
VE268 Roll Grooving Tool



OGS
OGS-200
EndSeal™

PARTS ORDERING INFORMATION

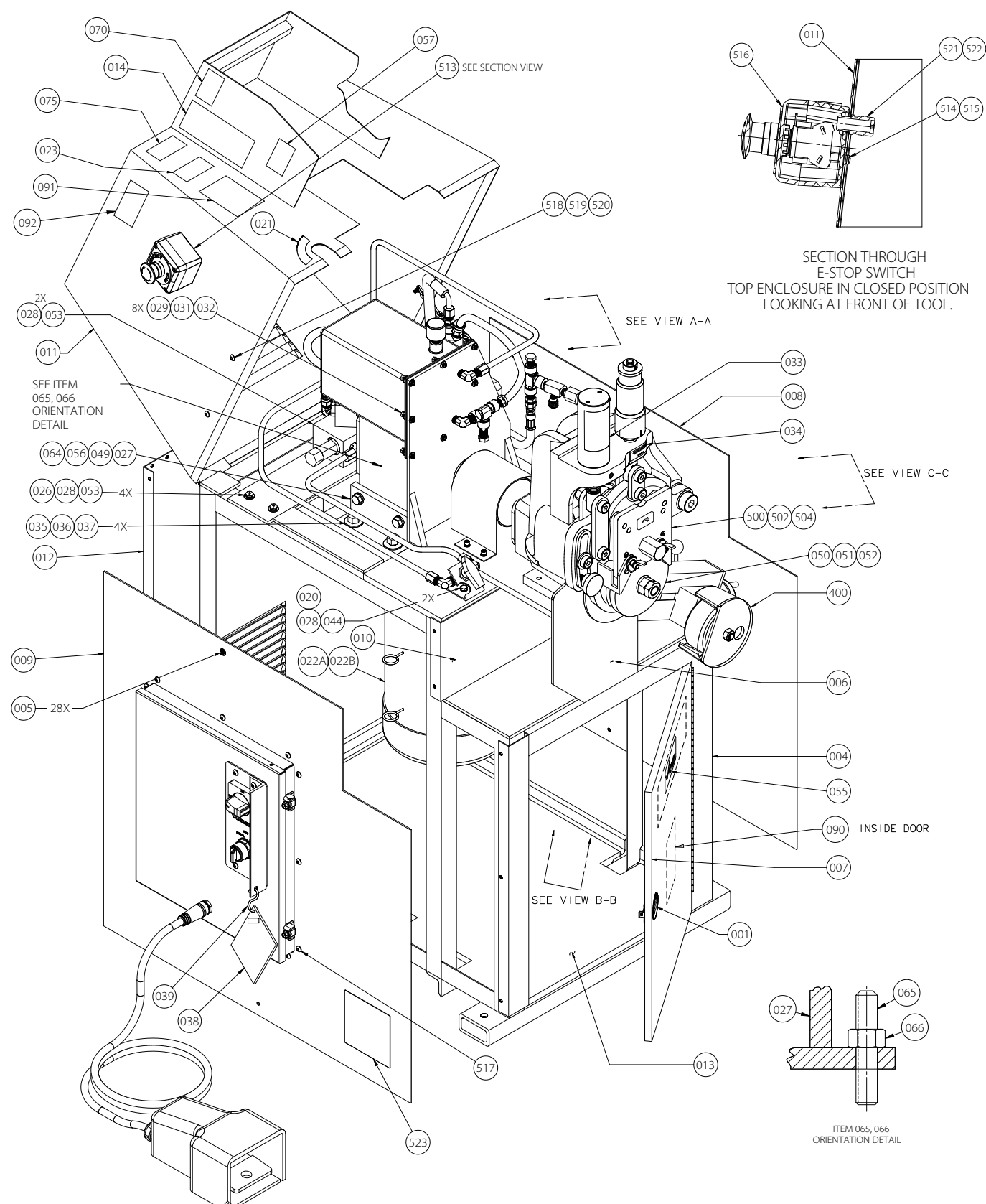
When ordering parts, the following information is necessary for Victaulic to process the order promptly:

1. Tool Model Number – VE268
2. Tool Serial Number – The Serial Number can be found on the side of the tool.
3. Quantity*, Item Number, Part Number, Description
4. Where to send the part(s) – Company Name and Address
5. To whose attention to send the part(s)
6. Purchase Order Number

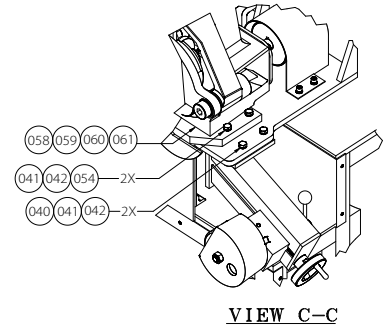
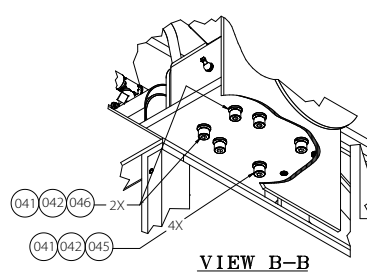
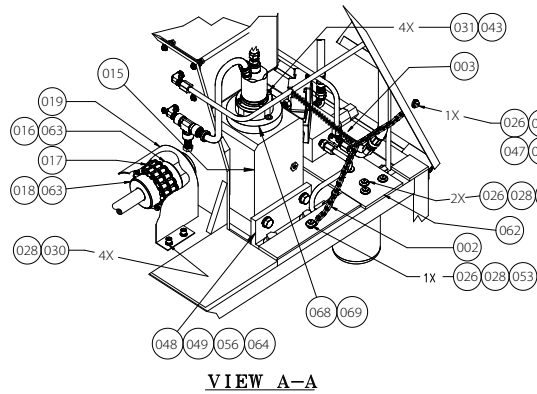
Parts may be ordered from your nearest Victaulic Sales Office.

* Quantity given in **Qty.** column indicates total number of pieces required per tool. Value of "A/R" indicates "As Required" which may differ based on usage and environment.

VE268 MAIN ASSEMBLY



VE268 MAIN ASSEMBLY (CONTINUED)



Item #	Part #	Qty.	Description
001	NM07000001	1	Latch
002	NM09000002	14"	Chain, Plated
003	NM03000003	1	Spring
004	R004274PNT	1	Frame
005	NS30012014	28	#12 - 24 x .88 Hvy. Duty Hex Washer Hd. Structural Self-Drilling and Tapping Screw
006	R006274PNT	1	Guard
007	R007274PNT	1	Front Door **
008	R008274PNT	1	Side Panel, RH
009	R009268PNT	1	Side Panel, LH **
010	R010274PNT	1	Front Panel
011	R011268PNT	1	Top Enclosure **
012	R012260PNT	1	Rear Enclosure
013	R013274PNT	1	Plywood Floor
014	R009424LBL	1	"C" Diameter Label #
015	R015274VE0	1	Gear Reducer Assembly
016	NM10000021	1	Chain Coupling ****
017	NM10000022	1	Chain
018	NM10000020	1	Chain Coupling
019	R012414PNT	1	Coupling Guard
020	R020274PNT	1	Ball Valve Mounting Bracket
021	R020260LBL	1	Pressure Setting Label #
022A	NE01000025	1	VE268 230/460V - Motor, 3 HP, 230/460V, 60 Hz, Three Phase
022B	NE01000030		VE268 380/415V - Motor, 3 HP, 190/380V, 50 Hz, Three Phase
023	R023268LBL	1	VE268 Series Label #
024	R024268LBL	1	Operating Specifications Label #
026	NW01040000	8	1/4" ID Flat Washer, Pltd.
027	R064274PNT	1	Left Gearbox Foot
028	NW03040000	20	1/4" ID Lock Washer, Split, Pltd.
029	NS06010010	8	#10 - 24 UNC x .63 Pan Head Cap Screw, Pltd.
030	NS03040008	4	1/4 - 20 UNC x .50 Lg. Socket Hd. Cap Screw, Blk. Ox.
031	NW03010000	12	#10 Lock Washer, Split, Pltd.
032	NN01010000	8	#10 - 24 UNC Hex Nut, Pltd.
033	R033274LBL	1	Roll Groove Warning Label #
034	R034272LAB	1	Decrease/Increase Groove Depth Label #
035	NS01080204	4	1/2 - 13 UNC x 2.25 Lg. Hex Hd. Cap Screw, Pltd.
036	NW01080000	4	1/2" ID Flat Washer, Pltd.
037	NN16080000	4	1/2 - 13 UNC Nylok Locking Hex Nut, Pltd.
038	NM07000005	1	S-Hook
039	R0392720FS	1	Guard Setting Pad Assembly
040	NS02060100	2	3/8 - 16 UNC x 1" Hex Hd. Cap Screw, Grd. 8, Pltd.
041	NW03060000	10	3/8" ID Split Lock Washer, Pltd.
042	NW01060000	10	3/8" ID Flat Washer, Pltd.
043	NS03010008	4	#10 - 24 UNC x .50 Socket Hd. Cap Screw, Blk. Ox.
044	NS01040008	2	1/4 - 20 UNC x .50 Lg. Hex Hd. Cap Screw, Blk. Ox.
045	NS03060200	4	3/8 - 16 UNC x 2.00 Socket Hd. Cap Screw, Blk. Ox.
046	NS03060104	2	3/8 - 16 UNC x 1.25 Socket Hd. Cap Screw, Blk. Ox.
047	NN01040000	5	1/4 - 20 UNC Hex Nut, Pltd.
048	R065274PNT	1	Right Gearbox Foot

Item #	Part #	Qty.	Description
049	NS02070104	4	7/16 - 14 UNC x 1 1/4" Lg. Hex Hd. Cap Screw, Pltd.
050	R902272L03	1	Lower Roll for 2 - 3 1/2" Steel Pipe
051	R904272L06	1	Lower Roll for 4 - 6" Steel Pipe
052	R908272L12	1	Lower Roll for 8 - 12" Steel Pipe
053	NS06040012	14	1/4 - 20 UNC x .75 Lg. Pan Hd. Phillips Screw, Pltd.
054	NS02060200	2	3/8 - 16 UNC x 2.00 Hex Hd. Cap Screw, Grd. 8, Pltd.
055	R055260LBL	1	Victaulic Logo Label #
056	NW01070000	4	7/16" ID Flat Washer, Pltd.
057	R010416LAB	1	Standard Wall Thickness Label #
058	-	A/R	Shim, .005 Thick
059	-	A/R	Shim, .007 Thick
060	-	A/R	Shim, .020 Thick
061	-	A/R	Shim, .040 Thick
062	R062274PNT	1	Manifold Mounting Plate
063	NK02004112	2	1/4 x 1.75" Lg. Square Key
064	NW03070000	4	7/16" ID Lock Washer, Pltd.
065	NS81060200	2	3/8 - 16 UNC x 2" Lg. Cup Pt. Set Screw, Blk. Ox.
066	NN01060000	2	3/8 - 16 UNC Hex Nut, Pltd.
068	R016274MCH	1	Gear Reducing Bearing Cover
069	NS02070104	4	7/16 - 14 UNC x 1 1/4" Lg. Hex Hd. Cap Screw, Pltd.
070	R070260VE0	1	"C" Diameter Reference Label for Copper #
075	R031272LAB	1	Instruction Warning Label #
090	R090424LAB	1	Electrical Danger Label #
091	R064268LBL	1	Tightening Direction Label #
092	R207264LBL	1	Groove Profile Information Label (Not Shown) #
190	R190272ASY	1	Arbor Assembly for 2 - 12" Pipe ***
400	R4002720FS	1	Stabilizer Assembly
502	R9A2272U06	1	Upper Roll Assembly for 2 - 6" Steel Pipe *
504	R9A8272U12	1	Upper Roll Assembly for 8 - 12" Steel Pipe *
505	R512260VE0	1	Lower Roll Removal Tool (Not Shown)
513	NE10000023	1	E-Stop Module *****
514	NW03000108	2	Lockwasher #8 *****
515	NS01008275	2	Socket Head Cap Screw 8 - 32 x 3/4" *****
516	NE10000024	2	E-Stop Legend Plate *****
517	NS02040012	15	Button Head Cap Screw 1/4 - 20 x 3/4" *****
518	NM16000038	3	Loop Clamp *****
519	NW03100002	3	Lockwasher 1/4" *****
520	NN01040000	3	Nut, 1/4 NPT *****
521	NM30000006	3	Cable Gland, 1/4 NPT, .120 - .390 Diameter *****
522	NH12004025	3	Locknut, 1/4 NPT *****
523A	R511921LBL	1	VE268 230/460V Specification Plate *****
523B	R511922LBL		VE268 380/415V Specification Plate *****
524	NN01008000	2	Nut, 8 - 32 *****

* Standard. Refer to pages 19 - 21 for optional upper roll cover/guard assemblies for grooving 3/4" - 1 1/2" pipe sizes and other pipe materials.

** Indicates additional items required or recommended when ordering.

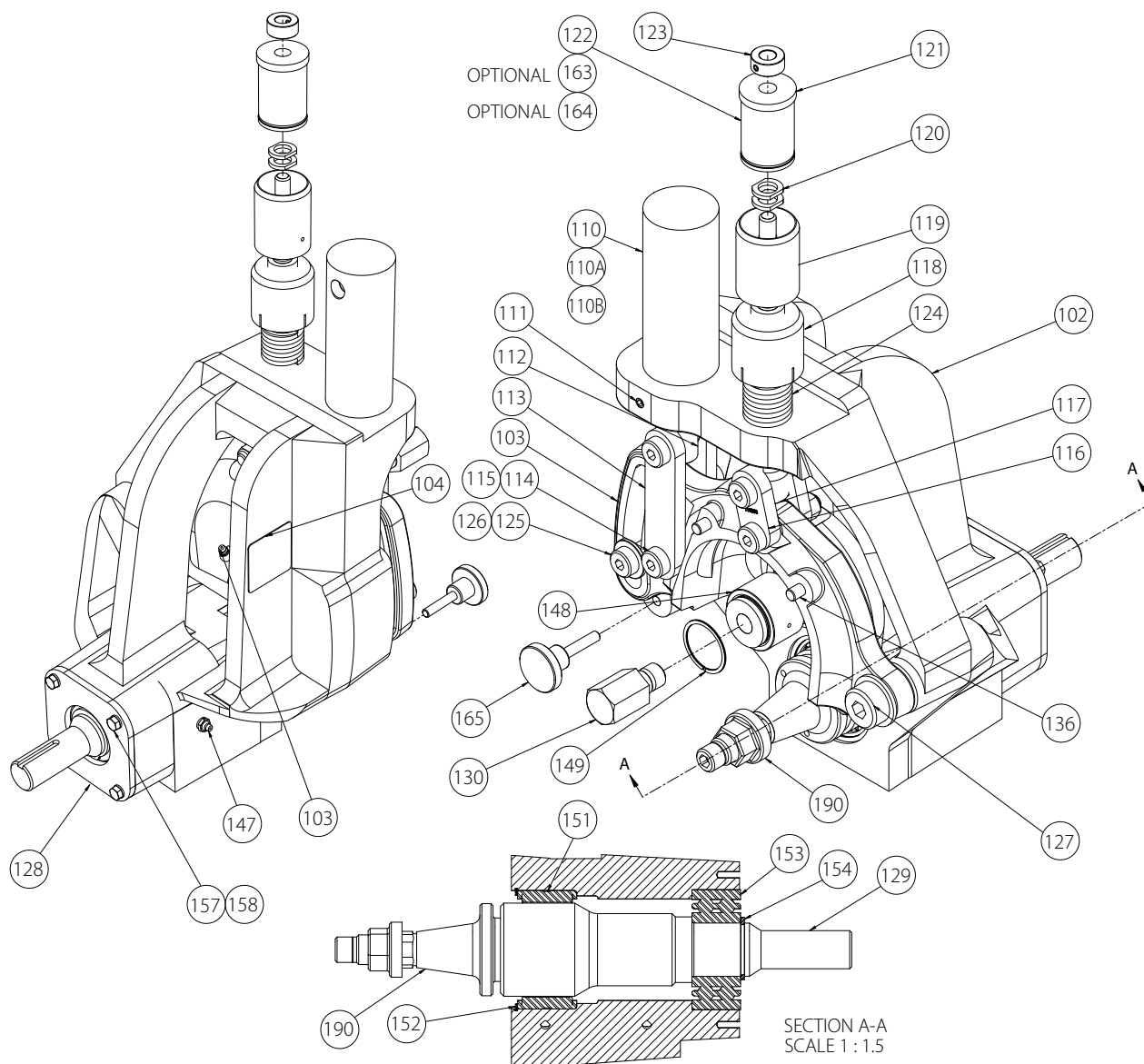
*** Standard, not shown. Refer to page 5 for optional arbor assemblies for grooving 3/4" and 1 - 1 1/2" pipe sizes.

