
VE272SFS Roll Grooving Tool



OGS
EndSeal™

PARTS ORDERING INFORMATION

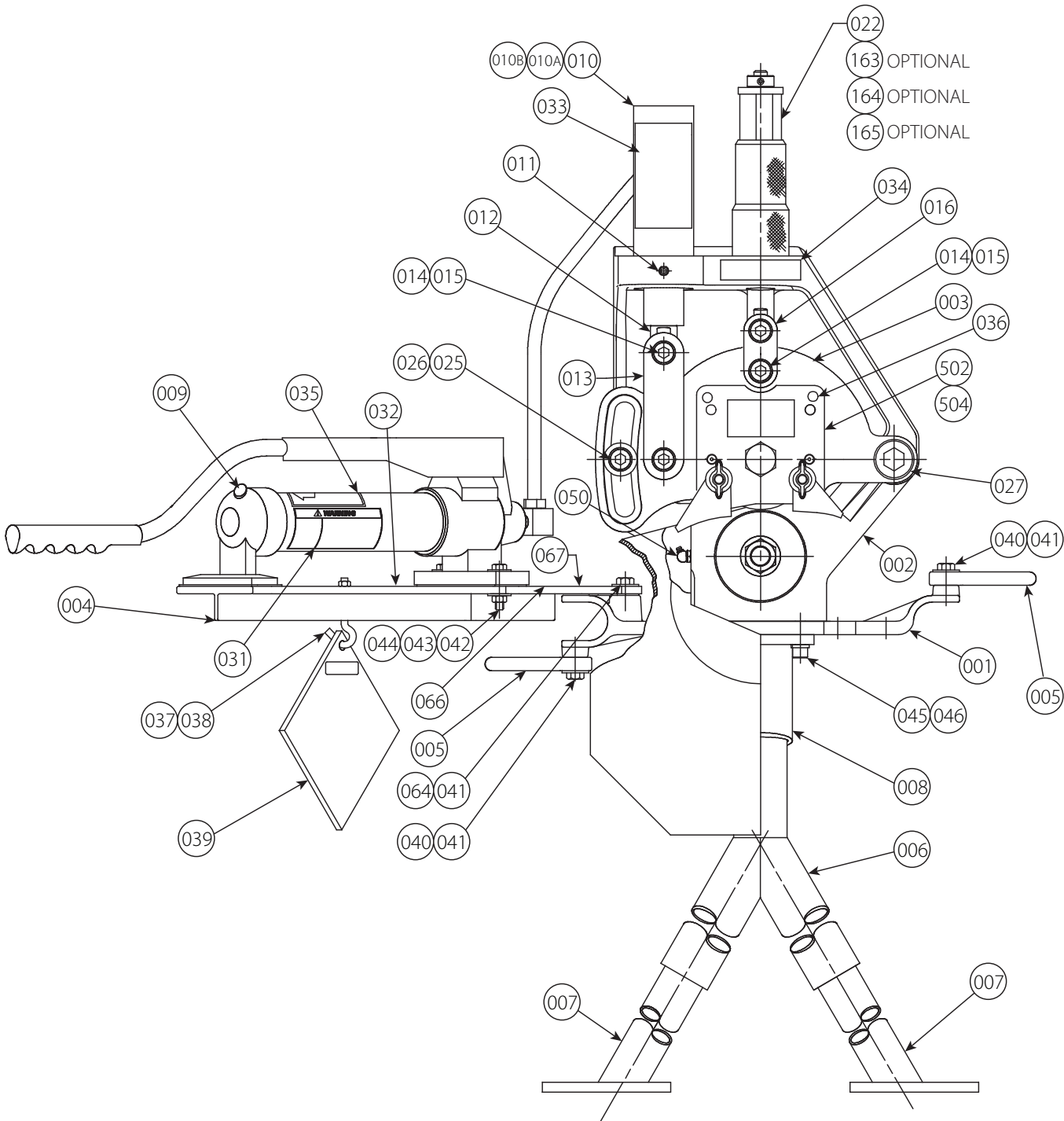
When ordering parts, the following information is necessary for Victaulic to process the order promptly:

1. Tool Model Number – VE272SFS
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

VE272SFS MAIN ASSEMBLY



VE272SFS MAIN ASSEMBLY (CONTINUED)

Item #	Part #	Qty.	Description
001	R0012720FS	1	Base
002	R0022720FS	1	Body
003	R003268MCH	1	Arm
004	R004272PLT	1	Pump Bracket
005	R005272PLT	2	Base Handle
006	R0062720FS	1	"Y" Upper Leg Support
007	R0072720FS	2	Leg
008	R0082720FS	1	Leg Base with Guard
009	R2012610FS	1	Hydraulic Hand Pump Assembly ##
009C	NHYD000040	1	Hand Pump Repair Kit (P37-SP006 Updated Design Power X Hand Pump Only, Not Shown)†
009F	NH50000077	1	Hand Pump Repair Kit (P-59 Original Design Hand Pump Only, Not Shown)†
010	NH01000008	1	Cylinder ###
010A	NHYD000039	1	Cylinder Repair Kit PowerX C10-XX / PSK-C10 ‡
010B	NH50000001	1	Cylinder Repair Kit SPX Power Team 300116
011	NS80060008	1	3/8 - 16 UNC x 1/2" Lg. Brass Tip Screw
012	R0122720FS	1	Cylinder Adapter
013	R0132720FS	2	Link - Cylinder to Arm
014	NS05100112	4	.625 x 1.625 Lg. Hex Socket Hd. Shoulder Screw, Blk. Ox.
015	NN16080000	4	1/2 - 13 UNC Heavy Hex Nylon Insert Lock Nut, Pltd.
016	R116268PLT	2	Link - Depth Adjuster to Arm
022	R122268LBL	1	Pipe Size Groove Depth Label #
025	R0252720FS	1	Guide Washer
026	R019226MCH	1	.625 x 1.00 Lg. Hex Socket Hd. Shoulder Screw
027	NS05160014	1	1.00 x .875 Lg. Hex Socket Hd. Shoulder Screw, Blk. Ox.
031	R031272LAB	1	Instructions Warning Label #
032	R009424LBL	1	"C" Diameter Label for Standard Pipe #
033	R033272LAB	1	Pinch Points Warning Label #
034	R034272LAB	1	Depth Stop Adjustment Direction Label #
035	R062260LBL	1	Hydraulic Hand Pump Label #
036	NP11006100	2	3/8 x 1.00" Lg. Groove Pin, Type H
037	NS40040000	1	1/4 - 20 UNC x 2 3/8" Lg. Hook Bolt with Nut
038	NN01040000	1	1/4 - 20 UNC Hex Nut, Pltd.
039	R0392720FS	1	Guard Setting Pad Assembly
040	NS01060100	4	3/8 - 16 UNC x 1.00" Lg. Hex Hd. Screw, Pltd.
041	NW01060000	6	3/8" Flat Washer, Pltd.
042	NS01050108	2	3/16 - 18 UNC x 1 1/2" Lg. Hex Hd. Screw, Pltd.
043	NW01050000	4	3/16" Flat Washer, Pltd.
044	NN01050000	2	3/16 - 18 UNC Hex Nut, Pltd.
045	NS03060108	4	3/8 - 16 UNC x 1 1/2" Lg. Socket Hd. Cap Screw, Blk. Ox.
046	NW03060000	4	3/8" Lock Washer, Pltd.
050	NM01000001	2	65° Grease Fitting, 1/8" NPT
064	NS01060014	2	3/8 - 16 UNC x 7/8" Lg. Hex Hd. Screw, Pltd.

