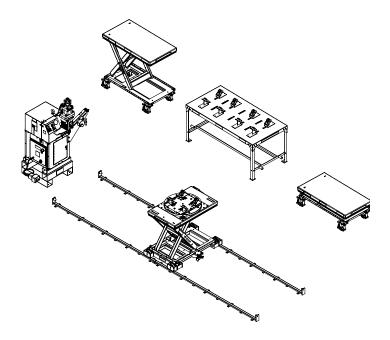
Series VAP131 Victaulic Lean Fabrication Cell for European Market

VAP131R VICTAULIC HYDRAULIC, ADJUSTABLE PIPE STAND VAP131F VICTAULIC HYDRAULIC POSITIONER VAP131T VICTAULIC ASSEMBLY TABLE



WARNING



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

- Before operating or servicing any pipe preparation tools, read all instructions in the operating and maintenance manual and all warning labels on the tool.
- Wear safety glasses, hardhat, foot protection, and hearing protection while working around pipe preparation tools.
- Save the operating and maintenance manual in a place accessible to all operators of the tool.

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

Original Instructions



TM-VAP131.EUR / Operating and Maintenance Instructions Manual

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HAZARD IDENTIFICATION

Definitions for identifying the various hazard levels are provided below.



This safety alert symbol indicates important safety messages. When you see this symbol, be alert to the possibility of personal injury. Carefully read and fully understand the message that follows.

A DANGER

 The use of the word "DANGER" identifies an immediate hazard with a likelihood of death or serious personal injury if instructions, including recommended precautions, are not followed.

WARNING

 The use of the word "WARNING" identifies the presence of hazards or unsafe practices that could result in death or serious personal injury if instructions, including recommended precautions, are not followed.

A CAUTION

 The use of the word "CAUTION" identifies possible hazards or unsafe practices that could result in personal injury and product or property damage if instructions, including recommended precautions, are not followed.

NOTICE

 The use of the word "NOTICE" identifies special instructions that are important but not related to hazards.

OPERATOR SAFETY INSTRUCTIONS

Series VAP131 Hydraulic, Adjustable Pipe Stands; Adjustable Positioners; and Assembly Tables are designed only for supporting pipe to be roll grooved and for supporting grooved pipe, valves, and fittings during assembly. The owner, lessee, or user is responsible for ensuring that each operator reads this manual and the hydraulic lift manufacturer's service manual and fully understands all requirements PRIOR to operation or servicing of Series VAP131 equipment. These instructions describe safe operation, including setup and maintenance. Each operator shall become familiar with the equipment's operations, applications, and limitations. Particular attention shall be given to reading and understanding the dangers, warnings, and cautions described throughout this manual.

Operators shall follow all appropriate Occupational Safety and Health Administration (OSHA) guidelines and training, and/or other nationally-recognized standards, as well as jobsite-specific requirements. Use of this equipment requires dexterity, mechanical skills, and sound safety habits. Although this equipment is designed and manufactured for safe, dependable operation, it is difficult to anticipate all combinations of circumstances that could result in an accident. The operator is cautioned to always practice "safety first" during each phase of use, including setup and maintenance.

Store this manual in a clean, dry area where it is always readily available. Additional copies are available upon request through your Victaulic Sales Representative, or a PDF version can be downloaded at victaulic.com.



A DANGER

- Avoid using Series VAP131 equipment in potentially dangerous environments. Do not expose
 the equipment to rain, and do not use equipment in damp or wet locations. Do not use equipment
 on sloped or uneven surfaces. Keep the work area well lit. Allow sufficient space to operate
 equipment properly.
- Ground equipment to protect the operator from electric shock. Verify that equipment is grounded properly prior to use.
- 3. Disconnect electrical power before servicing equipment. Only authorized personnel shall perform maintenance on the equipment. Always disconnect power before servicing or adjusting equipment.

A WARNING

- Prevent back injury. Do not attempt to lift any Series VAP131 equipment without mechanical lifting assistance.
- 2. Wear proper apparel. Do not wear loose clothing, jewelry, or anything that can become entangled in moving parts.
- 3. Wear protective items when working with tools. Always wear safety glasses, hardhat, foot protection, and hearing protection.
- 4. Keep hands and tools away from the ball transfers while pipe is being loaded or positioned. Pipe rotation can crush fingers and hands if caught between the pipe and ball transfers.
- 5. Do not reach inside the pipe ends during tool operation. Pipe edges can be sharp and can snag gloves, hands, and shirt sleeves. Fingers and hands can be crushed between pipe and lower roll.
- **6. Do not over-reach.** Maintain proper footing and balance at all times. DO NOT reach across the pipe preparation tool or pipe during operation.

