

Roll Groover Model 3006



The Gruvlok Model 3006 roll groover features a low maintenance quick roll change out design with the capability to groove 2" – 12" steel pipe, as well as 2" – 6" stainless steel. This machine is also compatible with the CTS Copper System for accurate and repeatable grooving of tube as small as 2" in diameter. Standard with each machine is the patented Gruvlok hands free nipple guide system. This one of a kind nipple guide system allows for the shortest nipple grooving in the business and is hands free for increased operator safety. A special hydraulic pump with a reduced height handle and pivoting location allow each operator to customize the machine for maximum comfort while grooving. Low cost, lightweight, user friendly, and reliable, the Model 3006 Roll Groover follows the quality Gruvlok tradition started with 1007/3007 models and takes the future of roll grooving one step further.

Gruvlok roll grooving technology is protected by U.S. Patents 5450738, 5570603, 5778715 and others pending.

- **Wide Grooving Range**
2" thru 8" Schedule 40 (standard wall) steel pipe
10" (.188" Wall)
12" (.219" wall)
2" thru 12" Sch. 10
2" thru 8" copper type K, L, M, and DWV
- **Pipe Lengths**
20' random Schedule 40 (standard wall) to 5" groove by groove nipples.
The shortest roll groove nipple capability in the industry: hands clear.
- **Hands Clear Grooving of Pipe and Nipples**
Enhanced operator safety provided by outboard guide roll assembly.
- **Accurate, Repeatable Groove Diameter Control**
Simplified direct action provided positive, repeatable control for grooving carbon and stainless piping.
For grooving copper, universal diameter gauge must be utilized.
- **Better Control of Pipe Flare**
Outboard guide roll assembly registers pipe for proper orientation.
- **Quick, Easy Setup and Roll Change**
- **Rugged Design Requires Minimal Maintenance**
Only periodic application of grease via grease fittings required.
- **User Friendly Design**
Pump has a special reduced height handle and adjustable location for operator comfort and safety.
- **Ease of Operation**
High grooving forces obtained though use of large capacity ram requires less pump effort.



PROJECT INFORMATION	APPROVAL STAMP
Project:	Approved
Address:	Approved as noted
Contractor:	Not approved
Engineer:	Remarks:
Submittal Date:	
Notes 1:	
Notes 2:	

Roll Groover Model 3006

Technical Data

Standard Equipment

Roll Groover complete with Adjustable Support Leg Assembly and roller sets for grooving 2"-6" and 8"-12" steel pipe, Steel/CTS Dual Guide Roll Assembly, hydraulic pump with pressure gauge, and two depth adjustment gauges. This unit is designed for direct attachment to your Ridgid® 300 Power Drive. Complete with comprehensive setup, operating and troubleshooting instructions.

- Shipped in a reusable wooden storage crate.
- Approximate shipping weight: 225 pounds.
- Required Ridgid 300 Power Drive not included.

Optional Equipment

Advanced Copper Method (IPS Copper) Option:

- Consisting of 2"-6" Advanced Copper Method roll set, Advanced Copper Method Guide Roll Assembly, and a 2"-6" Universal Diameter Gauge.
- 2"-6" Universal Diameter Gauge.

CTS Copper System Option:

- Consisting of 2"-8" roll set, 2"-6" CTS Depth Gauge, and 8" CTS Depth Gauge.

Groover Capability

Pipe Material	Pipe Size/Wall Thickness (Schedule) ^{1,2}								
In. DN(mm)	2 50	2½ 65	3 80	4 100	5 125	6 150	8 200	10 250	12 300
Steel	Schedule 10, 40							0.188"	0.219"
Stainless Steel	Steel Schedule 10S, 40S						n/a	n/a	n/a
CTS Copper System	K, L, M & DWV							n/a	n/a

Note:

- All wall thickness shown are the maximum wall thickness for the indicated pipe material.
- Minimum wall thickness for each pipe materials and size is:
- Contact an ASC Engineered Solutions™ Representative for more information on grooving alternate materials & wall thickness.

Steel: All Sizes — Sch. 10
 Stainless Steel: 2"-6" — Sch. 10S, 40S
 Copper: 2", 2½" — Type M
 3"-8" — Type DWV

Steel Pipe Grooving Times (Min: Sec.)

Pipe Size (In./DN(mm))/Max Steel Pipe Wall Thickness							
2 50	2½ 65	3 80	4 100	6 150	8 200	10 250	12 300
0:20	0:20	0:25	0:30	1:20	1:55	1:40	1:20

Grooving Times:

This chart shows approximate grooving times with the groover set-up for the proper size and groove diameter and the pipe properly positioned on the groover. The times shown are average times from the start of rotation of the pipe in the grooving rolls to completed groove.



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