

# 1200 Tapping Machine

Tapping Sizes: 12- to 42-inches

Model 1200M / Completion plug setting sizes 12- to 36-inches

Bulletin No:1000.001.07  
Version: 08.2024  
Supersedes: 1000.001.06 (07.2019)



## Description

Tapping machines are used for making connections to pipelines, tanks and plant piping without shutdown and are used to make hot taps in preparation for plugging machine applications.

T.D. Williamson Model 1200M Tapping Machines are designed to make hot taps into metal pipe, tank tops and walls\*. They are hydraulically operated and are used for making taps from 12- to 42-inches (305 mm to 1067 mm). Maximum working pressure is 1,480 psi (100 bar) at 100°F (38°C). Operating temperature is -20°F (-29°C) to 700°F (371°C) at 700 psi (48 bar) for intermittent service. Maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar).

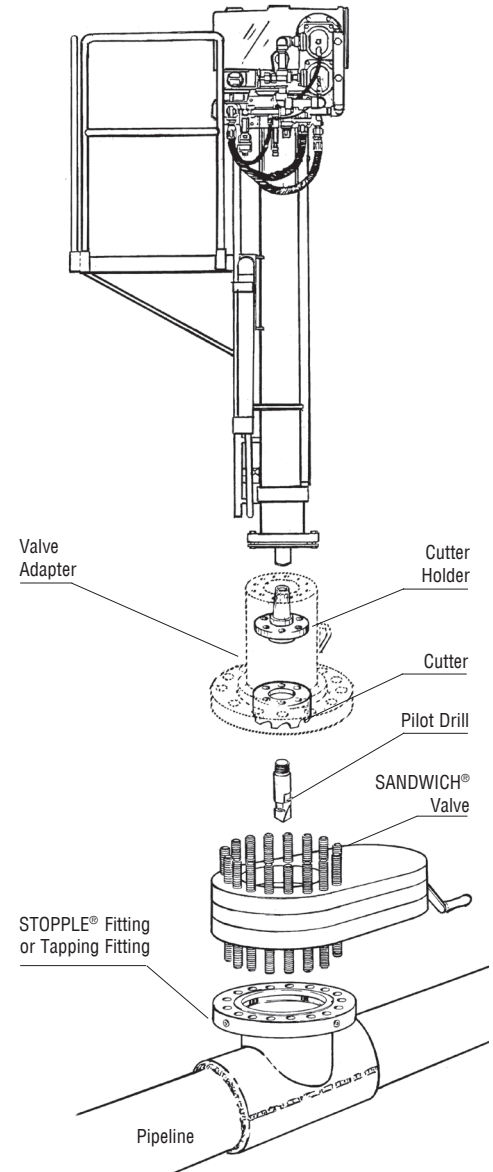
The 1200M Tapping Machine is fitted with a ladder and platform for operator use; meets NACE standard MR0175-2009 (sulfide stress cracking-resistant, metallic material for oilfield equipment; and can be used to install LOCK-O-RING® and LOCK-O-RING® Plus completion plugs from sizes 12- to 36-inches. The Tapping Machine Power Unit is compliant with EPA Tier 4 emission standards, has an emergency air shut-off valve and a four point lift system.

## Features

The basic machine includes:

- Tapping machine
- Ladder and platform
- Hydraulic piping
- Skid
- Connecting hoses
- Power unit
- Two-stage drive motor
- Feed motor
- Crank handle

## Typical Tapping Setup



\* Consult the factory for special cutters and pilots required for tank taps.



T.D. Williamson

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Dimensions and Part Numbers

# 1200 Tapping Machine Model 1200M

	Standard			XL		
	Part Number	Lbs.	Kg.	Part Number	Lbs.	Kg.
Complete System *:	12362620	3280	1487	05-2634-0000-01	3000	1360
Tapping Machine	12362527	1500	680	05-2634-0001	1850	840
Ladder and Platform	05-1079-0000	180	82	05-1080-0000	200	90
Hydraulic Piping	12362619	400	181	05-2635-0000	440	200
Skid	12397125	1200	544	12376647	1300	590
Power Unit with Diesel Engine**	12354757	1650	750	12354757	1650	750
Power Unit with Diesel Engine***	12355725	1700	773	12355725	1700	773

\* Taping Machine, ladder, platform and hydraulic piping included in Complete System 05-2634-0000-01

\*\* Battery and hydraulic fluid not included. Connecting hoses included.

\*\*\* Required for taps larger than 36- inch. Battery and hydraulic fluid not included.

