



**Transmate**

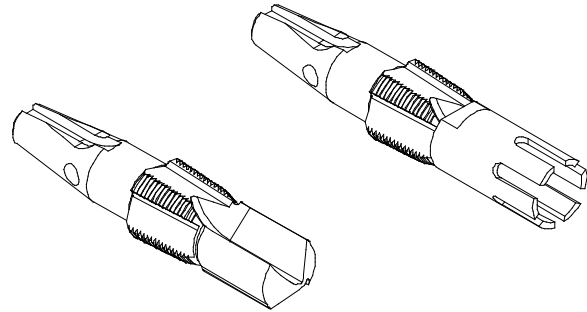
**TapMate Dry Tap**  
**357-00**

Thank you for purchasing the Transmate TapMate Dry Tap. It is designed to provide years of service if the instructions within this manual are followed.

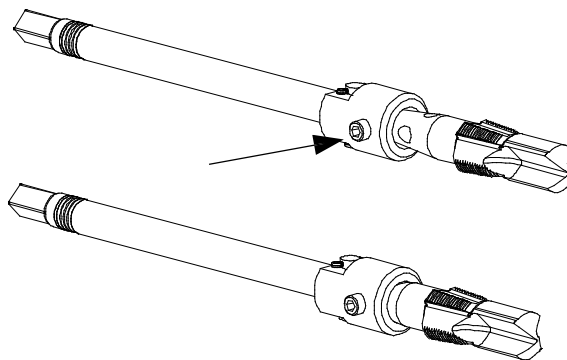
If you have any questions, please call us at 1-800-426-9341



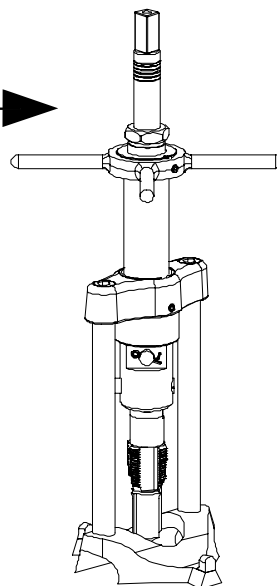
- 1) Select the appropriate drill/tap corresponding to the inlet threads on the corporation stop in use and also the type of pipe.
- 2) Make sure the set screw in the drill/tap holder is not protruding into the holders bore. Insert the drill/tap into the holders bore and tighten the set screw with the  $\frac{1}{4}$ " allen wrench provided. Lubricate the drills tip and edge as well as the taps teeth.