A CAUTION

- Series VAP131 components are designed ONLY for supporting pipe to be roll grooved for pipe sizes, materials, and wall thicknesses listed in the "Pipe Ratings" section.
- 2. Inspect the equipment. Before using Series VAP131 Hydraulic, Adjustable Pipe Stands; Adjustable Positioners; and Assembly Tables, check all moveable parts for any obstructions. Verify that all components are installed and secured properly.
- **3. Stay alert.** Do not operate pipe preparation tools and Series VAP131 equipment if you are drowsy from medication or fatigue.
- **4. Keep visitors, trainees, and observers away from the immediate work area.** All visitors shall be kept a safe distance from the equipment at all times.
- 5. Keep work areas clean. Keep the work area around the pipe preparation tool and Series VAP131 equipment clear of any obstructions that could limit the movement of the operator. Clean up any oil or other spills.
- The VAP131 Assembly Table, the track system, and the tool support shall be leveled and fastened securely to the ground or floor to prevent movement.
- **7. Do not force the equipment.** Do not force equipment to perform any functions beyond the capabilities described in these instructions. Do not overload equipment.
- **8. Maintain pipe preparation tools and accessories with care.** Keep equipment clean at all times to ensure proper and safe performance. Follow the instructions for lubricating components.
- Use only Victaulic replacement parts and accessories. Use of any other parts may result in a voided warranty, improper operation, or hazardous situations. Refer to the "Parts Ordering Information" section.
- Do not remove any labels from the pipe preparation tool or Series VAP131 equipment. Replace any damaged or worn labels.



INTRODUCTION

NOTICE

- . Drawings and/or pictures in this manual may be exaggerated for clarity.
- Series VAP131 components, along with this operating and maintenance instructions manual, contain trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic Company.
- For the VAP131R and VAP131F, always refer to the hydraulic lift manufacturer's service manual, provided with the shipment, for complete operating and maintenance instructions.

A CAUTION

- Series VAP131 components shall be used ONLY for supporting pipe designated in the "Pipe Ratings" section.
- . Series VAP131 components are not designed to support fittings for roll grooving.
- DO NOT use VAP131 components outdoors.

Failure to follow these instructions could result in damage to the equipment.

VAP131R Hydraulic, Adjustable Pipe Stands are designed specifically for supporting pipe to be grooved with Victaulic Roll Grooving Tools. The VAP131R is a heavy-duty unit that permits ease of pipe rotation on ball transfers, which are mounted to permit the use of pipe slings. A slot system is incorporated into the rotating table of the VAP131R, which permits adaptation of the ball transfer assemblies for accommodating various pipe sizes. Refer to the "NOTE" in the following column.

The turnstile design of the VAP131R allows pipe to be spun around for grooving of both ends without dismounting the pipe. Casters are included with the VAP131R that are designed to engage with a special track system for ease of positioning the pipe onto the grooving tool's lower roll.

VAP131F Hydraulic Positioners are heavy-duty units used in conjunction with the VAP131T to support grooved pipe, valves, and fittings during assembly. The VAP131F contains wheels that permit ease of transfer from one location to another.

The VAP131T Assembly Table is a heavy-duty, free-standing unit used in conjunction with the VAP131F for supporting grooved pipe, valves, and fittings during assembly. A slot system is incorporated into the VAP131T, which permits adaptation of the ball transfer assemblies for accommodating various pipe sizes. Refer to the "NOTE" below.

NOTE: For 33.7–88.9-mm/1–3-inch pipe sizes, friction slides and brakes (accessories sold separately) shall be used in place of ball transfer assemblies on the VAP131R and VAP131T. All other pipe sizes are accommodated by using ball transfer assemblies. Refer to the graphics on page 14 for proper placement of friction slides/brakes and ball transfer assemblies.

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LOAD RATINGS

Series VAP131 components support pipe sizes 25.4–610 mm/1–24 inches (0.5-meter/1½-foot to full, single 6-meter/20-foot random lengths).

The load rating for VAP131R Hydraulic, Adjustable Pipe Stands is 975 kilograms/2150 pounds.

The load rating for VAP131F Hydraulic Positioners is 998 kilograms/2200 pounds with the wheels installed. The load rating for VAP131F Hydraulic Positioners is 907 kilograms/2000 pounds without the wheels installed.

