PIPE PROCESSING EQUIPMENT

CUTTING • GROOVING • CHAMFERING • THREADING • DRILLING • END PREPPING
an introduction to PACE

We built our reputation as a manufacturer of tough, durable pipe grooving machinery for the fire protection, mining, paper, chemical and other industries. Pace Machinery is at work in virtually every developed country of the world, recognized as the most dependable and efficient equipment of its type.

As our customer base has grown, we have expanded the scope of the equipment we manufacture, so that now we can offer a complete line of machinery for grooving, cutting, chamfering, drilling, threading and end-prepping pipe.

Pace Pipe Processing Machines are built like fine machine tools. Every component has been carefully designed and machined to ensure efficient, trouble-free operation. Parts required to withstand high stress and torque are machined from special alloy steels to provide the service for which these machines are noted. For example: Idler and Main Shafts — through which torque and pressure are transmitted — are precision machined from Vacuum Melt Aircraft Quality materials ... the rugged speed reducers used in many Pace machines have strength, capacity and service life far beyond need — further insurance that your PACE machine will stand up to the most severe service.

roll grooving specifications

Every PACE Roll Groover will produce grooves of extraordinary quality in a wide range of piping materials including aluminum, steel and stainless steel. Design of the machines is such that pipe is grooved to required depth — yet pipe flare is held to an absolute minimum. Grooves themselves are bottom- radiused — no sharp corners to weaken or damage pipe integrity. As a result, PACE-grooved pipe is easier to assemble and couple.

<table>
<thead>
<tr>
<th>PIPE SIZE (IN.)</th>
<th>ACTUAL O.D. (IN.)</th>
<th>GASKET SEAT A</th>
<th>ROLL GROOVE WIDTH B’ + .030 – .015</th>
<th>GROOVE DIAMETER C</th>
<th>GROOVE DEPTH D</th>
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<th>GROOVE DEPTH D</th>
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model 1010
PORTABLE ROLL GROOVER

Capacity: 1 1/2" through 12" (38-305mm)
Produces accurately rolled grooves in a wide range of pipe types—
including newer varieties of thin-wall pipe. Use it in the shop or at the
job site. Easily operated hydraulic hand pump delivers up to 8000 psi
of rolling force to the pipe face. Pre-set depth gauge automatically
controls depth of rolled groove. Pipe is rotated by means of a speed
reducer driven by the unit’s electric motor. The drive shaft and idler
shafts are machined from Vacuum Melt Aircraft Quality Alloy steel to
insure long service life. Easily interchangeable Top and Bottom
Rollers (average time: less than 3 minutes) permits rapid change of
pipe diameters with nominal set-up costs.

Shipped in a durable, reusable hinged box.

MODEL 1010 SPECIFICATIONS
Capacity: 1 1/2" through 6" SCHD 40 (6mm)
1 1/2" through 12" SCHD 10 (5mm)
Pipe Rotation Speed: 30 RPM
Hydraulic Pressure at Roller: 8000 psi max.
Spindle Height from Floor: 33" (838mm)
Electric Motor: 1/2 HP 60 Hz 110 V.1 PH
Floor Space Required: 32" x 32" (813 x 813mm)
Shipping Weight: 300 lbs. (136 kgs)
Interchangeable Rollers:
TOP PIPE DIAMETER
1 1/2" through 6" (38 through 152mm)
8" through 12" (203 through 305mm)

BOTTOM PIPE DIAMETER
1 1/2" (38mm)
2" through 3 1/2" (51-89 mm)
4" through 6" (102-152mm)
8" through 12" (203-305mm)

*Other current characteristics available

STANDARD EQUIPMENT
Electric Motor • Groove Depth Gauge • Hydraulic Pump • Shipping/storage
Box • Rolls as specified on price list • Guards • Foot Switch

model 2010
AUTOMATED ROLL GROOVER

Capacity: 1 1/2" through 12" (38-305 mm)
Model 2010 is an automated high production pipe grooving machine
designed for use in the shop. Complete with a powered hydraulic
system contained in the sturdy steel base. Model 2010 produces
gently radided grooves which do not reduce the strength or structural
integrity of the pipe. The hydraulic system will deliver up to 8000 psi at
the point of roll grooving. Pressure is adjustable to permit optimum
grooving efficiency for each pipe wall thickness. After setting the
Automatic Depth Stop, the operator pushes a "Start" button and
watches as the Top Roller automatically rolls the groove to the pre-set
depth. Actuating a pressure release control raises the hydraulic ram,
permitting the operator to remove the pipe and check the groove.
Model 2010 is shipped completely assembled with Rollers.

