

# Roll Grooving

- Designed to improve speed and efficiency for fire sprinkler and other industrial installations.
- Wide selection of mechanical and hydraulic units for applications up to 24" in diameter.



| Type                          | No. of Models | Pipe Capacity |          | Page |
|-------------------------------|---------------|---------------|----------|------|
|                               |               | in.           | mm       |      |
| 915 Manual Roll Groover       | 1             | 1¼ - 12       | 32 - 300 | 5.2  |
| 975 Combo Roll Groover        | 1             | 1¼ - 6        | 32 - 150 | 5.4  |
| 916 Power-Driven Roll Groover | 4             | 1 - 6         | 50 - 150 | 5.6  |
| 918 Hydraulic Roll Groover    | 5             | 1 - 12        | 25 - 300 | 5.8  |
| 918-I Electric Roll Groover   | 2             | 1 - 12        | 25 - 300 | 5.10 |
| 920 Power-Driven Roll Groover | 1             | 2 - 24        | 50 - 600 | 5.12 |

# ROLL GROOVING

## Roll Groover Selection

|                             | 975                                                                               | 916                                                                               | 915                                                                               | 918                                                                                | 918-I                                                                               | 920                                                                                 |
|-----------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|                             |  |  |  |  |  |  |
|                             | Page 5.4                                                                          | Page 5.6                                                                          | Page 5.2                                                                          | Page 5.8                                                                           | Page 5.10                                                                           | Page 5.12                                                                           |
| <b>Capacity</b>             | 1¼" - 6"                                                                          | 1" - 6"                                                                           | 1¼" - 12"                                                                         | 1" - 12"                                                                           | 1" - 12"                                                                            | 2" - 24"                                                                            |
| <b>Weight</b>               | 26 lbs. (12 kg)                                                                   | 33 lbs. (15 kg)                                                                   | 23 lbs. (10 kg)                                                                   | 81 lbs. (37 kg)                                                                    | 185 lbs. (84 kg)                                                                    | 160 lbs. (73 kg)                                                                    |
| <b>"In-Place" Groover</b>   | •                                                                                 |                                                                                   | •                                                                                 |                                                                                    |                                                                                     |                                                                                     |
| <b>Hydraulic Actuated</b>   |                                                                                   |                                                                                   |                                                                                   | •                                                                                  | •                                                                                   | •                                                                                   |
| <b>Will do SS, PVC, Al</b>  | •                                                                                 | •                                                                                 | •                                                                                 | •                                                                                  | •                                                                                   | •                                                                                   |
| <b>Roll Sets for Copper</b> |                                                                                   | •                                                                                 | •                                                                                 | •                                                                                  | •                                                                                   | •                                                                                   |
| <b>Drive Units</b>          | RIDGID 300 / Page 4.16                                                            | RIDGID 300 / Page 4.16                                                            | Hand                                                                              | RIDGID 300 / Page 4.16                                                             | Included                                                                            | RIDGID 300 / Page 4.16                                                              |
|                             | RIDGID 300 Compact / Page 4.22                                                    | RIDGID 300 Compact / Page 4.22                                                    | —                                                                                 | RIDGID 300 Compact / Page 4.22                                                     | —                                                                                   | —                                                                                   |
|                             | RIDGID 1233 / Page 4.26                                                           | RIDGID 1233 / Page 4.26                                                           | —                                                                                 | RIDGID 1233 / Page 4.26                                                            | —                                                                                   | —                                                                                   |
|                             | or hand                                                                           | RIDGID 535* / Page 4.20                                                           | —                                                                                 | RIDGID 535* / Page 4.20                                                            | —                                                                                   | —                                                                                   |
|                             | —                                                                                 | —                                                                                 | —                                                                                 | RIDGID 1224 / Page 4.28                                                            | —                                                                                   | —                                                                                   |
| <b>Usage</b>                | Field                                                                             | Fab Shop / Field                                                                  | Field                                                                             | Fab Shop / Field                                                                   | Fab Shop / Field                                                                    | Fab Shop / Field                                                                    |

\* Adapter pieces required.

Note: Please check schedules in charts.

## Roll Groover/Threader Compatibility

| Roll Groover Model | Threader Model  |                      |            |      |                      |       |
|--------------------|-----------------|----------------------|------------|------|----------------------|-------|
|                    | 300 Power Drive | 300 Compact          | 535 Manual | 535A | 1233                 | 1224  |
| <b>916</b>         | 45007           | 48307                | 60382      | —    | 48307                | —     |
| <b>975</b>         | 33033           | 33588                | —          | —    | 33588                | —     |
| <b>918</b>         | 48297           | 57092 (1); 19131 (2) | 48387      | —    | 57092 (1); 19131 (2) | 48382 |
| <b>920</b>         | 95782           | —                    | —          | —    | —                    | —     |

(1) with roll set 2" - 12"

(2) with roll set 2" - 6"

## Model 915 Manual Roll Groover



Model 915

The new RIDGID® Model 915 Roll Groover is a manual roll groover for in-place field applications. The Model 915 requires only 3½" (9 cm) of clearance to travel around a pipe and a minimum of 2¾" (7 cm) of exposed pipe for grooving. With the appropriate roll sets, it can groove from 1¼" to 12" pipe, the widest range in its class! The Model 915's cast-in handle allows for easy transport or chaining the groover down to prevent theft. The Model 915 is a must for service work crews.