Item #	Part #	Qty.	Description
065	R069272LAB	1	Name Plate #
066	R064268LBL	1	Tightening Direction Label #
067	R207264LBL	1	Groove Profile Information Label #
163	R163274LBL	1	Groove Depth Label for ISO-65 and JIS Pipe #
164	R164274LBL	1	Groove Depth Label for JIS Pipe #
170	R900268LA1	1	Lower Roll Assembly for 3/4" Steel Pipe **
180	R901268LA2	1	Lower Roll Assembly for 1 - 1 1/2" Steel Pipe **
190	R190272ASY	1	Arbor Assembly for 2 - 12" Pipe ***
400	R4002720FS	1	Stabilizer Assembly **
500	R9A0268U02	1	Upper Roll Assembly for 3/4 - 1 1/2" Steel Pipe **
502	R9A2272U06	1	Upper Roll/Cover Guard Assembly for 2 - 6" Steel Pipe *
504	R9A8272U12	1	Upper Roll/Cover Guard Assembly for 8 - 12" Steel Pipe
505	R512260VE0	1	Lower Roll Removal Tool (Not Shown)

† Refer to page 8 for additional information.

‡ For 300116 POWER TEAM only.

* Standard. Refer to pages 11 - 13 for optional upper roll cover/guard assemblies for grooving 3/4 - 1 1/2" pipe sizes and other pipe materials.

** Optional, not shown.

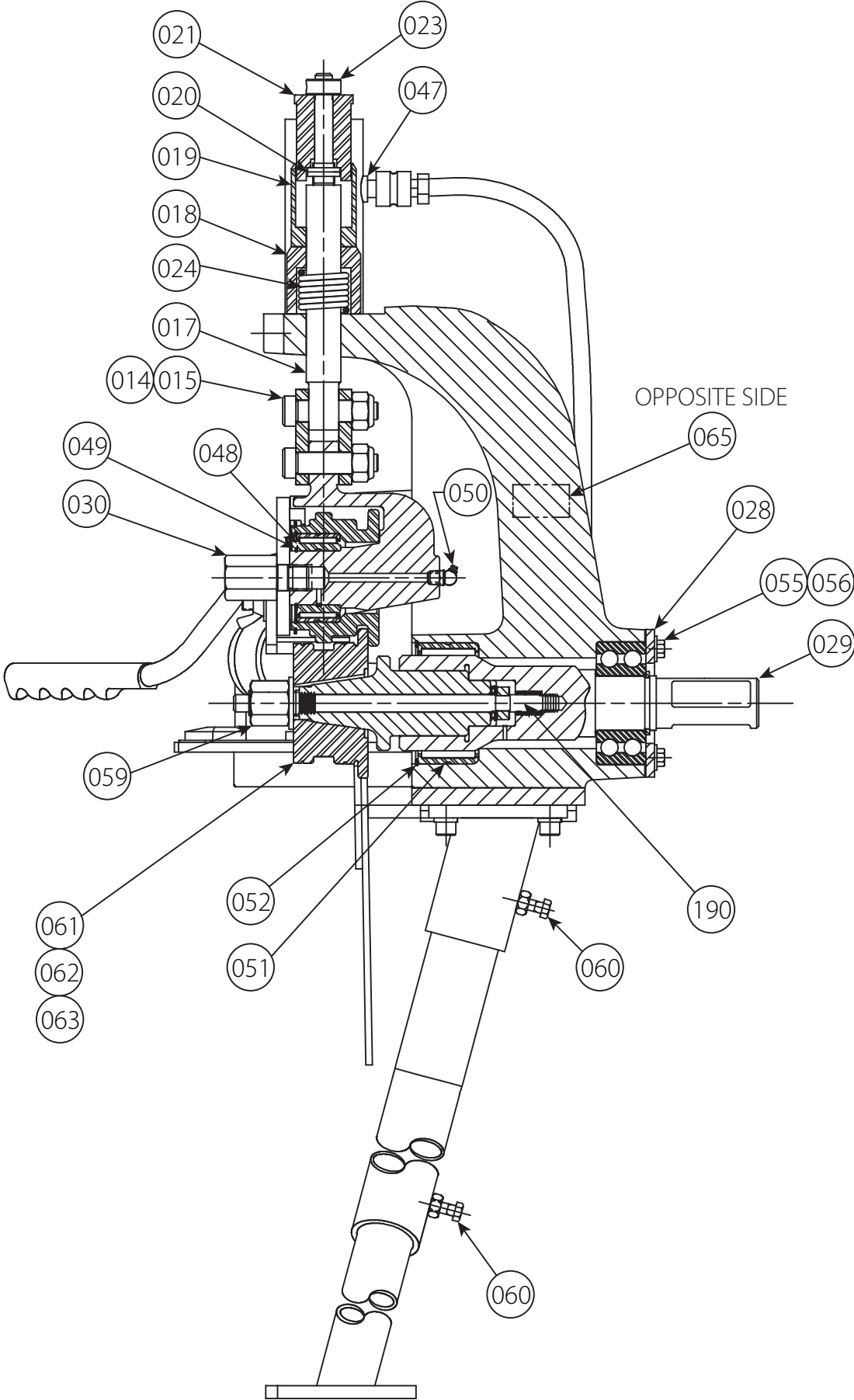
*** Standard, not shown. Refer to page 10 for optional arbor assemblies for grooving 3/4" and 1 - 1 1/2" pipe sizes.

