
VE460 Roll Grooving Tool



OGS
OGS-200
AGS™
EndSeal™

PARTS ORDERING INFORMATION

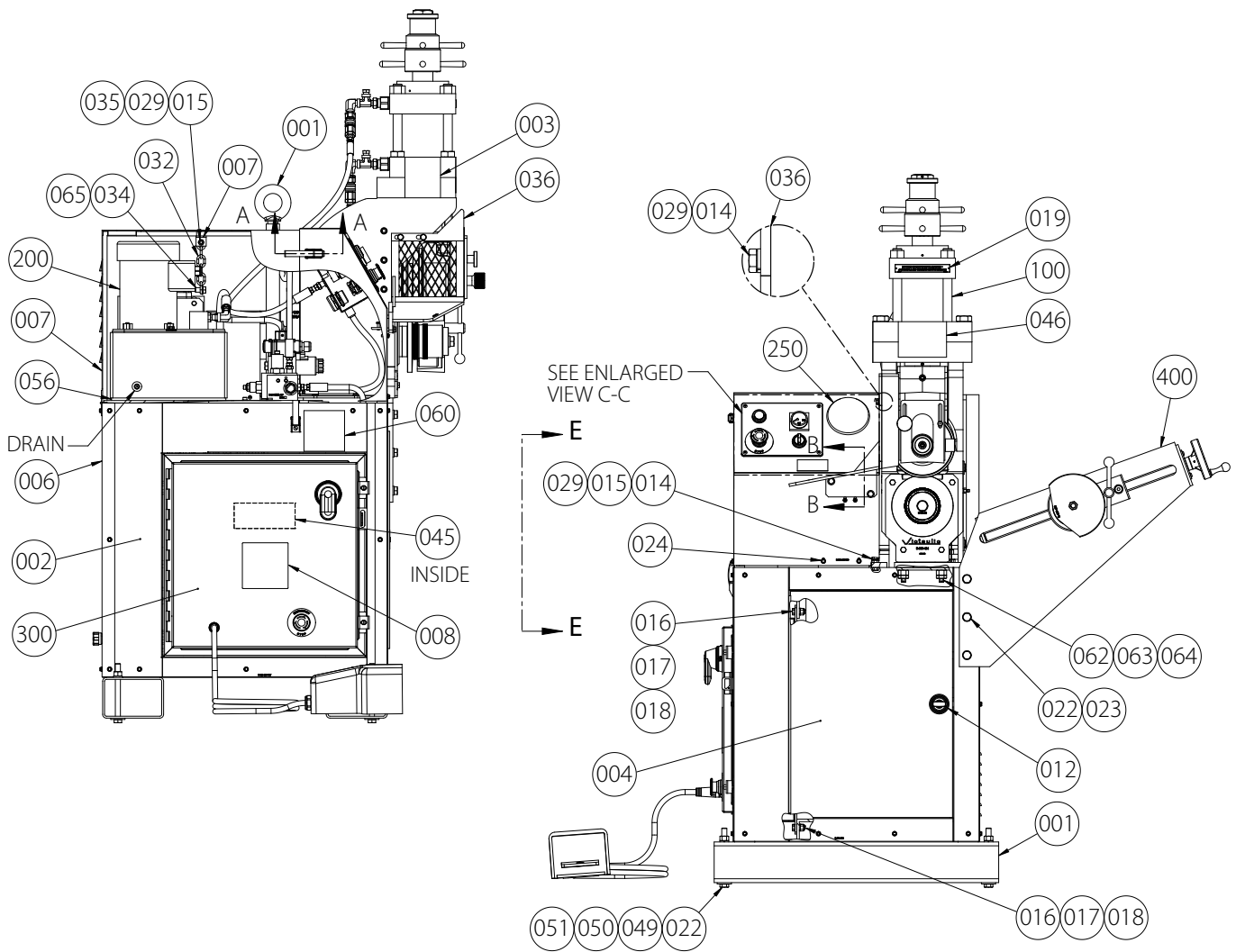
When ordering parts, the following information is necessary for Victaulic to process the order promptly:

1. Tool Model Number – VE460
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.

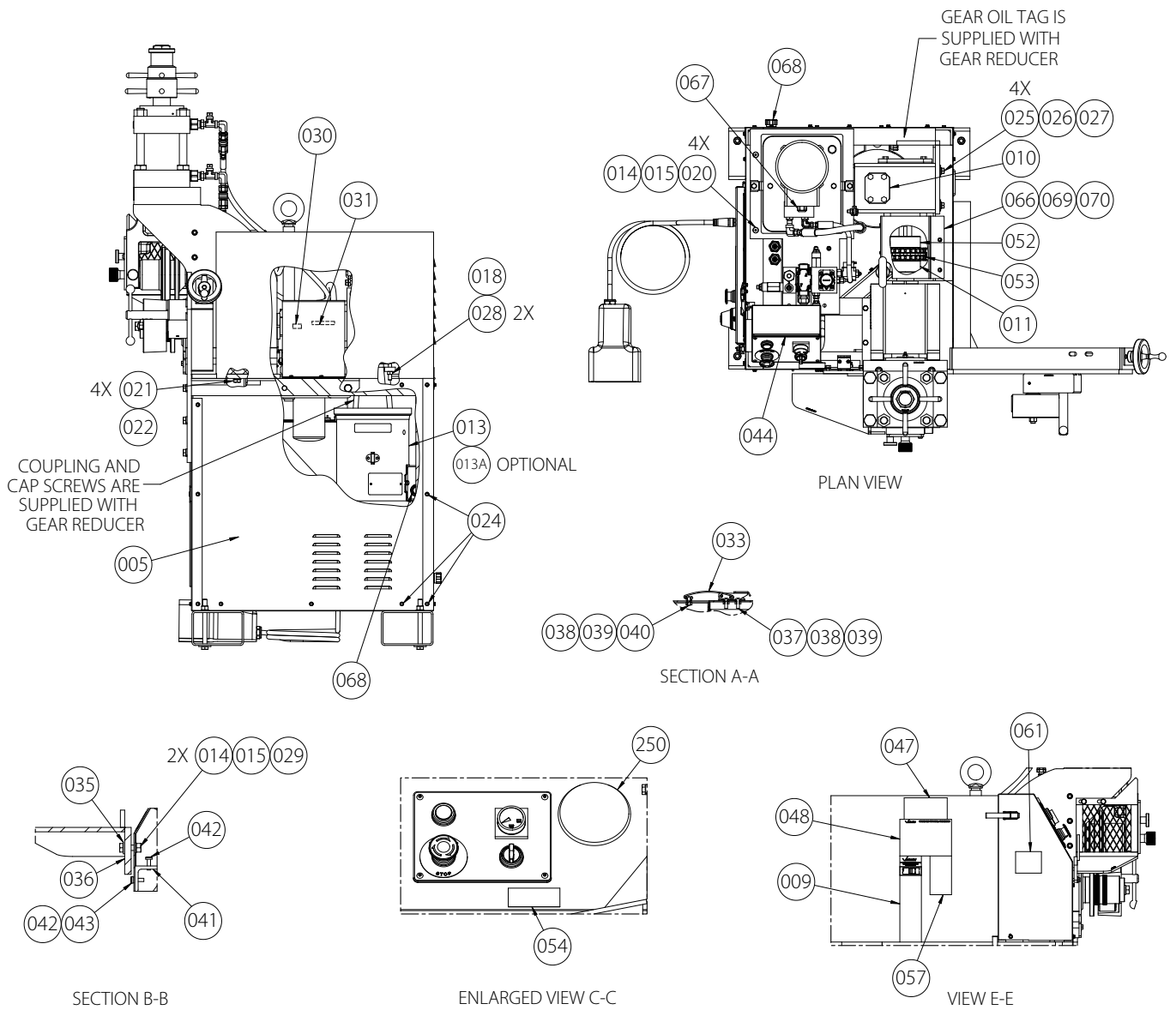
MAIN ASSEMBLY



Item #	Part #	Qty.	Description
001	R001460PNT	1	Frame, Weldment
002	R002424PNT	1	Enclosure, Left
003	R132460LBL	1	AGS Pipe Size Reference Label †
004	R004424PNT	1	Enclosure, Front with Door
005	R005424PNT	1	Enclosure, Right
006	R006424PNT	1	Enclosure, Rear
007	R007460PNT	1	Enclosure, Top
008	R008460LBL	1	Identification/Serial Number Plate †
009	R009424LBL	1	"C" Diameter Reference Label †
010	R010424VE0	1	Gear Reducer Assembly
011	NM1000001C	1	Coupling Half, 2 Dia Bore with 1/2 x 1/4 Keyway
012	NM07000001	1	Latch, Door, Flush Mount
013	NE01000001	1	Motor, 5 HP, 1740 RPM, 230/460V, 60 Hz, 3-Phase
013A	NE01000003	1	Motor, 5 HP, 1740 RPM, 380V 50/60 Hz
014	NW03050000	10	Washer, 3/16, Helical Spring-Lock
015	NN01050000	9	Nut, 3/16-18 Hex
016	NS01060100	4	Screw, 3/16-16 x 1 Hex Cap
017	NW03060000	4	Washer, 3/8, Helical Spring-Lock
018	NN01060000	6	Nut, 3/8-16 Hex
019	R148424LAB	1	Groove Diameter Adjustment Plate

Item #	Part #	Qty.	Description
020	NS04050100	4	Screw, 3/16-18 x 1 Flat Countersunk Head Cap
021	NS01080200	4	Screw, 1/2-13 x 2 x 1-1/4 Thread Hex Cap
022	NW03080000	13	Washer, 1/2, Helical Spring-Lock
023	NS01080108	5	Screw, 1/2-13 x 1-1/2 Hex Cap
024	NS30012014	44	Screw, #12-24 x 7/8 Hex Flange
025	NS02070104	4	Screw, 7/16-14 x 1-1/4 Hex Cap
026	NW01070000	4	Washer, 7/16 Nominal, 0.500 x 1.250 x 0.083
027	NW03070000	4	Washer, 3/8, Helical Spring-Lock
028	NS81060200	2	Screw, 3/8-16 x 2 Hex Socket Set, Cup Point
029	NS01050100	7	Screw, 3/16-18 x 1 Hex Cap
030	NK02080100	1	Key, Parallel, 1/2 x 1/2 x 1
031	NK02060210	1	Key, Parallel, 3/8 x 3/8 x 2-5/8
032	NM09000001	1	Chain, 2/0 Straight-Link, 0.19 Dia x 0.47 W x 0.88 L
033	NM07000002	2	Latch, Draw, Lever Tab Down, Button Keeper
034	NS01070012	1	Screw, 7/16-14 x 3/4 Hex Cap
035	NW01050000	3	Washer, 3/16 Nominal, 0.344 x 0.688 x 0.065
036	R036460PNT	1	Roll Guard
037	NS08008080	4	Screw, #8-32 x 1/2 Truss Head Machine, Slotted
038	NN01008000	6	Nut, #8-32 Hex Machine Screw
039	NW03008000	6	Washer, #8, Helical Spring-Lock

MAIN ASSEMBLY (CONTINUED)

