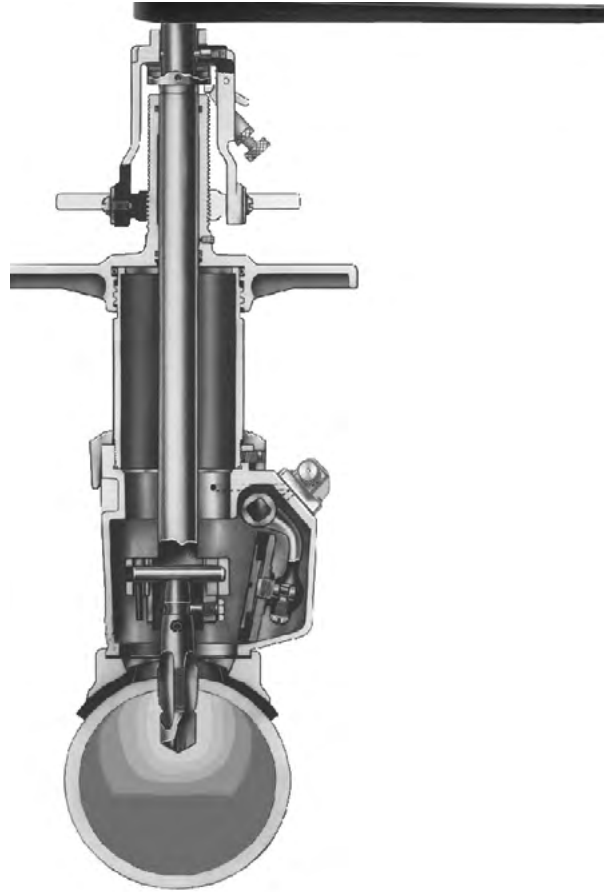


## MUELLER B-101-99007 Machine features

- **ANTI-FRICTION THRUST COLLAR** – fluorocarbon impregnated steel bearing sealed in a steel case - no lubrication required.
- **RATCHET HANDLE** – fully enclosed ratchet; permanently lubricated; quick reverse button.
- **LOCKING MECHANISM** – secures the boring bar to the feed yoke to prevent the drill from spiraling into the pipe before the hole is completely drilled. Helps prevent tool breakage.
- **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.
- **O-RING SEALS** – seal off special cavity inside feed sleeve to provide oil reservoir for lubricating boring bar and O-rings; boring bar wiper ring protects bottom O-ring.
- **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.
- **EASILY MAINTAINED BYPASS VALVE** – uses O-ring valve technology for better sealing. Locking feature prevents unintended operation.
- **BORING BAR** – chrome plated to resist corrosion; helps assure long life of O-ring seals.
- **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 stops and valves.
- **TOOL HOLDING METHOD** – transmits force evenly through drive pins on tool to drill and tap pipe. Retaining screw holds tool tightly in boring bar socket for precise alignment of tool and boring bar. Convenient knock-out pin allows easy tool removal.
- **FLOP VALVE** – seats with pressure, self-aligning, molded neoprene washer; lever handle has positive lock in open or closed position, position indicator included.



## MUELLER A-3™ Drilling and Tapping Machine (not shown)

Similar in design and features as the B-101™ machine, the A-3 machine can insert larger size tees.

## MUELLER B-101-99007 Machine - for drilling, tapping and inserting operations under pressure 1/2" to 2-1/2" inclusive

- Catalog number **39650**
- Hand or power operation
- Designed for use on pressurized or dry mains
- Insert or extract machine inserted service stop tees; pipe plugs to 2-1/2" in size
- Use on cast iron or steel pipe
- 90 psig (621 kPa) maximum working pressure without optional power clevis

\*When drilling or tapping above 1" by hand, use extension handle.