**** Chain includes the master link, pin, and set cotter pin.

***** Updated design.

Refer to pages 22 - 24 for images of product labels.

VE268 TOOL HEAD ASSEMBLY



Item #	Part #	Qty.	Description
102	R0022720FS	1	Body **
103	R003268MCH	1	Arm **
104	R069272LAB	1	Name Plate
110	NH01000008	1	Hydraulic Cylinder PowerX C10-4 **
110A	NHYD000039	1	Cylinder Repair Kit PowerX C10-XX / PSK-C10 *
110B	NH50000001	1	Cylinder Repair Kit 300116 Power Team *
111	NS80060008	1	3/8 - 16 UNC x 1/2" Lg. Brass Tip Set Screw
112	R0122720FS	1	Cylinder Adapter
113	R0132720FS	2	Link, Cylinder to Arm
114	NS05100110	4	.625 x 1.63 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
115	NN08080000	4	1/2 - 13 UNC Heavy Hex Nylon Insert Locking Nut, Pltd.
116	R116268PLT	2	Link, Depth Adjuster to Arm
117	R0172720FS	1	Shaft, Depth Adjuster
118	R0182720FS	1	Depth Adjuster Lock
119	R0192720FS	1	Depth Adjuster
120	R0202720FS	2	Pipe Size Indicator Calibrator
121	R0212720FS	1	Pipe Size Indicator Barrel **
122	R122268LBL	1	Pipe Size Groove Depth Label #
123	NS95040000	1	Collar with Set Screw
124	NM03000015	1	Spring

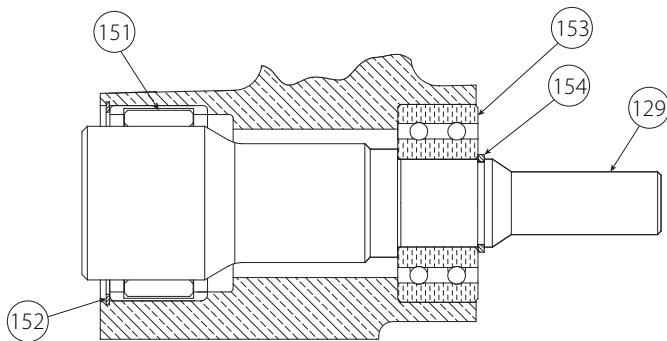
Item #	Part #	Qty.	Description
125	R0252720FS	1	Guide Washer
126	R019226MCH	1	5/8" x 1.00 Shoulder Screw
127	NS05160014	1	1.00 x .875 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
128	R0282720FS	1	Back Cover Plate
129	R129268MCH	1	Main Shaft
130	R0302720FS	1	Upper Roll Guard Cover Screw
136	NP11006100	2	.375 x 1.00 Lg. Type "H" Alloy Steel Groove Pin
147	NM01000002	1	1/8" NPT Straight Grease Fitting
148	NB04156002	1	Inner Race
149	NT03000017	1	Snap Ring
150	NM01000001	1	1/8" NPT 65° Grease Fitting
155	-	1	.75 ID SAE HighStrength Washer, Pltd.
156	-	1	3/4 - 10 UNC Nut, Grd. 5, Pltd.
157	-	4	1/4 - 20 UNC x .63 Lg. Hex Hd. Cap Screw, Pltd.
158	-	4	1/4" ID Helical Split Lock Washer, Pltd.
159	-	1	3/4 - 10 UNC Jam Nut, Pltd.
163	R163274LBL	1	Groove Depth Label for ISO65 and JIS Pipe#
164	R164274LBL	1	Groove Depth Label for DIN Pipe#
165	R110268ASY	1	Travel Stop Assembly

* Must confirm cylinder model number.

** Indicates additional items required or recommended when ordering.

Refer to pages 22 - 24 for images of product labels

VE268 MAIN SHAFT

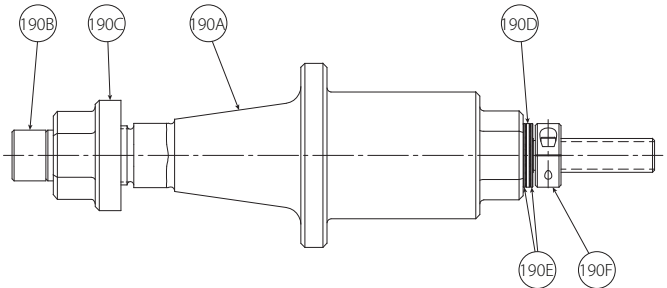


Item #	Part #	Qty.	Description
129	R129268MCH	1	Main Shaft
151	NB02275002	1	Needle Bearing
152	NT03000015	1	Snap Ring
153	NB01157002	1	40Mm ID x 90Mm OD x 36.5Mm Wide Double Row Ang. Contact Ball Bearing
154	NT03000017	1	Snap Ring

NOTICE

- Design "A" of the square drive arbor assembly for 2 - 12" pipe, shown below, supersedes Design "B".
- Components for Design "A" are not interchangeable with components of Designs "B" or "C".

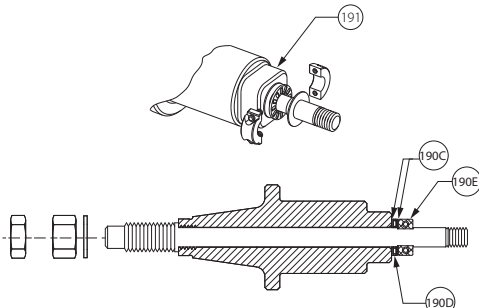
DESIGN "A" - SQUARE DRIVE ARBOR ASSEMBLY FOR 2 - 12" PIPE



Item #	Part #	Qty.	Description
190	R190272ASY	1	Arbor Assembly for 2 - 12" Pipe (Updated) *
190A	R195272MCH	1	Square Drive Tapered Roll Shaft for 2 - 12" Pipe
190B	R192272MCH	1	Retaining Stud, Tapered Roll Shaft
190C	R191272FNH	1	Lower Roll Nut
190D	NB03050001	1	.500 Bore Needle Thrust Bearing
190E	NB05050001	2	.500 Bore x 0.32 Thk. Thrust Washer
190F	NM13000002	1	Split Shaft Collar

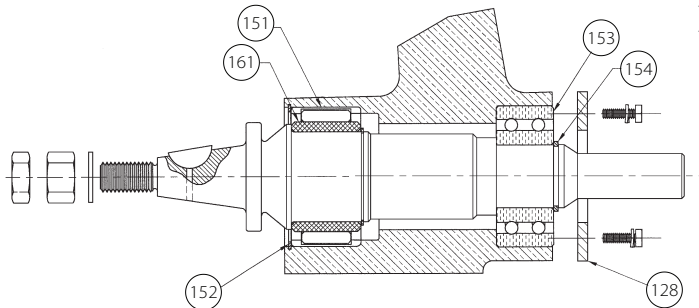
* Indicates additional items required or recommended when ordering.

DESIGN "B" - SQUARE DRIVE ARBOR ASSEMBLY FOR 2 - 12" PIPE **



** For reference only

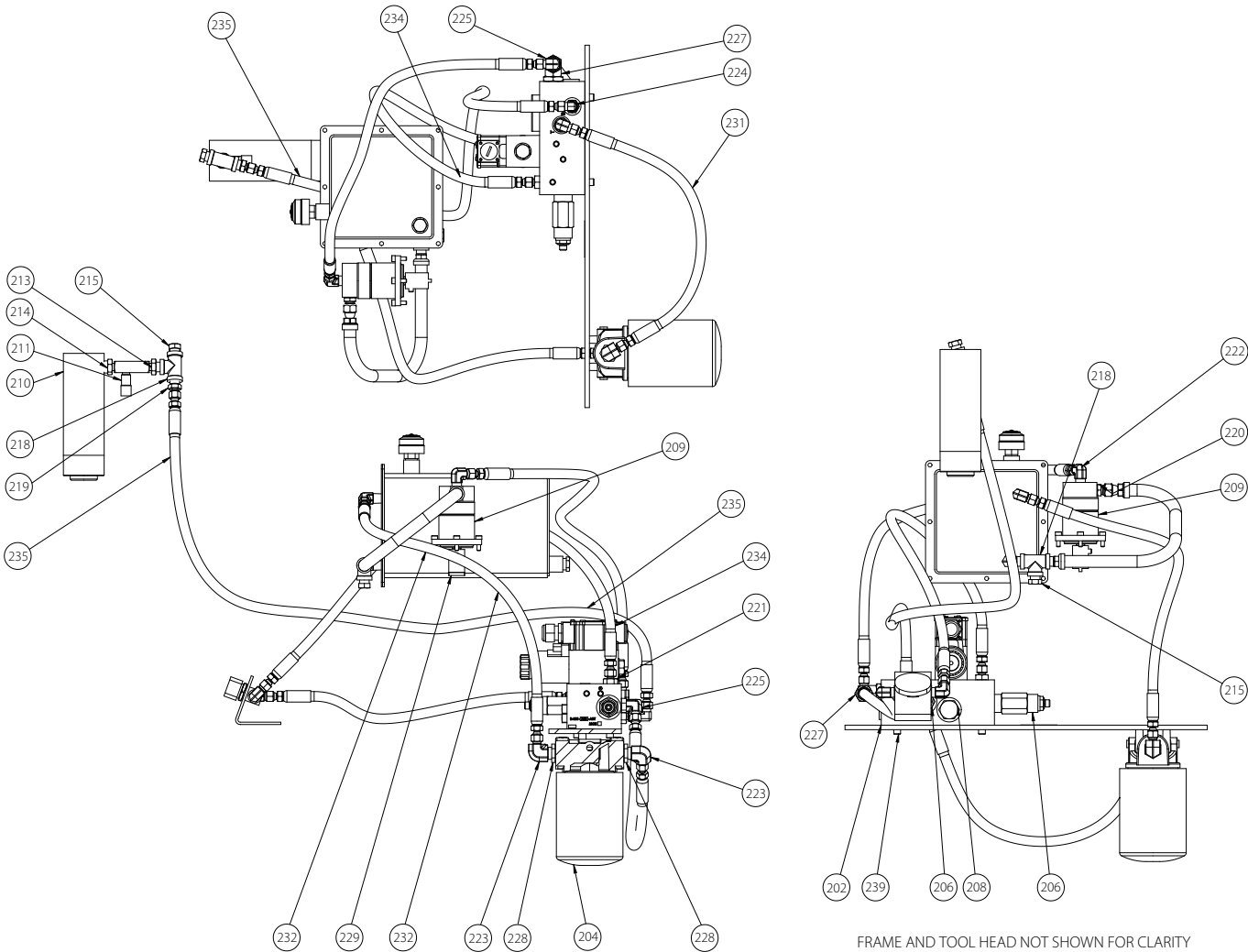
DESIGN "C" - KEY DRIVEN ARBOR ASSEMBLY FOR 2 - 12" PIPE ***



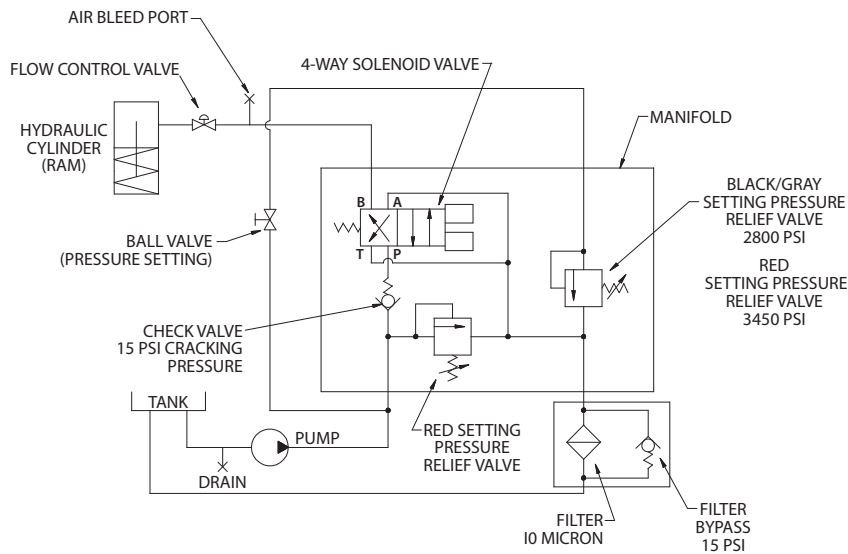
** For reference only. Contact Victaulic to verify application

*** Use part number R195268KIT and part number R129268MCH

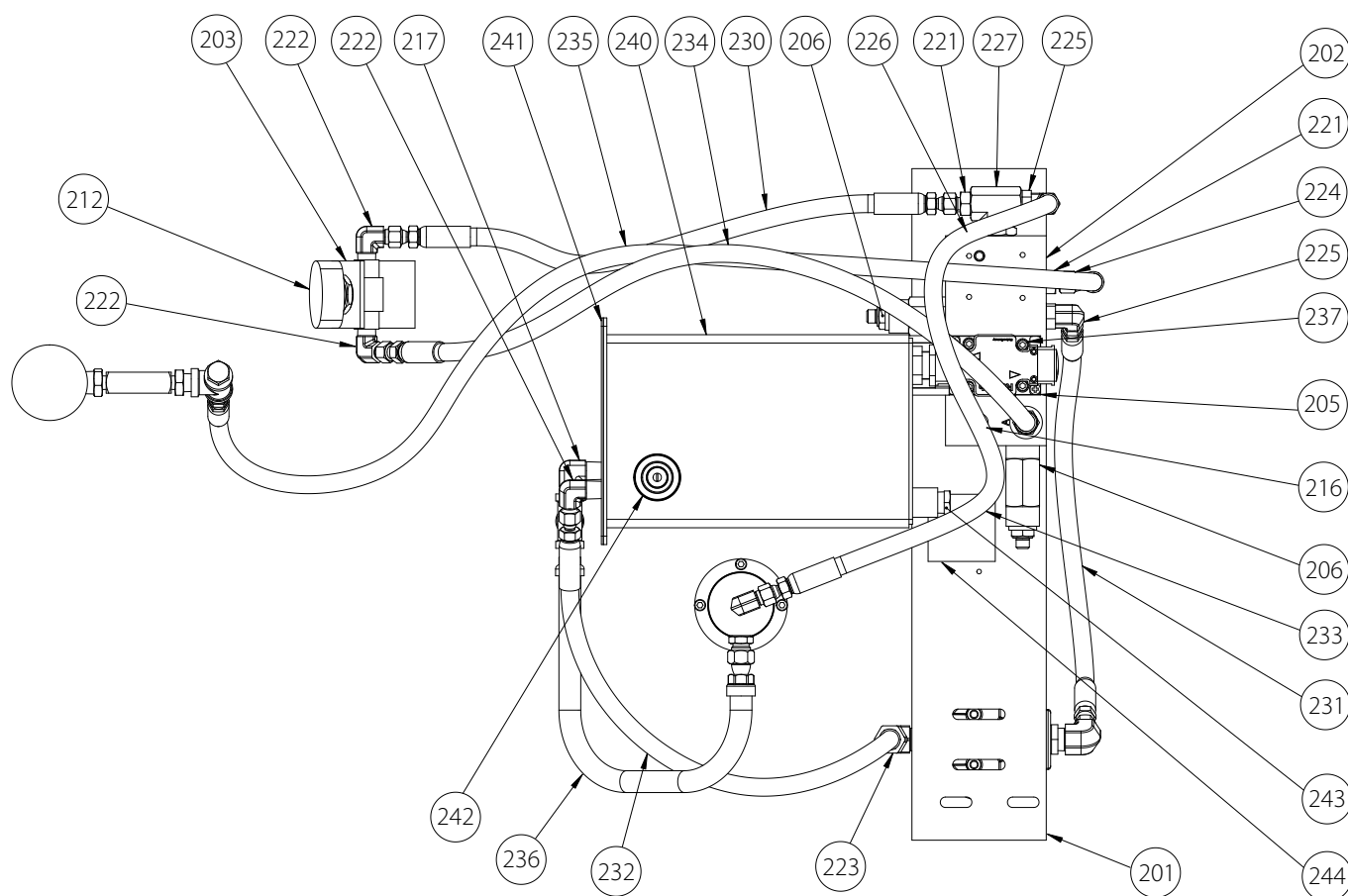
VE268 HYDRAULIC ASSEMBLY (UPDATED DESIGN)