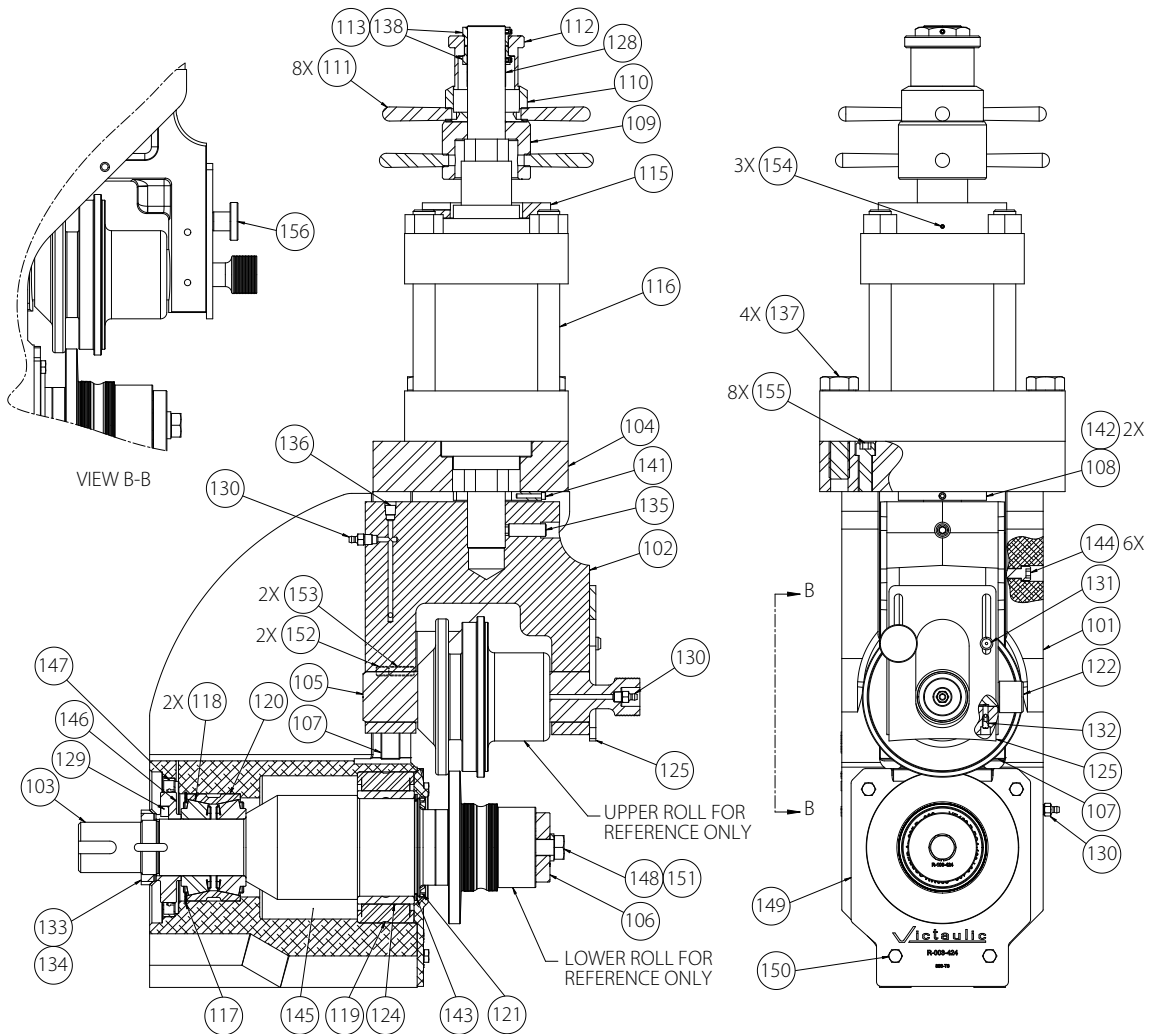


Item #	Part #	Qty.	Description
040	NS04008080	2	Screw, #8-32 x 1/2 Flat Countersunk Head Machine
041	R043424PNT	1	Guard Interlock Switch Bracket
042	NS06010010	4	Screw, #10-24 x 3/8 Pan Head Machine
043	NW03010000	2	Washer, #10, Helical Spring-Lock
044	NS21006001	2	Screw, #6-20 x 3/8 Flat Countersunk Head
045	R090424LAB	1	Danger Label †
046	R091424LAB	1	Warning Label †
047	R031272LAB	1	Instructions Warning Label †
048	R010416LAB	1	AGS Pipe Size Reference Label †
049	NS01080508	4	Screw, 1/2-13 x 5-1/2 x 1-1/4 Thread Hex Cap
050	NW01080000	4	Washer, 1/2 Nominal, Plain, 0.562 x 1.375 x 0.109
051	NN01080000	4	Nut, 1/2-13 Hex
052	NM10000015	1	Coupling Half, 1-1/2 Dia Bore with 3/8 x 3/16 Keyway
053	NM10000022	1	Coupling Chain, Steel
054	R095424LAB	1	Control Panel Warning Label †
056	R058424MCH	1	Vibration Isolator
057	R011424LBL	1	AGS Roll Groove Diameter Specification Label †
058	R077416ASY	1	AGS Guard Setting Pad Assembly (not shown)

Item #	Part #	Qty.	Description
059	R0392720FS	1	Guard Setting Pad Assembly (not shown)
061	R207264LBL	1	Groove Profile Information Label †
062	R140460FNH	2	Adjusting Stud
063	NN02080000	2	Nut, 1/2-20 Heavy Hex
064	NN04080000	2	Nut, 1/2-20 Heavy Hex Jam
065	NW01070000	1	Washer, 7/16 Nominal, 0.469 x 0.875 x 0.063
066	R051460PNT	1	Coupling Guard
067	NE06000015	1	Connector, 0.197 Dia to 0.512 Dia Range, 1/2 NPT
068	NELC000089	2	Connector, 3/8 to 3/4 Dia Cord Range
069	R052460PNT	1	Coupling Guard Bottom
70	NSCR000013	2	10-32 x 3/8 Button Head Cap Screw
100	R100460ASY	1	Tool Head Assembly
200	R260424ASY	1	Hydraulic Power Unit Assembly
250	R250436VE04	1	Hydraulic Panel Assembly
300	R300460ASY	1	Electrical Assembly
400	R400460ASY	1	Stabilizer Assembly

† Refer to pages 17-20 for images of product labels

TOOL HEAD ASSEMBLY (UPDATED DESIGN)

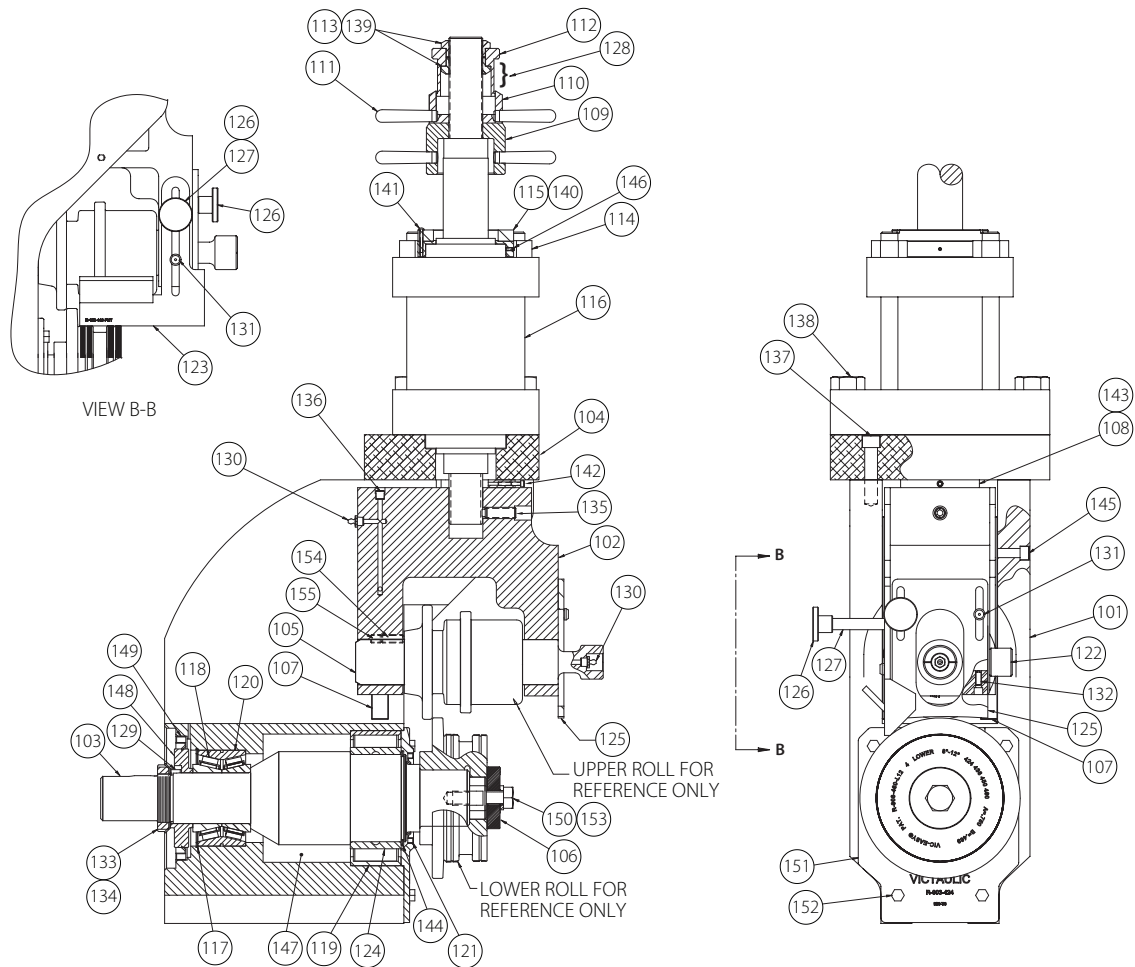


Item #	Part #	Qty.	Description
101	R101448MCH	1	Tool Head, Machining
102	R102448MCH	1	Slide, Quick Change System
103	R103460MCH	1	Main Shaft
104	R104436VE0	1	Cylinder Mounting Block
105	R105448MCH	1	Upper Shaft
106	R106424PLT	1	Lower Roll Washer
107	R107424MAC	2	Gib
108	R108436VE0	1	Slide Spacer
109	R109436VE0	1	Depth Adjuster Lock
110	R110436VE0	1	Depth Adjuster
111	R111424PLT	8	Depth Adjuster Handle
112	R112424PLT	1	Depth Adjuster Barrel
113	R113436VE0	2	Depth Adjuster Calibration Nut
115	R422460MCH	1	Base Ring
116	NM40000002	1	Cylinder, Hydraulic
117	NT53000425	1	Retaining Ring, Internal
118	NB02225001	2	Bearing, Tapered, Inner
119	NB02450001	1	Bearing, Needle Roller
120	NB04425001	1	Bearing, Cup
121	NM11000002	1	Seal, Radial Shaft
122	R122448PLT	1	Upper Shaft Pin
123	R123448PNT	1	Sliding Guard
124	NB04387001	1	Bearing Race
125	R130448PNT	1	Front Sliding Guard
128	R129460LBL	1	Pipe Size Indicator Label †
129	R164424MAC	1	Grease Seal Collar Key

Item #	Part #	Qty.	Description
130	NM01000002	3	Grease Fitting, Straight, 1/8-27 NPT
131	R131448PLT	1	Guard Retaining Stud
132	NM12000002	1	Spring Plunger, Ball-Nose, 1/4-20 Threaded
133	NB63000011	1	Locknut, Bearing
134	NB61000111	1	Lockwasher, Bearing
135	NS80080108	1	Screw, 1/2-13 x 1-1/2 Hex Socket Set, Brass Point
136	NH16002001	1	Plug, Countersunk Head, 1/8 NPT Male
137	NS01149308	4	Screw, 7/8-9 x 3-1/2 x 2 Thread Hex Cap
138	NS83010004	2	Screw, #10-32 x 1/4 Hex Socket Set, Brass Point
141	NS03008100	1	Screw, #8-32 x 1 Hex Socket Head Cap
142	NM12000001	2	Spring Plunger, Ball-Nose, #8-32 Thread
143	NT56000387	1	Retaining Ring, External
144	NS03060104	6	Screw, 3/8-16 x 1-1/4 Hex Socket Head Cap
145	NM02000001	A/R	General Purpose EP Lithium Base Grease
146	R153424MAC	1	Grease Seal Collar
147	NM11000001	1	Seal, Radial Shaft
148	NS02100200	1	Screw, 3/8-11 x 2 Hex Cap,
149	R003424MAC	1	Seal Housing, Machining
150	NS01050012	4	Screw, 3/16-18 x 3/4 Hex Cap
151	NW03100000	1	Washer, 3/8, Helical Spring-Lock
152	NS81060100	2	Screw, 3/8-16 x 1 Hex Socket Set, Cup Point
153	NS81060008	2	Screw, 3/8-16 x 1/2 Hex Socket Set, Cup Point
154	NS81006006	3	Screw, #6-32 x 3/8 Hex Socket Set, Cup Point
155	NS03080208	8	Screw, 1/2-13 x 2-1/2 Hex Socket Head Cap
156	R130460MCH	1	Front Sliding Guard Knob

† Refer to pages 17–20 for images of product labels

TOOL HEAD ASSEMBLY (ORIGINAL DESIGN)