The load rating for VAP131T Assembly Tables is 3629 kilograms/8000 pounds.

Ball transfers have a 318 kilogram/700-pound load rating. Verify that an adequate number of ball transfers are used to support the entire length of pipe.

A WARNING

. DO NOT exceed the load rating of Series VAP131 components.

Failure to follow this instruction could result in serious personal injury, property damage, and product damage.

ELECTRICAL INFORMATION

The VAP131R and VAP131F require 220-volt/6-amp, single-phase power.

EXTENSION CORD REQUIREMENTS

When pre-wired outlets are not available and an extension cord shall be used, it is important to use the proper cord size (i.e. Conductor Size American Wire Gauge). Cord size selection is based upon product rating (amps) and cord length (feet). Use of a cord size (gauge) thinner than required will cause significant voltage drop at the VAP131R or VAP131F during operation. Voltage drops may cause damage to the VAP131R or VAP131F, resulting in improper operation. **NOTE:** It is acceptable to use a cord size that is thicker than required.

The required cord sizes for cord lengths up to and including 31 m/100 ft are listed in the table below. Use of extension cords longer than 31 m/100 ft shall be avoided.

Drive Motor	Cord Lengths meters/feet						
Rating volts/amps	8 15 31 25 50 100						
220 6	14 gauge	12 gauge	10 gauge				

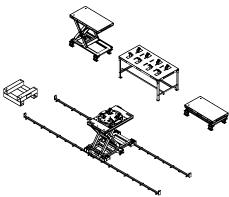
RECEIVING THE SHIPMENT

Series VAP131 components are partially assembled and are packaged in palletized containers.

- Net weight for the VAP131R is 363 kilograms/800 pounds.
- Net weight for the VAP131F is 199 kilograms/438 pounds.
- Net weight for the VAP131T is 227 kilograms/500 pounds.

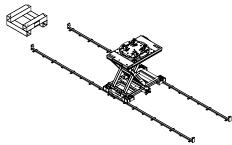
Upon receipt of the shipment, verify that all necessary parts are included. If any parts are missing, contact Victaulic.

CONTENTS OF VICTAULIC LEAN FABRICATION CELL OPTION



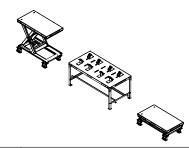
	••
Qty.	Description
1	Tool Support and Hardware
1	VAP131R Hydraulic, Adjustable Pipe Stand with Track Casters and Mounting Hardware
4	Track (3.0-meter/10-foot Length)
2	VAP131F Hydraulic Positioner with Wheels and Mounting Hardware
1	VAP131T Assembly Table with Hardware for Legs and Shelf Bracket
12	Ball Transfers/Ball Transfer Supports
1	TM-VAP131.EUR Operating and Maintenance Instructions Manual
1	Service Manual for the Hydraulic Lift

CONTENTS OF VICTAULIC HYDRAULIC, ADJUSTABLE PIPE STAND OPTION



Qty.	Description
1	Tool Support and Hardware
1	VAP131R Hydraulic, Adjustable Pipe Stand with Track Casters and Mounting Hardware
4	Track (3.0-meter/10-foot Length)
4	Ball Transfers/Ball Transfer Supports
1	TM-VAP131 Operating and Maintenance Instructions Manual
1	Service Manual for the Hydraulic Lift

CONTENTS OF VICTAULIC HYDRAULIC POSITIONER AND ASSEMBLY TABLE OPTION



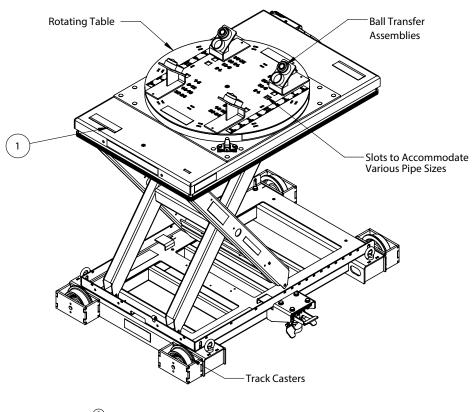
Qty.	Description
2	VAP131F Hydraulic Positioner with Wheels and Mounting Hardware
1	VAP131T Assembly Table with Hardware for Legs and Shelf Bracket
8	Ball Transfers/Ball Transfer Supports
1	TM-VAP131 Operating and Maintenance Instructions Manual
1	Service Manual for the Hydraulic Lift



VAP131R HYDRAULIC, ADJUSTABLE PIPE STAND NOMENCLATURE

NOTICE

- . Drawings and/or pictures in this manual may be exaggerated for clarity.
- VAP131R Hydraulic, Adjustable Pipe Stands, along with this operating and maintenance instructions manual, contain trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic Company.

