



BALLOMAX[®]

DESIGNED TO LAST



SECTION 12

Hot tap valve

Reduced bore

Hot tap valve - DN15-100, PN25

Type 68102 - Reduced bore

Welding × Welding

Fully welded steel ball valve.

Materials

See next page.

Applications

Hot tap valve for heating systems, district heating, cooling and industrial purpose.

Media

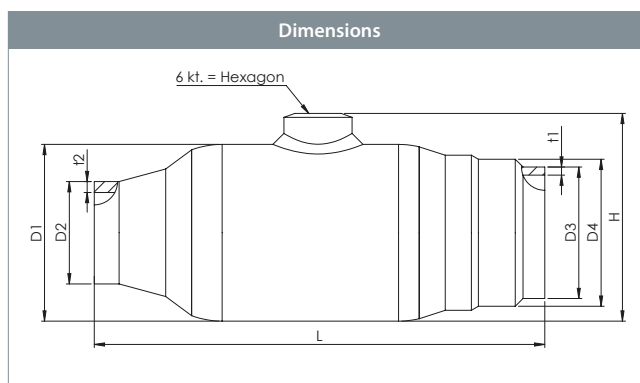
Water. Not suitable for steam. Other media on request. If in doubt, please contact BROEN Ballomax® Sales Department.

Operation

Hot tap valve with a cap screw and a hexagon recess for inserting an Allen key. The spindle has a notch for indication of position.

Notice

It is recommended that you read the "User manual for Ballomax® hot tap tool".



					All dimensions in mm										
DN	BROEN No.	Bore	Kvs	net Weight kg	Hex.	Drill size	Rec. RPM	L	H	t1	t2	D1	D2	D3	D4
15	68102015 000	15	8	0.6	5	14	400	127	53	2.0	3.5	42.4	23	21.3	G 7/8
20	68102020 000	15	15	0.6	5	14	400	127	53	2.3	3.5	42.4	23	26.9	G 7/8
25	68102025 000	20	27	0.9	5	19	300	143	63	2.6	3.5	51.0	28	33.7	G 1 1/8
32	68102032 000	25	40	1.2	5	24	300	145	68	2.6	3.5	57.0	33	42.4	G 1 1/2
40	68102040 000	32	69	1.8	7	30	250	178	96	2.6	4.0	76.1	42	48.3	G 1 3/4
50	68102050 000	39	110	3.2	7	37	200	198	107	2.9	5.0	88.9	52	60.3	G 2 1/4
65	68102065 000	49	180	3.8	8	48	200	205	118	2.9	7.5	108	64	76.1	M 64×2
80	68102080 000	63	288	5.2	8	60	150	200	137	3.2	8.0	127	80	88.9	M 76×2
100	68102100 000	78	470	9.3	10/12*	76	125	225	163	3.6	9.0	152	97	114.3	M 95×2

* 10 mm hex. key to operate pipe plug, 12 mm key to operate valve.

Hot tap valve - DN15-100, PN25

Type 68102 - Reduced bore



Technical drawing		Material description	
	1	Welding	Steel - P235GH / 1.0345 / EN 10217-2
	5	Valve body	Steel - P235GH / 1.0345 / EN 10217-2
	6	Ball	Stainless steel - AISI304L / 1.4306 / EN 10217-7
	7	Seat ring	PTFE 20% Carbon
	8	Back-up ring	Steel - DC01 / 1.0330 / EN 10130
	9	Disc spring	Steel - C75S / 1.1248 / EN 10132-4
	10	Neck ring	Steel - S355J2+N / 1.0570 / EN 10025-2
	11	Stem guide	Steel - S355J2+N / 1.0570 / EN 10025-2
	12	Stem	Stainless steel - ASTM420 / 1.4021 / EN 10088-3
	17	O-ring	Rubber - FPM70
	37	Pipe plug	Steel - 11SMnPb30 / 1.0718 / EN 10277-3
	1		
	7		

Hot tap tool - DN15-50 - DN65-100, PN25

Type 68500 - Reduced bore

Hot tap tool

BROEN Ballomax® hot tap valves from DN15 to DN100 make it very simple and economical to connect new district heating consumers to the existing network quite without causing any inconvenience and/or disconnection of supply.