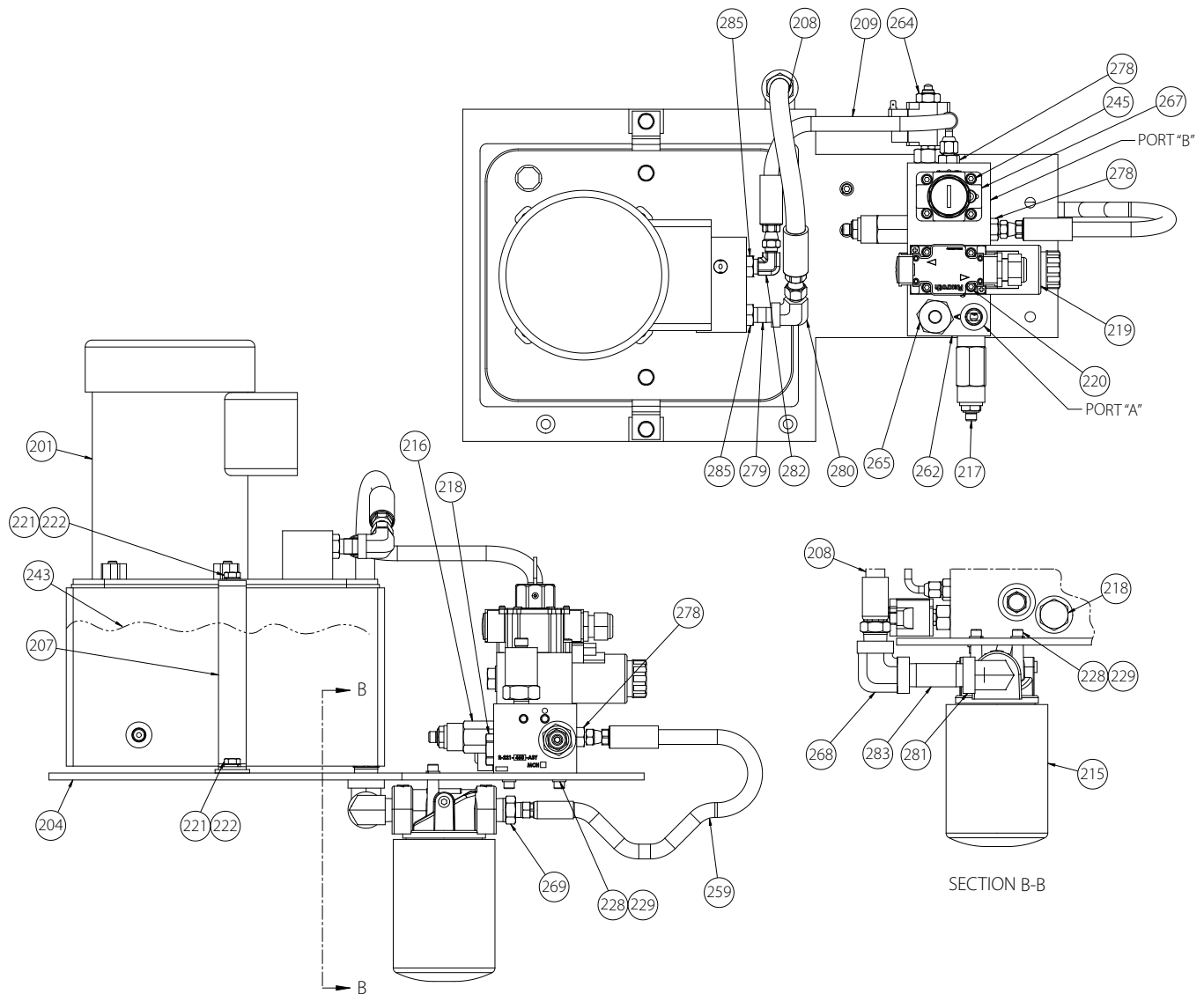


Item #	Part #	Qty.	Description
101	R101448MCH	1	Tool Head
102	R102448MCH	1	Slide, Quick Change
103	R103460MCH	1	Main Shaft
104	R104436VE0	1	Cylinder Mounting Block
105	R105448MCH	1	Upper Shaft
106	R106424PLT	1	Lower Roll Washer
107	R107424MAC	2	Gib
108	R108436VE0	1	Slide Spacer
109	R109436VE0	1	Depth Adjuster Lock
110	R110436VE0	1	Depth Adjuster
111	R111424PLT	8	Depth Adjuster Handle
112	R112424PLT	1	Depth Adjuster Barrel
113	R113436VE0	2	Depth Adjuster Calibration Nut
114	R114436VE0	1	Insulating Ring
115	R115436VE0	1	Grounding Ring
116	NM40000002	1	Cylinder
117	NT53000425	1	Retaining Ring
118	NB02225001	2	Tapered Roller Bearing
119	NB02450001	1	Roller Bearing
120	NB04425001	1	Bearing Cup
121	NM11000002	1	Grease Seal
122	R122448PLT	1	Upper Shaft Pin
123	R123448PNT	1	Sliding Guard
124	NB04387001	1	Bearing Race
125	R130448PNT	1	Front Sliding Guard
126	NM04000007	2	Knob
127	R127448PNT	1	Knob Stand-Off
128	R129460LBL	1	Pipe Size Indicator Label †

Item #	Part #	Qty.	Description
129	R164424MAC	1	Grease Seal Collar Key
130	NM01000002	2	Lube Fitting
131	R131448PLT	2	Guard Retaining Stud
132	NM12000002	1	Ball Plunger
133	NB63000011	1	Lock Nut
134	NB61000111	1	Lock Washer
135	NS80080108	1	½ - 13 UNC x 1½" Lg. Set Screw with Brass Tip
136	NH16002001	1	⅜" Flush Socket Pressure Plug
137	NS03080208	8	½ - 13 UNC x 2½" Lg. SHCS, Blk. Ox.
138	NS01149308	4	⅞ - 9 UNC x 3½" Lg. Grd. 8 Hex Bolt, Pltd.
139	NS83010004	2	#10 - 32 UNF x ¼" Lg. Set Screw with Brass Tip
140	NS04006100	2	#6 - 32 UNC x 1.00" Lg. Flat Hd. Slotted Screw, Pltd.
141	NS07006100	1	#6 - 32 UNC x 1.00" Lg. Rnd. Hd. Slotted Screw, Pltd.
142	NS03008100	1	#8 - 32 UNC x 1.00" Lg. SHCS, Blk. Ox.
143	NM12000001	2	Ball Plunger
144	NT56000387	1	Retaining Ring
145	NS03060104	6	⅜ - 16 UNC x 1¼" Lg. SHCS, Blk. Ox.
146	NS81006006	3	#6 - 32 UNC x ⅜" Lg. Cup Pt. Set Screw
147	NM02000001	A/R	General Purpose EP Lithium Base Grease
148	R153424MAC	1	Grease Seal Collar
149	NM11000001	1	Grease Seal
150	NS02100200	1	⅝ - 11 UNC x 2.00" Lg. Grd. 8 Hex Hd. Bolt
151	R003424MAC	1	Seal Housing
152	NS01050012	4	⅝ - 18 UNC x .75" Lg. Hex Hd. Cap Screw, Pltd.
153	NW03100000	1	⅜" Std. Lock Washer, Pltd.
154	NS81060100	2	⅜ - 16 UNC x 1.00" Lg. Cup Pt. Set Screw
155	NS81060008	2	⅜ - 16 UNC x .50" Lg. Cup Pt. Set Screw

† Refer to pages 17-20 for images of product labels

HYDRAULIC POWER UNIT ASSEMBLY (UPDATED DESIGN)

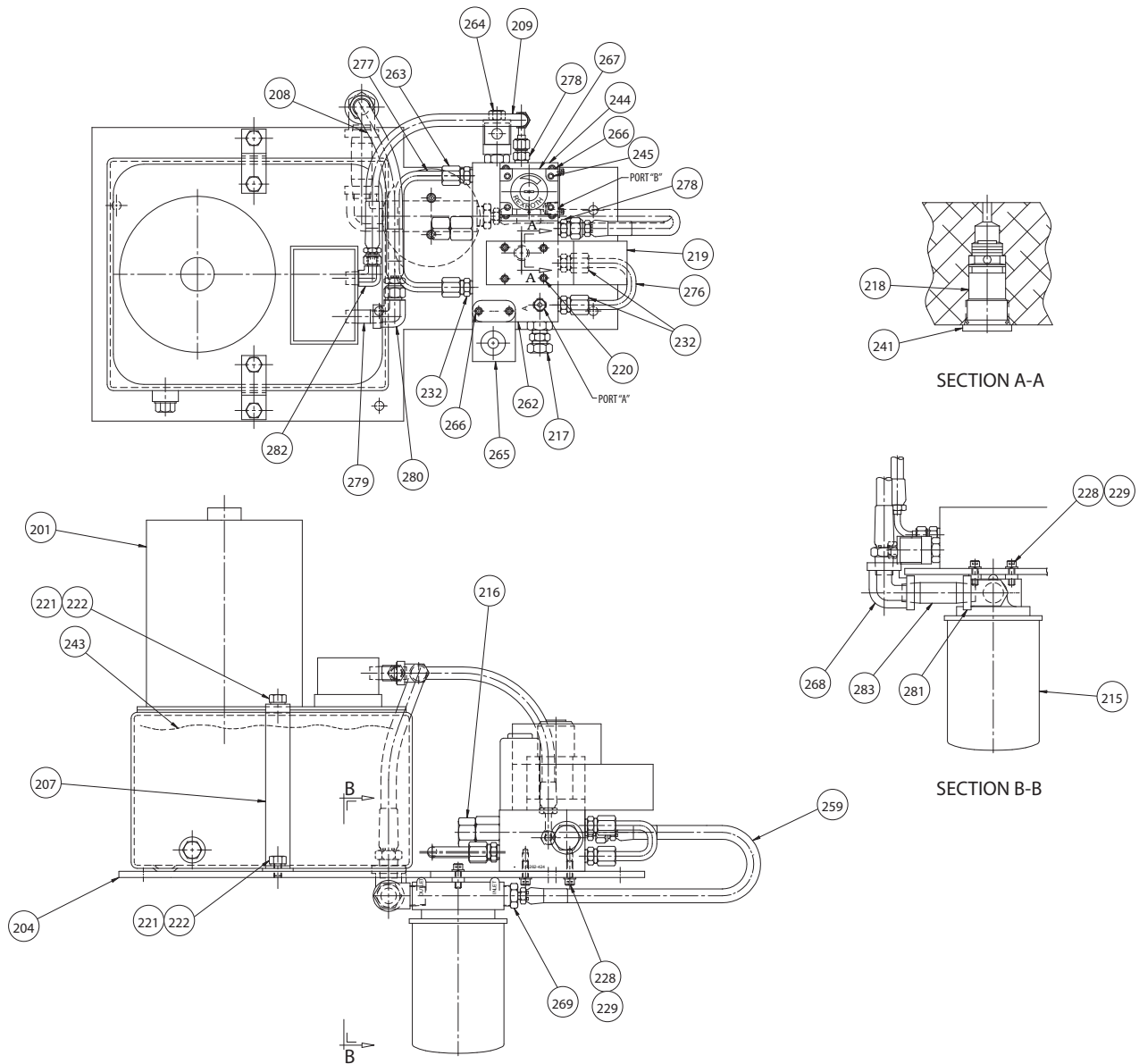


Item #	Part #	Qty.	Description
201	NH05000005	1	Pump, Electric/Hydraulic, Special Version
204	R204424PNT	1	Hydraulic System Mounting Plate
207	R207424PNT	2	Hydraulic Power Unit Mounting Bracket
208	R208424VE0	1	Hose Assembly
209	R209424VE0	1	Hose Assembly
215	NH08000002	1	Filter, 200 PSI Working Pressure, 25 GPM Return, 5 GPM Suction, 1/2 NPT Ports, Die Cast Aluminum Head
216	NHYD000017	1	Pressure Relief Valve, Cartridge, 7/8-14UNF Thread, 500 - 5000 PSI Operating Pressure
217	NHYD000028	1	Pressure Relief Valve, Cartridge, 7/8-14UNF Thread
218	NHYD000029	1	Check Valve, Cartridge, 7/8-14UNF Thread
219	NHYD000018	1	Valve, Flow Control, 4-Way Directional Spool
220	NS03010200	4	Screw, #10-24 x 2 x 7/8 Thread Hex Socket Head Cap
221	NS16050008	4	Screw, 3/16-24 x 1/2 Hex Cap
222	NW03050000	4	Washer, 3/16, Helical Spring-Lock
228	NW03040000	4	Washer, 1/4, Helical Spring-Lock
229	NS03040012	4	Screw, 1/4-20 x 3/4 Hex Socket Head Cap
232	NH11006001	3	Connector
241	NH16010001	1	O-Ring Plug
243	-	A/R	Hydraulic Oil, ISO 32

Item #	Part #	Qty.	Description
245	NH16010001	4	Screw, M5 x 0.8 x 35 x 22 Hex Socket Head Cap
259	R259424VE02	1	Hose Assembly
262	R221460ASY	1	Manifold Block Assembly
264	NHYD000030	1	Solenoid Valve
265	NHYD000033	1	Switch, Mechanical Pressure, 1/4 NPT
267	NH04000006	1	Valve, Flow Control with Flow Check
268	NH12008001	1	Elbow, Straight, 90 Deg, 1/2 NPT Female
269	NH04G52B01	1	Bushing Hex Head, 1/2 NPT Male to 1/4 NPT Female
278	NHYD000014	2	Male Connector, 7/16-20 SAE 37 Deg Flare Male x 7/16-18 SAE Straight Male with O-Ring x 1.230
279	NH11004002	1	Nipple, 1/4 NPT x 1-1/2
280	NH12004006	1	Elbow, 90 Deg Female, 1/4 NPT Female x 7/16-18 SAE 37 Deg Flare Male
281	NH12008002	1	Elbow, Street, 90 Deg, 1/2 NPT Female x 1/2 NPT Male
282	NH12004004	1	Elbow, 90 Deg Male, 7/16-20 SAE 37 Deg Flare Male x 1/4 NPT Male
283	NH11008003	1	Nipple, 1/2 NPT x 3
285	558F040000	2	Bushing, Hex Head, 3/8 NPT Male x 1/4 NPT Female

