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

The T-101 Drilling Machine is a manual or power-driven machine which taps into pipe while under pressure. It is used for making 1/2' through 4' (DN 15 - DN 100) taps without shutdown. It can be used to install 2” and 3” completion plugs in tapping nipples to permit recovery of tapping valves and to install TDW PIG-SIG® Scraper Passage Indicators.

1/2' through 4' (DN 15 - DN 100) taps without shutdown. It can be used to install 2” and 3” completion plugs in tapping nipples to permit recovery of tapping valves and to install TDW PIG-SIG® Scraper Passage Indicators.

**Features**

The Model T-101B Drilling Machine is available in two versions*: the standard T-101B with 18' of travel and the XL Model with 28' of travel.

The T-101B and T-101B-XL Drilling Machines meet NACE Standard MR0175-93, sulfide stress cracking resistant metallic material for oilfield equipment. The maximum working pressure is 1,480 psi (100 bar) at 100°F (38°C). Its operating temperatures are -20°F (-29°C) to 700°F (371°C) at 700 psi (48 bar) for intermittent service. The maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar). Other features include:

- Lightweight - 32 pounds (XL is 50 pounds)
- Versatile - 1/2” through 4” taps
- Operates to 1,480 psi (2,220 psi for 904 Model)

**Options**

T.D. Williamson, Inc., is committed to providing you with the exact product to assist you in planning, budgeting and meeting the specifications for your individual application needs. The following options are available:

- The T-101 Drilling Machine is furnished with a ratchet crank for manual operation. An optional hose-connected, hand-held air motor can be easily added.

ISO 9001 Certified

* The 904 Drilling Machine is a higher pressure (balanced) version of the T101B XL machine. It is rated at 2,220 psi (150 bar) at 180°F (82°C). For special requirements, such as higher pressure or temperature, consult the factory.
**Features**

The Model 904B Drilling Machine is available in the XL Model with 28-inches of travel.

The 904B Drilling Machine meets NACE Standard MR0175-2002, sulfide stress cracking resistant metallic material for oilfield equipment. The maximum working pressure is 2,220 psi (153 bar) at 100°F (38°C). Its operating temperatures are -20°F (-29°C) to 180°F (82°C) for intermittent service. The maximum continuous rating is 180°F (82°C) at 1,025 psi (48 bar).

The 904B Drilling Machine is a high pressure balanced machine. At this high pressure, it is limited to a maximum of 4-inch (DN 100) taps. For special requirements, such as higher pressure or temperature, consult the factory.

Other features include:
- Lightweight 85 pounds (39 kg)
- Versatile 1/2- through 4-inch taps
- Operates to 2,220 psi

**Options**

T.D. Williamson, Inc. is committed to providing you with the exact product to assist you in planning, budgeting and meeting the specifications for your individual application needs. The following options are available:

- The 904B Drilling Machine is furnished with a ratchet crank for manual operation. An optional hose-connected, hand-held air motor can be easily added or a hand held hydraulic drive option is available.

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

The 904 Drilling Machine is a manual or power-driven machine which taps into pipe while under pressure. It is used for making 1/2- through 4-inches (DN 15 - DN 100) taps without shutdown. It can be used to install 2-inch and 3-inch completion plugs in tapping nipples to permit recovery of tapping valves and to install TDW PIG-SIG® Scraper Passage Indicators.

**Toll Free**
1-888-TDWmSon (839-6766)
360 Tapping Machine

Sizes: 2-to 6-inch

Model 360A and 360B

**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.

Model 360 Tapping Machines can be either manual or hydraulically operated and are used for making tank and pipe taps from 2” to 6”. Its maximum working pressure is 1,480 psi (100 bar) at 100°F (38°C). Its operating temperature is -20°F (-29°C) to 700°F (371°C) at 700 psi (48 bar) for intermittent service. Its maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar).

**Features**

The basic machine includes:
- Lower-in crank
- Measuring rod
- Ring gasket
- Bleeder valve and nipple
- Motor adapter
- Set of bolts and nuts
- LOCK-O-RING® bypass gauge

**Options**

T.D. Williamson is committed to providing you with the exact product to assist you in planning, budgeting and meeting the specifications for your individual application needs. The following options are available:
- The Model 360A Tapping Machine is manually operated.
- The Model 360B Tapping Machine is air or hydraulic operated.

* For design code options not listed and additional sizes, consult your sales representative.

Patented in the United States and in other countries.

ISO 9001 Certified
Model 660C Tapping Machines can be either air or hydraulically operated and are used for making pipe and tank taps from 3” to 12” (DN 80 to DN 300). Its maximum working pressure is 1,480 psi (100 bar) at 100°F (38°C). Its operating temperature is -20°F (-29°C) to 700°F (371°C) at 700 psi (48 bar) for intermittent service. Its maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar).

This model features a split-frame for lower maintenance costs and ease of packing replacement.

### Features

The basic machine includes:
- Lower-in crank
- Measuring rod
- Retainer rod pusher
- Ring gasket
- Bleeder valve and nipple
- Motor adapter
- Set of bolts and nuts
- LOCK-O-RING® bypass gauge
- Capability to set LOCK-O-RING® and LOCK-O-RING® Plus completion plugs

### Options*

T.D. Williamson is committed to providing you with the exact product to assist you in planning, budgeting and meeting the specifications for your individual application needs. The following options are available:
- Model 660c Tapping Machine can be either air or hydraulically operated with optional dual drive.
- A flywheel can be installed on the tapping machine. It enhances performance of the tapping machine due to inertia and reduced stress on the gears.
- Hydraulic feed system can be installed as an option. It will assist technician to lower the completion plug during plug setting process.

