
VE270FSD and VE271FSD Roll Grooving Tools



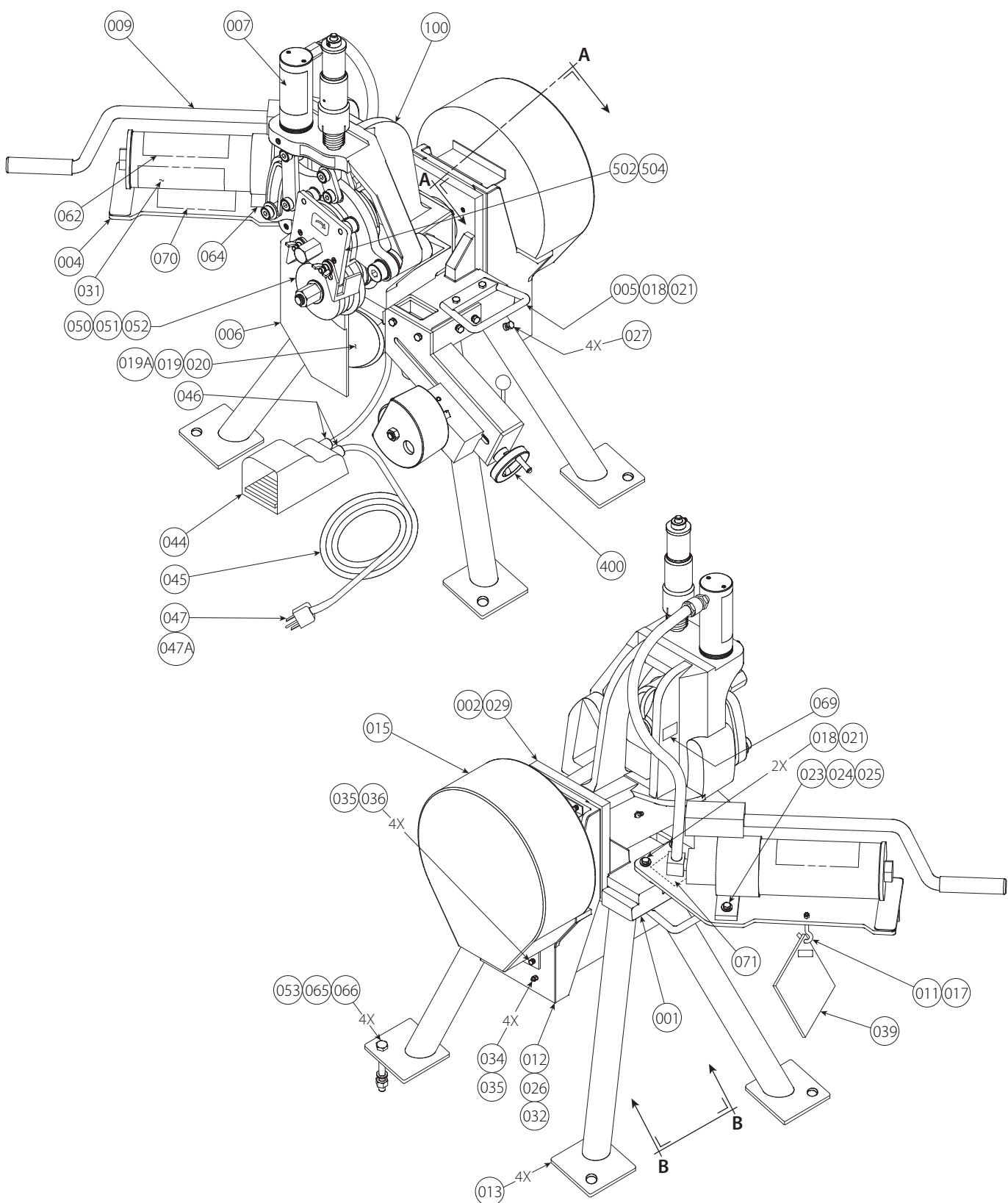
OGS
EndSeal™

PARTS ORDERING INFORMATION

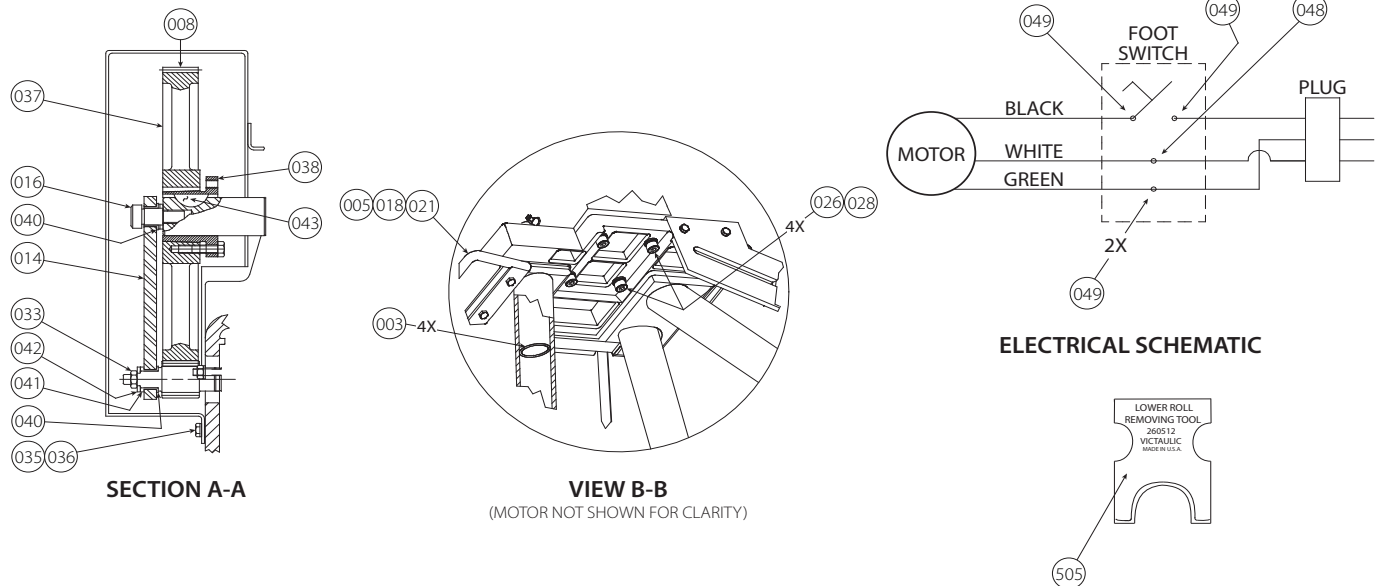
When ordering parts, the following information is necessary for Victaulic to process the order promptly:

1. Tool Model Number – VE270FSD or VE271FSD
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.



MAIN ASSEMBLY (CONTINUED)



