

**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.



Roll Grooving Type	No. of Models	Pipe Capacity (in.)	Page
915 Manual Roll Groover	1	1¼ - 12	5.3
975 Combo Roll Groover	2	1¼ - 6	5.4
916 Power-Driven Roll Groover	4	2 - 6	5.5
918 Hydraulic Roll Groover	5	1 - 12	5.6
918-I Electric Roll Groover	2	1 - 12	5.7
920 Electric Roll Groover	1	2 - 24	5.8



# ROLL GROOVING

	975	916	915	918	918-1	920
						
<b>Capacity</b>	Page 5.4 1¼"-6"	Page 5.5 ¼"-6"	Page 5.3 1¼"-12"	Page 5.6 1"-12"	Page 5.7 1"-12"	Page 5.8 2"-24"
<b>Weight</b>	26 lbs.	33 lbs.	23 lbs.	81 lbs.	185 lbs.	160 lbs.
<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 or hand**	RIDGID 300 / Page 4.16 RIDGID 535* / Page 4.20	Hand	RIDGID 300 / Page 4.16 RIDGID 535* / Page 4.20	Included	RIDGID 300 / Page 4.16
<b>Usage</b>	Field	Field	Field	Fab Shop / Field	Fab Shop/Field	Fab Shop/Field

\* Adapter pieces required.  
\*\* Works as powered or in-place groover.  
Note: Please check schedules in charts.

## PIPE SIZE & SCHEDULE CAPACITIES

Model	Material	Pipe Size (inches)/Schedule																	
		1	1¼	1½	2	2½	3	3½	4	4½	5	6	8	10	12	14	16	18-24	
975 page 5.4	Steel	Sch. 5, 10, 40																	
	Stainless	Sch. 5, 10, 40																	
	Aluminum	Sch. 5, 10, 40																	
	PVC	40	Sch. 40, 80										Sch. 40						
	Copper	K, L, M & DW																	
916 page 5.5	Steel	Sch. 5, 10, 40																	
	Stainless	5, 10	Sch. 5, 10, 40										Sch. 5, 10						
	Aluminum	Sch. 5, 10, 40																	
	PVC	Sch. 40	Sch. 40, 80										Sch. 40						
	Copper	K, L, M & DW																	
915 page 5.3	Steel	Sch. 5, 10, 40																	
	Stainless	Sch. 5, 10, 40																	
	Aluminum	Sch. 5, 10, 40																	
	PVC	40	40, 80	40	Sch. 40, 80										Sch. 40				
	Copper	K, L, M & DW																	
918/918-1 page 5.6 & 5.7	Steel	Sch. 5, 10, 40																	
	Stainless	5, 10	Sch. 5, 10, 40										Sch. 5, 10						
	Aluminum	Sch. 5, 10, 40																	
	PVC	40	40	40, 80	40	Sch. 40, 80										Sch. 40			
	Copper	K, L, M & DW																	
920 page 5.8	Steel	Sch. 5, 10, 40*																	
	Stainless	Sch. 5, 10, 40*																	
	Aluminum	Sch. 5, 10, 40*																	
	PVC	40	Sch. 40, 80										Sch. 40						
	Copper	K, L, M & DW																	

\* 8" grooving is not recommended for Sch. 40 if pipe hardness is above 150 BHN.  
\*\* Std. = Standard wall thickness (.375).  
Note: Use of roll sets on both carbon and stainless steel pipe can lead to contamination of the stainless material. This contamination could cause corrosion and premature pipe failure.  
To prevent ferrous contamination, use roll sets dedicated for stainless steel grooving.  
Note: Consult groover manual for exact capacity specifications.

## ROLL GROOVER/THREADER COMPATIBILITY

Roll Groover Model	Threader Model					
	1215*	300 Complete	300 Compact	535 Manual	535 Auto*	1224
916	-	45007	67662	60382	-	-
975	-	91207	-	-	-	-
918-1	-	48297	-	-	-	-
918-2	-	-	-	-	-	-
918-4	-	-	-	-	-	48382
918-5	-	-	-	48387	-	-
920	-	95782	-	-	-	-

\*Not recommended for roll grooving applications.

## Manual Roll Groovers



### 915 ROLL GROOVER

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

- Easy to use Depth Setting Gauge – Helps make accurate grooves.
- 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° bend-in handle makes grooving easier.

