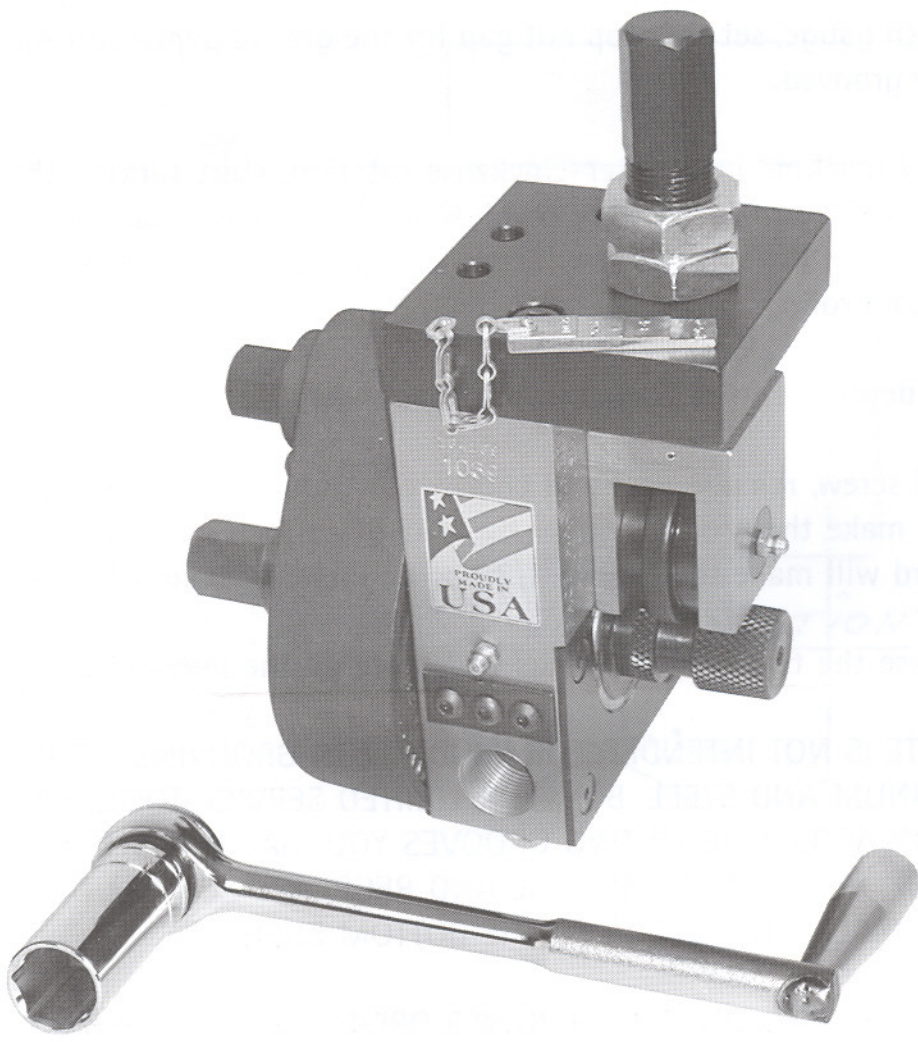



Page Mini-Mite Roll Groovers

OPERATING INSTRUCTIONS Model 1039



PACE 
MACHINERY GROUP, INC.

PACE MODEL 1039 OPERATING INSTRUCTIONS

1. Install 3/4" NPT x 6" pipe nipples (2 required) into sides of mini-mite.
2. Insert three sided flats on back of mini-mite drive shaft into hammer chuck on Rigid 300, making sure that hammer chuck is tight on flats of shaft.
3. Insert pipe to be roll grooved over bottom roll. Make sure that pipe is against front wear plate.
4. With 15/16" wrench or socket, lower top roll so that it comes in contact, with light pressure, against the pipe.
5. Using groove depth gauge, set the stop nut gap for the groove depth corresponding to the size of the pipe to be grooved.
6. Running the Rigid machine in counter-clockwise rotation, start turning the 15/16" hex lead screw giving it a little turn after every revolution of the pipe. You may have to move your pipe to the right just a little as you are facing the machine to insure that the pipe does not walk off the bottom roll.
7. Groove until the depth stop nut comes into contact with the top plate.
8. Back off the lead screw, remove pipe and check your groove diameter. Every 1/4 turn of the nut upwards will make the groove smaller by 1/32 of an inch in diameter. Every 1/4 turn of the nut downward will make the groove 1/32 of an inch larger in diameter.
9. Once a week grease the two grease fittings which are on the mini-mite.