Item #	Part #	Qty.	Description
001	R001276MCH	1	Table
002	R004276MCH	1	Vertical Plate
003	R003416PLT	4	Upper Leg
004	R004272PLT	1	Pump Bracket **
005	R005272PLT	2	Base Handle
006	R006276PNT	1	Guard
007	R033274LBL	1	Roll Warning Label#
008	-	As Req.	Lubriplate Gear Shield Heavy (Spray)
009	R2012610FS	1	Hydraulic Hand Pump Assembly **
011	NS40040000	1	1/4" Hook Bolt with Nut, 1/4 - 20 UNC x 2.625 Lg., Pltd.
012	R012417MAC	1	Motor Mounting Bracket
013	R013417PLT	4	Lower Leg
014	R014417PLT	1	Tie Bar **
015	R015417PNT	1	Gear Guard
016	NS05100012	1	.625 x .75 Lg. Shoulder Bolt, Blk. Ox.
017	NN01040000	1	1/4 - 20 UNC Hex Nut, Pltd.
018	NS01060100	6	3/8 - 16 UNC x 1.00 Lg. Hex Hd. Screw, Pltd.
019	R019416FSD	1	Gearmotor, 110 Volt
-	NE90000104	****	MTR BRUSH #20402-01 110V motors
-	NE90000112	2	Brush Cap
019A	R19A416FSD	1	Gearmotor, 220 Volt
-	NE90000162	****	220V BRSH ASY STAT# 2040210 220V motors
-	NE90000141	2	Brush Holder
020	R020417FSD	1	Gearmotor Filter
021	NW01060000	6	3/8" Flat Washer, Pltd.
023	NS01050108	2	5/16 - 18 UNC x 1.50 Lg. Hex Hd. Screw, Pltd.
024	NW01050000	4	5/16" Flat Washer, Pltd.
025	NN01050000	2	5/16 - 18 UNC Hex Nut, Pltd.
026	NW03060000	8	3/8" Lock Washer, Pltd.
027	NS01050012	4	5/16 - 18 UNC x .75 Lg. Grd. 5 Hex Hd. Cap Screw, Pltd.
028	NS03060200	4	3/8 - 16 UNC x 2.00 Lg. Socket Hd. Cap Screw, Blk. Ox.
029	NS03060100	6	3/8 - 16 UNC x 1.00 Lg. Socket Hd. Cap Screw, Blk. Ox.
031	R031272LAB	1	Instructions Warning Label#
032	NS01060104	4	3/8 - 16 UNC x 1.25 Lg. Hex Hd. Cap Screw, Pltd.
033	NN05060000	1	3/8 - 16 UNC Thin Elastic Locknut
034	NN02040000	4	1/4 - 28 UNC Hex Nut, Pltd.
035	NW03040000	8	1/4" Lock Washer, Pltd.
036	NS01040010	4	1/4 - 20 UNC x .63 Lg. Hex Hd. Cap Screw, Pltd.

Item #	Part #	Qty.	Description
037	R037417MAC	1	Spur Gear **
038	NM38000001	1	P1 Bushing with .375 Wide Keyway
039	R0392720FS	1	Guard Setting Pad Assembly
040	NB21062001	2	Flange Bushing
041	NB22062001	1	Thrust Bushing
042	NB40048001	1	Tongued Washer
043	NK01121000	1	#1210 Woodruff Key
044	NE03000002	1	Footswitch
045	NE04000011	1	15' Ext. Cord
046	NE06000001	2	Cord Grip Connector
047	NE08000003	1	Plug, 120 Volt
047A	-	1	Plug, 220 Volt
048	-	1	Wire Nut
049	-	4	#RB 14-18 Fork Wire Terminal
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	NW03080000	4	1/2" Lock Washer, Pltd.
062	R062260LBL	1	Hydraulic Hand Pump Label#
064	R064268LBL	1	Tightening Direction Label#
065	NN01080000	4	1/2 - 13 UNC Std. Hex Nut, Pltd.
066	NS01080204	4	1/2 - 13 UNC - 2A x 2.25 Lg. Hex Hd. Cap Screw, Pltd.
069	-	1	Name Plate#
070	R009424LBL	1	"C" Diameter Label for Standard Pipe#
071	R207264LBL	1	Groove Profile Information Label#
100	-	1	Tool Head Assembly
190	R190272ASY	1	Arbor Assembly for 2 - 12" Pipe ***
400	R400276FSD	1	Stabilizer Assembly (See page 8)
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

* Standard. Refer to pages 5 - 7 for optional upper roll cover/guard assemblies for grooving 3/4 - 1 1/2" pipe sizes and other pipe materials.

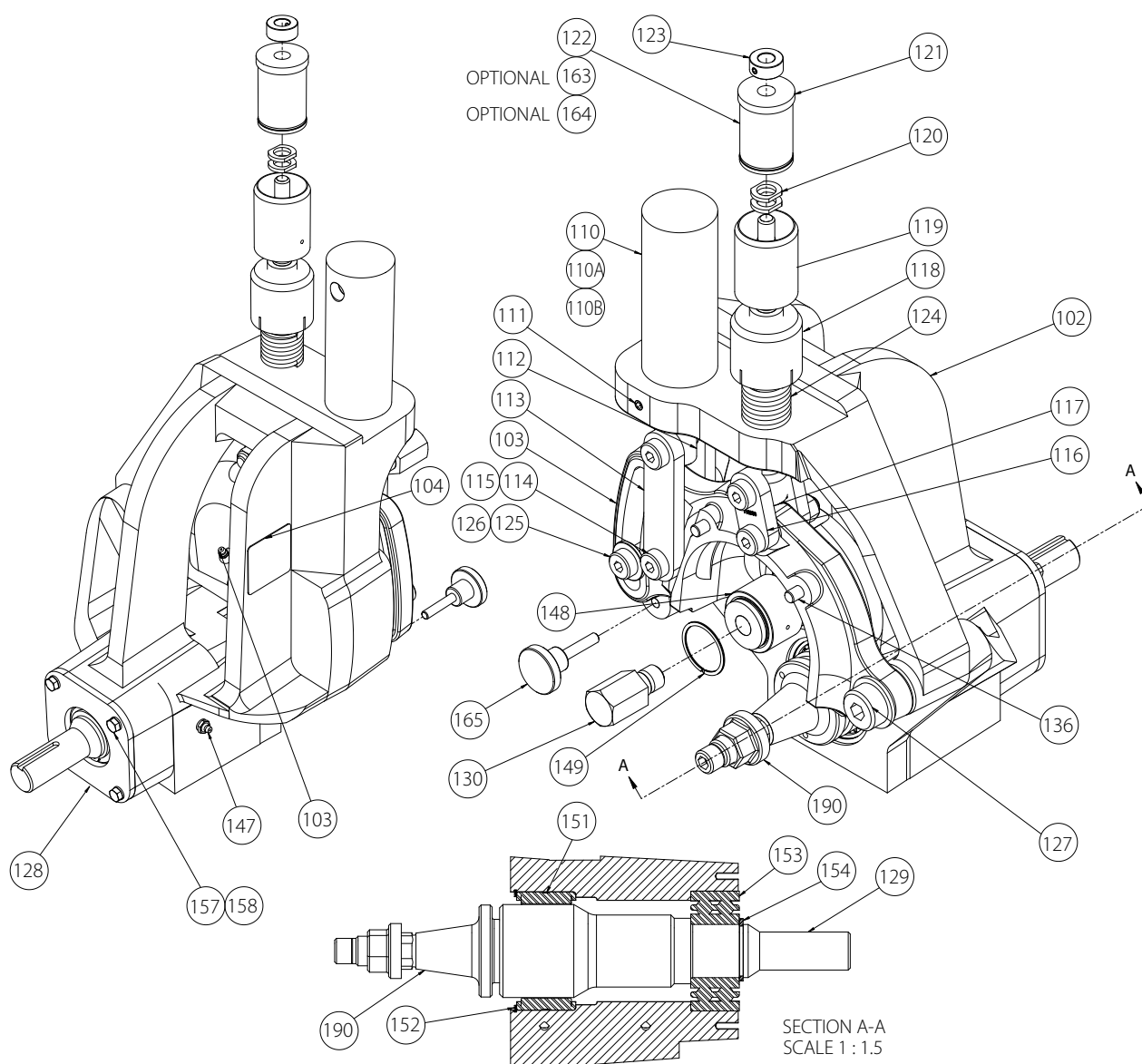
** Indicates additional items required or recommended when ordering.

