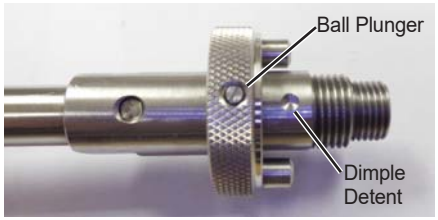
SIMTAP™

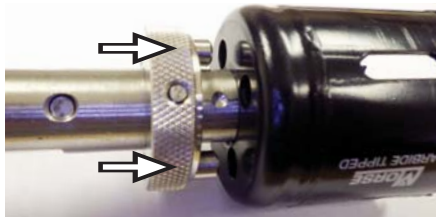
Ford SIMTAP™ Drilling Machine Operating Instructions (continued)

Operating Instructions for SIMDRIVE-SS-NL Drive Ring

Install drive ring to prevent cutter from excessively tightening on the boring bar or damaging the threads when drilling 1-1/2" and 2" holes through water pipes.

- Select parts to drill desired hole.
- Slide SIMDRIVE-SS-NL Drive Ring to the fully retracted position with the ball plunger aligned with the boring bar detent/dimple. (NOTE: The ball plunger is factory adjusted for best fit and operation so operator adjustment is not typically needed.)
- Thread the cutter onto boring bar until seated at base. (NOTE: pilot drill set screw is accessible while the SIMDRIVE-SS-NL Drive Ring is in the fully retracted position.)
- Rotate the cutter in the opposite (removal) direction only enough to align the drive pins with the mating holes in the cutter.
- Slide Drive Ring toward the cutter until the ball plunger engages the detent/dimple in the boring bar.





WARRANTY - READ BEFORE OPERATING

All merchandise is warranted to be free from defects in material and factory workmanship for one year from date of shipment from our factory. We will provide, free of charge, new products in equal quantities for any that prove defective within one year from date of shipment from our factory. Manufacturer shall not be liable for any loss, damage, or injury, direct or consequential, arising out of the use of or the inability to use the product. Before using, user shall determine the suitability of the product for user's intended use and user assumes all risk and liability whatever in connection therewith. No claims for labor or consequential damage will be allowed. The foregoing may not be changed except by agreement signed by an officer of the Manufacturer.

No other warranties are applicable or may be implied, including the implied warranty of merchantability and the implied warranty of fitness for particular purpose and any warranty relating to infringement or the like, all of which are disclaimed.

DAMAGE CAUSED BY IMPROPER TOOLS OR
HANDLING WILL VOID OUR WARRANTY

Refer to the FMB website (www.fordmeterbox.com) for additional and most recent instructions and product information.

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SIMTAP™

Drilling Machine Operating Instructions

FORD *SIMTAP*™
Operating and Assembly Instructions

DANGER: Do not use electric drill. Use of electric drill could result in shock or death. Follow the pipe manufacturer associations' installation and tapping/drilling recommendations.

- Remove the body from the case. The body is black in color and is identified by part number *SIMDMB-NL*. The SIMTAP™ body serves a dual purpose. It is also the 2" Flare Copper Thread Adapter (item #1).
- Choose the appropriate adapter for the corporation stop to be tapped. The adapters are color anodized and labeled with the thread type for ease in identification. Double check to ensure the rubber O-ring is in place on the adapter. Screw the adapter (item #2) into the body and hand tighten.
- Remove the stainless steel shaft from the case and insert the 1/4" coupon-retaining pilot bit. Be sure to slide the flat surface of the pilot bit (item #3) directly beneath the set screw. Once in place, firmly tighten the set screw with hex wrench.
- Select the appropriate carbide tipped hole saw or shell cutter (item #4) for the pipe material and the desired hole size. Hole saws and cutters are generally 1/8" undersized (example: 1" tap uses a 7/8" diameter cutter). (See last page for SIMDRIVE-SS-NL driver application and operation instructions.) Place over the pilot bit and screw onto the shaft arbor.
- Take the hexed end of the shaft and extend it through the front of the machine (adapter end) until it extends all the way through the body. Proceed by pulling the shaft (item #5) from behind until the hole saw bottoms out inside the body.
- Affix the SIMTAP™ Machine to the valve and hand tighten. Open the corporation stop (making sure it is in the fully open position) and push the shaft through the valve **gently** until the pilot bit makes contact with the pipe. Connect your 1/2" drive power source. Open the Chip Flushing Port. Begin your tap. Always rotate clockwise applying no more force than required for the cutter to engage the pipe. When the tap is complete, pull the power source back until the hole saw bottoms out inside the body. Close the corporation stop and remove your machine. Close the Chip Flushing Port. Open the corporation stop to flush chips prior to connecting the service line.