MODEL 2010 SPECIFICATIONS
Capacity: 1 1/2" through 6" SCHD 40 (6mm)
1 1/2" through 12" SCHD 10 (5mm)
Pipe Rotation Speed: 30 RPM
Hydraulic Pressure at Roller: 8000 psi max.
Spindle Height from Floor: 33" (838mm)
Electric Drive Motor: 1/2 HP 60 Hz 110 V.1 PH
Hydraulic Pump Motor: 1 HP 60 Hz 110 V.1 PH
Floor Space Required: 30" x 22" (762 x 559mm)
Shipping Weight: 510 lbs. (231 kgs)
Interchangeable Rollers:
TOP PIPE DIAMETER
1 1/2" through 6" (38 through 152mm)
8" through 12" (203 through 305mm)

BOTTOM PIPE DIAMETER
1 1/2" (38mm)
2" through 3 1/2" (51-89 mm)
4" through 6" (102-152mm)
8" through 12" (203-305mm)

*Other current characteristics available

STANDARD EQUIPMENT
Drive Motor • Hydraulic Pump Motor • Limit Switch for Depth Gauging •
Groove Depth Gauge • Hydraulic Pump • Rolls As Specified In Price List •
Guards • Foot Switch
model 1021
PORTABLE ROLL GROOVER
Capacity: 1 1/4" through 24" (32-610mm)
Portable Pipe Groover with a 2 HP motor rotates pipe from 1 1/4" through 24" diameter through a high torque, heavy duty speed reducer. Hand hydraulic pump applies up to 16,000 psi at the point of roll grooving to produce accurate grooves for quick installation of pipe couplings. Use it in the shop or on the job. Top and Bottom Rollers are easily interchanged to handle a wide range of pipe diameters.

MODEL 1021 SPECIFICATIONS
Capacity: 1 1/4" through 12" SCHD 40 (10mm)
12" through 24" Standard Wall .375 (9.5mm)
2" through 6" Copper Tubing K,L,M and DWV
Pipe Rotation Speed: 30 RPM
Hydraulic Pressure at Roller: 16,000 psi max.
Spindle Height from Floor: 33" (838mm)
Electric Motor: 2 HP 60 Hz 220 V 1 PH
Floor Space Required: 31 1/2" x 33 1/2" (800 x 857mm)
Shipping Weight: 430 lbs. (195 kgs)
Interchangeable Rollers:

<table>
<thead>
<tr>
<th>TOP PIPE DIAMETER</th>
<th>BOTTOM PIPE DIAMETER</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 1/4&quot; through 1 1/2&quot; (33-38mm)</td>
<td>1 1/4&quot; through 1 1/2&quot; (33-38mm)</td>
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<td>2&quot; through 3 1/2&quot; (51-89mm)</td>
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<td>4&quot; through 6&quot; (102-152mm)</td>
<td>4&quot; through 6&quot; (102-152mm)</td>
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<tr>
<td>8&quot; through 12&quot; (203-305mm)</td>
<td>8&quot; through 12&quot; (203-305mm)</td>
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<tr>
<td>14&quot; through 16&quot; (356-407mm)</td>
<td>14&quot; through 16&quot; (356-407mm)</td>
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<tr>
<td>18&quot; through 24&quot; (457-610mm)</td>
<td>18&quot; through 24&quot; (457-610mm)</td>
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</tbody>
</table>

*Other current characteristics available

STANDARD EQUIPMENT
- Electric Motor
- Groove Depth Gauge
- Hydraulic Hand Pump
- Shipping
- Storage Box
- Rolls As Specified In Price List
- Guards
- Foot Switch

model 2021
AUTOMATED ROLL GROOVER
Capacity: 1 1/4" through 24" (32-610mm)
You can roll groove a lot of pipe in a wide range of diameters with this model because the operator merely pushes a button to get the job done. Six easily interchanged Top and Bottom Rollers give Model 2021 the versatility to meet virtually any piping system requirement. The self-contained hydraulic system provides up to 16,000 psi pressure at the point of roll grooving. Hydraulic pressure is adjustable to provide optimum grooving efficiency for all diameters and wall thicknesses within the machine's range. Model 2021 is shipped completely assembled with Top and Bottom Rollers 4" through 8" installed on machine.

MODEL 2021 SPECIFICATIONS
Capacity: 1 1/4" through 12" SCHD 40 (10mm)
12" through 24" Standard Wall .375 (9.5MM)
2" through 6" Copper Tubing K,L,M and DWV
Pipe Rotation Speed: 30 RPM
Hydraulic Pressure at Roller: 16,000 psi max.
Spindle Height from Floor: 33" (838mm)
Electric Motor: 3 HP 60 Hz 220 V 3 PH
Hydraulic Pump Motor: 1 HP 60 Hz 220 V 3 PH
Floor Space Required: 30" x 22" (762 x 559mm)
Shipping Weight: 640 lbs. (290 kgs)
Interchangeable Rollers:

<table>
<thead>
<tr>
<th>TOP PIPE DIAMETER</th>
<th>BOTTOM PIPE DIAMETER</th>
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<td>18&quot; through 24&quot; (457-610mm)</td>
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</tbody>
</table>

*Other current characteristics available

STANDARD EQUIPMENT
- Electric Drive Motor
- Limit Switch for Depth Gauging
- Groove Depth Gauge
- Hydraulic Pump
- Model 4037 Nipple Bracket
- Rolls As Specified In Price List
- Guards
- Foot Switch
MODEL 1023
PORTABLE ROLL GROOVER
Same Capacity as Model 1021 only 110 Volt
Capacity: 1 1/4" through 24" (32-610mm)
Portable Pipe Groover has been designed with a heavy-duty, high-efficiency gear reducer. The helical inline gear reducer with only five percent energy loss, will allow pipe grooving 1 1/4" through 24" with a 110 volt electrical service. Hand hydraulic pump applies up to 16,000 PSI at the point of roll grooving to produce accurate grooves for quick installation of pipe couplings. Use it at the job site or in the shop. Top and bottom rollers are easily interchanged to handle a wide range of pipe diameters. Additional roll sets are available for copper tube grooving and also flush seal gasket dimensions.