This is the set screw that should not be protruding into the bore

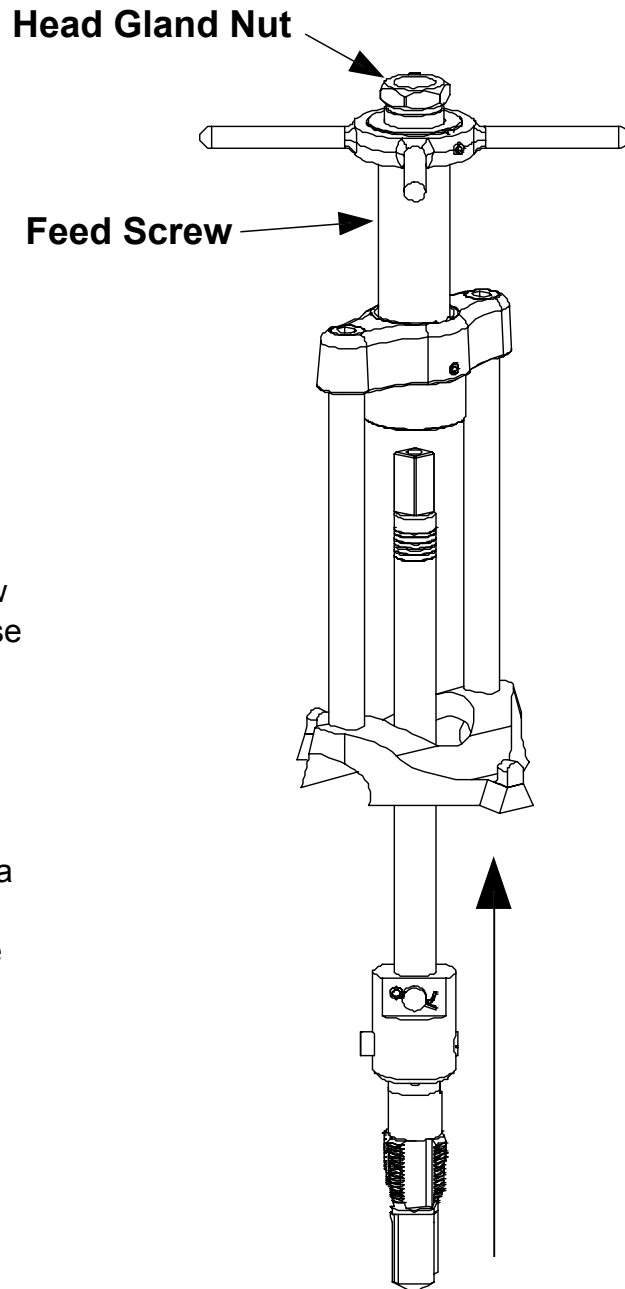


**Starting Position** →

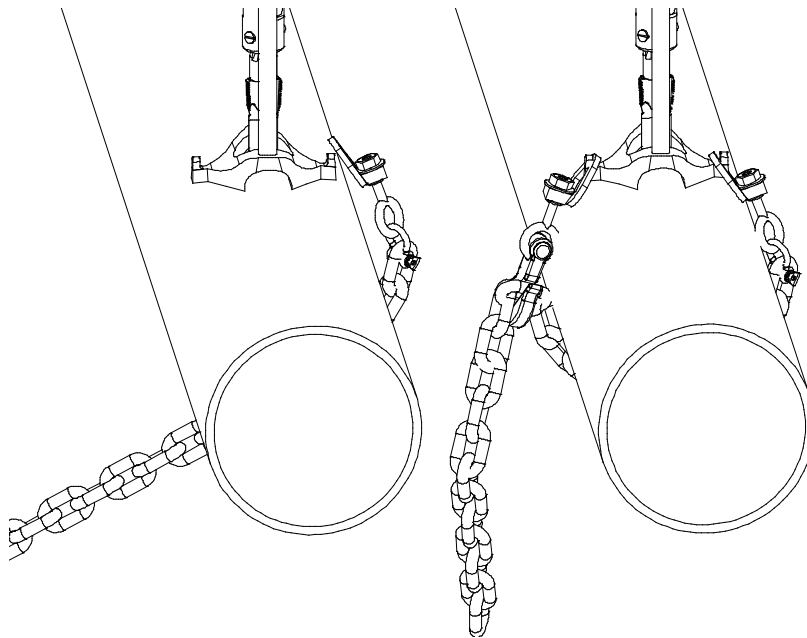


3) Push the holder up into the “Feed screw” and tighten the bronze “Head Gland Nut” located on the top of the machine (with 1 5/16” open end wrench) until snug. Rotate the feed screw back to the starting position which is as far back as the feed screw can be rotated in the counter clockwise direction.

4) Un-screw the eyebolts in the two delta rings out as far as possible, without them separating from the delta ring. Attach one end of the chain to the delta ring eyebolt with the shackle provided.



5) Position the Tapmate Dry Tap™ onto the main. Loop the delta ring (with chain attached) onto one ear of the saddle. Rap the chain around the pipe and slip the chain link into the hook on the other delta ring. Loop this delta ring over the other ear of the saddle. Rotate the Tapmate Dry Tap™ into position and tighten the delta ring nuts equally until the machine is secure.



