

Cold Tapping Procedure “Catching the Coupon”

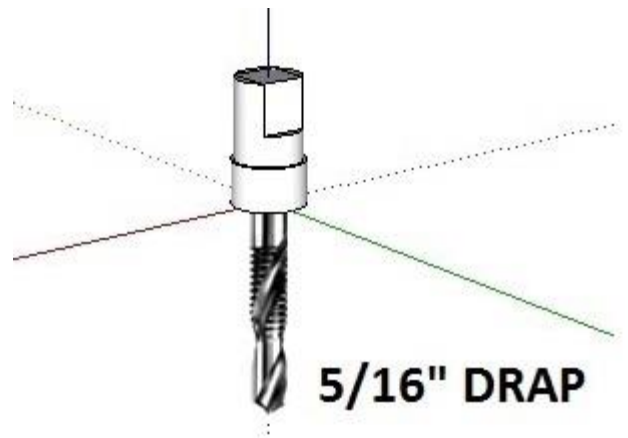
Hot Tapping = Pipe is pressurized

Cold Tapping = Pipe is NOT pressurized

Through the years we have helped customers with their hot and cold tapping applications. We stock all the necessary tools to tap, drill and catch the core of the pipe section you drill.

Part 1:

- You'll start by using a drap (drill/tap) to make the initial centering thread.
- Line up the Mag drill and drap cutter to make a 5/16" thread in the center of the future cut.

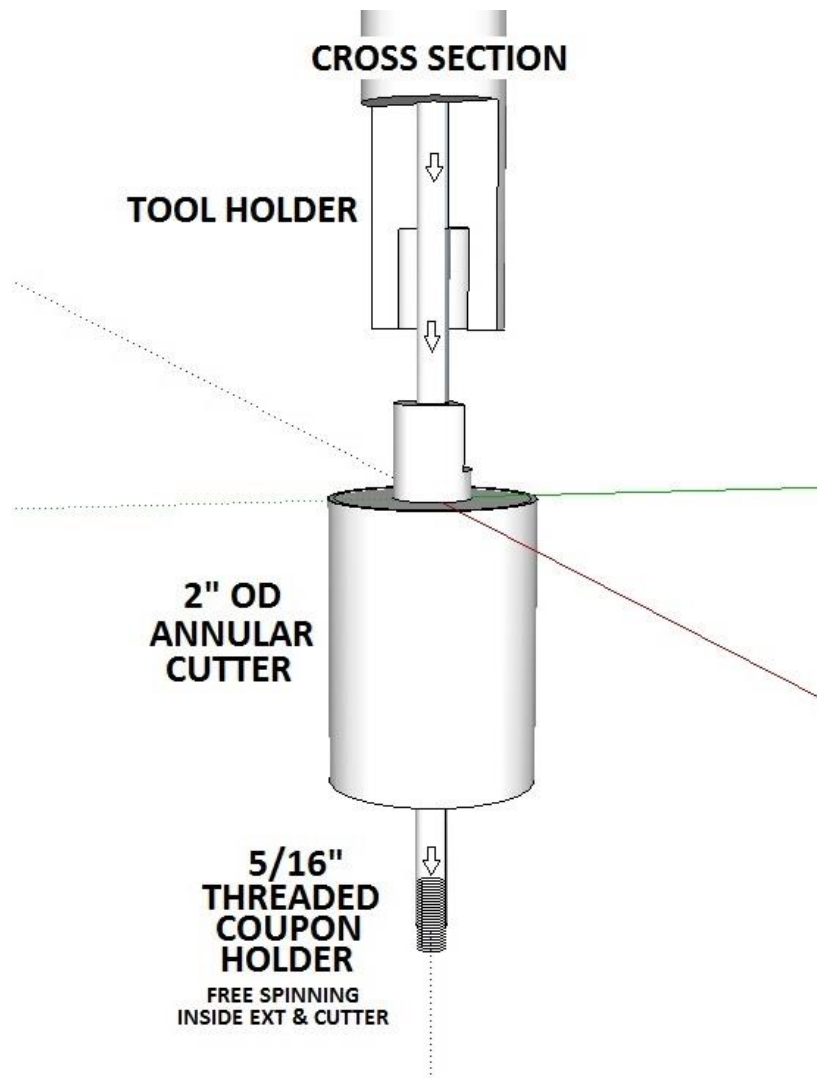


Part 2:

- Next, you will replace the 5/16" drap cutter with the annular cutter. Now you can take the coupon holder and slide it inside the tool holder.



- The coupon holder has a thread on the tip, it also is free spinning inside the extension shaft.
- Finally, with the coupon holder thread locked in place you can start with the mag drill, shaft extension and 2" annular cutter.



COLD TAPPING (Not Live Pipe)

“Get the Plug out”

[Must know Hole Size and Depth of Cut]

Products Needed:

- **Letter (F) Cobalt Drill**
- **½” Chuck Assembly**
- **CT Annular Cutter**
- **Threaded Pin w/Slot (5/16-18)**
- **Insert Bushing**
- **Mag Drill w/Reverse**

PROCESS STEPS

- 1. Drill Hole in pipe**
- 2. Thread Pin into hole**
- 3. Connect Cutter, Bushing and Pin to Mag Drill**
- 4. Cut hole in pipe**
- 5. Reverse the Mag Drill to unscrew the pin**
- 6. The Plug is then removed from the pipe**