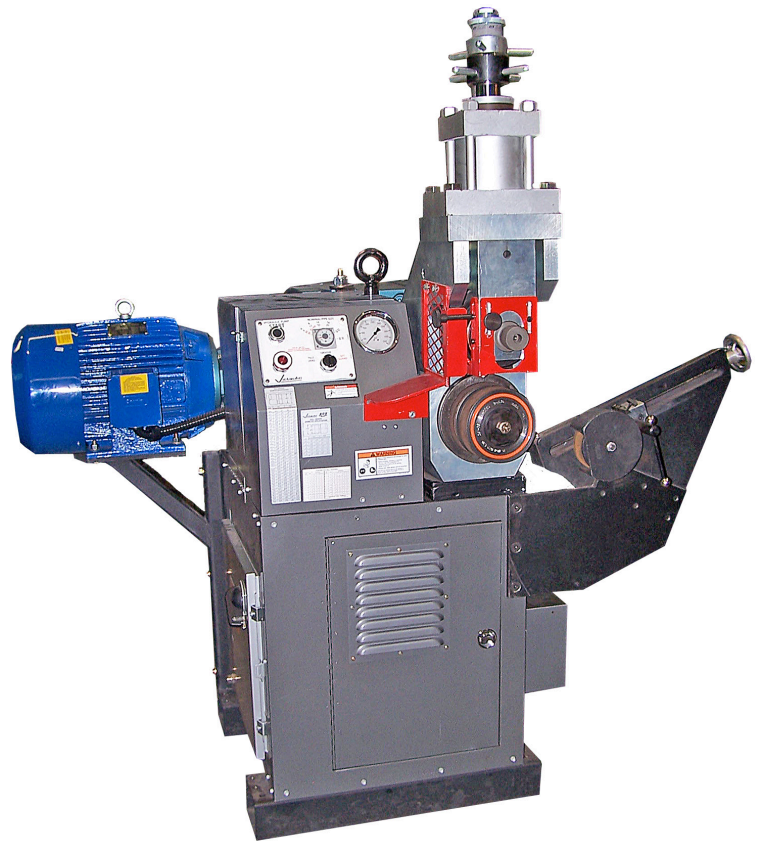


VE872 Roll Grooving Tool



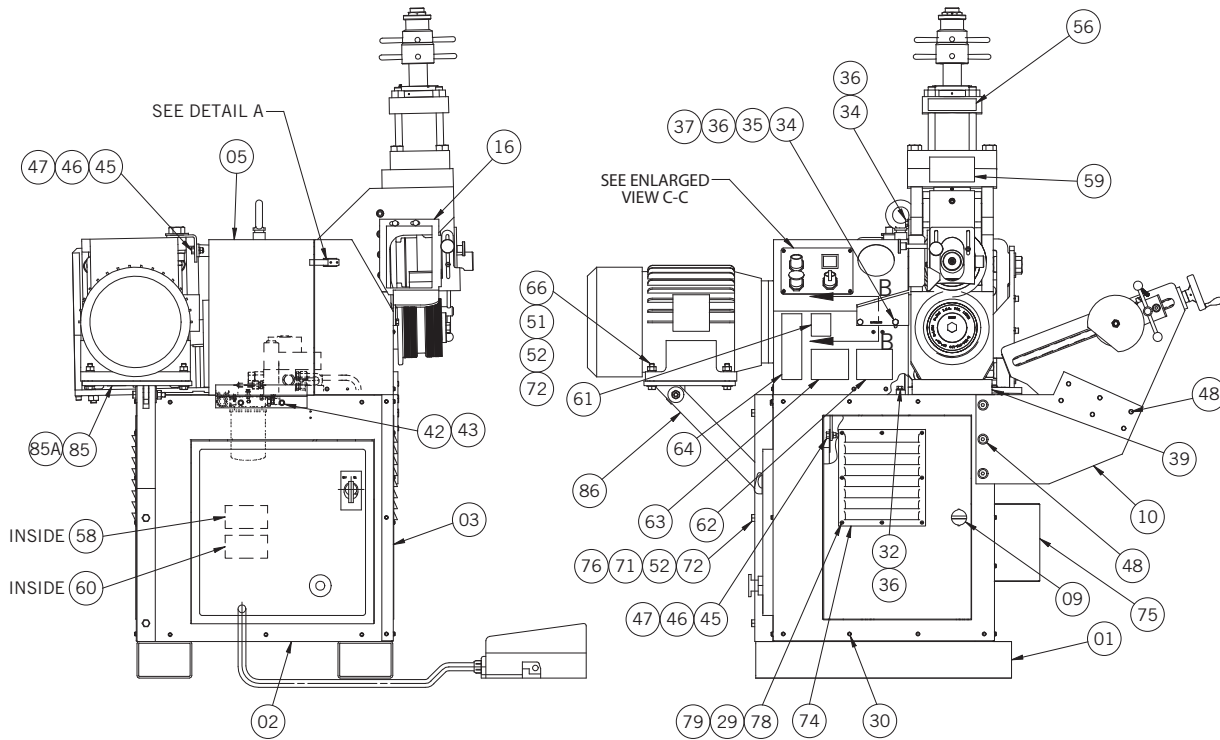
PARTS ORDERING INFORMATION

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

1. Tool Model Number – VE872
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.

VE872 Roll Grooving Tool

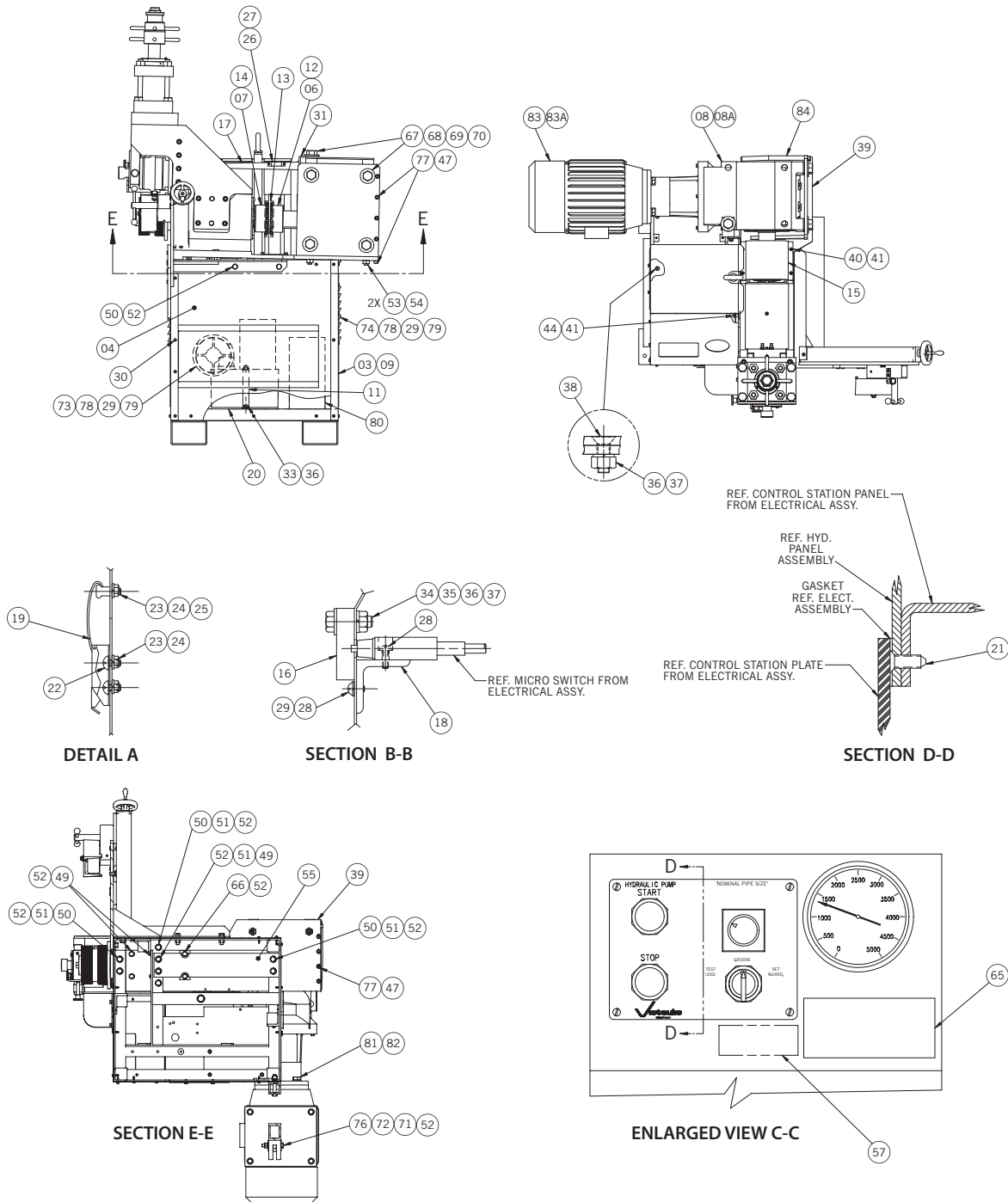


Item#	Part #	Qty.	Description
01	-	1	Frame
02	R-002-424-PNT	1	Enclosure, Left Side
03	-	2	Enclosure with Door
04	-	1	Enclosure, Right Side
05	-	1	Top Enclosure
06	-	1	Key, Square, .75 x 4.13 Lg.
07	-	1	Chain Coupling
08	-	1	Gear Reducer (Use on 230V)
08A	-	1	Gear Reducer (Use on 380V)
09	N-M07-000-001	2	Door Latch
10	-	1	Stabilizer Adapter Bracket
11	R-207-424-PNT	2	Hydraulic System Mounting Bracket
12	-	1	Chain Coupling, Ø.75 Bore
13	-	1	Chain
14	-	1	Key, Square, .50 x 1.00" Lg.
15	-	1	Coupling Guard
16	-	1	Roll Guard
17	-	1	Enclosure Support Bracket
18	R-043-424-PNT	1	Guard Interlock Switch Bracket
19	N-M07-000-002	1	Draw Latch Assembly
20	R-058-424-MCH	1	Vibration Isolator
21	-	2	#6-20 x .38 Type AB, Type 1 Cross Recessed Flat Csnk. Hd. Tapping Screw, Pltd.
22	N-S08-008-080	2	#8-32 UNC x .50 Lg. Slot. Truss Hd. Screw, Pltd.
23	N-N01-008-000	3	#8-32 UNC Hex Nut, Pltd.
24	N-W03-008-000	3	#8 Lock Washer, Pltd.
25	N-S04-008-080	1	#8-32 UNC x .50 Lg. Slot. Flt. Hd. Screw, Pltd.
26	-	2	#8-32 UNC x .38 Lg. Skt. Btn. Hd. Screw, Blk. Ox.
27	-	1	Magnetic Catch
28	N-S06-010-010	4	#10-24 UNC x .63 Lg. Pan Hd. Phillips Screw, Pltd.
29	N-W03-010-000	21	#10 Lock Washer, Pltd.
30	N-S30-012-014	39	#12-24 UNC x .88 Lg. Heavy Duty Hex Washer Hd. Structural Self Drilling Screw
31	-	1	Top Enclosure Support Bracket
32	N-S01-050-012	2	3/16-18 UNC x .75 Lg. Hex Hd. Screw, Pltd.
33	-	4	5/16-18 UNC x .50 Lg. Hex Hd. Screw, Pltd.
34	N-S01-050-100	4	5/16-18 UNC x 1.00 Lg. Hex Hd. Screw, Pltd.

Item#	Part #	Qty.	Description
35	N-W01-050-000	2	3/16" Flat Washer, Pltd.
36	N-W03-050-001	14	3/16" Lock Washer, Pltd.
37	N-N01-050-000	6	5/16-18UNC Hex Nut, Pltd.
38	N-S04-050-100	4	5/16-18UNC x 1.00 Lg. Hex Sock. Flat Hd. Blk. Ox.
