

Victaulic® Large Diameter Roll Grooving Tools

VE460 and 50T



VE460



50T

1.0 PRODUCT DESCRIPTION

Grooving Capability

- 4 – 78"/DN100 – DN1800

Application

- Production roll grooving tools designed for fabrication shop use
- Designed to roll groove carbon steel pipe with wall thickness ranging between .220" – .750", dependent on the tool. For other wall thickness and material, please contact Victaulic.

Large Diameter Tool Capability Chart for Carbon Steel

Pipe Yield Strength psi	Maximum Pipe Wall Thickness				Tool (Applicable OD Range)
	0.220-0.375" 5.1- 9.5 mm	0.500" 12.7 mm	0.625" 15.9 mm	0.750" 19.1 mm	
35,000 - 60,000 Max	YES	YES	–	–	VE460 (14 – 60")
	YES	YES	YES	YES	50T (14 – 78")
90,000 Max	–	–	–	–	VE460 (14 – 60")
	YES	YES	YES	YES	50T (14 – 78")

NOTE:

- For other pipe materials and yield strengths contact Victaulic for details.
- The VE460 can groove .220"/5.1 mm wall thickness with yield strengths up to 90,000 psi.

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

System No.		Location	
Submitted By		Date	

Spec Section		Paragraph	
Approved		Date	

2.0 CERTIFICATION/LISTINGS

Product designed and manufactured under the Victaulic Quality Management System, as certified by LPCB in accordance with ISO-9001:2008.

3.0 SPECIFICATIONS

VE460

- **Power Requirements:** 240/480-volt, 3 phase, 60 hertz.


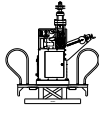
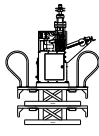
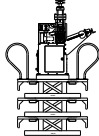
50T

- **Power Requirements:** 380 volt, 3 phase, 50/60 hertz.

NOTES:

- Tool requires certified electrician for electrical connection.
- Support bases are required to groove 30-inch/762 mm and larger pipe sizes.
- For additional power requirements contact Victaulic for details.





3.1 VE460 SUPPORT BASE KITS

		Roll Sets Included*	Railing and Platform Kit Qty	Support Base (Qty)	Tool Weight/ Shipping Weight Lbs.	Recommended Pipe Stand ¹
VE460		4 – 6"/ DN100 – DN150 8 – 12"/ DN200 – DN300 14 – 24"/ DN350 – DN600	N/A	N/A	1500/1750	VAPS224 OR VAPS1672 OR VAPS131R
Optional Accessories²						
26 – 38"/ 650 – 950 mm Grooving Kit		26 – 38"/ DN650 – DN950	1	1	N/A	VAPS1672
40 – 50"/ 1000 – 1200 mm Grooving Kit		40 – 50"/ DN1000 – DN1200	1 ³	2 ⁴	N/A	VAPS1672
54 – 60"/ 1300 – 1500 mm Grooving Kit		54 – 60"/ DN1300 – DN1500	1 ³	3 ⁴	N/A	VAPS1672

VE460 Optional Rolls: Optional rolls are available for Schedule 5S and 10S stainless steel pipe, PVC, and aluminum pipe.

- ¹ For proper operation, pipe stand(s) are required. See Accessories for details.
 - ² Optional Accessory Kits list REQUIRED COMPONENTS to groove up to the specified size. Kit components can be ordered individually or as a kit.
 - ³ Railing and Platform Kit is required only if preceding kit has not been ordered.
 - ⁴ Only one (1) Support Base is required if preceding kit has been ordered.
- * 50T roll sets not included in kit.