* For design code options not listed and additional sizes, consult your sales representative.
**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.

Tapping machines are also used to set completion plugs such as LOCK-O-RING® or LOCK-O-RING® Plus plugs after completion of hot tapping and plugging operations.

Model 760C Tapping Machines can be either air or hydraulically operated and are used for making pipe and tank taps from 3" to 16" (DN 80 to DN 400). Its maximum working pressure is 1,480 psi (102 bar) at 100°F (38°C). Its operating temperature is -20°F (-29°C) to 700°F (371°C) at 700 psi (48 bar) for intermittent service. Its maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar). This model features a split-frame for lower maintenance costs and ease of packing replacement.

**Features**

The basic machine includes:

- Lower-in crank
- Measuring rod
- Retainer rod pusher
- Ring gasket
- Bleeder valve and nipple
- Motor adapter
- Set of bolts and nuts
- LOCK-O-RING® bypass gauge
- Capability to set LOCK-O-RING® and LOCK-O-RING® Plus completion plugs

**Options**

T.D. Williamson is committed to providing you with the exact product to assist you in planning, budgeting and meeting the specifications for your individual application needs. The following options are available:

- Model 760C Tapping Machine can be either air or hydraulically operated with optional dual drive.
- A flywheel can be installed on the tapping machine. It enhances performance of the tapping machine due to inertia and reduced stress on the gears.
- Hydraulic feed system can be installed as an option. It will assist technician to lower the completion plug during plug setting process.

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* For design code options not listed and additional sizes, consult your sales representative.

Patented in the United States and in foreign countries. ISO 9001 Certified
860 Tapping Machine
Sizes: 4- through 20-inch  Model 860b

Description

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

The 860 Tapping Machine is hydraulically operated and is used for making pipe and tank taps from 4- to 20-inch (DN 80 to DN 500). It includes an electric start, diesel power unit. Its maximum working pressure is 1,480 psi (100 bar) at 100°F (38°C). Its operating temperature is -20°F (-9°C) to 700°F (371°C) at 700 psi (48 bar) for intermittent service. Its maximum continuous rating is 350°F (177°C) at 1,025 psi (70 bar).

This model features a split frame for lower maintenance costs and ease of packing replacement.

Features

The basic machine includes:
- Lower-in crank
- Measuring rod
- Retainer rod pusher
- Ring gasket
- Bleeder valve and nipple
- Motor adapter
- Set of bolts and nuts
- LOCK-O-RING® bypass gauge
- Convenient storage with tapping machine atop power unit
- Speed control without changing power unit RPM
- Pendant Control System (50°)

ISO 9001 Certified

Toll Free
1-888-TDWmSon (839-6766)
**936 Tapping Machine**

Sizes: 12- to 36-inch

Model 936E

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### 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.

The 936 Tapping Machine is hydraulically operated and is used for making pipe and tank taps from 12- to 36-inch. Its operating temperature is 0°F (-18°C) to 180°F (82°C) at 2,220 psi (153 bar). For temperatures above 180°F (82°C), consult the factory.

The 936 Tapping Machine’s unique pressure balanced system eliminates the effects of pipeline pressure, reducing operating loads on the feedscrew.

The 936 Tapping Machine meets NACE standard MR0175 (sulfide stress cracking resistant metallic material for oilfield equipment).

### Features

The basic machine includes:
- Tapping machine
- Ladder and platform
- Hydraulic piping
- Skid
- Connecting hoses
- Power unit
- 2-Stage drive motors
- Feed motor
- Pressure-balance system

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

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Patented in the United States and in foreign countries.
ISO 9001 Certified

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**Typical Tapping Setup**

![Diagram of Tapping Setup](image-url)
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.

- **Description**

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

- **Features**

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

  Patented in the United States and in other countries.

  ISO 9001 Certified

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

Patented in the United States and in other countries.

ISO 9001 Certified
The basic machine includes:
- Tapping machine
- Ladder and platform
- Hydraulic Piping
- Skid
- Connecting hoses
- Power unit
- Twin-drive motors
- Feed motor

T. D. Williamson, Inc., is committed to providing you with the exact product to assist you in planning, budgeting and meeting the specifications for your individual application needs.

The hydraulically powered 2400 has an optional electronic remote control system. The remote control unit gives the operator the advantage of remaining inside a temperature-controlled building while completing jobs in extreme climate conditions.

* For design code options not listed and additional sizes, consult your sales representative.

Features

* Typical Tapping Setup

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.

Model 2400 tapping machines are designed to make hot taps into metal pipe, tank tops and walls. It is hydraulically operated and is used for making pipe and tank taps from 30' to 60'. Its operating temperature is -20°F (-29°C) to 200°F (93°C) at 1,200 psi (82 bar).

Patented in the United States and in foreign countries.
ISO 9001 Certified

Toll Free
1-888-TDWmSon (839-6766)
Air Motors
For T-101b, T-101XL, TD-12, 904, 904XL Sizes 1/2” Through 6”

T.D. Williamson, Inc.’s Air Motors are efficient tools for operating TDW drilling machines. The Air Motors are designed for horizontal and vertical installation. These machines are designed to allow safe taps to be made in piping systems while under pressure.

