

Roll Grooving Tool

RG3400



1.0 PRODUCT DESCRIPTION

Grooving Capability

- Carbon Steel: 1" IGS™
- Carbon Steel/Stainless Steel: 1 – 12" OGS
- Light Wall Stainless Steel: 2 – 12"
- Copper: 2 – 8"
- PVC: 2 – 8"
- Aluminum: 2 – 12"

Application

- Hydraulic-feed field or shop tool

Performance

RG3400 RATINGS – MAXIMUM PIPE SIZE AND WALL THICKNESS CAPACITY ¹													
Pipe Material	Pipe Size inches DN												
	1 DN25	1 ¼ DN32	1 ½ DN40	2 DN50	2 ½	3 DN80	3 ½ DN90	4 DN100	5	6 DN150	8 DN200	10 DN250	12 DN300
Steel (IGS) ^{2,3}	Sch. 10 – 40	–											
Steel (OGS) ^{2,4}	Sch. 5 – 40										Sch. 5 – 20		
Stainless Steel ^{2,4}	Sch. 40S										Sch. 20S		
Lt. Wall SS ⁵	–		Sch. 5S - 10S										
Aluminum ^{6,7}	–		Sch. 5 – 40								Sch. 5 – 20		
PVC Plastic ⁶	–		Sch. 40	Sch. 40 – 80						Sch. 40	–		
Copper ⁸	–		Types K, L, M, DWV								–		

¹ Only RG3400-specific grooving rolls shall be used. Alternative Victaulic grooving rolls or parts from any other manufacturer shall not be used with the RG3400 Roll Grooving Tool.

² Maximum ratings are limited to 150 BHN (Brinell Hardness Number) and less.

³ Use grooving rolls marked with prefix RI.

⁴ Use grooving rolls marked with prefix R.

⁵ Use grooving rolls marked with prefix RX.

⁶ Use grooving rolls marked with prefix RP.

⁷ 6061-T4 or 6063-T4 alloy shall be used.

⁸ Use grooving rolls marked with prefix RR.

ALWAYS REFER TO ANY NOTIFICATIONS AT THE END OF THIS DOCUMENT REGARDING PRODUCT INSTALLATION, MAINTENANCE OR SUPPORT.

2.0 CERTIFICATION/LISTINGS



This product is designed and manufactured under the Victaulic Quality Management System, as certified by LPCB in accordance with ISO-9001:2015.

3.0 SPECIFICATIONS

Drive Requirements: Self-contained

Power Requirements:

- 220V 50HZ
- 220V 60HZ
- 110V 50HZ
- 120V 60HZ

4.0 ACCESSORIES/COMPONENTS

Included:

- (1) Tool with Motor and Hydraulic Pump Handle
- (1) Foot Switch
- (1) Pipe Stand
- (1) Go/No-Go Grooved Pipe Diameter Tape
- (1) Go/No-Go IGS Cable (Fire Protection Package only)
- (1) Storage Bag with Accessories
- (2) Operating and Maintenance Instructions Manuals

Grooving Roll Package (Choose one):

- (1) Fire Protection Roll Package: 1" IGS, 1 ¼ – 12" OGS
- (1) Carbon Steel/Stainless Steel OGS Roll Package: 1 – 12" OGS
- (1) Light Wall Stainless Steel Roll Package: 2 – 12"
- (1) Copper Roll Package: 2 – 8"

Optional Grooving Rolls:

Carbon Steel

1" IGS Rolls

- Grooving Capabilities:
 - Carbon Steel (Sch. 10-40)

Carbon Steel/Stainless Steel

1 – 1 ½" Rolls

- Grooving Capabilities:
 - Carbon Steel (Sch.5-40)/Stainless Steel (Sch. 40S)

1 ¼ – 1 ½" Rolls

- Grooving Capabilities:
 - Carbon Steel (Sch.5-40)/Stainless Steel (Sch. 40S)

2 – 3 ½" Rolls

- Grooving Capabilities:
 - Carbon Steel (Sch.5-40)/Stainless Steel (Sch. 40S)

4 – 6" Rolls

- Grooving Capabilities:
 - Carbon Steel (Sch.5-40)/Stainless Steel (Sch. 40S)

8 – 12" Rolls

- Grooving Capabilities:
 - 8": Carbon Steel (Sch.5-40)/Stainless Steel (Sch. 40S)
 - 10 – 12": Carbon Steel (Sch.5-20)/Stainless Steel (Sch. 20S)

