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RIDGID 46852

RIDGID 46852 916 Roll Groover for Copper Instruction Manual

1. Product Overview

The RIDGID 46852 916 Roll Groover is a robust tool designed for creating roll grooves in various pipe materials. It offers efficient and consistent grooving for applications involving steel, stainless steel, PVC, and copper pipes. This groover is engineered for quick and secure mounting onto compatible RIDGID Power Drives and Threading Machines, ensuring ease of use and reliable performance in demanding environments.

Key features include a cam-type feed actuation system that minimizes operator effort, a durable cast-iron housing built to withstand extensive field use, and a separate depth adjustment screw for precise and consistent groove depth control. Its lightweight design facilitates easy transport and storage, making it a versatile tool for professional use.



Figure 1: The RIDGID 46852 916 Roll Groover, a tool for creating grooves in various pipe materials.

2. Safety Information

Always prioritize safety when operating the RIDGID 46852 916 Roll Groover. Failure to follow these safety guidelines may result in serious injury or damage to the equipment.

- **Read the Manual:** Before operation, thoroughly read and understand this instruction manual and the manual for the power drive unit.
- **Personal Protective Equipment (PPE):** Always wear appropriate safety glasses or goggles, work gloves, and hearing protection.
- **Work Area:** Ensure your work area is clean, well-lit, and free from obstructions. Keep bystanders away from the operating machine.
- **Secure Workpiece:** Always ensure the pipe is properly secured and supported before grooving.
- **Power Disconnection:** Disconnect the power drive from its power source before making any adjustments, changing roll sets, or performing maintenance.

- **Inspect Tool:** Before each use, inspect the groover and power drive for any damage, loose parts, or worn components. Do not operate damaged equipment.
- **Proper Use:** Use the tool only for its intended purpose of roll grooving pipes. Do not modify the tool or use it for unintended applications.

3. Setup

3.1 Mounting the Groover

The 46852 916 Roll Groover is designed for quick and easy mounting to RIDGID Nos. 300 Power Drive, 535, or 1822 Threading Machines. Refer to your power drive's instruction manual for specific mounting procedures.

1. Ensure the power drive is disconnected from its power source.
2. Align the groover's mounting points with the corresponding points on the power drive.
3. Securely fasten the groover to the power drive using the provided hardware or integrated clamping mechanism. Ensure it is stable and does not wobble.

3.2 Installing Roll Sets

Select the appropriate roll set for the pipe material and size you intend to groove. Optional roll sets are available for various copper pipe types (K, L, M, DWV), steel pipe (Sch. 10, 40), and AWWA specifications.

1. With the power drive disconnected, locate the roll set retention mechanism on the groover.
2. Remove the existing roll set, if any, by disengaging the retention mechanism.
3. Carefully insert the desired drive roll and groove roll into their respective positions. Ensure they are correctly seated and aligned.
4. Secure the new roll set by engaging the retention mechanism. Verify that the rolls are firmly in place and can rotate freely.

3.3 Adjusting Groove Depth

The groover features a depth adjustment screw separate from the feed mechanism, allowing for precise and consistent groove depth.

- Turn the depth adjustment screw to set the desired groove depth. Consult pipe manufacturer specifications for recommended groove dimensions.
- Perform a test groove on a scrap piece of pipe to verify the depth before grooving the final workpiece. Adjust as necessary.

4. Operation

4.1 Preparing the Pipe

- Ensure the pipe ends are clean, deburred, and free of any obstructions or deformities.
- Mark the desired location for the groove on the pipe.
- Support the pipe adequately on both sides of the groover to prevent sagging or misalignment during operation.

4.2 Grooving Procedure

1. With the power drive connected and the groover mounted, position the pipe between the drive and groove rolls at the marked location.
2. Engage the power drive to start the pipe rotating.

3. Slowly actuate the cam-type feed handle to bring the groove roll into contact with the pipe. Apply steady pressure to form the groove.
4. Continue feeding until the desired groove depth is achieved, as indicated by the depth adjustment setting or visual inspection.
5. Once the groove is complete, disengage the feed handle and allow the pipe to rotate briefly to ensure a smooth finish.
6. Stop the power drive and carefully remove the grooved pipe.

5. Maintenance

Regular maintenance ensures the longevity and optimal performance of your RIDGID 46852 916 Roll Groover.

- **Cleaning:** After each use, clean the groover thoroughly to remove any metal shavings, dirt, or debris. Use a brush or compressed air.
- **Roll Set Inspection:** Periodically inspect the drive and groove rolls for wear, damage, or excessive buildup. Replace worn or damaged rolls promptly to maintain groove quality.
- **Lubrication:** Apply a light coat of machine oil to moving parts and pivot points as needed to ensure smooth operation and prevent corrosion. Avoid over-lubrication.
- **General Inspection:** Regularly check all fasteners for tightness. Inspect the cast-iron housing for cracks or damage.
- **Storage:** Store the groover in a clean, dry environment when not in use.

6. Troubleshooting

This section addresses common issues you might encounter during operation.

Problem	Possible Cause	Solution
Inconsistent groove depth	Incorrect depth adjustment; Worn roll set; Insufficient pipe support	Re-adjust depth screw; Replace roll set; Ensure proper pipe support
Difficulty feeding pipe	Rolls are dirty or damaged; Insufficient lubrication; Pipe not properly aligned	Clean or replace rolls; Lubricate moving parts; Re-align pipe
Groover not mounting securely	Mounting points obstructed; Incorrect alignment; Damaged mounting hardware	Clean mounting points; Re-align groover; Inspect and replace hardware
Excessive noise during operation	Lack of lubrication; Worn bearings or rolls; Loose components	Lubricate moving parts; Inspect and replace worn components; Tighten fasteners

7. Specifications

Technical specifications for the RIDGID 46852 916 Roll Groover:

- **Model Number:** 46852
- **Item Weight:** Approximately 34 pounds (15.4 kg)
- **Product Dimensions:** 8 x 27.5 x 11.7 inches (20.3 x 69.8 x 29.7 cm)
- **Capacity:**
  - 1 1/4" - 6" Schedule 10 steel, stainless steel, PVC

- 1 1/4" - 3" Schedule 40 steel, stainless steel, PVC
- 2" - 6" Copper (Type K, L, M, DWV) -*Optional roll sets required*

- **Compatible Power Drives:** RIDGID Nos. 300 Power Drive, 535, 1822 Threading Machines
- **Feed Actuation:** Cam-type
- **Housing Material:** Durable Cast-Iron
- **Included Components:** 46852 Roll Groover unit (roll sets may vary based on package)
- **Batteries Required:** No

8. Warranty Information

The RIDGID 46852 916 Roll Groover is backed by a Full Lifetime Warranty. This warranty covers defects in workmanship and materials. For specific terms and conditions, or to make a warranty claim, please refer to the official RIDGID warranty documentation or contact RIDGID customer support.

9. Customer Support

For further assistance, technical support, or to inquire about replacement parts and accessories, please contact RIDGID customer service. You can find contact information on the official RIDGID website or through your local authorized RIDGID dealer.

RIDGID Official Website: www.ridgid.com

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