High torque, PISTOL GRIP Air Motor with ½-inch male square drive head with ball detent attachment oiler.

Powerful, high torque, RIGHT ANGLE Air Motor with ½-inch male square drive head with ball detent attachment. Needle valve included for air supply regulation.

Caution: Improper use of Air Motors may result in Operator injury. Consult operating instructions before using your equipment.

Description

Features

The PISTOL GRIP Air Motor includes an auxiliary handle, which can be rotated 360 degrees. Also, these hand-held drills have an automatic oiler and a safety button for locking in the off position.

The RIGHT ANGLE Air Motor includes an air supply regulator to adjust revolutions per minute (RPM). It also includes a reversible direction, spring-loaded trigger for immediate release and stopping of Air Motor.

Toll Free
1-888-TDWmSon (839-6766)
In the pipeline industry, it is sometimes necessary to isolate a section of pipe without interrupting the service to a customer, whether that customer is a large user such as a steel mill or a private homeowner. The same necessity may also arise in a refinery or a petrochemical plant where it is desirable to avoid the shutdown of an entire unit. STOPPLE® Plugging Equipment has been developed by T.D. Williamson, Inc., to safely meet these requirements.

STOPPLE® Plugging Machines serve as temporary block valves installed anywhere in a piping system. They are used to isolate a section of line for repairs or additions without interruption of service.

The STOPPLE® Plugging Machine consists of three major sections: a hydraulic cylinder or jackscrew, a plugging head housing and a plugging head. It is available for pipe sizes 4" (DN 100) and larger. Its maximum operating temperature is 180°F (82°C).
Typical Applications
Plugging Without Shutdown – Typical Procedure

1. Weld Fittings

STOPPLE® Fittings with LOCK-O-RING® Flanges* are welded on each end of the section to be isolated. Bypass fittings with LOCK-O-RING Flanges and equalization fittings are welded to the line.

*See LOCK-O-RING Flanges, Bulletin 1120.001.00.

2. Make Taps

A SANDWICH® Tapping Valve* is mounted on each fitting and taps are made through the valves into the pipeline. The cutter is withdrawn after each tap, the valve closed, and the tapping machine removed.

*See SANDWICH® Valve, Bulletin 1020.001.00.

3. Plug Line

STOPPLE® Plugging Machines are mounted and the plugging heads are lowered through valves into sealing position. After the new section is tied in, pressure is equalized by connection from the STOPPLE® Housing to the pipeline (See A).

4. Recover Valves

Tapping machine cutters are replaced with LOCK-O-RING® Plugs, and tapping machines (or machine) are mounted on valves. The LOCK-O-RING® Plugs are lowered into position inside LOCK-O-RING® Flanges. Tapping machines are removed, valves recovered, and blind flanges installed.
**Typical Applications**

**Current and Future Expansion**

**Typical Option Flange Application/Planning for Future Expansion**

During new construction, a tee with LOCK-O-RING® Flange is welded to the line. Later, when a branch connection is needed, a full bore valve is installed and the LOCK-O-RING® Plug is removed with a tapping machine. A crossover line is then connected to the valve.

**Typical Branch Valve Application**

A special tee with a LOCK-O-RING® Flange is mounted on the LOCK-O-RING® Fitting. A new branch is installed on the outlet of the tee. A valve and tapping machine are installed on top of the tee. The tapping machine raises the LOCK-O-RING® Plug to the top LOCK-O-RING® Flange. The tapping machine and valve are removed and a blind flange installed.

**Typical Booster Station Application**

LOCK-O-RING® Flanges and Plugs are installed during initial construction to permit easy installation of a booster station at a later date. Illustrations depict general fitting applications only. Refer to TDW instruction manual for technical procedures. Never operate equipment without training.

T.D. Williamson, Inc.  P.O. Box 3409  Tulsa, Oklahoma 74101-3409  918-447-5100  Fax: 918-446-6327  www.tdwilliamson.com

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Typical Applications
Installation Anywhere in a Piping System

As Typical Equipment Isolation

Suction Header
Compressor
Faulty 20" Valve
STOPPLE® Plugging Machine
New 10" Valves

Isolation for Repair

TDW Services technicians are available around the clock to assist plant operators in tapping and plugging applications.

A compressor breakdown in the vapor recovery section of a large refinery created a problem for the operating company when a 20-inch block valve failed to hold.

A means was needed for isolating the compressor for repairs. This isolation was accomplished with TDW tapping and plugging equipment.

While the compressor was isolated and repairs were completed, a pair of new 10-inch block valves were installed on the suction lines leading to the compressor. This was done because the faulty 20-inch block valve could not be removed from the suction line.

Line Blocked for Modification

An 18-inch butterfly valve in a line carrying air to a cat cracker regenerator failed to operate properly.

TDW STOPPLE® Plugging equipment blocked the line temporarily while the valve was removed. However, after removing the valve, inspectors found it to be non-repairable. A decision was made to reinstall the valve, locking it in full open position. Workmen then modified the system to permit operation of the air line until the new valve could be delivered. The plugging machine was removed and a LOCK-O-RING® Plug was installed.