MODEL 1023 SPECIFICATIONS
Capacity: 1 1/4" through 12" SCHD 40 (10mm)
12" through 24" Standard Wall .375 wall (9.5mm)
2" through 8" Copper Tubing K, L, M and DWV
Spindle Speed: 30 RPM
Hydraulic Pressure at Roller: 16,000 PSI MAX.
Spindle height from floor: 33" (838mm)
Electric Motor: 1 1/2 HP 60Hz 110 V 1 PH
Floor Space Required: 31 1/2" x 33 1/2" (800 x 857mm)
Shipping Weight: 430 lbs

INTERCHANGEABLE ROLLERS
TOP PIPE DIAMETER
1 1/4" through 1 1/2" (32-38mm)
2" through 3 1/2" (51-89mm)
4" through 6" (102-152mm)
8" through 12" (203-305mm)
14" through 16" (356-407mm)
18" through 24" (457-610mm)

BOTTOM PIPE DIAMETER
1 1/4" through 1 1/2" (32-38mm)
2" through 3 1/2" (51-89mm)
4" through 6" (102-152mm)
8" through 12" (203-305mm)
14" through 16" (356-407mm)
18" through 24" (457-610mm)

STANDARD EQUIPMENT
Electric Motor • Groove Depth Gauge • Hydraulic Hand Pump • Shipping /Storage Box • Rolls As Specified In Price List • Guards • Foot Switch
model 1112
Portable Roll Groover
Capacity: 1" through 12" pipe (25-305mm) Schedule 40
Model 1112 requires just three Top Rollers and three Bottom Rollers
to produce specification quality grooves in pipe from 1" through 12"
diameter Schedule 40. Easily portable for on-the-job work, the Model
1112's electric motor rotates pipe at speeds of 35 RPM. The hand
hydraulic pump will deliver up to 15,000 psi pressure at the point of
roll grooving. Like all PACE Pipe Grooving Machines, Model 1112 is
ruggedly built to deliver long, trouble-free service.

MODEL 1112 SPECIFICATIONS
Capacity: 1" through 12" SCHD 40 (10mm)
2" through 6" Copper Tubing K,L,M and DWV
Pipe Rotation Speed: 35 RPM
Hydraulic Pressure at Roller: 15,000 psi max
Spindle Height from Floor: 35" (889mm)
Electric Motor: 1 1/2 HP 60Hz 110 V.1 PH.*
Floor Space Required: 32" x 32" (813x813 mm)
Shipping Weight: 220 lbs. (100kg)
Interchangeable Rollers:
TOP PIPE DIAMETER                      BOTTOM PIPE DIAMETER
1" through 1 1/2" (25-38mm)             1" through 1 1/2" (25-38mm)
2" through 6" (51-152mm)               2" through 6" (51-152mm)
8" through 12" (203-305mm)             8" through 12" (203-305mm)
*Other current characteristics available

STANDARD EQUIPMENT
Electric Drive Motor • Groove Depth Gauge • Hydraulic Hand Pump • Top and
Bottom Rollers 1-12" • Shipping/Storage Box • Guards • Foot Switch
OPTIONAL: Top and Bottom Copper Rollers 2-8"; Nipple Bracket

model 2112
Automated Roll Groover
Capacity: 1" through 12" pipe (25-305mm) Schedule 40
Model 2112 is a full power version of the Model 1112 and includes a
self contained hydraulic system capable of applying 15,000 lbs. of
pressure at the point of roll grooving to handle pipe up to 12" diameter
Schedule 40. The hydraulic pump, 1 HP pump motor and reservoir
are housed in the unit's sturdy steel base. Once the Automatic Depth
Stop is set, the operator pushes a button and the machine rolls the
groove to the predetermined depth. Moving the Pressure Release
Handle retracts the hydraulically powered Ram so the operator can
remove and check the groove. Model 2112 Is shipped completely
assembled.

MODEL 2112 SPECIFICATIONS
Capacity: 1" through 12" SCHD 40 (10mm)
2" through 6" Copper Tubing K,L,M and DWV
Pipe Rotation Speed: 35 RPM
Hydraulic Pressure at Roller: 15,000 psi max.
Spindle Height from floor: 35" (889mm)
Electric Drive Motor: 1 1/2 HP 60 Hz 110V 1 PH*
Hydraulic Pump Motor: 1 HP 60 Hz 110V 1 PH
Floor Space Required: 30" x 22" (762x559mm)
Shipping Weight: 470 lbs. (213 kg)
Interchangeable Rollers:
TOP PIPE DIAMETER                      BOTTOM PIPE DIAMETER
1" through 1 1/2" (25-38mm)             1" through 1 1/2" (25-38mm)
2" through 6" (51-152mm)               2" through 6" (51-152mm)
8" through 12" (203-305mm)             8" through 12" (203-305mm)
*Other current characteristics available

STANDARD EQUIPMENT
Electric Drive Motor • Limit Switch for depth gauging • Groove Depth Gauge •
Hydraulic Pump Motor • Hydraulic Pump • Top and Bottom Rollers 1-12" •
Guards • Foot Switch
OPTIONAL: Top and Bottom Copper Rollers 2-8"; Nipple Bracket
model 1012
1"-12" SCHEDULE 40
PORTABLE ROLL GROOVER

When the ultimate is required in your grooving needs 1" thru 12" Schedule 40, the Pace model 1012 will answer those needs. This Pace design, with new hydraulic ratio along with advanced spindle design allows greater strength and pressure in a compact package for grooving up to 12" Schedule 40, using a standard model Ridgid® 300.

