



Corporation Stops Installation Instructions

Tapping & Drilling Machine Adapter Charts

IMPORTANT NOTICE

A.Y. McDonald waterworks products are designed for reliable service. Like all brass products, however, they can be damaged by improper handling and use. **DAMAGE CAUSED BY IMPROPER USE AND HANDLING WILL VOID OUR WARRANTY.**

Maximum Size Drills to be used with A.Y. McDonald Corporation Stops - Per AWMA C-800 Table 1

CORPORATION SIZE	1/2"	5/8"	5/8" x 3/4"	3/4"	3/4" x 1"	1"	1 1/4"	1 1/2"	2"
Corp Stop with AWMA Thread Inlet	7/16"	9/16"	9/16"	1 1/16"	1 1/16"	15/16"	1 3/16"	1 7/16"	1 7/8"
Corp Stop with I.P. Thread Inlet	7/16"	--	--	1 1/16"	1 1/16"	7/8"	1 1/8"	1 7/16"	1 3/4"

*Threads per AWMA C-800, Table 4



WARNING: It is unlawful in **CALIFORNIA & VERMONT (effective 1/1/2010), MARYLAND (effective 1/1/2012), LOUISIANA (effective 1/1/2013) and the UNITED STATES OF AMERICA (effective 1/4/2014)** to use any product in the installation or repair of any public water system or any plumbing in a facility or system that provides water for human consumption if the wetted surface area of the product has a weighted average lead content greater than 0.25%. This prohibition does not extend to service saddles used in California, Louisiana or under USA Public Law 111-380.