VE268 HYDRAULIC SCHEMATIC (UPDATED DESIGN)



VE268 HYDRAULIC ASSEMBLY (UPDATED DESIGN) (CONTINUED)

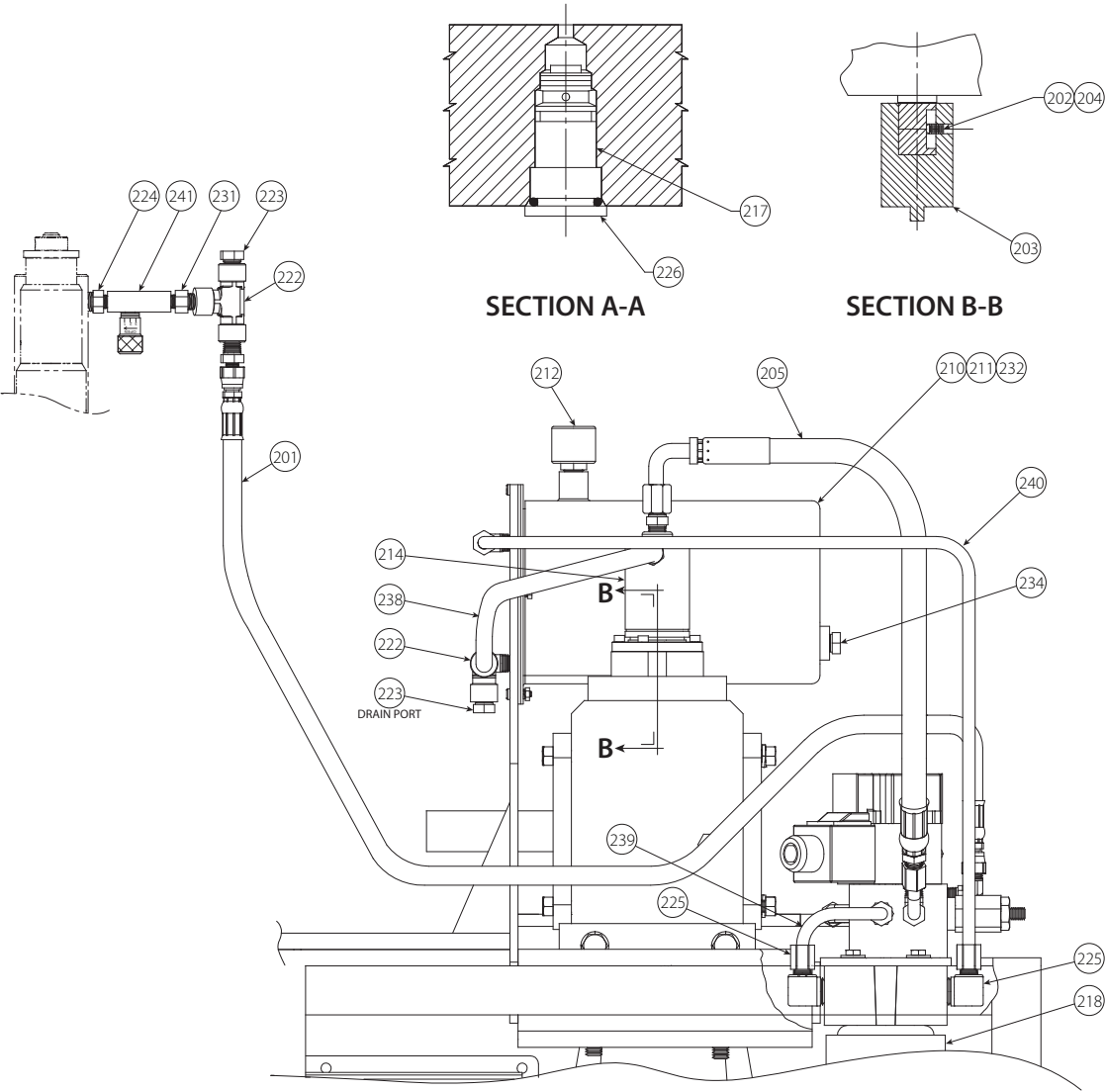


Item #	Part #	Qty.	Description
201	R063274PNT	1	Manifold Mounting Plate
202	R221268ASY	1	Hydraulic Manifold
203	R020274PNT	1	Ball Valve Mounting Bracket
204	NH08000003	1	Hydraulic Oil Filter
205	NH04000036	1	Control Valve **
206	NHYD000017	2	Cartridge Pressure Relief Valve
208	NHYD000029	1	Cartridge Check Valve
209	NH01000001	1	Hydraulic Pump
210	NH01000008	1	Hydraulic Cylinder PowerX C10-4
211	NHYD000031	1	Flow Control Valve
212	NH04000007	1	Ball Valve
213	NH11004010	1	Nipple, Hex Head, 1/4 NPT x 1/2 NPT x 1.260
214	NH11006006	1	Nipple, Hex Head, 3/8 NPT x 1/2 NPT x 1.260
215	NH16004001	2	Plug, Hex Head, 1/4 NPT Male
216	NHYD000019	1	Plug, Countersunk Head, 1/4 NPT Male
217	NH12004011	1	Elbow, Straight, 90 Degree, 1/4 NPT Male
218	NH14004001	2	Tee, Straight, 1/4 NPT Female
219	NH11004001	1	Male Connector, 3/16 - 20 SAE 37 Degree Flare Male x 1/4 NPT Male x 1.420
220	-	1	Male Connector, 3/16 - 18 SAE 37 Degree Flare Male x 1/4 NPT Male x 1.430
221	NHYD000014	3	Male Connector, 3/16 - 20 SAE 37 Degree Flare Male x 3/16-18 SAE Straight Male with O-Ring x 1.230
222	NH12004004	4	Elbow, 90 Degree Male, 3/16 - 20 SAE 37 Degree Flare Male x 1/4 NPT Male
223	-	2	Elbow, 90 Degree Male, 3/16 - 20 SAE 37 Degree Flare Male x 3/8 NPT Male
224	NHYD000020	1	Elbow, 90 Degree Swivel, 3/16 - 20 SAE 37 Degree Flare Female Swivel x 3/16 - 20 SAE 37 Degree Flare Male

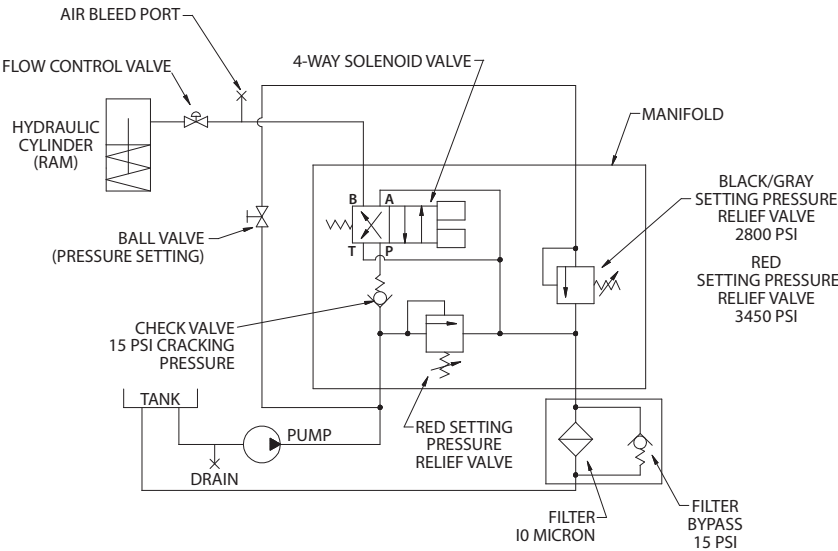
Item #	Part #	Qty.	Description
225	NH12004007	2	Elbow, 90 Degree Male, 3/16 - 20 SAE 37 Degree Flare Male x 3/16-18 SAE Straight Thread Male with O-Ring
226	NHYD000021	1	Plug, Hex Socket, Straight Thread O-Ring, 3/4 - 16
227	NHYD000022	1	Tee, Straight Thread Branch, 3/16 SAE Straight Female x 3/16 SAE Straight Female x 3/16 SAE Straight Male with O-Ring
228	NH11004030	2	Bushing, Hex Head, 1/2 NPT Male x 3/8 NPT Female
229	R003274MCH	1	Coupling, Pump Drive
230	NHYD000023	1	Hose Assembly
231	NHYD000023	1	Hose Assembly
232	NHYD000024	1	Hose Assembly
233	NHYD000024	1	Hose Assembly
234	NHYD000025	1	Hose Assembly
235	NHYD000025	1	Hose Assembly
236	R238274VEO	1	Hose Assembly
237	NS03010200	1	Screw, #10 - 24 x 2 x 3/8 Thread Hex Socket Head Cap
238	NS03040008	1	Screw, 1/4 - 20 x 1/2 Hex Socket Set, Half Dog Point
239	NS06040012	2	Screw, 1/4 - 20 x 3/4 Hex Socket Head Cap
240	R201260PNT	1	Hydraulic Reservoir
241	R232274GSK	1	Hydraulic Reservoir Gasket
242	NH07000001	1	Tank Breather
243	-	1	Plug, Hex Head, 3/8 NPT Male WEATHERHEAD #C3159X6
244	R115715LBL	1	Hot Surface Label

** Item 205 on 220/440 Volt, 3-Phase tool to be BOSCH-REXROTH#4WE6Y6X/EG24N9DL.

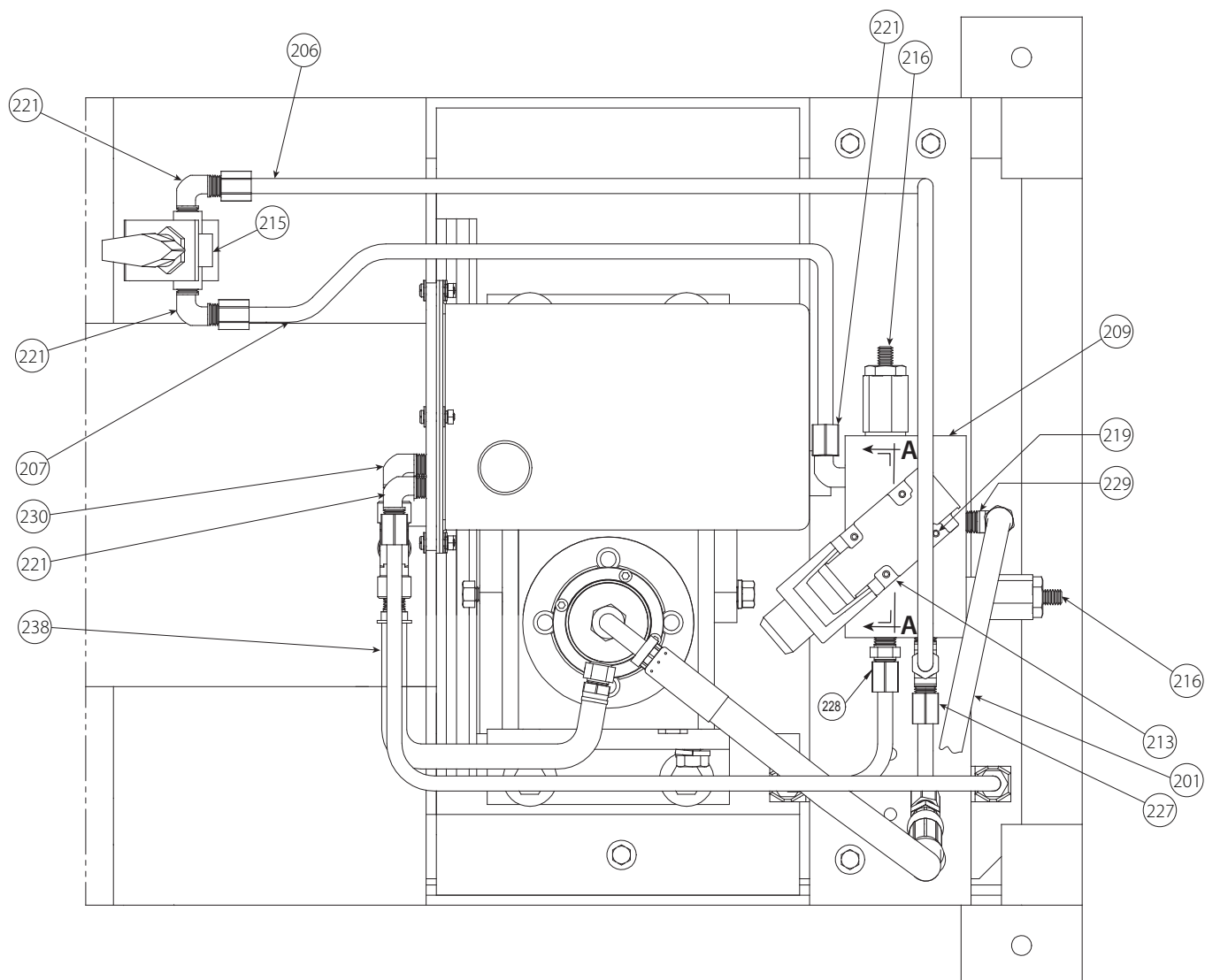
VE268 HYDRAULIC ASSEMBLY (ORIGINAL DESIGN)



VE268 HYDRAULIC SCHEMATIC (ORIGINAL DESIGN)



VE268 HYDRAULIC ASSEMBLY (ORIGINAL DESIGN) (CONTINUED)



