OPERATION MANUAL
REX 3/4" ~ 3"
GROOVING HEAD

292026 : ¾ ~ 2" / 292036 : 2½ ~ 3"

Important

For your own safety, best performance and a long tool life.
Before assembling and operating this unit, read this Operation Manual carefully and completely.
Learn the operation, application and potential hazards peculiar to this unit.

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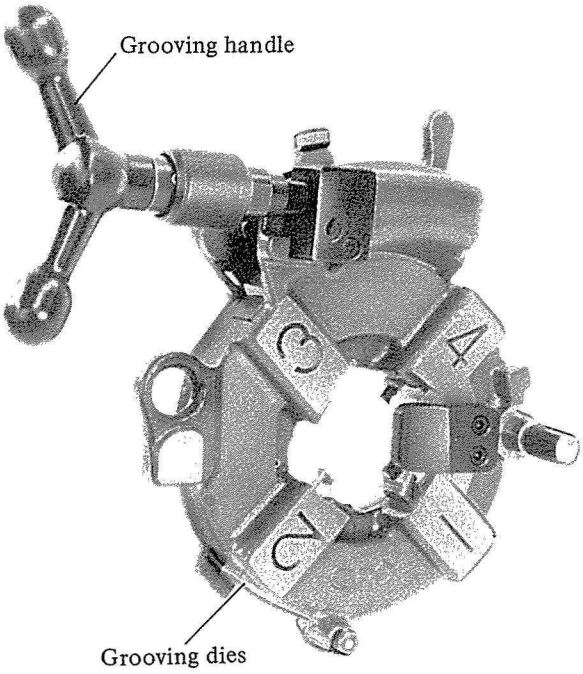
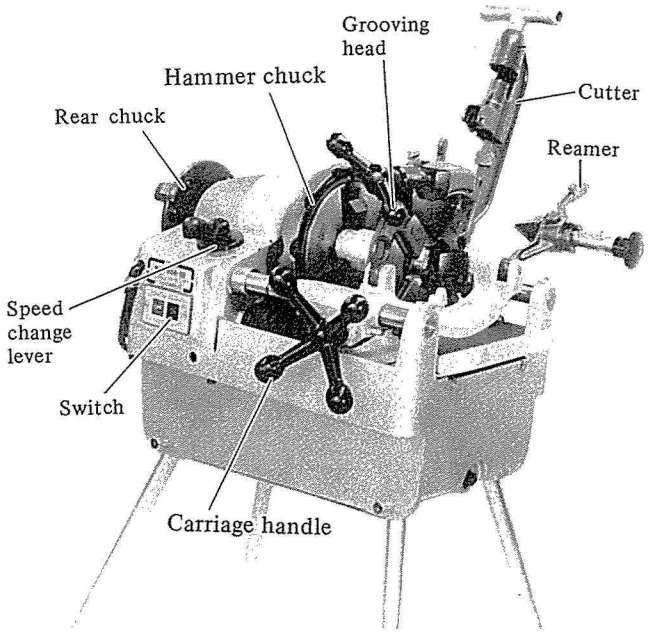
REX ¾" ~ 3" Grooving Head Main Parts





Grooving head 292026 : ¾ ~ 2"
292036 : 2½ ~ 3"

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Specifications

- **Specifications:**

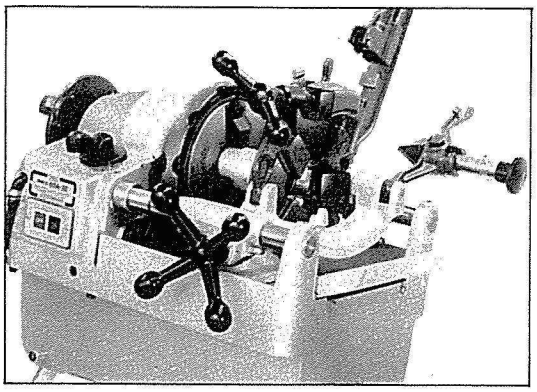
Speed:	High-speed rotation
Size:	(¾ ~ 2") (2½ ~ 3")
Dies:	(¾"), (1 x 2") and (2½ x 3")