Item	Sizes***				Operation	Method
Service Stop Tees	3/4"				Drill and tap main	Hand or power
					Insert Service Stop tee	Hand
					Extract Service Stop tee	Hand
Pipe Plugs	1/2"	5/8"	3/4"	1"	Drill and tap main	Hand or power
					Insert pipe plug	Hand
					Extract pipe plug	Hand
	1-1/4"	1-1/2"	2"	2-1/2"	Drill and tap main	Hand* or power**
					Insert pipe plug	Hand
					Extract pipe plug	Hand



\*\*When power operating the machine to drill and tap 1-1/2" and larger, only combined shell cutters and taps should be used.

### Equipment furnished with each machine:

- Metal Storage Chest (**89265**)
- Reversible Ratchet Handle (**528273**)
- Small Saddle Gasket (fits between machine and saddle) (**40066**)
- Large Saddle Gasket (fits between saddle and pipe) (**40067**)
- Flat Link Chain (**580551**)
- Chain Hooks, Nuts and Washers
- Open End Wrench (for E-Z® release inserting tools) (**501579**)
- Box End Wrench (for tightening chain hook nuts and tool retaining screw) (**500708**)
- Body Cleaning Chisel (for cleaning debris from inside machine body) (**40050**)
- Cutting Grease (**88366**)
- Instruction Manual (Form **8910**)
- Enhanced Bypass Relief Valve with Locking Feature (**682562**)



### Equipment to be selected:

- Combined Drills and Taps or Shell Cutters and Taps
- Inserting Tools (used to insert service stop tees or pipe plugs)
- Machine Saddles (adapts machine to specific type and size of main)

### Optional equipment:

- Extracting Tools (used to remove service stop tees or plugs from mains)
- Equipment for special uses
- Power Operator

Weight	
Total shipping weight	114 lbs. (52 kg)
Handling weight during operation - Upper section	20 lbs. (9 kg)
Handling weight during operation - Lower section	23 lbs. (10 kg)

\*\*\*Nominal

NOTE: All tools and equipment used with the B-101 machine can also be used with the B-100 machine.

"B-101" is a registered trademark of Mueller Co., Decatur, IL.



**MUELLER Combined Drills and Taps/Shell Cutter and Taps for MUELLER B-101-99007 Machines**

Mueller Combined Drills and Taps/Shell Cutter and Taps are designed and manufactured to perfectly match the corresponding service stop tee or plug thread to assure a pressure tight seal. To further assure these tools are of the highest quality, Mueller Combined Drills and Taps/Shell Cutter and Taps are tested by making an actual tap in a cast plate, and the resulting thread is gauged. Each Mueller Combined Drill and Tap/Shell Cutter and Tap is subjected to a hardness test to assure material integrity.

*NOTE: Mueller Co. offers a Reconditioning service for Mueller made combined drills and taps, combined shell cutters and taps, and shell cutters. Contact Mueller Customer Service Center for details.*

Type of Pipe	Size* of Pipe	Tap Size*	CD&T Part Number	Shell Cutter and Tap Complete Part Number
Cast Iron	4"-24"	3/4"	680581	-
Cast Iron	4"-24"	1"	680582	-
Cast Iron	4"-24"	1-1/4"	681503	681970
Cast Iron	4"-24"	1-1/2"	681504	681971
Cast Iron	4"-24"	2"	681505	681972
Cast Iron	4"-24"	2-1/2"	681506	681973
Steel	4"-24"	1/2"	680569	-
Steel	4"-24"	3/4"	680586	-
Steel	4"-24"	1"	680587	-
Steel	4"-48"	1-1/4"	681507	682263
Steel	4"-48"	1-1/2"	681508	682264
Steel	4"-48"	2"	681509	682265
Steel	4"-48"	2-1/2"	-	681973

\*Nominal

MUELLER E-Z Release® Inserting Tools are provided with a feature that allows the drilling and tapping machine to disengage the tee without backing the tee out of the main. E-Z Release Inserting Tools consist of two parts (a shank and a nut) which are joined by a coarse Acme thread. When the machine disengages

the tee, the two parts of the inserting tool separate at the Acme thread. The part of the inserting tool left attached to the tee is easily removed once the tapping machine is removed from the main.