* Apply pipe dope to all NPT threads**

HYDRAULIC POWER UNIT ASSEMBLY (ORIGINAL DESIGN)

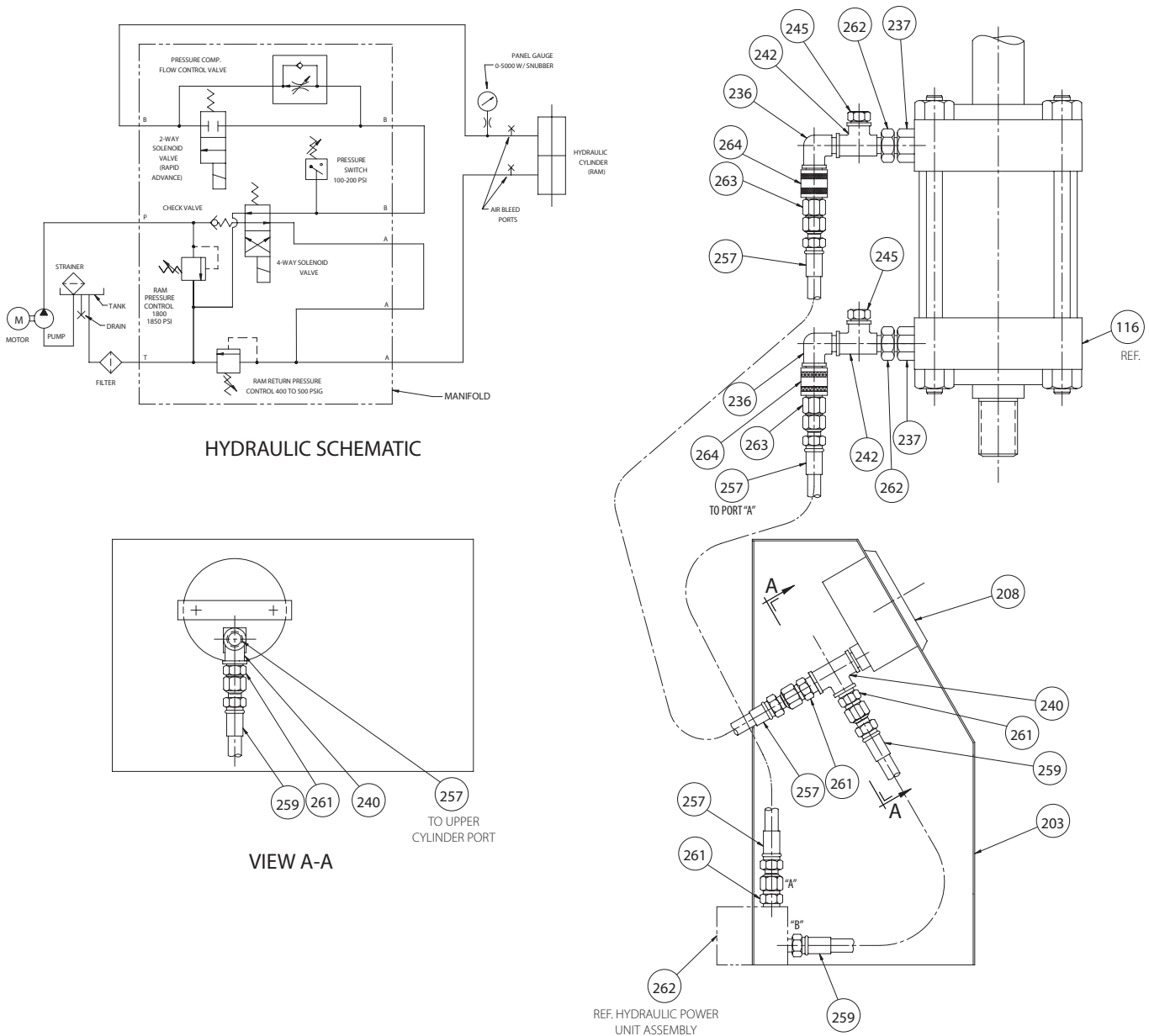


Item #	Part #	Qty.	Description
201	NH05000005	1	Hydraulic Power Unit
204	R204424PNT	1	Hydraulic System Mounting Plate
207	R207424PNT	2	Hydraulic System Mounting Bracket
208	R208424VE0	1	Hose Assembly
209	R209424VE0	1	Hose Assembly
215	NH08000002	1	Return Line Filter
216	NH04000030	1	Relief Valve
217	NH04000002	1	Relief Valve
218	NH04000003	1	Check Valve
219	NH04000004	1	4-Way Valve
220	NS03010200	4	#10 - 24 UNC x 2.0" Lg. Socket Hd. Cap Screw, Blk. Ox.
221	NS16050008	4	5/16 - 24 UNF x .50 Lg. Hex Hd. Cap Screw, Pltd.
222	NW03050000	4	5/16" Lockwasher, Pltd.
228	NW03040000	4	1/4" Lockwasher, Pltd.
229	NS03040012	4	1/4 - 20 UNC x .75 Lg. Socket Hd. Cap Screw, Blk. Ox.
232	NH11006001	3	Connector
241	NH16010001	1	O-Ring Plug
243	-	A/R	Hydraulic Oil, ISO 32
244	NH04000032	1	Adapter Plate

Item #	Part #	Qty.	Description
245	NS03005035	4	M5 x .8 x 35 mm Lg. Socket Hd. Cap Screw, Blk. Ox.
259	R259424VE0	1	Hose Assembly
262	R262424MAC	1	Hydraulic Manifold
263	NH11006002	1	Connector
264	NH04000005	1	Solenoid Valve
265	NH18000001	1	Pressure Switch
266	NS03010100	6	#10 - 24 UNC x 1.0 Lg. Socket Hd. Cap Screw, Blk. Ox.
267	NH04000006	1	2-Way Valve
268	NH12008001	1	90° Elbow, 1/2 Female NPT x 1/2 Female NPT
269	NH11008001	1	Reducing Bushing
276	R276424MAC	1	Hydraulic Tubing, Manifold to Manifold
277	R277424MAC	1	Hydraulic Tubing, Manifold to Manifold
278	NH11004001	2	Male Connector
279	NH11004002	1	1/4" Sch. 40 x 1.50 Lg. Pipe Nipple, Threaded Ends
280	NH12004006	1	90° Female Elbow, 1/4 Female NPT x 3/8 - 37° Flare Tube
281	NH12008002	1	90° Street Elbow, 1/2 Female NPT x 1/2 Male NPT
282	NH12004004	1	90° Male Elbow, 1/4 Male NPT x 1/4 - 37° Flare Tube
283	NH11008003	1	1/2" Sch. 40 x 3 Lg. Pipe Nipple, Threaded Ends

* Apply pipe dope to all NPT threads**

HYDRAULIC CYLINDER ASSEMBLY

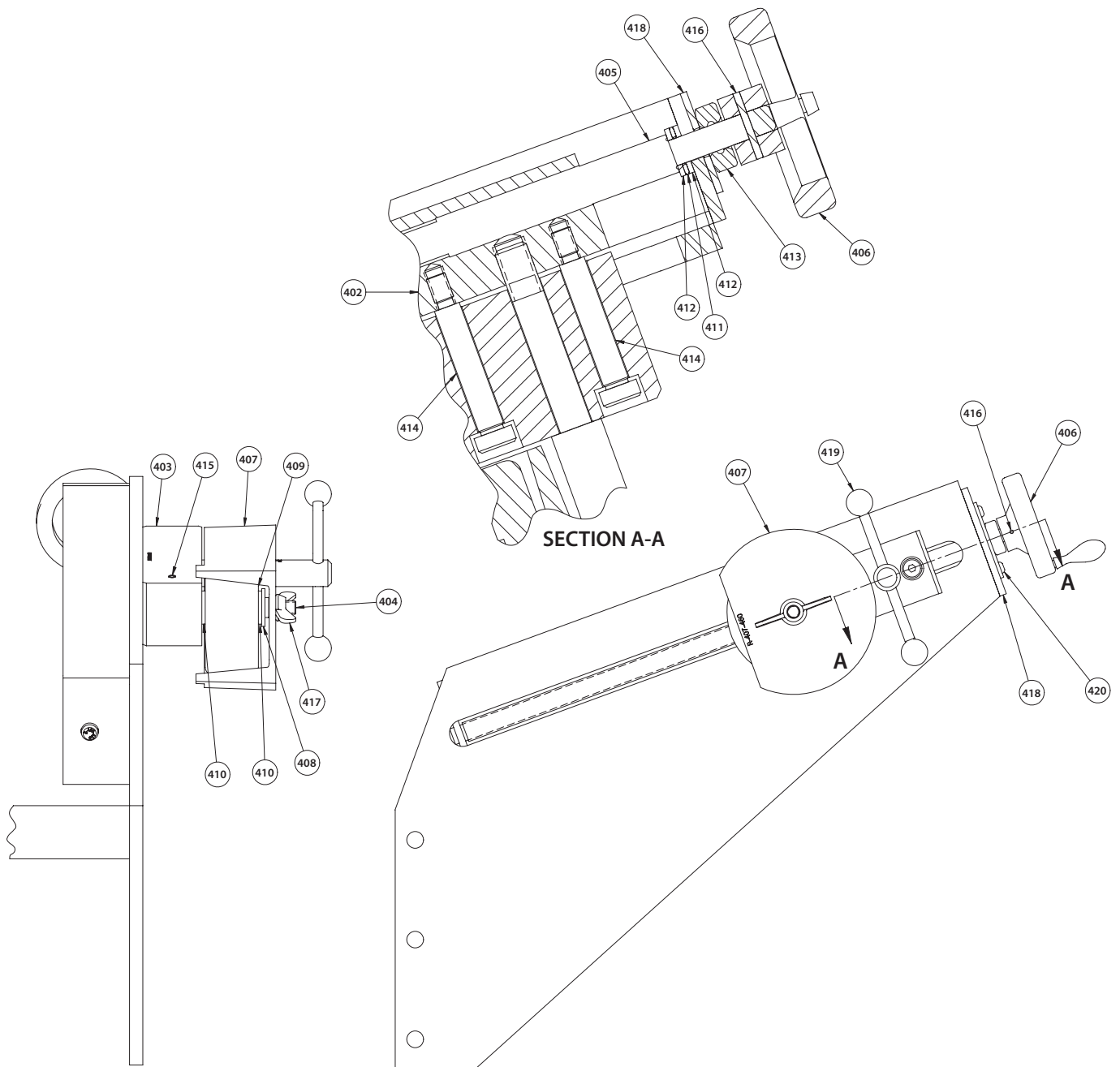


Item #	Part #	Qty.	Description
116	NM40000002	Ref.	Hydraulic Cylinder
203	R803436VE0	1	Hydraulic Panel
208	NH03000001	1	Gauge
236	NH12004002	2	90° Elbow
237	NH11006017	2	3/4" SAE to 1/2" NPT Female Adapter
240	NH14004001	1	Female Tee
242	NH14004002	2	Street Tee
245	NH16004001	2	Hex Head Plug

Item #	Part #	Qty.	Description
257	R257424VE0	2	Hose Assembly
259	R259424VE0	1	Hose Assembly
261	NH11004001	3	JIC 37° x 1/4 NPT Male Connector
262	NH11004015	2	1/2 NPT Male to 1/4 NPT Female Connector
263	NH11004012	2	Nipple
264	NH5004000F	2	Coupler