*** Standard, not shown. Refer to page 6 for optional arbor assemblies for grooving 3/4" and 1 - 1 1/2" pipe sizes.

**** Includes one brush. Requires two total per motor.

Refer to pages 13 - 15 for images of product labels

TOOL HEAD ASSEMBLY



Item #	Part #	Qty.	Description
102	R0022720FS	1	Body **
103	R003268MCH	1	Arm **
104	-	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

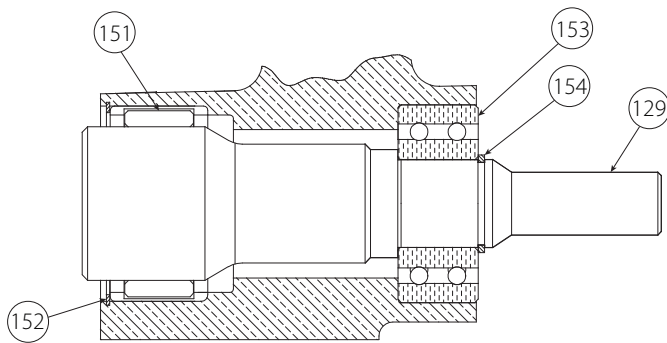
Item #	Part #	Qty.	Description
125	R0252720FS	1	Guide Washer
126	R019226MCH	1	3/8 x 1.00 Shoulder Screw
127	NS05160014	1	1.00 x .875 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
128	R0282720FS	1	Back Cover Plate
129	-	1	Main Shaft
130	R0302720FS	1	Upper Roll Guard Cover Screw
136	NP11006100	2	.375 x 1.00 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 13 - 15 for images of product labels

MAIN SHAFT

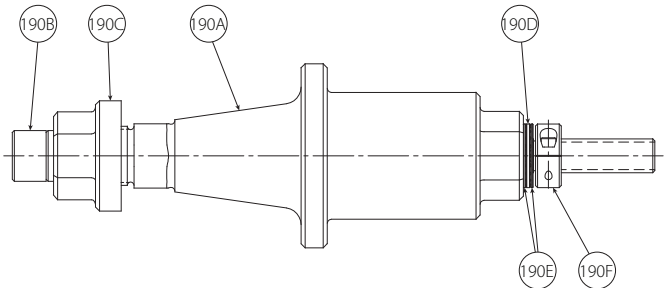


Item #	Part #	Qty.	Description
129	—	1	Main Shaft
151	NB02275002	1	Needle Bearing
152	NT03000015	1	Snap Ring
153	NB01157002	1	40Mm ID x 90Mm OD x 36.5Mm Wide Double Row Ang. Contact Ball Bearing
154	NT03000017	1	Snap Ring

NOTICE

- Design “A” of the square drive arbor assembly for 2 - 12” pipe, supersedes Design “B”.
- Components for Design “A” are not interchangeable with components of Design “B”.

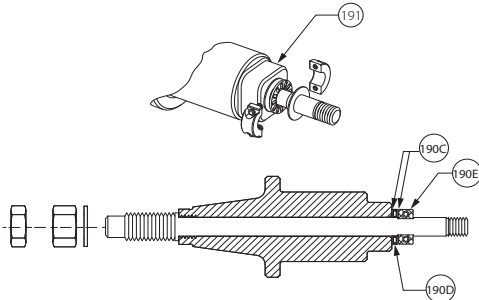
DESIGN “A” - SQUARE DRIVE ARBOR ASSEMBLY FOR 2 - 12” PIPE



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

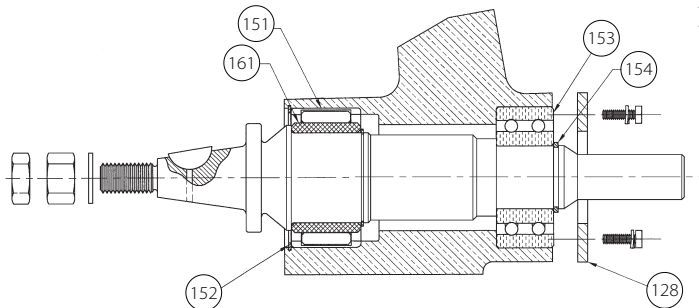
* Indicates additional items required or recommended when ordering.

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



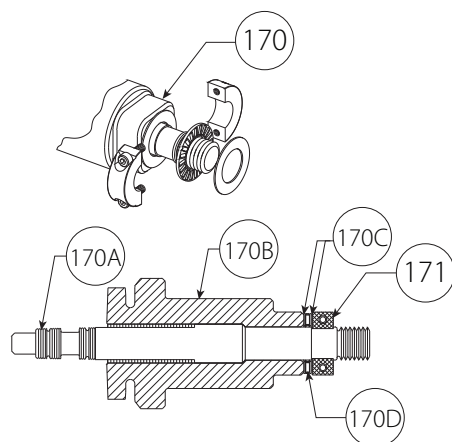
** For reference only. Contact Victaulic to verify application.

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

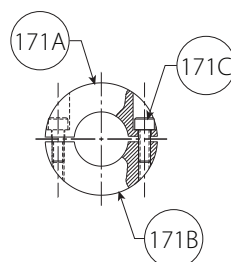


** For reference only. Contact Victaulic to verify application.
*** Use part number R195268KIT and part number R129268MCH.

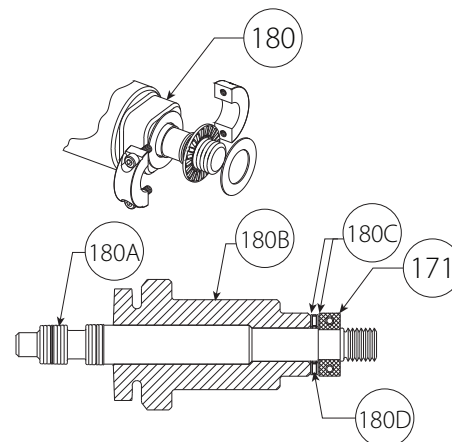
OPTIONAL ARBOR ASSEMBLIES



**Arbor Assembly for ¾" Pipe
(Item 170)**



**Shaft Collar Assembly
(Item 171)**



**Arbor Assembly for 1 - 1½" Pipe
(Item 180)**

ARBOR ASSEMBLY FOR 1 - 1½" PIPE

Item #	Part #	Qty.	Description
180	R901268LA2	1	Arbor Assembly for 1 - 1½" Pipe **
180A	R901268L02	1	Lower Roll for 1 - 1½" 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 ¾" PIPE

Item #	Part #	Qty.	Description
170	R900268LA1	1	Arbor Assembly for ¾" Pipe **
170A	R975268L75	1	Lower Roll for ¾" 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 ¾" Pipe **
–	RX01268LA2	1	Arbor Assembly for 1 - 1½" Pipe **
–	RX75268L75	1	Lower Roll for ¾" Stainless Steel Pipe
–	RX01268L02	1	Lower Roll for 1 - 1½" Stainless Steel Pipe