39	-	1	Mounting Plate
40	N-S03-040-008	4	1/4-20UNC x .50 Lg. SHCS, Blk. Ox.
41	N-W03-040-000	5	1/4" Lock Washer, Pltd.
42	N-S01-040-008	2	1/4-20UNC x .50 Lg. Hex Hd. Screw, Pltd.
43	N-W01-040-000	2	1/4" Flat Washer, Pltd.
44	-	1	1/4-20UNC x .88 Lg. Hex Hd. Screw, Pltd.
45	N-S01-060-100	5	3/8-16UNC x 1.00 Lg. Hex Hd. Screw, Pltd.
46	N-N01-060-000	5	3/8-16UNC Hex Nut, Pltd.
47	N-W03-060-000	13	3/8" Lock Washer, Pltd.
48	-	9	1/2-13UNC x 1.00 Lg. Skt. Flat Hd. Screw, Blk. Ox.
49	N-S01-080-200	6	1/2-13UNC x 2.00 Lg. Hex Hd. Screw, Pltd.
50	-	6	1/2-13UNC x 1.50 Lg. Pilot Pt. Set Screw, Blk. Ox.
51	N-W01-080-000	12	1/2" Flat Washer, Pltd.
52	N-W03-080-000	24	1/2" Lock Washer, Pltd.
53	-	2	5/8-11UNC x 1.50 Lg. Pilot Pt. Set Screw, Blk. Ox.
54	N-N01-100-000	2	5/8-11UNC Hex Nut, Pltd.
55	-	1	Support Plate
56	R-148-424-LAB	1	Groove Diameter Adjustment Plate#
57	R-095-424-LAB	1	Control Panel Warning Label#
58	R-090-424-LAB	1	Danger Label#
59	R-091-424-LAB	1	Warning Label#
60	R-024-268-LBL	1	Operating Specifications Label#
61	R-011-424-LBL	1	"C" Diameter Reference Label, AGS#
62	R-031-272-LAB	1	Insruction Warning Label#
63	R-010-416-LAB	1	Standard Wall Thickness Label#
64	R-009-424-LBL	1	Standard Wall Thickness Label#
65	R-065-872-LBL	Ref.	Identification/Serial No. Plate#
66	-	6	1/2-13UNC x 2.50 Lg. Hex Hd. Screw, Pltd.
67	-	5	1/8-13UNC x 3.50 Lg. Hex Hd. Screw, Pltd.
68	-	5	1" Flat Washer, SAE, Pltd.
69	-	5	1" Lock Washer, Pltd.
70	-	5	1/8 UNC Hex Nut, Pltd.

Refer to pages 13 - 16 for images of product labels

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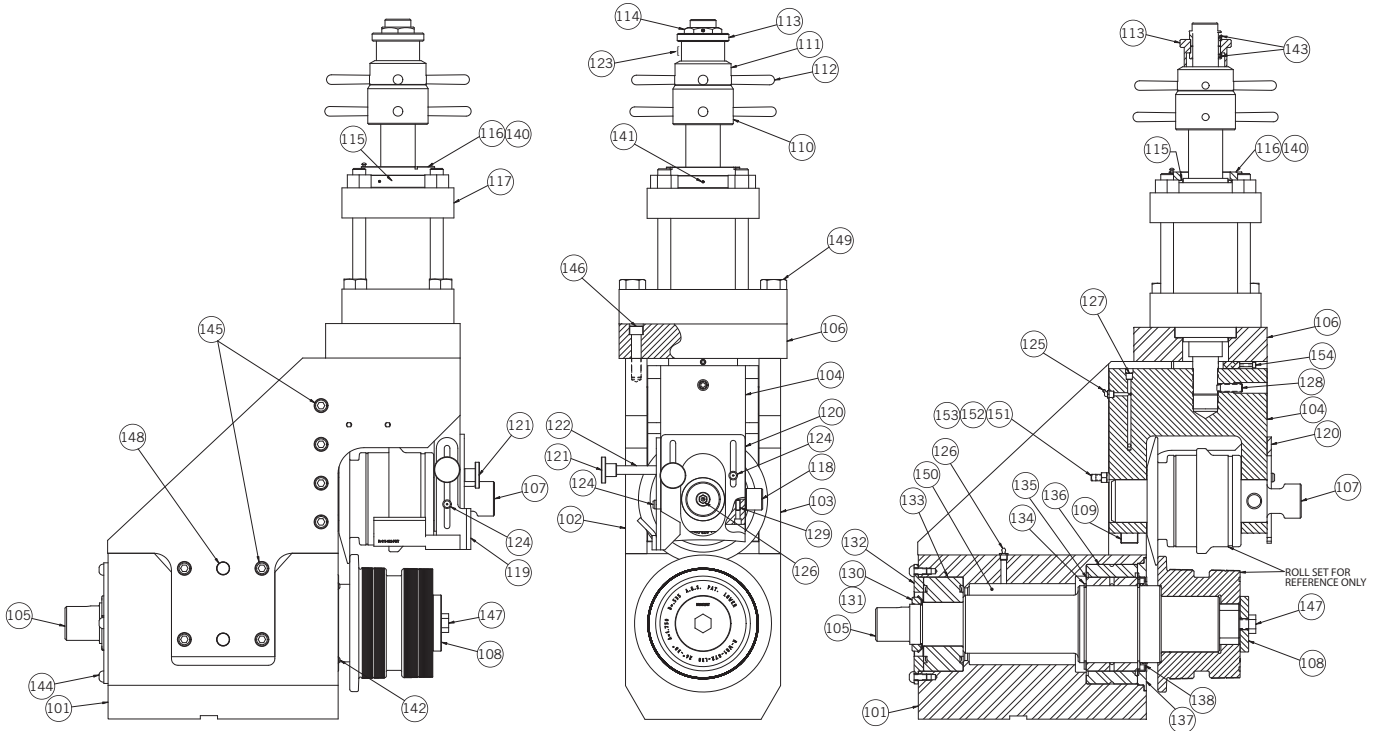


Item#	Part #	Qty.	Description
71	-	5	1/2" Flat Washer, .875 OD. Pltd.
72	N-N01-080-000	8	1/2-13UNC Hex Nut, Pltd.
73	-	1	Fan, Tube Axial
74	-	2	Louver
75	-	1	Air Intake
76	-	4	1/2-13UNC x 3.25" Lg. Hex Hd. Screw, Pltd.
77	-	8	3/8-16UNC x 2.00" Lg. Skt. Hd. Cap Screw, Pltd.
78	-	19	#10-32UNF x .375" Lg. Slotted Pan Hd. Screw, Pltd.
79	-	19	#10-32UNF Hex Nut, Pltd.
80	-	4	1/4-20UNC x .63" Lg. Skt. Hd. Screw, Blk. Ox.
81	-	4	3/4-10UNC x 2.50" Lg. Hex Hd. Bolt, Pltd.