Tapping Machine Adapters

CORPORATION MODEL / SIZE				MUELLER TAPPING MACHINES			HAYS TAPPING MACH. NO. B-1	REED CDTM1000 & 2000;TM1000	RIDGID MLT3401										
				OUTLET THREADS*	NO. B-100 & B-101	NO. B				NO. A-2 & A-3									
74701-22	5/8 x 3/4	74701B-22	3/4	74704Q	3/4	3/4" Copper	680600	680600	680600	353-06-106	98423	92182							
74701-22	3/4	74701BQ	3/4	74704T	3/4														
74701G	5/8 x 3/4	74701BH	3/4	74704B-22	3/4														
74701G	3/4	74701BQ	3/4	74704BG	3/4														
74701Q	3/4	74701BT	3/4	74704BQ	3/4														
74701T	5/8 x 3/4	74704-22	3/4	74704BT	3/4														
74701T	3/4	74704G	3/4																
74701-22	3/4 x 1	74701BQ	3/4 x 1	74704-33	3/4	1" Copper	680601	680601	680601	353-06-108	98424	92187							
74701-22	1	74701BQ	1	74704-3G	3/4														
74701G	1	74701BT	3/4 x 1	74704-3H	3/4														
74701Q	3/4 x 1	74701BT	1	74704-3Q	3/4														
74701Q	1	74701B-33	3/4	74704-44	3/4														
74701T	3/4 x 1	74701B-3G	3/4	74704-55	3/4														
74701T	1	74701B-3H	3/4	74704B-22	3/4 x 1														
74701-33	3/4	74701B-3Q	3/4	74704B-22	1														
74701-3G	3/4	74701B-44	3/4	74704BG	1														
74701-3H	3/4	74701B-55	3/4	74704BQ	1														
74701-3Q	3/4	74704-22	3/4 x 1	74704BT	3/4 x 1														
74701-44	3/4	74704-22	1	74704BT	1														
74701-55	3/4	74704G	3/4 x 1	74704B-33	3/4														
74701B-22	3/4 x 1	74704G	1	74704B-3G	3/4														
74701B-22	1	74704Q	3/4 x 1	74704B-3H	3/4														
74701BG	3/4 x 1	74704Q	1	74704B-3Q	3/4														
74701BG	1	74704T	3/4 x 1	74704B-44	3/4														
74701BH	1	74704T	1	74704B-55	3/4														
74701-22	1 x 1 1/4	74701BT	1 x 1 1/4	74704-44	3/4 x 1								1 1/4" Copper	680602	-	680602	353-06-110	-	-
74701-22	1 1/4	74701BT	1 1/4	74704-44	1														
74701G	1 1/4	74701B-33	1	74704-55	1														
74701Q	1 1/4	74701B-3G	1	74704BG	1 1/4														
74701T	1 x 1 1/4	74701B-3H	1	74704BQ	1 x 1 1/4														
74701T	1 1/4	74701B-3Q	1	74704BQ	1 1/4														
74701-33	3/4 x 1	74701B-44	3/4 x 1	74704BT	1 x 1 1/4														
74701-33	1	74701B-44	1	74704B-33	3/4 x 1														
74701-3G	1	74701B-55	1	74704B-33	1														
74701-3H	1	74704-22	1 x 1 1/4	74704B-3G	1														
74701-3Q	1	74704-22	1 1/4	74704B-3H	1														
74701-44	1	74704G	1 1/4	74704B-3Q	1														
74701-55	1	74704Q	1 1/4	74704B-44	3/4 x 1														
74701B-22	1 x 1 1/4	74704T	1 x 1 1/4	74704B-44	1														
74701B-22	1 1/4	74704T	1 1/4	74704B-55	1														
74701BG	1 x 1 1/4	74704-33	3/4 x 1																
74701BG	1 1/4	74704-33	1																
74701BQ	1 x 1 1/4	74704-3G	1																
74701BQ	1 1/4	74704-3Q	1																
74701-22	1 1/2	74701BQ	1 1/2	74704B-22	1 1/2	1 1/2" Special	-	-	680421	-	-	-							
74701G	1 1/2	74701BT	1 1/2	74704BG	1 1/2														
74701T	1 1/2	74704-22	1 1/2	74704BQ	1 1/2														
74701Q	1 1/2	74704G	1 1/2	74704BT	1 1/2														
74701B-22	1 1/2	74704Q	1 1/2																
74701BG	1 1/2	74704T	1 1/2																
74701-22	2	74701BQ	2	74704B-22	1 1/2 x 2	2" Special	-	-	680422	-	-	-							
74701G	2	74701BT	1 1/2 x 2	74704B-22	2														
74701Q	2	74701BT	2	74704BG	2														
74701T	2	74704-22	2	74704BQ	1 1/2 x 2														
74701B-22	1 1/2 x 2	74704G	2	74704BQ	2														
74701B-22	2	74704Q	2	74704BT	1 1/2 x 2														
74701BG	2	74704T	2	74704BT	2														
74701-22FT	1 1/2	74701B-44	1 x 1 1/2	74704B-22FT	1 1/2	1 1/2" Copper	-	-	88640	-	-	-							
74701TFT	1 1/2	74701B-44	1 1/2	74704BGFT	1 1/2														
74701B-22FT	1 1/2	74704-22FT	1 1/2	74704BTFT	1 1/2														
74701BGFT	1 1/2	74704GFT	1 1/2	74704B-44	1 x 1 1/2														
74701BTFT	1 1/2	74704TFT	1 1/2	74704B-44	1 1/2														
74701B-33	1 1/2																		
74701-22FT	2	74701B-33	1 1/2	74704BGFT	2	2" Copper	-	-	88641	-	-	-							
74701GFT	2	74701B-33	2	74704BTFT	1 1/2 x 2														
74701TFT	2	74701B-44	2	74704BTFT	2														
74701B-22FT	1 1/2 x 2	74704-22FT	2	74704B-33	1 1/2														
74701B-22FT	2	74704GFT	2	74704B-33	2														
74701BGFT	1 1/2 x 2	74704TFT	2	74704B-44	2														
74701BGFT	2	74704B-22FT	1 1/2 x 2	74704B-44	2														
74701BTFT	1 1/2 x 2	74704B-22FT	2	74704B-55	2														
74701BTFT	2	74704BGFT	1 1/2 x 2																

CAUTION:

1. PROTECT THREADS Nicks or distorted threads, especially on tapered threads, can cause leaks.
2. USE A GOOD THREAD SEALANT where threads are intended to provide a leak-proof connection. Do not overtighten.
3. DO NOT use Vaseline®, plumber's grease, or any other petroleum product on seals or o-rings.
4. USE ONLY A SMOOTH JAWED ADJUSTABLE WRENCH on the flats provided nearest the thread being made up. Serrated pipe wrenches apply a loose, improper fit that can distort the body and cause a leak, especially on valves.
5. Plug style corp valves should be installed so that the wrenching flats of a tightened valve are positioned top and bottom (See Figure 1).
6. AVOID DROPPING or the use of a hammer on any plug or key type valve. Impacts, causing dents or distortion, can cause leaks by unseating the plug portion of the valve.
7. PRESSURE TEST for leaks before backfilling.
8. FIELD TESTING Special high pressure field testing may require capping the outlet of corporation stops, curb stops and angle meter stops.
9. HIGH PRESSURE INSTALLATION Standard AWWA tapered plug valves are intended for not more than 100 PSIG water in sizes 1/2", 3/4" and 1" and 80 PSIG water for 1-1/4", 1-1/2" and 2" valves.
10. BACKFILL CAREFULLY to avoid damage to the service line and connections. Loop service piping on corporation connections to minimize strain on the body and connections (See Figure 1).
11. If valve leaks, open and close several times. This may reseal the key properly and stop the leak.
12. DO NOT TIGHTEN NUT AT BOTTOM OF VALVE. Adjusting this nut voids manufacturer's warranty.
13. Use only on cold water services.