Later, when the valve was delivered, a TDW Plugging Machine was reinstalled to permit recovery of the temporary valve and installation of the new one.

TDW Customer Services offers short courses in the operation and maintenance of our tapping and plugging equipment in a choice of low, intermediate or high pressure ranges.
Features/Options

LOCK-O-RING® Plugs Make Equipment Recovery Possible

Step 1
Upon completion of a tapping or plugging job, the temporary valve is recovered by setting a LOCK-O-RING® Plug in the LOCK-O-RING® Flange.

Step 2
A LOCK-O-RING® Plug is installed on the boring bar of the tapping machine. The machine is mounted on the tapping valve.

Step 3
The valve is opened and the tapping machine boring bar is extended to lower the plug into position inside the LOCK-O-RING® Flange.

Step 4
The flange segments are advanced into the plug groove. The tapping machine is released from the plug holder and the boring bar is retracted.

Step 5
The tapping machine and the valve are removed. The plug holder is removed from the plug.

Step 6
The blind flange is installed. The plug may be removed at any time to provide re-entry into the pipeline.

Detailed Plug Options

LOCK-O-RING® Plugs are welded to scarfed pipe spacers to install original coupons inside tapped holes to eliminate pigging hazards.

A special “flow through” LOCK-O-RING® assembly with guide bars will allow flow to pass into a branch line and permit pigs to traverse the opening.
TDW STOPPLE® Plugging Machines serve as temporary block valves installed anywhere in a piping system. They are used to isolate a section of line for repairs or additions without interruption of service.

The STOPPLE Plugging Machine consists of three major sections: a hydraulic cylinder or jackscrew, a plugging head housing, and a plugging head.

Operation of the hydraulic STOPPLE Plugging Machine is easy due to the location of the control valve, which is positioned at the lower end of the hydraulic cylinder. The hydraulically operated control bar has a direct reading scale visible to the operator, enabling him to know the plugging head position at all times.

- The TDW STOPPLE Plugging Machine is available for pipe sizes 4” (DN 100) and larger.
- Its maximum operating temperature is 180°F (82°C).

* For design code options not listed and additional sizes, consult your sales representative.

Features

- ISO 9001 Certified

Typical Setup

STOPPLE® Fitting

Hydraulic Cylinder

Bleeder Valve

Housing

Equalization Connection

Plugging Head

SANDWICH® Valve

Equalization Connection

STOPPLE® Fitting

ISO 9001 Certified

Toll Free

1-888-TDWmSon (839-6766)
SANDWICH® Valves
Sizes: 4-inch and larger

SANDWICH® Valves are designed for use with TDW Tapping Machines, TDW STOPPLE® Plugging Machines, and fittings with LOCK-O-RING® Flanges during hot tapping and plugging operations. SANDWICH Valves have flat-faced, serrated gasket surfaces and are supplied to match ASME Class 150, 300, 400 or 600 flanges.

SHORTSTOPP® 500 requires the use of 4” through 12” ASME Class 300 SANDWICH Valves.

Description

The SANDWICH Valve is bidirectional and can be installed on the fitting in any direction as long as the bore of the valve is in line with the fitting bore. The valve can be oriented parallel or perpendicular to the pipeline to fit the excavation.

Other design features of the SANDWICH Valve include an oversized bore, positive shutoff, a built-in pressure equalizing valve and integral flange studs.

Options

T. D. Williamson, Inc., is committed to providing you with the exact product to assist you in planning, budgeting and meeting the specifications for your individual application needs. The following options are available:

Available in sizes 4” (100 mm) through 22” is hand operated, 24” and larger valves are hydraulically operated.

Toll Free
1-888-TDWmSon (839-6766)
Steel Repair Sleeves

Half-Sole Segments, Sizes: 2- through 48-inch

T.D. Williamson provides a variety of alternatives to pipeline maintenance needs. The Steel Repair Sleeve is one such option. With the Steel Repair Sleeve, repairs can be made without shutting down the pipeline. Steel Repair Sleeves are available in a variety of sizes, from 2- through 48-inch.

The Steel Repair Sleeves are sold in the Half-Sole configuration. The Half-Sole segment can be used as a pad or cradle while a pair of Half-Sole segments can be used to create a full-encirclement steel sleeve. Steel Repair Sleeves may be made from rolled plate material. This maintenance option is ideal to repair defects in pipelines.

There are four types of material available for the Steel Repair Sleeves, two pressure-rated steels and two structural-grade steel. The pressure-rated steel sleeves can be used to repair leaking and non-leaking defects while the structural-grade steel sleeves can function as reinforcement for a defective area.

Steel Repair Sleeves can be used for internal and external corrosion, gouges, dents, grooves, arc burns, cracks, defective girth welds, laminations and leaks.

Pressure containing sleeves feature a wall thickness equal to or greater than required for the maximum allowable operating pressure or the full strength of the pipe being repaired. The Steel Repair Sleeve material is certified and the carbon equivalent (long formula) will not exceed 0.45 percent. Each half-sole segment comes with one pre-crimped back-up strip.

Steel Repair Sleeves can be used as pads or cradles for above ground piping, drain tile supports and patches (segments in 90° and 180° arcs, from 6-inches to 10 feet in length are available as specials).