Item#	Part #	Qty.	Description
82	-	4	3/4" Lock Washer, Pltd.
83	-	1	Motor, 230/460V
83A	-	1	Motor, 380V (Optional)
84	-	1	Gearbox Support Plarte
85	-	1	Motor Mounting Table, 230V
85A	-	1	Motor Mounting Table, 380V
86	-	1	Motor Support
87	R-207-264-LBL	1	Groove Profile Information Label (Not Shown)#

Refer to pages 13 - 16 for images of product labels

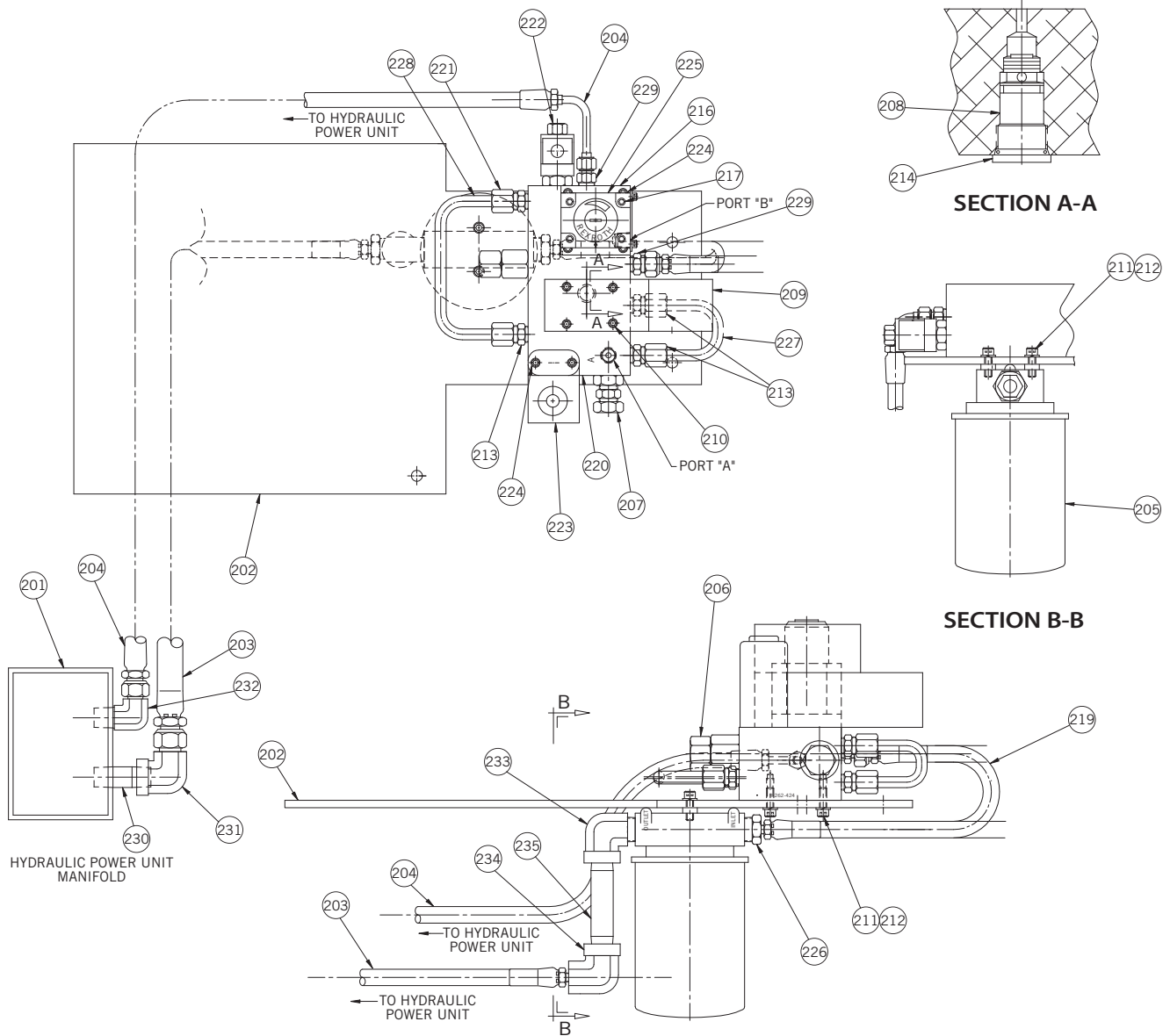
VE872 Roll Grooving Tool



Item#	Part #	Qty.	Description
101	-	1	Body
102	-	1	Side Plate, Left
103	-	1	Side Plate, Right
104	-	1	Slide
105	-	1	Main Shaft Assembly
106	-	1	Cylinder Mounting Block
107	-	1	Upper Shaft
108	-	1	Lower Roll Washer
109	-	2	Gib
110	-	1	Depth Adjuster Lock
111	R-110-436-VE0	1	Depth Adjuster
112	R-111-424-PLT	8	Depth Adjuster Handle
113	R-112-424-PLT	1	Depth Adjuster Barrel
114	R-113-436-VE0	2	Depth Adjuster Calibration Nut
115	R-114-436-VE0	1	Insulation Ring
116	R-115-436-VE0	1	Grounding Ring
117	N-M40-000-002	1	Cylinder
118	R-122-448-PLT	1	Upper Shaft Pin
119	-	1	Sliding Guard
120	-	1	Front Sliding Guard
121	N-M04-000-007	2	Knob
122	R-127-448-PNT	1	Knob Stand-Off
123	R-123-872-LBL	1	Pipe Size Indicator Label#
124	R-131-448-PLT	2	Guard Retaining Stud
125	-	1	Lube Fitting 45°
126	N-M01-000-002	2	Lube Fitting
127	-	1	1/8" Flush Socket Pressure Plug
128	N-S80-080-108	1	Set Screw with Brass Tip, 1/2-13UNC x 1.50" Lg.

Item#	Part #	Qty.	Description
129	N-M12-000-002	1	Ball Plunger
130	-	1	Locknut
131	-	1	Lockwasher
132	-	1	Rear Bearing Retainer
133	-	1	Ball Bearing
134	-	2	Retaining Ring
135	-	1	Bearing Race
136	-	1	Roller Bearing
137	-	1	Front Bearing Retainer
138	-	1	Grease Seal
139	N-S07-006-100	1	#6-32UNC x 1.00" Lg. Rnd. Hd. Slotted Screw, Pltd.
140	N-S04-006-100	2	#6-32UNC x 1.00" Lg. Flat Hd. Slotted Screw, Pltd.
141	N-S81-006-006	3	#6-32UNC x .38" Lg. Cup Pt. Set Screw, Blk. Ox.
142	-	4	#10-32UNF x .75" Lg. Skt. Btn. Hd. Screw, Blk. Ox.
143	-	2	#10-32UNF x .25" Lg. Set Screw W/Brass Tip
144	-	4	3/8-16UNC x .75" Lg. Skt. Btn. Hd. Screw, Blk. Ox.
145	-	16	1/2-13UNC x 1.25" Lg. SHCS, Blk. Ox.
146	-	8	1/2-13UNC x 2.50" Lg. SHCS, Blk. Ox.
147	-	1	3/8-11UNC x 1.50" Lg. HHCS, Grd. 8, Pltd.
148	-	4	Dowel Pin, Ø .750 x 1.75" Lg. STL. Hdn. Gnd.
149	-	4	7/8-9UNC x 3.50" Lg. HHCS, Grd. 8, Pltd.
150	-	As Req	Grease
151	-	2	Pilot Pt. Sq. Hd. Set Screw, 3/8-16UNC x 3.0" Lg. Blk. Ox.
152	N-N01-060-000	2	Hex Nut, 3/8-16UNC, Pltd.
153	-	2	3/8" Hi-Collar Lock Washer, Blk. Ox.
154	-	1	Slide Spacer Assembly