Optional Grooving Rolls (continued):

Lt Wall Stainless Steel RX

2 – 3 ½" Rolls

- Grooving Capabilities:
 - (Sch. 5S-10S)

4 – 6" Rolls

- Grooving Capabilities:
 - (Sch. 5S-10S)

8 – 12" Rolls

- Grooving Capabilities:
 - (Sch. 5S-10S)

Copper

2 – 6" Rolls

- Grooving Capabilities:
 - (Types K,L,M,DWV)

8" Rolls

- Grooving Capabilities:
 - (Types K,L,M,DWV)

PVC/Aluminum

2 – 3 ½" Rolls

- Grooving Capabilities
 - 2" – PVC (Sch.40)
 - 2 ½ – 3 ½": PVC (Sch. 40-80)
 - 2 – 3 ½": Aluminum (Sch. 5-40)

4 – 6" Rolls

- Grooving Capabilities:
 - 4 – 6": PVC (Sch. 40-80)
 - 4 – 6": Aluminum (Sch. 5-40)

8 – 12" Rolls

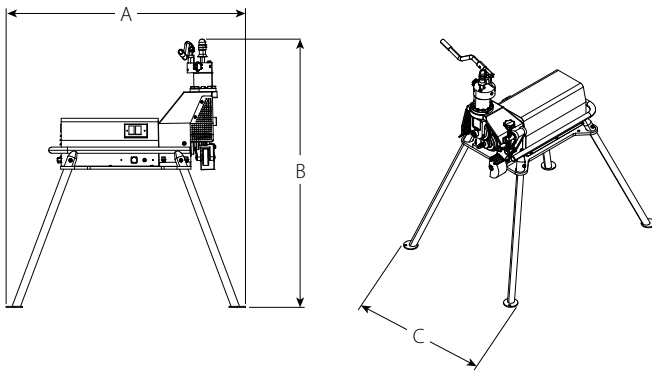
- Grooving Capabilities:
 - 8": PVC (Sch. 40)
 - 8": Aluminum (Sch. 5-40)
 - 10", 12": Aluminum (Sch. 5-20)

NOTES

- The Victaulic pipe stand is required for proper operation of the RG3400 roll grooving tool.
- Roll sets for the RG3400 roll grooving tool are not compatible with other Victaulic grooving tools.

5.0 DIMENSIONS

RG3400 Roll Grooving Tool



Dimensions			Assembled Weight
A	B	C	
inches	inches	inches	lb
mm	mm	mm	kg
43	51	32	302
1100	1300	820	137

6.0 NOTIFICATIONS

WARNING



Failure to follow instructions and warnings could result in death or serious personal injury and property damage.

- Before setting up, operating, or servicing the RG3400 Roll Grooving Tool, read all instructions in the TM-RG3400 Operating and Maintenance and all warning labels on the tool.
- Wear safety glasses, hardhat, foot protection, and hearing protection while working around the tool.

7.0 REFERENCE MATERIALS

[25.01: Original Groove System \(OGS\) Groove Specifications](#)

[25.06: Copper Tubing Roll Groove Specifications](#)

[25.14: Victaulic IGS Groove Specifications](#)

[RP-RG3400: RG3400 Repair Parts Manual](#)

[TM-RG3400: RG3400 Operating and Maintenance Instructions Manual](#)

User Responsibility for Product Selection and Suitability

Each user bears final responsibility for making a determination as to the suitability of Victaulic products for a particular end-use application, in accordance with industry standards and project specifications, as well as Victaulic performance, maintenance, safety, and warning instructions. Nothing in this or any other document, nor any verbal recommendation, advice, or opinion from any Victaulic employee, shall be deemed to alter, vary, supersede, or waive any provision of Victaulic Company's standard conditions of sale, installation guide, or this disclaimer.

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Note

This product shall be manufactured by Victaulic or to Victaulic specifications. All products to be installed in accordance with current Victaulic installation/assembly instructions. Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without incurring obligations.

Installation

Reference should always be made to the Victaulic installation handbook or installation instructions of the product you are installing. Handbooks are included with each shipment of Victaulic products, providing complete installation and assembly data, and are available in PDF format on our website at www.victaulic.com.

Warranty

Refer to the Warranty section of the current Price List or contact Victaulic for details.

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