

# Petersen<sup>®</sup> Hot Tappers

Tap into pipes without interrupting service  
 Insert inflatable stopper plugs into live lines



1/2" to 6" Hot Tap Kit

**Model 261-0020-K Hot Tapper Kit for 1/2" - 2" (12.7-50.8mm)**  
 Tapping sizes: 1/2", 3/4", 1", 1-1/4", 1-1/2", 2"

**Model 261-0060-K Hot Tapper Kit for 1/2" - 6" (12.7-152.4mm)**  
 Tapping sizes: 1/2", 3/4", 1", 1-1/4", 1-1/2", 2", 2-1/2", 3", 3-1/2", 4", 5", 6"

## Single Size Hot Tappers

261-0005	1/2"
261-0007	3/4"
261-0010	1"
261-0012	1-1/4"
261-0015	1-1/2"
261-0020	2"
261-0025	2-1/2"
261-0030	3"
261-0035	3-1/2"
261-0040	4"
261-0050	5"
261-0060	6"



Do Not exceed 120 psi max. (8.27 bar).  
 Do Not exceed 140°F fluid temperature.

Do Not exceed 550 RPM with any size drill.

Accessories available upon request: pipe saddles, pipe valves, drill, flanges, hose, and inflatable stopper plugs.

## Recommended Drill Speeds (RPM)

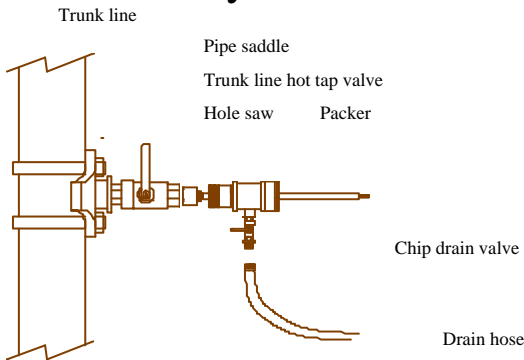
Size	Mild Steel	Cast Iron	Stainless Steel	Size	Mild Steel	Cast Iron	Stainless Steel
1/2"	550	440	295	2-1/2"	135	90	70
3/4"	460	300	230	3"	115	75	55
1"	350	235	175	3-1/2"	95	65	45
1-1/4"	275	180	140	4"	85	55	40
1-1/2"	230	150	115	5"	65	40	30
2"	170	115	85	6"	55	35	25



# HOT TAPPING INSTRUCTIONS

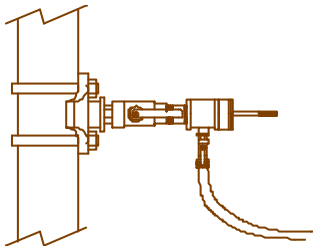
## With Petersen® Hot Tapping Equipment

### Assembly



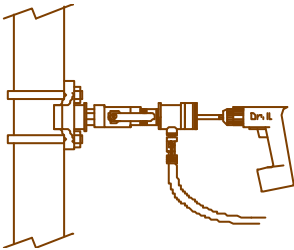
1. Attach pipe saddle to pipe trunk line per manufacturers instructions.
2. Attach trunk line hot tap valve to saddle per manufacturers instructions. Extra care is recommended on these joints as resealing after hot tapping would require relieving trunk line pressure.
3. Attach desired hole saw and pilot bit to Hot Tapper, tighten set screws to prevent units from separating during drilling operation.
4. Attach Hot Tapper unit tightly to trunk line hot tap valve; to prevent leakage of trunk line fluid.
5. Attach a drain hose to the Hot Tapper chip drain valve.

### Testing for Leaks Prior to Hot Tapping



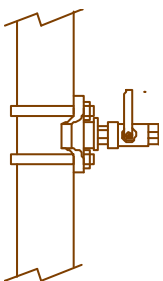
1. Pressurize drain hose with a fluid which is compatible with the trunk line fluid.
2. **CAUTION:** Do Not pressurize drain hose beyond 10% over trunk line pressure, the hose manufacturers recommendations, or higher than 120 psi. (Which ever is the lower pressure.)
3. Open both valves slowly and check for leaks, should leaks occur, immediately reduce pressure. (Any leaks should be repaired prior to Hot Tapping.)
4. Upon completion of leak testing, depressurize drain hose and place other end of hose in a location suitable to accept discharge of drill chips and trunk line fluid.

### Hot Tapping



1. Attach drill, air ratchet, or manual wrench to Hot Tapper, follow related manufacturers operating instructions.
2. Open chip drain valve and fully open trunk line tap valve.
3. Insert Tapper to contact trunk line and drill at recommended RPM.

