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RIDGID 47222

RIDGID 47222 918 Hydraulic Roll Groover Instruction Manual

1. Introduction

This manual provides essential information for the safe and effective operation, setup, and maintenance of the RIDGID 47222 918 Hydraulic Roll Groover. The 918 Roll Groover is designed for creating consistent, accurate grooves on various pipe materials, including steel, stainless steel, aluminum, and PVC pipes. It features a 15-ton hydraulic ram and a 2-stage pump for efficient performance and is compatible with RIDGID 300 Power Drive, 535M, 535A, 1822, and 1224 Threading Machines.

Please read this manual thoroughly before operating the equipment to ensure proper usage and to prevent injury or damage.

2. Safety Information

Always adhere to general safety practices when operating power tools. Failure to follow these instructions may result in serious injury or property damage.

- Read and understand all instructions before operating the tool.
- Wear appropriate personal protective equipment (PPE), including safety glasses, gloves, and hearing protection.
- Ensure the work area is clean, well-lit, and free from obstructions.
- Keep bystanders and children away from the operating area.
- Disconnect power before making adjustments, changing accessories, or performing maintenance.
- Secure the workpiece properly to prevent movement during operation.
- Do not operate the tool if you are tired or under the influence of drugs, alcohol, or medication.
- Use only RIDGID-approved accessories and parts.

3. Product Overview and Components

The RIDGID 918 Roll Groover is a hydraulic tool designed for efficient pipe grooving. Key components include the hydraulic ram, 2-stage pump, and groove and drive roll sets.



Figure 1: RIDGID 918 Roll Groover attached to a power drive unit. The image shows the main body of the groover, the hydraulic pump handle, and the connection point to a power drive.



Figure 2: Side view of the RIDGID 918 Roll Groover, highlighting the hydraulic mechanism and the pipe support system.

Key Features:

- 15-ton hydraulic ram for powerful grooving.
- 2-stage pump for efficient pressure delivery.
- Compatibility with RIDGID 300 Power Drive, 535M, 535A, 1822, and 1224 Threading Machines.
- Interchangeable groove and drive roll sets for various pipe sizes and materials.

4. Setup

4.1 Mounting the Groover

The 918 Roll Groover is designed for quick and easy one-person setup. It mounts directly to compatible RIDGID power drives.

1. Ensure the power drive is stable and securely positioned.
2. Align the mounting points of the 918 Roll Groover with the corresponding points on the RIDGID 300 Power Drive (or other compatible models).

3. Secure the groover to the power drive using the provided fasteners. Refer to the power drive's manual for specific mounting instructions.
4. Verify that all connections are tight and secure before proceeding.

4.2 Installing Groove and Drive Rolls

Select the appropriate groove and drive roll set for the pipe size and material you intend to groove.

1. Ensure the machine is powered off and disconnected from the power source.
2. Remove the existing roll set, if any, by following the instructions in the assembly guide.
3. Install the desired groove and drive rolls, ensuring they are correctly seated and secured. Roll set changeout is designed to be accomplished in seconds.
4. Confirm that the rolls rotate freely and are properly aligned.

5. Operating Instructions

Follow these steps for safe and effective pipe grooving.

1. **Prepare the Pipe:** Ensure the pipe end is clean, deburred, and free of any obstructions.
2. **Position the Pipe:** Place the pipe into the groover, ensuring it rests firmly on the support rollers and is centered between the groove and drive rolls.
3. **Engage the Power Drive:** Turn on the compatible RIDGID power drive. The drive rolls will begin to rotate the pipe.
4. **Apply Hydraulic Pressure:** Use the hydraulic pump handle to gradually apply pressure, bringing the groove roll into contact with the pipe. The 2-stage pump delivers high pressure with fewer strokes.
5. **Form the Groove:** Continue to pump the hydraulic handle, slowly increasing pressure until the desired groove depth is achieved. Monitor the grooving process to ensure a consistent and accurate groove.
6. **Release Pressure:** Once the groove is complete, release the hydraulic pressure slowly.
7. **Remove the Pipe:** Turn off the power drive and carefully remove the grooved pipe.
8. **Inspect the Groove:** Check the groove for proper depth, width, and consistency.

Grooving Capabilities:

- 1" - 12" Schedule 10 steel, stainless steel, PVC
- 1" - 8" Schedule 40 steel, PVC
- 1" - 2" Schedule 40 stainless steel
- 2" - 6" Copper (Types K, L, M, DWV)
- 2-1/2" - 6" Schedule 80 PVC

6. Maintenance

Regular maintenance ensures the longevity and optimal performance of your RIDGID 918 Roll Groover.

- **Cleaning:** After each use, clean the groover to remove any metal shavings, dirt, or debris. Use a brush or compressed air.
- **Lubrication:** Periodically lubricate moving parts as indicated in the detailed assembly guide.
- **Hydraulic Fluid:** Check the hydraulic fluid level regularly and refill if necessary with the recommended hydraulic fluid. Refer to the assembly guide for fluid specifications and procedures.
- **Roll Inspection:** Inspect groove and drive rolls for wear or damage. Replace worn rolls to maintain groove quality.

- **Storage:** Store the groover in a clean, dry environment when not in use.

7. Troubleshooting

This section addresses common issues you might encounter with the RIDGID 918 Roll Groover.

Problem	Possible Cause	Solution
Inconsistent groove depth	Worn rolls, improper pipe alignment, insufficient hydraulic pressure.	Inspect and replace rolls, ensure pipe is centered, check hydraulic fluid level and pump operation.
Groover not engaging pipe	Insufficient hydraulic pressure, incorrect roll set for pipe size, pipe not properly seated.	Increase hydraulic pressure, verify correct roll set, re-seat pipe.
Hydraulic pump not building pressure	Low hydraulic fluid, air in the system, faulty pump seals.	Check and refill hydraulic fluid, bleed air from the system (refer to assembly guide), contact service for pump repair.

For issues not listed here, or if solutions do not resolve the problem, contact RIDGID customer support.

8. Specifications

Feature	Detail
Model Number	47222
Hydraulic Ram Force	15 tons
Pump Type	2-Stage Hydraulic
Compatibility	RIDGID 300 Power Drive, 535M, 535A, 1822, 1224 Threading Machines
Grooving Capacity (Steel, Stainless Steel, PVC)	1" - 12" Schedule 10; 1" - 8" Schedule 40 (steel, PVC); 1" - 2" Schedule 40 (stainless steel)
Grooving Capacity (Copper)	2" - 6" (Types K, L, M, DWV)
Grooving Capacity (Schedule 80 PVC)	2-1/2" - 6"
Item Weight	95 pounds
Product Dimensions	27.56 x 11.81 x 7.87 inches
Handle Material	Polyvinyl Chloride

9. Warranty and Support

9.1 Warranty Information

RIDGID covers its products with a **Full Lifetime Warranty** against defects in material or workmanship for the life of the tool. For specific terms and conditions, please refer to the official RIDGID warranty documentation or visit their website.

9.2 Customer Support

For technical assistance, parts, or service, please contact RIDGID customer support. Contact information can typically be found on the official RIDGID website or through your local authorized dealer.

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