### Features

- Lightweight design – only 23 pounds (10,4 kg).
- Easy roll set change out – up to 12" pipe capacity in one unit for service versatility.
- Cast-in carrying handle – easy to transport or lock up to prevent theft.
- Included ratchet – 90 degree bend-in handle makes grooving easier.
- Available customized tool box – holds Model 915 groover and all available roll sets.
- Easy to use depth setting gauge – helps make accurate grooves.

### Standard Equipment

- Model 915 Roll Groover with 2" - 6" Sch. 10 (2" - 3½" Schedule 40).
- Roll Set Ratchet Wrench.



Some items sold separately.

## Model 915 Ordering Information and Accessories

| Catalog No. | Model No. | Description                                                                       | Weight |      |
|-------------|-----------|-----------------------------------------------------------------------------------|--------|------|
|             |           |                                                                                   | lb.    | kg   |
| 88232       | 915       | 915 Roll Groover with 2" - 6" Sch. 10 (2" - 3½" Sch. 40) Roll Set                 | 23     | 10,4 |
| 92437       | —         | Drive and Groove Roll Set for 1¼" - 1½" Sch. 10 or 40 Steel, Stainless Steel, PVC | 2      | 0,9  |
| 92447       | —         | Drive and Groove Roll Set for 4" - 6" Sch. 40 Steel, Stainless Steel, PVC         | 4.5    | 1,9  |
| 92442       | —         | Drive and Groove Roll Set for 8" - 12" Sch. 10 Steel, Stainless Steel, PVC        | 4.5    | 1,9  |
| 92452       | —         | Drive and Groove Roll Set for 2" - 8" Copper Tube Type K, L, M, and DWV           | 2      | 0,9  |
| 93642       | —         | Groove Roll 2" - 6"                                                               | 0.9    | 0,4  |
| 93757       | —         | Drive Roll 2" - 6"                                                                | 1.3    | 0,6  |
| 93497       | —         | 915 Tool Box                                                                      | 21.5   | 9,7  |
| 76827       | —         | Metric Diameter Tape                                                              | 0.5    | 0,1  |
| 76822       | —         | English Diameter Tape                                                             | 0.5    | 0,1  |

Note: A Roll Groove Set consists of a Groove Roll and a Drive Roll.

Copper Roll Groove Set includes Black Reaction Arm and one Copper Stabilizer Pad.

## Capacities

| Pipe Wall Thickness | Nominal Inch          | 1             | 1¼            | 1½            | 2             | 2½            | 3             | 4             | 6             | 8             | 10            | 12             |
|---------------------|-----------------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|----------------|
|                     | Schedule 10 in. (mm.) | .109<br>(2,8) | .109<br>(2,8) | .109<br>(2,8) | .109<br>(2,8) | .120<br>(3,0) | .120<br>(3,0) | .134<br>(3,4) | .134<br>(3,4) | .148<br>(3,8) | .165<br>(4,2) | .180<br>(4,6)  |
|                     | Schedule 40 in. (mm.) | .133<br>(3,4) | .149<br>(3,6) | .146<br>(3,7) | .154<br>(3,9) | .203<br>(5,2) | .216<br>(5,5) | .237<br>(6,0) | .280<br>(7,1) | .322<br>(8,2) | .365<br>(9,3) | .406<br>(10,3) |
| Pipe Diameter       | Nominal Metric mm     | 25,00         | 32,00         | 40,00         | 50,00         | 65,00         | 80,00         | 100,00        | 150,00        | 200,00        | 250,00        | 300,00         |
|                     | Actual O.D. Metric    | 33,40         | 42,16         | 48,26         | 60,33         | 73,03         | 88,90         | 114,30        | 168,28        | 219,08        | 273,05        | 323,85         |

| Model No. | Machine                          | Material              |                                                                          |                                   |          |                   |
|-----------|----------------------------------|-----------------------|--------------------------------------------------------------------------|-----------------------------------|----------|-------------------|
| 915       | Portable<br>Manually<br>Operated | Steel - Light Wall mm | EN 10255, DIN 2440, 2441, 2448, 2458 up to maximum<br>5,4 wall thickness |                                   | Max. 4,5 | DIN 2458 max. 5,4 |
|           |                                  | Stainless Steel mm    | Up to maximum 4,5 wall thickness                                         |                                   |          |                   |
|           |                                  | Use Roll Set          | 92437                                                                    | Standard equipment/ 93642 + 93757 |          | 92442             |
|           |                                  | Steel - Heavy Wall mm | Up to 7,1 wall                                                           |                                   |          |                   |
|           |                                  | Use roll set          | 92447                                                                    |                                   |          |                   |
|           |                                  | Copper                | ISO 274 / EN 1057                                                        |                                   |          |                   |
|           |                                  | Use Roll Set          | 92452                                                                    |                                   |          |                   |

**(TOOL TIP)** Ensure proper pipe end preparation because square cuts are critical to accurate and reliable grooves.

Model 975 Combo Roll Groover

NEW



Model 975



The Model 975 Combo Roll Groover is two tools in one. Like other RIDGID® roll groovers, the 975 mounts on the RIDGID® 300 Power Drive for machine-powered roll grooving jobs, but it is also designed to manually roll groove in-place pipe.