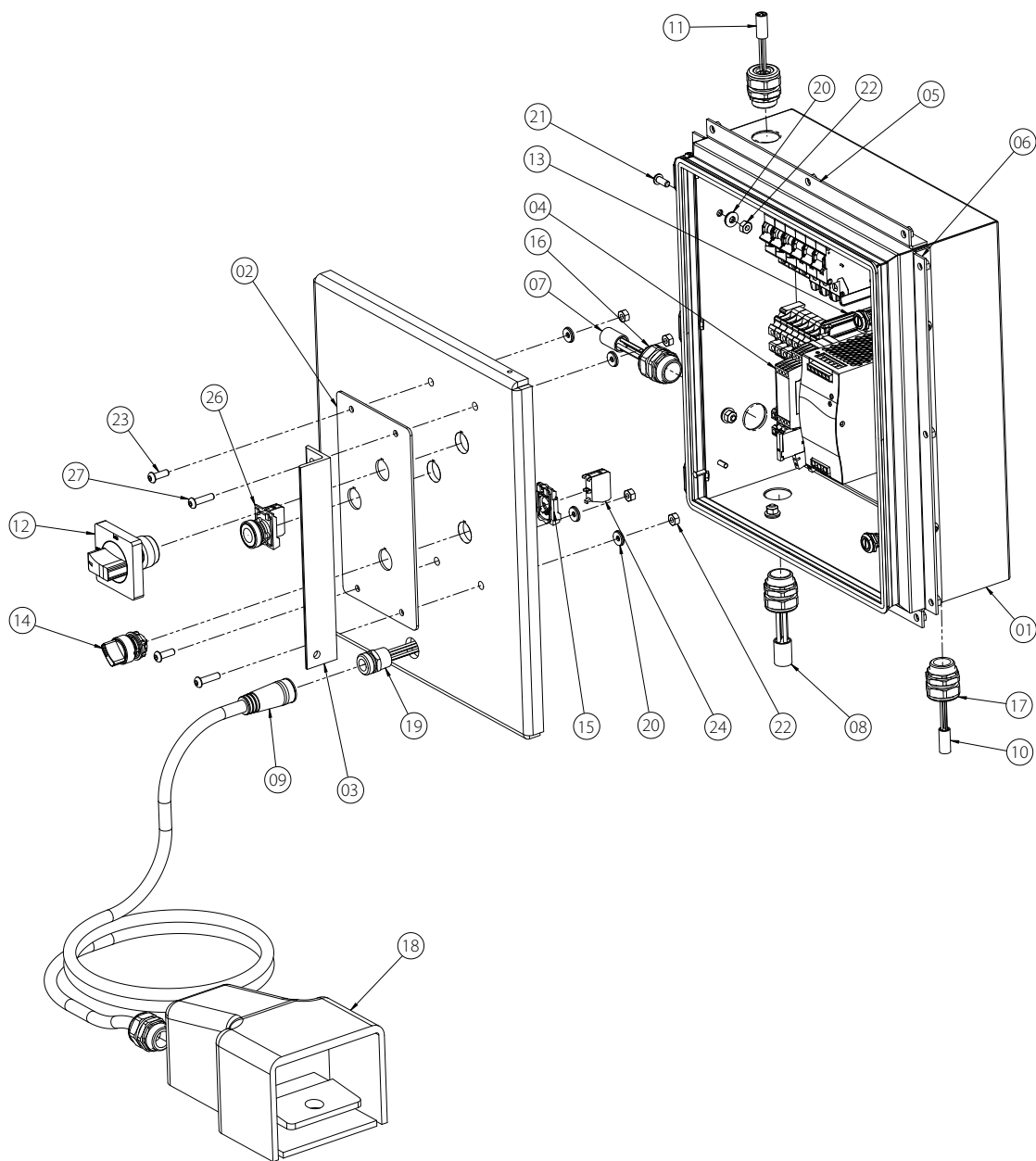
Item #	Part #	Qty.	Description
201	R201274VE0	1	Hose Assembly, Manifold-Cylinder
202	-	A/R	Loctite #271
203	R003274MCH	1	Pump Drive Coupling
204	NS90040008	1	¼ - 20 UNC x ½" Lg. Dog Point Set Screw
205	R205274VE0	1	Hose Assembly, PumpManifold *
206	R206274VE0	1	Tubing Detail, Manifold-Ball Valve
207	R207274VE0	1	Tubing Detail, Ball ValveManifold
209	R209274MCH	1	Manifold
210	R201260PNT	1	Tank
211	-	6 Qt.	ISO 32 Hydraulic Oil, or Equivalent
212	NH07000001	1	Breather
213	NH04000004	1	see note **
214	NH01000001	1	Pump
215	NH04000007	1	Ball Valve
216	NH04000030	2	Relief Valve
217	NH04000003	1	Check Valve
218	NH08000003	1	Hydraulic Oil Filter
219	NS03010200	4	#10 - 24 UNC x 2" Lg. Socket Hd. Cap Screw
221	NH12006002	4	90° Elbow
222	NH14004001	2	¼" Female Branch Tee

Item #	Part #	Qty.	Description
223	NH16004001	2	¼" Hex Head Plug
224	NH11006006	1	Reducing Hex Nipple
225	NH12006003	2	90° Elbow
226	NH16010001	1	Plug
227	NH14006002	1	Male Run Tee
228	NH11006001	1	Connector
229	NH12004002	1	90° Elbow
230	NH12004011	1	Male Elbow
231	NH11004010	1	Reducing Hex Nipple
232	R232274GSK	1	Hydraulic Reservoir Gasket
233	-	A/R	Permacel P-412 Ribbon Dope or Equivalent
234	NH16006001	1	Hex Head Plug
238	R238274VE0	1	Hose Assembly, Tank-Pump Inlet
239	R239274VE0	1	Tubing Detail, Manifold-Filter
240	R240274VE0	1	Tubing Detail, Filter-Tank
241	NH04000012	1	Flow Control Valve

* When purchasing item 205, also purchase item 227 (Male Run Tee)

** Item 213 on 220/440 Volt, 3-Phase tool to be Vickers #DG4V-32A-W-B-10 or Rexroth #4WE6-D51/W120-60 ND.

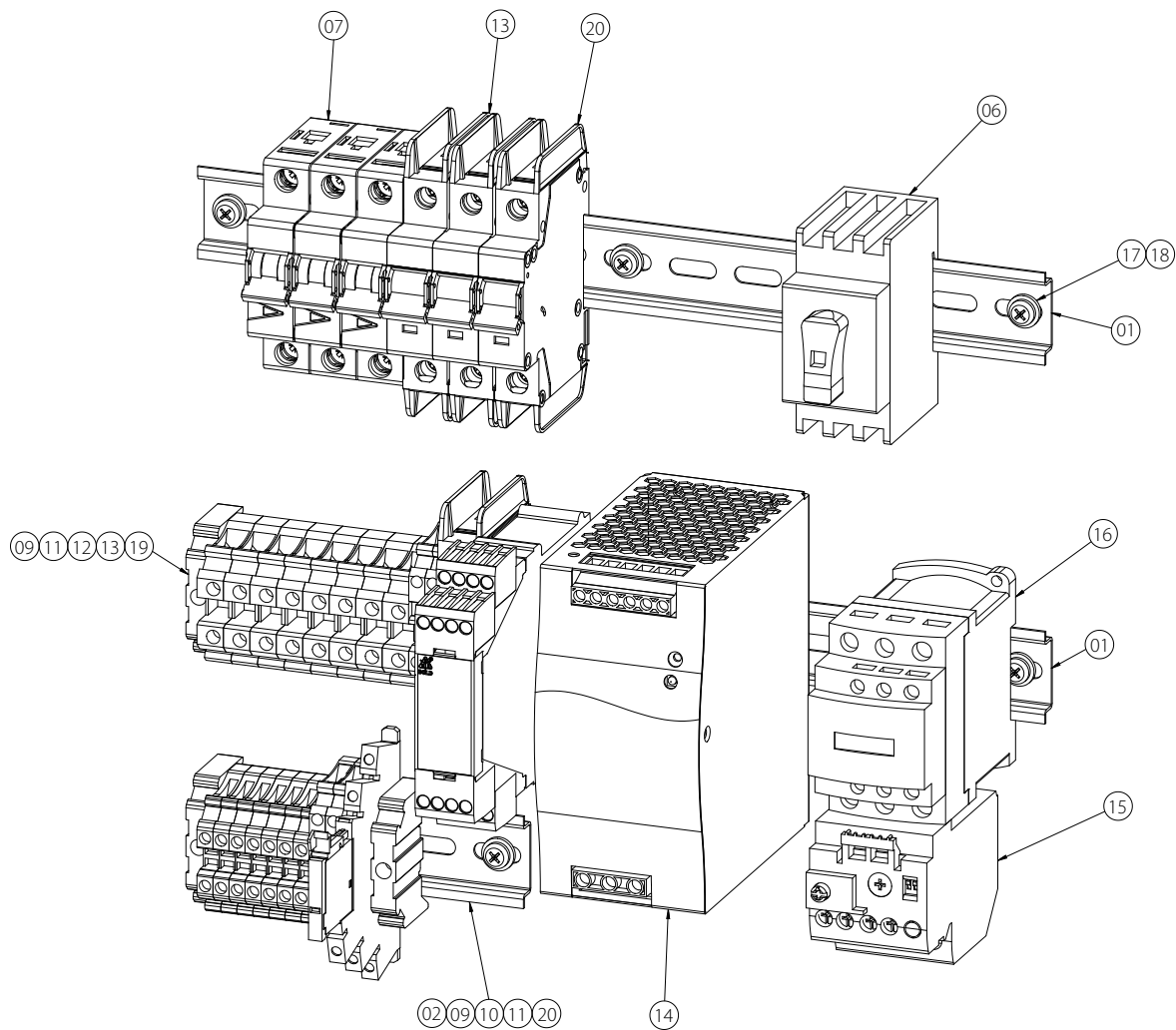
VE268 ELECTRICAL ASSEMBLY (UPDATED DESIGN)



Item #	Part #	Qty.	Description
01	—	1	Electrical Enclosure, 3 Phase
02	R011920LBL	1	Label, Electrical Panel
03	—	1	Switch Guard
04	—	1	Enclosure Panel Assembly
05	—	2	Mount Angle Short, Weldment
06	—	2	Mount Angle Long, Weldment
07	R310268SCH	1	Cable Assembly, External, Control Panel Bulkhead to Main Power Outlet
08	R311268SCH	1	Cable Assembly, External, Control Panel to Motor Terminal Block
09	R312268SCH	1	Cable Subassembly, External, Bulkhead Connector to Foot Switch
10	R313268SCH	1	Cable Assembly, External, Control Panel to Solenoid Valve
11	R314268SCH	1	Cable Assembly, External, Control Panel to Emergency Stop Switch
12	NELC000054	1	Handle, Operator, Mechanical Interlock

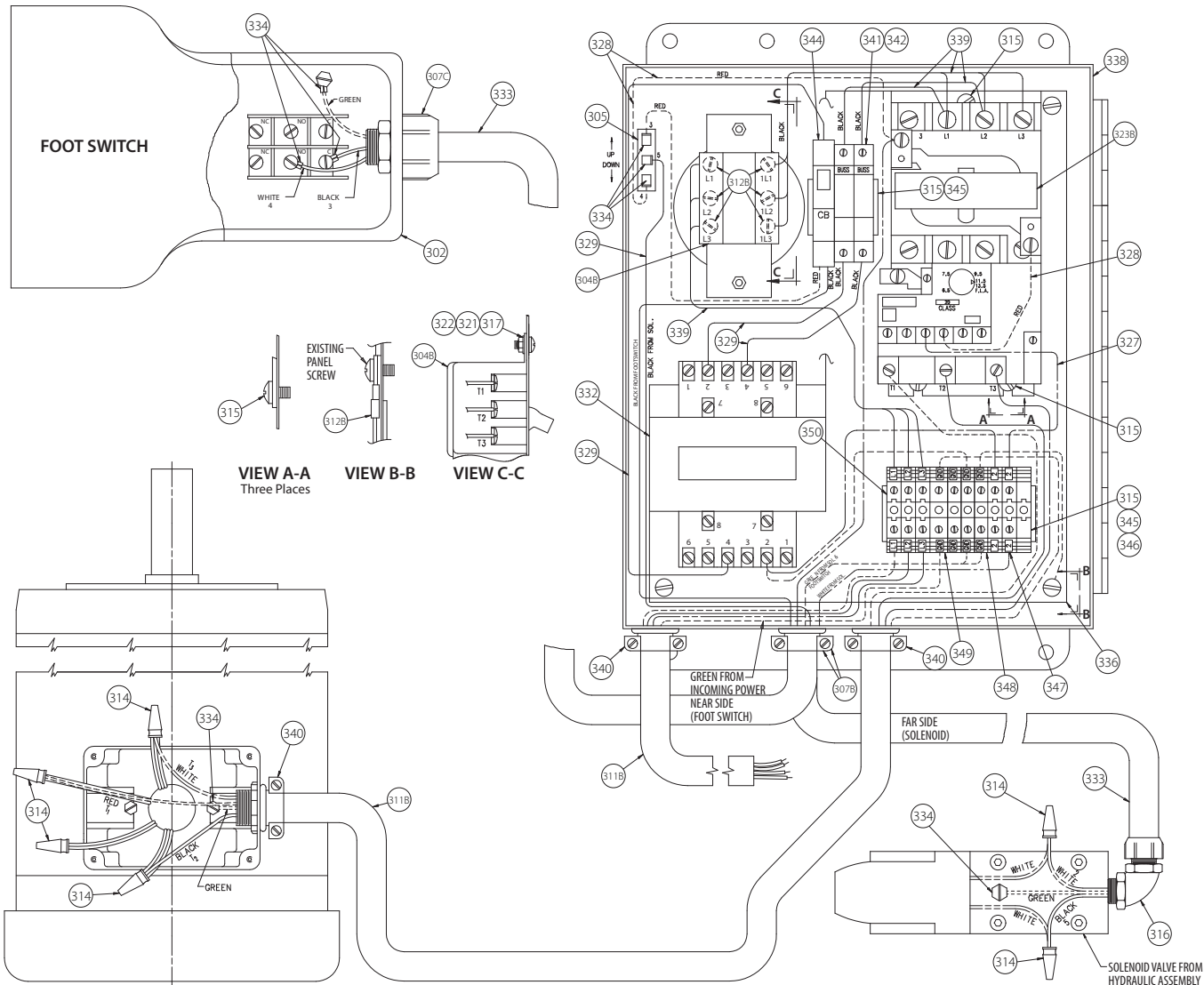
Item #	Part #	Qty.	Description
13	NELC000055	1	Disconnect Shaft
14	NELC000056	1	Switch, Selector
15	NELC000057	1	Adapter, Body Fixing Collar
16	NE01G51031	2	Connector, Cable Gland, 0.5100.710 Diameter
17	NE01G51032	3	Connector, Cable Gland, 0.3500.630 Diameter
18	NELC000004	1	Foot Switch, Single Stage, Cable Sub-assembly not included
19	NELC000058	1	Cable, Female Receptacle
20	NELC000059	10	Sealing Washer
21	NS10040380	8	¼ - 20 x ¾" Hex Socket Button Head Cap Screw
22	NN01040000	10	¼ - 20 Hex Nut
23	NS02040012	2	¼ - 20 x ¾" Hex Socket Button Head Cap Screw
24	NELC000061	1	Contact Block, Included with Item 24
26	NELC000060	1	Switch, Complete Assembly, Push Button, Green
27	NS10040001	2	¼ - 20 x 1" Button Head Cap Screw

VE268 ELECTRICAL ASSEMBLY (UPDATED DESIGN) (CONTINUED)



Item #	Part #	Qty.	Description
06	NELC000062	1	Disconnect, 3Pole, 1000VAC, 32 AMP
07	NELC000063	1	Circuit Breaker, 3Pole, 277/480 VAC, 20 AMP
13	NELC000064	2	Circuit Breaker, Single Pole, 277/480 VAC, 10 AMP
14	NELC000065	1	Power Supply
15	NELC000066	1	Thermal Overload
16	NELC000067	1	Contactor, 3Pole, 3 No, 440VAC, 18 AMP, 24V DC Coil
19	NELC000068	1	Module, Emergency Stop, 3 No Contacts, 24V DC
20	NELC000069	1	Relay, Power, SPDT, 24 VDC
21	NELC000070	1	Circuit Breaker, 2Pole, 277/480 VAC, 15 AMP