Refer to pages 14 - 15 for images of product labels

Additional parts required, see items 031 and 035

Additional parts required, see item 033

VE272SFS MAIN ASSEMBLY (CONTINUED)



VE272SFS MAIN ASSEMBLY (CONTINUED)

Item #	Part #	Qty.	Description
014	NS05100112	4	.625 x 1.625 Lg. Hex Socket Hd. Shoulder Screw, Blk. Ox.
015	NN16080000	4	½ - 13 UNC Heavy Hex Nylon Insert Lock Nut, Pltd.
017	R0172720FS	1	Depth Adjuster Shaft
018	R0182720FS	1	Depth Adjuster Lock
019	R0192720FS	1	Depth Adjuster
020	R0202720FS	2	Pipe Size Indicator Calibrator
021	R0212720FS	1	Pipe Size Indicator Barrel #
022	R122268LBL	1	Pipe Size Groove Depth Label #
023	NS95040000	1	Collar with Set Screw
024	NM03000015	1	Spring
028	R0282720FS	1	Back Cover Plate
029	R029266MCH	1	Main Shaft ††
030	R0302720FS	1	Upper Roll Guard Cover Screw
031	R031272LAB	1	Instructions Warning Label #
032	R009424LBL	1	"C" Diameter Label for Standard Pipe #
033	R033272LAB	1	Pinch Points Warning Label #
034	R034272LAB	1	Depth Stop Adjustment Direction Label #
035	R062260LBL	1	Hydraulic Hand Pump Label #
047	NH50000018	1	Ram Half Coupler
048	NB04156002	1	Inner Race
049	NT03000017	1	Snap Ring
050	NM01000001	2	65° Grease Fitting, ½" NPT
051	NB02275002	1	Needle Bearing
052	NT03000015	1	Snap Ring
055	NS01040010	4	¼ - 20 UNC x ¾" Lg. Hex Hd. Screw, Pltd.
056	NW03040000	4	¼" Lock Washer, Pltd.
059	R191272FNH	1	Lower Roll Nut
060	NS01050012	3	⅝ - 18 UNC x ¾" Lg. Hex Hd. Screw, Grade 5, Pltd.
061	R902272L03	1	Lower Roll for 2 - 3 ½" Steel Pipe
062	R904272L06	1	Lower Roll for 4 - 6" Steel Pipe
063	R908272L12	1	Lower Roll for 8 - 12" Steel Pipe
065	R069272LAB	1	Name Plate #
066	R064268LBL	1	Tightening Direction Label #
067	R207264LBL	1	Groove Profile Information Label #
163	R163274LBL	1	Groove Depth Label for ISO-65 and JIS Pipe #
164	R164274LBL	1	Groove Depth Label for JIS Pipe #
170	R900268LA1	1	Lower Roll Assembly for ¾" Steel Pipe **
180	R901268LA2	1	Lower Roll Assembly for 1 - 1 ½" Steel Pipe **

Item #	Part #	Qty.	Description
190	R190272ASY	1	Arbor Assembly for 2 - 12" Pipe ***
400	R4002720FS	1	Stabilizer Assembly **
500	R9A0268U02	1	Upper Roll Assembly for ¾ - 1 ½" Steel Pipe **
502	R9A2272U06	1	Upper Roll/Cover Guard Assembly for 2 - 6" Steel Pipe *
504	R9A8272U12	1	Upper Roll/Cover Guard Assembly for 8 - 12" Steel Pipe
505	R512260VE0	1	Lower Roll Removal Tool (Not Shown)

† Refer to page 8 for additional information.

†† Refer to page 6 for additional information.

‡ For 300116 POWER TEAM only.

* Standard. Refer to pages 11 - 13 for optional upper roll cover/guard assemblies for grooving ¾ - 1 ½" pipe sizes and other pipe materials.

** Optional, not shown.

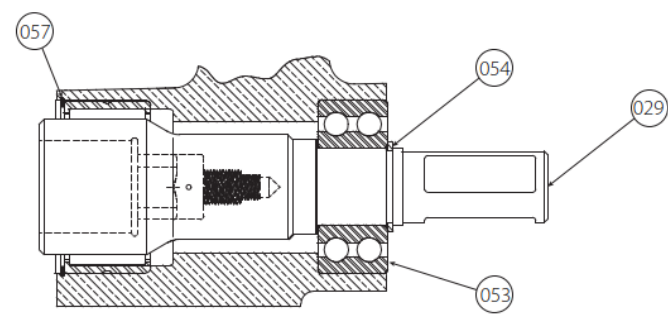
*** Standard, not shown. Refer to page 10 for optional arbor assemblies for grooving ¾" and 1 - 1 ½" pipe sizes.