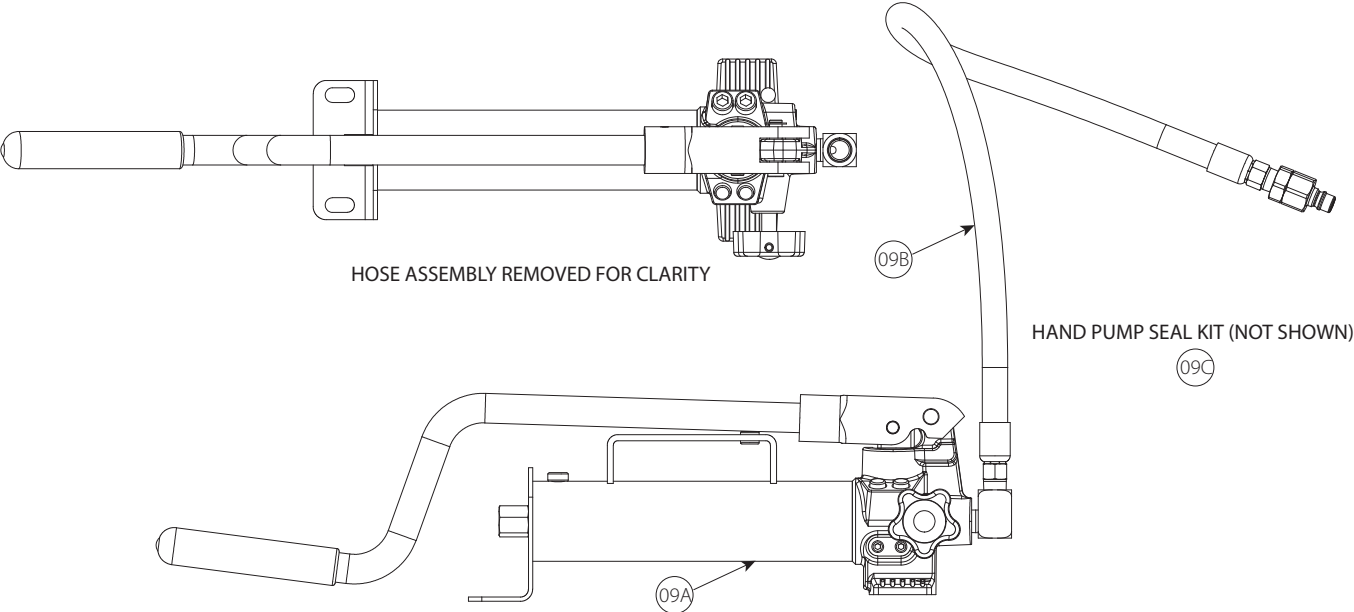
SHAFT COLLAR ASSEMBLY

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 ¾" Lg. SHCS, Blk. Ox. *

* Included in assembly. Not available for individual sale.

** Indicates additional items required or recommended when ordering.

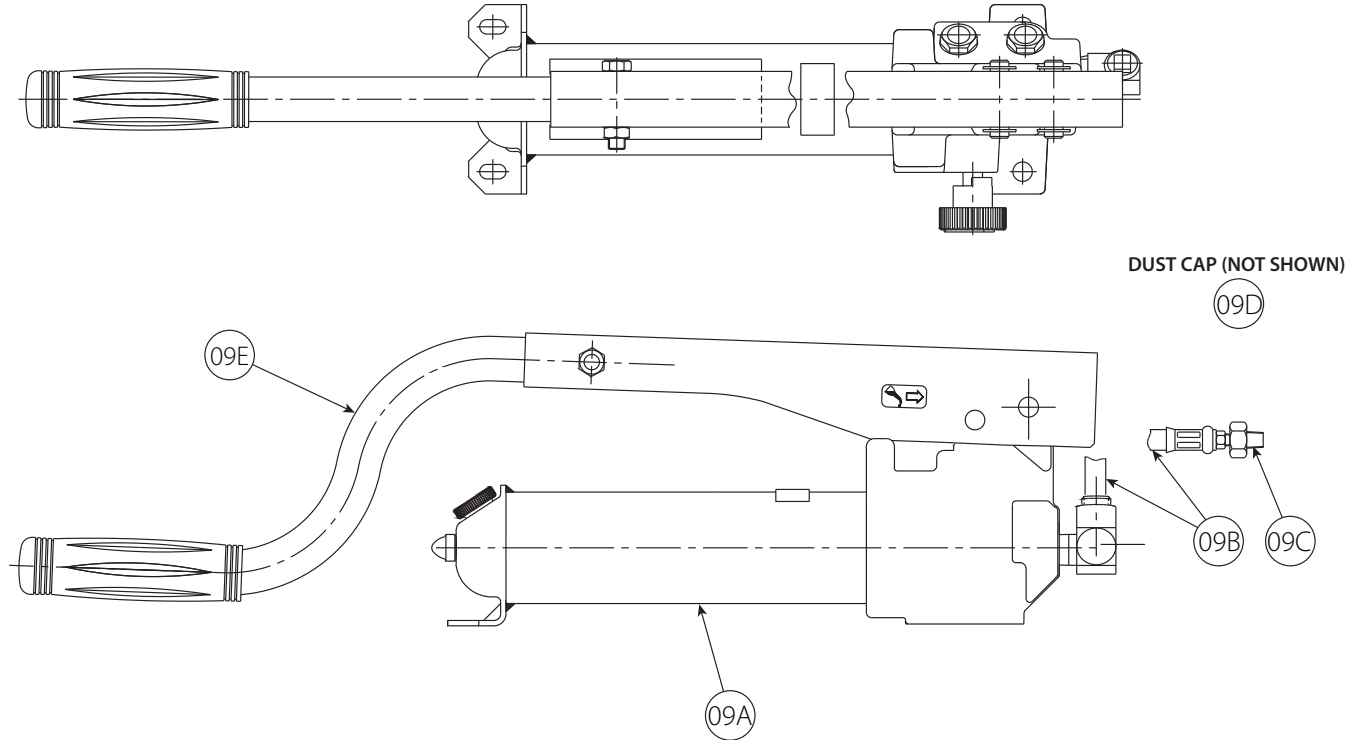
HYDRAULIC HAND PUMP ASSEMBLY (UPDATED DESIGN)



Item #	Part #	Qty.	Description
09A	R2012610FS	1	Hand Pump*
09B	NH02006002	1	Hydraulic Hose (25-inch Length with 3/8 NPT Ends)
09C	NHYD000040	1	Hand Pump Seal Kit (PowerX pump only)*

*Contact Victaulic to confirm model number.