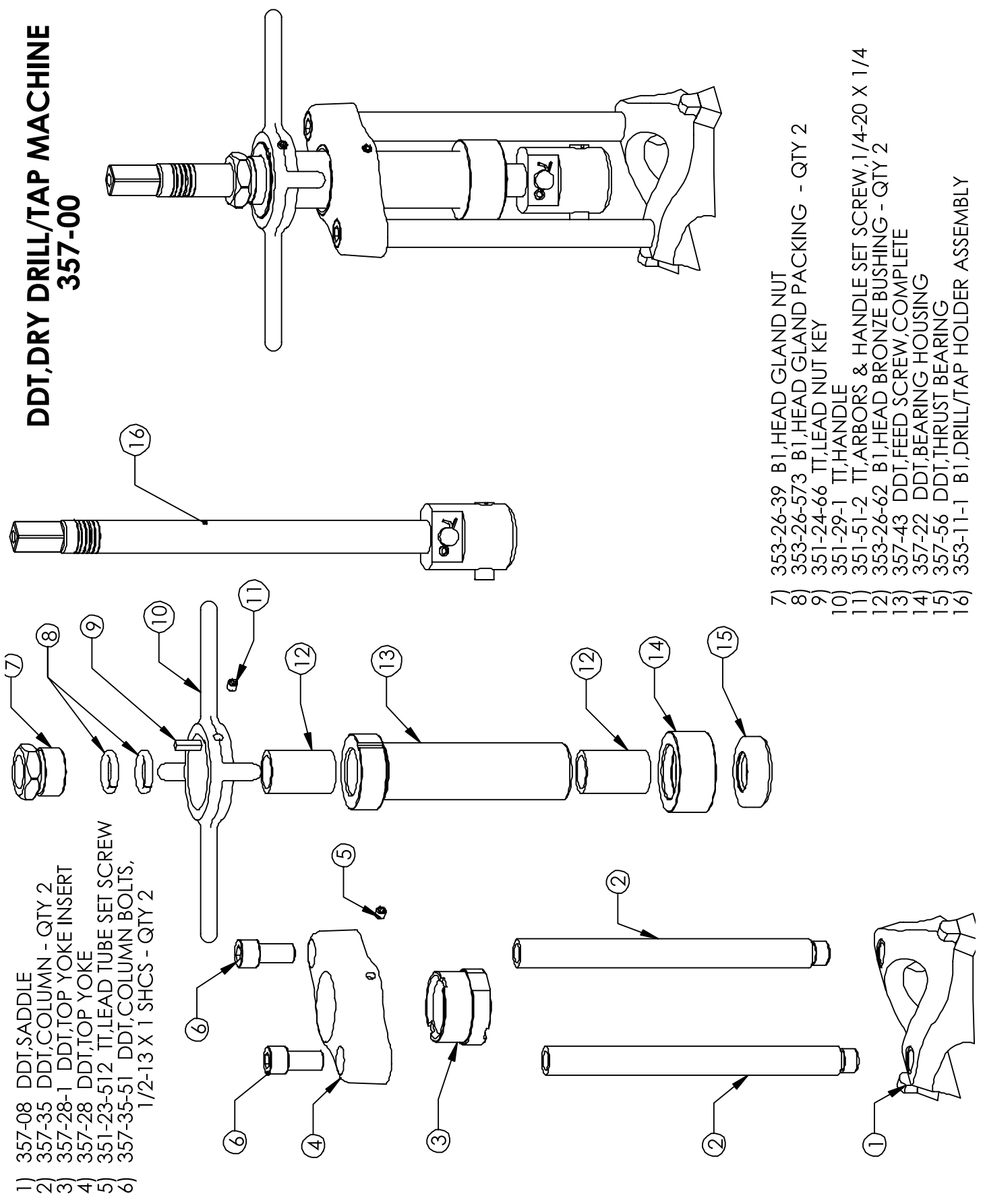
6) Feed the drill/tap down until it contacts the main, by rotating the feed screw in a clockwise direction. Loosen the Head gland nut and begin rotation the holder in a clockwise direction with the “Ratchet wrench”. Once the drill has bored the hole continue feeding the drill/tap down until the tap teeth begin to engage the main. Stop the rotating of the feed screw and continue rotating the holder in a clockwise direction. Tap the main to the desired thread depth.

7) Rotate the holder in the counter clockwise direction until the taps teeth disengage from the main. Tighten the head gland nut until its snug and then rotate the feed screw in a counter clockwise direction until it's at the starting position, without anymore rotating of the holder.

8) Loosen the delta ring nuts and disengage the chain from the machine.

