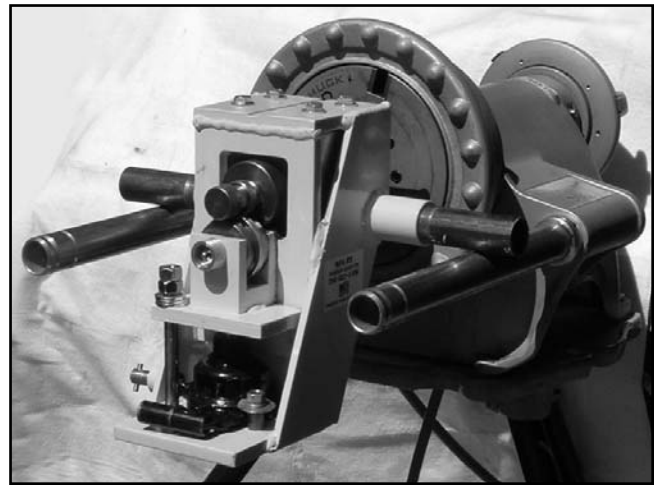


Revolutionary, New, Hydraulic Roll-Groover from ARGCO! **The Roll-Verine®**

- Fastest, portable hydraulic roll-groover in it's class.
Rolls a groove in 2", sch. 40 pipe in 12 seconds flat!
- Innovative mechanism:
It roll-grooves at the bottom of the pipe.
No adjustment of your pipe stands needed for different diameter pipe-saving you time and aggravation!
- 100% made in the USA!
- Quick mounting and removal on Ridgid 300® Power Drive
- Alignment groove on top of the Roll-Verine is provided for proper placement of pipe stands
- Groove pipe in forward or reverse direction
- Ratchet wrenches, breaker bars and sockets are not needed
- Heavy duty grease and grease gun included



Roll-Verine® Part # 33-09-225

Standard Equipment: 2" to 6" sch. 10/40 roll set and grease gun.

Capacity:

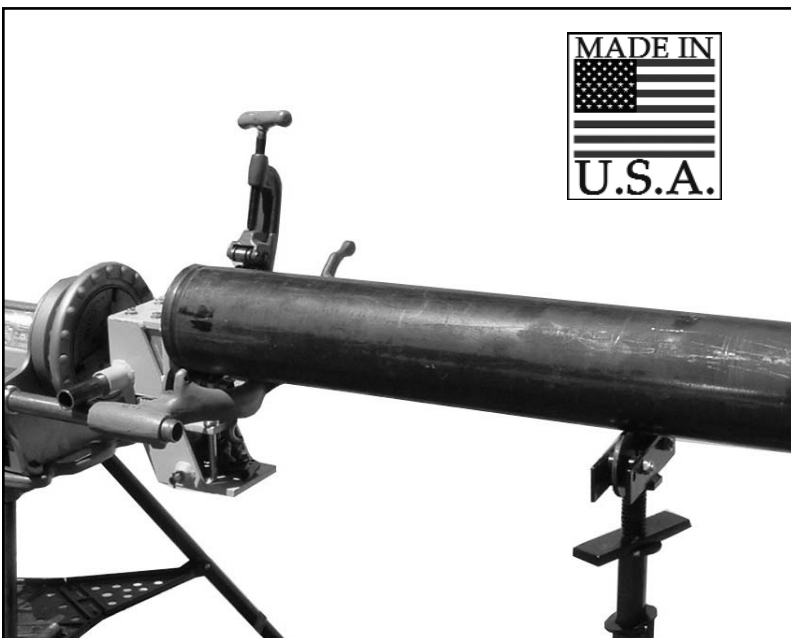
2" to 6" roller and shaft (standard)

Weight:

42 lbs. (Unmatched power at half the weight)

Dimensions:

5-1/2" wide x 11-1/2" tall x 13" front to back



A Harold Allen Product
RAM MACHINE L.L.C.
Patent Pending

RIDGID® is a trademark of RIDGID, Inc. The trade dress of the RIDGID® Model 300 Power Drive product is a trademark of RIDGID, Inc. ARGCO is not an authorized distributor of RIDGID® products

800-854-1015

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ROLL-VERINE®
HYDRAULIC ROLL GROOVING ATTACHMENT FOR RIDGID 300®

2" to 6" roller and shaft (sch. 40 & thin wall)
1-1/4" to 6" roller & shaft (up to 3" sch. 40 & 4" to 6" thin wall)
8" to 12" roller & shaft (sch. 20 thin wall)
1-1/4" to 12" (three roller & shaft sets)

OPERATING INSTRUCTIONS

WARNING! READ AND UNDERSTAND ALL INSTRUCTIONS.

FAILURE TO FOLLOW INSTRUCTIONS MAY RESULT IN SERIOUS PERSONAL INJURY.

WARNING! USE THE ROLL-VERINE® ONLY WITH A PIPE MACHINE WHICH HAS A PROPERLY OPERATING FOOT SWITCH.

TURN ON THE PIPE MACHINE BY STEPPING ON THE FOOT SWITCH.