Lengths	Boring Bar Travel		Machine		Machine With Measuring Rod	
	Inches	mm	Inches	mm	Inches	mm
1200	72	1828	110	2794	173	4394
1200 - XL	108	2743	146	3718	231	5867

### Operating Specifications

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	Hydraulically powered (1,800 lb-in. [203N-M] input torque)
Feed	0.004" (0.102 mm) per Revolution
Lower-In Crank	12 Turns per Inch (2.1 mm/turn)

\* For intermittent service only. Maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar).

### Power Unit

Engine: Perkins Diesel	38 hp at 2800 rpm
Pump	Vane Type or Variable Piston
Hydraulic Reservoir Capacity	55 Gallons
Engine Fuel Capacity (Diesel Engine)	10.5 Gallons
Relief Valve Preset at Factory	1,000 psi
Hydraulic Oil Filters	10 Micron
Motors (at tapping machine)	Gear Type
Battery 12-volt, 455 amp, Cold Crank at 0°F	Customer Provided

Cutter Holders	Inches	mm	Lbs.	Kg.	Part Number
	12-30	300-750	17-1/2	7.9	05-0056-0000
	30-36	750-900	17	7.7	05-0278-0000
	38-42	950-1050	29	13.2	05-0324-0000

### Plug Holders

LOCK-O-RING® Plug Holder	12-36	300-900	14	6.4	05-0076-0000
LOCK-O-RING® Plus Plug Holder	12-20	300-510	42	19	05-1383-0000
	22-36	560-900	19	8.6	07-2092-0000

### LOCK-O-RING® Bypass Gauge

	1.0	0.5 grams	07-1723-0000
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# 1200 Tapping Machine Model 1200M

## Adapters for Standard Valves

Nominal Tap Size		ASME Class 150 RF Flange			ASME Class 300 RF Flange			ASME Class 600 RF Flange		
Inches	DN	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number
12	300	170	77	06-5184-0012	255	116	06-5085-0012	268	122	06-5185-0012
14	350	240	109	06-5184-0014	232	105	06-6106-0014	354	161	06-5185-0014
16	400	280	127	06-9333-0016	315	143	06-6106-0016	510	231	06-5185-0016
18	450	329	149	06-5184-0018	363	165	06-6106-0018	560	254	06-5185-0018
20	500	425	193	06-5184-0020	465	211	06-6106-0020	730	331	06-5185-0020
22	550	416	189	06-5184-0022	567	257	06-6106-0022	925	420	06-5185-0022
24	600	612	278	06-5184-0024	786	357	06-6106-0024	1,125	510	06-5185-0024
26	650	633	287	06-5184-0026	920	417	06-6106-0026	1,455	660	06-5185-0026
28	700	700	318	06-5184-0028	1,066	484	06-6106-0028	1,530	694	06-5185-0028
30	750	791	359	06-5184-0030	1,375	624	06-6106-0030	1,875	851	06-5185-0030
32	800	990	449	06-5184-0032	1,580	720	06-6106-0032	2,036	924	06-5185-0032
36	900	1,650	748	06-5184-0036	2,650	1200	06-6106-0036	2,615	1,186	06-5185-0036
38	950	Available on Request			Available on Request			4,064	1,856	06-5087-0038
40	1000	Available on Request			Available on Request			5,042	2,287	06-5087-0040
42	1050	2870	1305	06-5184-0042	Available on Request			5,736	2,601	06-5087-0042

## Adapters for SANDWICH® Valves & Ball Valves (Compatible to set LOCK-O-RING® and LOCK-O-RING® Plus completion plugs)

		ASME Class 150 RF Flange			ASME Class 300 RF Flange			ASME Class 600 RF Flange		
Inches	mm	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number
12	300	280	127	26-3212-1215	330	150	26-3212-1230	410	186	26-3212-1260
14	350	315	143	26-3212-1415	380	173	26-3212-1430	435	198	26-3212-1460
16	400	440	200	26-3212-1615	535	243	26-3212-1630	650	295	26-3212-1660
18	450	500	227	26-3212-1815	630	286	26-3212-1830	770	350	26-3212-1860
20	500	675	307	26-3212-2015	825	375	26-3212-2030	1000	455	26-3212-2060
22	550	--	--	--	--	--	--	1150	523	26-3003-2260
24	600	--	--	--	--	--	--	1460	664	26-3003-2460
26	650	--	--	--	--	--	--	1830	832	26-3003-2660
28	700	--	--	--	--	--	--	2250	1023	26-3003-2860
30	750	--	--	--	--	--	--	2620	1191	26-3003-3060
32	800	--	--	--	--	--	--	3075	1395	26-3003-3260
34	850	--	--	--	--	--	--	3490	1586	26-3003-3460
36	900	--	--	--	--	--	--	4165	1893	26-3003-3660
38	950	--	--	--	--	--	--	4064	2032	06-5087-0038
40	1000	--	--	--	--	--	--	5050	2292	06-5087-0040
42	1050	--	--	--	--	--	--	5750	2615	06-5087-0042