* Apply pipe dope to all NPT threads**

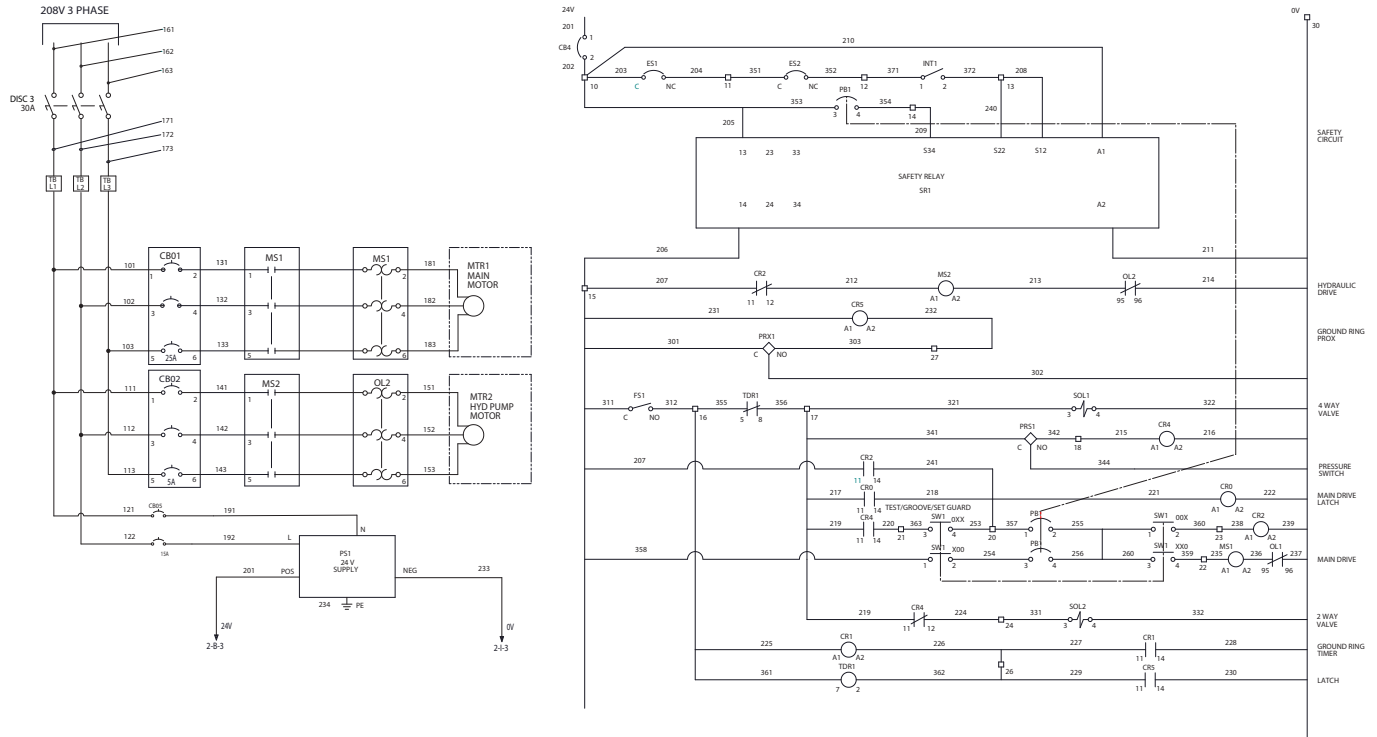
STABILIZER ASSEMBLY



Item#	Part #	Qty.	Description
400	R400460ASY	1	Stabilizer Assembly
401	R401460PNT	1	Stabilizer Main Body
402	R402424PLT	1	Stabilizer Guide Unit
403	R403424PLT	1	Stabilizer Guide
404	R404460FNH	1	Stabilizer Roller Shaft
405	R405460MCH	1	Stabilizer Adjusting Screw
406	R406424MAC	1	Stabilizer Handwheel
407	R407460PNT	1	Stabilizer Roller Guard
408	NB00460000	1	Tongued Washer
409	NM05000002	1	5 x 2 x 3/4 Wheel, Polyurethane Tread
410	NB05075004	2	Thrust Washer

Item#	Part #	Qty.	Description
411	NB03050001	1	Thrust Bearing
412	NB05050003	2	Thrust Washer
413	NB03050002	1	Thrust Bearing
414	NS05080208	2	.50 Dia. x 2.50 Lg. Soc. Hd. Shoulder Screw
415	NP01004208	1	.25 Dia. x 2.50 Lg. Roll Pin
416	NP01002104	1	.13 Dia. x 1.25 Lg. Roll Pin
417	NN00460000	1	Wing Nut
418	R418460PNT	1	Stabilizer Cap
419	R419460ASY	1	Stabilizer Locking Handle
420	NS10040008	2	1/4 - 20 UNC x .50 Lg. Button Hd. Hex Socket Screw, Blk. Ox.

ELECTRICAL ASSEMBLY (UPDATED DESIGN)

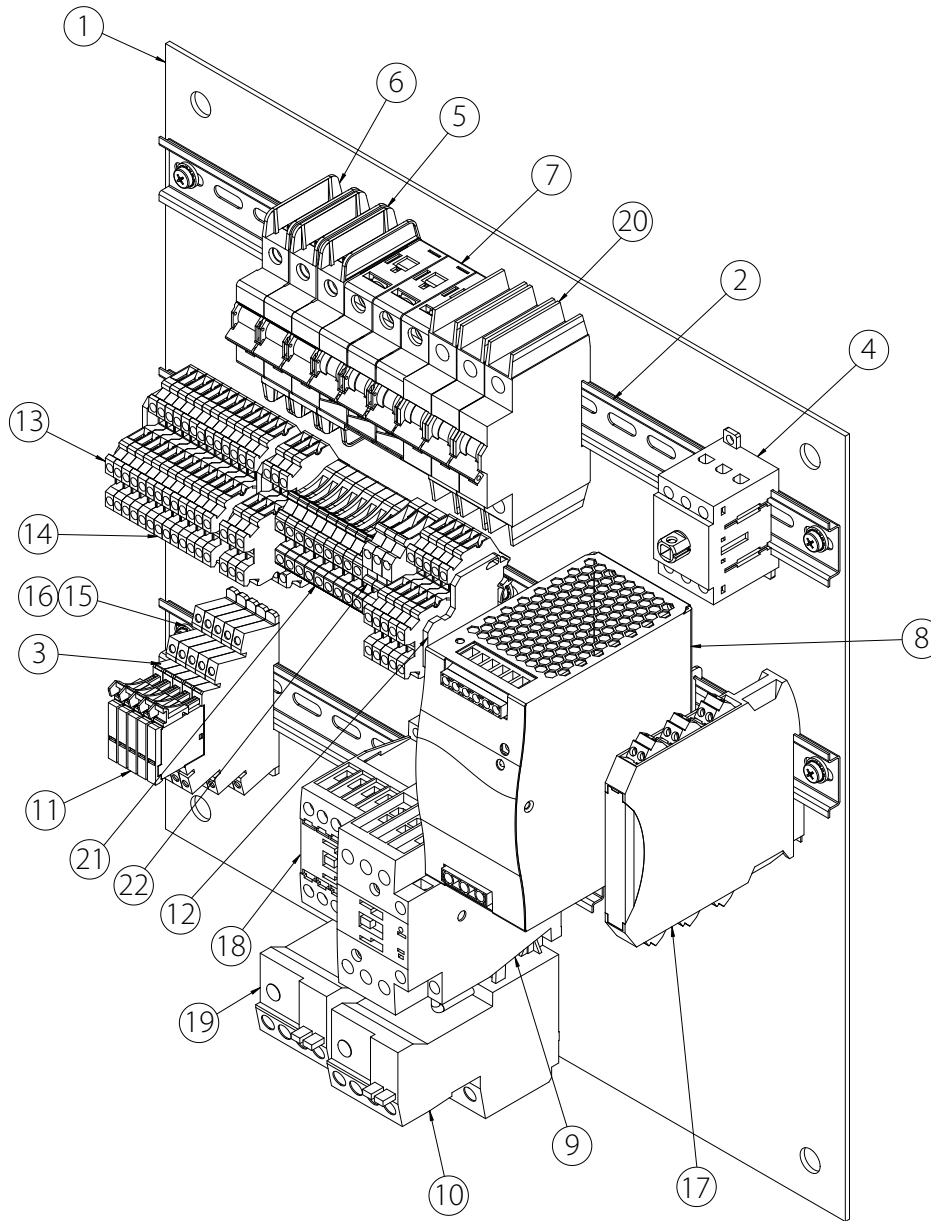


Item#	Part #	Qty.	Description
5	R651414LBL	1	Dial Label †
6	—	1	Enclosure Panel Assembly
7	NE03000003	1	Foot Switch
8	NELC000058	1	Cable, Female Receptacle, 7/8-16 UN Male
9	R312268SCH	1	Cable Sub-Assembly, External, Bulkhead Connector to Foot Switch
10	NE01G51032	1	Connector, Cable Gland, ¼ NPT Thread
11	NELC000046	1	Relay, Time Delay, Power On
12	NELC000072	1	Switch, Pushbutton, Round, Green
13	NELC000073	2	Switch, Pushbutton, Emergency Stop, Red
14	NELC000074	1	Switch, Selector, 30mm, 3 Position
15	NELC000075	1	Contact Block, 22mm Pilot Devices, 1 NC, 600 VAC, 10 AMP, Clamp Type Terminal, Red, Plastic Housing
16	NELC000076	3	Contact Block, 22mm Pilot Devices, 1 NO, 600 VAC, 10 AMP, Clamp Type Terminal, Blue, Plastic Housing
17	NELC000077	1	Relay, Socket, 8-Position
18	101010806	3	Connector, Cord, 3/8 to ¾ Dia Cord Range
19	NECL000089	1	Disconnect Shaft, 6.0 mm Square x 130 mm Length
20	NM04000018	1	Handle, Operator, Mechanical Interlock
21	NW03000005	2	Washer, M5, Helical Spring-Lock
22	NS03005010	2	Screw, M5 x 0.8 x 10 Button Head Cap, Hex Socket
23	NWSR000002	4	Locknut, 3/8-16 Hex Flange Serrated
24	NELC000078	2	Legend Plate, E-Stop, Round, 30mm, 70mm OD

Item#	Part #	Qty.	Description
25	R310268SCH	1	Cable Assembly, External, Bulkhead Connector to Main Power Station
26	R311268SCH	1	Cable Assembly, External, Bulkhead Connector to Motor Terminal Block, to Motor
27	R313268SCH	1	Cable Assembly, External, Bulkhead Connector to Solenoid Valve
28	R743414SCH	1	Cable Sub-Assembly, External, Bulkhead Connector to Motor
29	R744414SCH	1	Cable Sub-Assembly, External, Bulkhead Connector to Proximity Switch
30	R746414SCH	1	Cable Sub-Assembly, External, Bulkhead Connector to 2-Way Valve
31	R747414SCH	1	Cable Sub-Assembly, External, Bulkhead Connector to Pressure Switch
32	R316460SCH	1	Cable Sub-Assembly, External, Bulkhead Connector to Control Station
33	R315460SCH	1	Cable Sub-Assembly, External, Bulkhead Connector to 2-Way Valve
34	NM30000006	1	Connector, Cable Gland, ¼ NPT Thread
35	NE06000002	4	Connector, Cord, 3/8 to ½ Dia Cord Range
36	NE00G52010	2	Connector, Cable Gland, 1 NPT Thread

† Refer to pages 17–20 for images of product Labels

ELECTRICAL PANEL (UPDATED DESIGN)

