

Model HTK COSASCO® Two-Inch System Hot Tap Kit

Specifications:

- **Pressure Rating — 3600 PSI**
- **Compatible With 2" System**
- **Access Without Shutdown**

The COSASCO® Hot Tap Kit, (Part No. 126248), is designed to provide a means of adding the COSASCO® Access System to any pipeline or vessel already on stream without shutdown and without product loss. RCS recommends Access Fitting locations be planned for during the original design stage of the project, and installation performed prior to flow operations. However, the Hot Tap offers a safe, reliable method of trepanning a clean hole into the pipe vessel when access is desired or required later, when it is impractical to shut down.

In use, the desired COSASCO® Access Fitting Assembly is selected and the fitting welded into place on the pipeline or vessel. The integrity of the weld is determined by using the Hydrostatic Test Assembly, Part No. 121328, a component of the Kit. The Hot Tap Hollow Plug Assembly, together with the selected cutter, is then inserted into the Access Fitting Body.

The cutter shaft of the Hot Tap is rotated clockwise to trepan a hole of the same diameter as the Access Fitting Body bore (1.375 , 34.925 mm). A hand operated ratchet, adjustable wrench, or low RPM motorized power may be used. With the use of another component of the Kit, the Chip Remover Assembly (Part No. 127147 or 123492) excess cuttings can be removed and retained after trepanning. (Carbon Steel Pipes only).



Hot Tap Cutters are supplied in three styles; Square End Mill (Part No. 209557) to spotface the trepan area; 4-tooth Cutter (Part No.203510) recommended for wall thicknesses in excess of 5/16" (7.938 mm); and 6-tooth Cutter (Part No. 123921) for thinner pipewalls through 5/16". Normally, the entire operation can be safely completed in approximately 20 minutes.

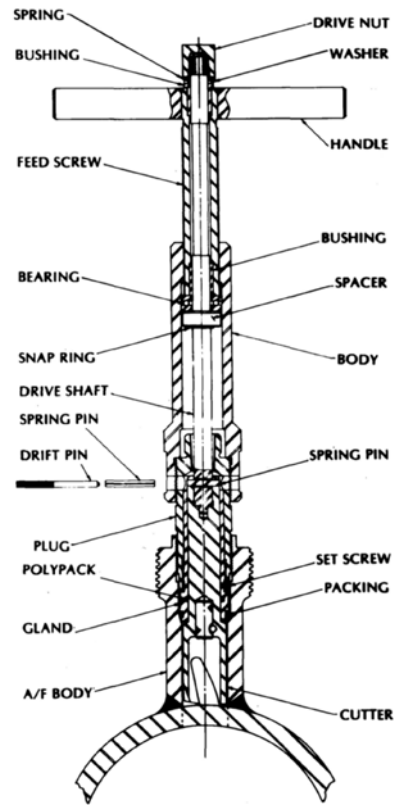
When trepanning is completed, the plug assembly containing the slug is removed by use of the Retriever and Service Valve. The Magnetic Swab Assembly (Part No. 121870), which is also included in the Hot Tap Kit, is then used to remove any excess cuttings, thereby leaving a clean hole. While the Service Valve and Retriever are still in place, a COSASCO® Solid or Hollow Plug Assembly with any of Cosasco's equipment or special tools may be installed for corrosion monitoring or prevention.

Hot Tapping can be performed safely with pressures up to 3600 PSI (24.8 MPa) and temperatures to +250 °F (+121° C). When under pressure, the Hot Tap Plug must be removed only in conjunction with a COSASCO® Retriever and Service Valve hook-up.

COSASCO® Hot Tap Kits include all equipment necessary to accomplish the hot tapping procedure; Magnetic Swab, Ship Remover, and Hydrostatic Test Assemblies, as well as an ample supply of spare parts. The entire Kit is packed in a heavy duty field service box for easy portability and storage.

COSASCO® Hot Tap Kits are in use around the world – from the extreme environmental conditions of Alaska and the North Sea to those of the Middle and Far East. Even under these varying extremes, the COSASCO® Hot Tap requires little special care and maintenance other than that given any precision tool. The cutters can be resharpened for longer life. The number of cuts depends largely on the hardness of the steel to be cut, and on the rate of feed while trepanning. Component assemblies, individual parts and Spare Parts/Repair Kit P/N 121115 is available for continued maintenance.

Hot Tap Assembly



Hot Tap Kit Weight: 55 lbs (25 kg)
Hot Tap Cubage: = 1.73 Cu. Ft.

Ordering Information:

Part Number	Description
126248	Hot Tap Kit
206371	Feed Screw Assembly
121328	Hydrostatic Tester Assembly
121870	Magnetic Swab Assembly
123492	Chip Remover Assembly
123921	Cutter, 6 Tooth
203510	Cutter, 4 Tooth
208557	Cutter, Square End Mill
206372	Plug Assembly



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