An hydraulic hand pump will deliver increased pressure for grooving up to .406 wall pipe to specification quality grooves. Top and bottom roll change is made easy with cross taper pin in the bottom roll and socket set screw in the top roll for positive no slip design. Like all Pace Roll Grooving tools, the model 1012 is rigidly designed for trouble free service.

MODEL 1012 SPECIFICATIONS
Capacity: 1" through 12" SCHD 40 (10mm)
2" through 6" Copper Tubing K.L.M and DWV
Shipping Weight: 125 lbs.
Interchangeable Rollers:
TOP PIPE DIAMETER
1" through 1 1/2"
2" through 6"
8" through 12"

BOTTOM PIPE DIAMETER
1" through 1 1/2"
2" through 6"
8" through 12"

OPTIONAL EQUIPMENT:
Pipe Nipple and Stabilizer Bracket

Pipe Nipple and Stabilizer Bracket Optional

Inspecting groove with Pace Go/No-Go Gauges to insure correct diameter.
model 1022
PIPE GROOVER FOR MOUNTING ON
Ridgid® 300 PIPE THREADER

Capacity: 1 1/4" through 16" (42mm - 408mm)
Get double duty from the Ridgid® 300 Pipe Threader by
converting it to a pipe groover with the Model 1022 Pipe
Groover. Designed for quick, easy mounting on standard Model
300 the 1022 Pipe Groover can roll grooves in pipe from 1 1/4"
to 16" diameter. The hand hydraulic pump will deliver up to
16,000 PSI pressure at the point of roll grooving; your
Threader's motor will rotate the pipe to produce specification-
quality grooves in pipe. Like all Pace Pipe Grooving machines,
the Model 1022 is ruggedly built to deliver easy, trouble-free
service.

MODEL 1022 SPECIFICATIONS
Capacity: 1 1/4" through 12" SCHD 40 (10mm)
12" through 16" Standard Wall .375 (9.5mm)
2" through 6" Copper Tubing K, L, M and DWV

Hydraulic Pressure at Roller: 16,000 PSI max.
Shipping Weight: 285 lbs. (129.3 kg)

Interchangeable Rollers:
TOP PIPE DIAMETER
1 1/4" through 1 1/2" (32-38mm)
2" through 3 1/2" (51-89mm)
4" through 6" (102-152mm)
8" through 12" (203-305mm)
14" through 16" (356-407mm)

BOTTOM PIPE DIAMETER
1 1/4" through 1 1/2" (32-38mm)
2" through 3 1/2" (51-89mm)
4" through 6" (102-152mm)
8" through 12" (203-305mm)
14" through 16" (356-407mm)

STANDARD EQUIPMENT:
Grooved Depth Gauge • Hydraulic Hand Pump • Rollers 1 1/4" through 16"
Shipping/Storage Box • Pipe Nipple and Stabilizer Bracket • Guards
Mini-Mites - Service Tools of Choice
Roll groovers for handling the unexpected
Pace Mini-Mite roll groovers allow you to be sure you can handle anything when you get on the job site. They’re handy, portable job-site tools that can save you hours of waiting for pipe to come back from the shop. Mini-Mites let you make quick adjustments no matter what obstacles are thrown in your way. New design has roller bearing front & back on main shaft.

model 1039

with ratchet hand crank, roll grooves 1 1/4" to 6"
Schedule 40 or thin wall steel pipe on the scaffold or anywhere power is unavailable.

Capacity: 1 1/4" through 6" SCHD 40 (7mm)
2" through 8" Copper Tube K,L,M and DWV

The Pace 1039 Mini-Mite™ Roll groover service tool goes from in-place grooving and can be chucked in a Ridgid Model 300 in seconds with no gearbox removal. The Pace 1039 Mini-Mite™ is self-contained and can be entirely operated with its own multi-function crank so there are no other tools needed! All hex drives on the the Pace 1039 Mini-Mite™ are 15/16", so one wrench fits everything.
Mini-Mites require no modifications or parts changes to groove any pipe or tubing in their size range.
Each comes with multi-step depth gauge.

model 1034

has same capacity as 1039,
but is used with the
Ridgid® Model 300 threader
for faster easier grooving.

Capacity: 1 1/4" through 6" SCHD 40 (7mm)

model 1066

also is used with the
Model 300, but is
designed to groove 2" to 8"
copper tube

Capacity: 2" through 8’ Copper Tube K,L,M and DWV

Hand Crank Unit Available
Model 1038-66
Pace Roll Grooving Attachments will double the utility of any power pipe threader by adapting it for production roll grooving. Built to deliver long, trouble-free service, these rugged machines mount in minutes without permanent modification to the threader, and can be removed just as quickly when the job is completed. The integral hydraulic hand pump will apply up to 8000 psi at the grooving roll, while the threader’s motor rotates the pipe producing specification quality grooves. Shipped with safety guards.