3.2 50T SUPPORT BASE KITS

		Railing and Platform Kit Qty	Support Base (Qty)	Recommended Pipe Stand ¹
50T		N/A	N/A	VAPS224 OR VAPS1672 OR VAPS131R
Optional Accessories²				
26 – 38"/ 650 – 950 mm Grooving Kit		1	1	VAPS1672
40 – 50"/ 1000 – 1200 mm Grooving Kit		1 ³	2 ⁴	VAPS1672
54 – 60"/ 1300 – 1500 mm Grooving Kit		1 ³	3 ⁴	VAPS1672

¹ For proper operation, pipe stand(s) are required. See Accessories for details.

² Optional Accessory Kits list REQUIRED COMPONENTS to groove up to the specified size. Kit components can be ordered individually or as a kit.

³ Railing and Platform Kit is required only if preceding kit has not been ordered.

⁴ Only one (1) Support Base is required if preceding kit has been ordered.

* Roll sets not included in kit.

4.0 ACCESSORIES/COMPONENTS

VE460

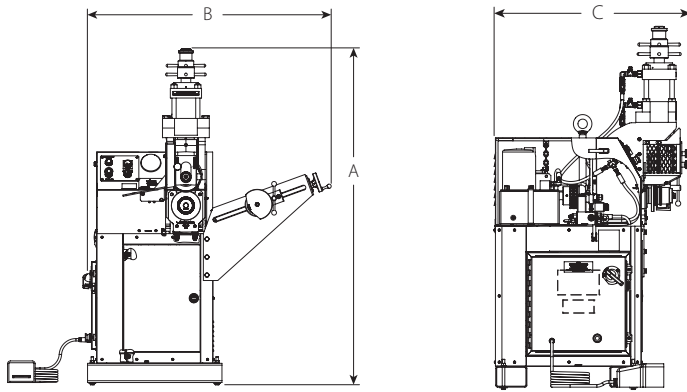
- One (1) VE460 Pipe Roll Grooving Tool
- One (1) Roll Set for 8 – 12-inch/219.1 – 323.9-mm Carbon Steel Pipe Mounted on the Tool (Unless Ordered Otherwise) – Original Groove System Specifications
- One (1) Roll Set for 4 – 6-inch/114.3-mm Steel Pipe – Original Groove System Specifications
- One (1) Roll Set for 14 – 24-inch/355.6 – 610-mm Steel Pipe AGS Specifications
- One (1) Stabilizer Assembly
- One (1) Stabilizer Mounting Hardware (Installed Loose in Mounting Holes for Stabilizer)
- One (1) Go/No-Go PT100A (inch) or PT101 (metric) Pipe Diameter Tape
- One (1) Hydraulic System Bleeder Tube
- One (1) Safety Foot Switch with Detachable Line Cord
- Two (2) TM-VE460 Operating and Maintenance Instructions Manual
- Two (2) RP-VE460 Repair Parts List

50T

- One (1) 50T Pipe Roll Grooving Tool
- One (1) Roll Set. Select roll size when ordering the tool
- One (1) Stabilizer Assembly (Pre-Installed)
- One (1) Safety Foot Switch with Detachable Line Cord
- One (1) Go/No-Go PT102A Pipe Diameter Tape
- One (1) Hydraulic System Bleeder Tube
- One (1) Guard Pad
- Two (2) TM-VE50T Operating and Maintenance Instructions Manual

5.0 DIMENSIONS

VE460



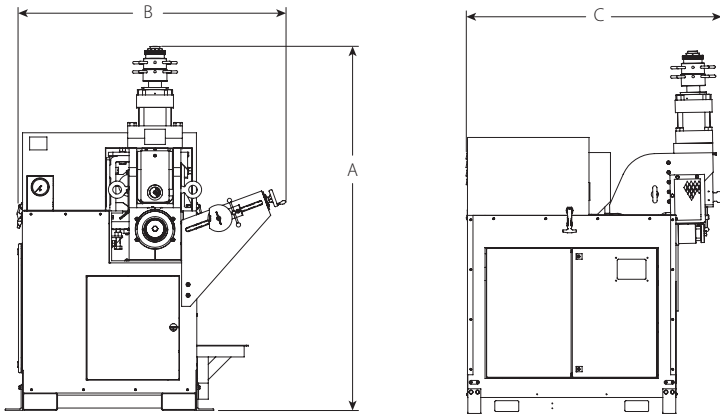
Dimensions			Tool Weight/ Shipping Weight
A	B	C	
inches	inches	inches	lb
mm	mm	mm	
71.12	50.80	37.38	1800
1806	1290	949	1980