Each Steel Repair Sleeve has standard bevels with a back-up strip and material certifications. Sleeve ends are square cut. Back-up strips are not included with Standard Girth Weld Steel Repair Sleeves but are available as special order.

NOTE: Steel Repair Sleeves are sold as single half-sole segments.

Girth Weld Steel Repair Sleeves are only sold as sets of two, half-sole segments.
STOPPLE® Fittings are full-branch split tees designed for use with TDW plugging machines. The design has undergone extensive strain-gauge and pulsation testing. The average cyclic lives of the fittings are 30% greater than other designs tested. STOPPLE Fittings are furnished with LOCK-O-RING® Flanges drilled and faced to match ASME Class 150, 300, or 600 flanges. Other ASME Class ratings are available upon request.

These reduced branch, split tee fittings are furnished with LOCK-O-RING Flanges for use as bypass fittings.

Factory welding of TDW STOPPLE fittings is 100% radiographically inspected at all TDW manufacturing plants except Nivelles, Belgium, where 100% ultrasonic examination is used.

Option

Reducing Branch Fitting

* 22", 26", 28" are Type C

Toll Free
1-888-TDWmSon (839-6766)
LOCK-O-RING® Flanges and Plugs

Sizes: 4- Through 36-inch

Description

LOCK-O-RING® Flanges and Plugs are used as a means of recovering tapping valves after a STOPPLE® Plugging Machine operation. They are used in new construction to permit future expansion of a pipeline or a piping system.

Providing a pressure-tight seal over the tapped holes, LOCK-O-RING Flanges eliminate the need for valves until such time as valves may be necessary. For example, fittings with LOCK-O-RING Flanges and Plugs are installed on the line during construction.

Later, when branch connections are needed, valves can be installed on the fittings and the LOCK-O-RING Plugs removed with a tapping machine. In some applications, LOCK-O-RING Flanges entirely eliminate the need for permanent valves.

Features

LOCK-O-RING Flanges are drilled and faced to match ASME Class 150, 300 or 600 flanges.

LOCK-O-RING Flanges are mounted on STOPPLE® Fittings. They are also used on reduced branch fittings and plain nipples (See Bulletin 1100.001.00).

For pig guides in side openings, a special flow-through LOCK-O-RING® assembly with guide bars will allow full flow into a branch line and will permit pigs to traverse the opening.

Patented in the United States and in foreign countries.

ISO 9001 Certified

Toll Free
1-888-TDWmSon (839-6766)
Tapping Fittings
Sizes: 2- through 30-inch

Description

Tapping Fittings are full-branch or reducing-branch split tees designed for use when installing branch lines. They are equipped with ASME Class 150, 300, 600. RF or RTJ flanges.

Fitting sleeves are an extruded type design. They are manufactured from a pressure-vessel quality, normalized, killed carbon steel plate with hardness below Rc22.

The Charpy impact value of the sleeves at -50°F is available on request.

Features

Flange-to-sleeve weld joints and sleeves are designed to meet pressure and reinforcement requirements of ASME codes, and are available in Class 150, 300 and 600. Other ASME Class ratings available upon request.

Fittings are manufactured with a controlled carbon equivalent to make welding easier in harsh outside environments.

All pressure-containing welds on the fittings have undergone X-ray inspection per ASME requirements.

Options

Use the grid inside to develop the part number for the tapping fitting of your choice.*

If the desired fitting meets standard specifications, it can be shipped from stock within two weeks in most cases.

Contact the factory for information concerning ordering of split sleeves (tees).

*Please confirm your choice with a Factory Representative

Toll Free
1-888-TDWmSon (839-6766)
Tapping fittings are full-branch split tees designed for use when connecting branch lines. They are offered in sizes 4- through 12- and 16-inch and meet B31.3 specifications for use in refinery and chemical plant piping systems. Fittings are equipped with RF or RTJ flanges.

are manufactured from a pressure-vessel quality, normalized, killed carbon steel plate with hardness below Rc22.

The Charpy impact value of the sleeves at -50°F is 15 ft-lbs average with 12 ft-lbs minimum.

Flange-to-sleeve weld joints and sleeves are designed to meet pressure and reinforcement requirements of ASME codes, and are available in Class 150, 300 and 600. Other ASME Class ratings available upon request.

Fittings are manufactured with a controlled carbon equivalent to make welding easier in harsh environments. Back-up strips are provided for all fittings.

All pressure-containing welds on the fittings have undergone X-ray inspection per ASME requirements. Fitting sleeves are an extruded type design. They

Rapid delivery: If the desired fitting meets standard specifications, it can be shipped from stock within two weeks in most cases.

Choice of flanges.

Available also to ASME B31.4 and B31.8 specifications.

For B31.1, consult factory.

Use the grid inside to develop the part number for the tapping fitting of your choice*

Contact the factory for information concerning ordering of split sleeves (tees).

*Please confirm your choice with a Factory Representative

New fittings incorporate a designed and manufactured offset allowing the placement of back-up strips

Tapping Fitting
Blind flange, studs, nuts and gasket sold separately

TDW Tapping Fittings
ASME B31.3 - Sizes: 4- through 12- and 16-inch

TDW Tapping Fittings
ASME B31.3 - Sizes: 4- through 12- and 16-inch

TDW Tapping Fittings
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TDW Tapping Fitting
Blind flange, studs, nuts and gasket sold separately

Options

Rapid delivery: If the desired fitting meets standard specifications, it can be shipped from stock within two weeks in most cases.