**model 1041**

**PIPE ROLL GROOVING ATTACHMENT FOR USE WITH Ridgid® 300 PIPE THREADER**
- Quickly converts your Ridgid® 300 Threader to a production roll groover
- Mounts/dismounts easily on standard Model 300
- Capacity: 1” through 12” pipe (25-305mm)

**MODEL 1041 SPECIFICATIONS**
- Capacity: 1” through 6” SCHD 40 (6mm), 1” through 12” SCHD 10 (5mm), 2” through 6” Copper Tubing K,LM and DWV
- Maximum Pressure at Roller: 8000 psi
- Shipping Weight: 94 lbs. (42.6 kgs)
- Interchangeable Rollers:
  - TOP PIPE DIAMETER
    - 1” through 6” (25-152mm)
    - 8” through 12” (203-305mm)
  - BOTTOM PIPE DIAMETER
    - 1” through 1 1/2” (25-38mm)
    - 2” through 6” (51-152mm)
    - 8” through 12” (203-305mm)

**model 1042**

**PIPE ROLL GROOVING ATTACHMENT FOR USE WITH REMS GIGANT® AND TORNADO® PIPE THREADER**
- Quickly converts your REMS GIGANT® or Tornado® Threader to a production roll groover
- Mounts/dismounts easily on either machine
- Capacity: 1” through 6” pipe (25-152mm)

**MODEL 1042 SPECIFICATIONS**
- Capacity: 1” through 6” SCHD 40 (6mm), 1” through 12” SCHD 10 (5mm), 2” through 6” Copper Tubing K,LM and DWV
- Maximum Pressure at Roller: 8000 psi
- Shipping Weight: 94 lbs. (43 kgs)
- Interchangeable Rollers:
  - TOP PIPE DIAMETER
    - 1” through 6” (25-152mm)
  - BOTTOM PIPE DIAMETER
    - 1” through 1 1/2” (25-38mm)
    - 2” through 6” (51-152mm)

**model 1043**

**PIPE ROLL GROOVING ATTACHMENT FOR USE WITH RIDGID® 1224 PIPE THREADER**
- Quickly converts your Ridgid® 1224 Threader to a high production roll groover
- Mounts/dismounts easily on standard Model 1224
- Capacity: 1” through 12” (25-305mm)

**MODEL 1043 SPECIFICATIONS**
- Capacity: 1” through 6” SCHD 40 (6mm), 1” through 12” SCHD 10 (5mm), 2” through 6” Copper Tubing K,LM and DWV
- Maximum pressure at Roller: 8000 psi
- Shipping Weight: 98 lbs. (44.5 kgs)
- Interchangeable Rollers:
  - TOP PIPE DIAMETER
    - 1” through 6” (25-152mm)
    - 8” through 12” (203-305mm)
  - BOTTOM PIPE DIAMETER
    - 1” through 1 1/2” (25-38mm)
    - 2” through 6” (51-152mm)
    - 8” through 12” (203-305mm)
**model 1044**
PIPE ROLL GROOVING ATTACHMENT FOR USE WITH RIDGID® 1822 PIPE THREADER

- Quickly converts your Ridgid® 1822 Threader to a production roll groover
- Mounts/dismounts easily on standard Model 1822
- Capacity: 1" through 6" Pipe (25-152mm)

**MODEL 1044 SPECIFICATIONS:**
- Capacity: 1" through 6" SChD 40 (6mm)
- 1" through 12" SChD 10 (5mm)
- 2" through 6" Copper Tubing K,L,M and DWV
- Maximum Pressure at Roller: 8000 psi
- Shipping Weight: 94 lbs. (43 kgs)
- Interchangeable Rollers:
  - TOP PIPE DIAMETER
  - 1" to 6" (25-152mm)
  - BOTTOM PIPE DIAMETER
  - 1" to 1 1/2" (25-38mm)
  - 2" to 6" (51-152mm)

**model 1045**
PIPE ROLL GROOVING ATTACHMENT FOR USE WITH WHEELER-REX 6092 THREADER

- Quickly converts your Wheeler-Rex 6092 Threader to a production roll groover
- Mounts/dismounts easily on standard Model 6092
- Capacity: 1" through 4" pipe (25-102mm)

**MODEL 1045 SPECIFICATIONS:**
- Capacity: 1" through 4" SChD 40 (6mm)
- 1" through 4" SChD 10 (5mm)
- 2" through 4" Copper Tubing K,L,M and DWV
- Maximum Pressure at Roller: 8000 psi
- Shipping Weight: 94 lbs. (43 kgs)
- Interchangeable Rollers:
  - TOP PIPE DIAMETER
  - 1" to 4" (25-102mm)
  - BOTTOM PIPE DIAMETER
  - 1" to 1 1/2" (25-38mm)
  - 2" to 4" (51-102mm)

**model 1046**
PIPE ROLL GROOVING ATTACHMENT FOR USE WITH RIDGID® 535 PIPE THREADER

- Quickly converts your Ridgid 535 Threader to a production roll groover
- Mounts/dismounts easily on standard Model 535
- Capacity: 1" through 6" pipe (25-152mm)