HYDRAULIC HAND PUMP ASSEMBLY (ORIGINAL DESIGN)*

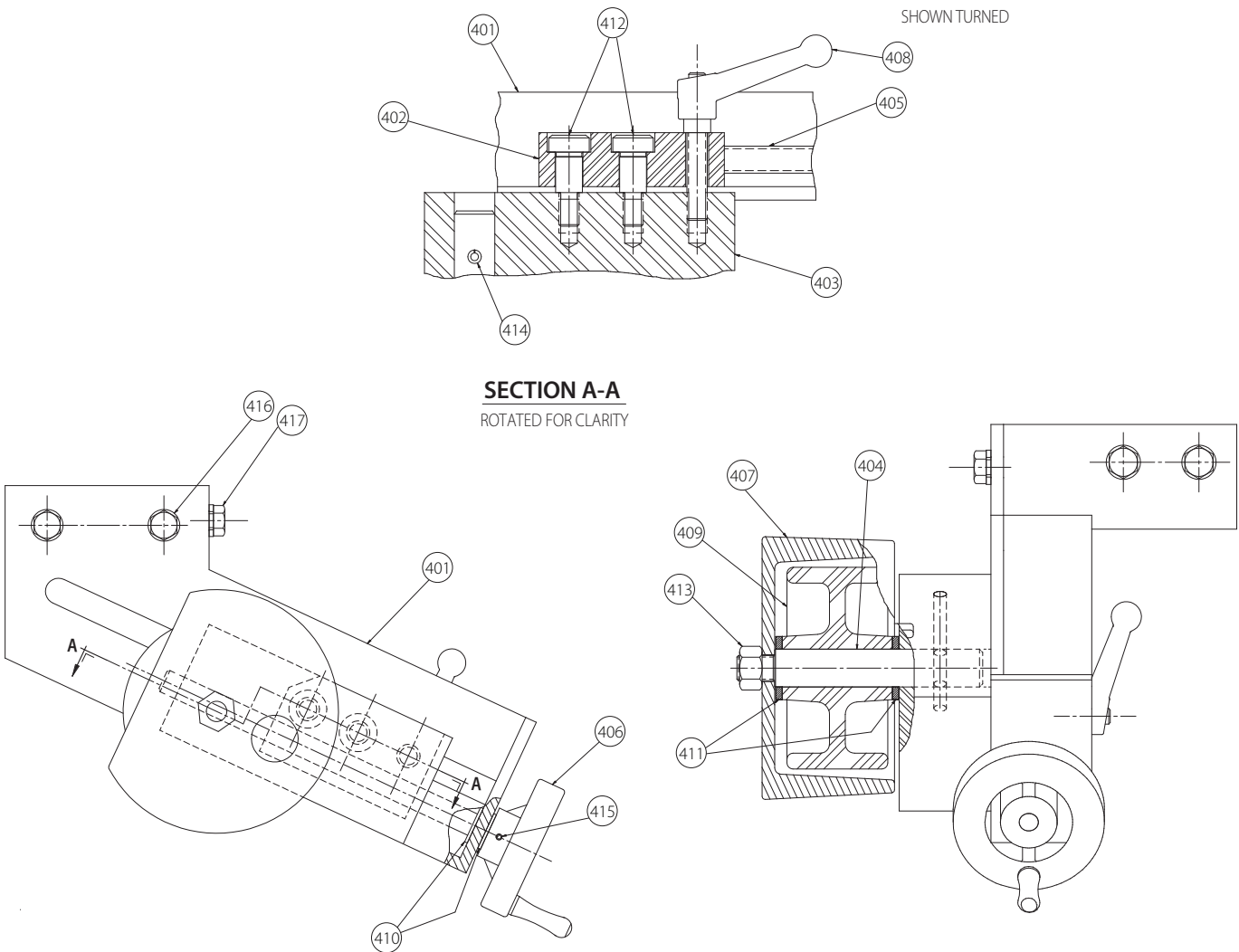


Item #	Part #	Qty.	Description
09A	—	1	Hand Pump*
09B	NH02006002	1	Hydraulic Hose (25-inch Length with 3/8 NPT Ends)
09C	NH50000017	1	Male Hose Half Coupler
09D	NH50000015	1	Dust Cap (covers item 09C)

Item #	Part #	Qty.	Description
09E	NH50000076	1	Curved Handle
09F	NH50000077	1	Hand Pump Repair Kit (P-59 Pump only, not shown)*

*Contact Victaulic

STABILIZER ASSEMBLY



Item #	Part #	Qty.	Description
400	R400276FSD	1	Stabilizer Assembly (Includes Items 401 – 417)
401	R401276PNT	1	Stabilizer Body
402	R402416PLT	1	Stabilizer Guide Nut
403	R403276PLT	1	Stabilizer Guide
404	R404416MAC	1	Stabilizer Roller Shaft
405	R405276MCH	1	Stabilizer Adjusting Screw
406	R406416MAC	1	Stabilizer Handwheel
407	R407416PNT	1	Stabilizer Wheel Guard
408	NM04000002	1	Locking Handle

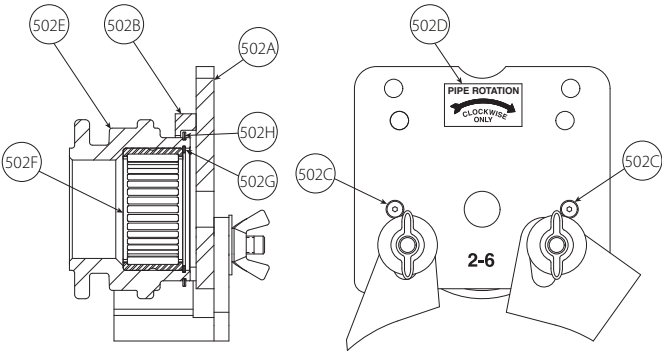
Item #	Part #	Qty.	Description
409	NM05000004	1	4" x 2" Polyurethane Wheel
410	NB05037002	2	Thrust Washer
411	NB05075004	2	Thrust Washer
412	NS05080012	2	.50 x .75" Lg. Socket Hd. Shoulder Bolt, Blk. Ox.
413	NN02080000	1	½ - 20 UNF Hex Nut, Pltd.
414	NP01004208	1	.25 x 2.50" Lg. Roll Pin
415	NP01002102	1	.125 x 1.125" Lg. Roll Pin
416	NS02060100	4	¾ - 16 UNC x 1.0" Lg. Grd. 8 Hex Hd. Cap Screw, Pltd.
417	NW03060000	4	¾" Lockwasher, Pltd.

STANDARD UPPER ROLL COVER/GUARD ASSEMBLIES

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

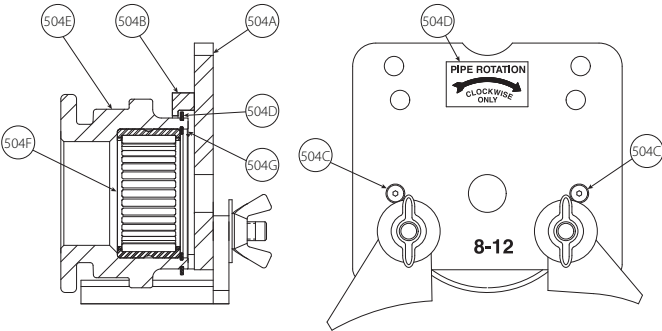
Item #	Part #	Qty.	Description
-	R9A2272U06	1	Upper Roll Assembly (Includes Items 502A - 502H)
502A	R510268WLD	1	Upper Roll Guard
502B	R1022720FS	1	Upper Roll Guard Cover Ring
502C	NS09008010	2	#8 - 32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
502D	R040416LAB	1	Pipe Rotation Label #
502F	NB02200001	1	Needle Bearing
502G	NT03000014	1	Snap Ring
502H	NT03000022	1	Snap Ring
**	R902272L03	1	2" - 3 1/2" Lower Roll **
**	R904272L06	1	4" - 6" Lower Roll **