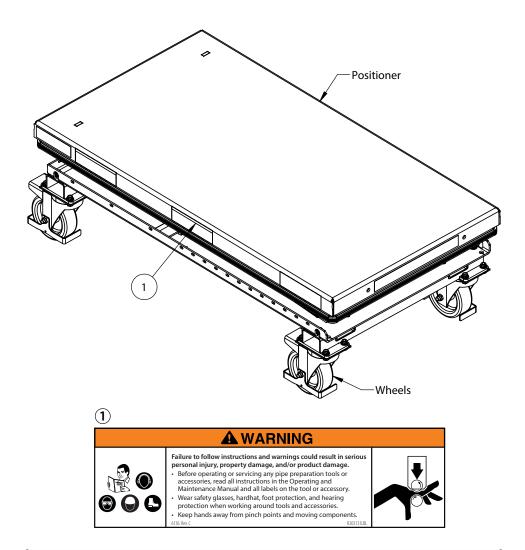




VAP131F HYDRAULIC POSITIONER NOMENCLATURE

NOTICE

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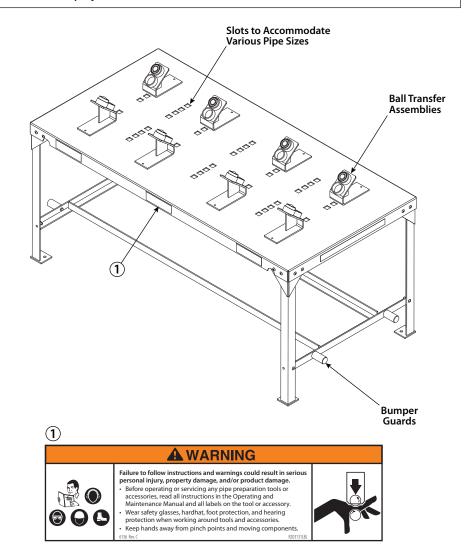




VAP131T ASSEMBLY TABLE NOMENCLATURE

NOTICE

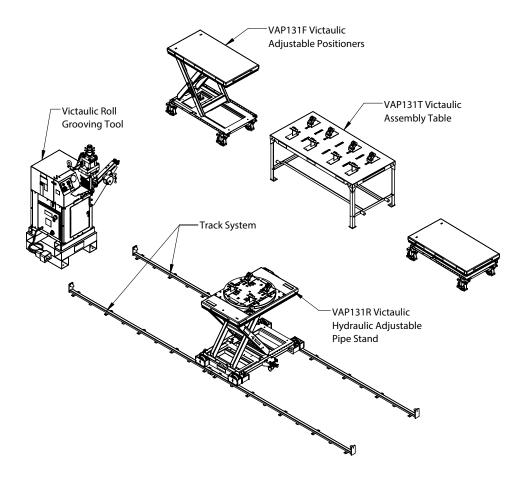
- . Drawings and/or pictures in this manual may be exaggerated for clarity.
- VAP131T Assembly Tables, along with this operating and maintenance instructions manual, contain trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic Company.





EXAMPLE OF FABRICATION SHOP LAYOUT

The layout shown below is for reference only. Series VAP131 components accommodate a variety of fabrication shop layouts and can be configured in multiple positions. Contact Victaulic with questions regarding layout options. NOTE: VAP131F Hydraulic Positioners SHALL be kept a minimum of 76 mm/3 inches away from the VAP131T Assembly Table during operation of the hydraulic lift.



A WARNING

- · Secure all electrical wiring.
- . DO NOT attempt to roll the VAP131R or VAP131F over any electrical cords.

Failure to follow these instructions could result in serious personal injury and product damage.

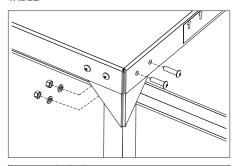
The VAP131R operates on 220VAC single phase and is equipped with a hand-controller that shall be plugged into the motor control base. Refer to the lift manufacturer's service manual, provided with the shipment, for complete information regarding power requirements and connections.