Refer to pages 14 - 15 for images of product labels

Additional parts required, see items 031 and 035

Additional parts required, see item 033

VE272SFS MAIN SHAFT

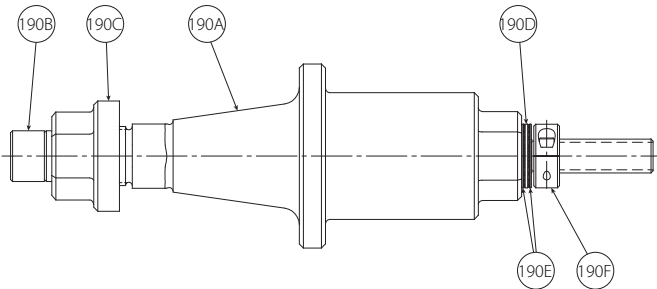


Item #	Part #	Qty.	Description
029	R029266MCH	1	Main Shaft
053	NB01157002	1	40mm ID x 90mm OD x 36.5mm Wide Double Row Angular Contact Ball Bearing
054	NT03000018	1	Snap Ring
057	NT03000015	1	Snap Ring

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 Design “B”.

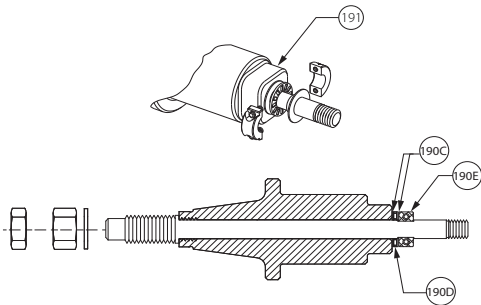
DESIGN “A” - SQUARE DRIVE ARBOR ASSEMBLY FOR 2 - 12” PIPE



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

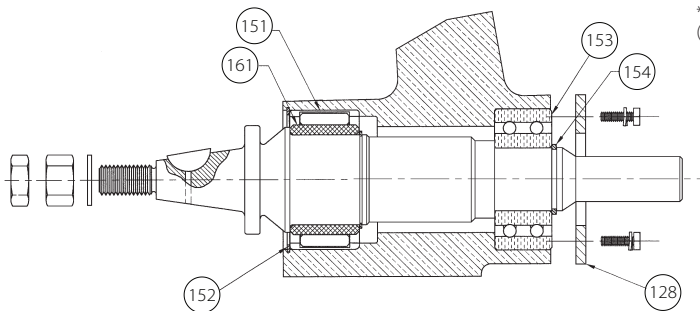
* Indicates additional items required or recommended when ordering.

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



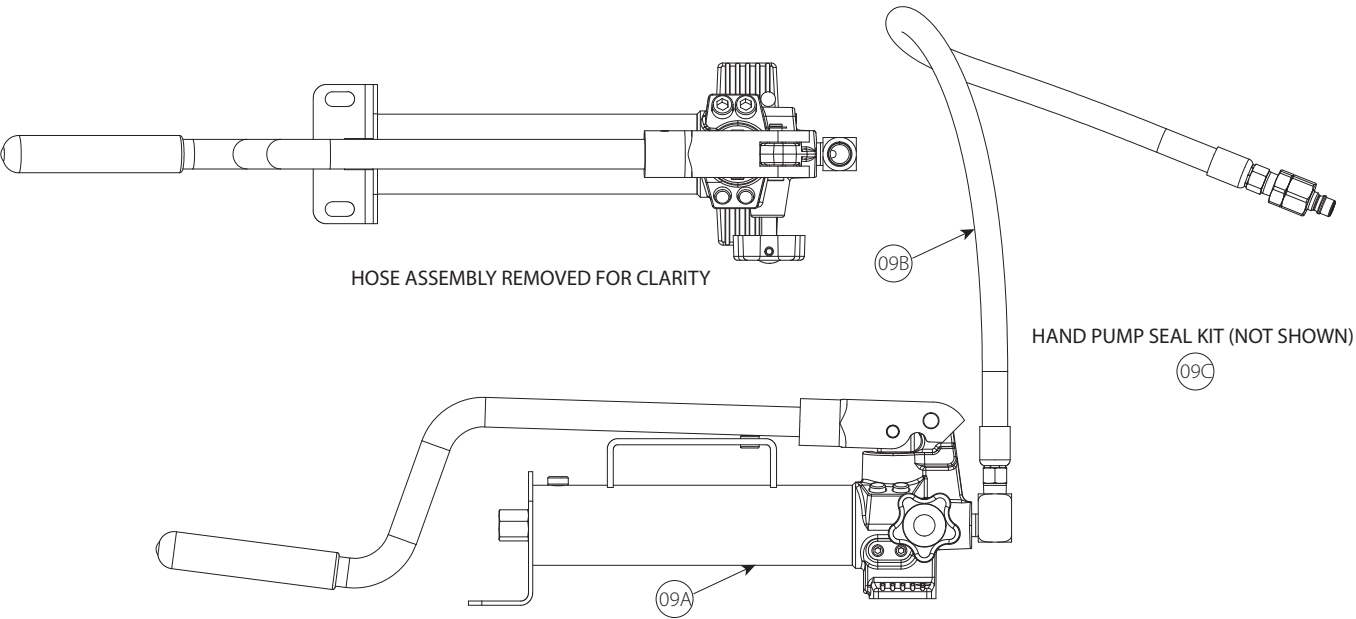
** For reference only. Contact Victaulic to verify application.

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



*** For reference only. Use part number R195268KIT and R029266MCH (includes Design A arbor item # 190) with 2-12” lower rolls (items # 50, 51, 52).

HYDRAULIC HAND PUMP ASSEMBLY (UPDATED DESIGN)