- **Other Accessories:**

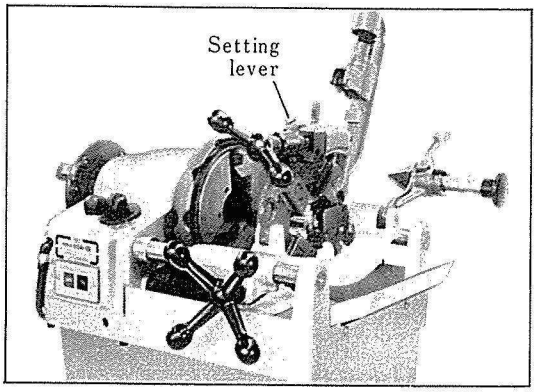
Beveling dies:	
Size:	(¾"), (1 x 2") and (2½ x 3")

Operating Instructions

1. Fitting the Grooving Head

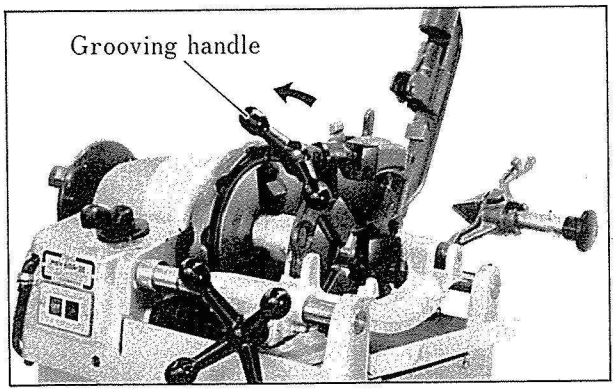


1. Fit the grooving head on the carriage in place of the die head.

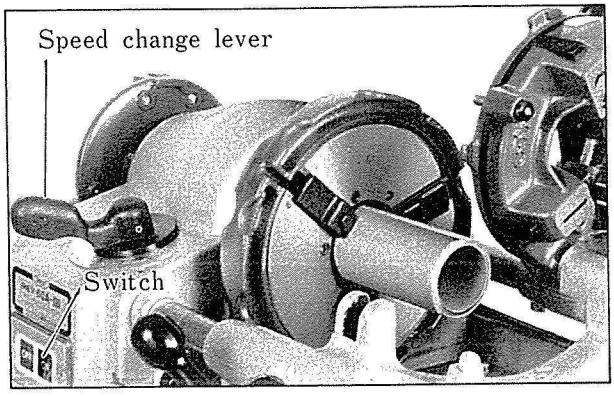


2. Flick the size setting lever to the required setting.

2. Grooving

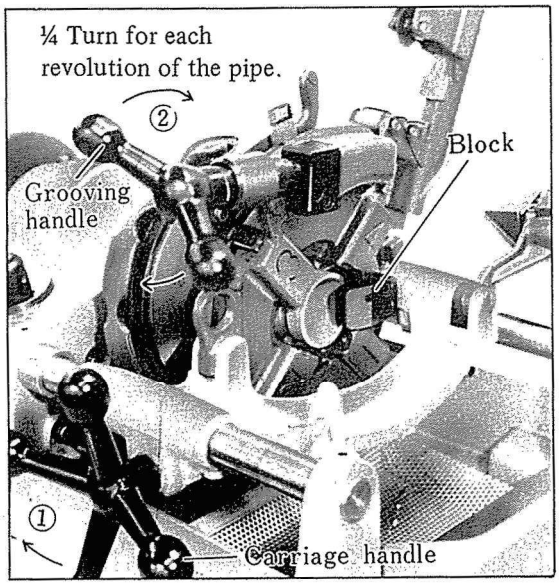


1. Open the dies wider than the pipe by turning the handle to the left.



2. Chuck the pipe, set the speed and switch the machine on. Oil will flow out from the grooving head automatically.

*Check that the pipe has been squarely cut before inserting as an irregular surface or an out-of-true end will need re-cutting before grooving.



3. Turn the carriage handle to the right to fit the groover onto the pipe as far as the stop block, then slowly turn the grooving handle to tighten the dies on the pipe, An off-center pipe may damage the dies if they are advanced too fast.

4. When the pipe is grooved evenly all round, release the carriage handle and tighten the grooving handle ¼ turn for each revolution of the pipe.