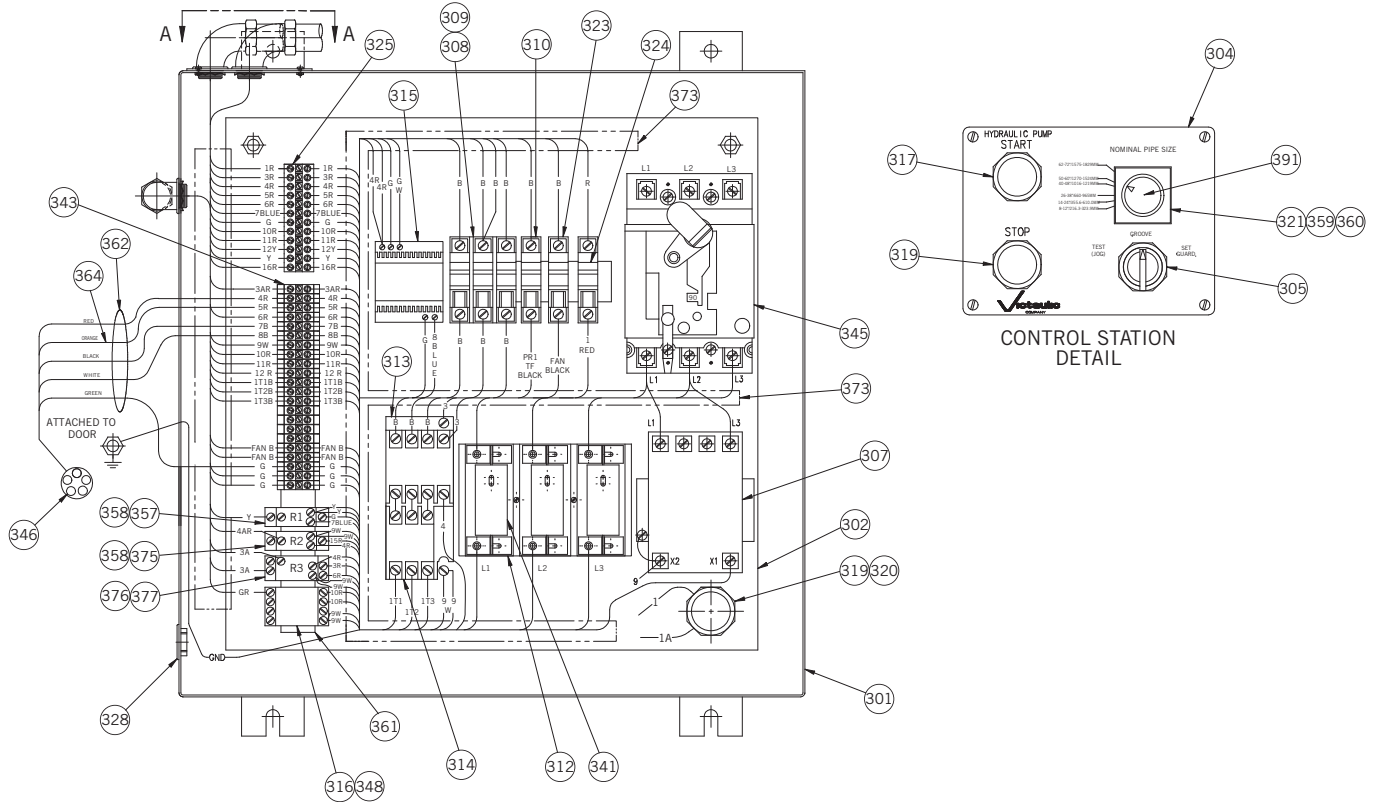
VE872 Roll Grooving Tool



Item#	Part #	Qty.	Description
201	N-H05-000-005	1	Hydraulic Power Unit
202	R-204-424-PNT	1	Hydraulic System Mounting Plate
203	-	1	Hose Assembly
204	-	1	Hose Assembly
205	N-H08-000-002	1	Return Line Filter
206	N-H04-000-030	1	Relief Valve
207	N-H04-000-002	1	Relief Valve
208	N-H04-000-003	1	Check Valve
209	N-H04-000-004	1	4-Way Valve
210	N-S03-010-200	4	#10-24UNC x 2.0" Lg. SHCS, Blk. Ox.
211	N-W03-040-000	4	1/4" Lock Washer, Pltd.
212	N-S03-040-012	4	1/4-20UNC x .75" Lg. SHCS, Blk. Ox.
213	N-H11-006-001	3	Connector
214	N-H16-010-001	1	O-Ring Plug
215	-	As Req	Hydraulic Oil, ISO 32
216	N-H04-000-032	1	Adapter Plate, Bieri #60333
217	-	4	M5 x .8 x 35MM Lg. SHCS. Blk. Ox.
218	-	As Req	Ribbon Dope
219	R-259-424-VE0	1	Hose Assembly

Item#	Part #	Qty.	Description
220	R-262-424-MAC	1	Hydraulic Manifold
221	N-H11-006-002	1	Connector
222	N-H04-000-005	1	Solenoid Valve
223	N-H18-000-001	1	Pressure Switch
224	N-S03-010-100	6	#10-24UNC x 1.0" Lg. SHCS, Blk. Ox.
225	N-H04-000-006	1	2-Way Valve
226	N-H11-008-001	1	Reducing Bushing
227	R-276-424-MAC	1	Hydraulic Tubing, Manifold to Manifold
228	R-277-424-MAC	1	Hydraulic Tubing, Manifold to Manifold
229	N-H11-004-001	2	Male Connector
230	N-H11-004-002	1	Pipe Nipple, 1/4" SCH.40 x 1.50" Lg. Thread Both Ends
231	N-H12-004-006	1	90° Female Elbow, 1/4 Female NPT x 3/8-37° Flare Tube
232	N-H12-004-004	1	90° Male Elbow, 1/4 Male NPT x 1/4-37° Flare Tube
233	-	1	90° Street Elbow, Steel, 1/2 Male NPT x 3/8 Female NPT
234	-	1	90° Street Elbow, Steel, 3/8 Female NPT x 1/4 Female NPT
235	-	1	Pipe Nipple, 3/8" Sch. 40 x 3.0" Lg. Thread Both Ends