VE268 230/460V ELECTRICAL ASSEMBLY (ORIGINAL DESIGN)

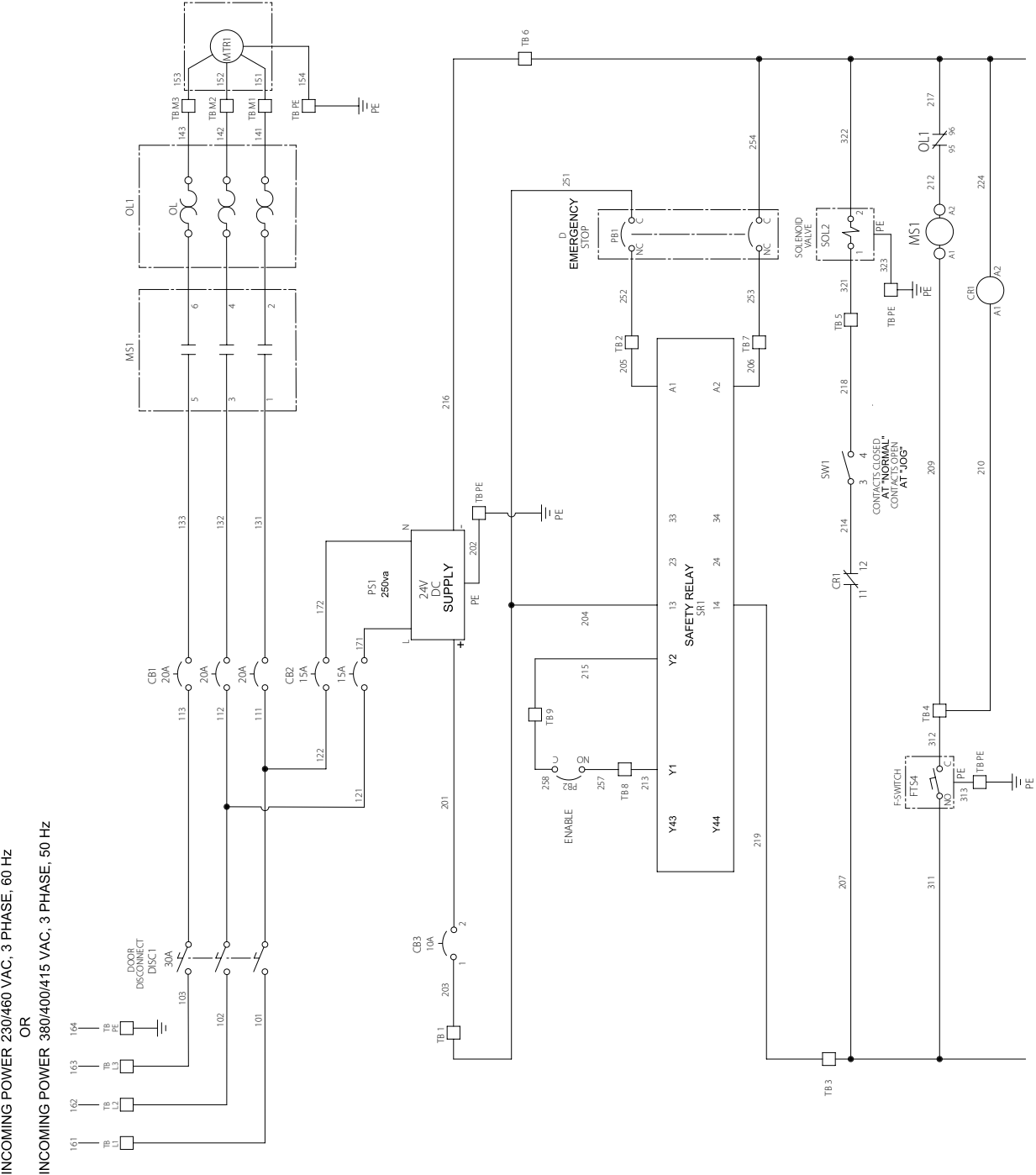


Item #	Part #	Qty.	Description
302	NE03000003	1	Footswitch (Cord and strain relief not included)
304B	-	1	Switch
305	-	1	Switch
307B	-	2	Connector
307C	NE06000002	1	Connector
311B	-	11 1/2	Line Cord
312B	-	13	Ring Terminal
314	-	6	Wire Nut
315	-	11	#8 - 32 UNC x .50 Lg. Binding Head Slot Screw
316	-	1	Connector
317	-	2	#6 - 32 UNC x .38 Lg. Pan Head Slot Screw
321	-	2	#6 Standard Flat Washer, Pltd.
322	-	2	#6 - 32 UNC Hex Nut, Pltd.
323B	-	1	Magnetic Starter
327	-	A/R	MTW 16 Gauge White
328	-	A/R	MTW 16 Gauge Red
329	-	A/R	MTW 16 Gauge Black

Item #	Part #	Qty.	Description
330	-	A/R	MTW 16 Gauge Green
332	-	1	Transformer
333	NE04000011	12 1/2 ft.	Line Cord
334	-	15	Ring Terminal
336	-	Ref.	Main Enclosure Panel
338	R338274VE0	Ref.	Electrical Box (Reference VE268 Main Assembly)
339	-	A/R	MTW 12 Gauge Black
340	-	3	Connector
341	-	2	Fuse, Primary
342	-	1	Fuse Holder, Primary
344	-	1	Circuit Breaker
345	-	A/R	DIN Rail
346	-	2	Terminal Block
347	-	2	Terminal Block
348	-	3	Terminal Block
349	-	1	Terminal Block
350	-	3	Terminal Block

VE268 ELECTRICAL DIAGRAM (UPDATED DESIGN)

- NOTES:
VE268:
1. INCOMING POWER REQUIREMENTS:
230VAC 60HZ 11.5 AMPS
460VAC 60HZ 18.5 AMPS
380VAC 50HZ 10.6 AMPS
400VAC 50HZ 10.1 AMPS
415VAC 50HZ 9.7 AMPS
 2. SET MOTOR OVERLOAD TO:
230VAC 60HZ 11.0 AMPS
460VAC 60HZ 5.5 AMPS
380VAC 50HZ 10.0 AMPS
400VAC 50HZ 9.5 AMPS
415VAC 50HZ 9.2 AMPS
 3. MOTOR FULL LOAD AMPS:
230VAC 60HZ 8.8 AMPS
460VAC 60HZ 4.4 AMPS
380VAC 50HZ 8.0 AMPS
400VAC 50HZ 7.6 AMPS
415VAC 50HZ 7.4 AMPS
 4. INCOMING POWER MUST BE SHORT CIRCUIT PROTECTED BY BREAKER OR FUSE.
 5. WIRE MOTOR TO PROVIDE CLOCKWISE ROTATION OF THE TOOL'S LOWER ROLL.
 6. LABEL ALL WIRES, CABLES, COMPONENTS AND TERMINAL BLOCKS.
 7. CONNECTION TO MAIN POWER SUPPLIED BY CUSTOMER.



VE268 230/460V ELECTRICAL DIAGRAM (ORIGINAL DESIGN)

	F.L.A. OVERLOAD	CLASS	PHASE IMBALANCE
230V	11.5 AMPS	20	*
460V	6.5 AMPS	20	*

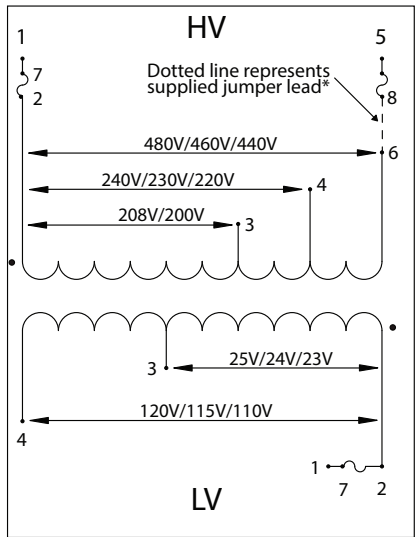
INCOMING POWER REQUIREMENTS

230 OR 460 VOLT 3 PHASE 60 HZ
8.8 AMP FULL LOAD AT 230V
4.4 AMP FULL LOAD AT 460V

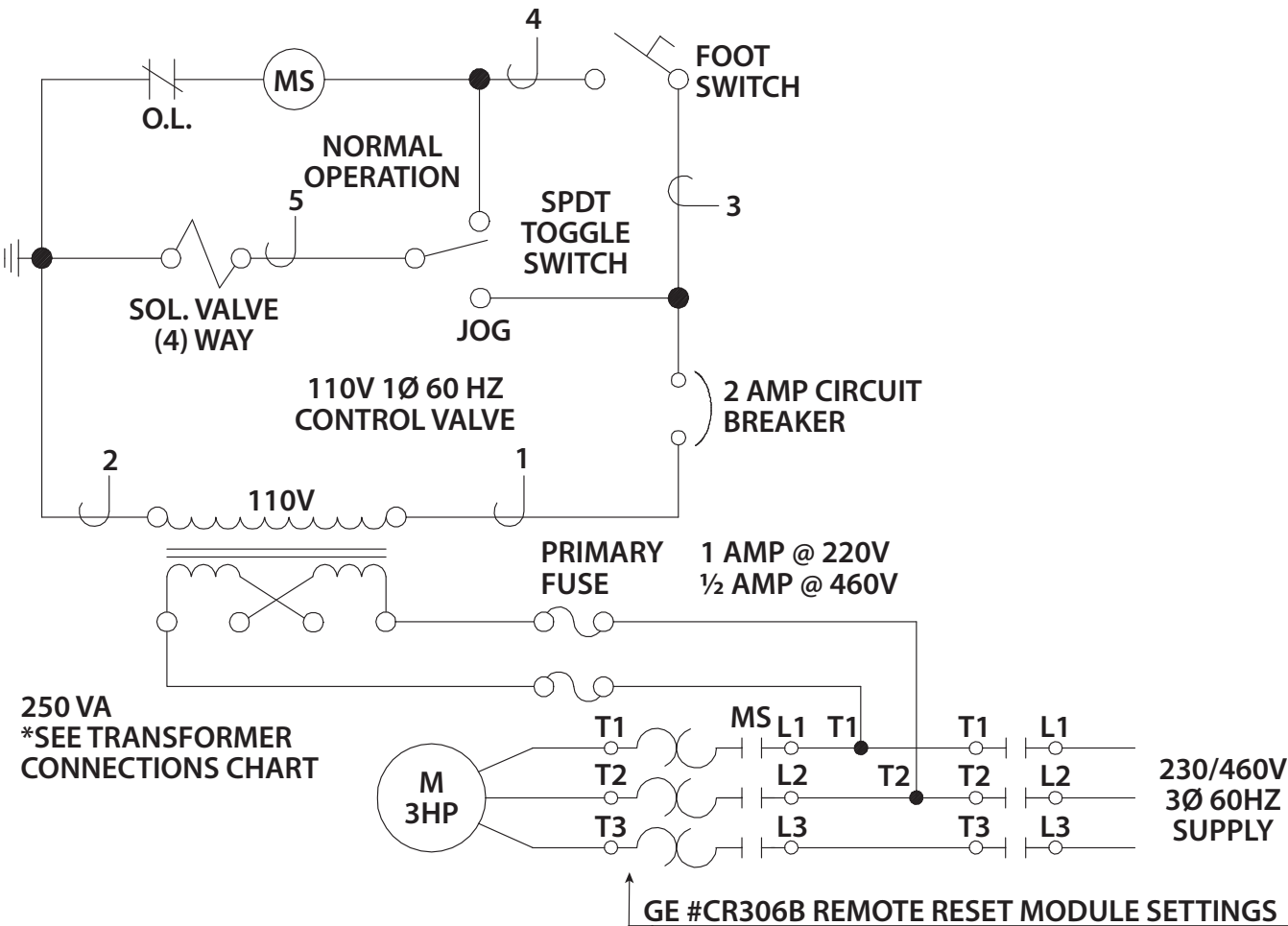
INCOMING POWER MUST BE SHORT
CIRCUIT PROTECTED BY BREAKER OR
FUSE.

* #CR306B MOTOR STARTER FEATURES
FIXED PHASE IMBALANCE PROTECTION

TRANSFORMER CONNECTIONS



* This primary fuse jumper is supplied with the
primary fuse kit only.
** Change primary HV Taps only as required.



VE268 380V ELECTRICAL DIAGRAM (ORIGINAL DESIGN)

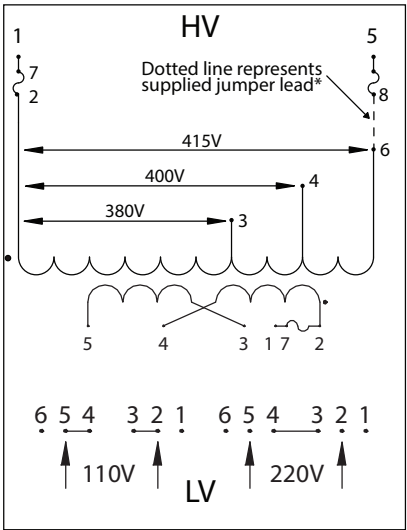
	F.L.A. OVERLOAD	CLASS	PHASE IMBALANCE
380V	6.5 AMPS	20	20

INCOMING POWER REQUIREMENTS

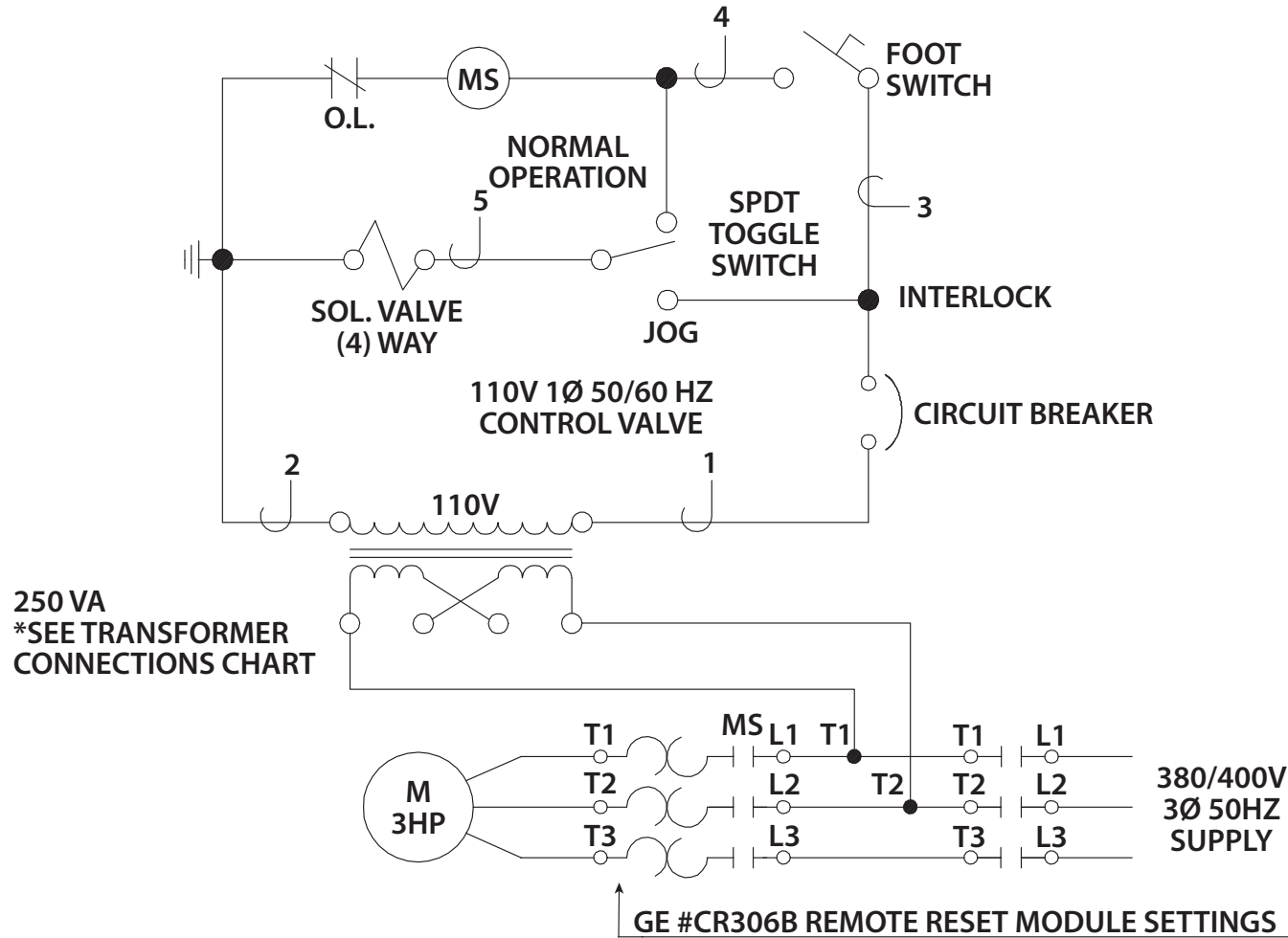
380 VOLT 3 PHASE 50 HZ
6.5 AMP FULL LOAD AT 380V
5.7 AMP (1.15 S.F.) 380V AT 50HZ

INCOMING POWER MUST BE SHORT
CIRCUIT PROTECTED BY BREAKER
OR FUSE.