Auto Tracking & Depth Setting Gauge Means Easier Use

The 975 Combo Groover includes new, patented auto tracking technology for significantly easier grooving. Whether you’re doing machine-powered or manual grooving, the AutoTrack gauge keeps the pipe automatically engaged to the groover throughout the grooving process. The 975 also includes a permanently-fixed depth setting gauge for quicker, repeatable set-up.

Less Hand-Force Required

When manually roll grooving, the 975’s 55% higher gear reduction means less hand-force is required versus competitive manual roll groovers. This is especially helpful for over-head roll grooving.

Durability And Portability

A tough, ductile iron construction means the 975 can absorb jobsite abuse and provide accurate grooves time after time. A cast-in handle makes the 975 easily portable to and from the jobsite.

Model 975 Ordering Information and Accessories

| Catalog No. | Model No. | Description                                             | Weight |      |
|-------------|-----------|---------------------------------------------------------|--------|------|
|             |           |                                                         | lb.    | kg   |
| 33033       | 975       | 975 Combo Roll Groover (Steel) for 300 PD               | 26.1   | 11,9 |
| 33588       | 975       | 975 Combo Roll Groover (Steel) for 300 Compact and 1233 | 56.1   | 25,5 |
| 33038       | 975       | 975 Combo Roll Groover (Copper) for 300 PD              | 26.1   | 11,9 |
| 67662       | —         | Adapter Bracket for 300 Compact                         | 15.9   | 7,2  |
| 33043       | —         | Roll Set Kit for 2" - 8" Copper Tube                    | 4.5    | 2,1  |
| 76822       | —         | Inch Diameter Tape                                      | 0.5    | 0,1  |
| 76827       | —         | Metric Diameter Tape                                    | 0.5    | 0,1  |
| 30708       | —         | Extension, ½" Drive, Locking                            | 0.5    | 0,1  |
| 30703       | —         | Ratchet, ½" Drive With 90° Bend                         | 1.7    | 0,8  |



For pipe stands, see page 2.4.



## Capacities

| Pipe Wall Thickness | Nominal Inch               | 1                  | 1¼                                                                    | 1½            | 2             | 2½            | 3             | 4             | 6             | 8             | 10            | 12             |
|---------------------|----------------------------|--------------------|-----------------------------------------------------------------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|----------------|
|                     | Schedule 10 in. (mm.)      | .109<br>(2,8)      | .109<br>(2,8)                                                         | .109<br>(2,8) | .109<br>(2,8) | .120<br>(3,0) | .120<br>(3,0) | .134<br>(3,4) | .134<br>(3,4) | .148<br>(3,8) | .165<br>(4,2) | .180<br>(4,6)  |
|                     | Schedule 40 in. (mm.)      | .133<br>(3,4)      | .149<br>(3,6)                                                         | .146<br>(3,7) | .154<br>(3,9) | .203<br>(5,2) | .216<br>(5,5) | .237<br>(6,0) | .280<br>(7,1) | .322<br>(8,2) | .365<br>(9,3) | .406<br>(10,3) |
| Pipe Diameter       | Nominal Metric mm          | 25,00              | 32,00                                                                 | 40,00         | 50,00         | 65,00         | 80,00         | 100,00        | 150,00        | 200,00        | 250,00        | 300,00         |
|                     | Actual O.D. Metric         | 33,40              | 42,16                                                                 | 48,26         | 60,33         | 73,03         | 88,90         | 114,30        | 168,28        | 219,08        | 273,05        | 323,85         |
| Model No.           | Machine                    | Material           |                                                                       |               |               |               |               |               |               |               |               |                |
| 975                 | 300<br>300 Compact<br>1233 | Steel mm           | EN 10255, DIN 2440, 2441, 2448, 2458 up to maximum 5,4 wall thickness |               |               |               |               |               |               |               |               |                |
|                     |                            | Stainless Steel mm | Up to maximum 4,5 wall thickness                                      |               |               |               |               |               |               |               |               |                |
|                     |                            | Use Roll Set       | Standard equipment                                                    |               |               |               |               |               |               |               |               |                |
|                     |                            | Copper             | ISO 274 / EN 1057                                                     |               |               |               |               |               |               |               |               |                |
|                     |                            | Use Roll Set       | Standard equipment with 33038 / 33043                                 |               |               |               |               |               |               |               |               |                |

## Power-Driven Model 916 Roll Groover



Model 916  
300 Power Drive  
not included in  
the standard  
equipment.

The RIDGID® Model 916 Roll Groover is the most durable and efficient lightweight portable unit available. Built with a solid, durable cast-iron housing, it withstands heavy usage, yet is light enough for easy transportation. It features a patented single stroke feed mechanism that allows for accurate operation quickly and effortlessly.