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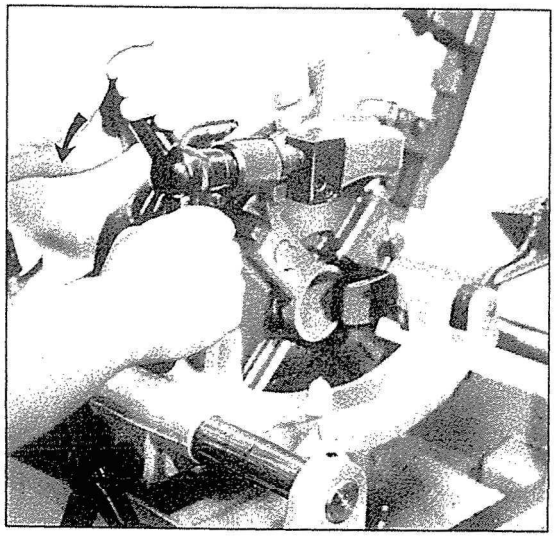
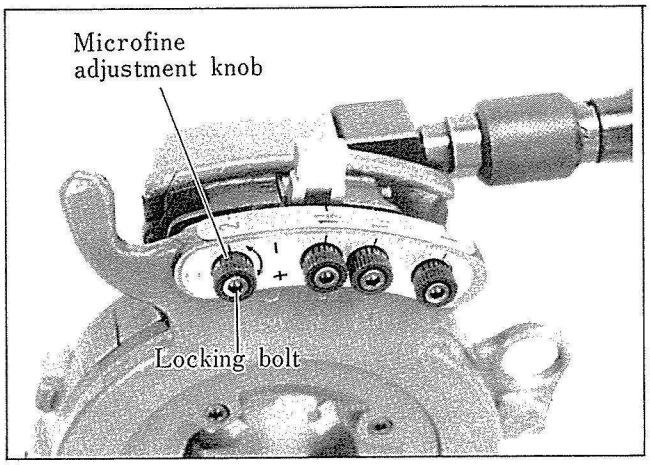


5. When the handle will turn no more, grocving is complete. Turn the grooving handle to the left :o clear the dies completely from the pipe and switch off the machine.

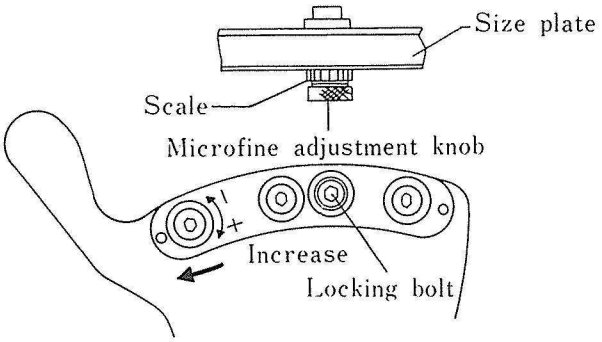
6. Remove the grooving head from the pipe by turning the carriage handle to the left. Remove the pipe and raise the grooving head.

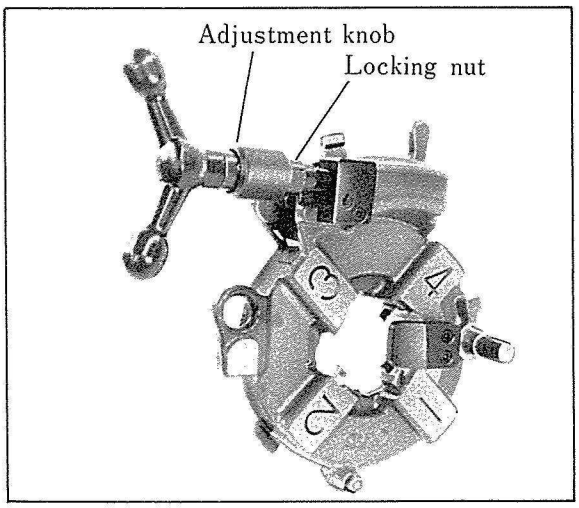
Changing the Grooving Depth

Grooving depth is set at the factory to standard specifications but can be adjusted for almost any desired setting.