Inside thread

### Screw Plugs for Machine Inserted Service Stop Tees

Type	Size*
	3/4"
E-Z Release Screw Plug	680595
Inside I.P. Thread	-
Screw Plug Outside I.P. Thread	680631



Outside thread



Inside thread

### Extracting Tools for Service Stop Tees

Type	Size*
	3/4"
Extracting Tool - Inside I.P. Thread	680619
Extracting Tool - Outside I.P. Thread	680638



Outside thread



Outside thread

### Inserting and Extracting Tools for H-10037-99004 Plugs

Type	Size*						
	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"	2-1/2"
Inserting Tool - Outside Thread	680643	680644	680644	680644	680645	680645	680645
Extracting Tool - Outside Thread	680640	680641	680641	680641	680642	680642	-

\*Nominal

# MUELLER® B-101-99007 DRILLING AND TAPPING MACHINE SADDLES

**MUELLER**

**12.5**

Shaded area indicates change Rev. 12-06

## Saddle for Cast Iron Pipe

Pipe Size*	O.D. Range of Pipe		Part Number
	Minimum	Maximum	
2"	2-11/16"	3"	75832
3"	3-1/2"	4"	75810
4"	4-3/8"	5"	75812
5"	5-13/16"	6-3/8"	75833
6"	6-7/16"	7-1/8"	75815
8"	8"	9-1/2"	75817
10"	10"	11-5/8"	40074
12"	11"	14-1/2"	75821
14"	14"	17-3/8"	75835
16"	16"	19-3/8"	75836
18"	17"	21-1/8"	75837
20"	19"	27-1/8"	75204
24"	21"	29-1/8"	75838
30"	26"	41"	75839
36"	28"	47"	75840
48"	32"	77"	75841

## Saddle for Steel Pipe

Pipe Size*	O.D. Range of Pipe		Part Number
	Minimum	Maximum	
2"	2-1/4"	2-11/16"	75808
2-1/2"	2-5/8"	3-1/8"	75809
3"	3-1/2"	4"	75810
3-1/2"	4"	4-5/16"	75811
4"	4-3/8"	5"	75812
5"	5-13/16"	6-3/8"	75833
6"	6-7/16"	7-1/8"	75815
8"	8"	9-1/2"	75817
10"	9-1/2"	12-1/4"	75819
12"	10-5/8"	13-1/8"	75820
14"	11"	14-1/2"	75821
16"	14"	17-3/8"	75835
18"	16"	19-3/8"	75836
20"	17"	21-1/8"	75837
24"	19"	27-1/8"	75204
30"	26"	41"	75839
36"	28"	47"	75840



**MUELLER® B-101™ Machine Saddles**

\*Nominal

**Ratchet Handle Extension**

PART NUMBER: **500684** – Extends length of ratchet handle to give more leverage when hand opening.

**Flat Link Chain with Eyebolt and Nut**

PART NUMBER: **580551** – For pipe up to 12".

**Flat Link Extension Chain with Bolts and Nuts**

PART NUMBER: **89059** – 4' (1.2m) extension chain increases 12" (305mm) chain to fit 12"-24" pipe.

PART NUMBER: **88126** – 6' (1.8m) extension chain increases 12" (305mm) chain to fit 12"-36" pipe.

PART NUMBER: **88127** – 10' (3.0m) extension chain increases 12" (305mm) chain to fit 12"-48" pipe.

**Flat Chain Hook with Nut**

PART NUMBER: **580550** Chain hook with nut.

**Chain Spreader**

PART NUMBER: **40321**

Used when tapping pipe 3" or smaller to spread the chain so that it will clear the lower edge of the body of the machine.