### Features

- Specifically designed for field service roll grooving applications.
- Quick and easy mount to RIDGID® Model 300 Power Drive, Model 535, Model 300 Compact and Model 1233 Machines. See chapter 4 of the catalog.
- Cam-type feed actuation – translates into minimum operator effort to form roll grooves.
- Durable cast-iron housing withstands extensive field use.
- Depth adjustment screw separate from feed mechanism allows for consistent groove depth.
- Lightweight, only 33 lbs., allows for easy transport and storage.
- Integral feed handle is part of overall unit. No extra tools required.
- Optional Roll Sets for: Copper 2" - 6" (Types K, L, M, DWV), 1" Sch. 10, 40 steel pipe.
- Optional 1¼" - 1½" and 2" - 6" AWWA (American Water Works Association) Roll Sets.
- Easy serviceability – drive and groove rolls are easy to change.

### Standard Equipment

- One 2" - 6" Roll Groove Set for steel. (2" - 6" Schedule 10, 2" - 3" Schedule 40).

### Model 916 Ordering Information and Accessories

| Catalog No.        | Model No. | Description                            | Weight |      |
|--------------------|-----------|----------------------------------------|--------|------|
|                    |           |                                        | lb.    | kg   |
| 45007              | 916       | Roll Groover for 300 Power Drive       | 33     | 15   |
| 60382              | 916       | Roll Groover for 535                   | 33     | 15   |
| 48307              | 916       | Roll Groover for 300 Compact / 1233    | 33     | 15   |
| <b>Accessories</b> |           |                                        |        |      |
| 45347              | —         | Roll Set for 1" Sch. 10, 40 (optional) | 6      | 2,6  |
| 45352              | —         | Roll Set for Copper (optional)         | 6      | 2,6  |
| 69667              | —         | Roll Set for 1¼" - 1½" AWWA (optional) | 6      | 2,6  |
| 69692              | —         | Roll Set for 2" - 6" AWWA (optional)   | 6      | 2,6  |
| 67662              | —         | Adapter Bracket for 300 Compact*       | 30     | 13,6 |
| 76822              | —         | English Diameter Tape                  | 0.5    | 0,1  |
| 76827              | —         | Metric Diameter Tape                   | 0.5    | 0,1  |

*Note: A Roll Set consists of a Groove Roll and a Drive Roll.*

*\* The adapter bracket allows 916 Roll Groover for 300 Power Drive (#45007) to be mounted on a 300 Compact.*



## Capacities

| Pipe Wall Thickness |                                   | Nominal Inch          | 1                                                                     | 1¼            | 1½            | 2             | 2½                         | 3             | 4             | 6              | 8             | 10            | 12             |  |
|---------------------|-----------------------------------|-----------------------|-----------------------------------------------------------------------|---------------|---------------|---------------|----------------------------|---------------|---------------|----------------|---------------|---------------|----------------|--|
|                     |                                   | Schedule 10 in. (mm.) | .109<br>(2,8)                                                         | .109<br>(2,8) | .109<br>(2,8) | .109<br>(2,8) | .120<br>(3,0)              | .120<br>(3,0) | .134<br>(3,4) | .134<br>(3,4)  | .148<br>(3,8) | .165<br>(4,2) | .180<br>(4,6)  |  |
|                     |                                   | Schedule 40 in. (mm.) | .133<br>(3,4)                                                         | .149<br>(3,6) | .146<br>(3,7) | .154<br>(3,9) | .203<br>(5,2)              | .216<br>(5,5) | .237<br>(6,0) | .280<br>(7,1)  | .322<br>(8,2) | .365<br>(9,3) | .406<br>(10,3) |  |
| Pipe Diameter       |                                   | Nominal Metric mm     | 25,00                                                                 | 32,00         | 40,00         | 50,00         | 65,00                      | 80,00         | 100,00        | 150,00         | 200,00        | 250,00        | 300,00         |  |
|                     |                                   | Actual O.D. Metric    | 33,40                                                                 | 42,16         | 48,26         | 60,33         | 73,03                      | 88,90         | 114,30        | 168,28         | 219,08        | 273,05        | 323,85         |  |
|                     |                                   |                       |                                                                       |               |               |               |                            |               |               |                |               |               |                |  |
| Model No.           | Machine                           | Material              |                                                                       |               |               |               |                            |               |               |                |               |               |                |  |
| 916                 | 300<br>300 Compact<br>1233<br>535 | Steel                 | EN 10255, DIN 2440, 2441, 2448, 2458 up to maximum 5,4 wall thickness |               |               |               |                            |               |               |                |               |               |                |  |
|                     |                                   | Stainless Steel mm    | Up to maximum 4,5 wall thickness                                      |               |               |               |                            |               |               |                |               |               |                |  |
|                     |                                   | Use Roll Set          | 45347                                                                 | 69667         |               |               | Standard equipment / 69692 |               |               |                |               |               |                |  |
|                     |                                   | Steel - Heavy Wall mm |                                                                       |               |               |               |                            |               |               | Up to 7,1 wall |               |               |                |  |
|                     |                                   | Copper                |                                                                       |               |               |               | ISO 274 / EN 1057          |               |               |                |               |               |                |  |
|                     |                                   | Use Roll Set          |                                                                       |               |               |               | 45352                      |               |               |                |               |               |                |  |