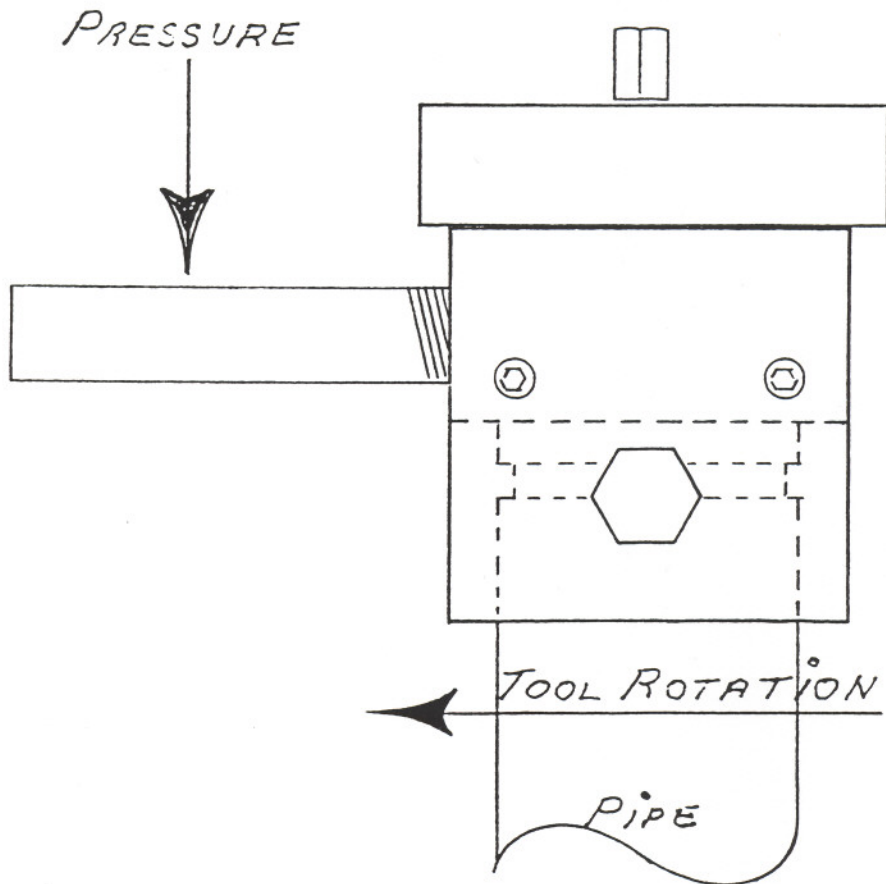
NOTE: THE MINI-MITE IS NOT INTENDED FOR PRODUCTION GROOVING. IT IS BUILT WITH HIGH ALLOY ALUMINUM AND STEEL, BUT AS A LIMITED SERVICE TOOL. ON 6" SCHEDULE 40 YOU MAY FIND AFTER ONE TO TWO GROOVES YOU MAY HAVE HIGH HEAT BUILD-UP IN THE HOUSING. ALLOW TOOL TO COOL AND REGREASE BOTTOM DRIVE SHAFT. IF IT IS NOT DONE DAMAGE MAY OCCUR TO THE BOTTOM BUSHING.