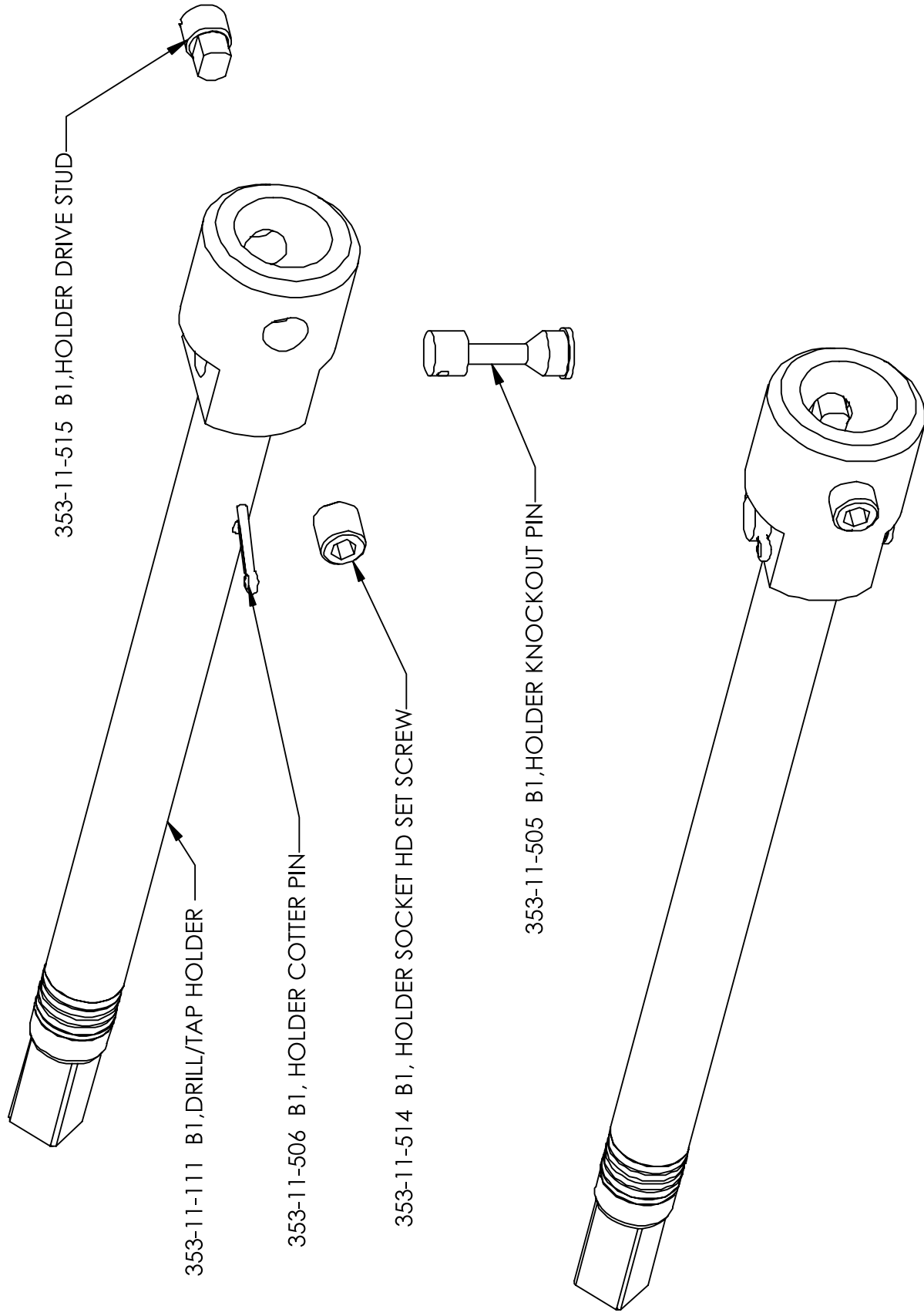
9) Lubricate the feed screw and holder shaft. Store the tapping machine in the box provided.