## Model 918 Hydraulic Roll Groover



Model 918

The RIDGID® Model 918 Hydraulic Roll Groover features a powerful 15-ton hydraulic ram in a compact, easy to transport unit. With one man set-up and operation, it is the ideal groover for job site requirements. The Model 918 mounts quickly to RIDGID® models 300 power drive, 535, 300 Compact, 1233, or 1224 threading machines. (See pages 4.16, 4.20, 4.22, 4.26 and 4.28.) Designed to provide maximum efficiency, it is capable of grooving up to 12" Schedule 10 and 8" Schedule 40 standard wall pipes. Roll Set changeout is accomplished in seconds.

### Standard Equipment

- One 2" - 6" Schedule 10/40 Roll Set.
- One 8" - 12" Schedule 10 (8" Schedule 40) Roll Set.
- Tools for Roll Set Change.
- One Carrying case for Roll Sets.

### Model 918 Ordering Information and Accessories

| Catalog No.              | Model No. | Description                                                                                           | Weight |      |
|--------------------------|-----------|-------------------------------------------------------------------------------------------------------|--------|------|
|                          |           |                                                                                                       | lb.    | kg   |
| 48297                    | 918       | 918 Roll Groover w/300 Power Drive Mount Kit 2" - 12"                                                 | 104    | 47,2 |
| 57092                    | 918       | 918 Roll Groover w/1233/300 Compact Carriage Mount Kit 2" - 12"                                       | 128    | 58   |
| 19131                    | 918       | 918 Roll Groover w/1233/300 Compact Carriage Mount Kit 2" - 6"                                        | 112    | 51   |
| 48382                    | 918       | 918 Roll Groover w/1224 Carriage Mount Kit 2" - 12"                                                   | 131    | 59,5 |
| 48387                    | 918       | 918 Roll Groover w/535 Carriage Mount Kit 2" - 12"                                                    | 117    | 53,1 |
| 47222                    | 918 only  | 918 Roll Groover Only 2" - 12"                                                                        | 95     | 43,1 |
| 58682                    | 918 only  | 918 Roll Groover Only 2" - 6"                                                                         | 71     | 32   |
| <b>Mounting Kit Only</b> |           |                                                                                                       |        |      |
| 48292                    | 911       | 300 Power Drive Mount Kit Only                                                                        | 9      | 4    |
| 56607                    | —         | 1233/300 Compact Carriage Mount Kit Only                                                              | 22     | 10   |
| 48397                    | 914       | 1224 Carriage Mount Kit Only                                                                          | 36     | 16,4 |
| 48402                    | 915       | 535 Carriage Mount Kit Only                                                                           | 22     | 10   |
| <b>Accessories</b>       |           |                                                                                                       |        |      |
| 48405                    | —         | Roll Set for 8" - 12" Sch. 10 (8" Sch. 40) with carry case.                                           | 18     | 8,2  |
| 48407                    | —         | Roll Set for 1¼" to 1½" Sch. 10/40. Tool box includes drive shaft, bolt and tools.                    | 10     | 4,5  |
| 48412                    | —         | Roll Set for 1" Sch. 10/40, and 1¼" to 1½" Sch. 10/40. Tool box includes drive shaft, bolt and tools. | 20     | 9    |
| 48417                    | —         | Roll Set for copper (2" - 6")                                                                         | 10     | 4,5  |
| 51432                    | —         | Drive Roll 2" - 6"                                                                                    | 12,6   | 5,7  |
| 49217                    | —         | Groove Roll 2" - 6"                                                                                   | 22     | 10   |
| 59992                    | —         | 2½" - 12" Stabilizer for grooving nipples. For 918 w/300, 300 Compact, 1233 Mounting Kit or 918-I     | 11     | 5    |
| 49662                    | —         | Tool Box                                                                                              | 5      | 2    |
| 76822                    | —         | English Diameter Tape                                                                                 | 0,5    | 0,1  |
| 76827                    | —         | Metric Diameter Tape                                                                                  | 0,5    | 0,1  |