TURN OFF THE PIPE MACHINE BY STEPPING OFF THE FOOT SWITCH.

USE PROPER EYE PROTECTION. DRESS PROPERLY.

KEEP HAIR, GLOVES AND LOOSE CLOTHING AWAY FROM MOVING PARTS. AVOID ENTANGLEMENT.

WHEN GROOVING PIPE, KEEP HANDS AWAY FROM GROOVING ROLLERS AND ROTATING PIPE.

NEVER REACH INSIDE OF PIPE!

1. Pipe machine should be placed on a flat, level surface.
Be sure pipe machine, Roll-Verine® and pipe stands are stable.
2. Install (2) 1" x 6" schedule 40 threaded pipe nipples into the pipe couplings on both sides of Roll-Verine®.
The nipples must be tight and the threaded end clearly visible in the inspection hole.
3. Mount Roll-Verine® onto pipe machine. It is not required to remove the carriage assembly (you must remove diehead).
Removal of the carriage assembly is optional. You are roll grooving on the bottom of the pipe at 6 o'clock position.
4. Fully insert the drive shaft of the Roll-Verine® into the chuck of the pipe machine. Match the 3 flats of the drive shaft to the jaws of the chuck.
Tighten jaws securely onto drive shaft.
5. Placing a pipe stand; 2 stands are helpful. Place the furthest pipe stand 3/4 of the pipe length from the Roll-Verine®. The 2nd stand one foot from the Roll-Verine®. Proper support of the pipe will prevent the pipe from falling or the unit from tipping.
Note: There is an alignment groove on the top of the Roll-Verine®. Place a short 1" pipe nipple onto the groove.
For easy alignment of the pipe stand: look into nipple when placing furthest pipe stand in front of Roll-Verine®.
6. Adjust elevation of furthest pipe stand to the bottom of knurled roll shaft. Do the same for pipe stand one foot from Roll-Verine®.
7. Place furthest end of pipe onto pipe stand and the other end between the rollers of Roll-Verine®. Pipe must be flush against shoulder of knurled roll shaft for proper groove.
8. Close release valve on hydraulic jack
9. Insert jack handle into socket of hydraulic jack.
10. Pump jack handle left and right until pipe becomes tight between rollers.
11. Place switch of pipe machine in "forward" direction.
12. Begin roll grooving.
13. Step on foot switch to begin operation of pipe machine.

ROLL-VERINE®

HYDRAULIC ROLL GROOVING ATTACHMENT FOR RIDGID 300®

OPERATING INSTRUCTIONS CONTINUED

14. Pump jack handle one stroke per full turn of pipe until proper groove is achieved.
 - A. Stop grooving if pipe begins to “roll-out” from between rollers. Place machine in “reverse” direction. Begin grooving- pipe should track in. Alternate: relocate furthest pipe stand left or right of center line one inch per 10 feet or 2 inches at 20 feet.
 - B. Proper depth of groove may be checked by using 1/2 of grooved coupling:
Stop pipe machine. Remove pipe from between rollers.
Place the key of the coupling fully into groove. Rotate the 1/2 coupling freely all the way around the groove. The groove is not deep enough if the coupling siezes and will not rotate. Continue grooving until proper groove depth is achieved.
Do not groove deeper than the coupling requires. It is no help.
 - C. When proper groove depth is achieved, set two 1/2” nuts against jack plate. Place bottom nut against jack plate and tighten top nut firmly against bottom nut. Continue roll grooving. Change setting when changing pipe diameter or wall thickness.
Occasionally re-check grooves.
15. Stop pipe machine.
16. Open release valve 1/4 turn counter clockwise.
17. Remove pipe.

Grooving Short nipples: All pipe diameters 2-1/2” and longer

Remove carriage assembly (so pipe coupling does not collide with carriage).

Connect the grooved end “short nipple” to a 3 foot (or longer) grooved pipe using a rigid coupling.

Place short nipple into the rollers of Roll-Verine® and support the other end of the pipe with a pipe stand.

Groove per instructions.

Changing roll shaft:

Unscrew both 1-1/2” nuts from back of roll shaft.

Remove washer. Slide shaft out and replace with new shaft.

Place washer against bearing.

Place first nut on roll shaft, tighten to 5 lbs. torque.

Secure into location with 2nd nut tightened firmly against 1st nut. Check shaft alignment to be sure it is centered over roller.

Hint: To remove or tighten nut, place the shaft of the Roll-Verine® into chuck of pipe machine.

Changing roller:

Loosen 1/4-20 x 1/2” set screw with Allen wrench.

Retract roller shaft.

Remove, replace roller.

Install roller shaft, re-tighten set screw, lubricate with grease gun (provided).

Note: 8” to 12” roller is directional. Do not install backward. The lettering should be facing you.