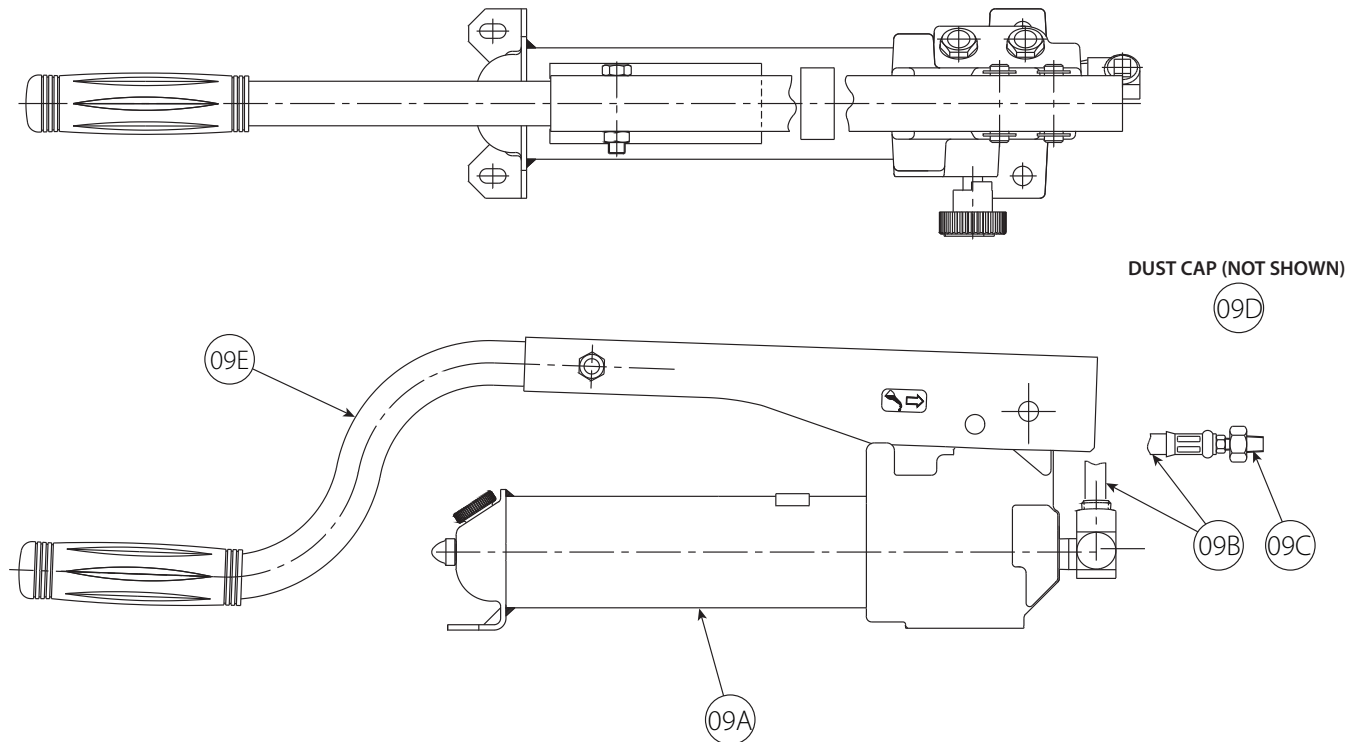


Item #	Part #	Qty.	Description
09A	R2012610FS	1	Hand Pump*
09B	NH02006002	1	Hydraulic Hose (25-inch Length with 3/8 NPT Ends)

Item #	Part #	Qty.	Description
09C	NHYD000040	1	Hand Pump Repair Kit (P37-SP006 Updated Design Power X Hand Pump Only, Not Shown)*

*Contact Victaulic to confirm model number.