*Note: A Roll Set consists of a Groove Roll and a Drive Roll.*

*"Do not use to groove 8" schedule 40 steel pipe harder than 150 Brinell".*





## Capacities

| Pipe Wall Thickness |                                           | Nominal Inch          | 1                                                                     | 1¼            | 1½            | 2                | 2½                                | 3             | 4             | 6             | 8             | 10            | 12             |
|---------------------|-------------------------------------------|-----------------------|-----------------------------------------------------------------------|---------------|---------------|------------------|-----------------------------------|---------------|---------------|---------------|---------------|---------------|----------------|
|                     |                                           | Schedule 10 in. (mm.) | .109<br>(2,8)                                                         | .109<br>(2,8) | .109<br>(2,8) | .109<br>(2,8)    | .120<br>(3,0)                     | .120<br>(3,0) | .134<br>(3,4) | .134<br>(3,4) | .148<br>(3,8) | .165<br>(4,2) | .180<br>(4,6)  |
|                     |                                           | Schedule 40 in. (mm.) | .133<br>(3,4)                                                         | .149<br>(3,6) | .146<br>(3,7) | .154<br>(3,9)    | .203<br>(5,2)                     | .216<br>(5,5) | .237<br>(6,0) | .280<br>(7,1) | .322<br>(8,2) | .365<br>(9,3) | .406<br>(10,3) |
| Pipe Diameter       |                                           | Nominal Metric mm     | 25,00                                                                 | 32,00         | 40,00         | 50,00            | 65,00                             | 80,00         | 100,00        | 150,00        | 200,00        | 250,00        | 300,00         |
|                     |                                           | Actual O.D. Metric    | 33,40                                                                 | 42,16         | 48,26         | 60,33            | 73,03                             | 88,90         | 114,30        | 168,28        | 219,08        | 273,05        | 323,85         |
|                     |                                           |                       |                                                                       |               |               |                  |                                   |               |               |               |               |               |                |
| Model No.           | Machine                                   | Material              |                                                                       |               |               |                  |                                   |               |               |               |               |               |                |
| 918                 | 300<br>300 Compact<br>1233<br>535<br>1224 | Steel mm              | EN 10255, DIN 2440, 2441, 2448, 2458 up to maximum 7,1 wall thickness |               |               |                  |                                   |               |               |               |               |               |                |
|                     |                                           | Stainless Steel mm    | Up to maximum 5,6 wall thickness                                      |               |               |                  |                                   |               |               |               |               |               |                |
|                     |                                           | Use Roll Set          |                                                                       |               | 48407         |                  | Standard equipment/ 49217 + 51432 |               |               |               |               | 48405         |                |
|                     |                                           |                       |                                                                       | 48412         |               |                  |                                   |               |               |               |               |               |                |
|                     |                                           | Copper                |                                                                       |               |               | ISO 274/ EN 1057 |                                   |               |               |               |               |               |                |
|                     |                                           | Use Roll Set          |                                                                       |               |               | 48417            |                                   |               |               |               |               |               |                |

# ROLL GROOVING

## Model 918-I Roll Groover



The RIDGID® Model 918-I Roll Grooving Machine is capable of grooving 1" to 8" Schedule 40 and 1" to 12" Schedule 10 pipe faster than any roll grooving machine in its class. Powered by a 1.2 HP universal motor and heavy duty transmission, the Model 918-I produces high quality grooves consistently and effortlessly.

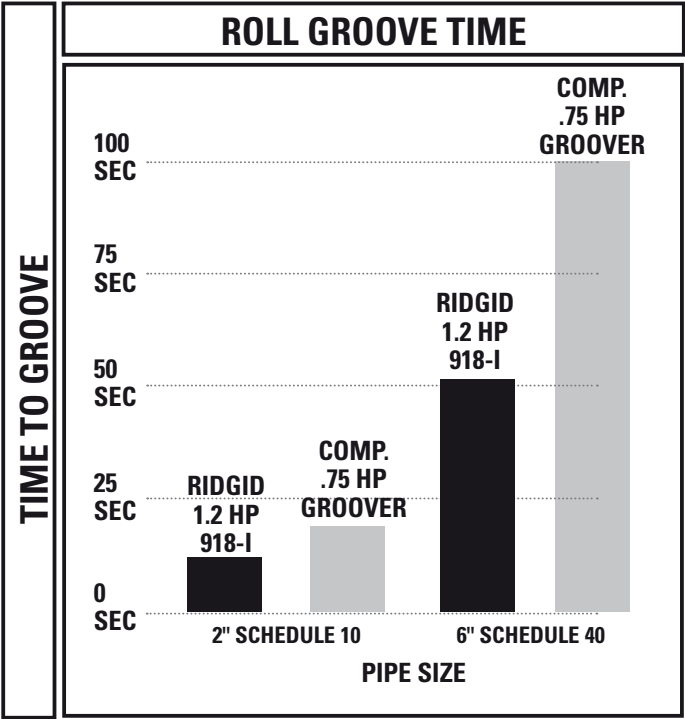
It comes standard with a rugged wheel stand built for mobility in the shop without compromising stability. The stand's tray is tough enough to support 200 lbs. (91 kg). The Model 918-I uses a custom-designed, two-stage hydraulic pump that minimizes pipe flare, operator fatigue and hydraulic fluid leaks.

### Features

- Fastest roll groove time in its class. (See Roll Groove Time chart below).
- Offers maximum versatility in roll grooving capacities (see specifications below).
- Custom engineered 2-stage, 15-ton hydraulic pump and ram eases grooving and reduces flare and operator's fatigue.
- Produces consistent, high quality roll grooves.

### Standard Equipment

- One 2" - 6" Schedule 10/40 Roll Set.
- One 8" - 12" Schedule 10 (8" Schedule 40) Roll Set.
- One Tool for Roll Set Changeout.
- One Carry Case for Roll Sets.
- One Heavy-Duty Wheel Stand with Tray.
- One Foot Switch.
- One 2½" - 12" Stabilizer for Grooving Nipples.