** Not shown
Refer to pages 13 - 15 for images of product labels



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 5/8" 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
**	R908272L12	1	8" - 12" Lower Roll **

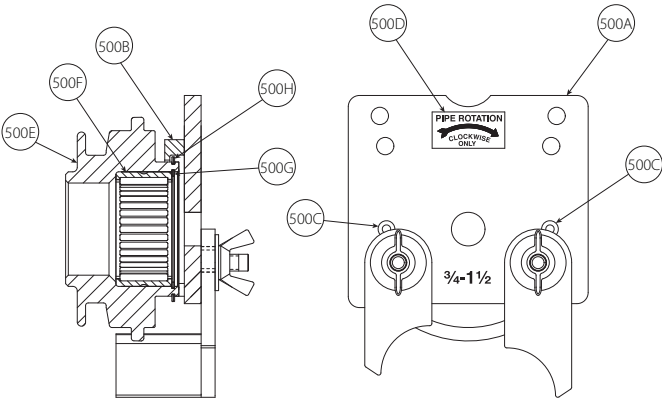


OPTIONAL UPPER ROLL COVER/GUARD ASSEMBLIES

UPPER ROLL ASSEMBLY FOR 3/4 - 1 1/2" 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 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500E	R900268U01	1	Upper Roll 3/4" - 1 1/2"
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring
170B*	R975268L75	1	Lower Roll for 3/4" (Requires additional parts)
180B*	R901268L02	1	Lower Roll for 1" - 1 1/2" (Requires additional parts)

NOTE: If Item #500E is sold separately, Item #500F will need to be pressed into it.
* See page 6.



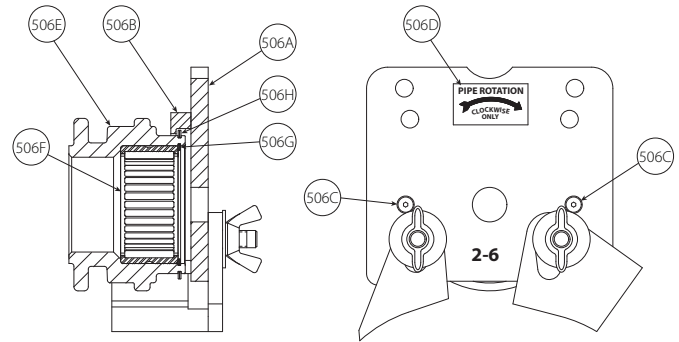
OPTIONAL UPPER ROLL COVER/GUARD ASSEMBLIES

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 - 3½" Lower Roll for Stainless Steel Pipe **
**	RX04272L06	1	4 - 6" Lower Roll for Stainless Steel Pipe **

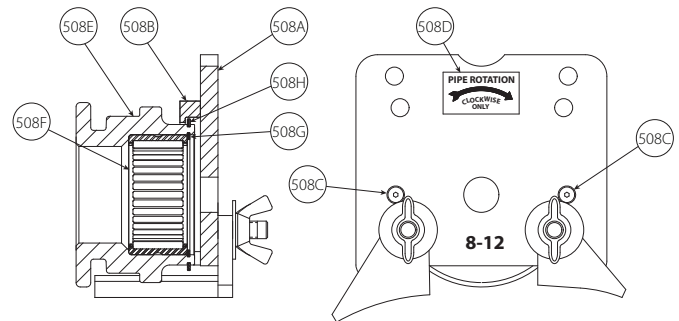
** Not shown

Refer to pages 13 - 15 for images of product labels



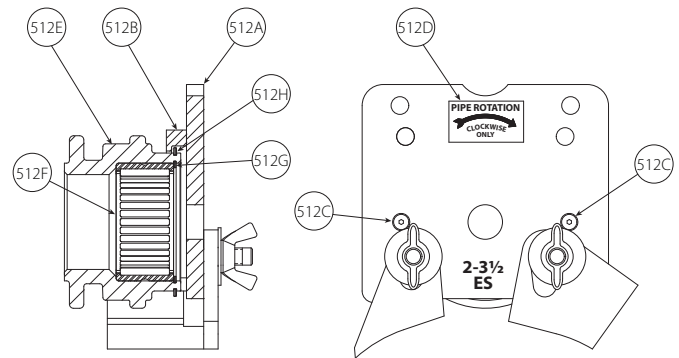
UPPER ROLL ASSEMBLY FOR 8 - 12" SCHEDULES 5S AND 10S STAINLESS STEEL PIPE (ITEM 508)

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 **



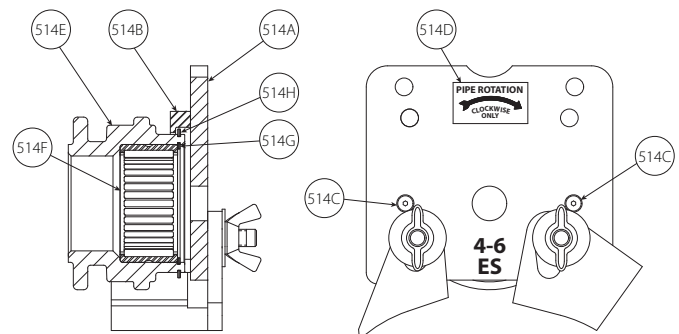
UPPER ROLL ASSEMBLY FOR 2 - 3½" PIPE FOR ENDSEAL™ PRODUCTS (ITEM 512)

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" - 3½" Lower Roll for EndSeal™ Pipe **



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 **



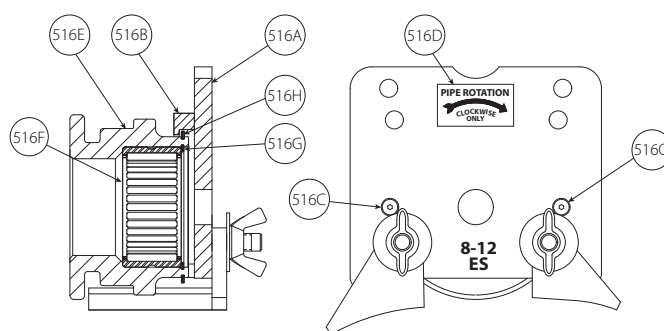
OPTIONAL UPPER ROLL COVER/GUARD ASSEMBLIES

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 5/8" 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 **

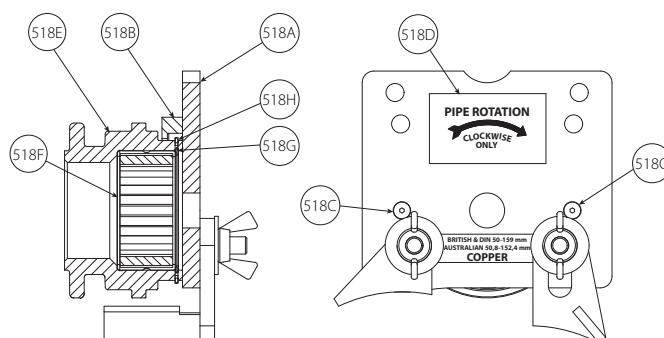
** Not shown

Refer to pages 13 - 15 for images of product labels



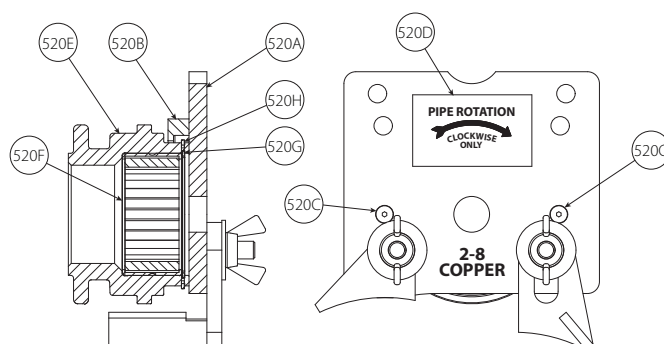
UPPER ROLL ASSEMBLY FOR 50.8 - 152.4 MM AUSTRALIAN AND 50 - 159 MM BRITISH/DIN COPPER TUBING (ITEM 518)