# DDT, DRY DRILL/TAP MACHINE 357-00



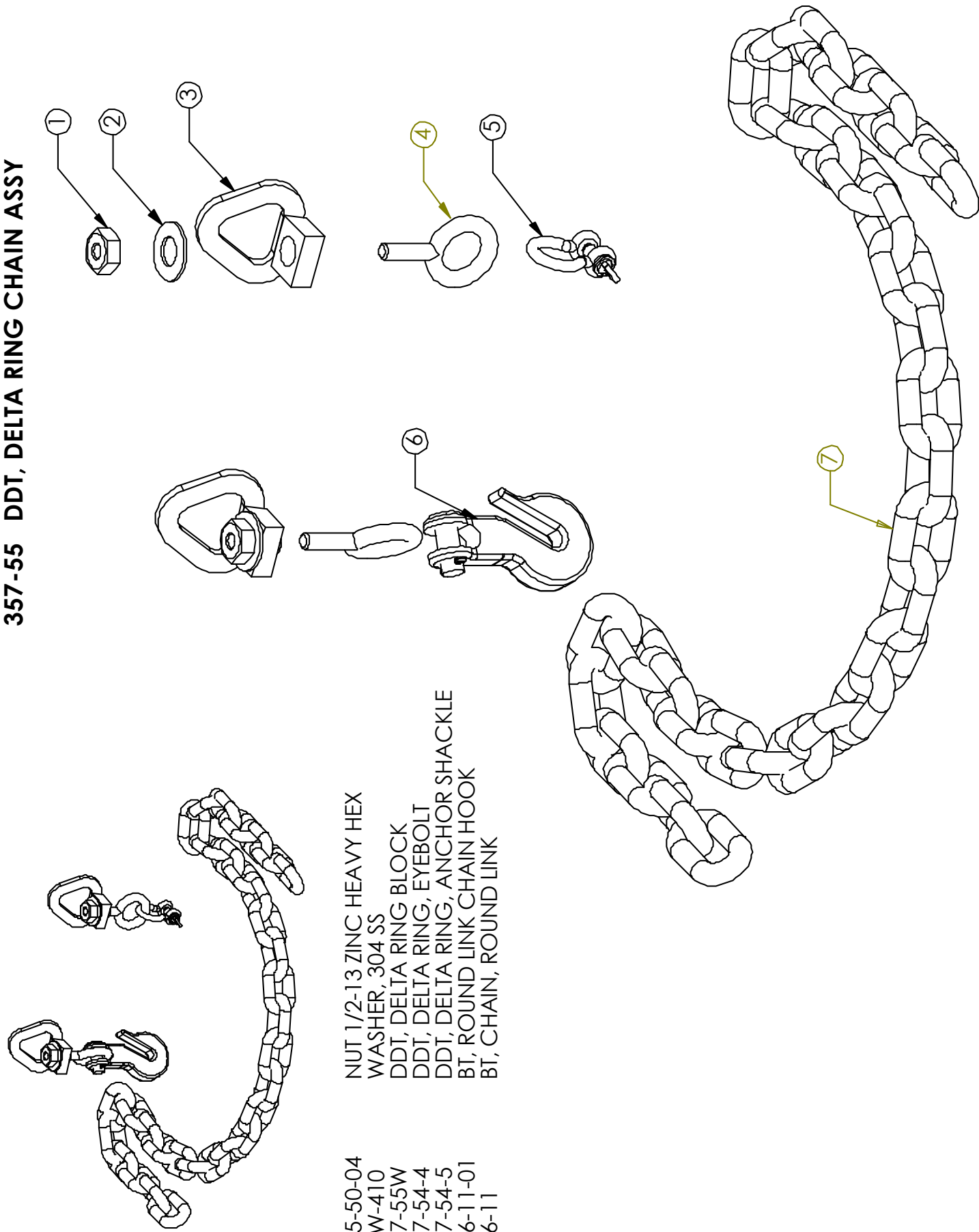
- 1) 357-08 DDT,SADDLE
- 2) 357-35 DDT,COLUMN - QTY 2
- 3) 357-28-1 DDT, TOP YOKE INSERT
- 4) 357-28 DDT, TOP YOKE
- 5) 351-23-512 TT, LEAD TUBE SET SCREW
- 6) 357-35-51 DDT,COLUMN BOLTS,  
1/2-13 X 1 SHCS - QTY 2

- 7) 353-26-39 B1, HEAD GLAND NUT
- 8) 353-26-573 B1, HEAD GLAND PACKING - QTY 2
- 9) 351-24-66 TT, LEAD NUT KEY
- 10) 351-29-1 TT, HANDLE
- 11) 351-51-2 TT, ARBORS & HANDLE SET SCREW, 1/4-20 X 1/4
- 12) 353-26-62 B1, HEAD BRONZE BUSHING - QTY 2
- 13) 357-43 DDT, FEED SCREW, COMPLETE
- 14) 357-22 DDT, BEARING HOUSING
- 15) 357-56 DDT, THRUST BEARING
- 16) 353-11-1 B1, DRILL/TAP HOLDER ASSEMBLY



**B1, DRILL/TAP HOLDER ASSEMBLY 9433-1 353-11-1**

# 357-55 DDT, DELTA RING CHAIN ASSY



- 1) 375-50-04
- 2) 8FW-410
- 3) 357-55W
- 4) 357-54-4
- 5) 357-54-5
- 6) 356-11-01
- 7) 356-11

- NUT 1/2-13 ZINC HEAVY HEX
- WASHER, 304 SS
- DDT, DELTA RING BLOCK
- DDT, DELTA RING, EYEBOLT
- DDT, DELTA RING, ANCHOR SHACKLE
- BT, ROUND LINK CHAIN HOOK
- BT, CHAIN, ROUND LINK