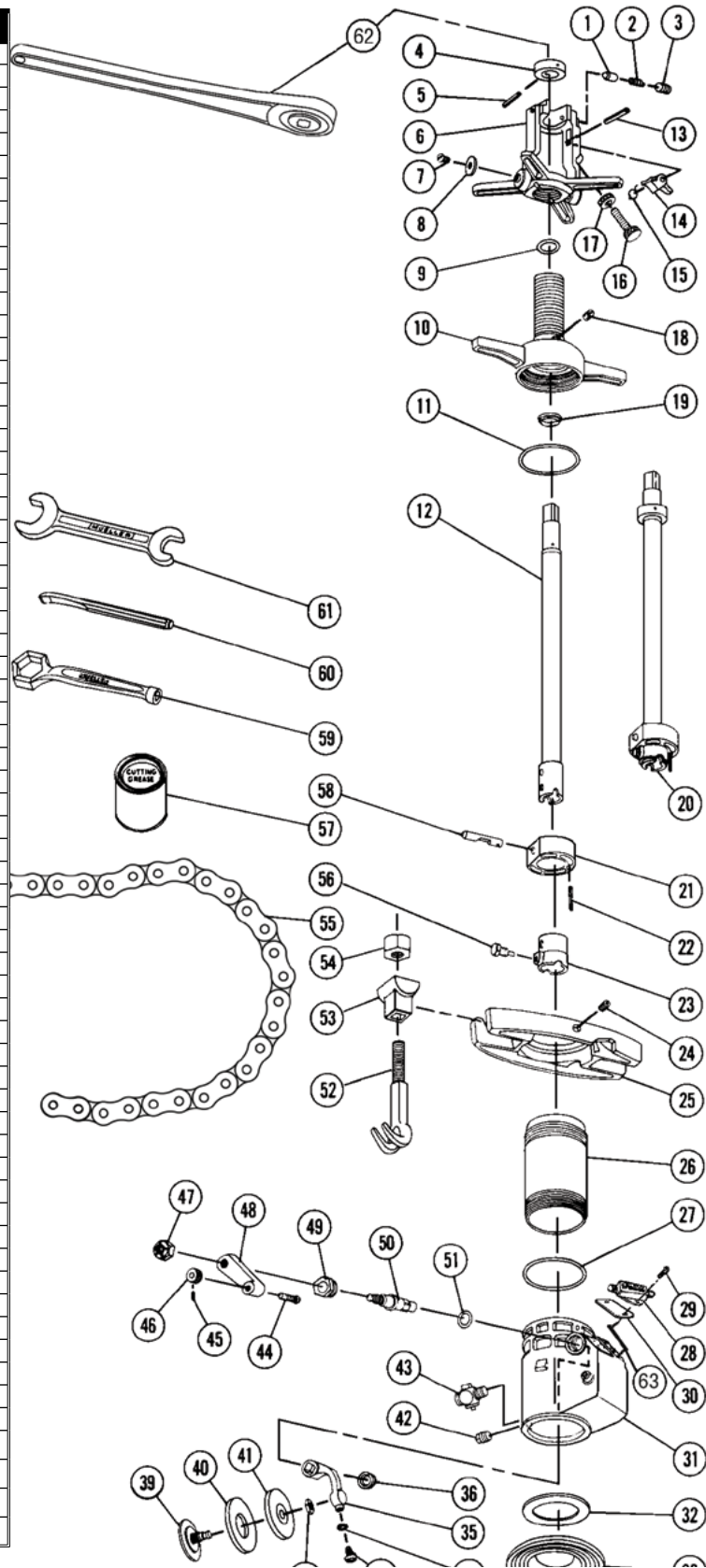
# MUELLER® B-101-99007 DRILLING AND TAPPING MACHINE REPAIR PARTS