**MODEL 1046 SPECIFICATIONS:**
- Capacity: 1" through 6" SChD 40 (6mm)
- 1" through 12" SChD 10 (5mm)
- 2" through 6" Copper Tubing K,L,M and DWV
- Maximum Pressure at Roller: 8000 psi
- Shipping Weight: 104 lbs. (47 kgs)
- Interchangeable Rollers:
  - TOP PIPE DIAMETER
  - 1" through 6" (25-152mm)
  - BOTTOM PIPE DIAMETER
  - 1" through 1 1/2" (25-38mm)
  - 2" through 6" (51-152mm)

**model 1047**
PIPE ROLL GROOVING ATTACHMENT FOR USE WITH COLLINS® 22-A CAPACITY 1" - 12"

**model 1048**
PIPE ROLL GROOVING ATTACHMENT FOR USE WITH WHEELER-REX 6090 CAPACITY 1" - 6"

**model 1049**
PIPE ROLL GROOVING ATTACHMENT FOR USE WITH ROTHENBERGER® SM300 CAPACITY 1" - 12"

"Ridgid®" is a registered trademark of Ridgid® Tool Co. Wheeler-Rex is a trade name of the Wheeler Manufacturing Corp.
model 2050
AUTOMATED ROLL GROOVER

Capacity: 4" through 30" Pipe (101.6-762mm) Pipe
Wide capacity, high production automated Pipe Groover with a fully automatic hydraulic system permits rolling specification-quality grooves in one operation. Push-button controls and easy pipe loading insure high output. A 5 HP motor rotates even largest diameter pipe under the Top Roller which is under hydraulic pressure. Model 2050 is designed for specialty shops and contractors doing a large volume of pipe work. Five Top and Five Bottom Rollers are required to handle the full range of the machine's 4" (101.6mm) through 30" (762mm) capacity. Shipped completely assembled with Rollers.

MODEL 2050 SPECIFICATIONS

Capacity: 4" through 12" SCH# 40 (10mm)
12" through 30" Standard Wall .375 (9.5mm)
Pipe Rotation Speed: 30 RPM
Hydraulic Pressure at Roller: 20,000 psi max.
Spindle Height from Floor: 36" (914mm)
Electric Drive Motor: 5 HP 60 Hz 220 V.3PH
Hydraulic Pump Motor: 2 HP 60 Hz 220 V.3PH
Floor Space Required: 40" x 36" (1016 x 914.4mm)
Shipping Weight: 1500 lbs. (680 kgs)
Interchangeable Rollers:

<table>
<thead>
<tr>
<th>TOP PIPE DIAMETER</th>
<th>BOTTOM PIPE DIAMETER</th>
</tr>
</thead>
<tbody>
<tr>
<td>4&quot; through 6&quot; (101.6-152.4mm)</td>
<td>4&quot; through 6&quot; (101-152.4mm)</td>
</tr>
<tr>
<td>8&quot; through 12&quot; (203.2-304.8mm)</td>
<td>8&quot; through 12&quot; (203.2-304.5mm)</td>
</tr>
<tr>
<td>14&quot; through 16&quot; (355.6-406.4mm)</td>
<td>14&quot; through 16&quot; (355.6-406.4mm)</td>
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<tr>
<td>18&quot; through 24&quot; (457.2-609.6mm)</td>
<td>18&quot; through 24&quot; (457.2-609.6mm)</td>
</tr>
<tr>
<td>26&quot; through 30&quot; (660.4-762mm)</td>
<td>26&quot; through 30&quot; (660.4-762mm)</td>
</tr>
</tbody>
</table>

*Also available in 50 cycle

STANDARD EQUIPMENT

Electric Drive Motor • Limit switch for depth gauging • Groove Depth Gauge • Hydraulic Pump Motor • Hydraulic Pump • Guards • Foot Switch
**model 1000**
**PORTABLE CUT GROOVER**

- Cuts grooves in 2, 2 1/2", 3, 3 1/2", 4, 5, 6 and 8" Schedule 40 pipe.
- Collet chucks for 10" and 12" pipe available
- Tooling for cut grooving ductile iron pipe also available
- Special collet chucks for non-standard dimension pipe can be supplied

The Pace Model 1000 is complete with 8 Collet Chucks, 4 High Speed Steel Grooving Blades and a Groove Gauge and is delivered ready to cut specification quality grooves in the complete 2" through 8" range of Schedule 40 pipe. Quick setups for each pipe size and simple operation make the Pace Model 1000 an extremely cost-effective tool for the fire protection and mechanical contractor. A 1 hp motor, driving through a heavy duty worm gear reducer, rotates pipe at 22 rpm for most effective cut grooving. Weighing only 185 lbs., Model 1000 is easily moved to the job.

**MODEL 1000 SPECIFICATIONS**
- **Capacity:** 2" through 12" SCHD 40 (10mm)
  - 2 1/2" through 8" SCHD 80 (13mm)
- **Power:** 1 HP, 115-230V, Enclosed Single Phase Motor.
- **Capacitor start. Output Speed:** 22 RPM.
- **Working Height:** 38"
- **Weight:** 185 lbs.

The Pace Pipe Cut Groover is shipped in a sturdy wooden box with storage area for individual collets, gauge and blades.

**FAST, ACCURATE SET-UPS FOR EACH PIPE SIZE**
Groove Gauge permits accurate adjustments of cutting blade and groove depth. Cutting blade is moved forward into contact with pipe by turning the handwheel. Large handwheel assures minimum effort.

