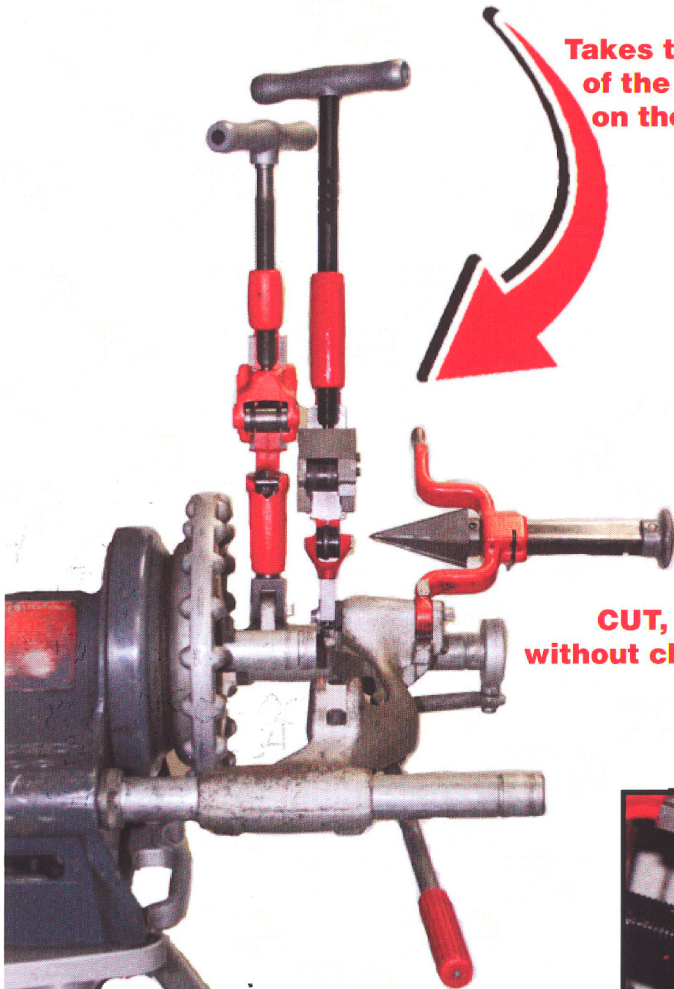


**NEW**

**PACE® 4075 IGS Roll Grooving Attachment**

Chucks into PT® Power Drive and RIDGID® 300 Power Drive  
GROOVES VICTAULIC™ 1" PROPRIETARY IGS™ GROOVE

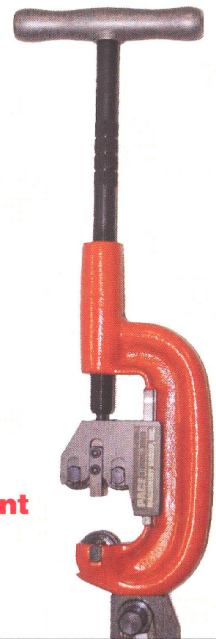


**Takes the place  
of the Die Head  
on the Carriage**



VICTAULIC STYLE 108  
FIRELOCK™ IGS™  
RIGID COUPLING

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



**GO, NO-GO GAUGE INCLUDED**

**— FEATURES —**

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



RIDGID® is a registered trademark of RIDGID®, Inc.  
"IGS"™ is a trademark of VICTAULIC CO OF AMERICA

## OPERATING INSTRUCTIONS

FOR 1" IGS VICTAULIC GROOVE  
POWERSOURCE IS RIDGID 300 PIPE THREADER

- 1) REMOVE PIPE THREADING HEAD
- 2) INSTALL PACE MODEL 4075 GROOVING TOOL, INSERTING PIVOT PIN INTO HOLE THAT DIE HEAD WAS REMOVED FROM.
- 3) INSTALL GO/NO GO GAGE ON **CARRIAGE** HANDLE, PLACING RING ON CHAIN, ONTO THE CARRIAGE HANDLE.
- 4) CUT AND REAM PIPE AS IF YOU WERE GOING TO THREAD IT.
- 5) 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.
- 6) BRING CARRIAGE FORWARD SO THAT THE PIPE STOP ON TOOL COMES IN CONTACT WITH PIPE END.

**NOTE: FIG 1 ARROW A**

- 7) 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.
- 8) START GROOVING TURNING HANDLE APPROXIMATELY 1/8 TURN PER REVOLUTION OF PIPE.
- 9) 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**

- 10) LOOK AT POSITION OF THE "T" HANDLE
- 11) CHECK GROOVE WITH GO/NO-GO GAGE
- 12) IF YOU NEED TO ADJUST THE DIAMETER BIGGER OR SMALLER YOU CAN CHANGE THIS BY WHERE YOU STOP GROOVING ON THE "T" HANDLE.
- 13) ONCE YOU KNOW THE FINISH POSITION OF THE "T" HANDLE, ALL YOUR GROOVES WILL REPEAT TO THE SAME DIAMETER
- 14) CONTINUE GROOVING

