



## 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).

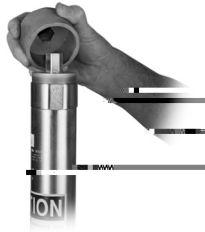
The 904B Drilling Machine is a high pressure balanced machine. At this high pressure, it is limited to a maximum of 4-inch (DN 100) taps. For special requirements, such as higher pressure or temperature, consult the factory.

Other features include:

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

## Dimensions and Part Numbers

### Drilling Machine



- The cap locks the feed and rotation of machine to set and retrieve completion plugs.

Item	Wt./ Lb.	Wt./Kg.	Part Number
904B XL Drilling Machine	85	39	05-1046-0000
Includes: Ratchet Crank			00-1443-0001
Cap			05-1028-0046
Bleeder Valve			00-0774-0001
Nipple			00-0220-0001
Packing Wrench			05-0184-0020
Optional Equipment:			
Air Motor	8	4	05-2160-0000
Hydraulic Drive (w/ 60' Hoses)	30	14	05-1026-0000
Drive Socket			00-1509-0004
Steel Carrying Case (XL)	20	9	05-2152-0000
Plug Holder for 2" THREAD-O-RING™ Plug			05-0185-0001
Plug Holder for 2" and 3" SHORTSTOPP® Completion Plug			08-2120-0000

### Operating Specifications

Maximum Operating Pressure	2220 psi (153 bar) @ 100°F (38°C)
Maximum Operating Temperature	180°F (82°C) @ 700 psi (48 bar)

### Drilling Machine Specifications

Item	Standard Model (XL)	
	Inches	mm
Boring Bar Travel	28	711
Overall Length	70 3/4	1797
Boring Bar Extension/Revolution	0.125	3.2
Feed Mechanism	Hand-Fed Machine	
2-inch 900# Flange	Standard	
2-inch NPT Adapter	Standard	

### Accessories for PIG-SIG® IV Installation

Item	Part Number
Drill for wall thickness more than 3/8 in. (9.5mm)	05-0193-0001
Valve Adapter for Cutter or Drill - for use on 2 in. (50 mm) threaded valve	00-0706-0016
2 in. (50 mm) THREAD-O-RING™ Plug Holder	05-0185-0001
2 in. (50 mm) ASME Class 600 conventional valve with 2-1/16 in. (53mm) through-bore is recommended for use in making PIG-SIG® IV Taps.	

# 904 Drilling Machine

Drills	Drill Diameter		Drill Length		Valve Size		Part Number
	Inches	DN	Inches	mm	Inches	mm	
	1/2	12.7	6	150	1-1/4 - 2	32-50	05-0203-0005
	1/2	12.7	22-1/4	565	1	25	05-0189-0001
	3/4	19.0	6	150	1-1/4 - 2	32-50	05-0203-0009
	3/4	19.0	22-1/4	565	1	25	05-0189-0002
	1	25.0	6	150	1-1/4 - 2	32-50	05-0203-0012
	1-1/4	32.0	6	150	1-1/2 - 2	40-50	05-0203-0013
	1-7/16	36.5	7-3/8	187	1-1/2 - 2	40-50	05-0193-0001

Hole Saws/Cutters and Holder Pilots	Tap Size		Cutter Diameter		Size-on-Size		Not Size-on-Size
	Inch	DN	Inch	mm	Hole Saw/Cutter Part No.	Holder Pilot Part No.	Holder Pilot Part No.
	1-1/4	32	1-5/16	33.3	00-1151-0005	05-1094-0000	05-0290-0000
	1-1/2	38	1-9/16	39.7	00-1151-0009	05-0275-0000	05-0290-0000
	2	50	1-7/8	47.6	05-0179-0002	05-0204-0000	05-0207-0000
	3	80	2-7/8	73.0	05-0179-0003	05-0204-0000	05-0207-0000
	4	100	3-7/8	98.4	05-0179-0004	05-0205-0000	05-0228-0000

Threaded Valve Adapters	Inches	DN	Part Number	Maximum Pressure	
				psi	Bar
	1	25	06-1223-0001	1480	100
	1-1/4	32	00-0757-0012	1480	100
	1-1/2	38	00-0757-0011	1480	100
	2	50	00-0706-0015	1480	100
	3	80	06-1303-0001-02	1480	100

Flanged Valve Adapters - ASME Class	Inches	DN	Class 150 RF	Class 300 RF	Class 600 RF	Class 900 RJT
3	80	06-1318-0015	06-1318-0030	06-1318-0060	-*	
4	100	06-1302-0015	06-1302-0030	06-1302-0060	-*	

\*Consult Factory

Valve Dimensions for Making Taps	Nominal Size		Minimum Bore	
	Inches	DN	Inches	mm
	2	50	2-1/16	52.4
	3	80	3-1/16	72.8
	4	100	4-1/32	102.4