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 5/8" 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) #



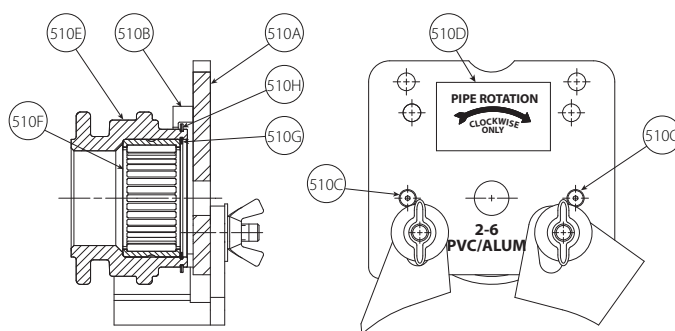
UPPER ROLL ASSEMBLY FOR 2 - 8" COPPER TUBING (ITEM 520)

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 5/8" 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 **



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 5/8" 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

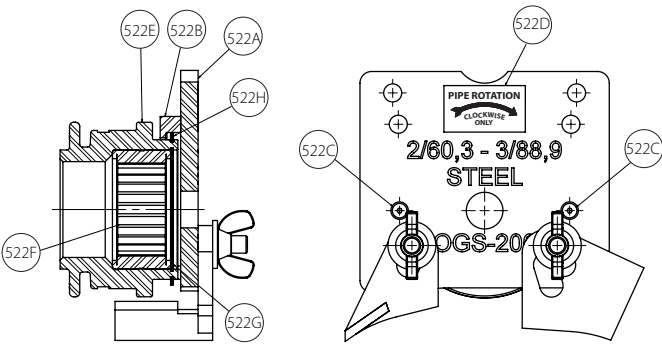


OPTIONAL UPPER ROLL COVER/GUARD ASSEMBLIES

UPPER ROLL GUARD ASSEMBLY FOR OGS-200
2"/60.3MM - 3"/88.9MM STEEL PIPE (ITEM 522)

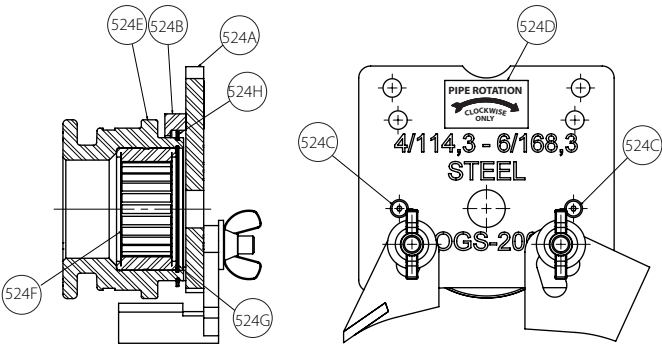
Item #	Part #	Qty.	Description
**	R9S2268UA3	1	Upper Roll Assembly (Includes Items 522A – 522H)
522A	R920268WLD	1	Upper Roll Guard
522B	R1022720FS	1	Upper Roll Guard Cover Ring
522C	NS09008010	2	#8 - 32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
522D	R040416LAB	1	Pipe Rotation Label #
522E	R9S2268U03	1	Upper Roll 2"/60.3mm - 3"/88.9mm
522F	NB02200001	1	Needle Bearing
522G	NT03000014	1	Snap Ring
522H	NT03000022	1	Snap Ring
**	R9S2268L03	1	Lower Roll 2"/60.3mm - 3"/88.9mm **

** Not shown
Refer to pages 13 - 15 for images of product labels



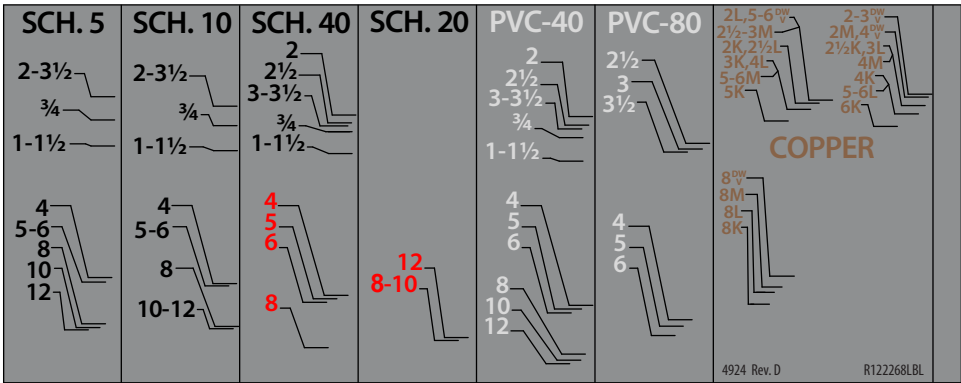
UPPER ROLL GUARD ASSEMBLY FOR OGS-200
4"/114.3MM - 6"/168.3MM STEEL PIPE (ITEM 524)

Item #	Part #	Qty.	Description
**	R9S4268UA6	1	Upper Roll Assembly (Includes Items 524A – 524H)
524A	R921268WLD	1	Upper Roll Guard
524B	R1022720FS	1	Upper Roll Guard Cover Ring
524C	NS09008010	2	#8 - 32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
524D	R040416LAB	1	Pipe Rotation Label #
524E	R9S4268U06	1	Upper Roll 4"/114.3mm - 6"/168.3mm
524F	NB02200001	1	Needle Bearing
524G	NT03000014	1	Snap Ring
524H	NT03000022	1	Snap Ring
**	R9S4268L06	1	Lower Roll 4"/114.4mm - 6"/168.3mm **

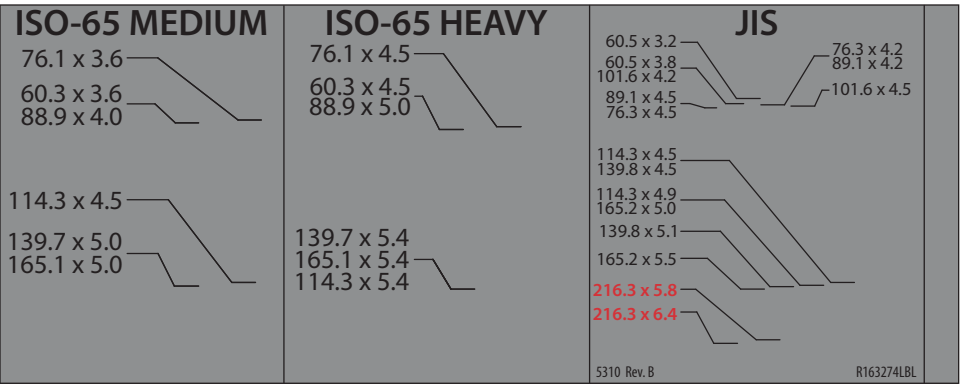


IMAGES OF THE LABELS ON PAGES 12 - 14 ARE NOT TO SCALE.