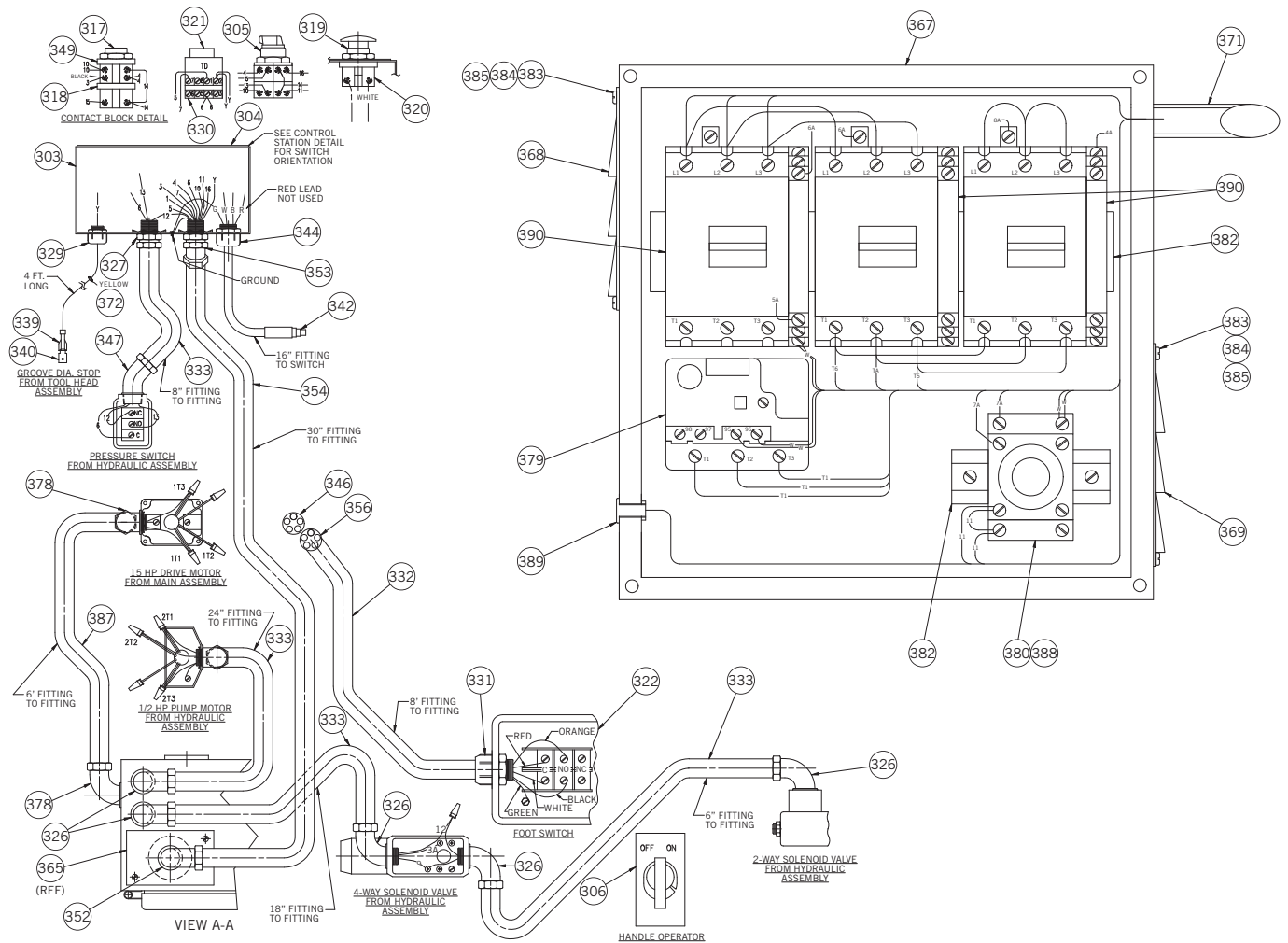
VE872 Roll Grooving Tool



Item#	Part #	Qty.	Description
301	R-301-424-PNT	Ref.	Main Electrical Enclosure
302	-	1	Main Enclosure Panel
303	R-303-460-MCH	Ref.	Control Station Enclosure
304	R-304-872-LBL	Ref.	Control Station Plate#
305	N-E02-000-013	1	Switch, 3-Position, Square D #9001KS42BH2
306	-	1	Oper. Mech.
307	-	1	Transformer, 230V, 60HZ
308	-	1	Fuse Holder
309	-	3	Fuse, Buss
310	-	2	Fuse, Buss, 1 Amp
311	-	1	Reducer Bushing
312	-	1	Fuse Block
313	-	1	Contactora
314	-	1	Thermal Overload
315	N-E16-000-002	1	Power Supply
316	-	1	Relay Socket, 8 Pin
317	N-E02-000-001	1	Push Button Oper. - Blk
318	N-E02-000-004	1	Contact Block
319	N-E02-000-002	2	Push Button Oper. - Red
320	N-E02-000-005	2	Contact Block
321	N-E09-000-004	1	Time Delay Relay with Adjustable Timer
322	N-E03-000-003	1	Foot Switch

Item#	Part #	Qty.	Description
323	-	3	Fuse Holder
324	-	1	Fuse, Buss
325	-	3	Plug Contact Block DIN Rail
326	-	5	Connector
327	-	1	Liq. Tight Conn.
328	-	1	Strain Relief
329	-	1	Strain Relief
330	-	1	Time Delay Relay Socket
331	-	1	Strain Relief Connector, Straight, Liquid Tight
332	-	12 Ft	Control Connector
333	-	93"	1/2" Plastic Liq. Tight
334	-	As Req	12 Ga. Black MTW (Line voltage circuits)
335	-	As Req	16 Ga. Red MTW (AC control circuits)
336	-	As Req	16 Ga. White MTW (Neutral)
337	-	As Req	16 Ga. Blue MTW (DC control circuits)
338	-	As Req	12 Ga. Green MTW (Ground)
339	-	1	Female Disconnect
340	-	1	Male Tab
341	-	3	Fuse
342	N-E02-000-006	1	Switch
343	-	3	Plug Contact Block
344	-	1	Strain Relief, Straight

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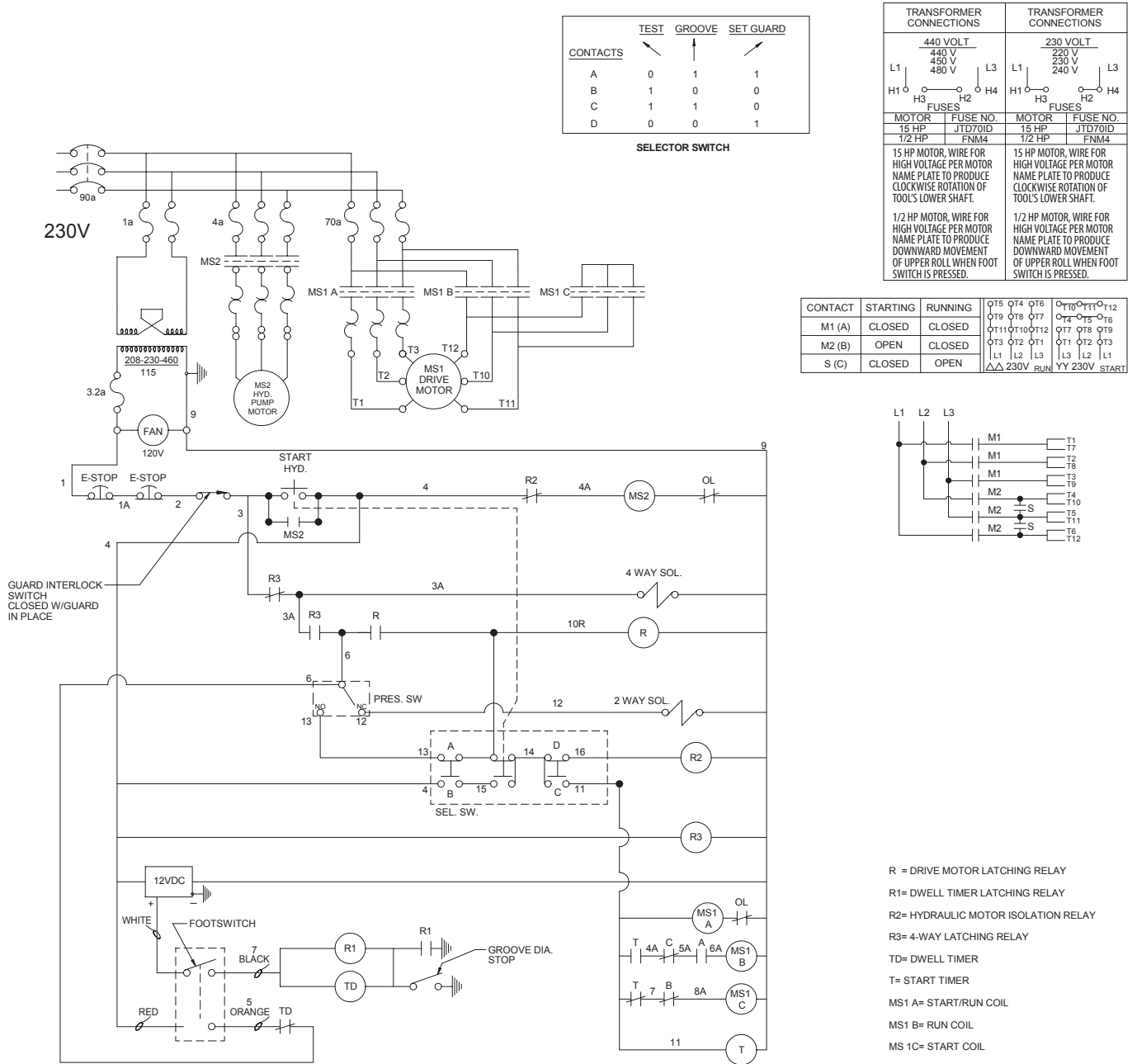
Item#	Part #	Qty.	Description
345	-	1	Circuit Breaker
346	N-E19-000-002	1	Receiver
347	-	1	Connector
348	-	1	Relay
349	-	3	Contact Block
352	-	1	Connector
353	-	1	Liq. Tight Connector
354	-	30"	3/4" Plastic Liquid Tight
355	-	6'	Flexible Conduct
356	N-E08-000-001	1	Male Plug
357	-	1	Relay, 12VDC
358	-	2	Relay Socket
359	-	1	Time Delay Relay Mnt. Frame
360	-	1	Time Delay Relay Gasket
361	-	1	DIN Rail Mounting Channel
362	-	24"	Spiral Wrap
364	-	As Req	16 Ga. Orange MTW (AC contol circuits)
365	R-301-424-PNT	Ref.	Cover Plate
366	-	As Req	12 Ga. Yellow MTW (interrupted ground)
367	-	1	Soft Start Enclosure
368	-	1	Louver

Item#	Part #	Qty.	Description
369	-	1	Louver, Modification
371	-	1	Pulling Elbow
372	-	As Req	16 Ga. Yellow MTW (Groove Dia. Stop Grnd. Ring)
373	-	As Req	Wireduct
375	-	1	Relay
376	-	1	Relay
377	-	1	Relay Socket
378	-	2	Connector, 90° Liquid Tight
379	-	1	Overload Relay, 230V
380	-	1	Relay with Timing Function
382	-	12"	DIN Rail Mount. Channel
383	-	6	10-32UNF x .38 Lg. SLTD. PAN Hd. Screw, Pltd.
384	-	6	#10 Lock Washer, Pltd.
385	-	6	10-32UNF Hex Nut, Pltd.
388	-	1	Relay Socket, 8 Pin
389	-	1	Connector, Liquid Tight
390	-	3	Contactors, 120V
391	R-651-414-LBL	1	Dial Label#
392	R-305-872-LBL	Ref.	Power Requirements Plate#

Refer to pages 13 - 16 for images of product labels

VE872 Roll Grooving Tool

ELECTRICAL SCHEMATIC (230-VOLT)



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

SELECTOR SWITCH

TRANSFORMER CONNECTIONS		TRANSFORMER CONNECTIONS	
440 VOLT		230 VOLT	
L1	440 V	L1	220 V
H1	450 V	H1	230 V
H3	480 V	H3	240 V
H2		H2	
H4		H4	
FUSES		FUSES	
MOTOR	FUSE NO.	MOTOR	FUSE NO.
15 HP	JTD701D	15 HP	JTD701D
1/2 HP	FNM4	1/2 HP	FNM4

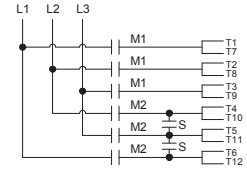
15 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAME PLATE TO PRODUCE COUNTERCLOCKWISE ROTATION OF TOOL'S LOWER SHAFT.