For pipe stands, see page 2.4.



## Model 918 Ordering Information and Accessories

| Catalog No.        | Model No. | Description                                                       | Weight |      |
|--------------------|-----------|-------------------------------------------------------------------|--------|------|
|                    |           |                                                                   | lb.    | kg   |
| 64977              | 918-I     | Roll Grooving Machine Complete. 115 V                             | 185    | 84,1 |
| 65902              | 918-I     | Roll Grooving Machine Complete. 230 V                             | 185    | 84,1 |
| <b>Accessories</b> |           |                                                                   |        |      |
| 48405              | —         | Roll Set for 8" - 12" Sch 10 (8" Sch 40) With Carry Case          | 18     | 8,2  |
| 48407              | —         | Roll Set for 1¼" - 1½" Sch 10/40 With Carry Case                  | 10     | 4,5  |
| 48412              | —         | Roll Set for 1" Sch 10/40 and 1¼" - 1½" Sch 10/40 With Carry Case | 20     | 9    |
| 48417              | —         | Roll Set for 2" - 6" Copper                                       | 10     | 4,5  |
| 51432              | —         | Drive Roll 2" - 6"                                                | 12,6   | 5,7  |
| 49217              | —         | Groove Roll 2" - 6"                                               | 22     | 10   |
| 59992              | —         | 2½" - 12" Stabilizer for Grooving Nipples                         | 11     | 5    |
| 76822              | —         | English Diameter Tape                                             | 0,5    | 0,1  |
| 76827              | —         | Metric Diameter Tape                                              | 0,5    | 0,1  |

Note: A Roll Set consists of a Groove Roll and a Drive Roll.

Note: "Do not use to groove 8" schedule 40 steel pipe harder than 150 Brinell".

## Capacities

| Pipe Wall Thickness | Nominal Inch          | 1             | 1¼            | 1½            | 2             | 2½            | 3             | 4             | 6             | 8             | 10            | 12             |
|---------------------|-----------------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|----------------|
|                     | Schedule 10 in. (mm.) | .109<br>(2,8) | .109<br>(2,8) | .109<br>(2,8) | .109<br>(2,8) | .120<br>(3,0) | .120<br>(3,0) | .134<br>(3,4) | .134<br>(3,4) | .148<br>(3,8) | .165<br>(4,2) | .180<br>(4,6)  |
|                     | Schedule 40 in. (mm.) | .133<br>(3,4) | .149<br>(3,6) | .146<br>(3,7) | .154<br>(3,9) | .203<br>(5,2) | .216<br>(5,5) | .237<br>(6,0) | .280<br>(7,1) | .322<br>(8,2) | .365<br>(9,3) | .406<br>(10,3) |
| Pipe Diameter       | Nominal Metric mm     | 25,00         | 32,00         | 40,00         | 50,00         | 65,00         | 80,00         | 100,00        | 150,00        | 200,00        | 250,00        | 300,00         |
|                     | Actual O.D. Metric    | 33,40         | 42,16         | 48,26         | 60,33         | 73,03         | 88,90         | 114,30        | 168,28        | 219,08        | 273,05        | 323,85         |

| Model No. | Machine               | Material           |                                                                       |
|-----------|-----------------------|--------------------|-----------------------------------------------------------------------|
| 918       | Integral Roll Groover | Steel mm           | EN 10255, DIN 2440, 2441, 2448, 2458 up to maximum 7,1 wall thickness |
|           |                       | Stainless Steel mm | Up to maximum 5,6 wall thickness                                      |
|           |                       | Use Roll Set       | 48407 Standard equipment / 49217 + 51432 48405                        |
|           |                       |                    | 48412                                                                 |
|           |                       | Copper             | ISO 274 / EN 1057                                                     |
|           |                       | Use Roll Set       | 48417                                                                 |

# ROLL GROOVING

## Model 920 Roll Groover



The RIDGID® Model 920 Roll Groover takes grooving to a whole new level. With a capacity range of 2" - 24" diameter pipe, it has the largest capacity of any RIDGID® roll groover. The Model 920 mounts to the RIDGID® Model 300 Power Drive for use in the field or shop. Also available is the Model RJ-624 Large Diameter Pipe Support for grooving pipe up to 24" in diameter, a perfect complement to the Model 920 Roll Groover (see page 2.5).

### Model 920 Benefits

- Largest grooving capacity in its class.
- Transportation Mode – Detachable Wheels enable one man to easily move the Model 920 around a jobsite.
- Patented Depth Setting Gauge – Easy and accurate groove depth setting does not require adjusting the protective guarding.
- Built-in Pressure Gauge – Helps operator monitor hydraulic pressure to control flare and optimize groove time.
- Front Roll Set Change-Out – User can switch groove roll sets quickly and easily.
- Easy Adjust Support Legs – Helpful when leveling the groover on uneven ground.

