Kit Includes:

- 32838 Driveshaft for 2" - 8" Copper
- 30893 Driveshaft Key
- 32843 Groove Roll for 2" - 8" Copper

⚠ WARNING

Read and understand the threading machine and roll groover operator's manuals and instructions for all other equipment being used before operating. Failure to follow all instructions may result in property damage and/or serious personal injury.

Make sure the machine FOR/OFF/REV switch is in the OFF position and the machine is unplugged before performing any maintenance or making any adjustments.

SAVE THESE INSTRUCTIONS!

Contact Ridge Tool Technical Service Department at (800) 519-3456 or techservices@ridgid.com if you have any questions.

Changing Roll Sets

NOTICE When changing roll set parts, always make sure drive and groove roll markings match. Mismatched parts can make improper grooves and cause leaks.

Remove the roll groover from the power drive or threading machine and place on a stable work bench.

Required Tools:

- 3/8" Hex Wrench
- 3/32" Hex Wrench
- .070" External Retaining Ring Pliers

Removing and Installing Drive Roll

1. Remove 6 screws that hold rear cover to the housing.
2. Remove the rear cover *(See Figure 1)*.

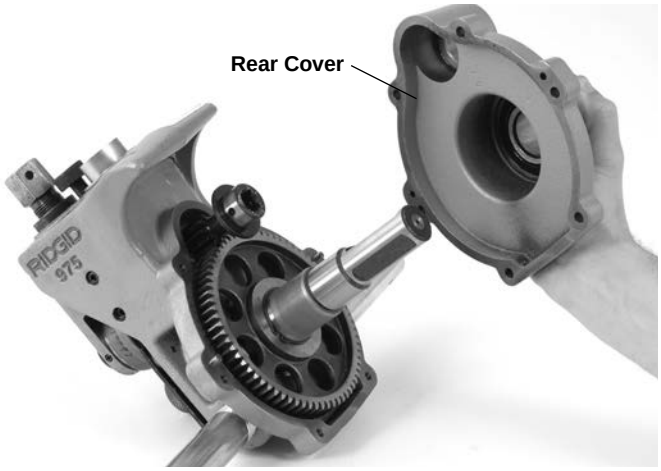

Figure 1 – Removing Rear Cover

3. Remove pinion.
4. Remove the driveshaft assembly out of the back of the 975 Roll Groover.
5. Remove retaining ring from driveshaft and slide gear off. *(See Figure 2.)*

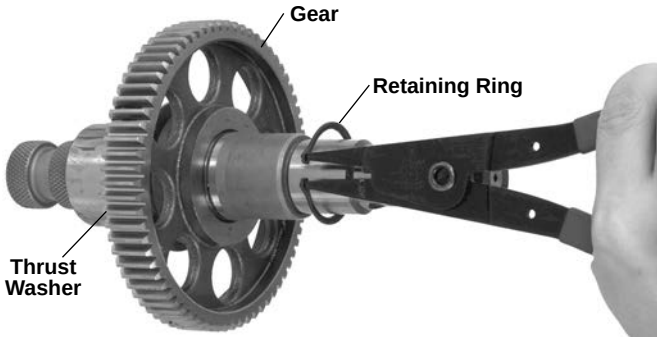

Figure 2 – Removing Retaining Ring

6. Remove key and then thrust washer.
7. Slide thrust washer onto new driveshaft.
8. Insert key and install gear.
9. Install retaining ring into driveshaft groove.
10. Place driveshaft assembly into main housing.
11. Grease from the gearbox may have been lost during the driveshaft change. Make sure the bearings and gear teeth are coated sufficiently with a good general purpose grease.
12. Insert pinion and reinstall rear cover. Tighten screws to 12-16 ft*lbs of torque.

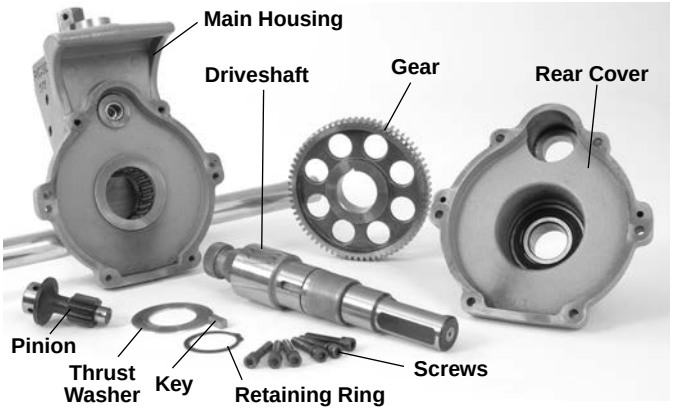

Figure 3 – 975 Combo Roll Groover Parts Diagram

Removing and Installing Groove Roll

1. Remove the setscrew that holds the groove roll shaft in place.
2. Pull the groove roll shaft out of the slide block and remove the groove roll and thrust washer.
3. Insert the thrust washer and new groove roll into the slide block. Ensure that the internal retaining ring in the groove roll is closest to the main housing, and that the groove roll is between the thrust washer and main housing. *(See Figure 4.)*
4. Replace the groove roll shaft and the set screw.
5. Visually inspect the alignment between the groove roll and the drive roll. If they are not aligned, check orientation of groove roll and thrust washer.