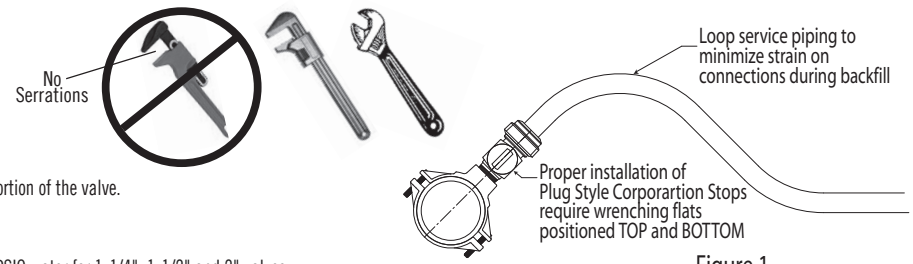


Figure 1

NOTE: For corps with Kitec® ends, remove Kitec® adaptor prior to drilling. Reassemble Kitec® adaptor to corp after drilling. Inspect all O-rings for damage prior to reassembly.

NOTE: For installations having pressures in excess of 100 PSIG (1/2", 3/4" and 1" corp stops) or 80 PSIG (1-1/4", 1-1/2" and 2" corp stops), the use of McDonald "ball-style" corporation stops is recommended. Ball corporations are for use with water only and are rated at 300 PSIG water pressure.