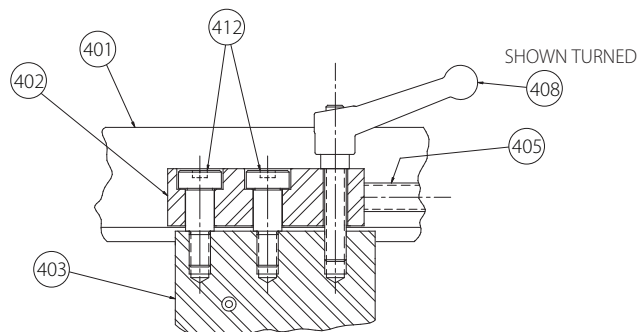
TRANSFORMER CONNECTIONS



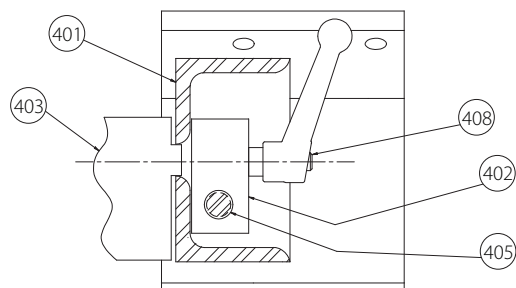
* This primary fuse jumper is supplied with the primary fuse kit only.
** Change primary HV Taps only as required.



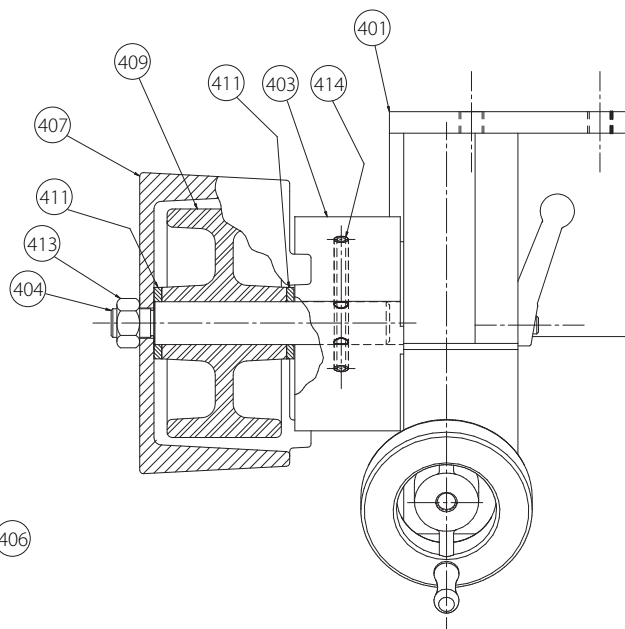
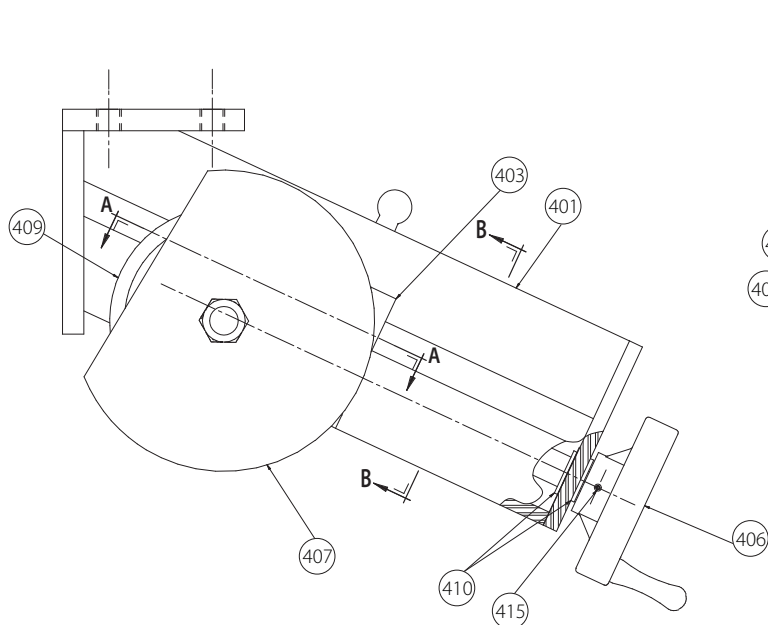
VE268 STABILIZER ASSEMBLY (R4002720FS)



SECTION A-A



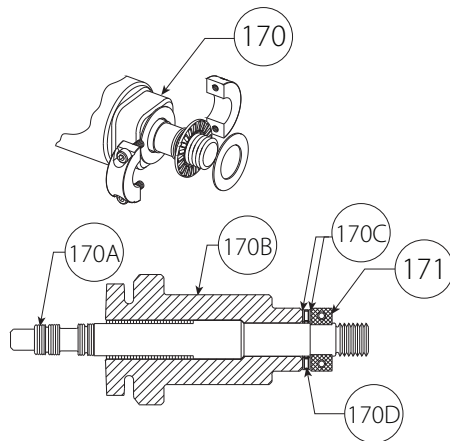
SECTION B-B



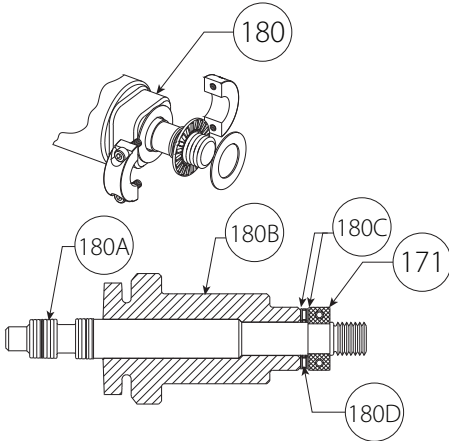
Item #	Part #	Qty.	Description
400	R4002720FS	1	Stabilizer Assembly, (includes items 401-415)
401	R4012720FS	1	Stabilizer Body
402	R402416PLT	1	Stabilizer Guide Nut
403	R403416PLT	1	Stabilizer Guide
404	R404416MAC	1	Stabilizer Wheel Shaft
405	R4052720FS	1	Stabilizer Adjustment Screw
406	R406416MAC	1	Stabilizer Handwheel
407	R407416PNT	1	Stabilizer Wheel Guard

Item #	Part #	Qty.	Description
408	NM04000002	1	Stabilizer Locking Handle w/ Stud
409	NM05000004	1	4" x 2" Polyurethane Wheel
410	NB05037002	2	Thrust Washer
411	NB05075004	2	Thrust Washer
412	NS05080012	2	½" Dia. x .75" Lg. Socket Hd. Shoulder Bolt, Blk. Ox.
413	NN02080000	1	½" - 20 UNF Hex Nut, Pltd.
414	NP01004208	1	¼" x 2.5" Lg. Roll Pin
415	NP01002102	1	⅛" x 1.125" Lg. Roll Pin

OPTIONAL VE268 ARBOR ASSEMBLIES



Arbor Assembly for 3/4" Pipe
(Item 170)



Arbor Assembly for 1 - 1 1/2" Pipe
(Item 180)

Shaft Collar Assembly
(Item 171)

ARBOR ASSEMBLY FOR 1 - 1 1/2" PIPE

Item #	Part #	Qty.	Description
180	R901268LA2	1	Arbor Assembly for 1 - 1 1/2" Pipe **
180A	R901268L02	1	Lower Roll for 1 - 1 1/2" Pipe
180B	R900268A02	1	Lower Roll Adapter
180C	NM30000005	2	0.031 Thk. x 0.750 Bore Special Flat Washer
180D	NB03750001	1	0.750 Bore Needle Thrust Bearing

ARBOR ASSEMBLY FOR 3/4" PIPE

Item #	Part #	Qty.	Description
170	R900268LA1	1	Arbor Assembly for 3/4" Pipe **
170A	R975268L75	1	Lower Roll for 3/4" Pipe
170B	R900268A02	1	Lower Roll Adapter
170C	NM30000005	2	0.031 Thk. x 0.750 Bore Special Flat Washer
170D	NB03750001	1	0.750 Bore Needle Thrust Bearing

ARBOR ASSEMBLIES FOR STAINLESS STEEL

Item #	Part #	Qty.	Description
-	RX00268LA1	1	Arbor Assembly for 3/4" Pipe **
-	RX01268LA2	1	Arbor Assembly for 1 - 1 1/2" Pipe **
-	RX75268L75	1	Lower Roll for 3/4" Stainless Steel Pipe
-	RX01268L02	1	Lower Roll for 1 - 1 1/2" Stainless Steel Pipe

SHAFT COLLAR ASSEMBLY

Item #	Part #	Qty.	Description
171	R173268ASY	1	Shaft Collar Assembly **
171A	R171268MCH	1	Shaft Collar - Top *
171B	R172268MCH	1	Shaft Collar - Bottom *
171C	NS03006006	2	#6-32 UNC x 3/8" Lg. SHCS, Blk. Ox. *

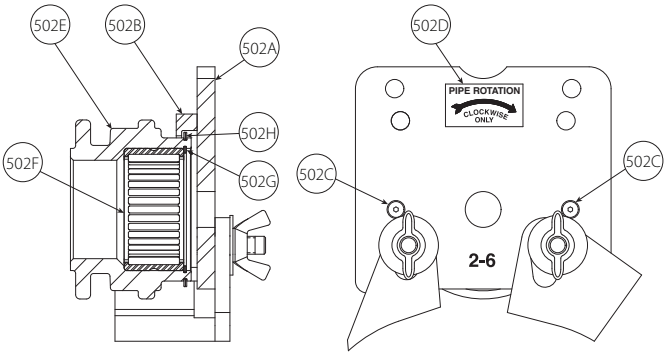
* Included in assembly. Not available for individual sale.
** Indicates additional items required or recommended when ordering.

STANDARD VE268 UPPER ROLL COVER/GUARD ASSEMBLIES

VE268 UPPER ROLL ASSEMBLY FOR 2 - 6" STEEL PIPE (ITEM 502)

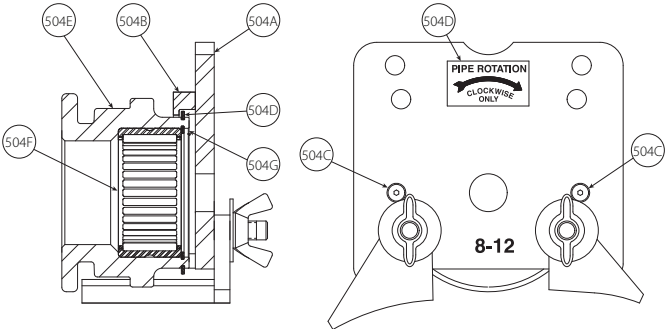
Item #	Part #	Qty.	Description
—	R9A2272U06	1	Upper Roll Assembly, Includes items 502A-502H
502A	R510268WLD	1	Upper Roll Guard
502B	R1022720FS	1	Upper Roll Guard Cover Ring
502C	NS09008010	2	#8 - 32 UNC x ¾" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
502D	R040416LAB	1	Pipe Rotation Label #
502F	NB02200001	1	Needle Bearing
502G	NT03000014	1	Snap Ring
502H	NT03000022	1	Snap Ring

Refer to pages 22 - 24 for images of product labels



VE268 UPPER ROLL ASSEMBLY FOR 8 - 12" STEEL PIPE (ITEM 504)

Item #	Part #	Qty.	Description
—	R9A8272U12	1	Upper Roll Assembly, Includes items 504A-504H
504A	R520268WLD	1	Upper Roll Guard
504B	R1022720FS	1	Upper Roll Guard Cover Ring
504C	NS09008010	2	#8 - 32 UNC x ¾" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
504D	R040416LAB	1	Pipe Rotation Label #
504F	NB02200001	1	Needle Bearing
504G	NT03000014	1	Snap Ring
504H	NT03000022	1	Snap Ring

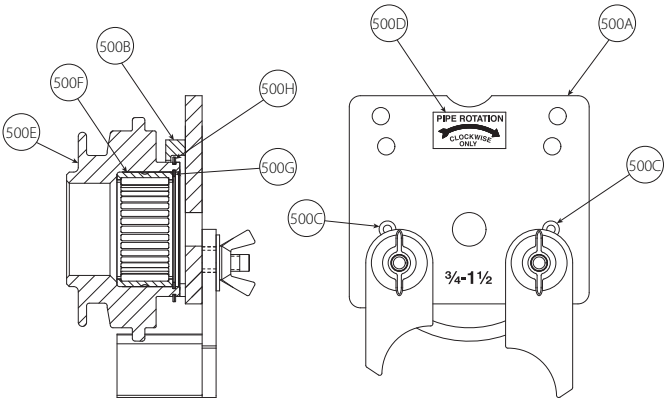


OPTIONAL VE268 UPPER ROLL COVER/GUARD ASSEMBLIES

VE268 UPPER ROLL ASSEMBLY FOR ¾ - 1 ½" STEEL PIPE (ITEM 500)

Item #	Part #	Qty.	Description
—	R9A0268U02	1	Upper Roll Assembly, Includes items 500A-500H
500A	R500268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8 - 32 UNC x ¾" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500E	R900268U01	1	Upper Roll ¾"-1 ½"
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring

Note: If 500E sold separately, will need item # 500F pressed into it.