Choice of flanges.

Available also to ASME B31.4 and B31.8 specifications.

For B31.1, consult factory.

Use the grid inside to develop the part number for the tapping fitting of your choice*

Contact the factory for information concerning ordering of split sleeves (tees).

*Please confirm your choice with a Factory Representative

ISO 9001 Certified

Toll Free
1-888-TDWmSon (839-6766)
Pressure and Temperature Ratings

- **10-inch 600 LB A105 Flange and A516 GR 70 Sleeve**
  - Temperature: -20 to 700°F
  - Pressure: 750 to 965 PSI

- **10-inch 600 LB A105 Flange and A537 CL1 Sleeve**
  - Temperature: -20 to 700°F
  - Pressure: 885 to 950 PSI

- **12-inch 600 LB A105 Flange and A516 GR 70 Sleeve**
  - Temperature: -20 to 700°F
  - Pressure: 730 to 930 PSI

- **12-inch 600 LB A105 Flange and A537 CL1 Sleeve**
  - Temperature: -20 to 700°F
  - Pressure: 855 to 915 PSI

- **16-inch 600 LB A105 Flange and A516 GR 70 Sleeve**
  - Temperature: -20 to 700°F
  - Pressure: 775 to 965 PSI

- **16-inch 600 LB A105 Flange and A537 CL1 Sleeve**
  - Temperature: -20 to 700°F
  - Pressure: 885 to 950 PSI
Tapping fittings are full-branch split tees designed for use when connecting branch lines. They are offered in sizes 4- through 12- and 16-inch and meet B31.4 specifications for use in pipeline transportation systems for liquid hydrocarbons and other liquids. Fittings are equipped with RF or RTJ flanges.

Fitting sleeves are an extruded type design. They are manufactured from a pressure-vessel quality, normalized, killed carbon steel plate with hardness below Rc22.

The Charpy impact value of the sleeves at -50°F is 15 ft-lbs average with 12 ft-lbs minimum.

Flange-to-sleeve weld joints and sleeves are designed to meet pressure and reinforcement requirements of ASME codes, and are available in Class 150, 300 and 600. Other ASME Class ratings available upon request.

Fittings are manufactured with a controlled carbon equivalent to make welding easier in harsh environments. Back-up strips are provided with all fittings.

All pressure-containing welds on the fittings have undergone X-ray inspection per ASME requirements.

Options

- Rapid delivery: If the desired fitting meets standard specifications, it can be shipped from stock within two weeks in most cases.
- Choice of flanges.
- Available also to ASME B31.3 and B31.8 specifications
- For B31.1, consult factory.

Use the grid inside to develop the part number for the tapping fitting of your choice*

Contact the factory for information concerning ordering of split sleeves (tees).

*Please confirm your choice with a Factory Representative
Tapping Fittings
ASME B31.8 - Sizes: 4- through 12- and 16-inch

Description

Tapping fittings are full-branch split tees designed for use when connecting branch lines. They are offered in sizes 4- through 12- and 16-inch and meet B31.8 specifications for use in gas transmission and distribution piping systems. Fittings are equipped with RF or RTJ flanges.

Features

- Flange-to-sleeve weld joints and sleeves are designed to meet pressure and reinforcement requirements of ASME codes, and are available in Class 150, 300, and 600. Other ASME Class ratings available upon request.

- Fittings are manufactured with a controlled carbon equivalent to make welding easier in harsh environments. Back-up strips are provided with all fittings.

- All pressure-containing welds on the fittings have undergone X-ray inspection per ASME requirements.

- Fitting sleeves are an extruded type design. They are manufactured from a pressure-vessel quality, normalized, killed carbon steel plate with hardness below Rc22.

- The Charpy impact value of the sleeves at -50°F is 15 ft-lbs average with 12 ft-lbs minimum.

Options

- Rapid delivery: If the desired fitting meets standard specifications, it can be shipped from stock within two weeks in most cases.

- Choice of flanges.

- Available also to ASME B31.3 and B31.4 specifications

- For B31.1, consult factory.

Use the grid inside to develop the part number for the tapping fitting of your choice*

Contact the factory for information concerning ordering of split sleeves (tees).

*Please confirm your choice with a Factory Representative

Toll Free
1-888-TDWmSon (839-6766)
No. 3 Branch Connection Fittings
Sizes: 2- Through 24-inch

The No. 3 Branch Connection fitting is a saddle fitting welded directly to the pipe. The following are additional features.

- All three classes of the fitting are rated to 700°F.
- When desired, a full encirclement reinforcing saddle is welded around the installed fitting, providing additional support and strength.
- Both the LOCK-O-RING® and LOCK-O-RING® Plus versions accept a completion plug and blind flange, permitting removal of the tapping valve (see note).

Note: The No. 3 Branch Connection Fitting with LOCK-O-RING® Plus Flange is available exclusively through TDW Services, Inc. Call 1-800-828-1988 for more information.

Options include:
- A choice of three flanges is available: Tapping, LOCK-O-RING, or LOCK-O-RING Plus (see note).
- Available in Class 150, 300 or 600
- With or without a full encirclement reinforcing saddle
- Choice of BUNA-N, Viton or EPDM O-Ring with LOCK-O-RING Flange and reinforcing saddle.
- Pressure ratings shown are for suffix option 10 @ 100°F only. Consult factory for additional ratings for higher temperatures.