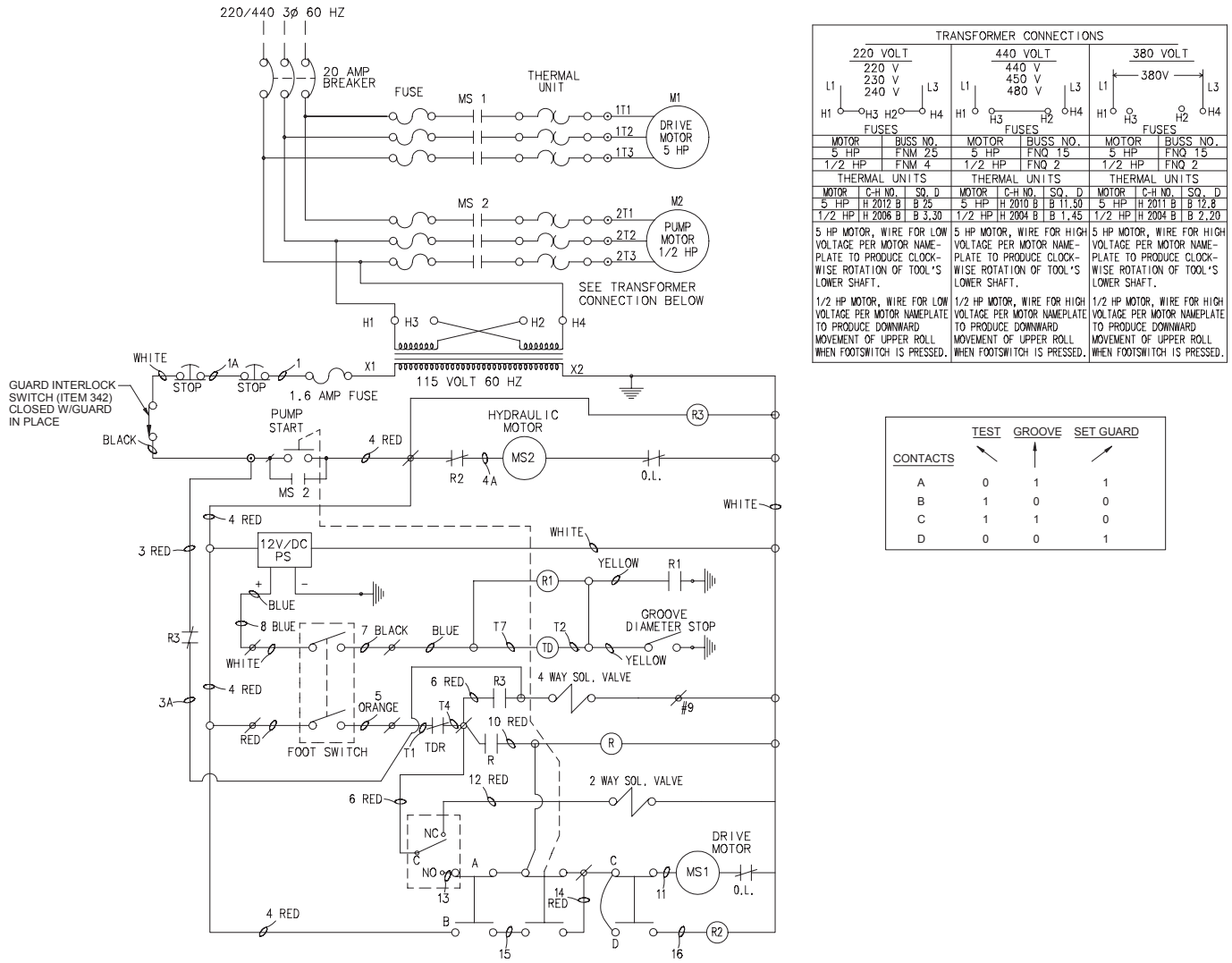


Item#	Part #	Qty.	Description
1	-	1	Electrical Panel Sub-Assembly
2	-	2	Din Rail, Symmetrical, Slotted, Type PR30, 35mm H x 7.5mm W x 1m L
3	-	1	Din Rail, Symmetrical, Slotted, Type PR30, 35mm H x 7.5mm W x 1m L
4	NELC000079	1	Disconnect, Non-Fusible, 3-Pole, 600 VAC, 30 AMP
5	NELC000070	1	Circuit Breaker, 2-Pole, 277/480 VAC, 15 AMP
6	NELC000064	1	Circuit Breaker, Single Pole, 277/480 VAC, 10 AMP
7	NELC000063	1	Circuit Breaker, 3-Pole, 277/480 VAC, 20 AMP
8	NELC000065	1	Power Supply, 200-500 VAC Nominal Input Voltage, 24V Nominal Output Voltage, 24-28V Adjustment Range, 0-10 AMP Output Current Range, 240W
9	NELC000067	1	Contactor, 3-Pole, 3PST-NO, 690VAC, 18 AMP, 15HP, Din Rail Mount
10	NELC000066	1	Relay, Overload, Thermal, Motor, 4 to 20 AMP Adjustment Range, 690V
11	NELC000069	5	Relay, Power, SPDT, 24 VDC, Din Rail Mount
12	NELC000080	3	Terminal End Plate, 32mm or 35mm Din Rail Mounted, Nylon

Item#	Part #	Qty.	Description
13	NELC000081	15	Terminal Block, 5.2mm WIDE, 35mm Din Rail Mounted, Double Level, 4 Terminal, Nylon, Gray
14	NELC000082	6	Terminal Block, 5.2mm WIDE, 32mm or 35mm Din Rail Mounted, Double Level, 4 Terminal, Nylon, Gray
15	-	8	Washer, 0.203 Nominal, 0.203 x 0.469 x 0.049
16	NSCR000014	8	Screw, #10-32 x 1/2 Pan Head Machine, Type 1 Cross Recessed and Washer, External Tooth-Lock
17	NELC000083	1	Relay, Safety Control, 24VDC, 5 AMPS, Category 4, 3 No Contacts, Din Rail Mount
18	NELC000084	1	Contactor, 3-Pole, 3PST-NO, 690VAC, 7 AMP, 5HP, Din Rail Mount
19	NELC000085	1	Relay, Overload, Thermal, Motor, 1 to 5 AMP Adjustment Range, 690V
20	NELC000086	1	Circuit Breaker, 3-Pole, 277/480 VAC, 5 AMP, D Curve, Din Rail Mounted
21	NELC000087	9	Terminal Block, 2 Pole, Feed Through, 2 Connection, 32 AMP, Nylon, Gray
22	NELC000088	3	Terminal Ground, 6.1mm W, 35mm Din Rail Mounted, 2-Terminal, Nylon, Green/Yellow

† Refer to pages 17-20 for images of product labels

ELECTRICAL ASSEMBLY (ORIGINAL DESIGN)



TRANSFORMER CONNECTIONS					
220 VOLT		440 VOLT		380 VOLT	
L1	220 V	L1	440 V	L1	380V
H1	230 V	H1	450 V	H1	
H2	240 V	H2	480 V	H2	
H3		H3		H3	
H4		H4		H4	
L3		L3		L3	
FUSES		FUSES		FUSES	
MOTOR	BUSS NO.	MOTOR	BUSS NO.	MOTOR	BUSS NO.
5 HP	FNM 25	5 HP	FNO 15	5 HP	FNO 15
1/2 HP	FNM 4	1/2 HP	FNO 2	1/2 HP	FNO 2
THERMAL UNITS		THERMAL UNITS		THERMAL UNITS	
MOTOR	C-H NO.	SO. D	MOTOR	C-H NO.	SO. D
5 HP	H 2012 B	B 25	5 HP	H 2018 B	B 11, 30
1/2 HP	H 2008 B	B 3, 30	1/2 HP	H 2004 B	B 1, 43
1/2 HP	H 2004 B	B 2, 20	1/2 HP	H 2004 B	B 2, 20
5 HP MOTOR. WIRE FOR LOW VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE CLOCK-WISE ROTATION OF TOOL'S LOWER SHAFT.			5 HP MOTOR. WIRE FOR HIGH VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE CLOCK-WISE ROTATION OF TOOL'S LOWER SHAFT.		
1/2 HP MOTOR. WIRE FOR LOW VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.			1/2 HP MOTOR. WIRE FOR HIGH VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.		
1/2 HP MOTOR. WIRE FOR HIGH VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.			1/2 HP MOTOR. WIRE FOR HIGH VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.		

CONTACTS	TEST	GROOVE	SET GUARD
A	0	1	1
B	1	0	0
C	1	1	0
D	0	0	1

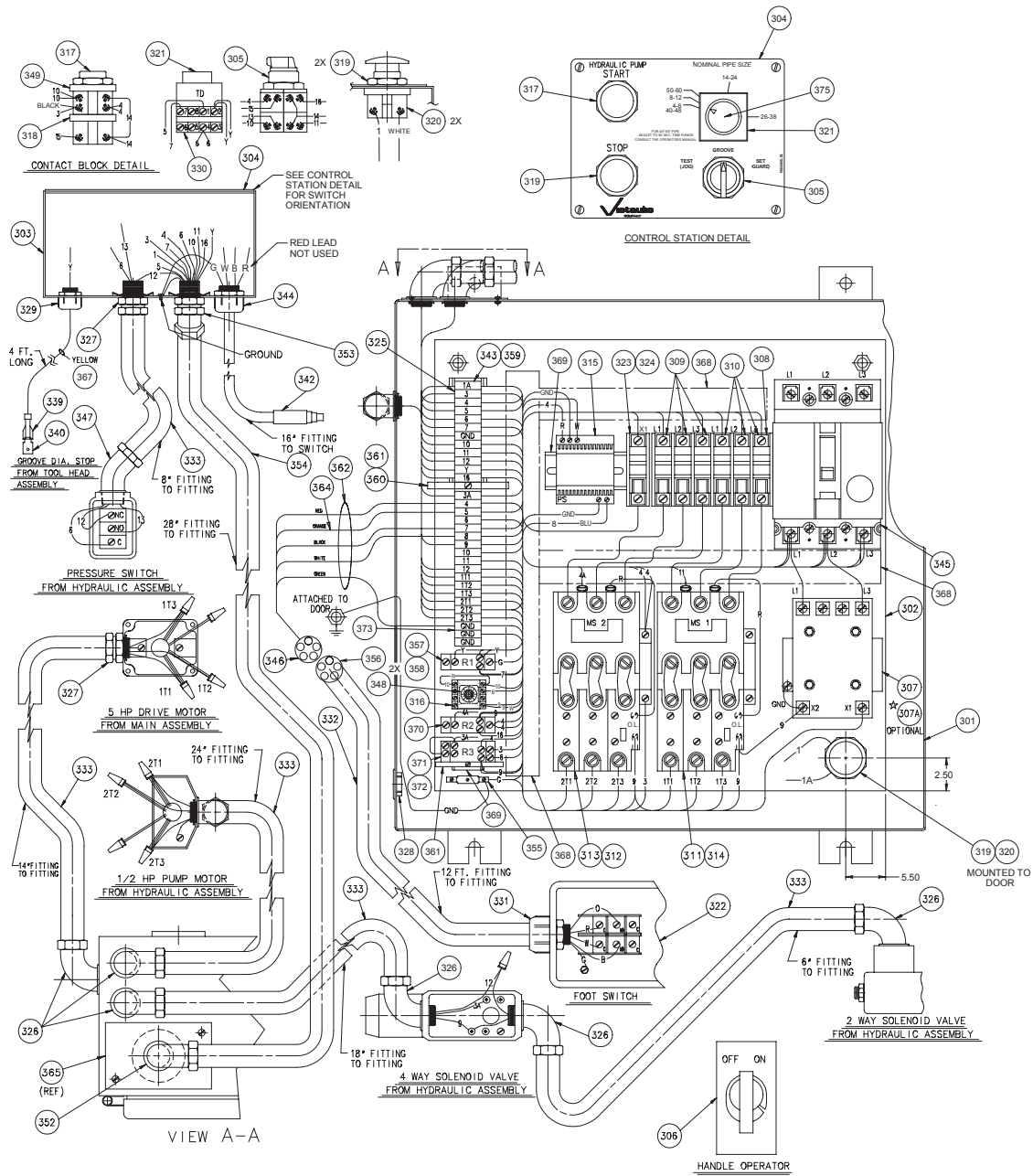
Item#	Part #	Qty.	Description
301	R301424PNT	Ref.	Main Electrical Enclosure
302	-	1	Main Enclosure Panel
303	R303460MCH	Ref.	Control Station Enclosure
304	R304460LBL	Ref.	Control Station Plate †
305	NE02000013	1	Switch, 3-Position
306	NE90000001	1	Handle Oper. Mech.
307	NE10000021	1	Transformer, 220V-440V, 60 Hz
307A	NE10000002	1	Transformer, 380V, 50/60 Hz
308	NE12000004	2	Fuse Holder
309	-	3	Fuse, Buss (see Transformer Connections table)
310	-	3	Fuse, Buss (see Transformer Connections table)
311	NE11000013	1	Magnetic Starter
312	-	3	Thermal Unit (see Transformer Connections table)
313	NE11000001	1	Magnetic Starter
314	-	3	Thermal Unit (see Transformer Connections table)
315	NE16000002	1	Power Supply
316	NE12000001	1	Relay Socket
317	NE02000001	1	Push Button Oper. - Blk.
318	NE02000004	1	Contact Block
319	NE02000002	2	Push Button Oper. - Red
320	NE02000005	2	Contact Block

Item#	Part #	Qty.	Description
321	NE09000004	1	Time Delay Relay with Adjustable Timer
322	NE03000003	1	Foot Switch
323	NE12000004	1	Fuse Holder
324	NE13000005	1	Fuse, Buss
325	-	20 Pt.	Track Mtd. Contact Term.
326	-	7	Connector, 1/2 90°
327	-	2	Connector, 1/2 Straight
328	-	1	Knock-Out Bushing
329	-	1	Strain Relief
330	-	1	Socket
331	NE06000002	1	Strain Relief Connector, Straight, Liquid-Tight
332	NE08000012	12 ft.	Control Connector, 5 Pole
333	-	93 in.	1/2 Plastic Extra Flex
334	-	A/R	12 Ga. Black MTW (Line Voltage Circuits)
335	-	A/R	16 Ga. Red MTW (AC Control Circuits)
336	-	A/R	16 Ga. White MTW (Neutral)
337	-	A/R	16 Ga. Blue MTW (DC Control Circuits)
338	-	A/R	12 Ga. Green MTW (Ground)
339	NE05000003	1	Female Disconnect
340	-	1	Male Tab
342	NE02000006	1	Switch

† Refer to pages 17-20 for images of product labels



ELECTRICAL PANEL (ORIGINAL DESIGN)