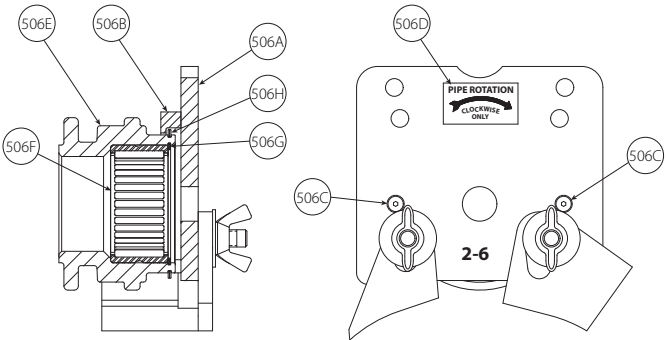
OPTIONAL VE268 UPPER ROLL COVER/GUARD ASSEMBLIES

VE268 UPPER ROLL ASSEMBLY FOR 2 - 6" SCHEDULES 5S AND 10S STAINLESS STEEL PIPE (ITEM 506)

Item #	Part #	Qty.	Description
**	RXA2272U06	1	Upper Roll Assembly, Includes items 506A-506H
506A	R510268WLD	1	Upper Roll Guard
506B	R1022720FS	1	Upper Roll Guard Cover Ring
506C	NS09008010	2	#8 - 32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
506D	R040416LAB	1	Pipe Rotation Label #
506F	NB02200001	1	Needle Bearing
506G	NT03000014	1	Snap Ring
506H	NT03000022	1	Snap Ring
**	RX02272L03	1	2 - 3 1/2" Lower Roll for Stainless Steel Pipe **
**	RX04272L06	1	4 - 6" Lower Roll for Stainless Steel Pipe **

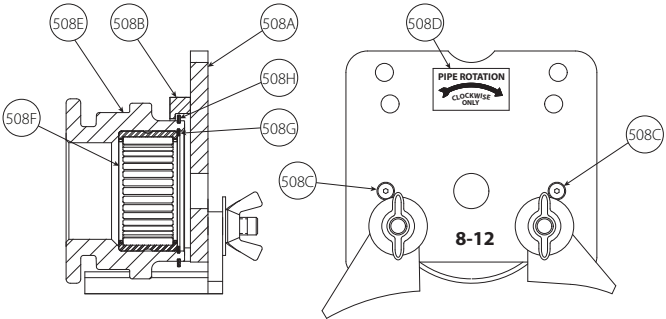
** Not shown

Refer to pages 22 - 24 for images of product labels



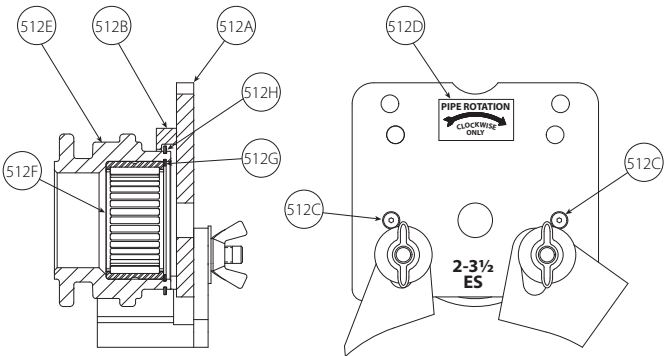
VE268 UPPER ROLL ASSEMBLY FOR 8 - 12" SCHEDULES 5S AND 10S STAINLESS STEEL PIPE (ITEM 508)

Item #	Part #	Qty.	Description
**	RXA8272U12	1	Upper Roll Assembly, Includes items 508A-508H
508A	R520268WLD	1	Upper Roll Guard
508B	R1022720FS	1	Upper Roll Guard Cover Ring
508C	NS09008010	2	#8 - 32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
508D	R040416LAB	1	Pipe Rotation Label #
508F	NB02200001	1	Needle Bearing
508G	NT03000014	1	Snap Ring
508H	NT03000022	1	Snap Ring
**	RX08272L12	1	8 - 12" Lower Roll for Stainless Steel Pipe **



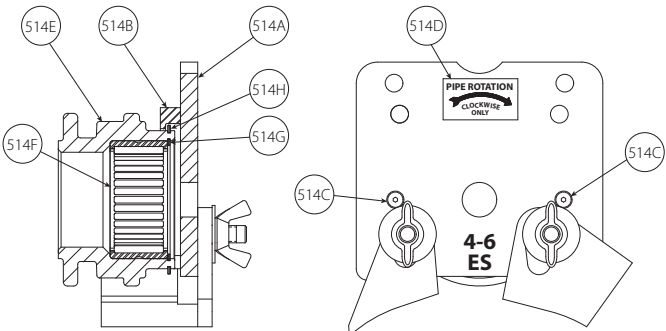
VE268 UPPER ROLL ASSEMBLY FOR 2 - 3 1/2" PIPE FOR ENDSEAL® PRODUCTS (ITEM 512)

Item #	Part #	Qty.	Description
**	RZA2272U03	1	Upper Roll Assembly, Includes items 512A-512H
512A	RZ00268WLD	1	Upper Roll Guard
512B	R1022720FS	1	Upper Roll Guard Cover Ring
512C	NS09008010	2	#8 - 32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
512D	R040416LAB	1	Pipe Rotation Label #
512F	NB02200001	1	Needle Bearing
512G	NT03000014	1	Snap Ring
512H	NT03000022	1	Snap Ring
**	RZ02272L03	1	2" - 3 1/2" Lower Roll for EndSeal® Pipe **



VE268 UPPER ROLL ASSEMBLY FOR 4 - 6" PIPE FOR ENDSEAL® PRODUCTS (ITEM 514)

Item #	Part #	Qty.	Description
**	RZA4272U06	1	Upper Roll Assembly, Includes items 514A-514H
514A	RZ10268WLD	1	Upper Roll Guard
514B	R1022720FS	1	Upper Roll Guard Cover Ring
514C	NS09008010	2	#8 - 32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
514D	R040416LAB	1	Pipe Rotation Label #
514F	NB02200001	1	Needle Bearing
514G	NT03000014	1	Snap Ring
514H	NT03000022	1	Snap Ring
**	RZ04272L06	1	4" - 6" Lower Roll for EndSeal® Pipe **



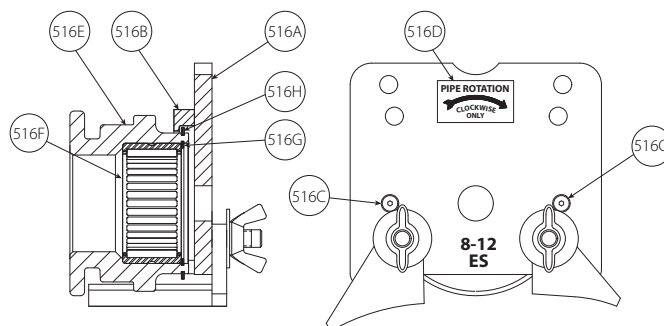
OPTIONAL VE268 UPPER ROLL COVER/GUARD ASSEMBLIES

VE268 UPPER ROLL ASSEMBLY FOR 8 - 12" PIPE FOR ENDSEAL® PRODUCTS (ITEM 516)

Item #	Part #	Qty.	Description
**	RZA8272U12	1	Upper Roll Assembly, Includes items 516A-516H
516A	RZ20268WLD	1	Upper Roll Guard
516B	R1022720FS	1	Upper Roll Guard Cover Ring
516C	NS09008010	2	#8 - 32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
516D	R040416LAB	1	Pipe Rotation Label #
516F	NB02200001	1	Needle Bearing
516G	NT03000014	1	Snap Ring
516H	NT03000022	1	Snap Ring
**	RZ08272L12	1	8" - 12" Lower Roll for EndSeal® Pipe **

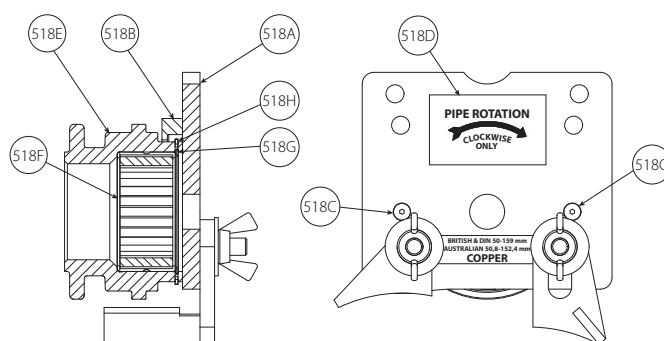
** Not shown

Refer to pages 22 - 24 for images of product labels



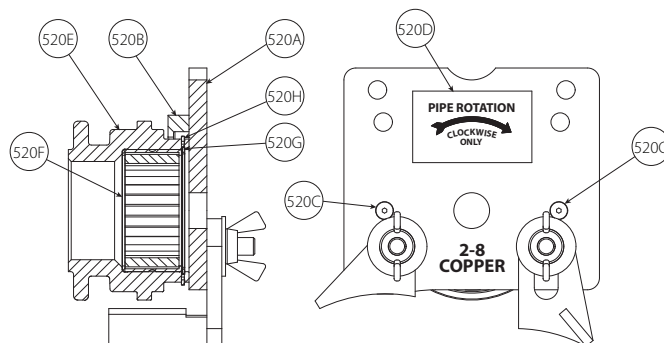
VE268 UPPER ROLL ASSEMBLY FOR 50.8 - 152.4 MM AUSTRALIAN AND 50 - 159 MM BRITISH/DIN COPPER TUBING (ITEM 518)

Item #	Part #	Qty.	Description
**	RRE1272UA6	1	Upper Roll Assembly, Includes items 518A-518H
518A	RR00268WLD	1	Upper Roll Guard
518B	R1022720FS	1	Upper Roll Guard Cover Ring
518C	NS09008010	2	#8 - 32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
518D	R040416LAB	1	Pipe Rotation Label #
518F	NB02200001	1	Needle Bearing
518G	NT03000014	1	Snap Ring
518H	NT03000022	1	Snap Ring
**	RRE1272L06	1	Lower Roll for Copper Pipe **
**	R157272LBL	1	Roll Guard Cover Label (Export) #



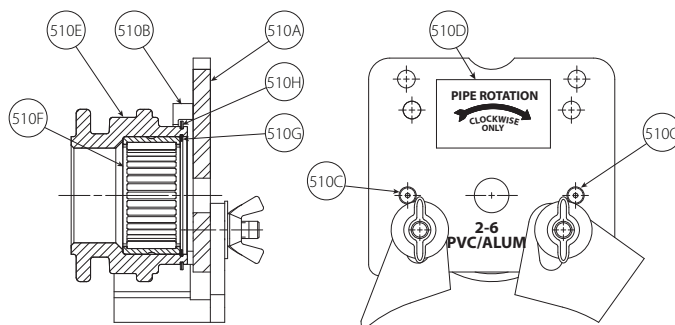
VE268 UPPER ROLL ASSEMBLY FOR 2 - 8" COPPER TUBING (ITEM 520)

Item #	Part #	Qty.	Description
**	RRA2272U08	1	Upper Roll Assembly, Includes items 520A-520H
520A	RR00268WLD	1	Upper Roll Guard
520B	R1022720FS	1	Upper Roll Guard Cover Ring
520C	NS09008010	2	#8 - 32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
520D	R040416LAB	1	Pipe Rotation Label #
520F	NB02200001	1	Needle Bearing
520G	NT03000014	1	Snap Ring
520H	NT03000022	1	Snap Ring
**	RR02272L06	1	2 - 6" Lower Roll for Copper Pipe **
**	RR08272L08	1	8" Lower Roll for Copper Pipe **



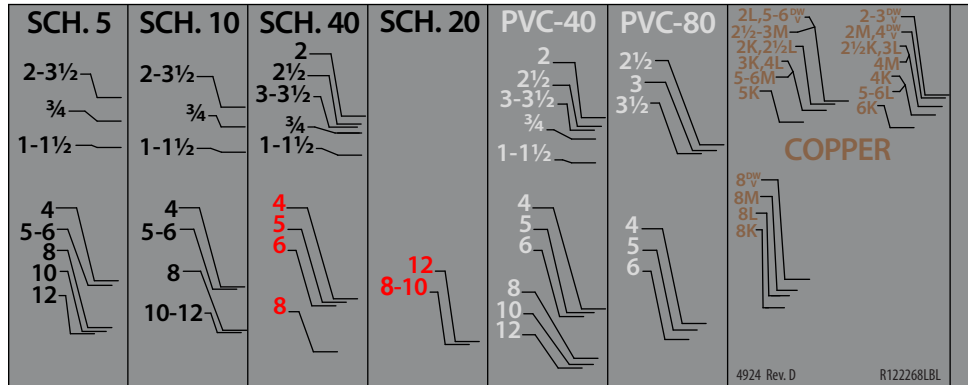
VE268 UPPER ROLL ASSEMBLY FOR 2 - 6" PVC AND ALUMINUM PIPE (ITEM 510)

Item #	Part #	Qty.	Description
**	RPA2272U06	1	Upper Roll Assembly, Includes items 510A-510H
510A	R530268WLD	1	Upper Roll Guard
510B	R1022720FS	1	Upper Roll Guard Cover Ring
510C	NS09008010	2	#8 - 32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
510D	R040416LAB	1	Pipe Rotation Label #
510F	NB02200001	1	Needle Bearing
510G	NT03000014	1	Snap Ring
510H	NT03000022	1	Snap Ring
**	RP02272L03	1	2 - 3 1/2" Lower Roll for Aluminum and PVC
**	RP04272L06	1	4 - 6" Lower Roll for Aluminum and PVC

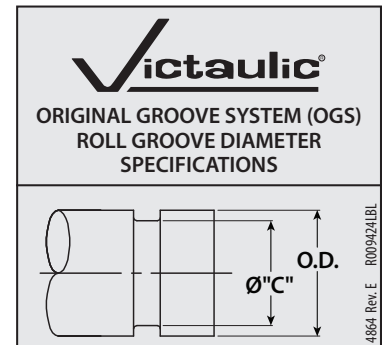


IMAGES OF THE LABELS ON PAGES 22 - 24 ARE NOT TO SCALE.

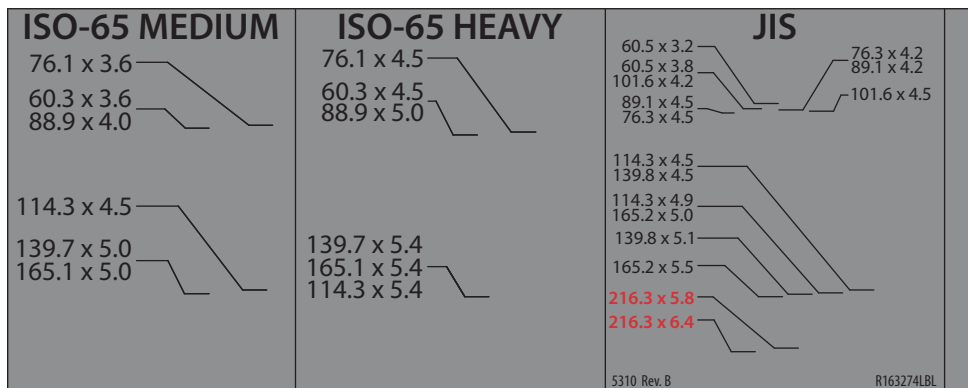
R122268LBL



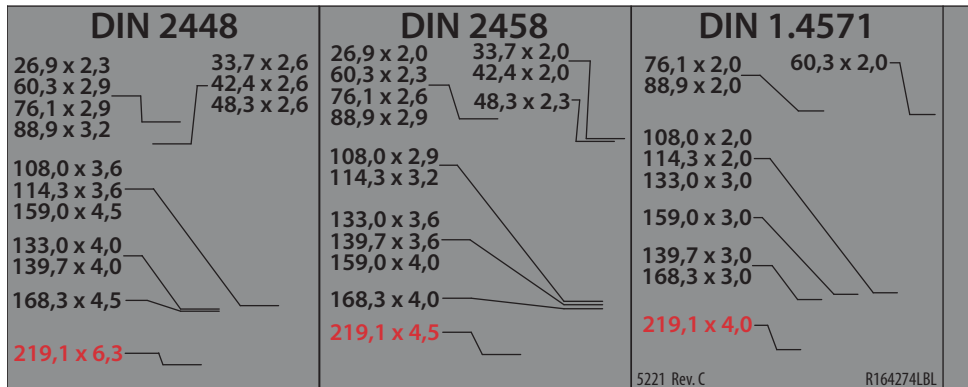
R009424LBL



R163274LBL



R164274LBL



R090424LAB

⚠ DANGER

Contact with hazardous voltage inside this door may result in death or serious personal injury.