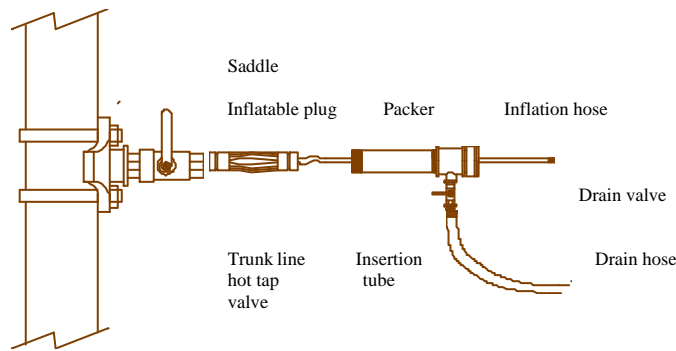
### Removal



1. Retract drill from trunk line tap valve. **CAUTION:** Do Not retract 1/2" drill
2. Fully close trunk line tap valve.
3. Remove drill, hose, and Hot Tapper from trunk line hot tap valve. **CAUTION:** Do Not loosen trunk line tap valve or trunk line pipe saddle or trunk line fluid will escape causing injury to operator or damage to surroundings.
4. The trunk line tap valve is now ready for service, attaching lines, or plug insertion tubes.

# HOT TAP INSERTION OF INFLATABLE PLUG

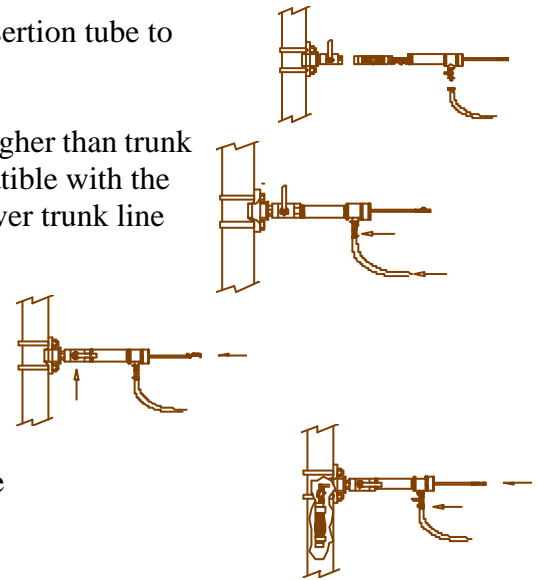
Using Petersen<sup>®</sup> Hot Tapper



## Insertion of Inflatable Plug

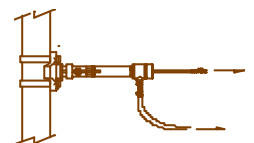
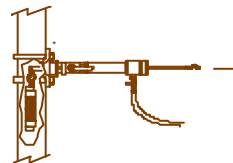
(**Caution:** Some plugs may be damaged during extraction or may require extraction down stream.)

1. Install plug and inflation hose into insertion tube, then attach insertion tube to trunk line hot tap valve.
2. Open drain valve and pressurize through drain hose to slightly higher than trunk line pressure. Pressurize drain hose with a fluid which is compatible with the trunk line fluid. (**Caution:** Do Not pressurize more than 10% over trunk line pressure.)
3. Open trunk line hot tap valve, the pressure from drain hose will push plug into trunk line.
4. When plug is located in trunk line, close drain valve and remove drain hose from pressure source.
5. Pressurize inflatable plug through inflation hose per manufacturers product data tables.



## Extraction of Inflatable Plug

6. Deflate plug through inflation hose.
7. With end of drain hose in suitable location for discharge of trunk line fluid; open drain valve and retract plug from trunk line into insertion tube. (Some plugs may be damaged during extraction or may require extraction down stream.)
8. Fully close trunk line tap valve. Remove Hot Tapper from trunk line tap valve.



**CAUTION:** Do Not loosen trunk line tap valve or trunk line pipe saddle; trunk line fluid will escape and may cause injury to operator and damage to surroundings.

# Petersen<sup>®</sup> Hot Tapper Spare Parts List



½" to 6" Hot Tap Kit

Arbor, Hex for hose saws $\leq$ 1-1/8"	910-8001
Arbor, Hex for hole saws $\geq$ 1-1/2"	910-8002
Drill Bit, ½" x 20"	910-8011
Packing Gland, ¾" mnpt x ½" ID	910-8103
Saw, Hole ¾"	910-9031
Saw, Hole 7/8"	910-9041
Saw, Hole 1-1/8"	910-9061
Saw, Hole 1-1/2"	910-9071
Saw, Hole 1-7/8"	910-9081
Saw, Hole 2-3/8"	910-9083
Saw, Hole 2-7/8"	910-9084
Saw, Hole 3-3/8"	910-9085
Saw, Hole 3-7/8"	910-9087
Saw, Hole 4-3/4"	910-9089
Saw, Hole 5-3/7" Deep cut	910-9091
Drill Shaft, 7/16" x 18"	910-9120
Drill Shaft, 7/16" x 24"	910-9124