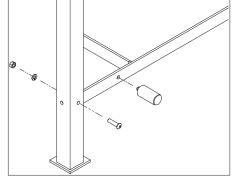
NOTE: Refer to the "Load Ratings" section for important information.

The VAP131F operates on 220VAC single phase and is equipped with a foot-controller that shall be plugged into the motor control base. Refer to the lift manufacturer's service manual, provided with the shipment, for complete information regarding power requirements and connections.

NOTE: Refer to the "Load Ratings" section for important information.

ASSEMBLY OF THE VAP131T ASSEMBLY TABLE

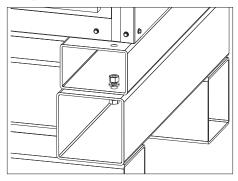




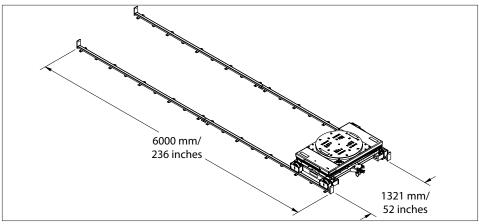
The VAP131T Assembly Table is shipped with the legs and shelf bracket removed. Refer to the drawings above for installation of the legs, bumper guards, and shelf bracket with the appropriate hardware provided.

ROLL GROOVING TOOL AND VAP131R SETUP

- 1. When grooving pipe that is supported with a VAP131R Hydraulic, Adjustable Pipe Stand, select a location for the tool and VAP131R by taking into consideration the following factors:
- 1a. Adequate space to handle pipe lengths
- **1b.** A firm and level surface for the tool and VAP131R



- **2a.** The roll grooving tool shall be installed on the tool support that is provided with the Kit 1 and Kit 2 Options. Refer to the drawing above and below for installation of the tool onto the tool support with the hardware provided.
- **2b.** Verify that the roll grooving tool/tool support is **LEVELED** and **FASTENED SECURELY** to the ground or floor. Refer to the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe.

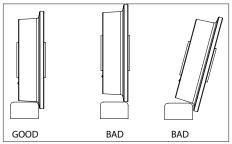




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- **3a.** Place the sections of track on the floor so that the VAP131R will be approximately in line with the tool's grooving rolls or slightly to the left or right to obtain the proper "tracking angle." Refer to the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe. **NOTE:** The track shall be placed 1321 mm/52 inches apart (refer to drawing on the previous page).
- **3b.** Verify that the sections of track are parallel and level front to back and that the pin of one section engages with the next section.
- **3c.** After the proper "tracking angle" is established, both sections of track shall be anchored to the floor to prevent movement. Refer to the "Final Adjustments" section.
- **4a.** Position the VAP131R Hydraulic, Adjustable Pipe Stand in an approximate operating location as follows. Always refer to the "Grooving Long Pipe Lengths" section in the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe.
- **4b.** Determine the length of pipe to be roll grooved.
- **4c.** Position the VAP131R at a distance slightly greater than half the pipe length from the tool (half the pipe length, plus 5%). Verify that the track casters are engaged with the track properly (refer to drawing below).



NOTE: A 10-mm/%-inch hole is provided at both ends of each track for an optional stop bolt anchor. Adding a stop bolt anchor will limit travel of the VAP131R and will help prevent the stand from rolling off the end of the track.

PIPE PREPARATION

Prepare pipe for roll grooving in accordance with the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe. In addition, inspect the pipe surface for dents or surface build-up where contact with the ball transfers will occur. The pipe surface shall be generally free from large dents, accumulations of dirt, rust, and grime that may interfere with smooth pipe rotation and/or traversing.

Pipe with external, axial weld seams can be supported with Series VAP131R Hydraulic, Adjustable Pipe Stands. However, the weld bead shall be smooth and rounded and at least three times as wide as it is high. The weld bead shall not exceed 3 mm/% inch in height.

NOTICE

 Grooving pipe that contains external weld seams will shorten the life of the ball transfer units.

INITIAL ADJUSTMENTS

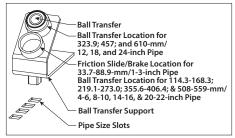
A CAUTION

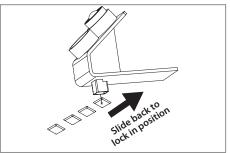
- VAP131 components shall be used ONLY for supporting pipe designated in the "Pipe Ratings" section of this manual.
- The ball transfers shall be installed in the ball transfer supports.