### Standard Equipment

- Model 920 Roll Groover with support legs.
- 2" - 6" Schedule 10/40 Groove Roll Set with box.
- 8" - 12" Schedule 10/40 Groove Roll Set.
- 14" - 16" Standard Wall (0.375) Groove Roll Set with box.
- Model 920 Training Video and User Manual.
- Transport wheels.

### Ordering Information and Accessories

| Catalog No. | Model No. | Description                                                                               | Weight |      |
|-------------|-----------|-------------------------------------------------------------------------------------------|--------|------|
|             |           |                                                                                           | lb.    | kg   |
| 95782       | 920       | 920 Roll Groover with 2" - 6" Sch. 40, 8" - 12" Sch. 40 and 14" - 16" Std. Wall Roll Sets | 199    | 90,3 |
| 96987       | —         | Drive and Groove Roll Set for 18" - 20" Sch. 10 Steel or Stainless Steel                  | 21     | 9,5  |
| 96992       | —         | Drive and Groove Roll Set for 22" - 24" Sch. 10 Steel or Stainless Steel                  | 22     | 10   |
| 96997       | —         | Drive and Groove Roll Set for 4" - 6" Sch. 40 Steel or Stainless Steel                    | 20     | 9    |
| 96982       | —         | Drive and Groove Roll Set for 2" - 8" Copper Tube Type K, L, M, and DMV                   | 20     | 9    |
| 96372       | RJ-624    | RJ-624 Large Diameter Pipe Stand                                                          | 167    | 75,7 |
| 76827       | —         | Metric Diameter Tape                                                                      | 0.5    | 0,1  |
| 76822       | —         | English Diameter Tape                                                                     | 0.5    | 0,1  |

*Note: See Pipe Stands on page 2.4.*



For pipe stands, see page 2.4.



## Capacities

| Pipe Wall Thickness |              | Nominal Inch          | 2                                                                     | 2½            | 3             | 4             | 6             | 8                          | 10            | 12             | 14           | 16           | 18           | 20           | 22           | 24           |  |
|---------------------|--------------|-----------------------|-----------------------------------------------------------------------|---------------|---------------|---------------|---------------|----------------------------|---------------|----------------|--------------|--------------|--------------|--------------|--------------|--------------|--|
|                     |              | Schedule 10 in. (mm.) | .109<br>(2,8)                                                         | .120<br>(3,0) | .120<br>(3,0) | .134<br>(3,4) | .134<br>(3,4) | .148<br>(3,8)              | .165<br>(4,2) | .180<br>(4,6)  | .25<br>(6,4) | .25<br>(6,4) | .25<br>(6,4) | .25<br>(6,4) | .25<br>(6,4) | .25<br>(6,4) |  |
|                     |              | Schedule 40 in. (mm.) | .154<br>(3,9)                                                         | .203<br>(5,2) | .216<br>(5,5) | .237<br>(6,0) | .280<br>(7,1) | .322<br>(8,2)              | .365<br>(9,3) | .406<br>(10,3) | —            | —            | —            | —            | —            | —            |  |
| Pipe Diameter       |              | Nominal Metric mm     | 50,00                                                                 | 65,00         | 80,00         | 100,00        | 150,00        | 200,00                     | 250,00        | 300,00         | 350,00       | 400,00       | 450,00       | 500,00       | 550,00       | 600,00       |  |
|                     |              | Actual O.D. Metric    | 60,33                                                                 | 73,03         | 88,90         | 114,30        | 168,28        | 219,08                     | 273,05        | 323,85         | 355,60       | 406,40       | 457,20       | 508,00       | 559,00       | 609,90       |  |
|                     |              |                       |                                                                       |               |               |               |               |                            |               |                |              |              |              |              |              |              |  |
| Model No.           | Machine      | Material              |                                                                       |               |               |               |               |                            |               |                |              |              |              |              |              |              |  |
| 920                 | Roll Groover | Steel mm              | EN 10255, DIN 2440, 2441, 2448, 2458 up to maximum 7,1 wall thickness |               |               |               |               |                            |               |                | Max. 6,4     | Max. 6,4     | Max. 6,4     | Max. 6,4     | Max. 6,4     | Max. 6,4     |  |
|                     |              | Use Roll Set          | Standard equipment / 10843                                            |               |               |               |               | Standard equipment / 10848 |               |                | 10853        |              | 96987        |              | 96992        |              |  |
|                     |              | Stainless Steel mm    | Up to maximum 4,5 wall thickness                                      |               |               |               |               |                            |               |                | Max. 5,6     | Max. 5,6     | Max. 5,6     | Max. 5,6     | Max. 5,6     | Max. 5,6     |  |
|                     |              | Use Roll Set mm       | Standard equipment / 10843                                            |               |               | 96997         |               | Standard equipment / 10848 |               |                | 10853        |              | 96987        |              | 96992        |              |  |
|                     |              | Copper                | ISO 274 / EN 1057                                                     |               |               |               |               |                            |               |                |              |              |              |              |              |              |  |
|                     |              | Use Roll Set          | 96982                                                                 |               |               |               |               |                            |               |                |              |              |              |              |              |              |  |

## ROLL GROOVING