**MUELLER**

**12.7**

Shaded area indicates change Rev. 12-06

Item No.	Part Name	Part Number
1	5000851	Detent Pin - 2
2	59810	Spring - 2
3	305006	Screw - 2
4	580610	Friction Collar
5	48130	Retaining Pin
6	580611	Feed Nut & Yoke Complete
7	312443	Yoke Retaining Screw - 2
8	537126	Washer - 2
9	79269	Boring Bar O-ring - 2
10	500685	Feed Sleeve & Cap
11	500687	Cap Packing
12	502022	Boring Bar
13	502027	Rollpin
14	502025	Pivot Arm
15	502026	Pivot Arm Spring
16	502028	Operating Screw
17	502029	Lock Nut
18	41435	Oil Plug
19	500887	Wiper Ring
20	580609	Boring Bar Complete
21	500692	Bearing
22	48130	Retaining Pin
23	500691	Bearing Sleeve
24	97795	Chain Yoke Retaining Screw
25	500683	Chain Yoke
26	500682	Cylinder
27	500670	Valve Body O-ring
28	682161	Bypass Valve Sub Assembly
29	312148	Bypass Valve Screw - 2
30	311812	Bypass Valve Gasket
31	502046	Valve Body
32	40066	Small Saddle Gasket
33	40067	Large Saddle Gasket
34	52165	Lock Washer
35	500672	Valve Gate Arm
36	72627	Spring
37	500675	Lock Screw
38	500676	Lock Nut
39	500674	Valve Washer And Stem
40	500673	Gate Washer
41	500671	Valve Gate
42	50369	Pipe Plug
44	501061	Handle Screw
45	302575	Lock Screw
46	46280	Handle Knob
47	500669	Handle Nut
48	500668	Lever Handle
49	500667	Valve Stem Retaining Nut
50	500666	Valve Stem
51	41301	Valve Stem O-ring
52	580550	Chain Hook - 1
53	500707	Chain Hook Washer - 2
54	500706	Chain Hook Nut - 2
55	580551	Chain
56	500694	Tool Retaining Screw
57	88366	Cutting Grease
58	500693	Knock Out Pin
59	500708	Chain Hook Wrench
60	40050	Body Cleaning Chisel
61	501579	Inserting Tool Wrench
62	528273	Ratchet Handle Complete
63	682162	Bypass Valve Safety Plate
	682561	Bypass Valve Key Repair Kit
	306991	Bypass Spare Retaining Ring
	682562	Bypass Valve Repair Kit



**NOTE:** These illustrations are for parts identification only. DO NOT use these illustrations for assembly or disassembly of machine. Mueller Co. offers a machine repair service. Contact Mueller Customer Service Center for details.

## MUELLER A-3 Machine - for drilling, tapping and inserting operations under pressure 1" to 2-1/2" inclusive

- Catalog number **39210**
- Hand or power operation
- Designed for use on pressurized or dry mains
- Insert or extract service stop tees 1" to 2" and pipe plugs to 2-1/2" in size
- Use on cast iron and steel pipe
- 90 psig (621 kPa) maximum working pressure without optional power clevis

Item	Sizes**					Operation	Method
Service Stop Tees	1"	1-1/4"	2"			Drill and tap main	Hand or power*
						Insert Service stop tee	Hand
						Extract Service stop tee	Hand
Pipe Plugs	1"	1-1/4"	1-1/2"	2"	2-1/2"	Drill and tap main	Hand or power*
						Insert pipe plug	Hand
						Extract pipe plug	Hand

\* When power operating the machine to drill and tap 1-1/2" and larger, only combined shell cutters and taps are recommended.



### Equipment furnished with each machine:

- Wooden storage chest (98829)
- Ratchet handle (85308)
- Ratchet handle extension (86391)
- Small saddle gasket (fits between machine and saddle) (40229)
- Large saddle gasket (fits between saddle and pipe) (40230)
- Flat link chain with eyebolt and nut for 6" thru 16" pipe (83518)
- Chain hook, nut and washer
- Box end wrench for tightening chain hook nuts and tool retaining tools (40028)
- Allen wrench (90322)
- Open end combination wrench for E-Z release inserting tools (75409)
- Body cleaning chisel (for cleaning debris from inside of machine body) (40205)
- Cutting grease (88366)
- Instruction Manual (Form 8541)

### Equipment to be selected:

- Combined drills and taps or shell cutters and taps
- Inserting tools (used to insert service stop tees or pipe plugs)
- Machine saddles (adapts machine to specific type and size of main)

### Optional equipment:

- Extracting tools (used to remove service stop tees or pipe plugs from mains)
- Equipment for special uses
- Power operator

