

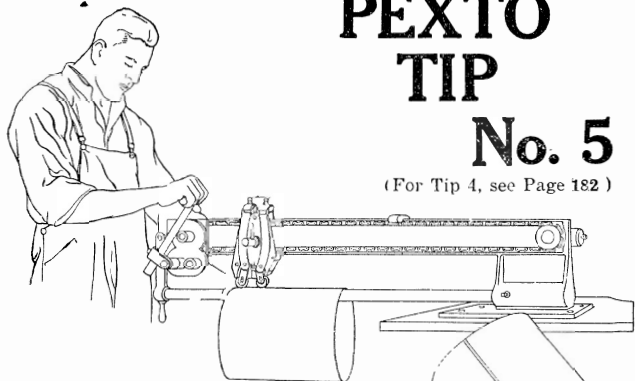
SECTION M

# Grooving Machines

# PEXTO TIP

## No. 5

(For Tip 4, see Page 182)



## RAPID GROOVING MACHINE

### A Time and Money Saver

Modern shop methods demand that time and money be saved, *but there must be no sacrifice of quality.* Real improvement in the finished product should result.

Pexto Rapid Grooving Machine No. 518A, illustrated above, accomplishes this. With a few turns of the crank, the seam is closed and grooved with a nicety and accuracy and speed not to be equalled by hand methods. The old hand groover and mallet form too expensive a proposition for these times.

There are a large variety of types in the Pexto line of Grooving Machines. No. 518A, because of its rapid operation, is ideal for shops where time-saving is imperative. The operator inserts and removes work, performing the entire operation without need for changing his position.

**GROOVED SEAM**—Pexto Tip No. 3 showed how the seam in the body of the can is prepared by the Folding Machine. Tip No. 4 explains the forming of the cylinder.

This fifth operation consists of the cylindrical body with the edges, or folds, hooked, being placed over the horn of the Grooving Machine

The Grooving Rolls pass over the seam, grooving and flattening it



1819 100% American **PEXTO** 100 Years 1919

# SERVICE AND QUALITY

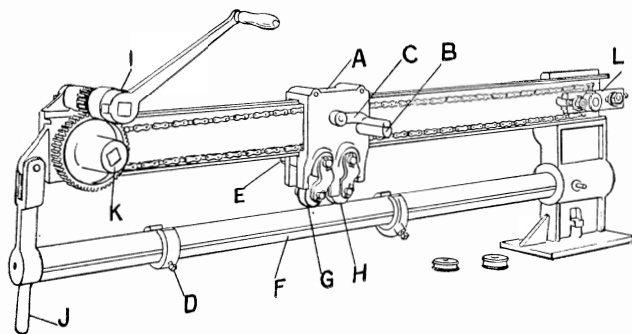


SATISFACTION ASSURED  
OR MONEY REFUNDED

1819 Imperial PEXTO Pattern 1919

GROOVING MACHINE

No. 520



Capacity—No. 20 Gauge Iron and Lighter

Specifications and General Description, Page 205A Insert.

205 insert

1819
Imperial
PEXTO
Pattern
1919

**GROOVING MACHINE**

No. 520

Illustration, Page 205 Insert.

**Capacity—No. 20 Gauge Iron and Lighter.**

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<b>New Number</b>	520
<b>Code Word</b>	Pextoimp
<b>Old Number</b>	

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Shipping Weight.....	approximately lbs. 410
Will Groove Work Length.....	inches 36
Diameter Smallest Pipe that can be Grooved.....	inches 3
Ratio of Gearing.....	3½ to 1
<b>Price</b> .....	
Shipped boxed regularly.....	

**NOTE**—Furnished with  $\frac{3}{16}$ -inch Grooving Roll for No. 20 Gauge,  $\frac{1}{16}$ -inch for No. 22 Gauge,  $\frac{5}{16}$ -inch for No. 24 Gauge and Lighter. Rolls of other dimensions are special and are only made when ordered at extra cost.