The procedure is very simple:

- 1) The main pipe is stripped where the branch is requested.
- 2) The hot tap valve is welded on to the pipe with the ball in open position.
- 3) The hot tap tool is mounted on the valve and connected to a drilling machine.
- 4) You drill directly through the valve and into the heating pipe.
- 5) Having drilled the hole, you pull back the bore, close the valve, remove the tool and the consumer can be connected to the network.

For Ballomax® hot tap valves DN65, DN80 and DN100 we recommend to use a specially developed reduction gear with a drill pressure unit to be connected between the hot tap tool and the drilling machine.

Content

See next pages.



DN15-50



DN65-100

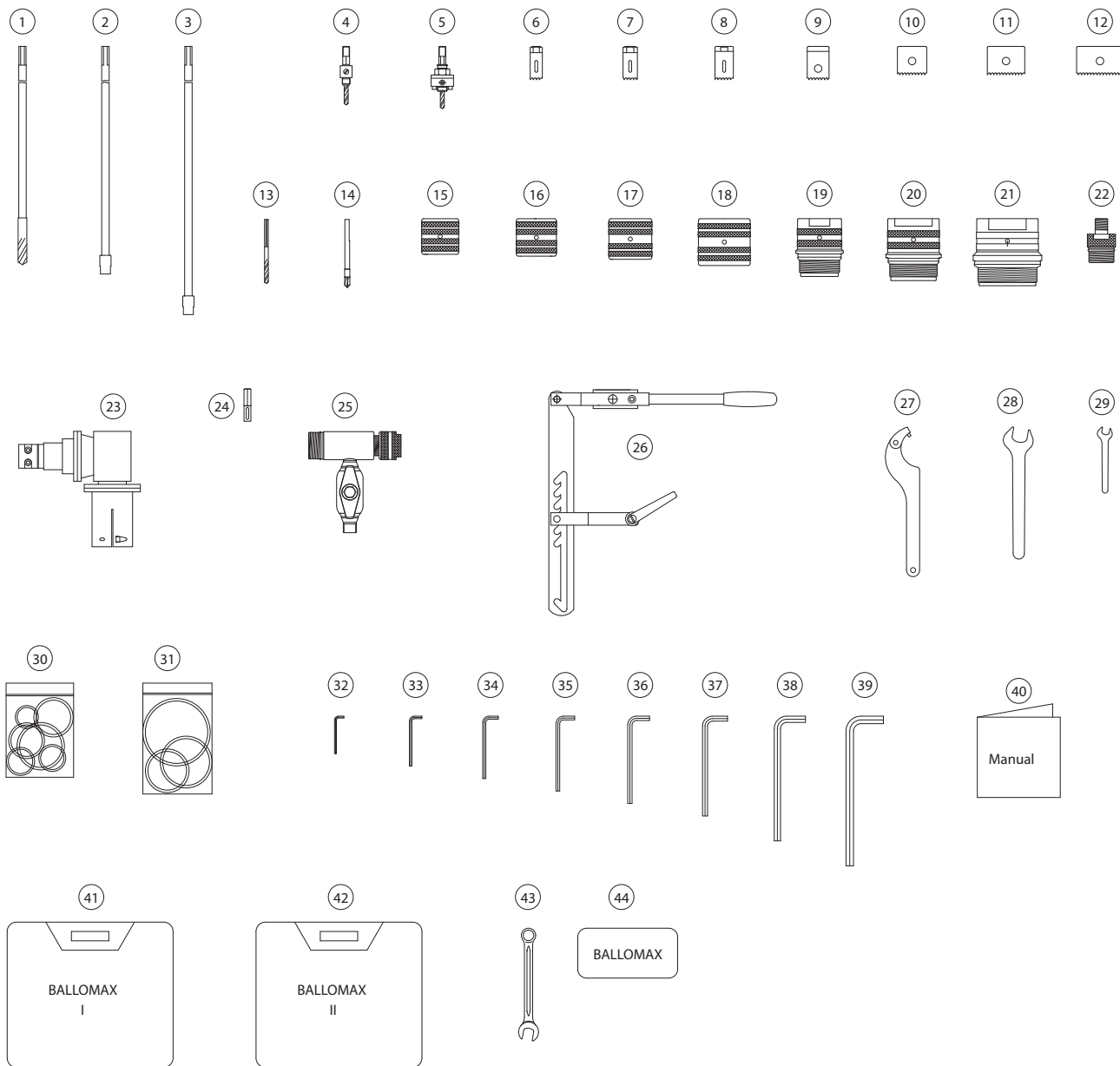
DN	BROEN No.	Description
15-50	68500015 000	Hot tap tool with case
65-100	68500100 000	Supplementary set