Failure to follow these instructions could result in damage to the equipment.

1. Determine the pipe size to be roll grooved. Refer to the pipe size label affixed to the VAP131R and VAP131T. Pipe sizes listed on top correspond with the upper ball transfer location. Pipe sizes listed on the bottom correspond with the lower ball transfer location. Verify that the ball transfer is installed in the appropriate location on each ball transfer support.

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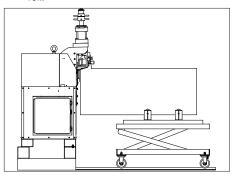


 Install the ball transfer assemblies in the slots marked for the appropriate pipe size. Verify that the ball transfers are facing toward the inside of the table and that the ball transfer assemblies are locked into position in the slots.

NOTICE

- The ball transfer supports may be placed in the innermost slots to gain height clearance when assembling valves and fittings.
- Friction slides and brakes (accessory items sold separately) can be used in place of the ball transfer assemblies to minimize pipe movement. Friction slides create slight resistance, while the friction brakes prevent pipe from rotating freely.
- To accommodate varying pipe diameters, the ball transfers and ball transfer supports may be placed in alternate positions to ensure that the pipe moves freely and is supported properly.

 Using the hand-held control switch, adjust the VAP131R height to a position that will support the pipe in an approximate level position when one end of the pipe is positioned on the roll grooving tool's lower roll.



4. Position the pipe on the VAP131R and onto the roll grooving tool's lower roll. If using a pipe sling, the sling can be positioned between the ball transfers when the pipe is positioned on the VAP131R.

A CAUTION

 Remove any pipe lifting devices from the pipe before performing final adjustments.

Failure to follow this instruction could cause damage to the pipe stand.

FINAL ADJUSTMENTS

For final adjustment of the VAP131R, grooving of the pipe is required. Roll groove the pipe by referring to the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe.

Examine the roll grooved pipe end for (A) excessive flare and/or (B) a scuffed pipe-end face.

- A. If pipe is excessively flared, it may be due to the VAP131R adjustments. To minimize flare:
- Verify that the roll grooving tool/tool support is LEVEL (especially front to back) and SECURED to the floor.



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- Verify that the pipe is LEVEL or that the back end of the pipe (end not being grooved) is slightly below level (¼ bubble maximum on a spirit level). Pipe level shall always be checked with pipe end to be grooved resting in position on the roll grooving tool's lower roll.
- 3. Reduce "tracking angle" to be as close to 0° as possible, while still maintaining pipe "tracking."
- B. If the pipe end has an excessively scuffed face, the usual causes are "over tracking" and/or an out-of-square pipe end. To minimize "over tracking," keep the VAP131R tracking angle as close to 0° as possible, while ensuring adequate "tracking."

VAP131R HYDRAULIC, ADJUSTABLE PIPE STAND TURNSTILE PROCEDURE

With the VAP131R positioned slightly beyond half the pipe length from the tool, it is possible to balance the pipe on the VAP131R and measure the groove diameter and/or rotate the pipe to groove the opposite end. The ball transfer units shall be installed in the proper sockets to utilize this feature. Refer to the "Initial Adjustments" section of this manual.

A CAUTION

 Do not attempt to use the turnstile feature for pipe longer than standard 6-meter/ 20-foot random lengths.

Failure to follow this instruction could cause damage to the pipe stand.

- Groove the pipe by referring to the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe.
- After the pipe and grooving rolls have stopped rotating, withdraw the grooved pipe from the roll grooving tool by sliding the pipe out of the tool SLOWLY to a point where it balances on the VAP131R.

WARNING

- Verify that the pipe is balanced before rotating the pipe.
- DO NOT leave the pipe unattended.

Failure to follow these instructions could result in serious personal injury or damage to the VAP131R.

- 3. Measure groove diameter.
- **4.** Unlock table then rotate the pipe to position the opposite end for grooving. When rotating pipe, walk with the pipe to maintain proper pipe balance.

MAINTENANCE

This section provides information about maintaining Series VAP131 components in proper operating condition. Replacement parts shall be ordered from Victaulic to ensure proper and safe operation. For the VAP131R and VAP131F, always refer to the hydraulic lift manufacturer's service manual for complete operating and maintenance information.

- 1. Regular lubrication is required for VAP131R and VAP131T. On a weekly basis, apply a dry graphite spray in the ball transfer units. Work the dry graphite in by rotating the ball transfer units
- On a monthly basis, lubricate the grease fittings and inspect the hydraulic hoses and electrical lines on the VAP131R and VAP131F.
- On an annual basis, or as needed, change the hydraulic fluid for the VAP131R and VAP131F.