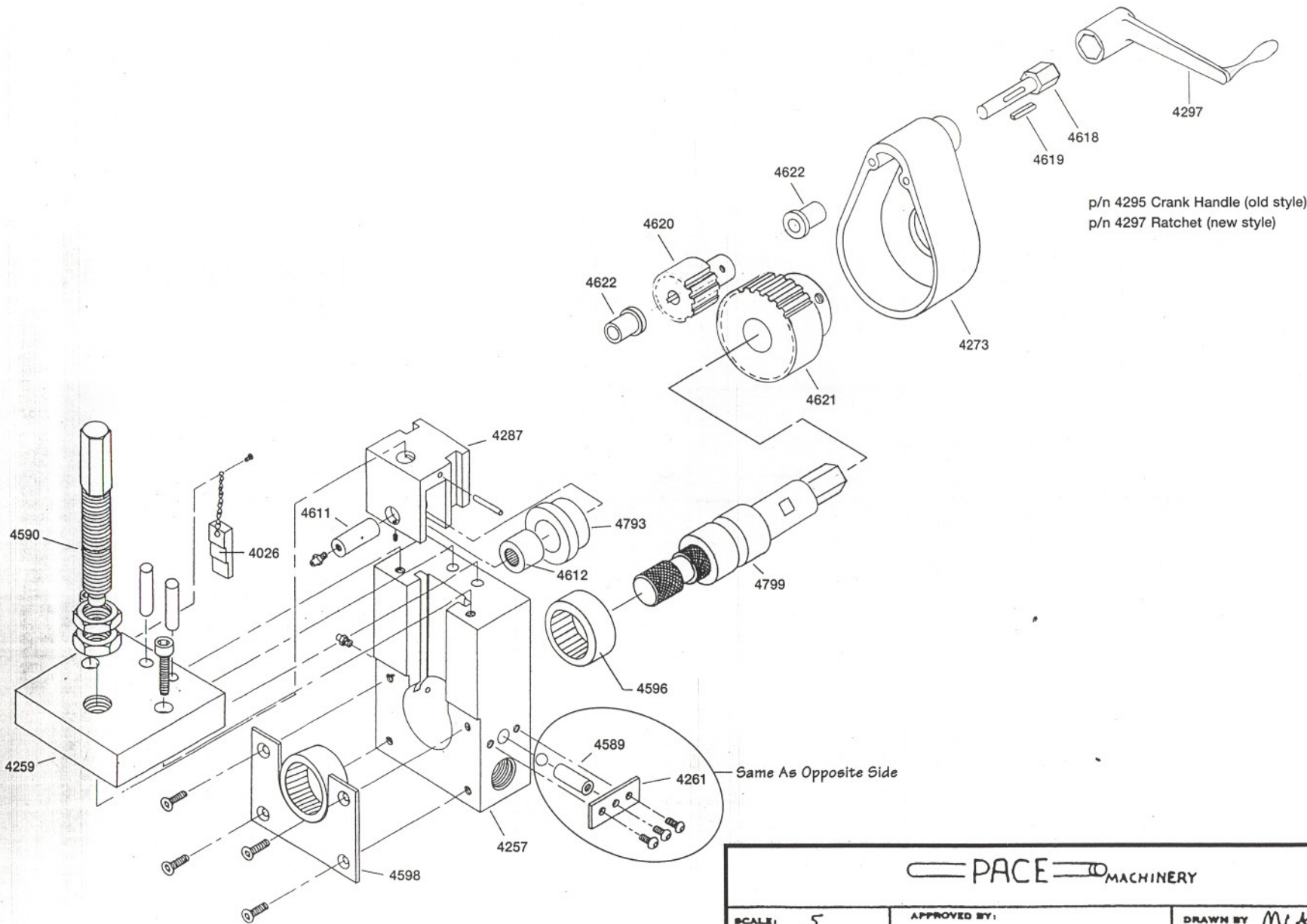
NOTE: MINI-MITE TO BE USED ONLY WITH POWER DRIVE WITH HAMMER CHUCK.

PACE MODEL 1039 ADDITIONAL OPERATING INSTRUCTIONS

NOTE: MODEL 1039

To insure that the 1039 Mini-Mite does not run off the pipe end, do the following step. Place one 3/4" x 6" pipe nipple into the support rod hole, that is, on the leading side. The side of the unit in the direction you are rotating. As you wind the tool around the pipe, apply pressure on the nipple toward the pipe face. This will ensure that the tool will not want to run off the pipe end.





p/n 4295 Crank Handle (old style)
 p/n 4297 Ratchet (new style)

Note:
 4798-Idler Roll with Bearing Copper
 4800-Drive Shaft Copper
 4021-Depth Gauge Copper

PACE MACHINERY		
SCALE: .5	APPROVED BY:	DRAWN BY <i>M.L.D.</i>
DATE: 2-22-90		REVISED
MINI-MITE ROLL GROOVER		
ASSEMBLY MODEL 1039		DRAWING NUMBER

PACE MACHINERY GROUP, INC.

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10/04