

# SIMTAP™

## Ford SIMTAP™ Drilling Machine Operating Instructions

### WARRANTY - READ BEFORE OPERATING

All merchandise is warranted to be free from defects in material and factory workmanship. We will provide free of charge new products in equal quantities for any that prove defective within one year from the date of shipment from our factory. **Manufacturer should 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 his 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.

DAMAGE CAUSED BY IMPROPER TOOLS OR  
HANDLING WILL VOID OUR WARRANTY

Refer to the FMB website (<http://www.fordmeterbox.com>) for additional and most recent instructions and product information.



THE FORD METER BOX COMPANY, INC.  
P.O. Box 443, Wabash, Indiana, USA 46992-0443  
Phone: 260-563-3171 • FAX: 800-826-3487 • Overseas FAX: 260-563-0167  
<http://www.fordmeterbox.com>

# SIMTAP™

## Drilling Machine Operating Instructions



# FORD SIMTAP™ Operating and Assembly Instructions

**Caution: Follow the pipe manufacturer associations' recommendations. Do not use electric drill. Use of electric drill could result in shock or death.**

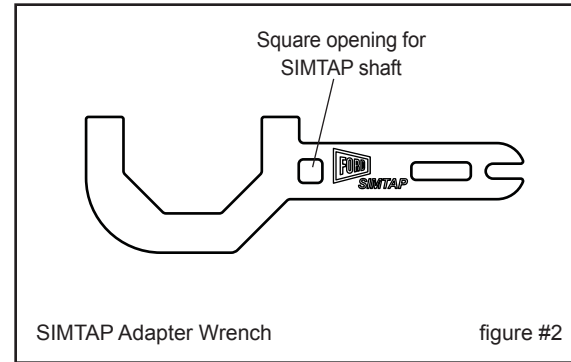
- Remove the body from the case. The body is black in color and is identified by part number SIMDMB. The SIMTAP™ body serves a dual purpose. It is also the 2" Flare Copper Thread Adapter (item #1).
- Choose the appropriate adapter for the corporation stop to be tapped. The adapters are color anodized 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 desired hole size. Hole saws and cutters are generally 1/8" undersized (example: 1" tap uses a 7/8" hole saw). 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 and 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. Open the corporation stop to flush chips prior to service connection.



### Important Tips

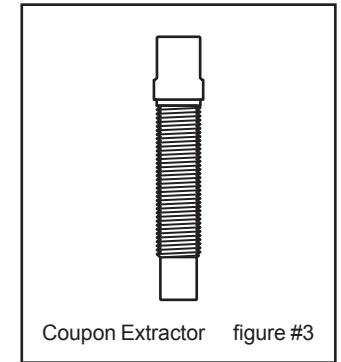
- Maximum drill RPM is 650
- Do not use with a hammer drill or impact driver
- Do not reverse the drill. Only rotate in a clockwise direction
- Do not use grease or lubricant that will allow chips to adhere to the cutters
- For proper coupon retention, the full length of the pilot drill retaining wire 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 (figure #2) for leverage, and to prevent the shaft from turning while removing cutters.
- Use provided coupon extractor (figure #3) 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.

**It's Just That Simple!**



SIMTAP Adapter Wrench

figure #2



Coupon Extractor figure #3

## FORD SIMTAP™ ADAPTERS

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



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