### SPECIFICATIONS

- Capacity – 1 ¼" - 12" Schedule 10 steel and stainless steel pipe
  - 2" - 8" K, L, M, DWV copper
  - 1 ¼" - 6" Schedule 40 PVC
  - 1 ½", 2 ½" - 3" Schedule 80 PVC
- Weight – 23 lbs. (including ratchet)
- Operation – Feed screw with ½" ratchet wrench (included)

Catalog No.	Model No.	Description	Weight	
			lb.	kg
88232	915	915 Roll Groover with 2" - 6" Sch. 10 (2" - 3 ½" Sch. 40) Roll Set	23	10.4

### Accessories

Catalog No.	Description	Weight	
		lb.	kg
92437	Drive and Groove Roll Set for 1¼" - 1½" Sch. 10 or 40 Steel, Stainless Steel, PVC	2.0	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	2.0	0.9
92452	Drive and Groove Roll Set for 2" - 8" Copper Tube Type K, L, M, and DWV	21.5	9.7
93497	915 Tool Box	0.5	0.1
76827	Metric Diameter Tape	0.9	0.4
76822	Inch Diameter Tape	1.3	0.6
93642	Groove Roll 2" - 6"		
93757	Drive Roll 2" - 6"		

*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.*

### Standard Equipment

Catalog No. Model No.	98232 915
93642 – Groove Roll 2" - 6"	•
93757 – Drive Roll 2" - 6"	•
92202 – Ratchet ½" Drive with 90° Bend	•

## Combo Roll Groovers



975 Roll Groover with Power Drive

### 975 COMBO ROLL GROOVER

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. It 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 AutoTracking gauge keeps the pipe automatically engaged to the groover throughout the grooving process. The 975 also includes a permanently 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 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.

### SPECIFICATIONS

- **Capacity** – 1 1/4" – 6" Schedule 10 and Schedule steel, aluminum, and PVC pipe
  - 1 1/4" – 6" Schedule 10, 1 1/4"
  - 2" Schedule 40 stainless steel pipe, 1 1/2"
  - 4" Schedule 80 PVC pipe
  - With roll change, 2" – 8" copper tube (Type K, L, M, and DWV)
- **Depth Adjustment** – Adjusting screw and integral, index depth gauge
- **Actuation** – Feed screw with 1/2" ratchet wrench (included), or any 15/16" hex wrench
- **Power Drive Mounting** – RIDGID 300 Power Drive 38/57 RPM (reverse direction only)

Catalog No.	Model No.	Description	Weight	
			lb.	kg
25638	975	975 Combo Roll Groover	26.1	11.9
32828		975 Combo Roll Groover for Use with Copper Tube		



### Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
32833	975	Roll Set Kit for 2" - 8" Copper Tube	5	2.3
67642	-	Adapter Bracket for 300 compact	30.0	13.6
76822	-	Inch Diameter Tape	1/2	0.1
76827	-	Metric Diameter Tape		

### Standard Equipment

Catalog No. Model No.	25638 975 Model 300	32828 975 Model 300
30883 - Shaft, Drive	●	
30933 - Roll Groove	●	
30703 - Ratchet, 1/2" Drive With 90° Bend	●	●
30708 - Extension, 1/2" Drive, Locking	●	●
87682 - Support Bar (2)	●	●
32833 - Roll Set Kit for 2" - 8" Copper Tube		●

## Power Roll Groovers



### POWER-DRIVEN 916 ROLL GROOVER

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. The 916 features a patented single stroke feed mechanism that allows for accurate operation quickly and effortlessly.

- Specifically designed for field service roll grooving applications.
- Quick and easy mount to RIDGID 300 Power Drive, 535 or 300 Compact Threading Machines.
- **Cam-type feed actuation** – translates into minimum operator effort to form roll grooves.
- Depth adjustment screw separate from feed mechanism allows for consistent groove depth.
- Lightweight for easy transport and storage.
- Integral feed handle is part of overall unit. No extra tools required.
- **Easy serviceability** – drive and groove rolls are easy to change.