ROLL-VERINE®

HYDRAULIC ROLL GROOVING ATTACHMENT FOR RIDGID 300®

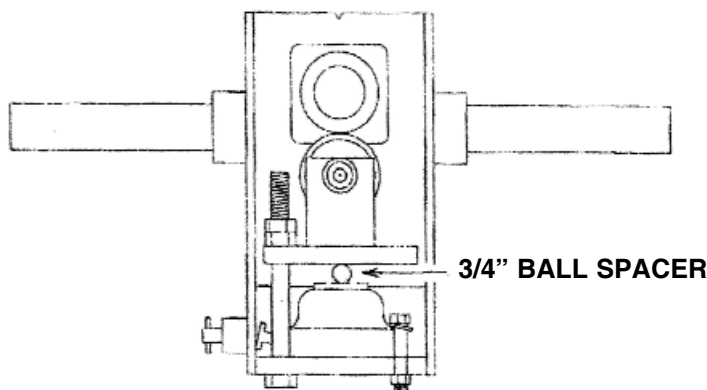
1-1/4" to 6" Thin Wall Roll Shaft Installation

1. Remove 2-6" schedule 40 roll shaft and replace with 1-1/4" to 6" thinwall roll shaft. (see changing roll shaft on page 2).
2" to 6" grooving wheel can remain in place.

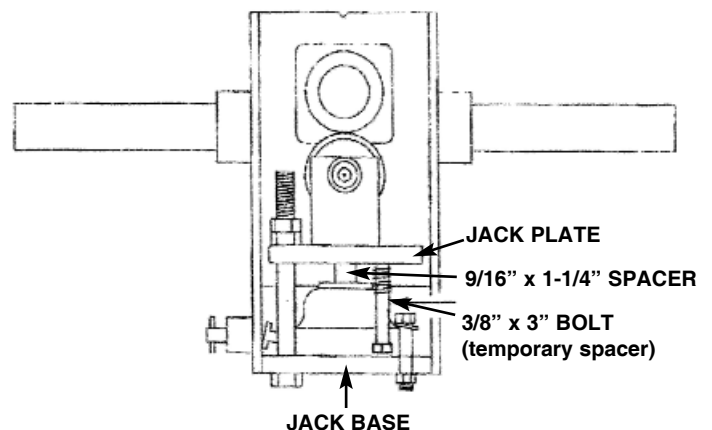
Remove 8" to 12" roll shaft and 8" to 12" grooving wheel. Install 1-1/4" to 6" thinwall roll shaft and 2" to 6" grooving wheel.
See page 5 for operating instructions.

2. Pump jack to upper most travel. Jack plate will be 3-3/8" above jack base.
3. Place 3/8" x 3" bolt (spacer) between jack plate and jack base (bolt overall length is 3-1/4")
4. Open the jack release valve one full turn - 360°. Jack plate is now resting on spacer.
5. Push the jack ram (piston) all the way down - FLAT.
6. Remove the 9/16" x 1-1/4" spacer.
7. Place a 3/4" steel ball on the top of the hole in the ram (piston).
8. Raise the jack and remove the spacer.
9. Proceed to roll groove per instructions.
10. Use 3/4" steel ball only with 1-1/4" to 6" thinwall roll shaft. This prevents the jack from over extension (sucking in air per troubleshooting #2)
11. Remove 3/4" steel ball to change to roll shafts 9/16" x 1-1/4" metal spacer for 2" to 6" schedule 40 roll shaft.
Failure to re-install there 9/16" x 1-1/4" metal spacer will break the jack.

1-1/4" to 6" ROLL SHAFT



2" to 6" ROLL SHAFT



ROLL-VERINE®

HYDRAULIC ROLL GROOVING ATTACHMENT FOR RIDGID 300®

MAINTENANCE

Lubricate grease fitting every 100 grooves for thinwall and 50 grooves for schedule 40.

Do not roll groove 1-1/2" pipe on 2" to 6" roll set. It will not come off of shaft. (If this occurs, you will have to cut pipe off of roller to remove).

Do not roll groove schedule 40 4", 5", 6" on 1-1/4" to 6" thinwall shaft.

1-1/4" to 6" groove begins 5/8" from end of pipe. 8" to 12" groove begins 3/4" from end of pipe.

PIPE THINWALL	NUMBER OF TURNS TO ROLL GROOVE
1-1/4" to 4"	3
5" to 6"	4
SCHEDULE 40	
1-1/4", 1-1/2", 2"	4
2-1/2", 3"	5
4"	6
6"	12

TROUBLESHOOTING

1. JACK WON'T LIFT

The Roll-Verine® is low on hydraulic jack oil; place jack level on flat surface. Wipe away all dirt from rubber fill plug.

Remove plug. Tip jack up 1/2 inch. Add hydraulic jack oil to bottom of fill hole -- do not overfill.

Properly insert plug. do not allow any dirt into oil reservoir.

Hint: Hydraulic jack oil is available at auto parts or hardware stores.

2. AIR IN PUMP

With jack sitting level on its base and ram retracted, bleed air by opening release valve. Pump for 10 seconds.

Close release valve and resume use.

WARRANTY, PARTS & SERVICE

WARRANTY

1 year warranty from date of sale.

PARTS & SERVICE

Contact your supplier or Harold Allen Products - Ram Machine LLC

1220 South Mountain View Road #B

Phone: 208-882-1396

Fax: 208-882-2634