NOTES

- Refer to TM-VE460 Operation and Maintenance Instruction Manual for power, installation and tool operation requirements.
- 3 feet (1 meter) of space between wall and back of tool for maintenance operations is required. Select a location for the tool and pipe stand by taking into consideration a permanent indoor location with a level concrete floor.

5.1 DIMENSIONS

50T









Dimensions			Tool Weight/ Shipping Weight
A	B	C	
inches	inches	inches	lb
mm	mm	mm	
83.91	61.68	58.68	3800
2131.3	1566.7	1490.5	4100

NOTES

- Refer to TM-50T Operation and Maintenance Instruction Manual for power, installation and tool operation requirements.
- 3 feet (1 meter) of space between wall and back of tool for maintenance operations is required. Select a location for the tool and pipe stand by taking into consideration a permanent indoor location with a level concrete floor.

6.0 NOTIFICATIONS

! WARNING

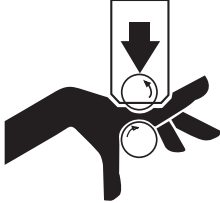


Failure to follow instructions and warnings could result in serious personal injury.

- Before operating or servicing this tool, read all instructions in the operating and maintenance manual and all labels on the tool.
- Wear safety glasses, hardhat, foot protection, and hearing protection.

If you have questions concerning the safe and proper operation of this tool, contact Victaulic, P.O. Box 31, Easton, PA 18044-0031, Phone: 1-800-PICKVIC, E-Mail: pickvic@victaulic.com.

! WARNING



Grooving rolls can crush or cut fingers and hands.

- Always disconnect the tool from the power source before making any tool adjustments.
- Make sure the guard is adjusted properly before grooving pipe.
- Loading/unloading pipe will place your hands close to the grooving rolls. Keep hands away from the grooving rolls and the roller on the pipe stabilizer during operation.
- Never reach inside the pipe ends or across the tool or pipe during operation.
- Never groove pipe that is shorter than the recommended lengths listed in the operating and maintenance manual.
- Never wear loose clothing, loose gloves, or anything that can become entangled in moving parts.

2244 Rev. D R007276LBL

- In order to achieve Victaulic specified product performance, the proper Victaulic roll grooving tool and corresponding Victaulic roll set must be selected. Failure to select the appropriate Victaulic roll set, or to use the correct Victaulic tool, may result in reduced performance or product failure. Tool specifications and capacities are listed with each tool.

7.0 REFERENCE MATERIALS

[TM-50T: Operation and Maintenance Instruction Manual](#)

[TM-VE460: Operation and Maintenance Instruction Manual](#)

[I-100 Field Installation Handbook](#)

[24.01: Pipe Preparation Tools Submittal](#)

[25.09: Advanced Groove System \(AGS\) Roll Groove Specifications](#)

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, and the applicable building codes and related regulations 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.

Intellectual Property Rights

No statement contained herein concerning a possible or suggested use of any material, product, service, or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of Victaulic or any of its subsidiaries or affiliates covering such use or design, or as a recommendation for the use of such material, product, service, or design in the infringement of any patent or other intellectual property right. The terms "Patented" or "Patent Pending" refer to design or utility patents or patent applications for articles and/or methods of use in the United States and/or other countries.

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.

Trademarks

Victaulic and all other Victaulic marks are the trademarks or registered trademarks of Victaulic Company, and/or its affiliated entities, in the U.S. and/or other countries.