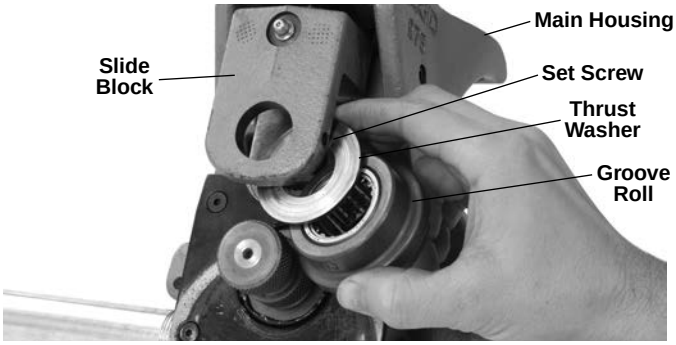

Figure 4

6. Grease as directed in *Lubrication Section* of manual.

Setting The Groove Diameter For Copper Tubing

When using the 975 Combo Roll Groover for copper tube, the groove depth gauge on the groover cannot be used. It will give incorrect groove diameters.

1. Turn the feedscrew clockwise to bring the groove roll down in contact with the pipe outside diameter, then turn the feedscrew one quarter additional turn. The adjusting screw may need to be loosened (turned counterclockwise) to allow the groove roll to contact pipe. The pipe and roll groover should be secure to each other at this point.
2. Make sure the groove depth gauge is in the grooving position. *(Figure 5)*
3. Turn the adjusting screw until it is flush with the top plate of the groover.
4. Find the diameter and type of pipe to be grooved on Table A and back the adjusting screw off the top plate the corresponding number of turns. For example, for 4" Sch. L copper, back the adjustment screw 1¼ turns.

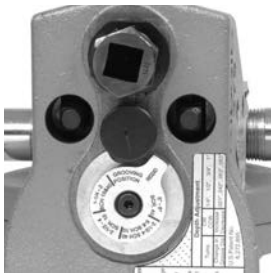

Figure 5 – Gauge In Grooving Position

Depth Adjustment for Roll Grooving Copper Tubing (Adjusting Screw Turns)

Dia.	K	L	M	DWV
2-2.5"	7/8	7/8	5/8	5/8
3"	1 1/16	1 1/16	1 1/16	1 1/16
4"	1 1/4	1 1/4	1 1/4	1 1/8
5"	1 1/2	1 1/2	1 1/2	1 1/2
6"	1 13/16	1 3/4	1 3/4	1 3/4
8"	2 1/2	2 3/8	2 1/8	2 1/8

Chart A – Depth Adjustment for Roll Grooving Copper Tubing

5. *Go to step 4 of "Setting/Measuring The Groove Diameter" in the 975 Combo Groover operator's manual. In step 6 use the Copper Roll Groove Specifications.*

Service and Repair

⚠ WARNING

Improper service or repair can make machine unsafe to operate.

Tool should be taken to a RIDGID Independent Authorized Service Center or returned to the factory.

When servicing this machine, only identical replacement parts should be used. Use of other parts may create a risk of serious injury.

Table I. Copper Roll Groove Specifications

1	2		3	4	5	6	7	8
Nom. Size Inches	Tubing Outside Diameter O.D.		A Gasket Seat A ±0.03	B Groove Width +.03 –.000	C Groove Dia. +.00 –.02	D Groove Depth Ref.[1]	T Min. Allow. Wall Thick.	Max. Allow. Flare Dia.
	Basic	Tolerance						
2"	2.125	±0.002	0.610	0.300	2.029	0.048	DWV	2.220
2 1/2"	2.625	±0.002	0.610	0.300	2.525	0.050	0.065	2.720
3"	3.125	±0.002	0.610	0.300	3.025	0.050	DWV	3.220
4"	4.125	±0.002	0.610	0.300	4.019	0.053	DWV	4.220
5"	5.125	±0.002	0.610	0.300	5.019	0.053	DWV	5.220
6"	6.125	±0.002	0.610	0.300	5.999	0.063	DWV	6.220
8"	8.125	+0.002/-0.004	0.610	0.300	7.959	0.083	DWV	8.220

1. Nominal Groove Depth is provided as a reference dimension. Do not use groove depth to determine groove acceptability.