Drilling Machine Adapters

*Threads per AWWA C-800, Table 4

CORPORATION MODEL / SIZE						OUTLET THREADS*	MUELLER DRILLING MACHINES		ROMAC TAPMATE TOO	HAYS DRILLING MACHINES		FORD DRILLING MODEL 77	REED DRILLING		RIDGID		SIMTAP			
							E-4 & E-5	D-4 & D-5		5930	5935		DM1000 & 2000	DMPVC	RT 1000	RT 3422		MLT 3401		
74701-22 74701-22 74701G 74701G 74701Q	5/8 x 3/4 3/4 5/8 x 3/4 3/4 3/4	74701T 74701T 74701B-22 74701BG 74701BH	5/8 x 3/4 3/4 3/4 3/4 3/4	74701BQ 74701BT 74704-22 74704G 74704Q	3/4 3/4 3/4 3/4 3/4	74704T 74704B-22 74704BG 74704BQ 74704BT	3/4 3/4 3/4 3/4 3/4	3/4" Copper	52019	37902	351-05-506	354-05-506	355-05-506	DMA2-3	08423	04426	83317	76057	92097	116A
74701-22 74701-22 74701G 74701Q 74701T 74701T 74701-33 74701-3G 74701-3H 74701-3Q 74701-44 74701-55 74701B-22	3/4 x 1 3/4 1 3/4 x 1 1 3/4 x 1 1 3/4 3/4 3/4 3/4 3/4 3/4 x 1	74701B-22 74701BG 74701BG 74701BH 74701BQ 74701BQ 74701BT 74701BT 74701B-33 74701B-3G 74701B-3H 74701B-3Q 74701B-44 74701B-44 74701B-55	1 3/4 x 1 1 1 3/4 x 1 1 3/4 x 1 1 3/4 3/4 3/4 3/4 3/4 3/4	74704-22 74704-22 74704G 74704G 74704Q 74704Q 74704T 74704T 74704-33 74704-3G 74704-3H 74704-3Q 74704-44 74704-44 74704-55	3/4 x 1 1 3/4 x 1 1 3/4 x 1 1 3/4 x 1 1 3/4 3/4 3/4 3/4 3/4 3/4	74704B-22 74704B-22 74704BG 74704BQ 74704BT 74704BT 74704B-33 74704B-3G 74704B-3H 74704B-3Q 74704B-44 74704B-55	3/4 x 1 1 1 1 3/4 x 1 1 3/4 3/4 3/4 3/4 3/4 3/4 3/4	1" Copper	36750	37903	351-05-508	354-05-508	355-05-508	DMA2-4	08424	04427	83322	76067	92012	117A
74701-22 74701-22 74701G 74701Q 74701T 74701T 74701-33 74701-33 74701-3G 74701-3H 74701-3Q 74701-44 74701-55 74701B-22	1 x 1 1/4 1/4 1/4 1/4 1 x 1 1/4 1/4 3/4 x 1 1 1 1 1 1 1 x 1 1/4	74701B-22 74701BG 74701BG 74701BQ 74701BQ 74701BT 74701BT 74701B-33 74701B-3G 74701B-3H 74701B-3Q 74701B-44 74701B-44 74701B-55	1/4 1 x 1 1/4 1/4 1 x 1 1/4 1/4 1 x 1 1/4 1/4 1 1 1 1 3/4 x 1 1 1	74704-22 74704-22 74704G 74704Q 74704T 74704T 74704-33 74704-33 74704-3G 74704-3Q 74704-44 74704-44 74704-55 74704BG	1 x 1 1/4 1/4 1/4 1/4 1 x 1 1/4 1/4 3/4 x 1 1 1 1 3/4 x 1 1 1 1/4	74704BQ 74704BQ 74704BT 74704B-33 74704B-33 74704B-3G 74704B-3H 74704B-3Q 74704B-44 74704B-44 74704B-55	1 x 1 1/4 1/4 1 x 1 1/4 3/4 x 1 1 1 3/4 x 1 1 1 1 1 1 1	1 1/4" Copper	45385	37904	351-05-510	354-05-510	355-05-510	DMA2-5	--	--	--	76072	92107	118A
74701-22 74701G 74701T 74701Q	1 1/2 1 1/2 1 1/2 1 1/2	74701B-22 74701BG 74701BQ 74701BT	1 1/2 1 1/2 1 1/2 1 1/2	74704-22 74704G 74704Q 74704T	1 1/2 1 1/2 1 1/2 1 1/2	74704B-22 74704BG 74704BQ 74704BT	1 1/2 1 1/2 1 1/2 1 1/2	1 1/2" Special	501949	507644	351-05-712	--	--	DMA4-6-Q	--	--	--	84007	92157	121A
74701-22 74701G 74701Q 74701T 74701B-22 74701B-22	2 2 2 2 1 1/2 x 2 2	74701BG 74701BQ 74701BT 74701BT 74704-22 74704G	2 2 1 1/2 x 2 2 2 2	74704Q 74704T 74704B-22 74704B-22 74704BG	2 2 1 1/2 x 2 2 2	74704BQ 74704BQ 74704BT 74704BT	1 1/2 X 2 2 1 1/2 x 2 2	2" Special	508199	507645	351-05-716	--	--	DMA4-7-Q	--	--	--	84012	92162	124A
74701-22FT 74701FT 74701B-22FT 74701BGFT	1 1/2 1 1/2 1 1/2 1 1/2	74701BFT 74701B-33 74701B-44 74701B-44	1 1/2 1 1/2 1 X 1 1/2 1 1/2	74704-22FT 74704GFT 74704FT 74704B-22FT	1 1/2 1 1/2 1 1/2 1 1/2	74704BGFT 74704BTFT 74704B-44 74704B-44	1 1/2 1 1/2 1 X 1 1/2 1 1/2	1 1/2" Copper	501947	37905	351-05-512	--	355-05-512	DMA2-6	08425	--	--	76077	92112	120A
74701-22FT 74701GFT 74701FT 74701B-22FT 74701B-22FT 74701BGFT 74701BGFT	2 2 2 1 1/2 x 2 2 1 1/2 X 2 2	74701BFT 74701BFT 74701B-33 74701B-33 74701B-44 74704-22FT 74704GFT	2 2 1 1/2 2 2 2 2	74704FT 74704B-22FT 74704B-22FT 74704BGFT 74704BGFT 74704BTFT	2 1 1/2 x 2 2 1 1/2 X 2 2 1 1/2 x 2 2	74704B-33 74704B-33 74704B-44 74704B-55	1 1/2 2 2 2	2" Copper	508201	37906	351-06-516	--	355-37	DMA2-7	08426	--	--	76082	92117	123A