1/2 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAME PLATE TO PRODUCE COUNTERCLOCKWISE ROTATION OF TOOL'S LOWER SHAFT.

1/2 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAME PLATE TO PRODUCE COUNTERCLOCKWISE ROTATION OF TOOL'S LOWER SHAFT.

1/2 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAME PLATE TO PRODUCE COUNTERCLOCKWISE ROTATION OF TOOL'S LOWER SHAFT.

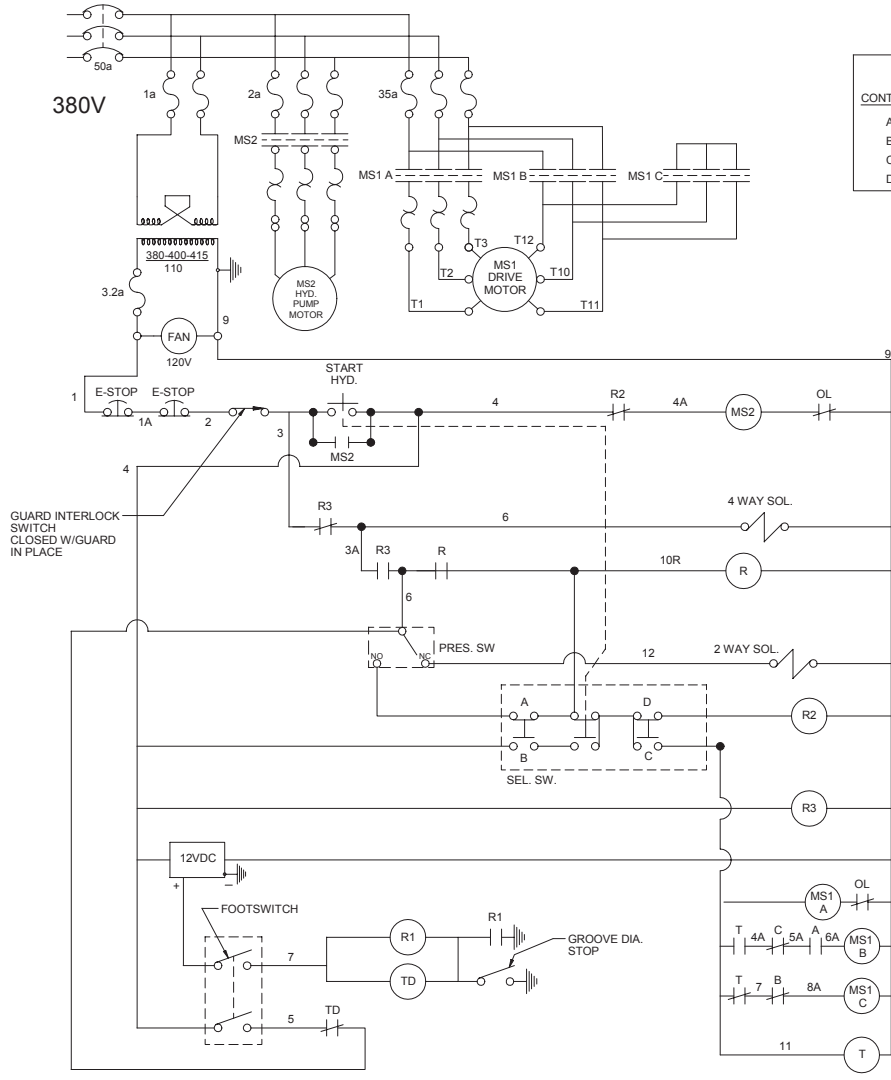
CONTACT	STARTING	RUNNING	Q75 Q76 Q77 Q78 Q79 Q80 Q81 Q82 Q83
M1 (A)	CLOSED	CLOSED	Q75 Q76 Q77 Q78 Q79 Q80 Q81 Q82 Q83
M2 (B)	OPEN	CLOSED	Q84 Q85 Q86 Q87 Q88 Q89 Q90 Q91 Q92 Q93
S (C)	CLOSED	OPEN	L1 L2 L3 L1 L2 L1



- R = DRIVE MOTOR LATCHING RELAY
- R1= DWELL TIMER LATCHING RELAY
- R2= HYDRAULIC MOTOR ISOLATION RELAY
- R3= 4-WAY LATCHING RELAY
- TD= DWELL TIMER
- T= START TIMER
- MS1 A= START/RUN COIL
- MS1 B= RUN COIL
- MS1 C= START COIL

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ELECTRICAL SCHEMATIC (380-VOLT)



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

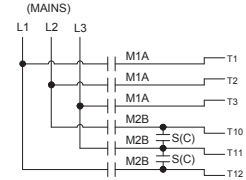
SELECTOR SWITCH

TRANSFORMER CONNECTIONS	
380 VOLT	
L1	380V
H1	H3
H2	H4
FUSES	
MOTOR	FUSE NO.
15 HP	JTD35ID
1/2 HP	FNB2

15 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAME PLATE TO PRODUCE CLOCKWISE ROTATION OF TOOL'S LOWER SHAFT.
1/2 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAME PLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOT SWITCH IS PRESSED.

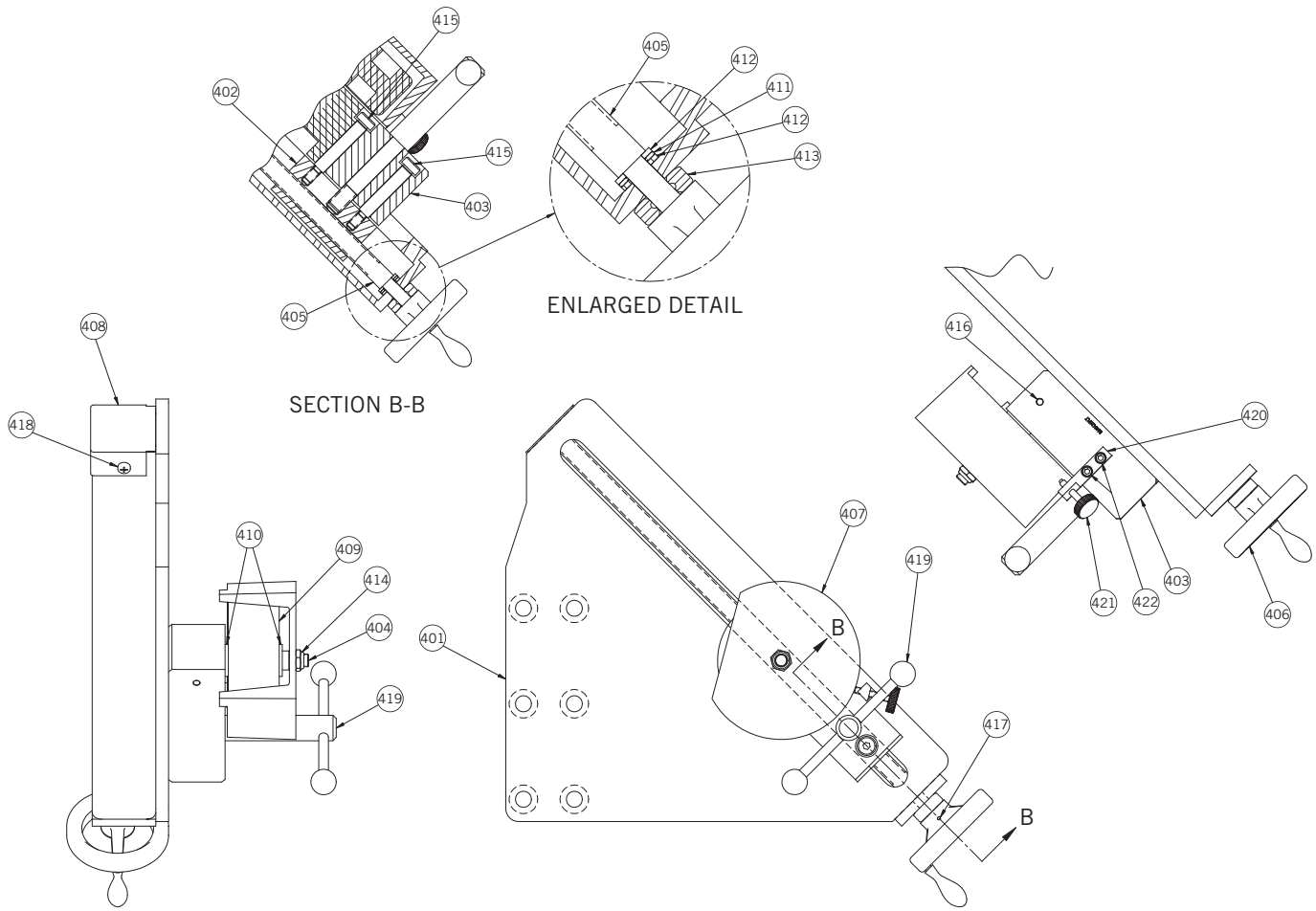
CONTACT	STARTING	RUNNING	Q16	Q15	Q14	Q11	Q11	Q12
M1(A)	CLOSED	CLOSED	Q16	Q15	Q14	Q11	Q11	Q12
M2(B)	OPEN	CLOSED	Q13	Q12	Q11	Q11	Q12	Q13
S(C)	CLOSED	OPEN	L1	L2	L3	L3	L2	L1