Hot tap tool - DN15-50 - DN65-100, PN25

Type 68500 - Reduced bore



Technical drawing



Hot tap tool - DN15-50, PN25

Type 68500 - Reduced bore

No.	Description	Material	BROEN No.
1	Drill with handle Ø14	Stainless steel W 1.4305	491385
2	Spoon bit drilling stem	Stainless steel W 1.4305	491394
4	Small spoon bit holder		491388
5	Holder, spoon bit with driver		491389
6	Spoon bit 19 mm		100845
7	Spoon bit 24 mm		100846
8	Spoon bit 30 mm		100847
9	Spoon bit 37 mm		100848
13	Centre drill Ø6,4 mm		100842
14	Centre drill Ø7 mm with jump ring		500058
15	Coupling for DN25	Chromium-plated brass	491380
16	Coupling for DN32	Chromium-plated brass	491381
17	Coupling for DN40	Chromium-plated brass	491382
18	Coupling for DN50	Chromium-plated brass	491383
22	Test cap	Chromium-plated brass	491384
25	Hot tap valve	Stainless steel	491375
	T-handle		66050010 000
	Nut		100113
	Valve		60105020
	Packings, a set of three	Ramilon 4586	491379
	Bearing	Brass	491378
	Union nut	Chromium-plated brass	491377
27	Hook spanner 6 mm		100841
28	Fork spanner M24		300091
29	Fork spanner M11		300090
30	Set of O-rings Ø31×3	NBR	100824
	Set of O-rings Ø37,2×3	NBR	100825
	Set of O-rings Ø39×3	NBR	100820
	Set of O-rings Ø50,39×3,53	NBR	100646
	Set of O-rings Ø55×4	NBR	100821
	Set of O-rings Ø68×4	NBR	100822
32	Hexagon key 1/8"		500147
33	Hexagon key 4 mm		100959
34	Hexagon key 5 mm		100960
36	Hexagon key 7 mm		500701
40	User's manual		
41	Suitcase with lining		100851
43	Closed spanner		300162
44	Label		491117

Hot tap tool - DN65-100, PN25



Type 68500 - Reduced bore

No.	Description	Material	BROEN No.
3	Spoon bit drilling stem	Stainless steel W 1.4305	497394
10	Spoon bit 48 mm		100940
11	Spoon bit 60 mm		100941
12	Spoon bit 76 mm		100942
19	Coupling for DN65	Chromium-plated brass	497380
20	Coupling for DN80	Chromium-plated brass	498380
21	Coupling for DN100	Chromium-plated brass	499380
23	Reduction gear		100943
24	Driver unit	Stainless steel	300100
26	Attachment unit		100944
31	Set of O-rings Ø62x4	NBR	100931
	Set of O-rings Ø75x4	NBR	100932
	Set of O-rings Ø100x4	NBR	100933
34	Hexagon key 5 mm		100960
35	Hexagon key 6 mm		100961
37	Hexagon key 8 mm		100962
38	Hexagon key 10 mm		100963
39	Hexagon key 12 mm		100964
40	User's manual		
42	Suitcase with lining		100965
44	Label		491117