\*\*Nominal

Weight	
Total shipping weight	188 lbs. (85 kg)
Handling weight during operation - Upper section	40 lbs. (18 kg)
Handling weight during operation - Lower section	58 lbs. (26 kg)





**MUELLER Combined Drills and Taps/Cutters and Taps for A-3 Machines**

Mueller Combined Drills and Taps/Cutters and Taps are designed and manufactured to perfectly match the corresponding tee or plug thread to assure a pressure tight seal. To further assure these tools are of the highest quality, Mueller Combined Drills and Taps/Cutters and Taps are tested by making an actual tap in a cast iron plate, and the resulting thread is gaged. Each Mueller Combined Drill and Tap/Cutters and Taps is subjected to a hardness test to assure material integrity.

*NOTE: MUELLER CO. offers a reconditioning service for MUELLER made combined drills and taps, combined shell cutters and taps, and shell cutters. Contact MUELLER Customer Service Center for details.*

Type of pipe	Size* of pipe	Tap size*	CD&T part number	Shell cutter & tap complete part number
Cast Iron	4"-24"	3/4"	680581	-
Cast Iron	4"-24"	1"	680582	-
Cast Iron	4"-24"	1-1/4"	681503	681970
Cast Iron	4"-24"	1-1/2"	681504	681971
Cast Iron	4"-24"	2"	681505	681972
Cast Iron	4"-24"	2-1/2"	681506	681973
Steel	4"-24"	1/2"	680569	-
Steel	4"-24"	3/4"	680586	-
Steel	4"-24"	1"	680587	-
Steel	4"-48"	1-1/4"	681507	682263
Steel	4"-48"	1-1/2"	681508	682264
Steel	4"-48"	2"	681509	682265
Steel	4"-48"	2-1/2"	-	681973

\*\*Nominal

MUELLER E-Z Release® Inserting Tools are provided with a feature that allows the drilling and tapping machine to disengage the tee without backing the tee out of the main. E-Z Release Inserting Tools consist of two parts (a shank and a nut) which are joined by a coarse Acme

thread. When the machine disengages the tee, the two parts of the inserting tool separate at the acme thread. The part of the inserting tool left attached to the tee is easily removed once the tapping machine is removed from the main.



Inside thread



Outside thread

### Screw plugs for machine inserted service stop tees

Type	Size*			
	1"	1-1/4"	2"	2-1/2"
E-Z Release Screw Plug	680596	680628	83066	83157
Inside I.P. Thread	-	680597	-	-
Screw Plug Outside I.P. Thread	680632	61212	61214	-



Inside thread



Outside thread

### Extracting tools for service stop tees

Type	Size*			
	1"	1-1/4"	2"	2-1/2"
Extracting Tool - Inside I.P. Thread	680620	680621	83180	-
Extracting Tool - Outside I.P. Thread	680639	-	-	-



Outside thread

### Inserting and extracting Tools for H-10037-99004 plugs

Type	Size*				
	1"	1-1/4"	1-1/2"	2"	2-1/2"
Inserting Tool - Outside Thread	680644	680644	680645	680645	680645
Extracting Tool - Outside Thread	680641	680641	680642	680642	-

\*\*Nominal

# MUELLER® A-3™ DRILLING AND TAPPING MACHINE SADDLES

**MUELLER**

**12.11**

Shaded area indicates change Rev. 12-06

## Saddle for Cast Iron Pipe

Pipe Size*	O.D. Range of Pipe		Part Number
	Minimum	Maximum	
4"	-	5"	75906
6"	6-9/16"	7-1/8"	75908
8"	8-7/8"	9-3/8"	75909
10"	10-1/8"	11-1/4"	75910
12"	11-7/8"	13-1/2"	40236
14"	14-1/8"	16-1/4"	75911
16"	16"	18-3/4"	40238
18"	17-3/4"	20-1/2"	75831
20"	18-1/8"	22-3/4"	40240
24"	22-1/2"	27-1/2"	40241
30"	25-3/4"	35"	75912
36"	30-1/8"	43"	75913
40"	31-1/4"	45"	76701
42"	34"	51"	59582
48"	34"	58"	75914