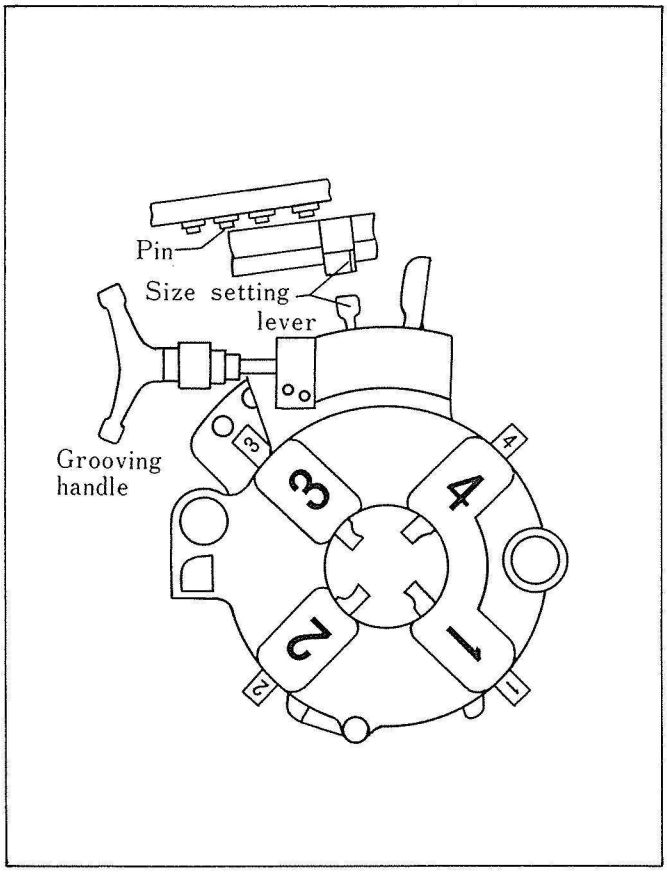


1. To adjust individual size settings:
   Loosen the locking bolt with a hex key.
   Turn the microfine adjustment knob to the right to incrase the depth, and to the left to decrease.
   Lock in position with the hex key.





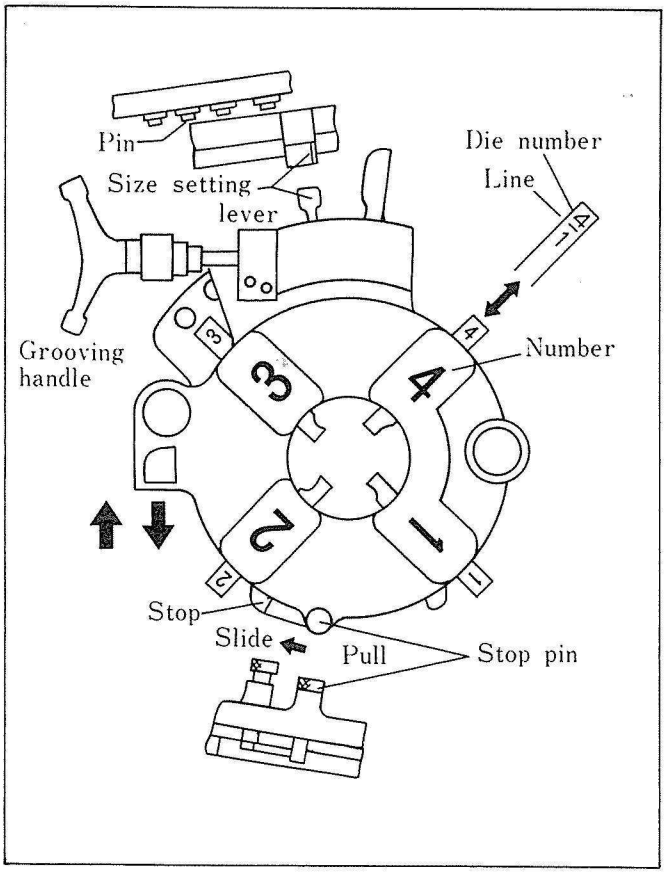
2. If this adjustment is not enough, further adjustment can be made by turning the adjustment ring to the right to increase depth, and to the left to decrease. First loosen the lock nut on the grooving handle, make the adjustment and lightly close the lock nut. Check with a test cut before tightening in position.



3. Adjustments made by the above method (2) will affect all size settings so make test cuts for each and readjust as necessary.

*¾ and 1¼ settings fall in the same position so it is only necessary to adjust one or the other.

Replacement of Dies



Removal:

1. Remove the die head from the carriage with the auto open lever in the open position
2. Lay the die head, lever upwards, on the bench and rotate to open dies.
3. Raise the stop pin to release and rotate the die head further. Dies can now be removed.

Replacement:

1. Insert replacement dies up to the line, making sure that the numbers on the dies match the numbers on the die head.
2. Dies are made as a matched set of four so be sure to use them as a set and to replace them all, not just one or two.
3. Rotate the die head handle clockwise to close the dies. Should the head prove difficult to close, remove the dies and reinsert them one by one until all four are correctly in place.

REX

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