Δ 380V/460V Y 380V/460V



- R = DRIVE MOTOR LATCHING RELAY
- R1= DWELL TIMER LATCHING RELAY
- R2= HYDRAULIC MOTOR ISOLATION RELAY
- R3= 4-WAY LATCHING RELAY
- TD= DWELL TIMER
- T= START TIMER
- MS1 A= START/RUN COIL
- MS1 B= RUN COIL
- MS1 C= START COIL

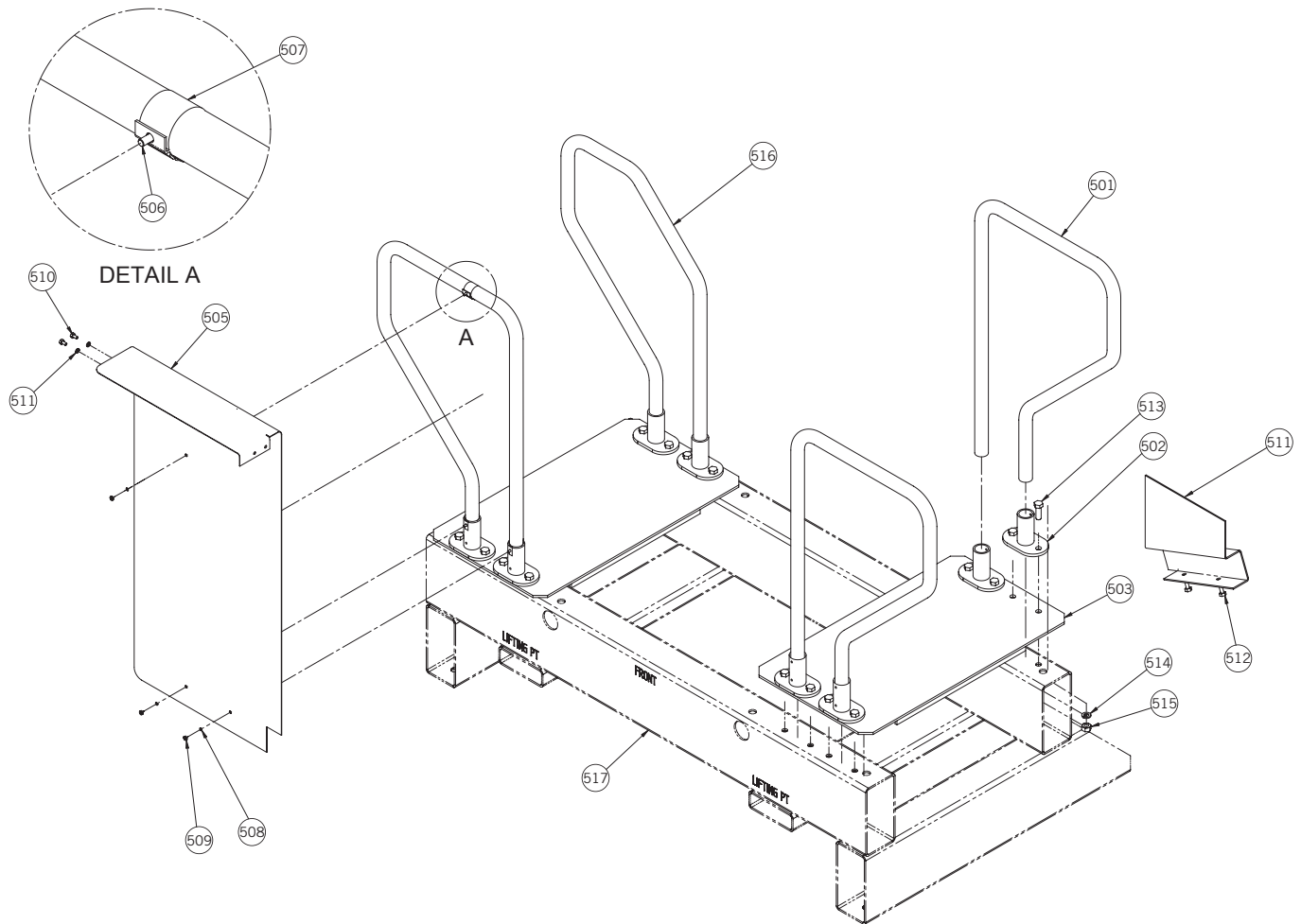
VE872 Roll Grooving Tool



Item#	Part #	Qty.	Description
401	-	1	Stabilizer Main Body
402	R-402-424-PLT	1	Guide Nut
403	-	1	Guide, Modification
404	R-404-424-MAC	1	Roller Shaft
405	R-405-424-MAC	1	Adjusting Screw
406	R-406-424-MAC	1	Hand Wheel
407	-	1	Roller Guard
408	R-408-424-PNT	1	Tube Cap
409	N-M05-000-002	1	Wheel, Polyurethane
410	N-B05-075-004	2	Thrust Washer
411	N-B03-050-001	1	Thrust Bearing

Item#	Part #	Qty.	Description
412	N-B05-050-003	2	Thrust Washer
413	N-B03-050-002	1	Thrust Bearing
414	-	1	Hex Nut, 1/2-20UNF, Pltd.
415	N-S05-080-208	2	Ø.50 x 2.50" Lg. Sock. Hd. Shoulder Screw
416	N-P01-004-208	1	Ø.25 x 2.50" Lg. Roll Pin
417	N-P01-002-104	1	Ø.13 x 1.25" Lg. Roll Pin
418	-	2	1/4-20UNC x .38" Lg. Pan Hd. Phillips Screw, Pltd.
419	R-419-424-PLT	1	Locking Handle
420	-	1	Roller Guard Locking Bracket
421	-	1	Knurled Hd. Steel Knob
422	N-S03-040-010	2	1/4-20UNC x .63" Lg. SHCS, Blk. Ox.

VE872 Roll Grooving Tool



Item#	Part #	Qty.	Description
501	R-553-460-PNT	3	Support Base Railing
502	-	8	Slip-On Structural Fitting
503	R-552-460-PNT	2	Platform
504	-	1	Left Side Guard
505	-	3	#10-24 UNC x .38 Lg. Skt. Btnhd. Screw, Blk. Ox.
506	-	3	Cinch Strap
507	-	3	#10 Lockwasher, Pltd.
508	-	3	#10-24 UNC Hex Nut, Pltd.
509	-	2	1/4-20 UNC x .50 Lg. Hex Hd. Screw, Pltd.

