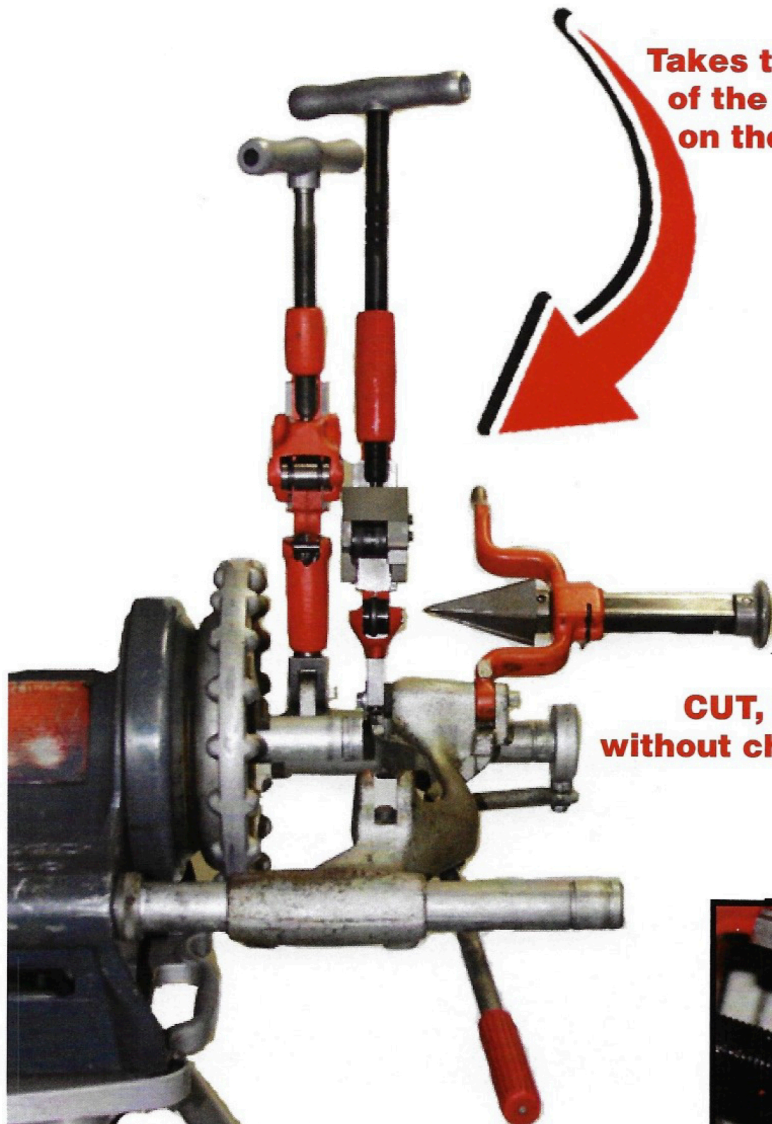


**NEW**

**PACE® 4080 Roll Grooving Attachment**

Chucks into PT® Power Drive and RIDGID® 300 Power Drive



**Takes the place  
of the Die Head  
on the Carriage**

**ROLL  
GROOVES  
1"-1½"  
PIPE  
SCHD 40 & 10**

**CUT, REAM & GROOVE  
without changing out equipment**



**GO, NO-GO GAUGE INCLUDED**

**— FEATURES —**

- Many have a Ridgid 300**
- Cost Efficient**
- Simple to Operate**
- Portable**
- No Mess...No Oil**



RIDGID® is a registered trademark of RIDGID®, Inc.



## **PACE® 4080 Roll Grooving Attachment**

Chucks into PT® Power Drive and RIDGID® 300 Power Drive  
GROOVES 1"-1½" PIPE

### **OPERATING INSTRUCTIONS**

FOR 1" - 1½" ROLL GROOVES

POWERSOURCE IS RIDGID 300 PIPE THREADER

- 1) REMOVE PIPE THREADING HEAD
- 2) INSTALL PACE MODEL 4080 GROOVING TOOL, INSERTING PIVOT PIN INTO HOLE THAT DIE HEAD WAS REMOVED FROM.
- 3) CUT AND REAM PIPE AS IF YOU WERE GOING TO THREAD IT.
- 4) NOW TO GROOVE. BRING GROOVING HEAD OVER TOP SIDE OF PIPE, OPENING ROLLS SO THAT ROLLERS FIT ON BOTH SIDES OF PIPE. TURN HANDLE CLOCKWISE SO THAT ROLLERS ALMOST COMES IN CONTACT WITH PIPE.
- 5) BRING CARRIAGE FORWARD SO THAT THE PIPE STOP ON TOOL COMES IN CONTACT WITH PIPE END.

**NOTE: FIG 1 ARROW A**

- 6) STEP ON FOOT SWITCH STARTING MACHINE. TURNING HANDLE TO APPLY LIGHT PRESSURE ON PIPE, HOLDING PIPE STOP IN CONTACT WITH PIPE END. MAINTAINING CONTACT WITH PIPE.
- 7) START GROOVING TURNING HANDLE APPROXIMATELY 1/8 TURN PER REVOLUTION OF PIPE.
- 8) TURN HANDLE UNTIL GROOVING ROLL OUTSIDE DIAMETER COMES IN CONTACT WITH THE OUTSIDE DIAMETER OF PIPE. WHEN THIS HAPPENS YOUR GROOVE IS DONE.

**NOTE: FIG 1 ARROW B**

- 9) LOOK AT POSITION OF THE "T" HANDLE
- 10) CHECK GROOVE WITH GO/NO-GO GAGE (FURNISHED WITH TOOL)
- 11) IF YOU NEED TO ADJUST THE DIAMETER BIGGER OR SMALLER YOU CAN CHANGE THIS BY WHERE YOU STOP GROOVING ON THE "T" HANDLE.
- 12) ONCE YOU KNOW THE FINISH POSITION OF THE "T" HANDLE, ALL YOUR GROOVES WILL REPEAT TO THE SAME DIAMETER
- 13) CONTINUE GROOVING
- 14) APPROXIMATELY 1 AND ONE QUARTER TURNS (FROM THE START) ON THE T-HANDLE WILL GIVE YOU PROPER GROOVE DEPTH