## Saddle for Steel Pipe

Pipe Size*	O.D. Range of Pipe		Part Number
	Minimum	Maximum	
4"	-	5"	75906
6"	6"	6-5/8"	46703
8"	8"	8-5/8"	45384
10"	10"	10-3/4"	43294
12"	11-7/8"	13-1/2"	40236
16"	14-1/8"	16-1/4"	75911
18"	16"	18-3/4"	40238
20"	17-3/4"	20-1/2"	75831
24"	22-1/2"	27-1/28"	40241
30"	25-3/4"	35"	75912
36"	30-1/8"	43"	75913



**MUELLER® A-3 Machine Saddles**

\*\*Nominal



**Flat Link Chain with Eyebolt and Nut**  
PART NUMBER: **85318** – For pipe up to 12".



**Flat Link Extension Chain with Bolts and Nuts**  
PART NUMBER: **82314** – increases 16" chain to fit 16"-24" pipe.  
PART NUMBER: **81028** – increases 16" chain to fit 16"-36" pipe.  
PART NUMBER: **81029** – increases 16" chain to fit 16"-48" pipe.



**Chain Spreader**  
PART NUMBER: **40321**  
Used when tapping pipe 6" or smaller to spread the chain so that it will clear the lower edge of the body of the machine.

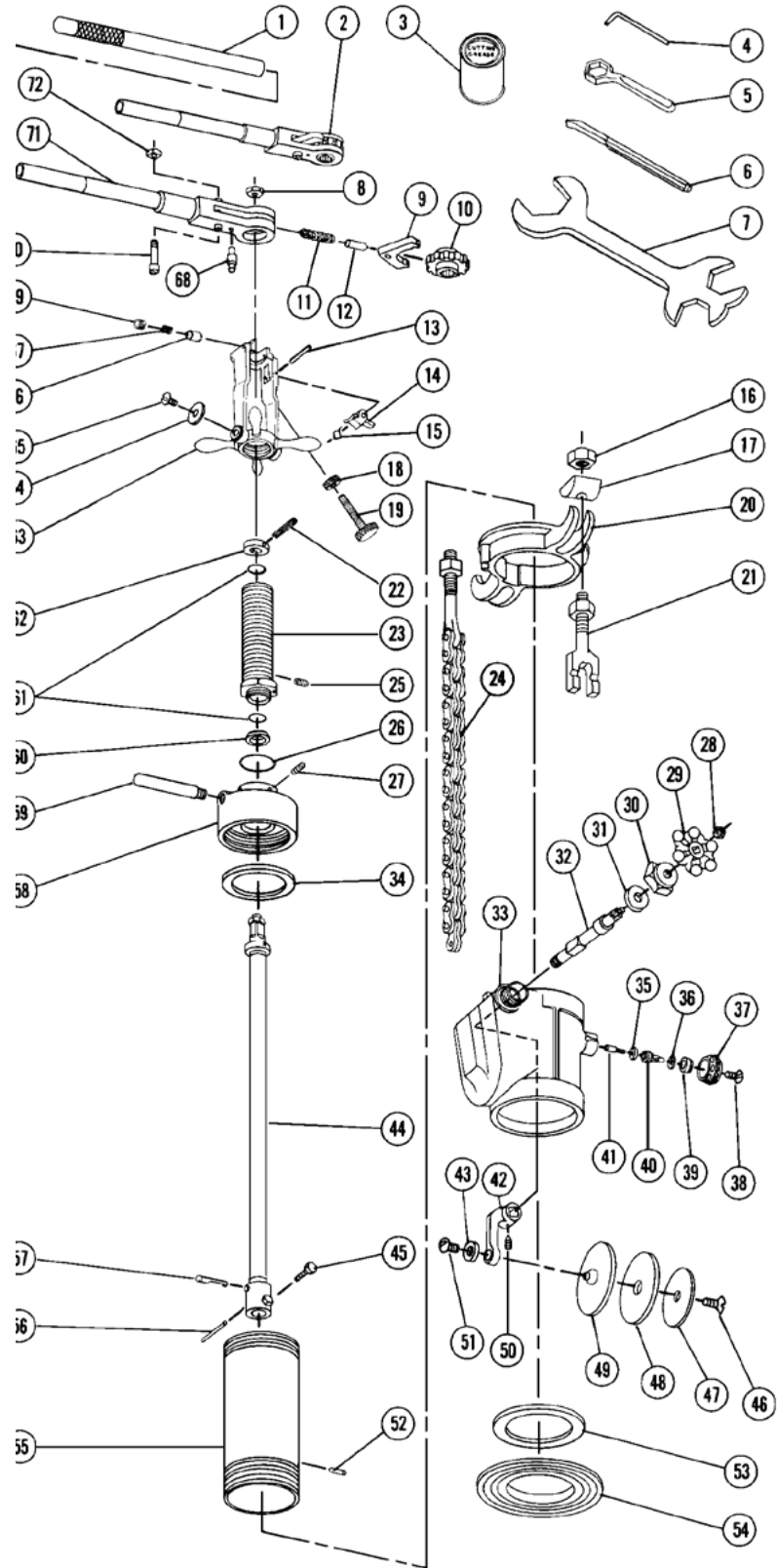
# MUELLER® A-3™ DRILLING AND TAPPING MACHINE REPAIR PARTS