Item#	Part #	Qty.	Description
510	-	2	1/4" Lockwasher, Pltd.
511	-	1	Stabilizer Top Guard
512	-	2	5/16-18 UNC x 1.00 Lg. Hex Hd. Screw, Pltd.
513	-	16	1/2-13 UNC x 1.50" Lg. Hex Hd. Bolt, Pltd.
514	-	16	1/2" Lock Washer-Pltd
515	-	16	1/2-13 UNC Hex Nut, Pltd.
516	-	1	Support Base Railing, Special
517	-	1	Support Base

NOTE: Four concrete anchors (5/8 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 - 72-inch/1270 - 1829-mm pipe sizes require three support bases

VE872 Roll Grooving Tool

GROOVING ROLL INFORMATION FOR THE ORIGINAL GROOVE SYSTEM

8 – 48-inch/219.1 – 1219-mm Steel Pipe, Original Groove System

Pipe Size		Original Groove System
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	Roll Part Numbers
8 - 12	8.625 - 12.750 219.1 - 323.9	Lower Roll R9Q1872L12 Upper Roll R9Q1872A12 Roll Set R9Q1872012

GROOVING ROLL INFORMATION FOR THE ADVANCED GROOVE SYSTEM (AGS)

8 – 48-inch/219.1 – 1219-mm Steel Pipe, Original Groove System

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 RWQ1872L24 Upper Roll RWQ1872A24 Roll Set RWQ1872024
26 OD - 38 OD	26.000 - 38.000 660 - 965	Lower Roll RWQ1872L38 Upper Roll RWQ1872A38 Roll Set RWQ1872038
40 OD - 48 OD	40.000 - 48.000 1016 - 1219	Lower Roll RWQ1872L48 Upper Roll RWQ1872A48 Roll Set RWQ1872048
50 OD - 72 OD	50.000 - 72.000 1270 - 1829	Lower Roll RWQ1872L72 Upper Roll RWQ1872A72 Roll Set RWQ1872072

VE872 Roll Grooving Tool

Images of the labels on pages 12 - 15 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

**ORIGINAL GROOVE SYSTEM (OGS)
ROLL GROOVE DIAMETER
SPECIFICATIONS**

4864 Rev. E - R009424LBL

SIZE	O.D.		Ø "C"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
¾ [26.9]	1,060 [26.9]	1,040 [26.4]	0,938 [23.8]	0,923 [23.4]
1 [33.7]	1,328 [33.7]	1,302 [33.1]	1,190 [30.2]	1,175 [29.9]
1¼ [42.4]	1,676 [42.6]	1,644 [41.8]	1,535 [39.0]	1,520 [38.6]
1½ [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]
2½ [73.0]	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]
3½ [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]
4½ [127.0]	5,050 [128.3]	4,969 [126.2]	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]
203.2 mm	8,063 [204.8]	7,969 [202.4]	7,816 [198.5]	7,791 [197.9]
8 [219.1]	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 [273.0]	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 [323.9]	12,813 [325.5]	12,719 [323.1]	12,531 [318.3]	12,501 [317.5]
14 OD [355.6]	14,063 [357.2]	13,969 [354.8]	13,781 [350.0]	13,751 [349.3]
15 OD [381.0]	15,063 [382.6]	14,969 [380.2]	14,781 [375.4]	14,751 [374.7]
16 OD [406.4]	16,063 [408.0]	15,969 [405.6]	15,781 [400.8]	15,751 [400.1]
18 OD [457]	18,063 [458.8]	17,969 [456.4]	17,781 [451.6]	17,751 [450.9]
20 OD [508]	20,063 [509.6]	19,969 [507.2]	19,781 [502.4]	19,751 [501.7]
22 OD [559]	22,063 [560.4]	21,969 [558.0]	21,656 [550.1]	21,626 [549.3]
24 OD [610]	24,063 [611.2]	23,969 [608.8]	23,656 [600.9]	23,626 [600.1]
26 OD [660]	26,063 [662.0]	25,937 [658.8]	25,500 [647.7]	25,437 [646.1]
28 OD [711]	28,063 [712.8]	27,937 [709.6]	27,500 [698.5]	27,437 [696.9]
30 OD [762]	30,063 [763.6]	29,937 [760.4]	29,500 [749.3]	29,437 [747.7]
32 OD [813]	32,063 [814.4]	31,937 [811.2]	31,500 [800.1]	31,437 [798.5]
36 OD [914]	36,063 [916.0]	35,937 [912.8]	35,500 [901.7]	35,437 [900.1]
42 OD [1067]	42,063 [1068.4]	41,937 [1065.2]	41,500 [1054.1]	41,437 [1052.5]
48 OD [1219]	48,063 [1220.8]	47,937 [1217.6]	47,500 [1206.5]	47,437 [1204.9]

R-024-268-LBL

MODEL

SERIAL NUMBER

DRIVE MOTOR

VOLTS	PHASE	HERTZ
208/230	1	50
440/460	3	60
380/400		50/60

HYDRAULIC MOTOR

VOLTS	PHASE	HERTZ
208/230	1	50
440/460	3	60
380/400		50/60

FULL-LOAD CURRENT

AMPS AT 230 VOLTS
AMPS AT 460 VOLTS
AMPS AT 380 VOLTS

FULL-LOAD CURRENT

AMPS AT 230 VOLTS
AMPS AT 460 VOLTS
AMPS AT 380 VOLTS

• GEAR OIL – AGMA 7

• HYDRAULIC OIL – HIGH-PRESSURE, ANTI-WEAR ISO GRADE 32

• BEARING LUBE – ANTI-WEAR, EXTREME PRESSURE NLGI GRADE 2

Electrical Assembly Drawing Revision Level

R-095-424-LAB

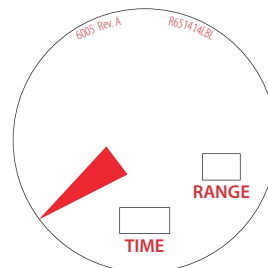
DANGER

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



VE872 Roll Grooving Tool

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

VE872 Roll Grooving Tool

R-123-872-LBL

8" - 12" 8 STD. & SCH.40 10-12 STD. & SCH.40 12 SCH.40 8-12 .500 WALL X-STRONG	14" - 24" AGS™ STD. .375 14-24	14" - 24" AGS™ .500 WALL, X-STRONG 14-24	26" - 72" AGS™ STD. .375 54-72 42-48 26-36	26" - 72" AGS™ .500 WALL 54-72 42-48 26-36
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6035 Rev. D R123872LBL

R-305-872-LBL

VE872

POWER SUPPLY REQUIREMENTS

230 VOLTS - 3 PHASE - 60 CYCLE
 FULL LOAD CURRENT 37.4 AMPS
 RATING OF LARGEST MOTOR 34.4 AMPS
 SHORT CIRCUIT INTERRUPTING CAPACITY 18,000 AMPS
 DIAGRAM NO. R-310-872-SCH

6008 Rev. A R305872LBL

R-065-872-LBL

VE872

VICTAULIC TOOL CO.

SERIAL NO.

R065872LBL

6034 Rev. C

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.

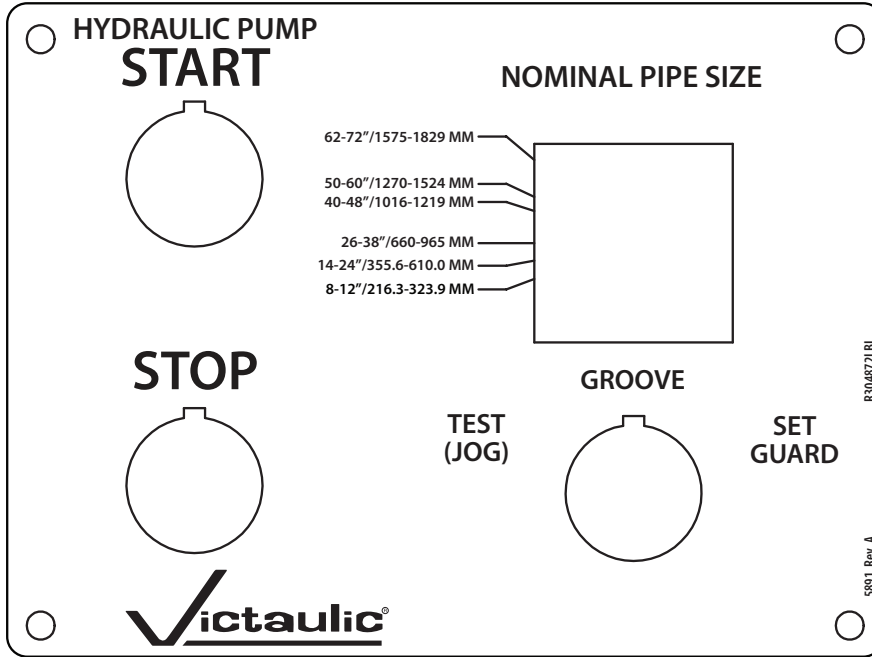
OD= Average Pipe Outside Diameter
 T = Pipe Wall Thickness
 A = Distance from Pipe End to Groove

B = Groove Width
 C = Average Diameter at Base of Groove
 D = Groove Depth
 F = Pipe-End Flare

7264 Rev. A R207264LBL

VE872 Roll Grooving Tool

R-304-872-LBL



R-011-424-LBL

Victaulic
AGS ROLL GROOVE DIAMETER SPECIFICATION

O.D.
Ø"C"

4810 Rev. G R011424LBL

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]
16 [406.4]	16.094 [408.8]	15.969 [405.6]	15.500 [393.7]	15.455 [392.6]
18 [457]	18.094 [459.6]	17.969 [456.4]	17.500 [444.5]	17.455 [443.4]
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]

For complete contact information, visit www.victaulic.com

RP-VE872 6173 REV B UPDATED 09/2013 RPL0872000

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RP-VE872