Features

Description

TDW has developed the Class 150, 300 and 600 No. 3 Branch Connection Fitting, designed to meet B31.3 requirements for refinery and chemical plant applications in sizes 2- through 24-inch. These fittings can be used on standard weight and larger pipe. Three different types of flanges are available along with a full encirclement reinforcing saddle.

Options

- A choice of three flanges is available: Tapping, LOCK-O-RING, or LOCK-O-RING Plus (see note).
- Available in Class 150, 300 or 600
- With or without a full encirclement reinforcing saddle
- Choice of BUNA-N, Viton or EPDM O-Ring with LOCK-O-RING Flange and reinforcing saddle.
- Pressure ratings shown are for suffix option 10 @ 100°F only. Consult factory for additional ratings for higher temperatures.

No. 3 Branch Connection Fitting
STOPPLE® Fitting Shown

Full Encirclement Reinforcing Saddle
Optional

ISO 9001 Certified

Toll Free
1-800-828-1988

T.D. Williamson, Inc.
P.O. Box 3409
Tulsa, Oklahoma 74101-3409
918-447-5100 Fax: 918-446-6327 www.tdwilliamson.com

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WEDGE-LOCK® Pipe Plugs
For 2- Through 14-inch

WEDGE-LOCK® Pipe Plugs are used for plugging pipe ends temporarily during such operations as testing piping and vessels, welding fittings to pipe ends without hazard of flammable vapors, and propelling pigs by compressed air.

Description

Features

WEDGE-LOCK® Pipe Plugs are available in sizes 2" through 14", and each size seals a variety of pipe inside diameters.

Options

Special clamps are available to support the pipe in higher pressure applications.

Patented in the United States and in foreign countries.
ISO 9001 Certified

Toll Free
1-888-TDWmSon (839-6766)
THREAD-O-RING™ Fittings
For Sizes: 2- and 3-inch

Description

THREAD-O-RING™ Fittings (T-O-R) are used with TDW STOPPLE® Plugging Machines as purge and equalization fittings. They can also be installed during new construction and used for blowdown connections on either side of a block valve. T-O-R Fittings are available in two sizes: 2” and 3” (DN 50 and DN 80).

The 2” T-O-R Fitting will accept the corrosion test coupons, thermometer wells, gauge adapters and other instrument probes.

The 2” T-O-R Fitting has a maximum operating pressure of 3600 psi (248 bar). The 3” fitting has a maximum operating pressure of 1500 psi (103 bar). Both sizes have a maximum operating temperature of 180°F (82°C).

Features

The complete THREAD-O-RING Fitting consists of: cap, plug, O-ring, and nipple.

THREAD-O-RING Fitting taps can be made without shutdown using the TDW T-101 Drilling Machine or the 360 Tapping Machine.

Two-inch T-O-R Plugs are set using either the T-101 Drilling Machine or the 360 Tapping Machine.

Three-inch T-O-R Plugs can be set with the 360 Tapping Machine only.

One of the many uses of the THREAD-O-RING Fitting is as a purge and equalization fitting during plugging operations on pipelines and plant piping.

ISO 9001 Certified

Toll Free
1-888-TDWmSon (839-6766)
THREAD-O-RING™ Flanged Fittings

Size: 2-inch

Description

THREAD-O-RING™ Flanged Fittings are used with TDW Tapping Machines as purge and equalization fittings. They can also be installed during new construction and used for blowdown connections on either side of a block valve.

In addition, the THREAD-O-RING Flanged Fitting will accept the corrosion test coupons, thermometer wells, gauge adapters and other instrument probes.

The THREAD-O-RING Flanged Fitting has a maximum operating pressure per the ANSI Class and Schedule and has a maximum operating temperature of 180°F (82°C).

Features

The complete THREAD-O-RING Flanged Fitting consists of: flange, plug, O-ring, and blind flange kit.

THREAD-O-RING Flanged Fitting taps can be made without shutdown using the TDW T-101 Drilling Machine or the 360 Tapping Machine.

The 2-inch THREAD-O-RING™ Plugs are set using either the T-101 Drilling Machine or the 360 Tapping Machine.

One of the many uses of the THREAD-O-RING Flanged Fitting is as a purge and equalization fitting during tapping operations on pipelines and plant piping.

ISO 9001 Certified

Toll Free
1-888-TDWmSon (839-6766)
Spherical 3-WAY™ Tee
with LOCK-O-RING® Flange - Sizes: 4- through 24-inch

Description

The 4-inch through 24-inch spherical three-way fittings are designed for use with STOPPLE® Plugging Equipment to temporarily stop flow in a line. A side or bottom outlet in the fittings permits installation of a bypass around the area where flow is stopped to keep the line in service. Spherical three-way fittings are furnished with LOCK-O-RING® Flanges drilled and faced to match ASME Class 150, 300 or 600 flanges. Other ASME Class ratings are available upon request. These fittings are available in 4- through 24-inch sizes.

Features

Spherical three-way fittings are compact and low-profile, with a side outlet at the same level as the main. With 4-inch through 12-inch sizes, the bottom half of the fitting can also be repositioned 180 degrees from the flange to create a bottom outlet. For 16-inch and larger sizes, the fitting must be specifically ordered as either a side or bottom outlet. Whether the outlet is to the side or on the bottom, the STOPPLE® Plugging Head can stop flow in the main line while flow continues through the outlet. These fittings may be used for lateral line tie-in, temporary relocation, or permanent relocation projects.