- ALWAYS disconnect the tool from the power source before performing maintenance or adjustments.
- Only qualified personnel should open this door.

5038 Rev. C
R090424LAB

SIZE	O.D.		ø "C"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
3/4	1.060	1.040	0.938	0.923
[26.9]	[26.9]	[26.4]	[23.8]	[23.4]
1	1.328	1.302	1.190	1.175
[33.7]	[33.7]	[33.1]	[30.2]	[29.9]
1 1/4	1.676	1.644	1.535	1.520
[42.4]	[42.6]	[41.8]	[39.0]	[38.6]
1 1/2	1.919	1.881	1.775	1.760
[48.3]	[48.7]	[47.8]	[45.1]	[44.7]
2	2.399	2.351	2.250	2.235
[60.3]	[60.9]	[59.7]	[57.2]	[56.8]
2 1/2	2.904	2.846	2.720	2.702
[73.0]	[73.8]	[72.3]	[69.1]	[68.6]
3	3.535	3.469	3.344	3.326
[88.9]	[89.8]	[88.1]	[84.9]	[84.5]
3 1/2	4.040	3.969	3.834	3.814
[101.6]	[102.6]	[100.8]	[97.4]	[96.9]
4	4.545	4.469	4.334	4.314
[114.3]	[115.4]	[113.5]	[110.1]	[109.6]
4 1/2	5.050	4.969	4.834	4.814
[127.0]	[128.3]	[126.2]	[122.8]	[122.3]
5	5.619	5.532	5.395	5.373
[141.3]	[142.7]	[140.5]	[137.0]	[136.5]
6	6.688	6.594	6.455	6.433
[168.3]	[169.9]	[167.5]	[164.0]	[163.4]
203.2 mm	8.063	7.969	7.816	7.791
[219.1]	[220.7]	[218.3]	[214.4]	[213.8]
8	8.688	8.594	8.441	8.416
[219.1]	[220.7]	[218.3]	[214.4]	[213.8]
254.0 mm	10.063	9.969	9.812	9.785
[254.0]	[255.6]	[253.2]	[249.2]	[248.5]
10	10.813	10.719	10.562	10.535
[273.0]	[274.7]	[272.3]	[268.3]	[267.6]
304.8 mm	12.063	11.969	11.781	11.751
[304.8]	[306.4]	[304.0]	[299.2]	[298.5]
12	12.813	12.719	12.531	12.501
[323.9]	[325.5]	[323.1]	[318.3]	[317.5]
14 OD	14.063	13.969	13.781	13.751
[355.6]	[357.2]	[354.8]	[350.0]	[349.3]
15 OD	15.063	14.969	14.781	14.751
[381.0]	[382.6]	[380.2]	[375.4]	[374.7]
16 OD	16.063	15.969	15.781	15.751
[406.4]	[408.0]	[405.6]	[400.8]	[400.1]
18 OD	18.063	17.969	17.781	17.751
[457]	[458.8]	[456.4]	[451.6]	[450.9]
20 OD	20.063	19.969	19.781	19.751
[508]	[509.6]	[507.2]	[502.4]	[501.7]
22 OD	22.063	21.969	21.656	21.626
[559]	[560.4]	[558.0]	[550.1]	[549.3]
24 OD	24.063	23.969	23.656	23.626
[610]	[611.2]	[608.8]	[600.9]	[600.1]
26 OD	26.063	25.937	25.500	25.437
[660]	[662.0]	[658.8]	[647.7]	[646.1]
28 OD	28.063	27.937	27.500	27.437
[711]	[712.8]	[709.6]	[698.5]	[696.9]
30 OD	30.063	29.937	29.500	29.437
[762]	[763.6]	[760.4]	[749.3]	[747.7]
32 OD	32.063	31.937	31.500	31.437
[813]	[814.4]	[811.2]	[800.1]	[798.5]
36 OD	36.063	35.937	35.500	35.437
[914]	[916.0]	[912.8]	[901.7]	[900.1]
42 OD	42.063	41.937	41.500	41.437
[1067]	[1068.4]	[1065.2]	[1054.1]	[1052.5]
48 OD	48.063	47.937	47.500	47.437
[1219]	[1220.8]	[1217.6]	[1206.5]	[1204.9]

R020260LBL



R010416LAB

STANDARD PIPE WALL THICKNESS																							
PIPE SIZE	O.D.	SCHEDULE										PIPE SIZE	O.D.	SCHEDULE									
		5	10	20	30	40	STD	80	XStrg.	5	10			20	30	40	STD	80	XStrg.				
¾	1.050	.065	.083	-	-	.113	.113	.154	.154	26	26.000	-	.312	.500	-	-	.375	-	.500				
1	1.315	.065	.109	-	-	.133	.133	.179	.179	28	28.000	-	.312	.500	.625	-	.375	-	.500				
1¼	1.660	.065	.109	-	-	.140	.140	.191	.191	30	30.000	-	.312	.500	.625	-	.375	-	.500				
1½	1.900	.065	.109	-	-	.145	.145	.200	.200	32	32.000	-	.312	.500	.625	.688	.375	-	.500				
2	2.375	.065	.109	-	-	.154	.154	.218	.218	36	36.000	-	.312	.500	.625	.750	.375	-	.500				
2½	2.875	.083	.120	-	-	.203	.203	.267	.276	38	38.000	-	-	-	-	-	.375	-	.500				
3	3.500	.083	.120	-	-	.216	.216	.300	.300	40	40.000	-	-	-	-	-	.375	-	.500				
3½	4.000	.083	.120	-	-	.226	.226	.318	.318	42	42.000	-	-	-	-	-	.375	-	.500				
4	4.500	.083	.120	-	-	.237	.237	.337	.337	44	44.000	-	-	-	-	-	.375	-	.500				
5	5.563	.109	.134	-	-	.258	.258	.375	.375	46	46.000	-	-	-	-	-	.375	-	.500				
6	6.625	.109	.134	-	-	.280	.280	.432	.432	48	48.000	-	-	-	-	-	.375	-	.500				
8	8.625	.109	.148	.250	.277	.322	.322	.500	.500	52	52.000	-	-	-	-	-	.375	-	.500				
10	10.750	.134	.165	.250	.307	.365	.365	.593	.500	54	54.000	-	-	-	-	-	.375	-	.500				
12	12.750	.165	.180	.250	.330	.406	.375	.687	.500	56	56.000	-	-	-	-	-	.375	-	.500				
14	14.000	-	.250	.312	.375	.437	.375	.750	.500	60	60.000	-	-	-	-	-	.375	-	.500				
16	16.000	-	.250	.312	.375	.500	.375	.843	.500	64	64.000	-	-	-	-	-	.375	-	.500				
18	18.000	-	.250	.312	.437	.562	.375	.937	.500	68	68.000	-	-	-	-	-	.375	-	.500				
20	20.000	-	.250	.375	.500	.593	.375	1.031	.500	72	72.000	-	-	-	-	-	.375	-	.500				
24	24.000	-	.250	.375	.562	.687	.375	1.281	.500	4920 Rev. D												R010416JAB	

R023268LBL



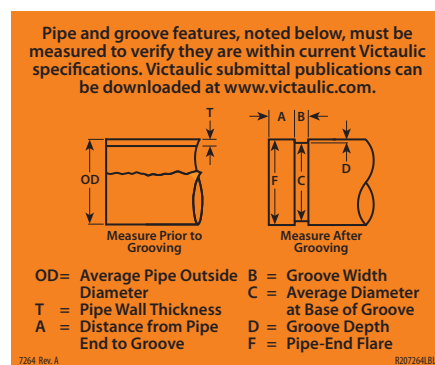
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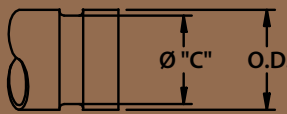
R115715LBL



R207264LBL



R070260VE0

COPPER ROLL GROOVE DIAMETER SPECIFICATION				
				
SIZE	O.D.		Ø "C"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
2 [54,0]	2.127 [54,0]	2.123 [53,9]	2.029 [51,5]	2.009 [51,0]
2½ [66,7]	2.627 [66,7]	2.623 [66,6]	2.525 [64,1]	2.505 [63,6]
3 [79,4]	3.127 [79,4]	3.123 [79,3]	3.025 [76,8]	3.005 [76,3]
4 [104,8]	4.127 [104,8]	4.123 [104,7]	4.019 [102,1]	3.999 [101,6]
5 [130,2]	5.127 [130,2]	5.123 [130,1]	4.999 [127,0]	4.979 [126,5]
6 [155,6]	6.127 [155,6]	6.123 [155,5]	5.999 [152,3]	5.979 [151,9]
8 [206,4]	8.127 [206,4]	8.121 [206,3]	7.959 [202,2]	7.939 [201,7]

-IMPORTANT-

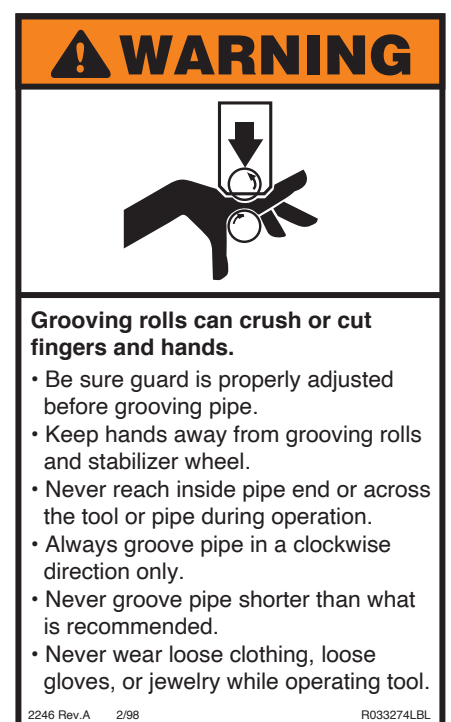
USE ONLY VICTAULIC GROOVING ROLLS DESIGNED FOR COPPER TUBING (COLOR CODED COPPER)

GROOVE COPPER TUBING AT A MODERATE RATE BY UNIFORMLY FORMING GROOVES IN 5 TO 10 TUBE ROTATIONS. FORMING GROOVES AT FASTER RATES CAN RESULT IN POOR GROOVE SHARPNESS AND JOINT FAILURE.

4921 Rev. E

R070260VE0

R033274LBL



VE268 Roll Grooving Tool

R511921LBL

VE268

SERIAL NO. DATE MFD.

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
230	3	60	11.5 AMPS
460	3	60	6.5 AMPS

DRIVE MOTOR:

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
230	3	60	8.8 AMPS
460	3	60	4.4 AMPS

SHORT CIRCUIT INTERRUPTING CAPACITY 5,000 AMPS

- GEAR OIL – AGMA 7
- HYDRAULIC OIL – HIGH-PRESSURE, ANTI-WEAR ISO GRADE 32
- BEARING LUBE – ANTI-WEAR, EXTREME PRESSURE NLGI GRADE 2

ELECTRICAL ASSEMBLY DWG. R-301-268-SCH REVISION LEVEL



Victaulic Company World Headquarters
4901 Kesslersville Road • Easton, PA 18040
victaulic.com

Manufactured in Canada

11921 Rev. C R511921LBL

R511922LBL

VE268

SERIAL NO. DATE MFD.

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
380	3	50	10.6 AMPS
415	3	50	9.7 AMPS

DRIVE MOTOR:

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
380	3	50	8.0 AMPS
415	3	50	7.4 AMPS

SHORT CIRCUIT INTERRUPTING CAPACITY 5,000 AMPS

- GEAR OIL – AGMA 7
- HYDRAULIC OIL – HIGH-PRESSURE, ANTI-WEAR ISO GRADE 32
- BEARING LUBE – ANTI-WEAR, EXTREME PRESSURE NLGI GRADE 2

ELECTRICAL ASSEMBLY DWG. R-301-268-SCH REVISION LEVEL

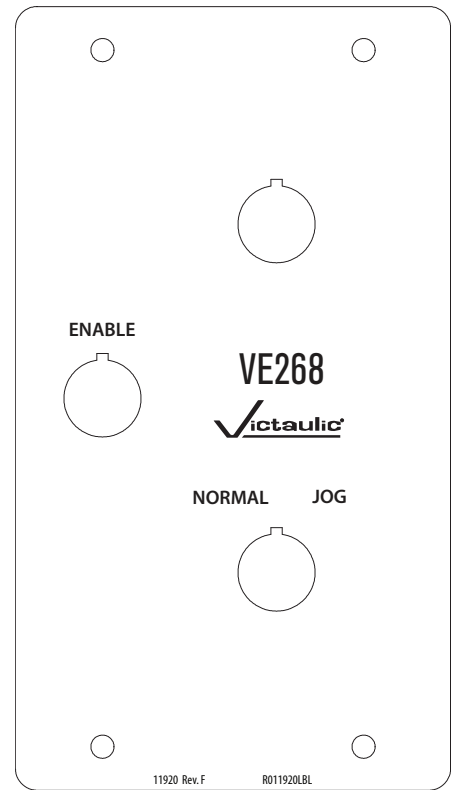


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11922 Rev. C R511922LBL

R011920LBL



11920 Rev. F R011920LBL

R031272LAB

**WARNING**

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

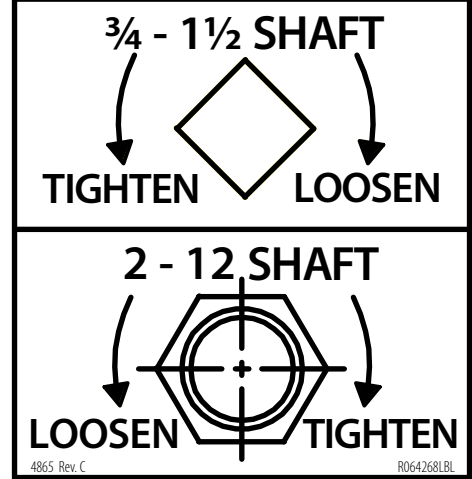
- Before operating or servicing any tools, read the entire operating and maintenance instructions manual and all labels on the tool.

- Wear safety glasses, hardhat, foot protection, and hearing protection.
- Operate the tool only with a safety foot switch. If the tool does not contain a safety foot switch, contact Victaulic.

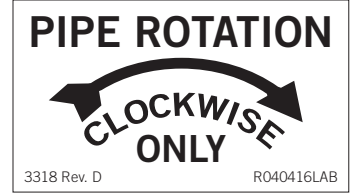
Contact Victaulic with questions regarding the safe and proper operation of tools:
Web: victaulic.com E-Mail: pickvic@victaulic.com Phone: 1-800-PICK-VIC

0567 Rev. E R031272LAB

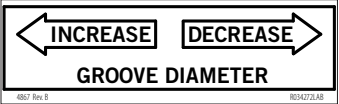
R064268LBL



R040416LAB



R034272LAB



R157272LBL

BRITISH & DIN 50 – 159 MM
AUSTRALIAN 50,8 – 203,2 MM

3373 Rev. C R157272LBL

For complete contact information, visit victaulic.com

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