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**GENERAL DESCRIPTION.**

The trained eye of a mechanic is not necessary to claim for these New Patterns a Masterpiece Machine for Grooving and Flattening the Seams in Heavy Sheet Metal Work. The more important principles embodied in the construction of this machine are original, making for a greatly serviceable and convenient machine for light as well as heavy work.

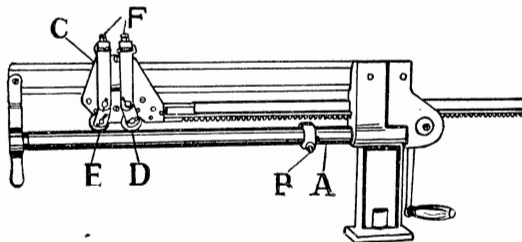
(A) is the Grooving Carriage that moves on a chain through Gears; (L) is a Take-up Attachment, if the chain should stretch after long and constant use; (C) is a Release Lever, disengaging the Carriage from Chain. When so disengaged the Carriage (A) can be worked backward and forward by the Handle (B) for Lightning Grooving on Light Material. The position of Hand Crank (I) offers a direct-acting motion. Fitting the Crank (I) in the Large Gear (K), the machine becomes Back Geared for greater ease when Grooving Heavy Iron. Pressure of the Grooving Roll (G) and Flattening Roll (H) is secured through eccentrics and which are quickly and easily adjusted through a turn of Knobs (E). The Flattening Roll (H) runs idle on the outward run and the Grooving Roll (G) idle on the backward run. The two Rolls do not press the seam at the same time, therefore easy grooving is assured. Lower Bar (F) is reversible, so that either the Flat surface or one of the Grooves which is planed into the Horn can be turned upward, permitting for the locating of seams on the inside or the outside of the work. The Stop (D) is steel and prevents work slipping while the Grooving is taking place.

The combination of features described offers an all-around Grooving Machine for light and heavy work up to 36 inches and No. 20 Gauge. The big, busy shop cannot afford to be without one.

Important Information, Page 204.

## GROOVING MACHINES

Nos. 506A and 507A



Capacity—No. 22 Gauge Iron and Lighter

New Number	506A	507A
Code Word	Pextoboss	Pextoboson
Old Number	210	220

Shipping Weight.....	approximately lbs	151	175
Length Grooving Horn.....	inches	33½	43½
Will Groove Work Length.....	inches	21½	31½
Diameter Smallest Pipe that can be Grooved.....	inches	2	2
Price .....			
Shipped boxed regularly.....			

NOTE—Furnished with ¼, 5-32 and ¾-inch Grooving Rolls and one Flattening Roll, and fitted with Flattening Attachment

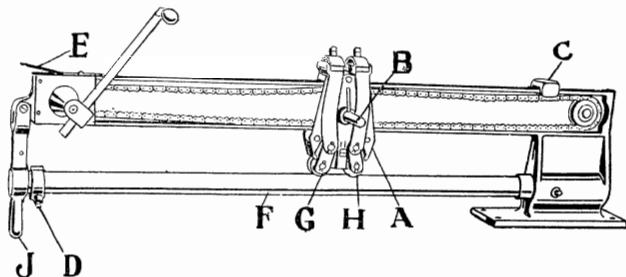
## GENERAL DESCRIPTION

These machines are constructed for general grooving and have an improvement consisting of an attachment which grooves and flattens the seams of cylinders in one operation. Lower Bar or Horn (A) is reversible, so that either the flat surface or one of the grooves which is planed into the Horn can be turned upward, permitting for the locating of seams on the inside or the outside of the work. The seam is put on the inside of work by means of Flat Roll which presses the seam into one of the grooves planed in the Horn, outside grooving is done in the usual manner by using the Grooved Rolls on flat surface of Horn. An Adjustable Stop Collar (B) is fitted on Lower Horn (A) to prevent work slipping while being grooved.