Spherical three-way fittings are designed to a maximum operating temperature of 180°F (82°C) as per ASME B31.4, or 100°F (38°C) as per ASME B31.8. All fittings are stamped with a serial number for complete material traceability. Material Test Reports are available upon request. Factory welding of these fittings is 100 percent radiographically inspected.

Options

After work is completed, a LOCK-O-RING® Completion Plug can be installed in the neck of the fitting, permitting removal of the tapping valve. A blind flange can be installed, providing protection for the plug.
TDW's History with the Water and Wastewater Industry

- In the early 1950s, TDW performed the first successful modification to a live operating water system.
- TDW offers folding plugging equipment and specialized fittings.
- TDW performed the first concrete plugging application.
- TDW provides sixty offices around the world.
- TDW holds ISO 9001 & 9002 certifications.
- TDW performs a successful application on a 96" diameter pipe in 1995.
- TDW has over a dozen registered engineers on staff.
The U-SEAL™ Casing Seal allows maximum flexibility for carrier pipe movement and concentric installations. The seal is held firmly in place by stainless steel bands and clamps. It comes in sizes 2" (50 mm) and larger.

The Z-SEAL™ Casing Seal is a thick, heavy-duty casing seal for installations where an extra rugged seal is desired.

Stainless steel bands hold the seal firmly in place. Z-SEAL Casing Seals come in sizes 2" (50 mm) and larger.

The flexible U-SEAL is designed for unique installations and maintains its seal regardless of the pipe position in relation to the casing. Two stainless-steel bands with adjustable double-end clamps hold the U-SEAL firmly in place. A screwdriver is the only tool needed for installation. The U-SEAL will withstand temperatures to 235°F (112°C).

The Z-SEAL is designed for installations where an extra-rugged seal is required. It is designed for use on pipe that is centered at the casing ends. A screwdriver is the only tool needed to tighten the stainless-steel bands and there are extra points for tightening on the larger sizes. The Z-SEAL will withstand temperatures to 235°F (112°C).

Typical Applications

U-SEAL™ Casing Seal

The U-SEAL can be installed two ways. The top drawing shows the "U" shape which provides for ample flexibility. It can also be installed with the shorter band on the outside.

Z-SEAL™ Casing Seal

The heavy-duty Z-SEAL will withstand the weight of backfill earth. No shield is required.
The M-2 Plastic THINSULATOR® pipe insulator is a high-density, polyethylene product, injection molded to provide low cost insulators of highest quality. This high-density polyethylene gives the M-2 such strength that it is made more compact than other insulators.

Features

The flexible M-2 Plastic THINSULATOR conforms to the pipe for uniform coating loading. Its low friction coefficient enables it to slide easily inside the casing.

Electrical properties include its dielectric strength: short time, 1/8” thickness, 500 volts/.001 inches (D149-64).

The casing insulator has robust mechanical properties. The tensile strength is rated at 4,000 psi at 20 inches/minute. Elongation is 25% at 20 inches/minute. It is resistant to impact fracture, with a notched toughness rating of 9 ft. lbs./in. (5 Joules/cm).

For best results, do not use above 120°F (50°C).

Options

The M-2 Plastic THINSULATORS are available in sizes 2” through 48”.

Extra points are available for tightening, if needed to fit bare or coated pipe, for which a screwdriver is the only tool required.

<table>
<thead>
<tr>
<th>M-2 Plastic THINSULATOR®</th>
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<td>8”, 10”, 12” (4 Segments)</td>
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<th>M-2 Plastic THINSULATOR®</th>
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<tr>
<td>2”, 3”, 4” (2 Segments)</td>
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<th>M-2 Plastic THINSULATOR®</th>
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<tr>
<td>6” (3 Segments)</td>
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</table>

Description

The M-2 Plastic THINSULATOR® pipe insulator is available in sizes 2” through 48”.

Extra points are available for tightening, if needed to fit bare or coated pipe, for which a screwdriver is the only tool required.
Standard Centering Cradles are used to center the pipe in the end of the casing, making it easy to install TDW Z-SEAL™ Casing Seal. The cradles also carry the weight of backfill dirt and insulate the pipe from the casing. They are recommended for use with TDW Concentric Support Insulators. Nonconcentric 3-Way Cradles restrain pipe in all directions. They are used with U-SEAL™ Casing Seals.

Concentric Support Insulators feature larger support runners at the bottom to center the pipe inside the casing. Ample clearance is allowed by the smaller runners to permit free movement into the casing. Cables and runners are nonconductive. This insulator is easily installed using either a speed wrench or ratchet.

Note: 3-Way Cradles cannot be secured to pipeline and should not be used as a substitute for insulators.

Ends joined by rubber tubing over swaged thimbles.

TDW Z-SEAL™ Casing Seal

Concentric Support Insulator

Standard Centering Cradle

3-Way Cradle

Insulators & Casing Cradles
Sizes up to 42-inch

T.D. Williamson, Inc.  P.O. Box 3409  Tulsa, Oklahoma 74101-3409  918-447-5100  Fax: 918-446-6327  www.tdwilliamson.com

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