HYDRAULIC HAND PUMP ASSEMBLY (ORIGINAL DESIGN)*

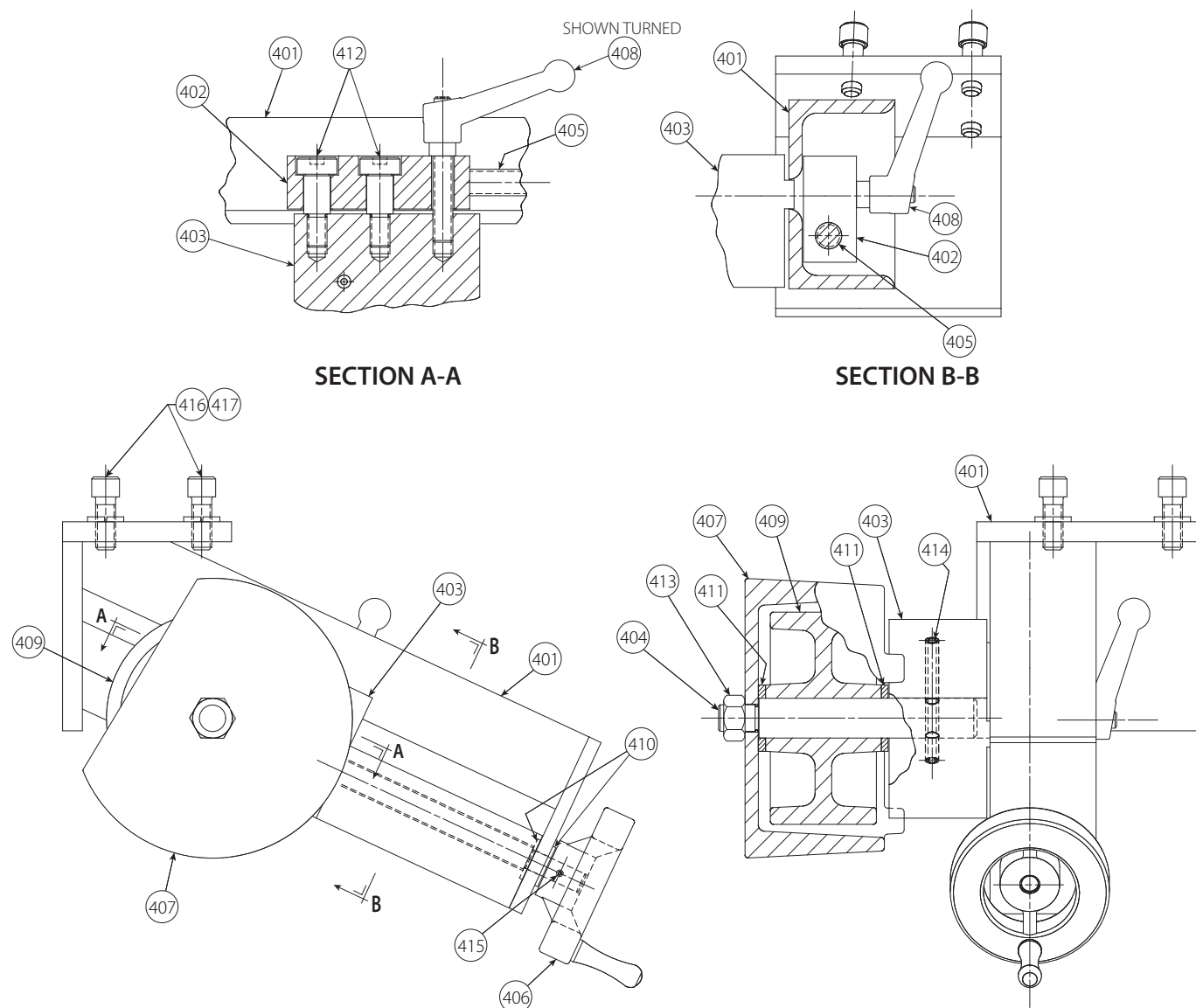


Item #	Part #	Qty.	Description
09A	-	1	Hand Pump*
09B	NH02006002	1	Hydraulic Hose (25-inch Length with 3/8 NPT Ends)
09C	NH50000017	1	Male Hose Half Coupler
09D	NH50000015	1	Dust Cap (covers item 09C)

Item #	Part #	Qty.	Description
09E	NH50000076	1	Curved Handle
09F	NH50000077	1	Hand Pump Repair Kit (P-59 Original Design Hand Pump Only, Not Shown)*

*Contact Victaulic

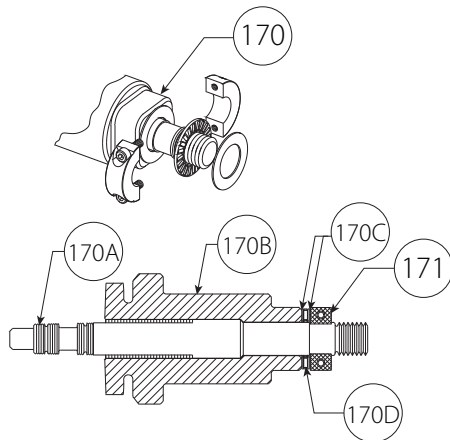
VE272SFS STABILIZER ASSEMBLY (OPTIONAL)



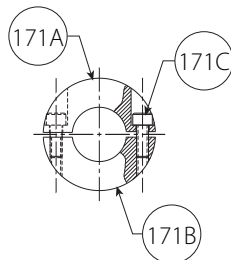
Item #	Part #	Qty.	Description
400	R4002720FS	1	Stabilizer Assembly (Includes Items 401-417)
401	R4012720FS	1	Stabilizer Body
402	R402416PLT	1	Stabilizer Guide Nut
403	R403416PLT	1	Stabilizer Guide
404	R404416MAC	1	Stabilizer Wheel Shaft
405	R4052720FS	1	Stabilizer Adjustment Screw
406	R406416MAC	1	Stabilizer Handwheel
407	R407416PNT	1	Stabilizer Wheel Guard
408	NM04000002	1	Locking Handle
409	NM05000004	1	4" x 2" Polyurethane Wheel

Item #	Part #	Qty.	Description
410	NB05037002	2	Thrust Washer
411	NB05075004	2	Thrust Washer
412	NS05080012	2	½" 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
416	NS02060100	4	⅜" - 16 UNC x 1" Lg. Hex Socket Hd. Cap Screw, Blk. Ox.
417	NW03060000	4	⅜" Std. Lock Washer, Pltd.

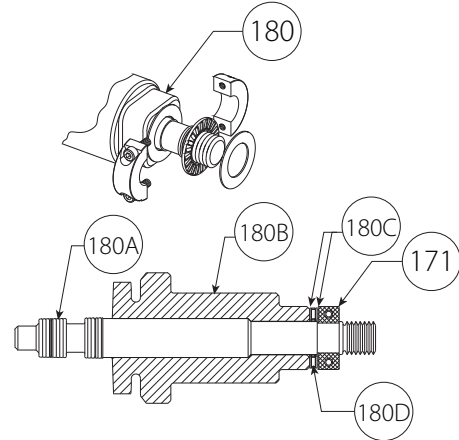
OPTIONAL VE272SFS ARBOR ASSEMBLIES



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



Shaft Collar Assembly
(Item 171)



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

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
170	RX00268LA1	1	Arbor Assembly for 3/4" Pipe **
180	RX01268LA2	1	Arbor Assembly for 1 - 1 1/2" Pipe **
170A	RX75268L75	1	Lower Roll for 3/4" Stainless Steel Pipe
180A	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. *

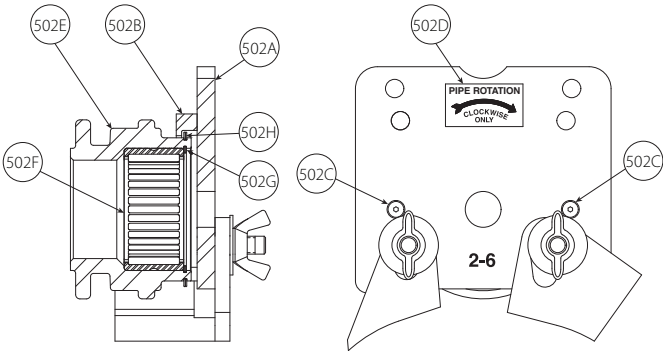
* Included in assembly. Not available for individual sale.
** Indicates additional items required or recommended when ordering.