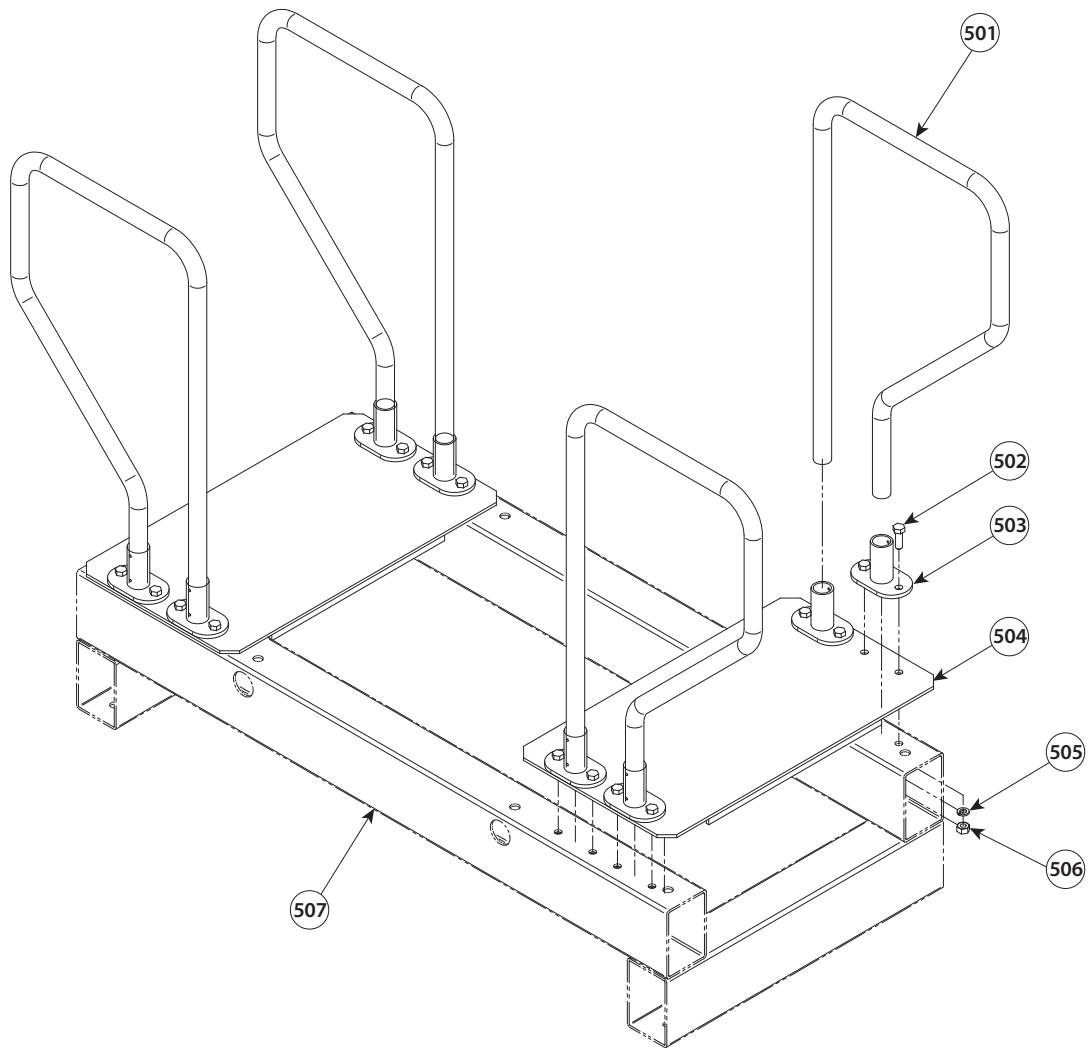


Item#	Part #	Qty.	Description
343	-	1	Fanning Strip Terminal
344	NE06000001	1	Strain Relief, Straight
345	NE15000001	1	Circuit Breaker
346	NE19000002	1	Receiver
347	-	1	Connector 1/2 45°
348	NE09000001	1	Relay R
349	NE02000003	1	Contact Block
352	NE06000039	1	Connector, 3/4 90°
353	-	1	Connector, 3/4 45°
354	-	30 in.	3/4 Plastic Extra Flex
356	NE08000001	1	Male Plug
357	NE09000003	1	Relay R1
358	NE12000003	1	Relay Socket
359	NE05000008	1	Terminal Plug
360	-	1	Track Mounted Contact End

Item#	Part #	Qty.	Description
361	-	2	Track Mounted Contact End Clamp
362	-	24 in.	Spiral Wrap
364	-	A/R	16 Ga. Orange MTW (AC Control Circuits)
365	R301424PNT	Ref.	Cover Plate
366	-	A/R	12 Ga. Yellow MTW (Interrupted Ground)
367	-	A/R	16 Ga. Yellow MTW (Groove Dia. Stop Ground Ring)
368	-	A/R	Panduit Wireduct
369	-	A/R	Din Rail
370	NE09000008	1	Relay R2
370A	NE12000007	1	Relay Socket
371	NE09000009	1	Relay R3
372	NE12000005	1	Relay Socket
373	-	4	Grounding Terminal Block
374	R305460LBL	Ref.	Power Requirements Plate †
375	R651414LBL	1	Dial Label †

† Refer to pages 17-20 for images of product labels

SUPPORT BASE ASSEMBLY



Item#	Part #	Qty.	Description
500	R550460KIT	1	Railing and Platform Kit
501	R553460PNT	4	Support Base Railing
502	-	16	Bolt, ½-13 UNC x 1.50 Hex Head
503	-	8	Slip-On Structural Fitting

Item#	Part #	Qty.	Description
504	R552460PNT	2	Platform
505	-	16	Washer, ½ Lock
506	-	16	Nut, ½-13 UNC Hex
507	R551460PNT	*	Support Base*

NOTE: Four concrete anchors (¾ x 4.25 wedge [not shown]) are required to anchor the support base to a concrete floor.

- * 24-inch/610-mm and smaller pipe sizes do not require a support base
- 26 - 38-inch/660 - 965-mm pipe sizes require one support base
- 40 - 48-inch/1016 - 1219-mm pipe sizes require two support bases
- 50 - 60-inch/1270 - 1524-mm pipe sizes require three support bases

GROOVING ROLL INFORMATION FOR THE ORIGINAL GROOVE SYSTEM

4–48-INCH/114.3–1219-MM STEEL PIPE AND 4–24-INCH/114.3–609.6-MM SCHEDULE 40 STAINLESS STEEL PIPE, ORIGINAL GROOVE SYSTEM

Pipe Size		Original Groove System
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	Roll Part Numbers
4 - 6	4.500 - 6.625 114.3 - 168.3	Lower Roll R904460L06 Upper Roll R9QA448U06 Roll Set R9Q1460006
8 - 12	8.625 - 12.750 219.1 - 323.9	Lower Roll R908460L12 Upper Roll R9QA448U12 Roll Set R9Q1460012
14 OD - 16 OD	14.000 - 16.000 355.6 - 406.4	Lower Roll R914460L16 Upper Roll R9QA448U16 Roll Set R9Q1460016
18 OD - 20 OD	18.000 - 20.000 457 - 508	Lower Roll R918460L20 Upper Roll R9QA448U20 Roll Set R9Q1460020
22 OD - 24 OD	22.000 - 24.000 559 - 610	Lower Roll R922460L24 Upper Roll R9QA448U24 Roll Set R9Q1460024
26 OD - 36 OD	26.000 - 36.000 660 - 914	Lower Roll R926460L36 Upper Roll R9QA448U36 Roll Set R9Q1460036
42 OD - 48 OD	42.000 - 48.000 1067 - 1219	Lower Roll R942460L48 Upper Roll R9QA448U48 Roll Set R9Q1460048

4–12-INCH/114.3–323.9-MM STEEL PIPE, ENDSEAL®

Pipe Size		"ES"
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	Roll Part Numbers
4 - 6	4.500 - 6.625 114.3 - 168.3	Lower Roll RZ04460L06 Upper Roll RZQA448U06 Roll Set RZQ1460006
8 - 12	8.625 - 12.750 219.1 - 323.9	Lower Roll RZ08460L12 Upper Roll RZQA448U12 Roll Set RZQ1460012

4–12-INCH/114.3–323.9-MM ALUMINUM PIPE AND PVC PLASTIC PIPE

Pipe Size		RP
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	Roll Part Numbers
4 - 6	4.500 - 6.625 114.3 - 168.3	Lower Roll RP04460L06 Upper Roll RPQA448U06 Roll Set RPQ1460006
8 - 12	8.625 - 12.750 219.1 - 323.9	Lower Roll RP08460L12 Upper Roll RPQA448U12 Roll Set RPQ1460012

4–24-INCH/114.3–609.6-MM SCHEDULES 5S AND 10S STAINLESS STEEL PIPE, ORIGINAL GROOVE SYSTEM

Pipe Size		RX
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	Roll Part Numbers
4 - 6	4.500 - 6.625 114.3 - 168.3	Lower Roll RX04460L06 Upper Roll RXQA448U06 Roll Set RXQ1460006
8 - 12	8.625 - 12.750 219.1 - 323.9	Lower Roll RX08460L12 Upper Roll RXQA448U12 Roll Set RXQ1460012
14 OD - 16 OD	14.000 - 16.000 355.6 - 406.4	Lower Roll RX14460L16 Upper Roll RXQA448U16 Roll Set RXQ1460016
18 OD - 20 OD	18.000 - 20.000 457 - 508	Lower Roll RX18460L20 Upper Roll RXQA448U20 Roll Set RXQ1460020
22 OD - 24 OD	22.000 - 24.000 559 - 610	Lower Roll RX22460L24 Upper Roll RXQA448U24 Roll Set RXQ1460024

GROOVING ROLL INFORMATION FOR THE ADVANCED GROOVE SYSTEM (AGS)

**14–60-INCH/355.6–1524-MM LIGHT-WALL,
STANDARD-WEIGHT, AND EXTRA-STRONG (XS) STEEL PIPE,
ADVANCED GROOVE SYSTEM (AGS)**

Pipe Size		RW
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	Roll Part Numbers
14 OD - 24 OD	14.000 - 24.000 355.6 - 610	Lower Roll RW02460L24 Upper Roll RWQ2448ASY Roll Set RWQ2460024
26 OD - 38 OD	26.000 - 38.000 660 - 965	Lower Roll RWQ3460L38 Upper Roll RWQ3460A38 Roll Set RWQ3460038
40 OD - 50 OD	40.000 - 50.000 1016 - 1270	Lower Roll RWQ3460L50 Upper Roll RWQ3460A50 Roll Set RWQ3460050
54 OD - 60 OD	54.000 - 60.000 1371.6 - 1524	Lower Roll RWQ3460L60 Upper Roll RWQ3460A60 Roll Set RWQ3460060

**14–24-INCH/355.6–609.6-MM SCHEDULES 5S AND 10S
STAINLESS STEEL PIPE, ADVANCED GROOVE SYSTEM (AGS)**

Pipe Size		RWX
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	Roll Part Numbers
14 OD - 18 OD	14.000 - 18.000 355.6 - 457	Lower Roll RW0X460L18 Upper Roll RWQX448A24 Roll Set RWQX460018
20 OD - 24 OD	20.000 - 24.000 508 - 610	Lower Roll RW0X460L24 Upper Roll RWQX448A24 Roll Set RWQX460024

IMAGES OF THE LABELS ON PAGES 17 - 20 ARE NOT TO SCALE.

R-091-424-LAB

WARNING

Grooving rolls can crush or cut fingers and hands.

- Always disconnect the tool from the power source before making any tool adjustments.
- 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.