**MUELLER**

**12.13**

Shaded area indicates change Rev. 12-06

Item No.	Part Number	Part Name
1	86391	Handle extension
2	85308	Ratchet handle complete
3	88366	Cutting grease
4	90322	Allen wrench
5	40028	Chain nut wrench
6	40205	Chisel
7	75409	Wrench
8	46029	Boring bar nut
9	40004	Ratchet dog
10	40137	Ratchet wheel
11	40007	Spring
12	40006	Spring pin
13	502027	Rollpin
14	502025	Pivot arm
15	502026	Pivot arm spring
16	40211	Chain hook nut
17	40212	Chain hook washer
18	502029	Lock nut
20	40213	Chain yoke
21	89099	Chain hook
22	48130	Friction collar rollpin
23	503149	Feed sleeve
24	85318	Chain for 6"-16" mains
25	41435	Oil plug
26	45374	Feed sleeve O-ring
27	98430	Set screw
28	58849	Handwheel nut
29	58519	Handwheel
30	40193	Stem packing nut
31	58461	Stem packing washer
32	40194	Valve stem
33	503147	Valve body
34	40189	Cap gasket
35	42042	Seat washer
36	40049	Seat nut washer
37	40043	Hand knob
38	40044	Hand knob screw
39	40048	Seat nut
40	40045	Stem
41	40047	Screw
42	40195	Gate arm
43	40203	Gate screw washer
44	580967	Boring bar assembly
45	62501	Tool retaining screw
46	40200	Seat washer screw
47	40197	Gate washer
48	40198	Seat washer
49	40196	Gate
50	40013	Stem set screw
51	40202	Gate-to-arm screw
52	40023	Yoke retaining pin
53	40229	Small saddle gasket
54	40230	Large saddle gasket
55	58093	Cylinder
56	56694	Retaining pin
57	40015	Drift pin
58	503148	Cap
59	40020	Handle
60	501273	Boring bar wiper ring
61	51458	Boring bar O-ring
62	580610	Friction collar
63	580898	Feed yoke
64	50133	Washer
65	79745	Retaining screw
66	500851	Detent
67	59810	Detent spring
68	40139	Stud
69	305006	Detent screw
70	40138	Bolt*
71	80111	Handle bar
72	46255	Nut*



Storage Chest not shown

\*Order both parts when replacing either one.

**NOTE:** These illustrations are for parts identification only. DO NOT use these illustrations for assembly or disassembly of machine. Mueller Co. offers a machine repair service. Contact Mueller Customer Service Center for details.

**TO ORDER SPECIFY QUANTITY, PART NUMBER AND PART NAME (include catalog number and model number of machine)**

**12.14**

**MUELLER**

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Rev. 12-12 Shaded area indicates changes

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