

FAQ

A-3 Machine

Q: “The two studs inside the end of the boring bar have been damaged or sheared off. How do I fix this?”

A: Excessive torque can cause these studs to bend or shear. Excessive torque is caused by the use of dull combined drills and taps or dull combined shell cutters and taps or trying to final tighten a corporation stop into the main using the A-3 machine.

The studs are not field replaceable. A new boring bar (580967) is required.

A: Improper insertion of the tool shank in the boring bar. If the tool shank is not inserted far enough into the boring bar to allow the retaining screw to engage the “dimple”, the tool will be loose during the operation and cause the damage. The tool retaining screw (62501) should also be checked to make sure the bullet nose of this screw is not damaged. Replace, if damaged.

Q: “Can I convert my A-2 machine to an A-3 machine?”

A: Yes. To convert your A-2 machine to an A-3 machine you will need to replace the boring bar with the A-3 boring bar complete (#580893) and replace the feed nut and yoke with the A-3 feed nut and yoke (#580894). All other parts are the same.

Q: “My by-pass relief valve is not working.”

A: Disassemble the by-pass relief valve assembly and clean all parts. Use the by-pass clean out tool (50529) to re-tap and clean out the threaded portion of the machine by-pass. Replace the seat washer (#42042) and the seat nut washer (#40049) and any other damaged parts and re-assemble.

Q: “The Gate assembly does not open completely.”

A: Check the body offset (where gate sits when fully open) to see if pipe chips and cutting grease have accumulated. If this is the problem, use the body-cleaning chisel (part #40205) to remove the build up chips and grease.

Q: “I cannot get the body to seal on the small saddle gasket and I have replaced the small saddle gasket.”

A: Check the bottom of the body for damage. If the surface is warped or damaged, replace the body (part #503147).

Q: “The machine is requiring more torque to operate. What can I do?”

A: Check your combined drill and tap or combined shell cutter and tap to make sure the cutting edges are sharp and your tools are not missing any tapping teeth. Replace the tool if damaged or sharpen if dull.

A: Check the friction collar (part #580610) to make sure the top and bottom bearings rotate freely. If these bearings do not rotate freely, replace the friction collar and check the underside of the feed yoke (part #580894) for damage. Replace the feed yoke if damaged. Check threads on the feed sleeve (503141) and cap (part # 503148) for wear or damage and replace if necessary.

Q: “I am having trouble producing good threads in the pipe during the tapping operation.”

A: Several operational errors can cause improper threads.

A: When tapping ductile or cast iron, the tapping line on the boring bar should be flush with the top of the feed sleeve to assure proper thread depth. Traveling past this point could produce an oversized hole. Stopping short of tapping line could produce an undersized hole.

A: The feed nut and yoke should not be used to force the boring bar down during the entire thread-tapping portion of installation. This can deform the threads. The feed nut and yoke should be used only to catch a couple of threads in the main.

Q: “When do I use the power clevis?”

A: The power clevis is used to control the boring bar movement when working at line pressures above 90 PSI.

Note: Operating instruction manual for the A-3 Machine (Form 8541) is available by contacting MUELLER Customer Service Dept. at 1-800-423-1323.

MUELLER CO. offers a sharpening service for the cutting equipment. Contact your local distributor for pricing and details.