### SPECIFICATIONS

- **Capacity** – 1 1/4" - 6" Schedule 10 steel and stainless steel
  - 1 1/4" - 3" Schedule 40 steel and stainless steel
  - Optional 2" - 6" copper (Type K, L, M, DWV)
  - Optional 1" Schedule 10, 40 steel pipe
  - 1 1/4" - 1 1/2" and 2" - 6" AWWA roll sets

Catalog No.	Model No.	Description	Weight	
			lb.	kg
45007	916	Roll Groover for 300 Power Drive	33	15
46852		Roll Groover for Copper Tubing for 300 Power Drive	34	15.5
60382		Roll Groover for 535	33	15
48307		Roll Groover for 300 Compact/ 1233		

### Accessories

Catalog No.	Description	Weight	
		lb.	kg
45347	Roll Set f/1" incl. Ref. No. 35 36	6	2.6
45352	Roll Set f/Copper Tubing incl. Ref. No. 35 36		
69667	Roll Set 1 1/4" to 1 1/2" (AWWA)		
69692	Roll Set 2" to 6" (AWWA)	30	13.6
67662	Adapter Bracket for 300 Compact		
76822	Inch Diameter Tape	1/2	0.1
76827	Metric Diameter Tape		

### Standard Equipment

Catalog No. Model No. Power Drive Mounting	45007 916 Model 300	46852 916 Model 300	60382 916 Model 535	48307 916 Models 300 Compact/1233
45397 - Shaft, ASM Drive 916	•	•	•	•
45587 - Roll, Groove w/bearing	•	•	•	•

## Power Roll Groovers



### 918 ROLL GROOVER

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, the 918 is the ideal groover for job site requirements. The 918 mounts quickly to RIDGID 300 power drive, 535, 1822, or 1224 Threading Machines. Designed to provide maximum efficiency, the 918 is capable of grooving up to 12" Schedule 10 and 8" Schedule 40 standard wall pipes.

- Compact lightweight design allows for easy transport.
- Extensive grooving capacity for a wide range of applications.
- Rugged, durable housing enables unit to withstand harsh use.
- Two-stage pump plus 15 ton ram permit quick and smooth operation.
- Quick easy set-up. Easy rollset changeout.
- Specifically designed groove and drive rolls product consistent, accurate grooves throughout the capacity range.

### SPECIFICATIONS

- Capacity – 1" - 12" Sch. 10 Steel, Stainless Steel
  - 1" - 8" Sch 40 Steel, PVC
  - 1" - 2" Sch 40 Stainless Steel
  - 2" - 6" Copper (Type K, L, M, & DWV)
  - 2 ½"-4" Sch 80 PVC

Catalog No.	Model No.	Description	Weight	
			lb.	kg
48297	918-1	918 Roll Groover w/300 Power Drive Mount Kit	104	47.2
48377	918-2	918 Roll Groover w/1822 Power Drive Mount Kit	134	60.9
48382	918-4	918 Roll Groover w/1224 Carriage Mount Kit	131	59.5
48387	918-5	918 Roll Groover w/535 Carriage Mount Kit	117	53.1
47222	918 only	918 Roll Groover Only	95	43.1

### Mounting Kit Only

Catalog No.	Model No.	Description	Weight	
			lb.	kg
48292	911	300 Power Drive Mount Kit Only	9	4
48392	912	1822 Carriage Mount Kit Only	39	17.7
48397	914	1224 Carriage Mount Kit Only	36	16.4
48402	915	535 Carriage Mount Kit Only	22	10

### Accessories

Catalog No.	Description	Weight	
		lb.	kg
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
59992	2½"- 12" Stabilizer for Grooving Nipples	11	5
49662	Tool Box	5	2
76822	Inch Diameter Tape	½	0.1
76827	Metric Diameter Tape		

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.

### Standard Equipment

Catalog No. Model No.	48297 918-1 Model 300	48377 918-2 Model 1822	48362 918-4 Model 1224	48367 918-5 Model 535	47222 918 only -
48405 - Roll Set for 8"-12" Sch 10 (8" Sch 40) With Carry Case	•	•	•	•	•
49217 - Groove Roll 2" - 6"	•	•	•	•	•
51432 - Drive Roll 2" - 6"	•	•	•	•	•
53987 - Roll Storage Case	•	•	•	•	•
29087 - T Handle hex key 1/8"	•	•	•	•	•
54317 - Box Wrench	•	•	•	•	•
48292 - 300 Power Drive Mount Kit Only	•				
48392 - 1822 Carriage Mount Only		•			
48397 - 1224 Carriage Mount Kit Only			•		
48402 - 535 Carriage Mount Kit Only				•	

## Power Roll Groovers



### 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, it produces high quality grooves consistently and effortlessly. 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. Features a custom-designed, two-stage hydraulic pump that minimizes pipe flare, operator fatigue and hydraulic fluid leaks.

