

Depth Adjustment

1. Lift feed handle.
2. Back depth adjustment screw out to stop.
3. Tighten adjustment screw number of turns shown opposite pipe/tube to be grooved.

Note: Make test groove to check groove diameter.

1 ½ - 2in. & 2 - 6 in. Roll Set

Pipe Diameter	Sch. 10 No. of turns	Sch. 40 No. of turns
6	2 ½	N/A
4	2 ¾	N/A
3 ½	2 ¾	N/A
3	2 ½	¾
2 ½	2 ½	1
2	2 ½	1 ½
1 ½	2 ½	1 ¾
1 ¼	2 ¾	1 ¾

Copper Roll Set (Optional)

Tubing Diameter	Copper Tubing Type No. of turns			
	K	L	M	DWM
6	1 ¼	2 ½	3	4 ¼
5	1 ¾	2 ¾	3 ¼	4 ¼
4	2 ½	3 ¼	3 ½	4 ½
3	3 ¼	3 ½	4 ¼	4 ¾
2 ½	3 ½	4	4 ¼	N/A
2	4	4 ¼	4 ½	N/A

1 Inch Roll Set (Optional)

Pipe Diameter	Sch. 10 No. of turns	Sch. 40 No. of turns
1	5	4 ¼

1 ¼ - 1 ½ Inch Roll Set (Optional)

Pipe Diameter	Sch. 10 No. of turns	Sch. 40 No. of turns.
1 ½	3 ¾	3
1 ¼	3 ½	3

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