5037 Rev. C
R091424LAB

R-009-424-LBL

ROLL GROOVE DIAMETER SPECIFICATION				
SIZE	O.D.		Ø "C"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
3/4 [26.9]	1.060 [26.9]	1.040 [26.4]	.938 [23.8]	.923 [23.4]
1 [33.7]	1.328 [33.7]	1.302 [33.1]	1.190 [30.2]	1.175 [29.9]
1 1/4 [42.4]	1.676 [42.6]	1.644 [41.8]	1.535 [39.0]	1.520 [38.6]
1 1/2 [48.3]	1.919 [48.7]	1.881 [47.8]	1.775 [45.1]	1.760 [44.7]
2 [60.3]	2.399 [60.9]	2.351 [59.7]	2.250 [57.2]	2.235 [56.8]
2 1/2 [73]	2.904 [73.8]	2.846 [72.3]	2.720 [69.1]	2.702 [68.6]
3 [88.9]	3.535 [89.8]	3.469 [88.1]	3.344 [84.9]	3.326 [84.5]
3 1/2 [101.6]	4.040 [102.6]	3.969 [100.8]	3.834 [97.4]	3.814 [96.9]
4 [114.3]	4.545 [115.4]	4.469 [113.5]	4.334 [110.1]	4.314 [109.6]
4 1/2 [127]	5.050 [128.3]	4.969 [126.3]	4.834 [122.8]	4.814 [122.3]
5 [141.3]	5.619 [142.7]	5.532 [140.5]	5.395 [137.0]	5.373 [136.5]
6 [168.3]	6.688 [169.9]	6.594 [167.5]	6.455 [164.0]	6.433 [163.4]
8 [203.2]	8.063 [204.8]	7.969 [202.4]	7.816 [198.5]	7.791 [197.9]
10 [254]	10.813 [274.7]	10.719 [272.3]	10.562 [268.3]	10.535 [267.6]
12 [304.8]	12.063 [306.4]	11.969 [304.0]	11.781 [299.2]	11.751 [298.5]
14 O.D. [355.6]	14.063 [357.2]	13.969 [354.8]	13.781 [350.0]	13.751 [349.3]
15 O.D. [381.2]	15.063 [382.6]	14.969 [380.2]	14.781 [375.4]	14.751 [374.7]
16 O.D. [406.4]	16.063 [408.0]	15.969 [405.6]	15.781 [400.8]	15.751 [400.1]
18 O.D. [457]	18.063 [458.8]	17.969 [456.4]	17.781 [451.6]	17.751 [450.9]
20 O.D. [508]	20.063 [509.6]	19.969 [507.2]	19.781 [502.4]	19.751 [501.7]
22 O.D. [559]	22.063 [560.4]	21.969 [558.0]	21.656 [550.1]	21.626 [549.3]
24 O.D. [610]	24.063 [611.2]	23.969 [608.8]	23.656 [600.9]	23.626 [600.1]
26 O.D. [660]	26.093 [662.8]	25.969 [659.6]	25.500 [647.7]	25.437 [646.1]
28 O.D. [711]	28.093 [713.6]	27.969 [710.4]	27.500 [698.5]	27.437 [696.9]
30 O.D. [762]	30.093 [764.4]	29.969 [761.2]	29.500 [749.3]	29.437 [747.7]
32 O.D. [813]	32.093 [815.2]	31.969 [812.0]	31.500 [800.1]	31.437 [798.5]
36 O.D. [914]	36.093 [916.8]	35.969 [913.6]	35.500 [901.7]	35.437 [900.1]
42 O.D. [1067]	42.093 [1069.2]	41.969 [1066.0]	41.500 [1054.1]	41.437 [1052.5]
48 O.D. [1219]	48.093 [1221.6]	47.969 [1218.4]	47.500 [1206.5]	47.437 [1204.9]

R-008-460-LBL

VE460

SERIAL NO.

DATE MFD.

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
<input type="text" value="230"/>	<input type="text" value="3"/>	<input type="text" value="50/60"/>	<input type="text" value="18.3 AMPS"/>
<input type="text" value="380"/>	<input type="text" value="3"/>	<input type="text" value="50/60"/>	<input type="text" value="9.9 AMPS"/>
<input type="text" value="415"/>	<input type="text" value="3"/>	<input type="text" value="50/60"/>	<input type="text" value="9.1 AMPS"/>
<input type="text" value="460"/>	<input type="text" value="3"/>	<input type="text" value="50/60"/>	<input type="text" value="8.2 AMPS"/>

DRIVE MOTOR:

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
<input type="text" value="230"/>	<input type="text" value="3"/>	<input type="text" value="50/60"/>	<input type="text" value="12.6 AMPS"/>
<input type="text" value="380"/>	<input type="text" value="3"/>	<input type="text" value="50/60"/>	<input type="text" value="7.6 AMPS"/>
<input type="text" value="415"/>	<input type="text" value="3"/>	<input type="text" value="50/60"/>	<input type="text" value="7.0 AMPS"/>
<input type="text" value="460"/>	<input type="text" value="3"/>	<input type="text" value="50/60"/>	<input type="text" value="6.3 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-301-460-MCH REVISION LEVEL

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

Manufactured in Canada

5844 Rev. D R008460LBL

R-090-424-LAB

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. B
R090424LAB

R-010-416-LAB

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									R010416LAB		

R-148-424-LAB

**1/4 TURN ON GROOVE DEPTH ADJUSTER =
 .042-INCH/1.1-MM CHANGE IN GROOVE DIAMETER**

5846 Rev. B
R148424LAB

R-129-460-LBL

SCH.5S 4 5-6 8 10-12	SCH.10S 4-6 8 10-12	.50 WALL 26-36	SCH.20 12 8-10	SCH.40 4 5 6 8 10 12	STD. 26-36 12	SCH.80 PVC 4 5 6	AGS[®] C.S. B A J C D E K L F	AGS[®] S.S. A G B H
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5655 Rev. C R129460LBL

R-305-460-LBL

VE460

POWER SUPPLY REQUIREMENTS

220/440 VOLTS - 3 PHASE - 60 CYCLE

FULL LOAD CURRENT 17/8.5 AMPS

RATING OF LARGEST MOTOR 13.6/6.8 AMPS

SHORT CIRCUIT INTERRUPTING CAPACITY 10,000 AMPS

DIAGRAM NO. R-301-460-SCH

5847 Rev. C R305460LBL

R-095-424-LAB

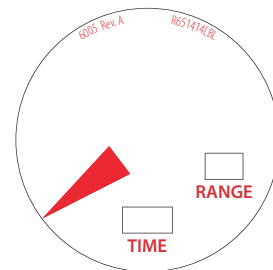
⚠ DANGER

Contact with hazardous voltage inside this cover plate 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 cover plate.

3308 Rev. B R095424LBL

R-651-414-LBL



R-031-272-LAB

⚠ WARNING

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

- Before operating or servicing any pipe preparation tools, read all instructions in the Operating and Maintenance Instructions Manual and all labels on the tool.
- Wear safety glasses, hardhat, foot protection, and hearing protection when working around tools.

If you need additional copies of any literature, or if you have questions concerning the safe and proper operation of any pipe preparation tools, contact Victaulic, P.O. Box 31, Easton, PA 18044-0031, Phone 1-800-PICK VIC, E-Mail: pickvic@victaulic.com.

0567 Rev. D R031272LAB

R-207-264-LBL

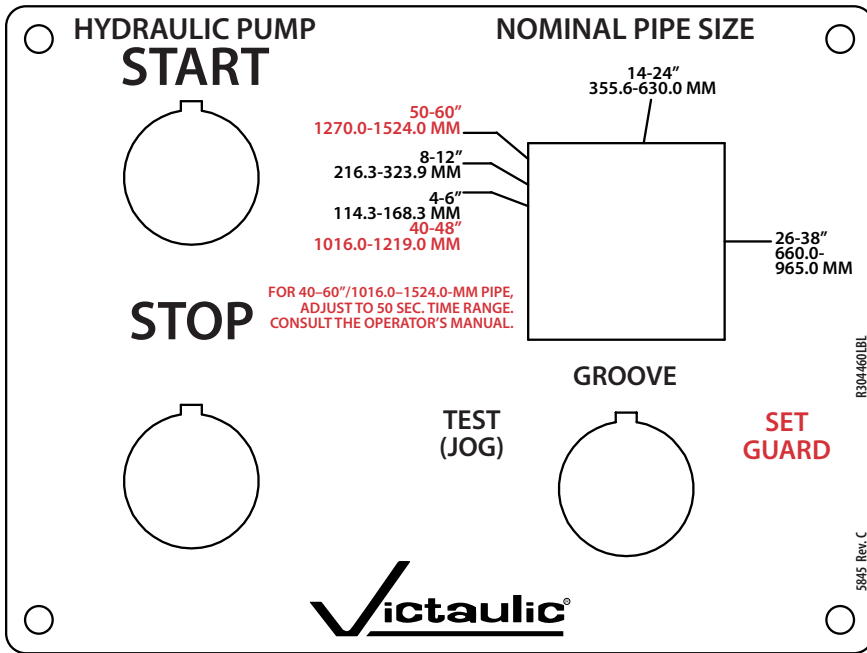
Pipe and groove features, noted below, must be measured to verify they are within current Victaulic specifications. Victaulic submittal publications can be downloaded at www.victaulic.com.

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

VE460 Roll Grooving Tool

R-304-460-LBL



R-011-424-LBL

Victaulic[®]
AGS[™] ROLL GROOVE DIAMETER SPECIFICATION

SIZE	O.D.		ø \"C\"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
14 [355.6]	14.094 [358.0]	13.969 [354.8]	13.500 [342.9]	13.455 [341.8]
377 mm	14.937 [379.4]	14.812 [376.2]	14.343 [364.3]	14.298 [363.2]
16 [406.4]	16.094 [408.8]	15.969 [405.6]	15.500 [393.7]	15.455 [392.6]
426 mm	16.866 [428.4]	16.741 [425.2]	16.272 [413.3]	16.227 [412.2]
18 [457]	18.094 [459.6]	17.969 [456.4]	17.500 [444.5]	17.455 [443.4]
480 mm	18.992 [482.4]	18.867 [479.2]	18.398 [467.3]	18.353 [466.2]
20 [508]	20.094 [510.4]	19.969 [507.2]	19.500 [495.3]	19.455 [494.2]
22 [559]	22.094 [561.2]	21.969 [558.0]	21.500 [546.1]	21.455 [545.0]
24 [610]	24.094 [612.0]	23.969 [608.8]	23.500 [596.9]	23.455 [595.8]
26 [660]	26.063 [662.0]	25.937 [658.8]	25.430 [645.9]	25.370 [644.4]
28 [711]	28.063 [712.8]	27.937 [709.6]	27.430 [696.7]	27.370 [695.2]
30 [762]	30.063 [763.6]	29.937 [760.4]	29.430 [747.5]	29.370 [746.0]
32 [813]	32.063 [814.4]	31.937 [811.2]	31.430 [798.3]	31.370 [796.8]
34 [837]	34.063 [865.2]	33.937 [862.0]	33.430 [849.1]	33.370 [847.6]
36 [914]	36.063 [916.0]	35.937 [912.8]	35.430 [899.9]	35.370 [898.4]
38 [965]	38.063 [966.8]	37.937 [963.6]	37.430 [950.7]	37.370 [949.2]
40 [1016]	40.063 [1017.6]	39.937 [1014.4]	39.375 [1000.1]	39.315 [998.6]
42 [1067]	42.063 [1068.4]	41.937 [1065.2]	41.375 [1050.9]	41.315 [1049.4]
44 [1118]	44.063 [1119.2]	43.937 [1116.0]	43.375 [1101.7]	43.315 [1100.2]
46 [1168]	46.063 [1170.0]	45.937 [1166.8]	45.375 [1152.5]	45.315 [1151.0]
48 [1219]	48.063 [1220.8]	47.937 [1217.6]	47.375 [1203.3]	47.315 [1201.8]
50 [1270]	50.063 [1271.6]	49.937 [1268.4]	49.375 [1254.1]	49.315 [1252.6]
54 [1372]	54.063 [1373.2]	53.937 [1370.0]	53.430 [1357.1]	53.370 [1355.6]
56 [1422]	56.063 [1424.0]	55.937 [1420.8]	55.430 [1407.9]	55.370 [1406.4]
60 [1524]	60.063 [1525.6]	59.937 [1522.4]	59.430 [1509.5]	59.370 [1508.0]
62 [1575]	62.063 [1576.4]	61.937 [1573.2]	61.430 [1560.3]	61.370 [1558.8]
72 [1829]	72.063 [1830.4]	71.937 [1827.2]	71.430 [1814.3]	71.370 [1812.8]

R-132-460-LBL

AGS[™] CARBON STEEL

.220" (5.6 mm)	A
Schedule 10 .250" (6.3 mm)	B
.315" (8.0 mm)	C
26 - 38" (660.0 - 965.2 mm) Std. Weight .375" (9.5 mm)	C
.346" (8.8 mm)	D
Std. Weight .375" (9.5 mm)	E
Extra Strong .500" (12.7 mm)	F
40 - 60" (1016.0 - 1524.0 mm) Std. Weight .375" (9.5 mm)	J
40 - 60" (1016.0 - 1524.0 mm) Extra Strong .500" (12.7 mm)	K
26 - 38" Extra Strong .500" (12.7 mm)	L

AGS[™] STAINLESS STEEL

14 - 18" (355.6 - 457.0 mm) Schedule 5S .165" (4.2 mm)	G
20 - 22" (508.0 - 559.0 mm) Schedule 5S .188" (4.8 mm)	A
24" (610.0 mm) Schedule 5S .218" (5.5 mm)	B
14 - 18" (355.6 - 457.0 mm) Schedule 10S .188" (4.8 mm)	A
20 - 22" (508.0 - 559.0 mm) Schedule 10S .218" (5.5 mm)	B
24" (610.0 mm) Schedule 10S .250" (6.4 mm)	H
14 - 24" (355.6 - 610.0 mm) Schedule 10 .250" (6.4 mm)	H

5656 Rev. B R132460LBL

For complete contact information, visit victaulic.com

RP-VE460 5808 REV E UPDATED 11/2020 RPL0460000

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