Model 1000 will accept Collet Chucks up to 12", 8" diameter Chuck shown.

Pipe Stop (A) automatically locates position of groove to be cut. Adjustable Groove Depth Stop (B) automatically controls depth of cut.
model 1002
PORTABLE CUT GROOVER

- Cut grooves or bevels the end of any size pipe from 8" through 24".
- Shipped ready for use on black pipe.
- Self-aligning mounts directly on end of pipe and won't roll off.
- Weighs 88 lbs. Uses any external power source equipped with square drive.
- Operates through 2:1 reduction gearing.

Model 1002 is a versatile cut groover. It requires no stand or special setup, but mounts directly on the end of the pipe being grooved. Model 1002 is self-aligning on the pipe and can be operated manually or with any external power source equipped with a square drive. An accurate, vernier-type gauge makes setup for different size pipe quick and easy. The blades in this groover can be easily changed by removing only one screw. Blades are marked to show the range of pipe diameters they fit, and shims furnished with the machines match the position of the grooving bit to the pipe size being cut. Groove depth can be set easily and accurately using only a groove-depth gauge.
PIPE SUPPORT STANDS
Pipe support stands should always be used when rolling or cutting grooves in pipe. For cut grooving they are essential to keep the pipe level; for roll grooving, stands are adjusted to provide the slight downward pitch needed to keep the end of the pipe in firm contact with the back flange of the bottom roller. In every size range, Pace stands are made extra-rigid to prevent the “pendulum effect” which with less sturdy stands can whip the pipe off the support stand during a roll grooving operation.

model 4031
Capacity: 1" through 4" Pipe; 600 lbs. max.
A 22" diameter base and 2" column give this stand plenty of strength for supporting any pipe in its size range. The saddle has two roller bearings for free rotation of the pipe, and absorbs vibration to ensure a smooth, uniform groove. Saddle height is adjustable over a 10" (254mm) range.
The two-roller-bearing saddle may be ordered alone as No. 4032. Replacement roller bearing is No. 4025.

model 4000
Capacity: 2" through 8" Pipe; 900 lbs. max.
The base of this stand is the same as used in Model 4031, above. A saddle with four roller bearings provides greater side support for the pipe and increased dampening of vibration without impairing the unit's free-rolling characteristics. Saddle height is adjustable over a 10" (254mm) range.
The four-roller-bearing saddle may be ordered alone as No. 4001. Replacement roller bearing is No. 4025.

model 4033
Capacity: 2" through 14" Pipe; 1200 lbs. max.
This extra-heavy-duty pipe support stand uses two 2" columns on a 22" diameter base to give it exceptional stability and resistance to vibration and pendulum effect. Each column incorporates a sturdy, threaded post infinitely adjustable over a 10" (254 mm) range. The saddle utilizes six roller bearings in an array that provides excellent support for all pipes in its size range.
Replacement roller bearing is No. 4025.

model 4040
Capacity: 12"-24" Pipe; 4000 lbs. max.
This is our SuperStand! Fabricated of 6" diameter steel pipe welded to a 36" diameter base, this massive stand can support up to two tons of pipe during grooving operations. Pipe saddle height is adjustable over a 5" (127 mm) range.
model 4039
MOUNTING FEET
Fit Models 1000, 1010, 1020, 1021, 1023 and 1040 Portable Groovers. There are many situations where a portable groover will be employed in a single location long enough to make a semi-permanent installation desirable. By simply adding a set of these mounting feet and bolting the machine to the floor, the user gains some of the increased stability and rigidity typical of a stationary groover. When the work is completed, the unit can quickly and easily be disassembled and trucked to a new location.

model 4037
NIPPLE BRACKET
Capacity: 8" through 24" (203-610mm) Pipe. Fits Models 1020, 1021, 1023, 2020, 2021 and 2050 Roll Groovers
This nipple bracket was developed to permit safer, more efficient roll grooving of pipe too short to mount in a pipe stand. The plastic composition clamp-roller fixes pipe nipple in a controlled, slightly eccentric position so that the pipe is held firmly against the back flange of the bottom roller as it rotates. Pipe nipples as short as 6" can be grooved using this tool, permitting high production rates without the need for manual positioning by shop personnel.

go / no-go gauges
Because they simulate a pipe coupling, Pace Go/No-Go Gauges are an excellent tool to use for quickly determining accuracy of groove depth. After a groove is rolled, the appropriate gauge is matched to it. If the gauge will not fit, the groove is too shallow; if the gauge slides past its No-Go marking, the groove is too deep. Made of steel and hard-chrome plated for durability, these gauges are easy to use and remain permanently accurate. Standard size gauges are made for groove diameters from 1" (25.4mm) to 12" (305mm). Other sizes can be furnished on request.

universal gauge
The Pace Universal Groove Gauge can accomplish many functions in only one tool. No other gauging tool can do as much. The primary job of this gauge is to check groove depth and tolerance from 2" thru 8", but goes on from there. Grooves can be checked while the pipe is on the machine. The groove can be checked while the grooving process is happening because of the very hard, heat treated wear surface and the spring loaded size bar. This is much easier than using a coupling half where you must remove the pipe to use. What if the coupling is not accurate? Chrome plated finish for high durability...a must for rougher use and long life.
Think of Pace Tools and Machines for ease of use and durability.
model 3013
PORTA-BORE
Designed for fast, efficient operation, using Slugger® cutters, hole saws and drills