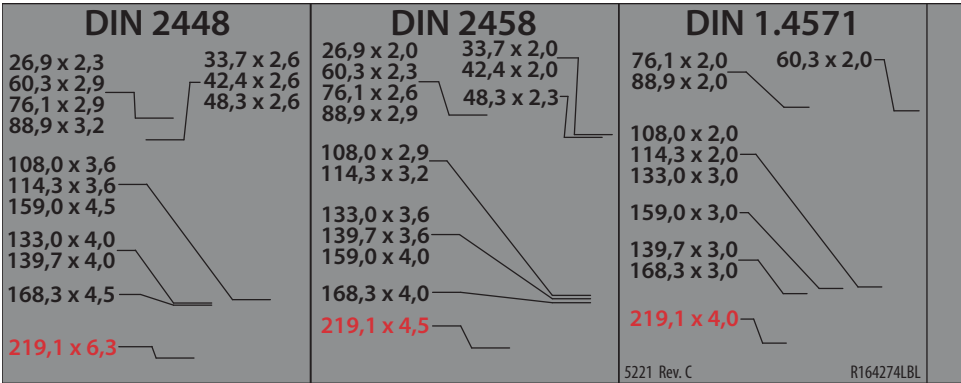
R122268LBL



R163274LBL

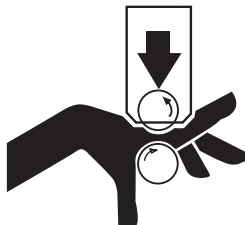


R164274LBL



R007276LBL


WARNING



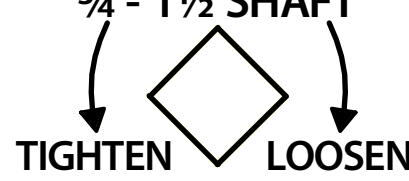
Grooving rolls can crush or cut fingers and hands.

- 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

R064268LBL

3/4 - 1 1/2 SHAFT



2 - 12 SHAFT



4865 Rev. C
R064268LBL

R034272LAB



INCREASE

DECREASE



GROOVE DIAMETER

4867 Rev. B
R034272LAB

R040416LAB

PIPE ROTATION



3318 Rev. D
R040416LAB

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.

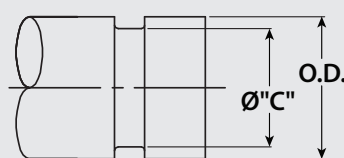
- Wear safety glasses, hardhat, foot protection, and hearing protection.
- Operate the tool only with a safety foot switch. If the tool does not contain a safety foot switch, contact Victaulic.

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

R009424LBL

 ORIGINAL GROOVE SYSTEM (OGS) ROLL GROOVE DIAMETER SPECIFICATIONS				
 4864 Rev. E R009424LBL				
SIZE	O.D.		Ø "C"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
¾	1.060 [26.9]	1.040 [26.4]	0.938 [23.8]	0.923 [23.4]
1	1.328 [33.7]	1.302 [33.1]	1.190 [30.2]	1.175 [29.9]
1 ¼	1.676 [42.6]	1.644 [41.8]	1.535 [39.0]	1.520 [38.6]
1 ½	1.919 [48.7]	1.881 [47.8]	1.775 [45.1]	1.760 [44.7]
2	2.399 [60.9]	2.351 [59.7]	2.250 [57.2]	2.235 [56.8]
2 ½	2.904 [73.8]	2.846 [72.3]	2.720 [69.1]	2.702 [68.6]
3	3.535 [89.8]	3.469 [88.1]	3.344 [84.9]	3.326 [84.5]
3 ½	4.040 [102.6]	3.969 [100.8]	3.834 [97.4]	3.814 [96.9]
4	4.545 [115.4]	4.469 [113.5]	4.334 [110.1]	4.314 [109.6]
4 ½	5.050 [128.3]	4.969 [126.2]	4.834 [122.8]	4.814 [122.3]
5	5.619 [142.7]	5.532 [140.5]	5.395 [137.0]	5.373 [136.5]
6	6.688 [169.9]	6.594 [167.5]	6.455 [164.0]	6.433 [163.4]
203.2 mm	8.063 [204.8]	7.969 [202.4]	7.816 [198.5]	7.791 [197.9]
8	8.688 [220.7]	8.594 [218.3]	8.441 [214.4]	8.416 [213.8]
254.0 mm	10.063 [255.6]	9.969 [253.2]	9.812 [249.2]	9.785 [248.5]
10	10.813 [274.7]	10.719 [272.3]	10.562 [268.3]	10.535 [267.6]
304.8 mm	12.063 [306.4]	11.969 [304.0]	11.781 [299.2]	11.751 [298.5]
12	12.813 [325.5]	12.719 [323.1]	12.531 [318.3]	12.501 [317.5]
14 OD	14.063 [357.2]	13.969 [354.8]	13.781 [350.0]	13.751 [349.3]
15 OD	15.063 [382.6]	14.969 [380.2]	14.781 [375.4]	14.751 [374.7]
16 OD	16.063 [408.0]	15.969 [405.6]	15.781 [400.8]	15.751 [400.1]
18 OD	18.063 [458.8]	17.969 [456.4]	17.781 [451.6]	17.751 [450.9]
20 OD	20.063 [509.6]	19.969 [507.2]	19.781 [502.4]	19.751 [501.7]
22 OD	22.063 [560.4]	21.969 [558.0]	21.656 [550.1]	21.626 [549.3]
24 OD	24.063 [611.2]	23.969 [608.8]	23.656 [600.9]	23.626 [600.1]
26 OD	26.063 [662.0]	25.937 [658.8]	25.500 [647.7]	25.437 [646.1]
28 OD	28.063 [712.8]	27.937 [709.6]	27.500 [698.5]	27.437 [696.9]
30 OD	30.063 [763.6]	29.937 [760.4]	29.500 [749.3]	29.437 [747.7]
32 OD	32.063 [814.4]	31.937 [811.2]	31.500 [800.1]	31.437 [798.5]
36 OD	36.063 [916.0]	35.937 [912.8]	35.500 [901.7]	35.437 [900.1]
42 OD	42.063 [1068.4]	41.937 [1065.2]	41.500 [1054.1]	41.437 [1052.5]
48 OD	48.063 [1220.8]	47.937 [1217.6]	47.500 [1206.5]	47.437 [1204.9]

R062260LBL

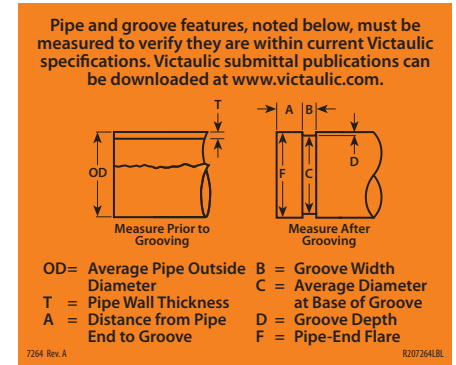


R157272LBL

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

3373 Rev. C R157272LBL

R207264LBL



VE270FSD and VE271FSD Roll Grooving Tools
