



360 Tapping Machine

Operating Specifications

Boring Bar Travel	24" (610 mm)
Tank Taps*	2" to 4" (100 DN)
Pipe Taps*	2" to 6" (150 DN)
THREAD-O-RING™ Plug Setting	2" (50 DN) and 3" (80 DN)
LOCK-O-RING® and LOCK-O-RING Plus Plug Setting	4" (100 DN) and 6" (150 DN)
Maximum Operating Pressure	1,480 psi (100 bar) at 100°F (38°C)
Maximum Operating Temperature	700°F (371°C) at 700 psi (48 bar)**
Power	Manual, Air Motor or Hydraulic
Feed Rate	0.005" (0.127 mm) per revolution
"Lower-In" Crank	12 turns per inch (2 mm per turn)
Length (without measuring rod)	42-3/4" (1,086 mm)
Length (with measuring rod)	70" (1,778 mm)
Meets NACE specification	MR0175-93

* See note 4 in "Recommended Options" Chart. ** For intermittent service only. Maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar).

Assembly Options

Tapping Machines	Model	Type of Drive		Container		Weight
		Air Motor Drive	Hydraulic Motor Drive	Skid *	Steel Carrying Case	
Assembly Number	360b					LB (KG)
12346995	•	•				200 (91)
12346996	•	•			•	300 (136)
12346997	•	•		•		260 (118)
12346998	•		•			205 (93)
12346999	•		•		•	305 (138)
12347000	•		•	•		265 (120)

All basic Tapping Machines include: measuring rod and stop collar, bleeder valve, packing wrenches, "lower-in" crank, and power crank.

* If skid is not purchased with tapping machine, there is special crating charge. Consult factory.

** Manual Drive Tapping Machine is not compatible with an air or hydraulic drive.



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LOCK-O-RING® & LOCK-O-RING® Plus Plug Holders

Size		LOCK-O-RING® Holders			LOCK-O-RING® Plus Holders			LOCK-O-RING® Bypass Gauge		
Inches	DN	Lb.	Kg.	Part Number	Lb.	Kg.	Part Number	Lb.	Kg.	Part Number
2	50	--	--	--	--	--	--	1/2	0.2	07-1723-0000
4	100	5	2	05-0074-0000	5	2	12309297	--	--	
6	150	5	2	05-0074-0000	5	2	12309297			
4-#900	100	--	--	--	5	2	12309298	--	--	
6-#900	150	--	--	--	5	2	12309298	--	--	

Twist Drills

Nominal Tap Size		Actual Size		Weight		Part Number
Inches	DN	Inches	mm	Lb.	Kg.	
2	50	1-7/16	37	6	3	05-0046-0004

Insert Drills

Nominal Tap Size		Actual Size		Weight		Part Number
Inches	DN	Inches	mm	Lb.	Kg.	
1	25	3/4	19	2-1/2	1	05-0047-0001
1-1/4	32	1	25	4	2	05-0047-0002
1-1/2	40	1-1/4	32	5-1/2	3	05-0047-0003

Standard Cutters & Pilot Drills

Nominal Tap Size		Actual Size		Cutters			Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Wt./Lb.	Wt./Kg.	Part Number	Wt./Lb.	Wt./Kg.	Part Number	Part Number
3	80	2-7/16	61.9	1	0.4	05-0001-0001	1/22	0.2	05-0293-0001	00-1424-0012
4	100	3-7/16	87.3	2	0.9	05-0328-0004	1/2	0.2	05-0293-0008	00-1424-0012
6	150	5-15/32	138.9	5-3/4	3	05-0328-0006	2	0.9	05-0293-0002	00-1424-0003

SHORTSTOPP® Cutters & Pilot Drills

Nominal Tap Size		Actual Size		Cutters			Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Wt./Lb.	Wt./Kg.	Part Number	Wt./Lb.	Wt./Kg.	Part Number	Part Number
4	100	3-7/8	98.4	3-1/4	1	05-0330-0004	1/2	0.2	05-0293-0008	00-1424-0012
6	150	5-7/8	149.2	8-3/4	3	05-0330-0006	2	0.9	05-0293-0002	00-1424-0003

STOPPLE® Cutters & Pilot Drills

Nominal Tap Size		Actual Size		Cutters			Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Wt./Lb.	Wt./Kg.	Part Number	Wt./Lb.	Wt./Kg.	Part Number	Part Number
4	100	3-15/16	100	3-1/2	2	05-0329-0004	1/2	0.2	05-0293-0008	00-1424-0012
6	150	5-15/16	150.8	9	4	05-0329-0006	2	0.9	05-0293-0002	00-1424-0003



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Tapping Size-On-Size (Recommended Options)

Cutter Size			
2"	3"	4"	6"
A	A	A	A
B	B	B	B
C	C	C	
D	D	D	
E	E	E	E
F	F	F	

Notes:

- The following letters represent:
 A = Carbon steel pipe SMYS (Specified Minimum Yield Strength) 30,000 to 50,000 psi maximum, tensile strength of 70,000 psi.
 B = Carbon steel pipe SMYS 50,000 to 70,000 psi maximum, tensile strength of 90,000 psi.
 C = Cast iron pipe. Cutting characteristics vary widely; hard to predict.
 D = Chrome-moly, high temperature, steel pipe.
 E = 300 series stainless steel pipe.
 F = Flat-plate cuts using special cutters on the materials listed above (refer to Notes 3 and 4). Pilot drill must be through before cutter tooth engages material.
- The table for selecting power options (above) is based on the latest TDW designs and past experience. The data should be used as a guideline. There have been, and will be, conditions which will not strictly follow the guidelines.
- Special cutters are available for flat plates, stainless steel pipe, cast iron pipe and other special conditions.
- When tapping a larger pipe or tank, the cutter will sometimes go through the flat-plate condition. For example, all teeth are cutting at the same time. This is the most power-consuming condition possible and special cutters may be required. Considering cutter size, diameter of cylinder, wall thickness, feed rates, different materials of construction, etc., there are many possibilities. The following table gives some examples of flat-plate conditions. Any pipe or tank with wall thicknesses greater than those shown will also be considered flat-plate.

Cutter Size	Nom. Pipe x Wall	Nom. Pipe x Wall	Nom. Pipe x Wall
3"	4" x .359"	6" x .232"	8" x .176"
4"	6" x .481"	8" x .357"	10" x .282"
6"	10" x .748"	12" x .616"	14" x .556"

Dimensions and Part Numbers

360 Tapping Machine



T.D. Williamson

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