STANDARD VE272SFS UPPER ROLL COVER/GUARD ASSEMBLIES

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

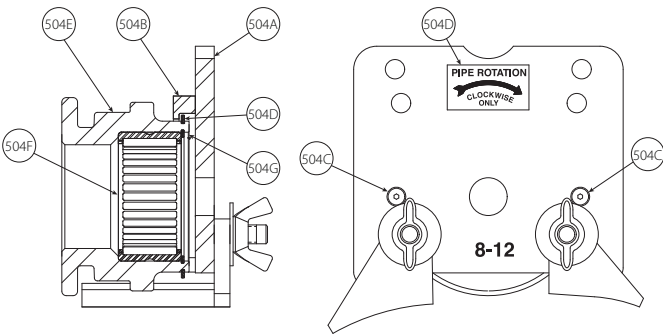
Item #	Part #	Qty.	Description
-	R9A2272U06	1	Upper Roll Assembly (Includes Items 502A – 502H)
502A	R510268WLD	1	Upper Roll Guard
502B	R1022720FS	1	Upper Roll Guard Cover Ring
502C	NS09008010	2	#8 - 32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
502D	R040416LAB	1	Pipe Rotation Label #
502F	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 14 - 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 **

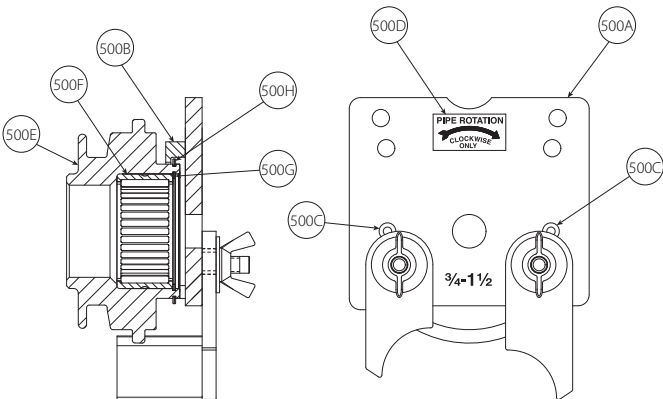


OPTIONAL VE272SFS UPPER ROLL COVER/GUARD ASSEMBLIES

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 10.



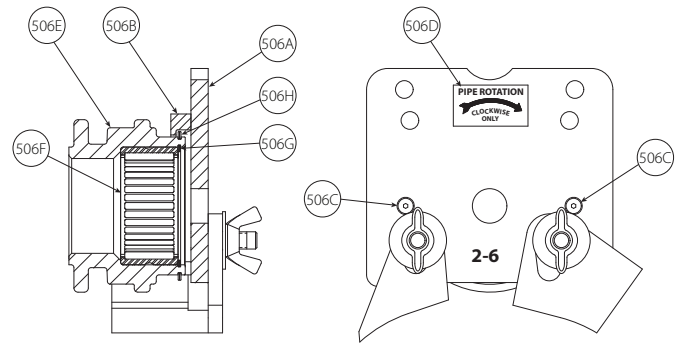
OPTIONAL VE272SFS UPPER ROLL COVER/GUARD ASSEMBLIES

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 - 3 1/2" Lower Roll for Stainless Steel Pipe **
**	RX04272L06	1	4 - 6" Lower Roll for Stainless Steel Pipe **

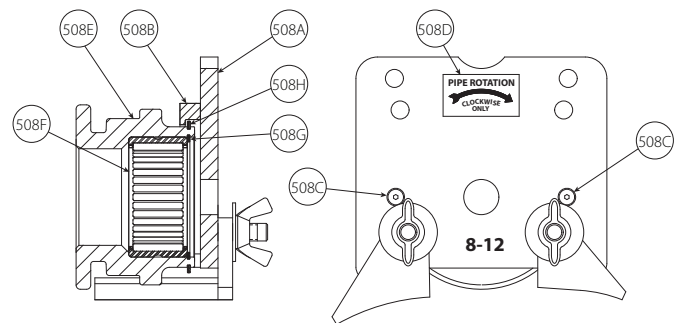
** Not shown

Refer to pages 14 - 15 for images of product labels



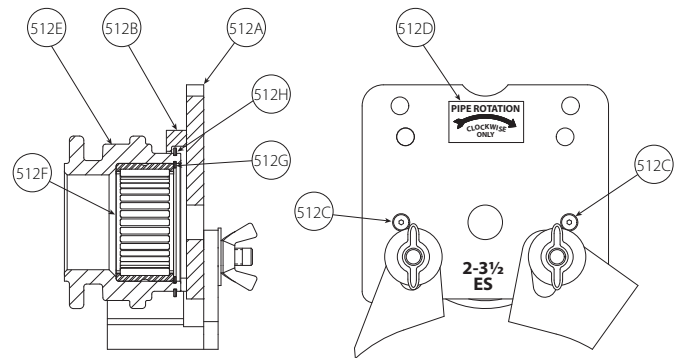
UPPER ROLL ASSEMBLY FOR 8 - 12" SCHEDULES 5S AND 10S STAINLESS STEEL PIPE (ITEM 508)

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 **



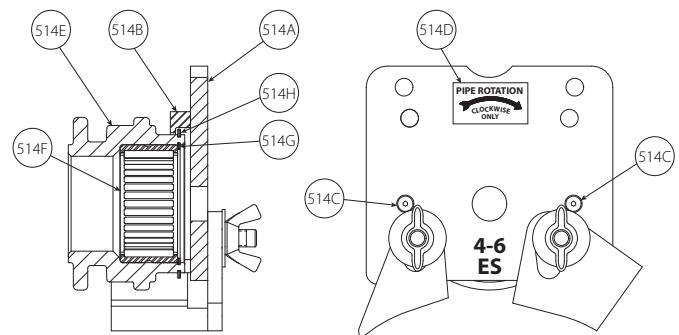
UPPER ROLL ASSEMBLY FOR 2 - 3 1/2" PIPE FOR ENDSEAL™ PRODUCTS (ITEM 512)

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	NB02-00001	1	Needle Bearing
512G	NT03000014	1	Snap Ring
512H	NT03000022	1	Snap Ring
**	RZ02272L03	1	2" - 3 1/2" 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 **



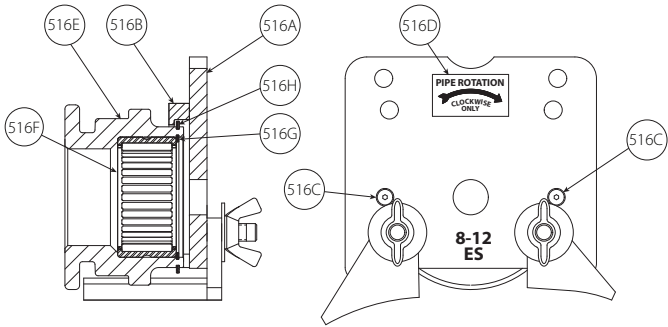
OPTIONAL VE272SFS UPPER ROLL COVER/GUARD ASSEMBLIES