- Solid alloy aluminum construction. It is the most ruggedly constructed machine in the industry.
- Slide and gibbs are heat treated aluminum that is Teflon coated to insure long life. Slide assembly is positioned together by gauge block machining. This assembly is located by dowelled gibbs that are precisely aligned with the V-block. There are no elongated holes which could allow misalignment.
- Motor is a 10 Amp draw industrial drill motor with internal 4-speed gear box 110, 175, 245, 385 RPM. Spindle bore is a No. 3 Morse Taper.
- Electrical Panel meets the highest standard of operating safety. A Circuit Breaker assures no safety hazard to the operator or machine.
- Arbor support design for use with Slugger® cutters, or drill chuck for use with hole saws or drills.
- Chain clamp is standard on all units and clamps to pipe diameters 1 1/4" through 12".*
- Optional speed toggle clamp, clamps 1 1/4" through 6" pipe.*

*Both clamps ensure positive holding during hole cutting operations and can by used in any position.

- Oil feed. - The arbor is designed with an oil reservoir for automatic gravity feed during the cutting operation in the vertical position.
- Easy part replacement - building block design allows easy part repair or replacement. (No need to ship machine out for repair).

MODEL 3013 SPECIFICATIONS:
Heavy Duty - 42 lbs, 110, 175, 245, 385 RPM. Cuts up to 4 1/2" diameter holes in 1 1/4" through 12" diameter pipe. 110 volts 10 amps, (220 Volts is available).
model 8100
Buck-on
Machine

Fast, accurate fitting installation on 1", 1 1/4", 1 1/2" and 2" pipe.

Infinite Torque adjustment range
Easy to operate
Engineered for production work
No bushing boxes required

The PACE BUCK-ON machine helps you improve productivity by bucking-on a wide variety of fittings quickly and accurately. It reduces the time you spend waiting for pipe and fittings to be joined. And that improves profitability.

Pace has streamlined the buck-on process with a new clutch design and universal cam chuck.

The new clutch allows an infinite range of adjustment for better results with any kind of pipe dope. The simpler clutch design also means greater reliability, eliminating costly downtime.

In addition, the universal cam chuck saves set-up time by eliminating the need for keys and box liners.

EASY TO OPERATE

To use the Pace Buck-on machine, you simply turn the knob until the indicator needle matches the prescribed pressure setting. Then place the fitting into the jaws, adjust the size with a hex key, slide the pipe in place and use the foot switch to clamp the pipe. The air system will clamp the pipe with the proper pressure automatically. It also assures safety by locking out the start cycle unless the pipe jaws are clamped.

BUILT FOR PRODUCTION WORK

Pace has engineered the Buck-on machine to stand up to the rigors of all day, every day use. Its electronic motor, cooling fan and filters are housed on a sturdy steel cabinet.

MODEL 8100 SPECIFICATIONS

Height: 42"
Width: 32"
Depth: 32"
Motor: 3 HP, 3 phase, 220V
Weight: 600 lbs.
model 5021
PIPE-END PREP MACHINE

A heavy-duty, high-production machine that simultaneously grinds, chamfers, reams and marks pipe for plain-end fittings.

Here's a tough, hard-working machine you can count on for day-in, day-out, high volume production of pipe prepared for use with plain-end fittings. The Pace 5021 can be bench mounted for use on the jobsite, or mounted permanently on our optional heavy-duty stand for shop use.

Operation is simplicity itself:

1. Insert pipe and tighten it against the drive rollers with the toggle clamp. Clamping action forces knurled marking wheel against pipe. Preset roller stop locates pipe properly for marking, chamfering and grinding.
2. Start drive motor by depressing foot pedal. Pipe is marked automatically as it rotates under the marking wheel.
3. Pull down the operating lever to bring chamfering and reaming tools in contact with end of pipe, and to grind pipe o.d. to smooth finish. Preset roller stop ensures correct chamfer and proper location of ground finish and mark.

That's all there is to it!

SPECIFICATIONS

Pipe Size Range: 1" through 2"

Drive Motor: 1 1/2 hp., 120 volt, 60 Hz, Single Phase. Drives through cog belt to gear reducer.

Marking Wheels: Adjustable to 1/8", 1/6", 1/4" and 1/2" with two marking wheels

Weight: 222 lbs. (without optional stand)

model 5200
AIR CLAMP ACCESSORY FOR MODELS 5020 & 5021

Fast, efficient, automatic pipe clamping for high production pipe shops. Needs only 80 psi shop air pressure to produce 1000 lbs. of clamping pressure.

Air clamp is preset to handle pipe from 1" to 2" without need for adjustments.

After positioning pipe on the drive roller, actuating the foot pedal automatically clamps the pipe and starts the drive motor.

Tool holder is easily adjusted to size of pipe being prepped. Simply loosen screws (A) and slide chamfer/ream tool holder to marked setting (B) for size of pipe. Tighten screws.

Pipe is marked, chamfered, reamed and ground smooth in one fast operation.

Toggle clamp assembly is mounted on heavy steel post; can be easily adjusted to desired pipe size by sliding it up or down on gear rack. Rollers are mounted on four ball bearings.