# 1200 Tapping Machine Model 1200M

## Standard Hot Tap Applications

Nominal Tap Size		Actual Size		Standard Cutters			Standard Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number	Part Number
12	300	11-1/2	292	36	16	05-0389-0012	5	2	05-0294-0001	00-1424-0008
14	350	12-3/4	324	42	19	05-0389-0014	5-1/2	3	05-0294-0002	00-1424-0008
16	400	14-11/16	373	55	25	05-0389-0016	6	3	05-0294-0003	00-1424-0008
18	450	15-1/16	383	64	29	05-0388-0016	6	3	05-0294-0003	00-1424-0008
20	500	17	432	84	38	05-0388-0018	6-1/2	3	05-0294-0004	00-1424-0008
22	550	19	483	98	45	05-0388-0020	7-1/2	3	05-0294-0005	00-1424-0008
24	600	21	533	125	57	05-0388-0022	8	3	05-0294-0006	00-1424-0008
26	650	23	584	126	57	05-0388-0024	8-1/2	4	05-0294-0007	00-1424-0008
28	700	25	635	156	71	05-0388-0026	10-1/2	5	05-0294-0008	00-1424-0008
30	750	27	686	232	105	05-0388-0028	11	5	05-0294-0009	00-1424-0008
32	800	29	737	275	125	05-0388-0030	15	7	05-0294-0010	00-1424-0009
34	850	31	787	350	159	05-0388-0032	15	7	05-0294-0010	00-1424-0009
36	900	33	838	395	179	05-0388-0034	18	8	05-0294-0011	00-1424-0009
38	950	35	889	430	195	05-0388-0036	18	8	05-0294-0011	00-1424-0009
40	1000	36-7/8	937	450	204	05-0388-0038	20	9	05-0294-0020	00-1424-0009
42	1050	38-7/8	987	523	238	05-0388-0040	20	9	05-0294-0020	00-1424-0009

## Tapping for STOPPLE® and STOPPLE® Train Plugging Applications

Nominal Tap Size		Actual Size		STOPPLE® Cutters			STOPPLE® Pilot Drills			Spare U-Rods
Inches	DN	Inches	mm	Lbs.	Kg.	Part Number	Lbs.	Kg.	Part Number	Part Number
12	300	11-13/16	300	40-1/2	18	05-0388-0012	5	2	05-0294-0001	00-1424-0008
14	350	13-1/16	332	49	22	05-0388-0014	5-1/2	3	05-0294-0002	00-1424-0008
16	400	15-1/16	383	53-1/2	24	05-0388-0016	6	3	05-0294-0003	00-1424-0008
18	450	17	432	84	38	05-0388-0018	6-1/2	3	05-0294-0004	00-1424-0008
20	500	19	483	98	45	05-0388-0020	7-1/2	3	05-0294-0005	00-1424-0008
22	550	21	533	125	57	05-0388-0022	8	4	05-0294-0006	00-1424-0008
24	600	23	584	126	57	05-0388-0024	8-1/2	4	05-0294-0007	00-1424-0008
26	650	25	635	156	71	05-0388-0026	10-1/2	5	05-0294-0008	00-1424-0008
28	700	27	686	232	105	05-0388-0028	11	5	05-0294-0009	00-1424-0008
30	750	29	737	275	125	05-0388-0030	11	5	05-0294-0009	00-1424-0008
32	800	31	787	330	150	05-0388-0032	15	7	05-0294-0009*	00-1424-0009
34	850	33	838	395	179	05-0388-0034	18	8	05-0294-0011	00-1424-0009
36	900	35	889	430	195	05-0388-0036	18	8	05-0294-0011	00-1424-0009
38	950	36-7/8	937	450	204	05-0388-0038	20	9	05-0294-0020	00-1424-0009
40	1000	38-7/8	987	523	238	05-0388-0040	20	9	05-0294-0020	00-1424-0009
42	1050	40-7/8	1038	606	276	05-0388-0042	20	9	05-0294-0020	00-1424-0009

\*Requires Cutter Holder 05-0278-0000 for making 30-inch (750 mm) taps.