An improved feature will be found in the Carriage (C) which holds Flattening Roll (D) and Grooving Roll (E). The Flattening Roll (D) runs idle on the outward run and the Grooving Roll (E) runs idle on the backward run. In other words, both Rolls do not press on the seam at the same time, which makes for easy grooving. The old style Friction Spring and Roll for tension are not used, the tension being secured through a more simple arrangement at (F), which permits for greater uniformity in the seams grooved and eliminates frequent spring breakage.

## GROOVING MACHINES

No. 518A



Capacity.—No 24 Gauge Iron and Lighter

New Number	518A
Code Word	Pextocomet
Old Number	518

Shipping Weight.....	approximately lbs	200
Will Groove Work Length.....	inches	30
Diameter of Smallest Pipe that can be Grooved.....	inches	2
Price .....		
Shipped boxed regularly.....		

NOTE—Six Rolls are furnished, one each with 3-16, 7-16 and 15-32 inch grooves, two with 5-16 inch grooves and one Flattening Roll

## GENERAL DESCRIPTION

The best machine of its kind for grooving the longitudinal seams in stove pipe and other sheet metal cylinders. It differs from the ordinary Groover in that it is more rapid, the operator standing in front of the machine and does not have to change his position when inserting and removing work and operating the machine. The Traveling Carriage (A) is quickly and easily returned to the starting point by means of handle (B). Adjustable Stop (C) on Upper Bar stops the Traveling Carriage at any desired point to suit length of work. Adjustable Stop (D) or Lower Bar prevents work from slipping while being grooved. Spring (E) holds Latch (J) out of the operator's way while work is removed and inserted in the machine.

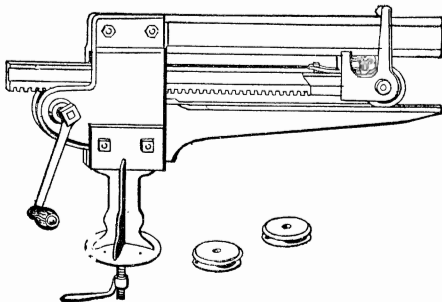
Lower Bar (F) is reversible, so that either the flat surface or one of the grooves which is planed into the Horn can be turned upward, permitting for the locating of seams on the inside or the outside of the work. The seam is put on the inside of work by means of Flat Roll which presses the seam into one of the grooves planed into the Horn. Outside grooving is done in the usual manner by using the Grooved Roll and flat surface of Horn. The Traveling Carriage (A) has two Rolls one for Grooving (G) and one for Flattening (H) the seam at the same operation.

The Grooving Carriage (A) is so arranged that the Flattening Roll (H) runs idle on the outward run and the Grooving Roll (G) idle on the backward run. The two Rolls do not press the seam at the same time therefore easy grooving is assured

1819 CharterOak **PEXTO** Pattern 1919

GROOVING MACHINES

No. 502



Capacity—No. 24 Gauge Iron and Lighter.

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New Number	502
Code Word	Pextoak
Old Number	01

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Shipping Weight . . . . .	approximately lbs	102
Will Groove Work Length . . . . .	inches	20
Size of Grooving Horn, Large End . . . . .	inches	3
Size of Grooving Horn, Small End . . . . .	inches	1 <sup>5</sup> / <sub>8</sub>
Price . . . . .		
Shipped boxed regularly . . . . .		

NOTE—Furnished with three Grooving Rolls, <sup>3</sup>/<sub>8</sub>, 5-32 and 7-32 inch.

GENERAL DESCRIPTION

These machines are constructed with Steel Bar and Milled Horn. They will be found serviceable for grooving the seams on tin cans, pails, boilers, etc. They are easy to operate and simple in construction.

For further information refer to Page 204

Pexto Tools and Machines are well known and widely used in all parts of the World.