### SPECIFICATIONS

- **Capacity** – 1" - 12" Schedule 10 steel and stainless steel
  - 1" - 8" Schedule 40 steel, stainless steel and PVC
  - 2" - 6" copper (types K, L, M & DWV)
  - 1½", 2½" - 4" Schedule 80 PVC
- **Motor** – Universal 1/2 HP, 45 RPM (no load). Approved by CSA to CSA and UL standards.
- **Motor Control** – On/off heavy-duty with foot switch

Catalog No.	Model No.	Description	Voltage		Weight	
			V	lb.	kg	
64977	918-I	Roll Grooving Machine Complete	115	185	84.1	
65902		Roll Grooving Machine (230V)	230			

### Accessories

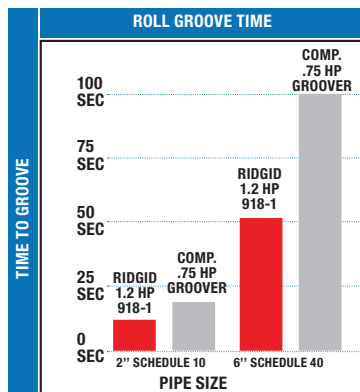
Catalog No.	Description	Weight	
		lb.	kg
48405	Roll Set for 8"-12" Sch 10 (8" Sch 40) With Carry Case	18	8.2
48407	Roll Set for 1¼"-1½" Sch 10/40 With Carry Case	10	4.5
48412	Roll Set for 1" Sch 10/40 and 1¼"-1½" Sch 10/40 with Carry Case	20	9
48417	Roll Set for 2"-6" Copper	10	4.5
59992	2½"- 12" Stabilizer for Grooving Nipples	11	5
76822	Inch Diameter Tape	½	0.1
76827	Metric Diameter Tape		

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.

### Standard Equipment

Catalog No. Model No.	64977 918-I	65902 918-I
36642 - Footswitch, ASM	•	•
48405 - Roll Set for 8"-12" Sch 10 (8" Sch 40) With Carry Case	•	•
49217 - Groove Roll 2" - 6"	•	•
51432 - Drive Roll 2" - 6"	•	•
59992 - 2½"- 12" Stabilizer for Grooving Nipples	•	•
64192 - Stand, ASM 9181	•	•
49087 - T-Handle Hex Key, ⅜"	•	•
54317 - Box Wrench	•	•
67192 - Spanner Wrench	•	•
67197 - Hex Key ⅜"	•	•
53987 - Roll Storage Case	•	•



## Power Roll Groovers



### 920 ROLL GROOVER

The RIDGID® 920 Roll Groover takes grooving to a whole new level. With a capacity range of 2"-24" diameter pipe, the 920 has the largest capacity of any RIDGID roll groover. The 920 mounts to the RIDGID 300 Power Drive for use in the field or shop. Also available is the RJ624 Large Diameter Pipe Support for grooving pipe up to 24" in diameter, a perfect complement to the 920 Roll Groover.

- Largest grooving capacity in its class.
- **Transportation Mode** – Detachable wheels enable one man to easily move the 920 around a jobsite. Also available is a Model No. 32 Transporter.
- **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.

### SPECIFICATIONS

- **Capacity** – 2" -12" Schedule 5, 10, & 40 steel, stainless steel and aluminum\*
  - 14" - 16" Schedule 5 & 10 steel, stainless steel and aluminum
  - 18" - 24" .250 wall steel, stainless steel and aluminum
  - 2" - 8" Schedule 40 PVC
  - 2½" - 4 Schedule 80 PVC
  - 2" - 8" copper (K & L)
  - 2½" - 8" copper (K, L, & M)
  - 3" - 8" copper (DWW)

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	380	90.3

### Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
42575	32	#32 Transport Cart	14 ¼	6.5
76822		Inch Diameter Tape	½	0.1
76827		Metric Diameter Tape		
96372	RJ624	Large Diameter Pipe Stand	167	75.7
96982		Drive and Groove Roll Set for 2" - 8" Copper Tube Type K, L, M, and DMV	20	9
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

### Standard Equipment

Catalog No. Model No.	95782 920
42575 - #32 Transporter (for Power Drives and Tristand Vises)	●
920 Training Video And User Manual	●
10843 - Set of Rolls 2-6" 920	●
10848 - Set of Rolls 8-12" 920	●
10853 - Set of Rolls 14-16" 920	●