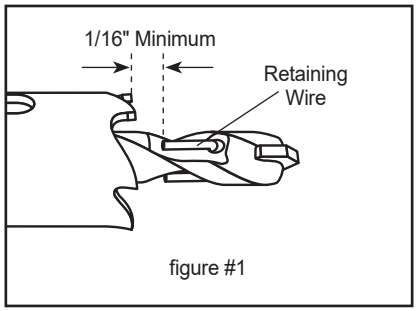
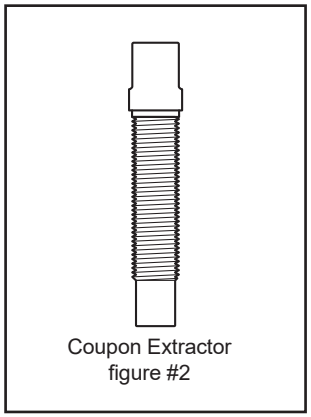


figure #1


Coupon Extractor
figure #2

FORD *SIMTAP*™ ADAPTERS

Part Number: SIMDMA1-3-NL Color: Red Description: 3/4" Iron Pipe Thread	
Part Number: SIMDMA2-3-NL Color: Purple Description: 3/4" Flare Copper Thread	
Part Number: SIMDMA1-4-NL Color: Turquoise Description: 1" Iron Pipe Thread	
Part Number: SIMDMA2-4-NL Color: Gray Description: 1" Flare Copper Thread	
Part Number: SIMDMA6-4-Q-NL Color: Blue Description: 1" PEP Quick Joint Thread	
Part Number: SIMDMA1-6-NL Color: Brown Description: 1-1/2" Iron Pipe Thread	
Part Number: SIMDMA2-6-NL Color: Orange Description: 1-1/2" Flare Copper Thread	
Part Number: SIMDMA4-6-Q-NL Color: Green Description: 1-1/2" CTS Quick Joint Thread	
Part Number: SIMDMA1-7-NL Color: Gold Description: 2" Iron Pipe Thread	
Part Number: SIMDMA4-7-Q-NL Color: Yellow Description: 2" CTS Quick Joint Thread	

IMPORTANT TIPS AND PROCEDURES

- Maximum drill RPM is 650
- When using pneumatic drill, the compressor must provide continuous 6 CFM @ 90 PSI
- Do not use with a hammer drill or impact driver
- Do not reverse the drill. Only rotate in a clockwise direction
- Push straight down on the drill, keeping the shaft straight. Side-loading the shaft will cause premature wear on the shaft, seal and bushing.
- The pilot bit may become loose in the boring bar during repeated hole drilling. It is recommended to check the pilot bit set screw between cuts to make sure it remains tight. Failure to keep the set screw tight could result in the loss of the pilot bit in the pipe.
- When drilling ductile iron pipe, we recommend using a low viscosity food grade lubricant or grease. Do not use grease or lubricant that will allow chips to adhere to the cutters
- For proper coupon retention, the full length of the pilot drill retaining wire must extend beyond the main cutter to allow proper gripping of the coupon (figure #1)
- To assist with cutter removal, remove the shaft from the machine body and slide the shaft through the square opening in the adapter wrench for leverage, and to prevent the shaft from turning while removing cutters.
- Use provided coupon extractor (figure #2) to free stuck coupons. After removing the pilot bit, remove the cutter from the shaft. Thread the appropriate extractor through the bottom of the cutter to release the coupon.
- Use caution when applying force to the machine to avoid drilling through the back side of the pipe.
- Remove chips, clean and inspect inside the machine and the entire cutter (including the teeth) after each tap.