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

Item #	Part #	Qty.	Description
**	R-ZA8-272-U12	1	Upper Roll Assembly (Includes Items 516A – 516H)
516A	R-Z20-268-WLD	1	Upper Roll Guard
516B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
516C	N-S09-008-010	2	#8 - 32 UNC x ¾" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
516D	R-040-416-LAB	1	Pipe Rotation Label #
516F	N-B02-200-001	1	Needle Bearing
516G	N-T03-000-014	1	Snap Ring
516H	N-T03-000-022	1	Snap Ring
**	R-Z08-272-L12	1	8" - 12" Lower Roll for EndSeal™ Pipe **

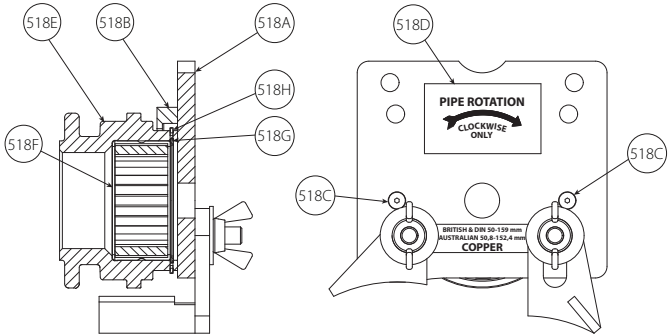
** Not shown

Refer to pages 14 - 15 for images of product labels



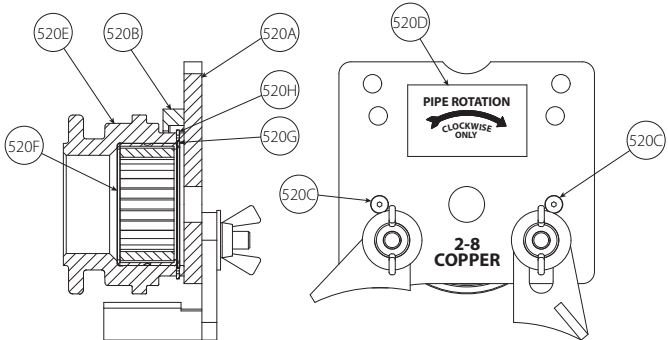
UPPER ROLL ASSEMBLY FOR 50.8 - 152.4 MM
AUSTRALIAN AND 50 - 159 MM BRITISH/DIN
COPPER TUBING (ITEM 518)

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 ¾" 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) #



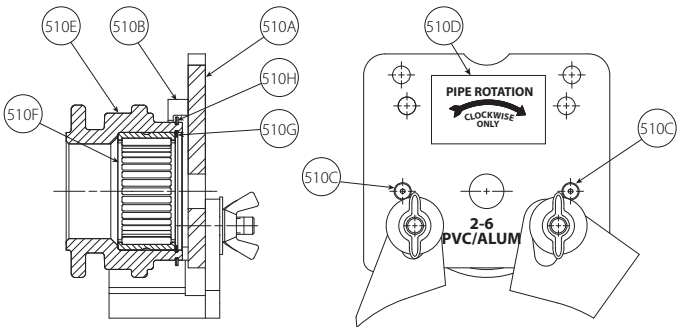
UPPER ROLL ASSEMBLY FOR 2 - 8" COPPER
TUBING (ITEM 520)

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 ¾" 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 **



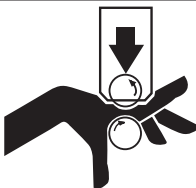
UPPER ROLL ASSEMBLY FOR 2 - 6" PVC AND
ALUMINUM PIPE (ITEM 510)

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 ¾" 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 ½" Lower Roll for Aluminum and PVC
**	RP04272L06	1	4 - 6" Lower Roll for Aluminum and PVC



R033272LAB

⚠ 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 rollers. 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.
- Always groove pipe in a **CLOCKWISE** direction.
- 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.

0585 Rev. D R033272LAB

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.

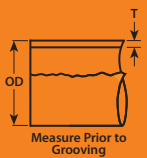
Contact Victaulic with questions regarding the safe and proper operation of tools:

Web: victaulic.com **E-Mail:** pickvic@victaulic.com **Phone:** 1-800-PICK-VIC

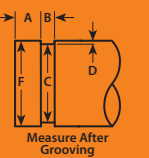
0567 Rev. E R031272LAB

R207264LBL

Pipe and groove features, noted below, must be measured to verify they are within current Victaulic specifications. Victaulic submittal publications can be downloaded at www.victaulic.com.



Measure Prior to Grooving



Measure After Grooving

OD = Average Pipe Outside Diameter
T = Pipe Wall Thickness
A = Distance from Pipe End to Groove
B = Groove Width
C = Average Diameter at Base of Groove
D = Groove Depth
F = Pipe-End Flare

7264 Rev. A R207264LBL

R034272LAB

← INCREASE

DECREASE →

GROOVE DIAMETER

4867 Rev. B R034272LAB

R062260LBL

HYDRAULIC OIL FILL
Refer to operating instructions for checking and filling procedures

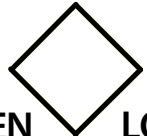


VIC-EASY® ROLL GROOVING TOOL
HYDRAULIC HAND PUMP

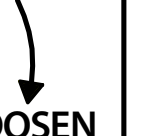
4811 Rev. B R062260LBL

R064268LBL

3/4 - 1 1/2 SHAFT



TIGHTEN

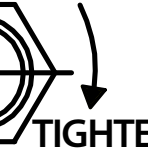


LOOSEN

2 - 12 SHAFT



LOOSEN



TIGHTEN

4865 Rev. C R064268LBL

R157272LBL

BRITISH & DIN 50 – 159 mm
AUSTRALIAN 50,8 – 152,4 MM

3373 Rev. A 11/01 R157272LBL

R069272LAB



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

MODEL

SERIAL NO.

DATE MFD.





7272 Rev. A R069272LAB

VE272SFS Roll Grooving Tool