HYDRAULIC FLUID REQUIREMENTS

Weight	Fluid Temperature
ISO 32	-8 to 64° C



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PARTS ORDERING INFORMATION

When ordering parts, the following information is required for Victaulic to process the order and send the correct part(s). Order parts by calling 1 800 PICK VIC.

- 1. Model Number
- 2. Quantity, Part Number, and Description
- 3. Where to Send the Part(s)
- 4. To Whose Attention to Send the Part(s)
- 5. Purchase Order Number

TROUBLESHOOTING

Always refer to the hydraulic lift manufacturer's service manual for additional troubleshooting information.

PROBLEM	POSSIBLE CAUSE	SOLUTION				
Pipe flare is excessive	Pipe is "over tracking"					
	Pipe height adjustment is too high					
	Roll grooving tool is tilted forward					
Pipe face is excessively scuffed	Pipe is "over tracking"	Refer to the Operating and Maintenance Instructions Manual for				
Pipe will not stay in roll grooving tool	Insufficient pipe tracking angle	the applicable tool being used to roll groove the pipe.				
	Pipe rotating in the wrong direction					
	Pipe not square cut					
	Back end of pipe is above level.					
	Roll grooving tool is tilted forward					
	Ball transfer(s) are jammed or sticking	Remove the ball transfer(s). With the ball side down, tap the ball				
Pipe skids on one or more of the ball transfers	Ball transfer(s) are clogged or there is a lack of lubrication on the ball transfer(s)	Transfer(s) on a hard surface to remove loose dirt and debris from inside the unit. Re-install the ball transfer(s) and lubricate with a dry graphite spray. Refer to the "Maintenance" section.				

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PIPE RATINGS

Pipe Size		Nominal Wall Thickness Dimensions - mm/inches*							
Nominal Size DN/inches	Actual Pipe Outside Diameter mm/inches		Pipe ickness Max.	Pipe	ss Steel Wall mess Max.		um Pipe ickness Max.		Pipe ickness Max.
DN25	33.7	1.7	3.4	1.7	3.4	1.7	3.4	3.4	4.5
1	1.315	0.065	0.133	0.065	0.133	0.065	0.133	0.133	0.179
DN50	60.3	1.7	3.9	3.9	3.9	1.7	3.9	3.9	3.9
2	2.375 73.0	0.065 2.1	0.154 5.2	0.154 5.2	0.154 5.2	0.065 2.1	0.154 5.2	0.154 5.2	7.0
21/2	2.875	0.083	0.203	0.203	0.203	0.083	0.203	0.203	0.276
DN80	88.9	2.1	5.5	5.5	5.5	2.1	5.5	5.5	7.6
3	3.500	0.083	0.216	0.216	0.216	0.083	0.216	0.216	0.300
DN90	101.6	2.1	5.7	5.7	5.7	2.1	5.7	5.7	8.1
3½	4.000	0.083	0.226	0.226	0.226	0.083	0.226	0.226	0.318
DN100 4	114.3 4.500	2.1 0.083	9.5 0.375	6.0 0.237	6.0 0.237	2.1 0.083	6.0 0.237	6.0 0.237	8.6 0.337
	127.0	2.4	9.5	6.0	6.0	2.4	6.0	0.237	0.557
41/2	5.000	0.095	0.375	0.237	0.237	0.095	0.237		
	141.3	2.8	9.5	6.6	6.6	2.8	6.6	6.6	9.5
5	5.563	0.109	0.375	0.258	0.258	0.109	0.258	0.258	0.375
	152.4 6.000	2.8 0.109	9.5 0.375	6.6 0.258	6.6 0.258	2.8 0.109	6.6 0.258		
DN150	168.3	2.8	9.5	7.1	7.1	2.8	7.1	7.1	11.0
6	6.625	0.109	0.375	0.280	0.280	0.109	0.280	0.280	0.432
	203.2	2.8	9.5	6.4	8.2	2.8	8.2		
	8.000	0.109	0.375	0.250	0.322	0.109	0.322		
DN200	219.1	2.8	9.5	6.4	8.2	2.8	8.2	8.2	12.7
8 DN250	8.625 273.0	0.109 3.4	0.375 9.5	0.250 6.4	0.322 9.3	0.109 3.4	0.322 6.4	0.322 9.3	0.500 15.1
10	10.750	3.4 0.134	0.375	0.250	0.365	0.134	0.250	0.365	0.593
DN300	323.9	4.0	9.5	6.4	9.5	4.0	6.4	10.3	17.5
12	12.750	0.156	0.375	0.250	0.375	0.156	0.250	0.406	0.687
DN350	355.6	4.0	9.5	7.9	9.5			11.1	11.1
14	14.000	0.156	0.375	0.312	0.375			0.438	0.438
DN400 16	406.4 16.000	4.2 0.165	9.5 0.375	7.9 0.312	9.5 0.375			12.7 0.500	12.7 0.500
DN450	457.0	4.2	9.5	9.5	9.5			0.500	0.500
18	18.000	0.165	0.375	0.375	0.375				
DN500	508.0	4.7	9.5	9.5	9.5				
20	20.000	0.183	0.375	0.375	0.375				
DN550 22	559.0 22.000	4.8	9.5 0.375	9.5	9.5				
DN600	610.0	0.188 5.5	9.5	0.375 9.5	0.375 9.5				
24	24.000	0.218	0.375	0.375	0.375				

This table is applicable only to ANSI piping and is based upon the following material grades. Refer to the appropriate international standard for other systems.

Statel – Brinell Hardness Number (BHN) of 180 BHN and less. **NOTE:** When roll grooving steel pipe at or near the maximum rated thickness, the pipe shall not exceed the yield strength of API-5L Grade "B", ASTM Grade "B", 150 BHN maximum. Stainless Steel - Types 304/304L and 316/316L

Aluminum - Grades 6061-T4 and 6063-T4

PVC Type I, Grade I (PVC 1120) PVC Type I, Grade II (PVC 1220) PVC Type II, Grade I (PVC 2116)



^{*} All minimum and maximum wall thicknesses are nominal

EC DECLARATION OF CONFORMITY

In Accordance with the Machinery Directive 2006/42/EC

Victaulic Company, headquartered at 4901 Kesslersville Road, Easton, PA 18040, USA, hereby declares that the machinery listed below complies with the essential safety requirements of the Machinery Directive, 2006/42/EC.

Product Models: VAP131R, VAP131F

Serial No.: Refer to Machinery Nameplate

Product Description: Lift Table

Conformity Assessment: 2006/42/EC, Annex I

Reference Standards: EN IEC 60204-1: 2018

EN 1570-1

Technical Documentation: The relevant technical documentation prepared in

accordance with Annex VII (A) of the Machinery Directive 2006/42/EC, will be made available upon request to the

governing authorities.

Authorized Representative: Victaulic Company

c/o Victaulic Europe BVBA

Prijkelstraat 36 9810, Nazareth Belgium

Signed for and on behalf of Victaulic Company,

Len R. Swantek

Mr. Len R. Swantek

Director – Global Regulatory Compliance Machinery Manufacturer Representative

Place of Issue: Easton, Pennsylvania, USA

Date of Issue: January 18, 2024

ictaulic



UK DECLARATION OF CONFORMITY

In Accordance with The Supply of Machinery (Safety) Regulations 2008 No. 1597

Victaulic Company, headquartered at 4901 Kesslersville Road, Easton, PA 18040, USA, hereby declares that the machinery listed below complies with the essential safety requirements of The Supply of Machinery (Safety) Regulations 2008 No. 1597.

Product Models: VAP131R, VAP131F

Serial No.: Refer to Machinery Nameplate

Product Description: Lift Table

Conformity Assessment: 2008 No. 1597, Annex I

Reference Standards: EN IEC 60204-1: 2018

EN 1570-1

Technical Documentation: The relevant technical documentation prepared in

accordance with Annex VII (A) of The Supply of Machinery (Safety) Regulations 2008 No. 1597, will be made available upon request to the governing

authorities.

Authorized Representative: Victaulic Company

c/o Victaulic Europe BVBA

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Signed for and on behalf of Victaulic Company,

Len R. Swantek

Mr. Len R. Swantek

Director – Global Regulatory Compliance Machinery Manufacturer Representative

Place of Issue: Easton, Pennsylvania, USA

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Series VAP131 Victaulic Lean Fabrication Cell for European Market

VAP131R VICTAULIC HYDRAULIC, ADJUSTABLE PIPE STAND VAP131F VICTAULIC HYDRAULIC POSITIONER VAP131T VICTAULIC ASSEMBLY TABLE

